



DETERMINATION OF EXCESS FLOCK OR DUST

Application

Procedure "A" is used to determine if loose or excess flock is present on the surface of parts so treated. (Glove compartment boxes, flocked carpets, etc.)

Procedure "B" is used to determine the amount of dust on perforated hardboard parts. (Truck headliners, etc.)

Apparatus and Materials Required

Vacuum Cleaner

74.5 ft³/min (35.2L/s) Flow Rate, 15kPa
Oreck XL PRO5 or equivalent

Source: Oreck Commercial/Hospitality
40 Grissom Road
Plymouth, MA 02360

Nozzle Attachment

Figure 1. Crevasse tool cut perpendicular, 28 X 9 mm orifice dimensions.

Crocking Cloth

50 x 50 mm crockmeter squares (style 3)

Source: Test Fabrics, Inc.
P.O. Box 26
415 Delaware Ave.
West Pittston, PA 18643, USA
Phone: (717) 603-0432
Fax: (717) 603-0433

Analytical Balance

Conditioning and Test Conditions

All test values indicated herein are based on material conditioned in a controlled atmosphere of 23 +/- 2 °C and 50 +/- 5 % relative humidity for not less than 24 h prior to testing and tested under the same conditions unless otherwise specified.

Date	Action	Revisions	Rev. 3
2014 04 22	Editorial	Added 15kPa to vacuum cleaner details	R. Harris, NA
2014 03 27	Revised	Identified vacuum metrics / clarified process calculation	R. Harris, NA
1998 10 14	Released		



Procedure "A"

1. The test shall be conducted between measured lengths marked on several representative portions of the flocked part. The total of the measured lengths multiplied by the nozzle orifice length (28 mm) shall provide a minimum area of 32,258 mm² unless otherwise specified in the engineering specification (See Figure 1), for example – the 28 X 9 mm nozzle orifice would require traversing 1152 mm (3 bands, 384 mm in length or 4 bands, 288 mm in length or equivalent) to vacuum an area measuring 32,258 mm².
2. Weigh a piece of crocking cloth and record weight in milligrams.
3. Place the crocking cloth over the vacuum hose and slip the nozzle attachment over the cloth so that it will catch the flock.
4. Turn on the vacuum. With moderate pressure on the nozzle attachment, make one pass between the marked lines so that the specified lengths are vacuumed.
5. Turn off the vacuum, hold the nozzle assembly vertically and carefully remove the nozzle attachment so as not to disturb the trapped flock.
6. Remove the crocking cloth, reweigh and record weight of cloth plus flock in milligrams.
7. Subtract the original weight of the crock cloth to determine flock weight.
8. Weight of flock removed shall be reported in milligrams for an area of 32,258 mm² or as otherwise required in the engineering specification.

Procedure "B"

1. The test shall be conducted within a 305 x 305 mm area marked on the backside of a representative part. The total area to be tested shall be 930.25 cm² unless otherwise specified in the engineering specification.
2. Follow steps 2 and 3 of Procedure "A".
3. Turn vacuum on. With moderate pressure on the nozzle attachment, make two passes over the entire surface area of the square drawn on the sample part.
4. Follow steps 5 and 6 of Procedure "A".
5. Weight of dust removed from the sample shall be reported in milligrams/sq cm unless otherwise required by the engineering specification.

Chemicals, materials, parts, and equipment referenced in this document must be used and handled properly. Each party is responsible for determining proper use and handling in its facilities.