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

GB/T 31904-2024

Nonwoven fusible interlining

非织造粘合衬

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Standardization Administration of the PRC**

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Foreword

This document is in accordance with the provisions of GB/T 1.1-2020 "Guidelines for standardization work Part

1. Structure and drafting rules for standardization documents" Drafting. This document replaces GB/T 31904-2015 "Nonwoven fusible interlining". Compared with GB/T 31904-2015, except for structural adjustment and editing In addition to the changes in performance, the main technical changes are as follows:

- Changed the scope of the document (see Chapter 1, Chapter 1 of the.2015 edition);
- Changed the terms and definitions (see 3.1, 3.1 of the.2015 edition);
- Added product marking (see 4.2);
- Deleted some clauses in the classification regulations (see 5.1 of the.2015 edition);
- Physical and chemical properties added peel strength test specimen width 2.5cm assessment index and color fastness assessment index (see Table 1,.2015 edition Table 1);
- Changed the writing order of items in appearance quality and color difference assessment indicators (see Table 2, Table 2 of the.2015 edition);
- Added normative Appendix A "Sample photos of assessment of appearance changes of adhesive interlining after washing" (see Appendix A). Please note that some of the contents of this document may involve patents. The issuing organization of this document does not assume the responsibility for identifying patents. This document was proposed by the China National Textile and Apparel Council. This document is under the jurisdiction of the National Technical Committee on Standardization of Textiles (SAC/TC209). This document was drafted by: Zhejiang Jinsanfa Fusible Interlining Co., Ltd., Nantong Haihui Technology Development Co., Ltd., Jiangsu Yiyi New Materials Co., Ltd. Company, Nantong Jianghuai Interlining Co., Ltd., Shenghe New Materials Technology (Jiaxing) Co., Ltd., Qidong Meiyi Interlining Co., Ltd., Zhejiang Aoyu New Material Technology Co., Ltd., Shanghai Textile

Industry Technical Supervision Institute, and China Industrial Textiles Industry Association. The main drafters of this document are. Wang Aiqin, Gao Shenghuan, Cao Ping, Tang Xindong, Liu Jian, Sheng Qiuhui, Gu Yuanyuan, Chen Yu, Li Guimei, and Zuo Shuwen. The previous versions of this document and the documents it replaces are as follows:

---First published in.2015 as GB/T 31904-2015;

---This is the first revision. Nonwoven fusible interlining

1 Scope

China's national product standard for nonwoven fusible interlining, and the current edition of GB/T 31904, replacing the 2015 edition. It defines the terms, and specifies the product classification, the marking, the requirements, the test methods, the inspection rules and the packaging, with a normative annex of sample photographs for assessing the change in appearance of fused interlining after washing. Nonwoven fusible interlining is the most widely used interlining there is. Its base is a nonwoven fabric - fibres bonded into a web rather than woven or knitted - which is cheap, dimensionally stable in all directions and available in a wide range of weights, and it carries a thermoplastic adhesive applied as a pattern of dots on one face. The garment maker fuses it to the face fabric under heat and pressure, and the two behave as one material thereafter. Its performance is judged on two things above all. Peel strength measures how firmly the bond holds, and it is what fails when a collar or a cuff begins to bubble after washing. Appearance after washing measures whether the fused assembly still looks right - whether the face fabric has puckered, blistered or changed in handle - and it is judged visually, which is why the 2024 revision adds a normative annex of sample photographs against which that judgement is made. The revision also revises the scope and the terms, adds product marking, deletes some classification provisions, adds an assessment index for peel strength measured on a 2.5 cm wide specimen and an index for colour fastness, and reorders the appearance quality and colour difference indexes. Issued on 15 March 2024 and in force since 1 October 2024.

2 Normative references

The contents of the following documents constitute the essential clauses of this document through normative references in this document. For referenced documents without a date, only the version corresponding to that date applies to this document; for referenced documents without a date, the latest version (including all amendments) applies to This document.

GB/T 250 Textiles - Grey scale for colour fastness tests

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

GB/T 4666 Textile fabrics - Determination of length and width

GB/T 5711 Textiles - Tests for colour fastness - Colour fastness to dry cleaning using tetrachloroethylene

GB/T 6152-1997 Textiles - Tests for colour fastness - Colour fastness to hot pressing

GB/T 8170 Rules for rounding off values and expression and determination of limit values

GB/T 15557 Clothing Terminology

GB 18401 National basic safety technical specification for textile products

GB/T 24218.1 Textiles - Test methods for nonwovens - Part

GB/T 28465 Inspection Rules for Garment Interlinings

GB 31701 Safety Technical Specification for Infant and Children's Textile Products

GB/T 31902 Inspection method for appearance defects of clothing linings

GB/T 31903 Product marking, logo and packaging of garment interlinings FZ/T 01047

Standard light source conditions for visual assessment of color fastness of textiles FZ/T

01081 Test method for hot melt adhesive coating amount of adhesive interlining FZ/T 01082

Test method for dry heat dimensional change of adhesive interlining FZ/T 01083 Test

method for appearance and dimensional changes of adhesive interlining after dry cleaning

FZ/T 01084 Test method for appearance and dimensional changes of adhesive interlining

after washing FZ/T 01085-2018 Test method for peel strength of adhesive interlining FZ/T

01110 Test method for adhesive penetration of fusible interlining after bonding and pressing

FZ/T 60031-2020 Test method for appearance and dimensional changes of garment

interlining after steam ironing FZ/T 60034-2021 Test method for powder loss of adhesive

interlining FZ/T 60047 Test method for dimensional change of garment interlining after

washing

3 Terms and definitions

The terms and definitions defined in GB/T 15557 and the following apply to this document.