

信迪服饰有限公司/ZIPPERONESHOP CO., LTD.

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|  | 互拼长拉链测试指导 | 文件号/Doc.no | |
| | Guide line for interchangeable (long) zippers | 页码/Page | 1 |
| 部门/Dept. | 品管部 /Quality Dept. | 总页数/Total | 4 |

1.0 目的/ Purpose

评价互拼链带长度，确保拉链在规定的标准范围内。

Evaluate the length of interchangeable zipper to ensure that the zipper is within the specified standard range

2.0 范围/ Scope

长度 $L \leq 315\text{mm}$ ，偏差 $\pm 3\text{mm}$

$315\text{mm} < L \leq 630\text{mm}$ ，偏差 $\pm 5\text{mm}$

$630\text{mm} < L \leq 1000\text{mm}$ ，偏差 $\pm 6\text{mm}$

$L > 1000\text{mm}$ ，偏差 $+2\text{CM}$

3.0 安全事项/ Safety Warning

在检查范围内，竖起警告标致，慎防拉链跌落，引致员工跌倒。

In the inspection area, erect a warning Peugeot to prevent the zipper falling down, causing someone to fall.

4.0 人员资格/ Personnel Qualification

进行测试人员须通过相应培训并经品管部授权。

Personnel who conduct the test should be trained and authorized by Quality Dept.

5.0 测试材料/ Materials

长台一张 Long table

长捲尺 Long tmeasure tape

6.0 测试项目 / Apparatus

| 方块/插销 | 方块插销应无毛刺和刺手的棱角 | 拉链封样 | 手感 |
|--------------------------|--|-----------------|------------------------------|
| Pin/Box | Square bolt shall be free of burrs and prick edges and corners | | Hand feeling |
| 牙链带检查 | 布带染色要均匀，无杂色，上下批次色泽应一致无褪色（白色织物包裹三公斤的砝码，在织物上往复擦拭十次，白色织物不应有明显异色），异常时送中心做色牢度测试 | 拉链封样 | 目测+砝码 |
| Zipper chain examination | Zipper chain dyeing should be uniform, no variegated color, the upper and lower batches of color should be consistent without fading (white fabric wrapped with a weight of three kilograms, wipe on the fabric for ten times, white fabric should not have obvious different colors), abnormal sent to the center for color fastness test | Attached sample | Visual inspection add weight |

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| 部门(Dept.) | 品管部 (Quality Dept.) | 总页数 | 4 |

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|--------------------------|--|-----------------|-------------------|
| 拉链头检查 | 1) 拉链头表面喷涂层牢固, 均匀一致, 无气泡, 无脱落, 拉头拉启轻松, 顺畅, 锁固而不滑脱, 拉片翻动灵活。 2) 拉链头部不可装返 (依样板) | 拉链封样 | 目测 |
| Slider examination | 1) The spraying layer on the surface of the zipper slider is firm, uniform and consistent, without bubbles and peel off, the slider is lightly and smoothly in pulling and opening, locked without slipping off, and the puller is flexible in turning over. 2) The slider cannot be installed back (according to the template) | Attached sample | Visual inspection |
| 链牙检查 | 整条拉链零部件齐全, 链齿排列整齐, 不得有缺齿和坏齿 | 拉链封样 | 目测 |
| Zipper chain examination | The whole zipper parts are completed, and the chain is arranged in a neat way, so it is not allowed. There are missing teeth and broken teeth | Attached sample | Visual inspection |

6.1 测试标准与要求 / Test standards and requirements

| 检验项目 | 检验标准及要求 | 检验工具 | 检验方法 |
|----------------------------|--|-----------------|---------------------------------------|
| Inspection items | Inspection standards and requirements | Inspection tool | Inspection method |
| 开尾拉链插拔 | 插拔启动应灵活无卡阻, 加强胶带与布带应粘合牢固, 整齐, 加强胶带应无发白, 起层 (插拔10次无异常) | 拉链封样 | 目测+手感 |
| Open-end Pin & Box | The insertion and extraction of the start-up should be flexible and free of jamming, strengthening the tape and zipper. The tape should be firmly bonded and neatly arranged, and the reinforced tape should be free of turn pale or peeling (no abnormality after 10 times of insertion and extraction) | | Visual inspection + hand feeling |
| 拉链互配性检查 | 1) 尼龙拉链同批次, 上下批次应可实现互配, 背后最大误差小于1cm 2) 树脂拉链应可以完全互配 | | 目视+测量 |
| Zipper compatibility check | 1. The same batch of nylon zippers should be inter-compatible with different batches, with a maximum error of less than 1cm in the back. 2. Resin (Plastic) zippers should be fully inter-compatible. | | Visual + measurement |
| 气味检测 | 无刺激性气味 | | 嗅觉, 与样品对比 |
| Odor detection | No pungent odor | | Sense of smell, compared with samples |

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| 部门/Dept. | 品管部 /Quality Dept. | 总页数/Total | 4 |

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|--|--|-------------------------------|---|
| 尺寸检查 | 拉链尺寸参数, 和允取公差见附表2 | 钢卷尺 | 目视+测量 |
| Dimensional inspection | See Schedule 2 for zipper size parameters and allowable tolerances | Steel tape measure | Visual + measurement |
| 平整度检测 | 见附表3 | | 目视+测量 |
| Flatness detection | See Schedule 3 | | Visual + measurement |
| 强度测试 | 强度测试, 尼龙拉链见附表4、树脂拉链见表5 | 拉力计 | 见图附表3、附表4 |
| Strength test | Strength test: See appendix 4 for nylon zippers and appendix 5 for resin zippers. | Tension gauge | See appendix 3 and 4 of the figure |
| 牙链带色牢度测试 | 耐摩擦色牢度:4级 | 摩擦色牢度测试仪 | GB/T3920 GB/T250 |
| Color fastness test of zipper chain tape | Colour fastness to rubbing: Grade 4 | Rubbing color fastness tester | GB/T3920 GB/T250 |
| 甲醛检测 | ≤75mg/Kg | 空气质量检测仪 | GB/T19941 |
| Formaldehyde detection | ≤75mg/Kg | Air quality detector | GB/T19941 |
| RoHS | 有毒物质行值应符合欧盟(EU)2015-863-RoHS-2 和我司管控要求 | | GB/T39560. 301 GB/T39560. 6 GB/T39560. 6. 701 GB/T39560. 8 |
| RoHS | The row value of toxic substances shall conform to the European Union (EU) 2015-863- | | GB/T39560. 301 GB/T39560. 6 GB/T39560. 6. 701 GB/T39560. 8 |

6.2 拉链尺寸及容许公差表 (2)/Zipper Dimensions and Acceptable Tolerance Table (Appendix 2)

Zipper Dimensions and Acceptable Tolerance Table

| 拉链规格 | 拉链尺寸(cm) | 公差尺寸(cm) |
|---|--------------------------|---|
| Zipper specification | Zipper dimensions (cm) | Tolerance dimension (cm) |
| 特殊要求:树脂拉链3#4#5# | 26cm 33cm 40cm 45cm 48cm | 公差尺寸控制在+0.3以内 |
| Special requirements: Resin zipper 3 # 4 # 5 # | 26cm 33cm 40cm 45cm 48cm | Tolerance dimensions are controlled within +0.3 |
| 3# 4# 5# 拉链 Zipper | L(长度) <31.5 | ±0.3 |
| | L(长度) 31.5-63 | ±0.5 |
| | L(长度) 63-100 | ±0.6 |
| | L(长度) <31.5 | ±0.4 |
| | L(长度) 31.5-63 | ±0.6 |
| | L(长度) 63-100 | ±0.8 |
| 所有拉链 All zippers | L(长度) >100 | ±0.10 |

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6.3 拉链平整度允许公差标准/ Appendix 3 Tolerance standard for flatness of zipper

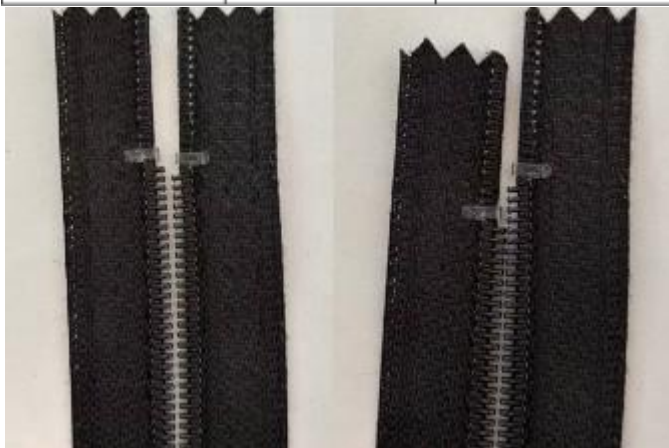
| | | | | |
|--|------|---------|---------|----------|
| 拉链长度尺寸 单位毫米 Zipper length dimension unit millimeter | ≤180 | 180~315 | 315~630 | 630~1000 |
| 平整度 (波浪弯高度/mm) Smoothness (wave bend height/mm) | ≤8 | | | |
| 波浪弯允许个数 Permissible number of wave bends | 1 | 3 | 5 | 7 |

6.4 表4 尼龙拉链物理性能强度测试/ Appendix 4 Physical properties and strength test of nylon zipper

| 测试项目 Test item | 标准要求 Standard requirements | | | | 检测方法 Detection method |
|--|----------------------------|-----|-----|-----|--------------------------|
| | 3# | 4# | 5# | 8# | |
| 平拉强力(N) ≥ Flat tensile strength (N) ≥ | 380 | 400 | 600 | 800 | OB/T 2173-2014. 7. 2. 1 |
| 拉链头自锁强力 (N) ≥ Self-locking strength of slider (N) ≥ | 20 | 30 | 35 | 60 | OB/T 2173-2014. 7. 2. 12 |

6.5 结果评定/ Assessment of Results

| | | | | | |
|-------|-----------|---------------------|-----------|-----|-------------------|
| 耐盐雾测试 | 5%浓度 24小时 | 要求无任何变色腐蚀等现象 | | | |
| 互配率 | 100% | 同尺寸拉链任意互配后齿牙错齿≤3颗链齿 | | | 拉链任意互配后顺滑度要符合行业标准 |
| 色差值 | 厂家标准 | L: 颜色明暗度 控制1.5以内 | A: 红绿光偏差值 | 色差值 | 1.5级以上判定不合格 |



正确 ✓ Correct

最大容忍公差5~8% Maximum Tolerance 5~8%

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