

ICS 61.060
CCS Y78



**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 11413-2015

Replacing GB/T 11413-2005

Test method for bond strength of leather shoes heels

皮鞋后跟结合力试验方法

Issued on: September 11, 2015

Implemented on: April 1, 2016

**Issued by: General Administration of Quality Supervision, Inspection and
Quarantine of the People's Republic of China;
Standardization Administration of China**

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Foreword

This Standard was drafted in accordance with the rules given in GB/T 1.1-2009. This Standard replaces GB/T 11413-2005 Test methods for bond strength of leather shoes heels. Compared with GB/T 11413-2005, the main modifications are as follows: - added GB/T 16825.1-2008 Verification of static uniaxial testing machines - Part 1.

Tension/compression testing machines - Verification and calibration of the force-measuring system in normative references; - added two forms of pull fixtures for different heel forms; - described some actual situations in the test results. Attention is drawn to the possibility that some of the elements of this Standard may be the subject of patent rights. The issuing authority shall not be held responsible for identifying any or all such patent rights. This Standard was proposed by China Light Industry Federation. This Standard shall be under the jurisdiction of Sub-committee on Leather Shoes, National Technical Committee on Footwear of Standardization Administration of China (SAC/TC305/SC1). The drafting organizations of this Standard. Wenzhou Quality and Technical Supervision and Inspection Institute [National Footwear Quality Supervision and Inspection Center (Wenzhou)], China Leather and Footwear Industry Research Institute, Zhejiang Red Dragonfly Footwear Company Limited, Wenzhou Haibin Xiu Long Shoes Co., Ltd. Main drafters of this Standard. Ye Zhengmao, Yang Zhimin, Yu Shuxian, Shang Yuanjun, Zhang Xiulong, Mao Xiaohui, Pan Wenwen. Versions of standard substituted by this Standard are. - GB/T 11413-1989, GB/T 11413-2005. Test method for bond strength of leather shoes heels

1 Scope

GB/T 11413-2015 is the Chinese national standard on test method for bond strength of

leather shoes heels, in the field of clothing industry. The /T suffix marks it as a recommended standard: it is not compulsory by itself, but it becomes binding as soon as a contract, a tender or a customer specification calls it up - which in practice is how most foreign buyers meet it. It was issued on 11 September 2015 by the General Administration of Quality Supervision, Inspection and Quarantine of the People's Republic of China; Standardization Administration of China, and has been in force since 1 April 2016. Classification: ICS 61.060, CCS Y78. This page is published from the official record of the standard held by the Chinese standards administration: the identification, the dates, the classification and the issuing body are taken from there. The clause text, the tables and the numeric limits are in the document itself, which is delivered complete in English translation.

This Standard specifies the test method for the bond force of the heel and the posterior or outer soles. This Standard is applicable to heel and heel lasting or shoes adhesive or stapled with outsole. This Standard is not applicable to leather shoes of which the heel is integrated with the outsole.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

GB/T 16825.1-2008, Verification of static uniaxial testing machines - Part 1.

Tension/compression testing machines - Verification and calibration of the force-measuring system

3 Principle

Put the finished shoes on a special fixture. Stretch to the heel and posterior or outsole for separation on the tensile testing machine at a certain speed. The required force shall be bond strength of leather shoes heels.

4.1 Tensile testing machine

4.1.1 Tensile testing machine shall meet the requirements of GB/T 16825.1-2008. The maximum load shall not be less than 1500 N.

4.1.2 The precision is grade 2.

4.1.3 The stretching speed can be adjusted to (25 ± 2) mm/min. lasting or outsole. Stop immediately and record the maximum load.

7.7 During the test, if the upper is torn or the heel is separated and the insole is pulled out, if the heel is not separated from the heel lasting or outsole, it shall terminate the test and record the maximum load.

7.8 During the test, if it reaches to the maximum load of the testing machine due to excessive bond strength of heel but the heel is still not separated from the heel lasting or outsole, it shall terminate the test and record the maximum load.

7.9 During the test, if the heel is broken or fractured, the heel is not separated from the heel lasting or outsole, it shall terminate the test and record the maximum load.

7.10 If it only measures whether the heel bond strength meets the specified value requirements, then when the load value reaches the product standard value, it shall check whether the heel is separated from the heel lasting or outsole after the load is maintained for 15s ~ 20s.

7.11 The other samples shall be carried out in the same method.

8 Test results

8.1 Take the maximum load recorded during the test as the test results, in Newtons (N). The test results shall be nearest to 5N.

8.2 During the test, if the heel is not separated from the heel lasting or outsole after there is situation described in 7.7, 7.8,

7.10 test, it shall take the maximum load recorded as the test results and indicate "unseparated" as well as the corresponding situation.

8.3 The test results for each shoe shall be expressed separately.

9 Test report

The test report shall contain the following information.

- a) reference to this test method;
- b) descriptions on test specimen name, heel height, fixture type, heel material, heel assembly form (adhesive or stapling), heel separation;
- c) heel bond strength;