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

**GB/T 17760-2019**

Replacing GB/T 17760-2009

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**Inspection method for printed or dyed fabric surface defects**

印染布布面疵点检验方法

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### 1 Scope

GB/T 17760-2019 is the Chinese national standard on inspection method for printed or dyed fabric surface defects, in the field of textile and leather technology. 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 4 June 2019 by the State Administration for Market Regulation; Standardization Administration of China, and has been in force since 1

January 2020. Classification: ICS 59.080.01, CCS W70. 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 stipulates the terms, definitions, inspection conditions, operational stipulations, inspection methods and inspection report of inspection method for printed or dyed fabric surface defects. This Standard is applicable to various kinds of bleached, dyed and printed fabric, which is produced through machine-weaving, and with the raw material of cotton, chemical fiber and other pure or blended natural yarn.

## 2 Normative References

The following documents are indispensable to the application of this document. In terms of references with a specified date, only versions with a specified date are applicable to this document. In terms of references without a specified date, the latest version (including all the modifications) is applicable to this document.

GB/T 250 Textiles - Tests for Color Fastness - Grey Scale for Assessing Change in Color;

GB/T 24250 Woven Fabrics - Description of Defects - Vocabulary

## 3 Terms and Definitions

What is defined in GB/T 24250, and the following terms and definitions are applicable to this document.

**3.1 Point Assessing Point** assessing refers to the method which assesses the number and severity of fabric surface defects through point and stipulates the maximum limit.

**3.2 Defect Marking Method** Defect marking method refers to the method which displays the location and number of certain surface defects through marking and stipulates length discount to replace defects.

**3.3 Damage** Damage refers to holes, broken edges, edge exclusions, and floats over

0.3 cm.

## 4.1 Inspection Conditions

**4.1.1** During inspection, illuminance on the fabric surface shall be not lower than 750 lx. The distance between eyes and the fabric surface shall be 55 cm ~ 60 cm.

**4.1.2** When platform inspection is adopted, use 3 ~ 4 PCS of 40 W cyan fluorescent tubes

with cover. The distance between the inspection light source and the fabric surface shall be

4.1.3 When cloth inspection machine is adopted, the angle of the cloth inspection board shall be 45°. The highest linear speed of the cloth inspection machine shall be 40 m/min.

## 4.2 Operational Stipulations

4.2.1 Adopt cloth inspection machine or platform inspection.

4.2.2 The inspection of fabric surface defects shall subject to the front surface (the surface with plait stamping) of cloth. In terms of twill fabric: yarn fabric: the left oblique "" shall be the front surface; thread fabric: the right oblique "" shall be the front surface. Or, the front surface of fabric may also be confirmed in accordance with the customers' demands.

4.2.3 Use measuring instrument to measure the length of each fabric surface defect. The division value of the measuring instrument shall be 1 mm.

4.2.4 Chromatic aberration shall be assessed in accordance with GB/T 250.

4.2.5 When the cloth inspection machine and the platform inspection are contradictory, the result shall subject to platform inspection.

## 5.1.1 Point assessing

5.1.1.1 Adopt four-point assessing method. The stipulations of point assessing shall comply with Table 1. Table 1 -- Stipulations of Four-point Assessing Method 3

0.2 cm and less than

0.2 cm dispersed defects that would affect the appearance; 15 dark-color defects and 10 light-color defects 1

### 5.1.2.3 Stipulations of defect marking length discount: defect length does not exceed

20.0 cm: length discount shall be

20.0 cm; defect length is

50.0 cm, length discount shall subject to the actual length of defect.

### 5.1.2.4 Above

2.0 cm broken holes, stopping gears in dyeing and finishing processing, above

50.0 cm warp-wise severe defects shall not be marked. Instead, they shall be cut through.

5.1.2.5 The location of defect marking shall all be on the fabric of corresponding parts where the defect exists.

5.2 Inspection of Dispersed Defects Inspection methods for dispersed defects may be degraded in accordance with the degree of severity, the overall effect of the affected appearance and product standards.

### 5.3 Measurement of Defects

5.3.1 The length of defects shall be measured in accordance with the maximum warp- wise or weft-wise length.

5.3.2 When the length of warp-wise defects exceeds 1 m, the excessive part shall be separately measured and counted, then, assessed in accordance with Table 1.

5.3.3 Curved defects shall be measured in accordance with the maximum distance of the actual influence. Overlapped defects shall be assessed in accordance with the severity.

5.3.4 When various defects simultaneously exist in warp-wise 1 m and less than 1 m, the defects shall be respectively measured and accumulatively assessed. The maximum assessed point shall exceed 4-point; the maximum defect marking number shall not exceed 1.

5.3.5 In terms of dispersed spots which are difficult to be counted or measured, in accordance with the maximum length and width of such dispersion, respectively measure and count them; accumulate the assessed point.

5.3.6 When the same partial defects exist in the same fabric, the accumulative point shall not exceed the degraded limit point of the defect. When the point of other partial defects that simultaneously exist shall be accumulated, plus the starting point of the already-degraded grade and the accumulative point of partial defects. Thus, the total point of the fabric can be obtained.

## 8 Double warp 2 warps parallelly woven into single yarn (strand) fabric

9 Parallel thread tightness Uneven tension when single yarn is twisted into strand

10 Loose warp Partial warps are woven into fabric under loose tension

11 Tight warp Partial warps are woven under excessive degree of twist

12 Warp hanging Partial warps are under excessive tension in fabric

13 Warp shrinkage ripple Partial warps become loose under accidental tension, which leads to ripple-shaped rolls-and-swells on fabric surface

## 20 Knot Knot that would affect the quality of the subsequent processes