

Table 3 Appearance defect requirements (Continue)

Category	Defects name	Superior grade product	First grade product	Qualified grade product
<p>Note 1: See Annex B for description of appearance defects.</p> <p>Note 2: Description of defect degree: ——Not obvious: refers to a relatively vague defect that can be faintly seen by inspectors but barely seen by non-professionals. ——Obvious: refers to the defect with a relatively clear boundary that can be seen directly.</p> <p>Note 3: Minor part refers to the part where the defect has little influence on the wearing, such as areas on both sides of 1/6 of the side seam and 1/6 of the sleeve bottom seam of the coat, or 1/5 of the length of the trousers below the waist and both sides of 1/6 of the inside seam of the trousers.</p> <p>Note 4: The colour difference is rated according to GB/T 250.</p> <p>Note 5: Appearance defects not listed in this table may be rated referring to similar defects.</p>				
<p>^a Yarn joint defects are not allowed on the face.</p> <p>^b Colour difference is not tested for patchwork fabrics.</p>				

6 Test method

6.1 Inspection of safety requirements

Inspection of safety requirements shall be carried out according to items and test methods specified in GB 18401 and/or GB 31701.

6.2 Internal quality

6.2.1 Fibre content

Perform the test as specified in GB/T 2910 (all parts), GB/T 16988, FZ/T 01026, FZ/T 01057 (all parts), FZ/T 01101, FZ/T 01112, etc.

6.2.2 Mean fibre diameter of cashmere

Perform the test as specified in GB/T 10685.

6.2.3 Bursting strength

Perform the test as specified in GB/T 7742.1 or GB/T 7742.2, the test area shall be 7,3 cm² (diameter 30,5 mm), and the arbitration shall be conducted according to GB/T 7742.1.

6.2.4 Cover factor

Perform the test as specified in FZ/T 70008.

6.2.5 Pilling

Perform the test as specified in GB/T 4802.3, 10 800 r for worsted products and 7 200 r for semi-worsted and woollen products, evaluate the pilling grade by comparing with GSB 16-3239.

6.2.6 Spirality angle

Perform the test as specified in FZ/T 20011, the washing procedure is 7A, wash one time.

6.2.7 Dichloromethane-soluble matter

Perform the test as specified in FZ/T 20018.

6.2.8 Alkylphenols and alkylphenol ethoxylates

Perform the test as specified in GB/T 23322.

6.2.9 Dimensional change of dry-cleaning

6.2.9.1 Perform the test as specified in GB/T 19981.2, wash once with highly sensitive material according to dry-cleaning procedures without ironing. Prepare samples as specified in FZ/T 70009-2012, see Annex A for measurement parts for patchwork clothing.

6.2.9.2 Calculate the dimensional change of dry-cleaning for each pair of marking points in length and width directions of the test specimen according to Formula (1)

$$L = \frac{l_1 - l_0}{l_0} \times 100 \quad \dots \dots \dots (1)$$

where:

L dimensional change of dry-cleaning, %;

l_0 original size before washing, in millimeter (mm);

l_1 size after washing, in millimeter (mm).

6.2.9.3 The final result of dimensional change of dry-cleaning is the average value in length and the average value in width directions, the final result shall be accurate to 0,1%.

6.2.10 Mass deviation per piece

6.2.10.1 After balanced for 24 hrs under the temperature of $20\text{ }^{\circ}\text{C} \pm 2\text{ }^{\circ}\text{C}$ and relative humidity of $65\% \pm 4\%$, the samples are weighed one by one and accurate to the nearest 0,5 g, calculate the average value to obtain the initial mass (m_1) of a single finished product.

6.2.10.2 Cut 2 specimens for moisture regain test from one of the samples, each specimen weight is not less than 10 g, measure the actual moisture regain of the test specimen according to GB/T 9995.

6.2.10.3 Calculate the conventional mass of a single finished product according to Formula (2), accurate to 0,1 g (conventional moisture regain is as specified in GB/T 9994).

$$m_0 = \frac{m_1 \times (1 + R_0)}{1 + R_1} \quad \dots \dots \dots (2)$$

where:

m_0 conventional mass of a single finished product, expressed in gram (g);

m_1 the initial mass of a single finished product, expressed in gram (g);

R_0 conventional moisture regain, %;

R_1 tested moisture regain, %.

6.2.10.4 Calculate the single piece mass deviation of finished product according to Formula (3), accurate to 0,1%.

$$D_G = \frac{m_0 - m}{m} \times 100 \dots\dots\dots (3)$$

where:

D_G a single piece mass Deviation, %;

m_0 conventional mass of a single finished product, expressed in gram (g);

m specified mass of a single finished product, expressed in gram (g).

6.2.11 Colour fastness to light

Carry out the test according to method 3 specified in GB/T 8427-2019.

6.2.12 Colour fastness to washing

Perform the test according to GB/T 12490-2014, hand washing with care products shall be subject to condition A1S, machine washable products shall be subject to condition B2S.

6.2.13 Colour fastness to perspiration

Perform the test as specified in GB/T 3922.

6.2.14 Colour fastness to water

Perform the test as specified in GB/T 5713.

6.2.15 Colour fastness to rubbing

Perform the test as specified in GB/T 3920.

6.2.16 Colour fastness to dry-cleaning

Perform the test as specified in GB/T 5711.

6.2.17 Colour fastness to transfer in joints

Perform the test according to method A in GB/T 31127-2014.

6.2.18 Dimensional change after washing

Perform the test as described in FZ/T 70009-2012, refer to Annex A for measurement positions of stitching clothing.

6.3 Appearance quality inspection

6.3.1 Conditions of appearance quality inspection

6.3.1.1 Generally, the inspection is carried out under the light using two 40 W fluorescent lamps with lampshade. The distance between the lamp tube and the center of the inspection table is 80 cm \pm 5 cm. The natural north light is preferable for natural light source.

6.3.1.2 The finished product shall be spread on the table during the inspection, the inspector shall face the finished product, the distance between the viewing eyes and the center of the finished product is about 45 cm.

6.3.1.3 Use steel tape to measure the dimensions of test specimen.

6.3.2 Inspection method for specifications and dimensions

The measurement methods for the main parts of finished products are shown in Table 4 and Figure 1.

Table 4 Specification measurement method

Category	Name	Measurement method
Tops	Cloth length	Measure down from the top of the shoulder to the bottom of the hem
	Chest breadth	Measure horizontally at 1,5 cm below armpit
	Sleeve length	Set-in sleeve refers to the distance from the highest point of sleeves to cuff hem, raglan sleeve refers to the distance from the middle point of back neckline to the cuff hem through the peak point.
Trousers	Trousers length	Measure down from 1/4 of the back waist width down to the hem of the trouser.
	Straight crotch	The trousers is folded relative to each other, and measure downward from the upper side of waist band to the crotch angle.
	Cross crotch	The trousers is folded relative to each other, and measure horizontally from the crotch angle.
Skirt (Half slip)	Skirt length	Measure down from 1/4 of the back waist width down to the hem of the skirt.
	Hip breadth	Measure horizontally at 20 cm below waist (straight skirt only).
Skirt (Dress)	Skirt length	Measure down from the top of the shoulder to the hem of the skirt.
	Chest breadth	Measure horizontally at 1,5 cm below armpit.
	Sleeve length	Set-in sleeve refers to the distance from the highest point of sleeves to cuff hem, raglan sleeve refers to the distance from the middle point of back neckline to the cuff hem through the peak point.
	Hip breadth	Measure horizontally at 20 cm below waist (straight skirt only).
Scarf	1/2 length	Fold the scarf in half along the length direction, measure the half length (excluding tassel length).
	Width	Transverse measuring the middle of scarf.

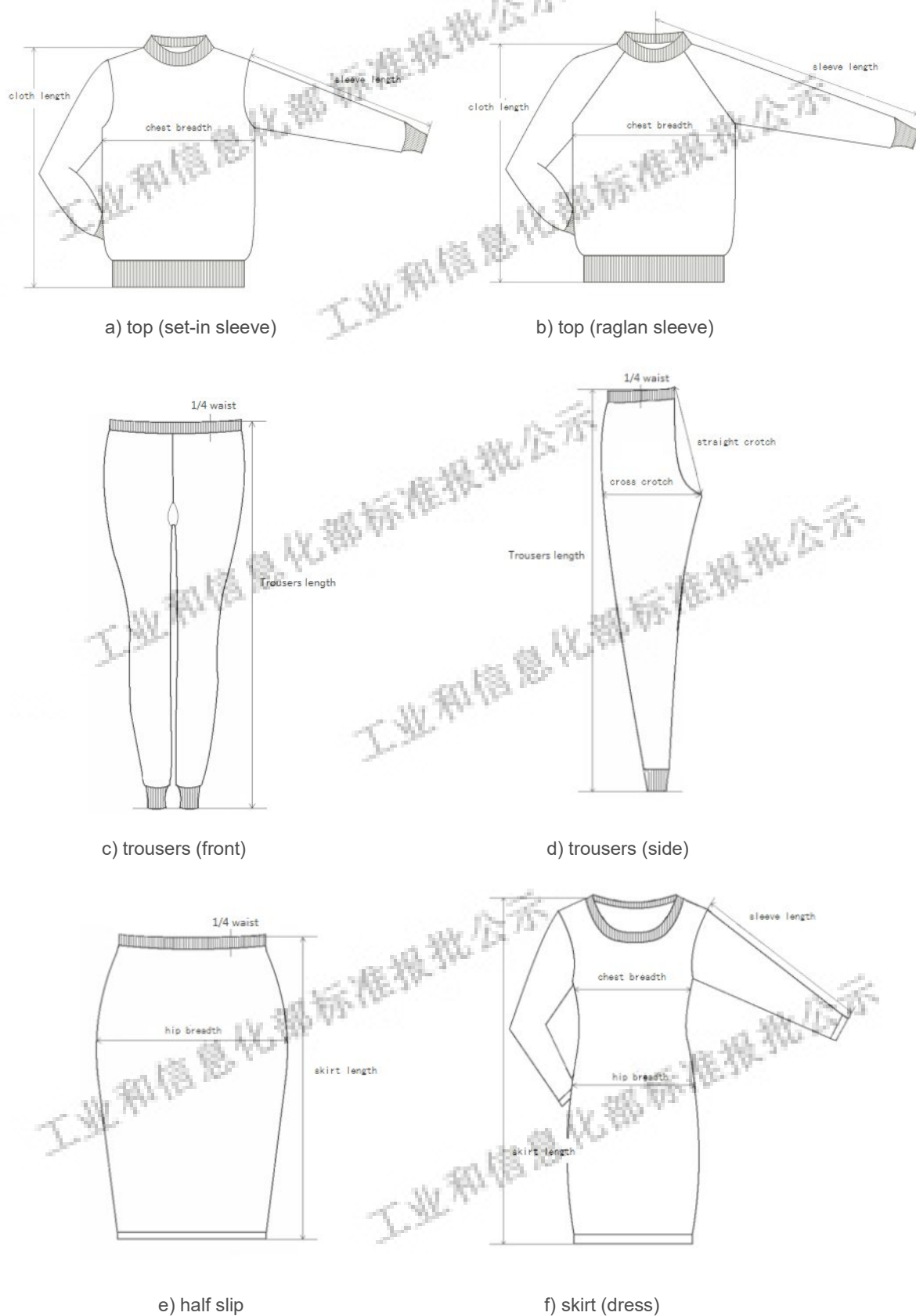
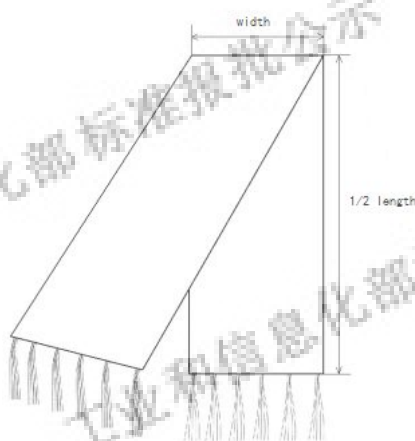


Figure 1 Schematic diagram of size inspection of main parts



f) scarf

Figure 1 Schematic diagram of size inspection of main parts (Continue)**6.3.3 Test of seam elongation**

Perform the test according to FZ/T 20031, the load is 33 N.

6.3.4 Test of collar opening stretchability

Perform the test according to FZ/T 20032, the load is 33 N.

7 Inspection rules**7.1 sampling**

7.1.1 Products of the same batch of raw material, variety and quality shall be taken as one inspection batch.

7.1.2 Samples of internal quality and appearance quality shall be randomly selected from the inspection batch.

7.1.3 Samples for internal quality inspection shall be selected according to lots, and the number of samples shall meet the requirements of various tests.

7.1.4 Samples for colour fastness test shall include all colour numbers of the batch.

7.1.5 3% (at least 10 pieces) shall be selected by batch for samples of the single mass deviation rate test.

7.1.6 The number of samples for appearance quality inspection shall be in accordance with the one-time sampling scheme for normal inspection, general inspection level II and acceptance quality limit AQL = 2,5 in GB/T 2828.1-2012, and the specific scheme is shown in Table 5.

Table 5 Sampling plan for appearance quality inspection

Number (N)	Sample Capacity (n)	Acceptance Number (Ac)	Rejection Number (Re)
2~8	5	0	1
9~15	5	0	1
16~25	5	0	1
26~50	5	0	1
51~90	20	1	2
91~150	20	1	2
151~280	32	2	3
281~500	50	3	4
501~1 200	80	5	6
1 201~3 200	125	7	8
>3 200	200	10	11

7.2 Judgment rules

7.2.1 Assessment of internal quality

The internal quality of batch samples shall be tested according to 5.3, if all requirements are met for the corresponding products, the internal quality is qualified, otherwise, it is unqualified. If the internal quality of all samples is qualified, the internal quality of the batch of products is qualified; otherwise, the internal quality of the batch of products is unqualified. Colour fastness grade is accessed to different colour numbers. When the colour fastness of some colour number is unqualified, only the products of that colour are judged as unqualified.

7.2.2 Assessment of appearance quality

The appearance quality of batch samples shall be tested according to 5.4, if all requirements are met for the corresponding products, the appearance quality is qualified, otherwise it is unqualified. If the appearance quality of all samples is qualified, or the number of unqualified samples does not exceed Acceptance Number (AC) in Table 5, the appearance quality of the batch of samples is qualified; if the number of unqualified samples reaches the Rejection Number (Re) in Table 5, the appearance quality of the batch of products is unqualified.

7.2.3 Comprehensive assessment

7.2.3.1 If all products do not meet the requirements of GB 18401, and infants and children's products do not meet the requirements of GB 31701, the products are judged unqualified.

7.2.3.2 According to the marked products, if both the internal quality and the appearance quality are qualified, the batch of products is qualified; if any item of the internal quality or appearance quality is unqualified, the batch of products is unqualified.

8 Re-inspection rules

In the case that any dispute arises concerning the test results of the inspection batch, re-inspection may be submitted. The re-inspection rules shall be conducted according to the initial inspection, the re-inspection result is the final result.

9 Packaging and marking

9.1 Packaging

9.1.1 The packaging of product shall be conducted as described in GB/T 4856.

9.1.2 Attention shall be paid to moth proofing in the packaging of cashmere knitting goods.

9.2 Marking

9.2.1 Instructions and labelling for each single cashmere knitwear shall conform to GB/T 5296.4 and GB 18401, Those instructions and labelling for infant's and children's products shall conform to GB/T 5296.4 and GB 31701.

9.2.2 The main specification and dimension of ordinary cashmere knitwear are expressed in centimeters. Mark chest breadth for tops; mark length for trousers and mark hip breadth for skirts. Or alternatively mark as specified in GB/T 1335 (all parts).

9.2.3 Slim fit or fashionable cashmere knitwear may be marked with the appropriate wearing range in centimeters. For example, if a top is marked 95 to 105, it indicates the appropriate range of wearing is 95~105 cm of chest circumference. Or alternatively mark as specified in GB/T 1335 (all parts).

9.2.4 Scarves shall be labeled with their geometric dimensions. For example, rectangular scarves and shawls shall be labeled with length x width (excluding tassel length), while triangular scarves and shawls shall be labeled with bottom length x height (excluding tassel length), in centimeter.

9.2.5 Other products shall be marked according to specifications in corresponding product standards.

10 Others

Other requirements of both parties shall be carried out in accordance with the contract.

Annex A (Normative)

Measuring positions of washing and dry-cleaning dimensional change for patchwork garment

A.1 When measuring the length of the top in the straight direction, measure down from the top of the shoulder to the bottom of the hem. The average length of the front, back, left and right sides is used as the calculation basis. When measuring in the width direction, measure horizontally 5 cm below armpit. The measurement value of the front is taken as the calculation basis, and marks are made before the measurement so as to facilitate the measurement after washing. The way of measuring top is shown in Figure A.1.

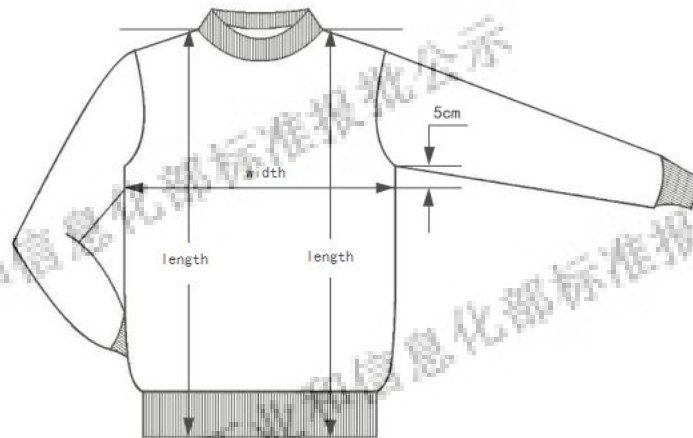


Figure A.1

A.2 Four groups of marks are made for the length direction of trousers: the inner ends (a_1 and a_2) and the outer ends (b_1 and b_2); the width directions are marked with three groups: waist (c), knee (d) and trousers opening (e), as shown in Figure A.2 and Figure A.3.

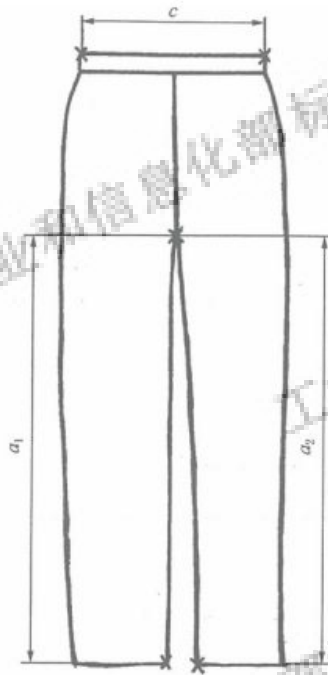


Figure A.2

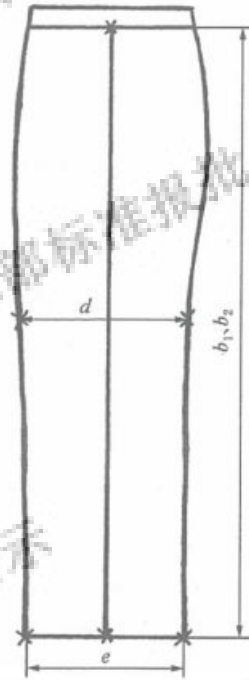


Figure A.3

A.3 Three groups of marks are made in the direction of skirt length: skirt length of three parts (a_1 , a_2 , a_3); Three groups of marks are made in the direction of width: skirt waist (b), two ends of skirt hem (c), and two ends of middle of skirt length (d), as shown in Figure A.4.

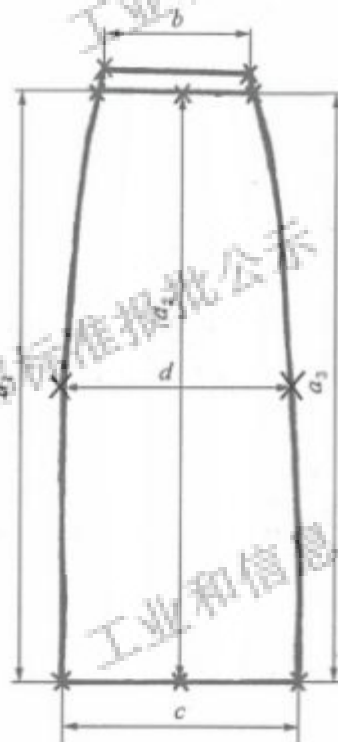


Figure A.4

Annex B

(Normative)

Description of appearance defects

B.1 Unevenness: Due to the yarn unevenness in short distance, the finished product presents shade cloud spots.

B.2 Thick or thin nep: Thick nep refers to a large and protruding bar formed on the product, thin nep refers to a small concave bar formed on products; these defects are often caused by uneven yarn in short length.

B.3 Thick or thin bar: The thickness difference is too large, so that the product appears obvious thin and thick fragments, these defects are often caused by uneven yarn in long length.

B.4 Uneven dyeing: Due to uneven absorption of raw materials during dyeing, the product shows different colour depth.

B.5 Colour bar: Due to uneven colour, products with obvious boundaries on the piece.

B.6 Burr, Neps, Wool flake: There are impurities such as burr, neps, wool flakes on the yarn, which affects the appearance of the product.

B.7 Fuzz stitch: Because of the needle tongue or shaft damaged or they are prickly, part yarn of the loop is fuzzed during knitting.

B.8 Split stitch: Part yarn in the loop (less than 1/2) is split from the needle during knitting.

B.9 Tucking: Due to equipment reasons, large and slightly protruding loops on the finished product;

Birdeye (butterfly loop): Two loops overlap in a loop hole to form a triangular hole on the finished product.

Flat loops: The pattern on the finished product is not prominent, such as grenadine motif is not fat, cardigan stitch is not protruding, etc.

B.10 Uneven loops: Due to poor knitting, the finished product has different loop size and slazy knitting, there are some defects on the product, such as band, tight loops, thin or thick place, etc.

B.11 Inner yarn out of the surface: In interknitting product, the inner yarn is exposed on the surface of the fabric.

Uneven mixing: Uneven mixing of different colour fibres.

B.12 Pattern misregister: Incorrect pattern or misfit of screen printing, discharge printing or jacquard fabric.

B.13 Dropped stitch, Drop out: In the process of knitting, the loop is not covered, forming small holes, or multiple loops are drop out into larger holes

Hole: Small holes formed during knitting due to loosed joints or broken yarns.

B.14 Poor overseam stitch and embroidery: Thin stitch, uneven stitch, leaky stitch, open stitch, etc., the embroidery is out of shape, flower position skew, colour and spacing mismatch.

B.15 Poor buttonhole or poor fixed button: Different spacing of buttonholes, obvious skewness, uneven stitch or wrong buttonholes; the button position and buttonhole are inconsistent, and the stitching knot is not firm.

B.16 Burl mark: The marks left by the repair of the fabric.

B.17 Stain: Local stains on the surface of the fabric, including rust, water spot, oil stains, etc.

B.18 Colour difference: The colour and luster of products are different

B.19 Poor dyeing: Uneven dyeing, skitteriness and poor dye penetration at joints caused during the dyeing of finished process.

B.20 Iron spot: The finished products are ironed and shaped improperly, resulting in deterioration, yellowing and coking due to fibre damage.
