

Finished Goods Testing Manual **FGT-22**

Rubbing aging of closure parts

Index Update – Rubbing aging of closure parts FGT-22

<i>Update Date</i>	<i>Changed Items</i>
05.04.07	<ul style="list-style-type: none"> ● Procedure adjusted to new format
19.09.07	<ul style="list-style-type: none"> ● Evaluation advise added.
29.08.08	<ul style="list-style-type: none"> ● Evaluation table with cycle amount added
11.12.08	<ul style="list-style-type: none"> ● Evaluation table revised according to feedback from Asia
23.12.08	<ul style="list-style-type: none"> ● Pictures revised
12.02.12	<ul style="list-style-type: none"> ● Test procedure update with pauses between cycles, Evaluation table guideline added
10.07.12	<ul style="list-style-type: none"> ● Test procedure divided into 2 parts - A and B
24.10.17	<ul style="list-style-type: none"> ● Step 9 instruction for testing coated eyelet was added
24.11.17	<ul style="list-style-type: none"> ● Reference was updated because GE-30 no longer exists ● Evaluation was updated
23.06.21	<ul style="list-style-type: none"> ● Update requirement table in Procedure A and update of ref. document

Valid for: All kinds of lace closed closing systems

Reference: ISO 22774:2004

Purpose

- To simulate long-term rubbing between laces and closure parts

Apparatus

- Lace abrasion tester according to PFI (see *figure 1*) updated version with new control box



Number Of Test Pieces

- Depending on the shoe, 2 parts of the lacing systems must be tested.

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Test Procedure A

1. Test procedure A should be used first. If test procedure A have PASS status, there is no need to perform test procedure B
2. Test must be conducted under standard room conditions (23°C ±2°C, with a humidity of 50% ±10%).
3. Cut out pieces of the different closure from the shoe (see example in „*figure 2*“)



4. Clamp the part of the eye stay into the moving clamp of the machine (see“ *figure 3*“).



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5. Contrive the lace, which belongs originally to the tested shoe though the eyelet, lace loop etc and fix one end with one immovable clamp (a).
6. Attach a weight of 1,000 g (b) to the loose end of the lace and tight it with another immovable clamp (c) (see “*figure 4*”).

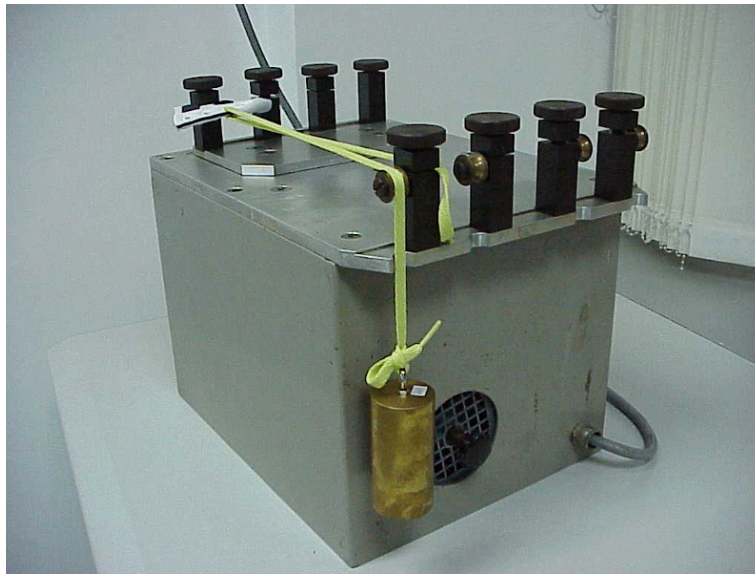


figure 4

7. No pause between the cycles
8. Fix amount of cycles following bellow table
9. For coated eyelet, check the coating every 50 cycles. Stop the test when the coating has any visual damage or reached the requirement. Record the number of cycles as test result.

Type of lace	Intended use/Categories	Amount of cycles
All kinds of laces	Performance & Hybrid (All categories)	500
All kinds of laces	Casual& Fashion (All categories)	300
Leather laces	All intended use (All categories)	300

Test Procedure B

- Same as test procedure A, but with 90 sec pause between cycles

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- Test procedure B should be performed every time when test fail on test procedure A

Evaluation





- Let the machine run for number of cycles listed in the table. The lace, eyelet and the closure area are checked visually for any damage and breakage. For the lace evaluations:
 - Flat laces must be rejected when they are completely broken
 - Oval and round laces must be rejected when the core can be completely seen
- The lace and the closure area are **not** evaluated on colour migration or colour change.
- Use below table with guidelines for evaluation

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FGT 22 - evaluation criteria			
Visual changes of eyelet or area around	Description	PICTURES	EVALUATION
Broken / Damage	Eyelet/eyelet or area around is broken or severe damaged		FAIL
Tearing	Eyelet or area around hole have tear		FAIL
Abrasion	Area around eyelet have abrasion on the surface		PASS
Deformation	Eyelet itself or area was deformed due to force applied but does not have any breakage or tear		PASS

Purchasing Address

- All necessary equipment required can be purchased from PFI: Lace abrasion machine "Adidas edition"

PFI

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