

**测科企业标准**  
**Corporate Standard of TESTEX**  
TS M003-2020

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口罩用无纺布质量管控标准

**Quality Control Standard of Non-Woven Fabric for Face Mask**

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# Catalog

Foreword

- 1 Scope of application
- 2 References
- 3 Terms and definitions
- 4 Technology requirement
- 5 Experiment method
- 6 Marks, packaging, transportation and storage

## Foreword

This standard is the recommended standard for helping mask manufacturers buying the right mask material- pp non-woven. Since the implementation of this standard, as a non-woven fabric supply standard and production standard for the production of Meike masks, it is only used for the production of masks.

### 1 Scope of application

This standard is used to standardize the non-woven fabrics used in the production of masks, to guide the production process of masks, and to solve the following problems: deviations in mask size, excessive breathing resistance and other problems.

### 2 Reference

GB 19083-2010 Technical requirements for medical protective masks

### 3 Terms and definitions

Width 175mm	Width 195mm	Width 260mm	
Weight 25g	Weight 25g	Weight 25g	Weight 50g
Diameter 55mm	Diameter 55mm	Diameter 55mm	Diameter 55mm

#### 4 Technology requirement

Safety and health requirements	Health and Safety	1. Dry, no mildew or moth-eaten phenomenon; 2. No arthropods or cockroach eggs that are harmful to health; 3. No inclusion of silt and metal objects, miscellaneous plastic braid	
Exterior	Marks	Product model specification/manufacturer/ batch number/quantity are clear and complete	
	Width	±3mm	
	Surface	The thickness is uniform, the surface is smooth, there are no obvious creases, and the package is neat; no holes, cracks or cuts are allowed.	
Odor	Odor	No odor or irritating smell	
physicochemical properties	Wiegth	Specification: 25 g/m <sup>2</sup> with tolerance of ±2 g/m <sup>2</sup> Specification: 50 g/m <sup>2</sup> with tolerance of ±3 g/m <sup>2</sup>	
	VOC	No compounds that may release carcinogenic VOCs	
	Pathogenic bacteria	Pseudomonas aeruginosa, Staphylococcus aureus, hemolytic streptococcus should not be detected Pathogenic bacteria	
	REACH	Conforms to the latest 163 requirements of REACH, as well as carcinogenic and sensitizing requirements	
	Formaldehyde	Formaldehyde content ≤ 20mg/Kg	
	pH	pH 4.0-8.5	
	Ash	Ash content ≤ 2%	
	Tension and elongation (25g/m <sup>2</sup> )	Breaking tension (N)	Breaking elongation (%)
		Horizontal≥20, Portrait≥25	Horizontal≥50, Portrait≥ 100
	Tension and elongation (30g/m <sup>2</sup> )	Breaking tension (N)	Breaking elongation (%)
		Horizontal≥35, Portrait≥45	Horizontal≥140, Portrait≥ 130
	Tension and elongation (50g/m <sup>2</sup> )	Breaking tension (N)	Breaking elongation (%)
		Horizontal≥60, Portrait≥90	Horizontal≥130, Portrait≥ 120

## 5 Experiment method

### 5.1 Breaking strength and breaking elongation:

According to the method specified in GB/T 24218.3, the test shall meet the requirements of Table3. (Strip method: sample width 50mm, clamping distance 200mm, speed 100mm/min, the maximum force in the stretching process as the tensile strength)

### 5.2 Odor

Test according to the method specified in 6.7 of GB 18401-2010

### 5.3 Microbiological index

Test according to the method specified in Appendix B of GB 15979-2002

## 6 Marks, packaging, transportation and storage

### 6.1 Marks

6.1.1 The minimum information on the minimum packaging of the product should provide the following information:

- a) Production unit name, address, contact information;
- b) Product name, product specifications (gram weight, width, weight, etc.)
- c) Production batch number, validity period;

6.1.2 The following marks should be on the large packaging of the product:

- a) Production unit name, address, contact information;
- b) Product name, product specifications (gram weight, width, weight, etc.), quantity
- c) Production batch number, validity period;

6.1.3 The following marks shall be on the inspection certificate:

- a) production batch number;
- b) inspection date;
- c) inspector code;
- d) inspection pass seal.

### 6.2 Packing

Product packaging materials should ensure that the product quality is not damaged and convenient to transport.

### 6.3 Transportation

The product should be protected from light, water, moisture, pollution, breakage and crushing during transportation.

### 6.4 Storage

The product should be stored in a dry, ventilated, dark and clean environment, away from fire and

flammable materials.