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

GB/T 31903-2024

Identification, marking and packing for garment interlining

服装衬布产品标记、标志与包装

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Foreword

This document was drafted in accordance with the rules given in GB/T 1.1-2020.

It replaces GB/T 31903-2015, Rules for the product naming, marking and packing of garment interlinings, and the title has changed accordingly.

It was proposed by the China National Textile and Apparel Council and is under the jurisdiction of the National Technical Committee on Textiles Standardization (SAC/TC 209).

1 Scope

This document specifies the product identification, the marking and the packing of garment interlining.

It applies to the identification, marking and packing of interlining products used in garment manufacture.

Why the humblest standard is the most used

Of the three interlining standards this is the least technical and the one a garment factory consults most often.

Interlining is bought by specification, delivered in rolls, stored, and then used weeks or months later by a fusing press operator who was not involved in buying it.

Everything that operator needs to know has to be on the roll, because the purchase specification is in an office and the sample that was approved is in a file.

So the marking is not documentation about the product; it is the working instruction for using it.

4 What has to be identified

An interlining is characterised by its base fabric - woven, knitted or nonwoven - by its weight, by its adhesive type and coating pattern, by its fusing conditions and by its colour.

None of those is visible on a roll. Two rolls that look and feel identical can carry different adhesives requiring different fusing temperatures.

The product identification is the coded designation that carries this, and it is what allows a factory to reorder the same material and a supplier to know what was meant.

Getting the designation system right is therefore worth a standard of its own, which is what this document is.

5 The fusing conditions are the critical marking

Fusible interlining is bonded to the face fabric in a fusing press under a set temperature, pressure and dwell time, and those three numbers belong to the interlining rather than to the press.

Set the temperature too low or the time too short and the adhesive does not flow into the face fabric: the bond peels in the first wash, and the garment fails at the customer.

Set them too high and the adhesive strikes through the face fabric, which shows as a shine or a hard patch on the outside of a finished garment - and cannot be repaired.

Requiring the fusing conditions on the roll marking puts that information where the operator setting the press can read it, which is the single most consequential requirement in the document.

5 Marking that survives the warehouse

A roll of interlining is handled several times between delivery and use, stored on end or on a rack, and often partly used and returned to stock.

So the marking has to stay attached and legible through all of that, and it has to identify a part-used roll as well as a full one.

That is why marking is specified as a requirement rather than left to the supplier's label design, and why the standard addresses what is marked on the roll as well as what is on the packaging.

Handling and storage marks follow GB/T 191, and where the product reaches a consumer the instructions for use of textiles under GB 5296.4 apply.

6 Packing

The packing requirements protect the roll in transit and in store, and for interlining the specific risks are crushing, moisture and heat.

A crushed roll takes a permanent crease, and a creased interlining fuses with the crease still in it, which telegraphs through the face fabric.

Moisture affects the adhesive coating, and heat is worse: a roll stored against a hot surface can partly activate its adhesive, after which it will not fuse evenly and the roll is unusable.

The accompanying documents clause completes the chain from supplier to fusing press, and together with GB/T 31902 for defect inspection and GB/T 31904 for nonwoven fusible interlining it gives the sector a complete set.