

测科企业标准
Corporate Standard of TESTEX

TS M002-2020

口罩弹性耳带质量管控标准

Quality Control Standard of Elastic Earloops for Face Mask

2020-05-08 released

2020-05-09 implemented

Released by TESTEX INSTRUMENT LTD

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Foreword

This standard is the recommended standard for guiding mask manufacturer to buy the suitable mask earloops. Since the implementation of this standard, as the supply standard and production standard of elastic earloops for medical masks, it is only used for the production of masks.

1 Scope of application

This standard is used to regulate the elastic earloops used in the production of masks, to guide the production process of the masks, and to solve the following problems: the welding of the earbands is not firm, the length of the earloops is different, and the earloop feed card machine and other problems.

2 Product specification

Earloops for flat masks: wire diameter 3mm, gram weight 800m/kg, that is 1kg for 800 meters.

KN95 ear loops: wire diameter 5mm, gram weight 400m/kg, that is 1kg for 400 meters.

3 Technology requirement

3.1 Non-toxic, Non-cancerous, No skin irritation, odorless.

3.2 No harm to the wearer in use.

3.3 Inner quality requirements for elastic ear straps of masks.

Elongation ratio	1: 2.5 and below
Tensile elastic rate /%	N75
Formaldehyde content (mg/kg)	≤20
pH value	4.0-7.5
Odor	No

3.4 Exterior quality requirements

Item		Technical requirements
Width	3mm,5 mm	±0.5mm
Stains		3 and below
Fracture elasticity		Not allowed
Oil filament		Not allowed
Broken edge		Not allowed
Note 1: Masks with stains, fracture elasticity, oil filaments, broken edges, etc. are evaluated with a unit length of 45 m per roll (tube), and if they are exceeded, they will be converted accordingly.		

4 Experiment method

4.1 pH test According to GB/T 7573

4.2 Formaldehyde content According to GB/T 2912.1

4.3 Odor test According to GB 18401

4.4 Decomposable carcinogenic aromatic amine dye test According to GB/T 17592

4.5 Elongation ratio: The ratio of the tension-free 10cm length to the length after stretching to the limit

4.6 Tensile elastic recovery rate test

According to the regulations in Chapter 9.3.3 of FZ/T 60021-2010, the fixed elongation is 50%, and the number of repeated stretching is 5 times

4.7 Appearance quality inspection

Use indoor north-facing natural light source. If the light source is insufficient and the illuminance is less than 600lx, the illuminance can be supplemented at a distance of (80cm±5cm) at a 40W fluorescent lamp.

4.8 The width deviation is executed according to the fifth check in FZTT60021-2010

4.9 Fracture elasticity means that the elastic material in the elastic earloop of the mask breaks or loses its elasticity, and the product shrinks or becomes excessively narrowed. It is evaluated by visual inspection and feel.

5 Packaging, transportation and storage

5.1 Products with different batch numbers, varieties, and specifications should be packaged separately and marked separately. The outer packaging should indicate the article number, product name, specifications, quantity, factory name, factory address, production date, product implementation standards, etc.

5.2 Mask elastic earloops generally have side-by-side, tube-shaped, twisted, and other packaging methods, which can be used according to mask production needs and user requirements.

5.3 During product transportation and loading and unloading, do not drag or hook to avoid damage to the packaging and product.

5.4 The product should be stored in a ventilated, dry, clean warehouse and protected from moth and poison.