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

MT/T 763-1997

**Test Methods and Judgment Rules for the Physical and
Mechanical Properties of Base Fabric for Coating Fabric on Fan
Drum Used for Coal Mine**
(English Translation)

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Physical and mechanical properties of coal mine air duct coated cloth base cloth Test methods and judgment rules

1 Scope

This standard specifies the test methods and judgments for the physical and mechanical properties of duct-coated base cloth for coal mines (hereinafter referred to as coated base cloth) rule.

This standard applies to the use of a variety of fiber materials made of air duct coated cloth base cloth. Such as glass fiber cloth, glass wool interwoven cloth, chemical fiber cloth, Synthetic fiber cloth and so on.

2 Reference standards the following standards contain provisions that, through reference in this standard, constitute provisions of this standard. When this standard was published, the editions shown were all is effective. All standards will be revised, and all parties using this standard should explore the possibility of using the latest versions of the following standards.

GB/T

4667-1995 Determination of width of woven fabrics GB/T 7689.1-87 Textile glass fiber woven fabrics-Determination of thickness GB/T 7689.4-89 Textile glass fiber woven fabrics, determination of width and length GB/T 10111-88 Random sampling method using random number dice

3 Requirements

3.1 Specifications of coated cloth base cloth

3.1.1 The thickness of the coated fabric base fabric shall be ≤ 0.50 mm.

3.1.2 The width of the coated fabric base fabric shall comply with the requirements in Table 1.

Table 1 Width of coated cloth base cloth mm

Number 1 2 3

Width 915 15-5 1320 15-5 1610 15-5

3.2 Physical and Mechanical Properties of Coated Fabric

3.2.1 Longitudinal breaking strength of coated fabric base cloth, first grade product should be ≥ 2200 N/50 mm, secondary product should be ≥ 1800 N/50 mm.

3.2.2 Weft breaking strength of coated fabric base fabric, first grade product should be ≥ 2200 N/50 mm, secondary product should be ≥ 1800 N/50 mm.

3.2.3 Warp tearing force of coated cloth base cloth, first grade product should be ≥ 300 N, secondary product should be ≥ 250 N.

3.2.4 Weft tearing force of coated base cloth, first grade product should be ≥ 300 N, secondary product should be ≥ 250 N.

3.2.5 The elongation at break of the base cloth of the coated fabric should be $\leq 10\%$.

3.2.6 The elongation at break in the weft direction of the coated base fabric shall be $\leq 10\%$.

4 Test method

4.1 Determination of thickness of coated fabric base fabric 7689.1.

4.2 Determination of width of coated fabric base fabric 4667 and GB/T 7689.4.

4.3 The determination of warp and weft breaking strength and elongation at break of coated base fabric shall be carried out in accordance with the provisions of Appendix A.

4.4 The measured warp and weft tearing force of coated fabric base fabric shall be determined in accordance with Appendix B.

5 Inspection rules

5.1 Factory inspection and type inspection

5.1.1 The factory inspection of coated fabrics shall be inspected batch by batch by the quality inspection department of the manufacturer according to the items specified in Table 2.

Table 2 Factory inspection and type inspection of coated cloth

Inspection item factory inspection type inspection 3.1.1 sqrt sqrt 3.1.2 sqrt sqrt 3.2.1 sqrt sqrt 3.2.2 sqrt sqrt 3.2.3-sqrt 3.2.4-sqrt 3.2.5-sqrt 3.2.6-sqrt Note.

"sqrt" means should be checked; "-" means not to check

5.1.2 The type inspection of coated cloth base cloth shall be inspected by the quality inspection department authorized by the state according to the items specified in Table 2.

5.1.3 Type inspection should be carried out in one of the following situations.

- a) Trial-type identification when new or old products are transferred to production.
- b) After formal production, if there are major changes in materials and processes, which may affect product performance;
- c) When production resumes after 1 year of production suspension;
- d) When the national product quality supervision department requests the type inspection.

5.2 Sampling method and grouping rules

5.2.1 A certain number of unit products of the same specification and the same production process are produced stably and continuously as a batch. When both the supplier and the buyer settle the inspection, Take the shipment batch as the inspection batch.

5.2.2 Physical and mechanical properties of coated base cloth (warp and weft tear strength, warp and weft tear force, warp and weft tear elongation) GB/T 10111 sampling method at a distance from the cloth end 5 Randomly selected outside m, the number of samples is 4 m2.

6 Decision rules

6.1

For the items that fail the inspection, double samples shall be taken from the same batch of products to retest the unqualified items.

The item was judged unqualified.

6.2

The warp and weft tearing strength and warp and weft tearing force of the coated base fabric are judged to be unqualified if any of them fails.

6.3

If there are two unqualified items in other items, the batch of products is judged as unqualified.

Appendix A

(Standard appendix)

Determination of warp and weft breaking strength and elongation of coated base fabric A1 Principle the specimen is stretched on a constant speed tensile machine at a certain pulling speed to the maximum tensile force measured during the fracture and the increase in specimen length Added value.

A2 Equipment

A2.1 The measurement range is 0 ~ 5 kN, constant speed tensile machine with accuracy of $\pm 1\%$.

A2.2 The tensile machine shall have a speed regulating device and an elongation measuring device.

A2.3 The center points of the upper and lower clamps of the tensile machine should be within the tensile axis.

The samples should be in the same plane. The effective width of the gripper jaws should not be less than 60 mm, the clamping surface should be able to clamp the specimen without sliding, if necessary Clamps with lines, grooves, or corrugated surfaces can be used. The clamping surface can be lined with appropriate materials to avoid damaging the specimen.

A3 Test conditions

The temperature of the laboratory is 20 ± 2 °C, relative humidity is $(65 \pm 5)\%$. When testing under non-standard conditions, the test site should be recorded Point temperature and relative humidity.

A4 Sample and preparation A4.1 Sample according to GB/T 10111 standard random sample (5 from the cloth end)