
**Footwear — Test methods for insoles —
Heel pin holding strength**

*Chaussures — Méthodes d'essai applicables aux premières de montage —
Tenue des clous pour talon*

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 3.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this International Standard may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

International Standard ISO 20867 was prepared by the European Committee for Standardization (as EN 12745:1999) and was adopted, under a special "fast-track procedure", by Technical Committee ISO/TC 216, *Footwear* in parallel with its approval by the ISO member bodies.

Annex A of this International Standard is given for information only.

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Foreword

This European Standard has been prepared by Technical Committee CEN/TC 309 "Footwear", the secretariat of which is held by AENOR.

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of an identical text or by endorsement, at the latest by March 2000, and conflicting national standards shall be withdrawn at the latest by March 2000.

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

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1 Scope

This draft standard specifies a method to determine the ability of an insole component to hold a heel pin and to prevent its head from being pulled through the insole component.

The method is applicable to insoles used in the seat of footwear with inside attached heels, and also to seat components where outside heel attachments are used and the heel pin is clenched.

2 Normative references

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to, or revisions of, any of these publications apply to this European Standard only when incorporated into it by amendment or revision. For undated references the latest edition of the publication referred to applies.

EN 12222	Footwear - Standard atmospheres for conditioning and testing of footwear and components for footwear
prEN 13400:1998	Footwear - Sampling location of components for footwear
ISO 5893	Rubber and plastic test equipment - Tensile, flexural and compression types (constant rate of traverse) - Description

3 Definitions

For the purpose of this standard the following definition applies:

heel pin holding strength:

The force required to push a simulated heel pin head through the insole material.

4 Apparatus and material

The following apparatus and material shall be used:

4.1 Drill

Drill, fitted with twist drill bit, 2,0 mm \pm 0,1 mm diameter.

4.2 Dynamometer

The tensile-testing machine shall comply with the requirements of ISO 5893, to an accuracy corresponding to grade B, with a constant rate of traverse of 100 mm/min \pm 20 mm/min. Autographic recording of force or a maximum force pointer is recommended.

4.3 Attachment for the dynamometer

Attachment for the dynamometer, consisting of the following two parts:

- a) **Rigid test piece supporting plate**, with a 12 mm diameter circular hole and a means of attachment to the force measuring system, so that the line of action of the force applied during testing passes through the centre of the hole and is perpendicular to the plate.
- b) **Fitting for the drive system**, providing a means of pushing a rod through the test piece; the leading part of the rod consists of a 2 mm diameter shank, and the remainder a head of 4,0 mm \pm 0,2 mm diameter, the two sections joining at a shoulder in the form of a plane perpendicular to the axis of the rod (These dimensions correspond to those of 8 mm x 14 mm gauge heel pin).

The combined attachment shall be designed to ensure that the axis of the rod passes through the centre of the hole in the test piece supporting plate (see figure 1).

4.4 Dial micrometer gauge

Dial micrometer gauge, complying with the following requirements:

The gauge shall stand on a firm base, it shall be dead weight loaded and the force applied shall be 3,85N \pm 0,10N. The presser foot shall be flat, circular and 10,0 mm in diameter, and its direction of movement shall be normal to the face of the anvil. The anvil shall be the flat, horizontal surface of a cylinder of diameter 10,0 mm projecting 3 mm from the surface of a flat circular platform of diameter 50 mm. The axes of the presser foot, the platform and the projecting anvil shall coincide and shall be the same as the direction of movement of the foot. The faces of the foot and anvil shall be parallel for all positions of the foot, the error not exceeding 0,005 mm. The dial gauge shall be graduated to read to 0,01 mm directly. It shall have a dial of sufficiently large size to give an open scale and a suitable pointer close to the scale to minimize errors due to parallax. The readings of the gauge shall be accurate to 0,01 mm all along the scale.

4.5 Distilled water

4.6 Rectangular knife

Rectangular knife, to cut a test piece of 80 mm x 20 mm. The inner surface of the knife shall be angled outward from the cutting edge at approximately 5° to the vertical so that when the test piece is cut it passes through the knife without damage to the test piece edge.

5 Sampling and conditioning

Using the rectangular knife described in 4.6, cut two rectangular test pieces of 80 mm x 20 mm from the shoe insoles cut insoles or the component as supplied. Use one test piece for dry testing (see 6.1) and one for wet testing (see 6.2).

If the test pieces are taken from the shoe insoles or cut insoles, sampling shall be done in accordance with prEN 13400:1998.

The test piece for dry testing (see 6.1) shall be conditioned according to EN 12222 for a minimum of 48 h before testing and the test shall be carried out in this atmosphere.

The test piece for wet testing requires no conditioning before the method described in 6.2 is carried out.

6 Test method

6.1 Dry testing

6.1.1 Measure the thickness of the test piece, using the micrometer gauge (see 4.4), at three points on the centre line parallel to the 80 mm side, at distances 20 mm, 40 mm and 60 mm respectively from one end.

6.1.2 Using the 2,0 mm diameter drill bit (see 4.1), make three holes along the centre line of the test piece parallel to the 80 mm side, at distances 20 mm, 40 mm and 60 mm respectively from one end.

6.1.3 Fit the shank of the rod through one hole with the rod head on the foot side of the material. Operate the dynamometer (see 4.2) at a jaw separation speed of 100 mm/min \pm 20 mm/min, continuously recording the force, until the insole fails. Note the maximum force exerted, correcting, if necessary, for any effect of the weight of the test attachment on the force recorded.

6.1.4 Repeat the method described in 6.1.3 using each of the other two holes in the test piece.

6.2 Wet testing

6.2.1 Applying the procedure described in 6.1.1 measure the thickness of the test piece. Using the 2,0 mm diameter drill bit (see 4.1), make three holes along the centre line parallel to the 80 mm side at distances of 20 mm, 40 mm and 60 mm respectively from one end. Soak the test piece in water at $23\text{ }^{\circ}\text{C} \pm 2\text{ }^{\circ}\text{C}$ for 6 h. Remove it from the water and blot the surface.

6.2.2 Without delay, carry out the method described in 6.1.3 and 6.1.4.

7 Expression of results

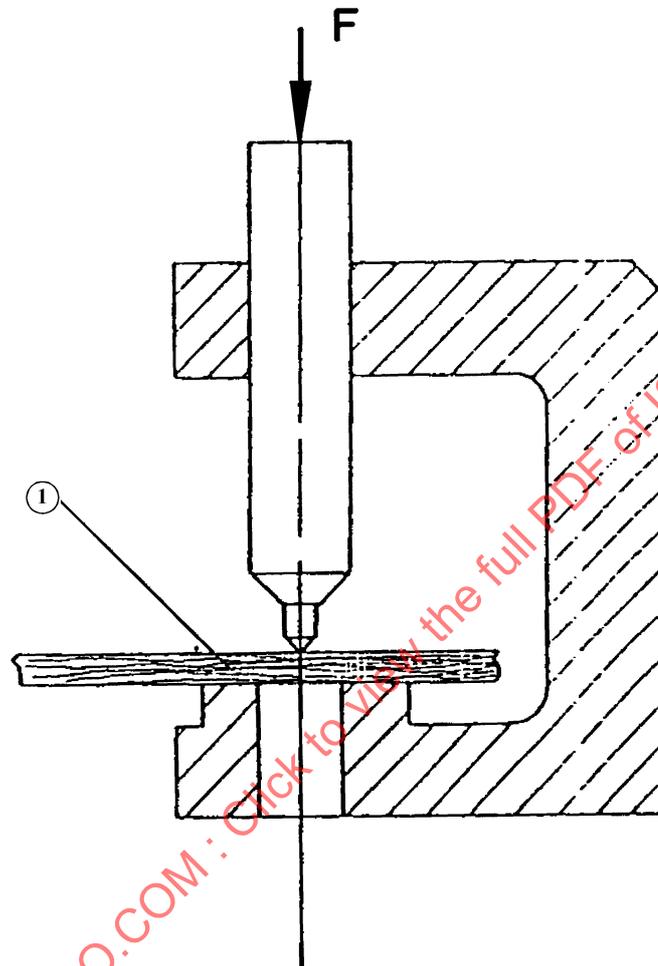
7.1 Calculate separately the mean of the three maximum forces noted for each test piece and express the results in newton, as the heel pin holding strength of the dry and the wet insole material respectively.

7.2 Calculate also the mean value for the thickness of each test piece.

8 Test report

The test report shall include the following information:

- a) the results, for the wet and the dry insole material, expressed in accordance with 7.1.
- b) the thickness of the insole material, expressed in accordance with 7.2;
- c) nature and full identification of the sample;
- d) description of sampling procedure, where relevant;
- e) reference to the method of test;
- f) details of any deviation from the standard test procedure;
- g) the date of testing.



1 Test piece

Figure 1 - Attachment for the tensile-testing machine