



SURFACE VEHICLE RECOMMENDED PRACTICE

J3064™

JAN2022

Issued

2022-01

Standard Specification for Allowable Defects in Rolled Goods for Interior Trim

RATIONALE

This specification defines the number of allowable defects in purchased fabric and plastic rolled goods in unlaminated and laminated states.

1. SCOPE

- 1.1 This specification is written for rolled goods used for trim sets for automotive seats. Face materials are fabric-woven or knitted textiles, and plastic goods like polyvinyl chloride (PVC), thermoplastic polyolefin (TPO), or thermoplastic polyurethane (TPU). This specification covers material rolled goods with and without foam or backing adhered to the face material.
- 1.2 Units shall be SI.
- 1.3 This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. REFERENCES

There are no referenced publications specified herein.

3. DEFINITIONS

3.1 ROLLED GOODS

Less-finished material that is generally used for interior trim. Material is typically a textile or plastic, with or without a backing or laminate.

3.2 DEFECT TYPES

3.2.1 Spot defect

A defect, flaw, or splice that is less than 115 mm long in the machine direction.

3.2.2 Running defect

A defect or flaw that is equal to or greater than 115 mm long in the machine direction.

3.3 GROSS METERS

Total meters of material on a roll.

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3.4 LAMINATION DEFECT

Any defect associated with the lamination process including backing, foam, film, and/or lamination process.

3.5 NET METERS

Total meters of usable material on a roll. This number is calculated by subtracting the number of meters of allowance from the gross meters on a roll.

4. LABELING

4.1 Tags and labels shall use AIAG format.

4.2 Tags and labels must show gross and net meters on the roll.

5. FLAGGING AND ALLOWANCE

5.1 General Flagging Requirements

5.1.1 All material rolls shall be flagged on the selvage or non-usable edge to indicate the total number of defects in the roll.

5.1.2 Allowances for the defects shall be made on the number of linear meters for the full width of the roll. The total allowance shall be indicated on the material tag and label.

5.1.3 The actual defect shall be marked with a marker or a crayon. A China marker is recommended. The color of marker used shall be a contrasting color to the face material so that it can be easily seen.

5.2 Color of Flags

5.2.1 Spot defect or splice in face material - red.

5.2.2 Spot defect or splice in the laminate or backing material - blue.

5.2.3 Running defect (face, backing or laminate) - yellow.

5.3 Type of Flag

5.3.1 Flags are colored as specified in 5.2.

5.3.2 Strings used may be fiber or plastic.

5.3.3 Strings shall be at least 76 mm in length.

5.3.4 Metal needles or staples are not allowed.

5.3.5 The strings shall be attached to the edge of the roll or selvage and shall be inline with the defect.

5.3.6 Strings shall be on the right side of the roll when looking into the roll, face side up.

5.4 Flagging Defects

5.4.1 Spot Defects