



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

GB/T 3903.26-2020

**Footwear - Test methods for stiffeners and toepuffs -
Bondability**

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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 3903.26-2008 "Footwear - Test methods for stiffeners and toepuffs - Bondability"; compared with GB/T 3903.26-2008, the major technical changes are as follows:

- Modify normative references (see Chapter 2; Chapter 2 of version 2008);
- Add a footnote (see 4.3.2; 4.3.2 of version 2008);
- Modify requirements for the reference leather (see 4.4; 4.4 of version 2008);
- Add requirements for acetone or other organic solvent type ketones (see 4.7);
- Modify requirements for the number of samples (see 5.1; 5.1.1 of version 2008);
- Modify requirements for the heating time (see 5.1.4; 5.1.4 of version 2008);
- Modify requirements for the unstuck length of the sample (see 5.2.3; 5.2.3 of version 2008);
- Modify requirements for the soaking time (see 6.5; 6.5 of version 2008);

- Change intermediate value of force to average value of force (see Figure 1; Figure 1 of version 2008);
- Change wet adhesion to wet bondability (see 7.2.2; 7.2.2 of version 2008);
- Modify requirements for the test report (see Chapter 8; Chapter 8 of version 2008);

The translation method used in this Standard is equivalent to ISO 20863:2018 "Footwear - Test methods for stiffeners and toepuffs - Bondability".

The documents of our country that have a consistent correspondence with the international documents that are referenced in this Standard are as follows:

- 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 (ISO 7500-1:2004, IDT)
 - GB/T 22049-2019 Footwear - Standard atmospheres for conditioning and testing of footwear and components for footwear (ISO 18454:2018, IDT)
- Foot wear - Test methods for stiffeners and toepuffs -
Bondability

1 Scope

This Standard specifies test methods for the bondability of heat activated and solvent activated stiffeners and toepuffs to upper and lining materials.

This Standard applies to stiffeners and toepuffs for foot wear.

2 Normative references

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

ISO 7500-1 Metallic materials - Calibration and verification of static uniaxial testing machines - Part 1: Tension/compression testing machines - Calibration and verification of the force-measuring system

ISO 18454 Footwear - Standard atmospheres for conditioning and testing of footwear and components for footwear

3 Terms and definitions

The following terms and definitions are applicable to this document.

3.1

Bondability

The ability of a material to bond with itself or other materials through pressure and/or heating and the use of uniform adhesives.

4 Test equipment and materials

The following equipment and materials shall be used:

4.1 Tensile testing machine: with a jaw separation rate of 100 mm/min +/-10

mm/min, an applicable force range (this will usually be less than 100 N),

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