

广东省纺织团体标准技术委员会

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广东省纺织团体标准 T/GDTEX 12-2020 《可水洗重复使用织物口罩》英文参考版的说明

为满足会员企业和有关单位采用广东省纺织团体标准 T/GDTEX 12-2020 《可水洗重复使用织物口罩》（以下简称该标准）的需要，广东省纺织团体标准技术委员会对标准文本进行了翻译，完成了英文参考版，有关情况说明如下：

1、该标准的中文版本是全国团体标准平台公布的正式版本，该标准以中文版本为准，英文参考版本仅供参考，使用英文参考版本时如有疑义则以中文版本为准。

2、使用该标准的英文参考版时，应同时提供标准的中文版本，以便使用者随时查阅中文版本，确保标准使用的准确性和完整性。

3、广东省纺织团体标准采用简写 GDTEX Organization standard，广东省纺织协会 Guangdong Textile Association 简称“GDTA”，广东省纺织团体标准技术委员会 Guangdong Textile Organization standard Technical Commission 简称“GDTEX”。

广东省纺织团体标准技术委员会

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联系人：刘干民，电话：13725267818，邮箱：3221415975@qq.com

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广东省纺织团体标准

T/GDTEX 12—2020

可水洗重复使用织物口罩

Washable-Reusable fabric mask

2020-06-09 发布

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广东省纺织协会 发布



前 言

本标准按照 GB/T 1.1-2020给出的规则起草。

本标准由单导科技发展（广州）有限公司和广东省纺织协会共同提出。

本标准由广东省纺织团体标准技术委员会归口。

本标准起草单位：单导科技发展（广州）有限公司、广东省纺织协会、广州蒙特罗户外用品有限公司、华懋（厦门）新材料科技股份有限公司、华懋（厦门）特种材料有限公司、珠海姗拉娜化妆品有限公司、广州市微生物研究所、东莞海关综合技术中心、广州工业经济联合会、广州市标准化研究院、广州检验检测认证集团有限公司、广东省测试分析研究所（中国广州分析测试中心）。

本标准主要起草人：吴宁西、刘干民、张初全、杨艺宗、刘惠林、刘英丹、王贵清、夏枫耿、郑少锋、王泽新、朱静娴、李洪燕、黄明华。

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可水洗重复使用织物口罩

1 范围

本标准给出了可水洗重复使用织物口罩的术语和定义、分类和规格、要求、试验方法、检验规则、标志、包装、运输、贮存、报废。

本标准适用于经洗涤或消毒后可重复使用的织物口罩。

本标准不适用于缺氧环境、水下作业、逃生、消防、医用及工业防尘等特殊行业用呼吸防护用品，不适用于36个月及以下婴幼儿使用的口罩，不适用于带固定呼吸阀的口罩。

2 规范性引用文件

下列文件对于本文件的应用是必不可少的。凡是注日期的引用文件，仅注日期的版本适用于本文件。凡是不注日期的引用文件，其最新版本（包括所有的修改单）适用于本文件。

GB 2626-2019 呼吸防护用品自吸过滤式防颗粒物

GB/T 3921 纺织品 色牢度试验 耐皂洗色牢度

GB/T 3922 纺织品 色牢度试验 耐汗渍色牢度

GB/T 5713 纺织品 色牢度试验 耐水色牢度

GB/T 8629-2017 纺织品 试验用家庭洗涤和干燥程序

GB 18401 国家纺织产品基本安全技术规范

GB/T 18830 纺织品 防紫外线性能的评定

GB/T 18886 纺织品 色牢度试验 耐唾液色牢度

GB/T 19095 垃圾分类图示标志

GB/T 20944.3-2008 纺织品 抗菌性能的评价 第3部分 振荡法

GB/T 29865 纺织品 色牢度试验 耐摩擦色牢度 小面积法

GB 31701 婴幼儿及儿童纺织产品安全技术规范

T/GDTEX 11 口罩弹性带

3 术语和定义

下列术语和定义适用于本文件。

3.1

可水洗重复使用织物口罩 washable-reusable fabric mask

在日常生活中，经水洗或消毒重复使用后仍具有与初始功能相当的，由功能性织物制成的口罩。

4 分类和规格

4.1 产品分类

4.1.1 可水洗重复使用织物口罩按照形状分为平面型、立体型及其他形状。

4.1.2 可水洗重复使用织物口罩按照防护效果分为高级和初级。

4.2 产品规格

4.2.1 产品规格依据设计要求或供需双方协议规定确定。

4.2.2 产品设计时，应符合人体测量学原则，适合人体头面型，口罩周边应保证与面部贴合；口罩带应能将口罩牢固地固定在头面上，不应出现明显压迫感或疼痛，应可调节，便于佩戴或摘除；部件的设计组成应不易产生结构性破损。

5 要求

5.1 基本要求

5.1.1 产品不应使用高毒性、致癌性或潜在致癌性物质以及已知的可导致皮肤刺激或其他不良反应的材料，其他限制使用物质的残留量应符合相关要求。

5.1.2 佩戴时不应対使用者造成伤害。

5.1.3 产品应符合GB 18401A类要求，供儿童佩戴的可水洗重复使用织物口罩还应符合GB 31701的要求。

5.1.4 产品采用的弹性带应符合T/GDTEX 11的要求。

5.1.5 可水洗重复使用织物口罩在产品使用说明建议的使用期后应按产品使用说明推荐的方法进行水洗或消毒才能重复使用。

5.2 内在质量

内在质量要求见表1。

表1 内在质量要求

项目		水洗或消毒次数	指标	
			高级	初级
口罩带与口罩体连接点处断裂强力/N \geq		0	20	
		50		
抑菌率/% \geq	金黄色葡萄球菌	0	99	
		50	80	
	大肠杆菌	0	70	
		50	70	
	白色念珠菌	0	60	
		50	60	
色牢度/级 \geq	耐皂洗色牢度	0	4	
	耐汗渍色牢度	0	4	
	耐水色牢度	0	4	
	耐唾液色牢度	0	4 (只测试贴肤面)	
	耐干摩擦牢度	0	4	
	耐湿摩擦牢度	0	3-4	
呼吸阻力/Pa \leq	吸气阻力	0	150	
		50		
	呼气阻力	0	145	
		50		
过滤效率/% \geq	盐性颗粒物	0	85	70
		50	80	70
紫外线防护系数UPF $>$		0	40	
		50		
注1: 水洗或消毒次数0时的指标是指产品的初始状态时应达到的要求。				
注2: 水洗或消毒50次时的指标是指按产品使用说明的规定每次使用后都应按使用说明进行水洗或消毒, 水洗或消毒50次后仍然应达到的要求。				

5.3 外观质量

5.3.1 产品外观应整洁、形状完好, 表面不得有破损、污渍及其他明显缺陷。

5.3.2 产品内层不宜使用染色和印花面料, 平面型口罩外层应有颜色、图案或其他区分标志。

5.3.3 产品外形的长度和宽度的尺寸偏差在产品规格的 ± 1 厘米以内。

6 试验方法

6.1 口罩带与口罩体连接点处断裂强力

任取三个样品，按GB 2626-2019中的6.12的规定进行试验。

6.2 抑菌率

按GB/T 20944.3-2008 第3部分 振荡法的规定进行试验。

6.3 耐皂洗色牢度按GB/T 3921规定执行。

6.4 耐汗渍色牢度按GB/T 3922规定执行。

6.5 耐水色牢度按GB/T 5713规定执行。

6.6 耐唾液色牢度按GB/T 18886规定执行，只测试贴肤面。

6.7 耐摩擦色牢度按GB/T 29865规定执行。

6.8 呼吸阻力按GB 2626-2019中的6.5、6.6规定执行。

6.9 防紫外线性能按GB/T 18830规定执行。

6.10 盐性颗粒物过滤效率

任取三个样品，不需要进行预处理，按GB 2626-2019中的6.3规定进行试验。

6.11 水洗和消毒

6.11.1 水洗试验按GB/T 8629-2017中的4H程序和F翻滚烘干规定执行。50次重复水洗试验时，宜按4H程序连续洗10次，然后烘干，计为10次重复洗涤，如此重复五次。带可拆装呼吸阀的可水洗重复使用织物口罩在洗涤前应拆除呼吸阀后洗涤。

6.11.2 酒精喷洒消毒，每次采用含量75%以上医用酒精均匀喷洒口罩内外表面，自然晾干。

6.11.3 水洗或消毒50次后的内在质量指标试验时，可以任选水洗或消毒的其中一种方法进行试验，选择后不宜随意更改。

7 检验规则

7.1 抽样

按交货批号的同一品种、同一规格（型号）的产品作为检验批次，从每检验批次产品中按试验要求随机抽取相应数量的样品，当同一批次产品数量大于1万个时，检验数量进行相应的加倍。

7.2 型式检验

正常生产时每年进行一次型式检验。

型式检验项目为本标准第5章规定的所有要求，有下列情况时也应进行型式检验：

- a) 产品正式批量生产时；
- b) 原材料进货渠道改变时；
- c) 生产工艺有重大改变或产品质量不稳定时；
- d) 停产六个月以上、恢复生产时；
- e) 国家质量监督主管部门提出型式检验要求时；

7.3 判定规则

产品不符合第5章中所规定的任何一项质量要求时，该批产品判定为不合格。

8 包装、贮运和标志

8.1 包装和贮存

8.1.1 产品应密封装箱，包装应该能够防止机械破坏和试用前的污染。

8.1.2 产品应贮存在通风、干燥、清洁的库房内，并防蛀防霉。

8.1.3 产品运输和装卸过程中，切勿拖曳、钩挂，避免损坏包装和产品。

8.2 标志

产品的最小包装应有清晰的中文标志，如果包装是透明的，应可以透过包装看到标志，标志内容至少包括：

- a) 制造商名称、地址及联系方式；
- b) 产品名称；
- c) 主要原材料（内层、外层、过滤层）；
- d) 执行标准；
- e) 产品规格尺寸；
- f) 使用说明（至少应包括正反面识别、佩戴方式、洗涤和消毒方式等）；
- g) 使用人群；
- h) 生产日期和（或）批号；
- i) 保质日期；
- j) 如为带可拆装呼吸阀的可水洗重复使用织物口罩，并注明可拆装呼吸阀的使用及维护方法。

9 报废

9.1 口罩在下列情况下需要报废：出厂前的质量问题、使用过程中材料破损、超过保质日期、使用终止。

9.2 所有的报废口罩应根据GB/T 19095 规定进行处理。



参考文献

- [1] FZ/T 73049-2014 针织口罩
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GDTE
全国团体标准信息平台

广东省纺织协会
团体标准

可水洗重复使用织物口罩

T/GDTEX 12—2020

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广东省纺织团体标准技术委员会编印
广东省广州市越秀区麓湖路5号岭南大厦A503室
(510095)

电话：020-83862990

网址：www.gdtextiles.cn

邮箱：gdsfzxh@163.com

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GDTEX Organization standard

T/GDTEX 12-2020

Washable-Reusable Fabric Mask

可水洗重复使用织物口罩

(English edition only provides a reference)

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Preface

This standard is drafted according to the rules given by GB/T 1.1-2020.

This standard is proposed jointly by Oneway dry Technology Development (Guangzhou) Co., Ltd and Guangdong Textile Association(GDTA).

This standard is centralized management by Guangdong Textile Organization Standards Technical Commission(GDTEX).

The drafting enterprises of this standard are as follows: Oneway dry Technology Development (Guangzhou) Co., Ltd.; Guangdong Textile Association(GDTA); Guangzhou Montech Outdoor Products Co., Ltd.; Huamao (Xiamen) New Materials Technology Co., Ltd.; Huamao (Xiamen) Special Materials Co., Ltd.; Zhuhai Sunrana Cosmetics Co., Ltd.; Guangzhou Microbiology Institute; Dongguan Customs Integrated Technology Center; Guangzhou Federation of Industrial Economics;; Guangzhou Institute of Standardization; Guangzhou Inspection and Certification Group Co., Ltd.; Guangdong Institute of Test and Analysis [China (Guangzhou) Analysis and Test Center].

The main drafters of this standard: Wu Ningxi, Liu Ganmin, Zhang Chuquan, Yang Yizong, Liu Huilin, Liu Yingdan, Wang Guiqing, Xia Fenggeng, Zheng Shaofeng, Wang Zexin, Zhu Jingxian, Li Hongyan, Huang Minghua.

Please note that certain elements of this standard may involved with patents. The issuing agency of this standard is not responsible for identifying these patents.

The text of this standard can be downloaded on the National Group Standard Information Platform and the website of Guangdong Textile Association.

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Any ambiguity arising from languages used in standard, the Chinese language shall prevail.

Washable-Reusable Fabric Mask

1. Scope

This standard is stated the terms and definitions, classifications and specifications, requirements, test methods, inspection rules, marks, packaging, transportation, storage, and the scrap of washable-reusable fabric mask.

This standard applies to fabric mask that can be reused after washing or disinfecting.

This standard is not applicable to respiratory protective equipment for special industries such as anoxic environment, underwater operation, escape, fire fighting, medical and industrial dust prevention, etc. It cannot be used by infants or young children who are under 36 months or less, and is also not suitable for them to wear masks with fixed breathing valve.

2. Normative Citation Documents

The following documents are essential for the application of this standard. The date-only version of any reference documents are compliant with this standard. The latest version of any undated reference documents (including all modifications) applies to this standard.

GB 2626-2019: Respiratory protective equipment self-priming filter to prevent particulate matter;

GB/T 3921: Colour fastness test of textiles to soaping;

GB/T 3922: Colour fastness test of textiles to perspiration;

GB/T 5713: Colour fastness test of textiles to water;

GB/T 8629-2017: Household washing and drying procedures for textile tests;

GB 18401: National technical specification for basic safety of textile products;

GB/T 18830: Evaluation of UV-resistant properties of textiles;

GB/T 18886: Colour fastness test of textiles to saliva;

GB/T 19095: Garbage sorting icon;

GB /T 20944.3-2008: Evaluation of antibacterial properties of textiles (Part 3-Oscillation method);

GB/T 29865: Colour fastness test textiles - small area method for colour fastness to friction;

GB 31701: Technical specification for safety of textile products for infants and children;

T/GDTEX 11: Mask elastic band.

3. Terms and Definitions

The following terms and definitions are applies to this document.

3.1 Washable-Reusable Fabric Mask

In daily life, after being washed or reused after disinfection, it still works equivalent to the one made of functional fabric with initial function.

4. Classifications and Specifications

4.1 Product classifications

4.1.1 The washable-reusable fabric mask is divided into flat, solid and other shapes.

4.1.2 The protective effect of the washable reusable fabric mask can be divided into senior and primary.

4.2 Product specifications

4.2.1 The product specifications are determined by the design requirements or the agreement between the supplier and the purchaser.

4.2.2 Product design should conform to the principles of anthropometry, which is suitable for the head shape. The mask edges must fit with human face; the mask should be able to be fixed by its belts firmly without feeling overt pressure or pain; it should be adjustable, easy to be worn or removed; and its components should not be damaged structurally easily.

5. Requirements

5.1 Basic requirements

5.1.1 The products should not be used with highly toxic, carcinogenic or potentially carcinogenic substances as well as materials known to cause skin irritation or other adverse reactions, and the residues of other restricted substances should comply with relevant requirements.

5.1.2 Without causing injury to the user when wearing it.

5.1.3 The product should meet with the requirements of GB 18401A, and the one for children should comply with both GB 18401A and GB 31701.

5.1.4 The elastic band for the product shall meet the requirements of the T/GDTEX 11.

5.1.5 After the recommended using period, the washable-reusable fabric mask can only be reused after being washed or disinfected according to the method stated in the User Manual.

5.2 Internal Quality

Internal quality requirements are shown in Table 1.

Table 1: Internal Quality Requirements

Project		Numbers of Washing/ Disinfecting Times	Indicators	
			Senior	Primary
Breaking Strength of the Join between Mask and Belt/N \geq		0	20	
		50		
Antibacterial Percentage /% \geq	Staphylococcus Aureus	0	99	
		50	80	
	Bacterium Coli	0	70	
		50	70	
	Monilia Albicans	0	60	
		50	60	
Colour Fastness /Grade \geq	Soap Washing Fastness	0	4	
	Perspiration Fastness	0	4	
	Water Fastness	0	4	
	Saliva Fastness	0	4(Test Only the Skin Contact Side)	
	Dry Rubbing Fastness	0	4	
	Wet Rubbing Fastness		0	3-4
Respiratory Resistance	Inspiratory Resistance	0	150	
		50		

/Pa ≤	Expiratory Resistance	0	145	
		50		
Filtration Efficiency/% ≥	Salt Particulate Matter	0	85	70
		50	80	70
UV Protection Factor(UPF) >		0	40	
		50		
<p>Note 1: When numbers of washing/disinfecting times shows "0", the indicators refers to the initial state of product performance.</p> <p>Note 2: When numbers of washing/disinfecting times shows "50", the indicators refers to the performance of product being washed or disinfected for 50 times according to the method stated in the User Manual.</p>				

5.3 External Quality

5.3.1 Product appearance should be neat, in intact shape; its surface must not be damaged, stained or with other obvious defects.

5.3.2 The inner layer of the product should not be used with dyeing or printing fabrics; the outer layer of the flat mask should have color, pattern or other distinguishing marks.

5.3.3 The deviation of length and width should within ± 1 cm of the product specification.

6. Testing methods

6.1 The breaking strength of the join between mask and belt:

Three samples were taken and tested randomly as specified in 6.12 of the GB 2626-2019.

6.2 Antibacterial Percentage:

Tested by the Oscillation Method as specified in Part 3 of GB /T 20944.3-2008.

6.3 Colour fastness test to soaping according to GB/T 3921 regulations.

6.4 Colour fastness test to perspiration according to GB/T 3922 regulations.

6.5 Colour fastness test to water according to GB/T 5713 regulations.

6.6 Color fastness test to saliva according to the GB/T 18886 regulations and only skin contact side is tested.

6.7 Color fastness test to friction according to GB/T 29865 regulations.

6.8 Respiratory resistance is performed according to the provisions 6.5 and 6.6 in the GB 2626-2019.

6.9 UV protection performance according to GB/T 18830 regulations.

6.10 The filtration efficiency of salt particulate matter:

Take three samples randomly without being pretreatment, testing them according to 6.3 in the GB 2626-2019.

6.11 Washing and disinfecting:

6.11.1 The washing test is carried out according to the 4H and F rolling-drying procedures which are specified in the GB/T 8629-2017: firstly, washing the product continuously for 10 times in accordance with the 4H procedure, and then drying it, this is counted for 10 times of repeated washing. Repeated five times as above. The breather valve of washable-reusable fabric mask with detachable breathing valve should be removed before washing.

6.11.2 Alcohol spraying disinfection: spray the medical alcohol content which is more than 75% evenly on the mask inside and outside, and dry it naturally.

6.11.3 After being washed or disinfected for 50 times, in order to test the indicators of product internal quality, either the washing or disinfecting tests can be selected, and it is not recommended for any changes after selecting.

7. Inspection Rules

7.1 Sampling

The products which with same variety and same specifications (model) from the delivery batch numbers would be regarded as inspection batches. According to test requirements, the samples are selected randomly in same quantity from Each inspection batch. The amount of inspection would be increased accordingly If product quantity from the same batch is more than 10,000 pcs.

7.2 Type Inspection

Type inspection being carried out once a year in regular production.

The product should be tested comply with all the requirements specified in Chapter 5 in this standard when doing type inspection, and it shall also be carried out if:

- a) product is mass-produced formally;
- b) the purchase channel of raw material is changed;
- c) the production process is changed significantly or product quality is unstable;

- d) resume production after stopping for more than six months;
- e) the National Quality Supervision Authorities requires the type inspection ;

7.3 Decision Rules

If the product does not meet any of the quality requirements specified in Chapter 5, the batch is judged as unqualified.

8. Packaging, Storing, and Marking

8.1 Packaging and storing

8.1.1 Products should be sealed and packed; packaging should be able to prevent mechanical damages and contamination before use.

8.1.2 Products should be stored in a warehouse which is ventilated, dry, clean. And beware of moth and mildew.

8.1.3 During the transportation, do not drag or hook to avoid damage to packaging and products.

8.2 Logo

The minimum package of the product shall be clearly marked in Chinese. If it is transparent, the logo shall be visible through the package.

The logo shall include at least:

- a) the name, address, and contact information of the manufacturer;
- b) product name;
- c) the main raw materials (inner, outer, filter);
- d) the implement criteria;
- e) product specification and dimension;
- f) user instructions (including at least positive and negative identification, wearing, washing and disinfecting, etc.);
- g) use of population;
- h) production date and/or batch number;
- i) date of warranty;
- j) for washable-reusable fabric mask with detachable breathing valve, the using and maintaining methods of detachable breathing valve should be stated.

9. Scrap

9.1 The mask should be scrapped in the following cases: quality problems before leaving the factory; material breakage during using; exceeding the warranty date; the termination of using.

9.2 All end-of-life masks should be handled according to GB/T 19095 regulations.

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References

[1]FZ/T 73049-2014 Knitting Masks

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Guangdong Textile Association

Group Standard

Washable-Reusable Fabric Mask

T/GDTEX 12—2020

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Standards and Technical Committee

A503 Room, Lingnan Building ,No. 5 Luhu Road, Yuexiu
District, Guangzhou City, Guangdong Province (510095)

Tel :020-83862990

Website: [www.gdtextiles .cn](http://www.gdtextiles.cn)

Email: [gdsfzxh @163.com](mailto:gdsfzxh@163.com)

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