

**Jalatsid. Jäigastusplaatide ja ninatäidiste
katsemeetodid. Liimitavus**

Footwear - Test methods for stiffeners and toepuffs -
Bondability

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN ISO 20863:2005 sisaldab Euroopa standardi EN ISO 20863:2004 ingliskeelset teksti. Käesolev dokument on jõustatud 25.01.2005 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes. Standard on kättesaadav Eesti standardiorganisatsioonist.	This Estonian standard EVS-EN ISO 20863:2005 consists of the English text of the European standard EN ISO 20863:2004. This document is endorsed on 25.01.2005 with the notification being published in the official publication of the Estonian national standardisation organisation. The standard is available from Estonian standardisation organisation.
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Käsitlusala: This International Standard specifies a method for the determination of the bondability of heat activated and solvent activated stiffeners and toepuffs to upper and lining materials.	Scope: This International Standard specifies a method for the determination of the bondability of heat activated and solvent activated stiffeners and toepuffs to upper and lining materials.
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ICS 61.060

Võtmesõnad:

English version

Footwear

Test methods for stiffeners and toepuffs

Bondability

(ISO 20863:2004)

Chaussures – Méthodes d'essai pour
contreforts et renforts – Aptitude au
collage (ISO 20863:2004)

Schuhe – Prüfverfahren für Hinterkap-
pen und Zehenkappen – Klebefestig-
keit (ISO 20863:2004)

This European Standard was approved by CEN on 2004-08-23.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Management Centre or to any CEN member.

The European Standards exist in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Cyprus, the Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, the Netherlands, Norway, Poland, Portugal, Slovakia, Slovenia, Spain, Sweden, Switzerland, and the United Kingdom.

CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

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Foreword

This document (EN ISO 20863:2004) has been prepared by Technical Committee CEN/TC 309 "Footwear", the secretariat of which is held by AENOR, in collaboration with Technical Committee ISO/TC 216 "Footwear".

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by June 2005, and conflicting national standards shall be withdrawn at the latest by June 2005.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

1 Scope

This document specifies a method for the determination of the bondability of heat activated and solvent activated stiffeners and toepuffs to upper and lining materials.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 12222, *Footwear — Standard atmospheres for conditioning and testing of footwear and components for footwear*.

EN ISO 3696, *Water for analytical laboratory use — Specification and test methods (ISO 3696:1987)*.

EN ISO 4048, *Leather — Determination of matter soluble in dichloromethane (ISO 4048:1977)*.

EN ISO 7500-1, *Metallic materials — Verification of static uniaxial testing machines — Part 1: Tension/compression testing machines — Verification and calibration of the force-measuring system (ISO 7500-1:2004)*.

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

bondability

aptitude of a material to be bonded to it self or to other material by applying pressure and/or heat and eventually adhesive.

4 Apparatus and materials

4.1 General

The following apparatus and materials shall be used.

4.2 Tensile testing machine with a jaw separation rate of $100 \text{ mm/min} \pm 10 \text{ mm/min}$, an appropriate force range (this will usually be less than 100 N), capable of measuring the force to an accuracy of better than 2 % as specified by class 2 in EN ISO 7500-1, which registers the force applied in terms of the displacement.

4.3 Press knife or other means of cutting rectangular test specimens of $(150 \text{ mm} \pm 10 \text{ mm}) \times (30 \text{ mm} \pm 2 \text{ mm})$.

4.4 Press with the following characteristics.

4.4.1 Heated plates which can maintain a pre-established temperature with a precision of $\pm 5 \text{ }^{\circ}\text{C}$.

4.4.2 Operating pressure of $245 \text{ kPa} \pm 5 \text{ kPa}$ (245 kPa are $2,5 \text{ kg/cm}^2$).

4.5 Reference leather, full chrome splits (thickness of 1,5 mm to 1,7 mm) with a grease content of 4 % in total fat and 1 % in fatty acid (see EN ISO 4048).

4.6 Non-woven fabric, $150 \text{ g} \pm 20 \text{ g}$ per square metre.