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FZ

**TEXTILE INDUSTRY STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

FZ/T 73019.1-2017

Knitted shape inner wear - Elastic style

针织塑身内衣 弹力型 清晰版

(English Translation)

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1 Scope

This Standard specifies the terms and definitions, size, requirements, tests, judgment rules, use instructions, packaging, transportation, and storage of knitted shape inner wear-elastic style products.

This Standard applies to the identification of the quality of elastic-style knitted shape inner wear and side seam-free knitted shape inner wear products.

This Standard does not apply to the clothing of infants and young children aged 36 months or less.

2 Normative references

The following documents are indispensable for the application of this document.

For the dated references, only the editions with the dates indicated are applicable to this document. For the undated references, the latest edition (including all the amendments) are applicable to this document.

GB/T 250 Textiles - Tests for colour fastness - Grey scale for assessing change in colour

GB/T 2910 (all parts) Textiles - Quantitative chemical analysis

GB/T 2912.1 Textiles - Determination of formaldehyde - Part 1: Free and hydrolyzed formaldehyde (water extraction method)

GB/T 3920 Textiles - Tests for colour fastness - Colour fastness to rubbing

GB/T 3921-2008 Textiles - Tests for colour fastness - Colour fastness to washing with soap

or soap and soda

GB/T 3922 Textiles - Testing method for colour fastness to perspiration

GB/T 4802.1-2008 Textiles - Determination of fabric propensity to surface fuzzing and to pilling - Part 1: Circular locus method

GB/T 4856 Package of cotton goods and knitwear

GB/T 5296.4 Instructions for use of products of consumer interest - Part 4:

Textiles and apparel the net chest (waist) circumference of the human body suitable, for example:

155-165/85-90, or according to the provisions of GB/T 6411.

5.1 Requirement content

Requirements are divided into two aspects: intrinsic quality and appearance quality. Intrinsic quality includes indicators such as fiber content, formaldehyde content, pH value, odor, decomposable carcinogenic aromatic amine dye, colour fastness to washing with soap or soap and soda, colour fastness to rubbing, colour fastness to perspiration, colour fastness to water, size stability to washing, and pilling. Appearance quality includes indicators such as surface defects, size deviations of major parts of the finished product, size differences of symmetrical parts, stitch elongation, and sewing regulations.

5.2 Grading regulations

5.2.1

The quality grade of knitted shape inner wear-elastic style products is divided into superior product, first-class product, and qualified product.

5.2.2

For the quality grading of knitted shape inner wear-elastic style products, the intrinsic quality is graded by lot (delivery lot); the appearance quality is graded by piece. The combination of intrinsic quality and appearance quality is graded at the lowest grade.

5.2.3

The indicators of intrinsic quality take the lowest one of the test results as the grading basis of this lot of products.

5.2.4

When the appearance quality problems of different grades are found on the same product, it is graded at the lowest grade. Only two extreme surface defects of the same grade are allowed on the same product; those exceeding this limit shall be reduced by one grade.

5.3 Intrinsic quality requirements

5.3.1

The intrinsic quality requirements are shown in Table 1.

Table 5 -- Stitch density regulations

In number of stitches per 2 centimeter

Category Flat seam

Flat double needle

Three- needle machine

Four- needle machine

Rolling collar

Rolling belt

Wide banding machine

Overlock

Overlock and rolling rim

>= 9 8 9 8 9 9 8 8 7

Note: The stitch density is measured in the middle of a sewing process.

5.4.5.6 The seam width of the overlock machine, for three threads, is not less than 0.3 cm; for four threads, is not less than 0.4 cm; for five threads, is not less than 0.6 cm.

5.4.5.7 For the skipped stitch for single stitch of double-needle covering stitch

machine, it is allowed to disperse 1 stitch in 3 places.

6.1 Sampling quantity

6.1.1

As for appearance quality, the delivery lot is randomly sampled 1%~3% according to the variety, colour, and size, no less than 20 pieces. If the lot size is less than 20 pieces, the total is inspected.

6.1.2

As for intrinsic quality, the delivery lot is randomly sampled 4 pieces according to the variety, colour, and size. If insufficient, the number of pieces may be increased.

6.2.1.1 Generally, use lamplight to inspect. USE a 40 W white-light fluorescent

lamp; ADD a lamp cover thereon. The vertical distance between the lamp cover and the center of inspection table is (80 ± 5) cm.

6.2.1.2 If natural light is used indoors, the light source shall enter in the north to the left (or right) upper angle, so that the sunlight cannot be directed to the product.

6.2.1.3 During the inspection, the product shall be spread evenly on the inspection table. The table shall be covered with a white cloth. The line of sight of the inspector shall face the surface of the flat stand product. The visual distance is more than 35 cm.

Flatten the product; MEASURE 10 cm in the middle of the sleeve seam, side seam, or trousers seam and mark it; STRETCH hard and measure the extended size of the seam. According to formula (1), calculate the stitch elongation. The final result, according to GB/T 8170, is rounded-off to a single digit.

Where:

B - Stitch elongation;

L - Stitch size after stretching, in centimeters (cm).

6.3.1 Inspection conditions for intrinsic quality

6.3.1.1

The sample taken shall not have any defects affecting the test.

6.3.1.2

When the test of size stability to washing is carried out, the sample shall, at room temperature, be evenly spread on a smooth surface for 20 h. Under the conditions of a test chamber temperature of $(20\pm2)^{\circ}\text{C}$ and a relative humidity of $(65\pm4)\%$, after humidifying for 4 h, carry out the test.

6.3.2.1 Fiber content

Execute according to FZ/T 01057 (all parts), GB/T 2910 (all parts), FZ/T 01026,

FZ/T 01095. The sampling locations include at least the middle of front waist of the top and the middle of abdomen of the trousers.

6.3.2.2 Formaldehyde content

Execute according to GB/T 2912.1.

6.3.2.3 pH value

Execute according to GB/T 7573.