Corporate Standard of TESTEX

Quality Control Standard of Non-Woven Fabric for Face Mask

2020-05-08 released

2020-05-09 implemented

Released by TESTEX INSTRUMENT LTD
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

<table>
<thead>
<tr>
<th>Width 175mm</th>
<th>Width 195mm</th>
<th>Width 260mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Weight 25g</td>
<td>Weight 25g</td>
<td>Weight 25g</td>
</tr>
<tr>
<td>Diameter 55mm</td>
<td>Diameter 55mm</td>
<td>Diameter 55mm</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Weight 50g</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Diameter 55mm</td>
</tr>
</tbody>
</table>
## 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;  
<table>
<thead>
<tr>
<th></th>
<th>3. No inclusion of silt and metal objects, miscellaneous plastic braid</th>
</tr>
</thead>
</table>

### Exterior

<table>
<thead>
<tr>
<th>Marks</th>
<th>Product model specification/manufacturer/ batch number/quantity are clear and complete</th>
</tr>
</thead>
<tbody>
<tr>
<td>Width</td>
<td>±3mm</td>
</tr>
<tr>
<td>Surface</td>
<td>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.</td>
</tr>
</tbody>
</table>

### Odor

| Odor                          | No odor or irritating smell |

### Physicochemical properties

| Wieght                        | Specification: 25 g/m 2 with tolerance of ±2 g/m 2  
<table>
<thead>
<tr>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>VOC</td>
<td>No compounds that may release carcinogenic VOCs</td>
</tr>
<tr>
<td>Pathogenic bacteria</td>
<td>Pseudomonas aeruginosa, Staphylococcus aureus, hemolytic streptococcus should not be detected</td>
</tr>
<tr>
<td>REACH</td>
<td>Conforms to the latest 163 requirements of REACH, as well as carcinogenic and sensitizing requirements</td>
</tr>
<tr>
<td>Formaldehyde</td>
<td>Formaldehyde content ≤ 20mg/Kg</td>
</tr>
<tr>
<td>pH</td>
<td>pH 4.0-8.5</td>
</tr>
<tr>
<td>Ash</td>
<td>Ash content ≤ 2%</td>
</tr>
</tbody>
</table>
| Tension and elongation (25g/m2) | Breaking tension (N) Breaking elongation (%)  
|                                | Horizontal≥20, Portrait≥25                                                    |
| Tension and elongation (30g/m2) | Breaking tension (N) Breaking elongation (%)  
|                                | Horizontal≥35, Portrait≥45                                                    |
| Tension and elongation (50g/m2) | Breaking tension (N) Breaking elongation (%)  
|                                | Horizontal≥60, Portrait≥90                                                    |
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.