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**Footwear — Performance requirements  
for components for footwear — Uppers**

*Chaussures — Exigences de performance pour les composants des  
chaussures — Tiges*

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Published in Switzerland

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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 2.

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.

In exceptional circumstances, when a technical committee has collected data of a different kind from that which is normally published as an International Standard ("state of the art", for example), it may decide by a simple majority vote of its participating members to publish a Technical Report. A Technical Report is entirely informative in nature and does not have to be reviewed until the data it provides are considered to be no longer valid or useful.

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

ISO/TR 20879 was prepared by the European Committee for Standardization (CEN) Technical Committee CEN/TC 309, *Footwear*, in collaboration with Technical Committee ISO/TC 216, *Footwear*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

# Footwear — Performance requirements for components for footwear — Uppers

## 1 Scope

This Technical Report establishes the performance requirements for uppers components for footwear (not for the finished footwear), irrespective of the material, in order to assess the suitability for the end use. It also establishes the test methods to be used to evaluate the compliance with the requirements.

This Technical Report applies to uppers for all kinds of footwear as defined in Clause 3.

This Technical Report is intended to be used as a reference between the footwear manufacturer and the supplier. It is not intended for third party certification of finished shoes destined for the consumer.

## 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.

ISO 31-0, *Quantities and units — Part 0: General principles*

EN 1391, *Adhesives for leather and footwear materials — A method for evaluating the bondability of materials — Minimum requirements and material classification*

EN 1392, *Adhesives for leather and footwear materials — Solvent-based and dispersion adhesives — Test methods for measuring the bond strength under specified conditions*

EN ISO 4047, *Leather — Determination of sulphated total ash and sulphated water-insoluble ash*

EN ISO 4098, *Leather — Chemical tests — Determination of water-soluble matter, water-soluble inorganic matter and water-soluble organic matter*

EN ISO 17693, *Footwear — Test methods for uppers — Resistance to damage on lasting*

ISO 17694, *Footwear — Test methods for uppers and lining — Flex resistance*

ISO 17696, *Footwear — Test methods for uppers, lining and insoles — Tear strength*

ISO 17697, *Footwear — Test methods for uppers, lining and insoles — Seam strength*

ISO 17698, *Footwear — Test methods for uppers — Delamination resistance*

ISO 17699, *Footwear — Test methods for uppers and lining — Water permeability and absorption*

EN ISO 17700, *Footwear — Test methods for uppers, linings and insoles — Colour fastness to rubbing*

ISO 17701, *Footwear — Test methods for uppers, lining and insoles — Colour migration*

ISO 17702, *Footwear — Test methods for uppers — Water resistance*

ISO 17703, *Footwear — Test methods for uppers — High temperature behaviour*

ISO 17704, *Footwear — Test methods for uppers, lining and insoles — Abrasion resistance*

ISO 17705, *Footwear — Test methods for uppers, lining and insoles — Thermal insulation*

ISO 17706, *Footwear — Test methods for uppers — Tensile strength and elongation*

ISO 17709, *Footwear — Sampling location, preparation and duration of conditioning of samples and test pieces*

EN ISO 19952, *Footwear — Vocabulary*

### **3 Terms and definitions**

For the purposes of this document, the terms and definitions given in EN ISO 19952 apply.

### **4 Requirements**

#### **4.1 General**

This Technical Report establishes two different types of performance requirement.

The essential requirements shall all be taken into account. The additional ones can be additionally agreed by the component supplier and the footwear manufacturer as indicated in 4.2 to 4.10.

The results of each single analytical determination, as well as the average values, shall be rounded off in accordance with ISO 31-0.

When taken from finished footwear, the sample shall be prepared in accordance with ISO 17709.

## 4.2 Performance requirements for uppers components for general purpose sports footwear

### 4.2.1 Essential requirements

These essential requirements shall be fulfilled in all cases. See Table 1.

**Table 1 — Test methods and properties for general sports footwear — Essential requirements**

| Test method                                   | Property        | Requirement  |   |   |
|---|-----------------|--|---|---|
| ISO 17694                                     | Flex resistance | For leather,<br>dry 100 000 cycles<br>(w.v.d.) <sup>a</sup><br>wet 20 000 cycles<br>(w.v.d.)   | For coated leather,<br>dry 100 000 cycles<br>(w.v.d.)<br>wet 20 000 cycles<br>(w.v.d.)<br>at – 5 °C 20 000 cycles<br>(w.v.d.) | For other materials,<br>dry 100 000 cycles<br>(w.v.d.)<br>at – 5 °C 20 000 cycles<br>(w.v.d.) |
| ISO 17696                                     | Tear strength   | ≥ 40 N average tear force  |   |   |
| EN ISO 17700                                  | Colour fastness | Inside staining:<br>method A: if unlined footwear, must comply ≥ 2/3 after 50 cycles with perspiration solution<br>Outside surface colour change and staining:<br>method A: ≥ 3 (grey scale) after 150 cycles dry and 50 cycles wet.<br>method B: ≥ 3 to 4 (grey scale) after 512 cycles dry and 128 cycles wet. |   |   |
| <sup>a</sup> w.v.d. = without visible damage. |                 |  |   |   |

## 4.2.2 Additional requirements

These additional requirements should be agreed upon by both component supplier and footwear manufacturer. See Table 2.

Table 2 — Test methods and properties for general sports footwear — Additional requirements

| Subclause    | Test method   | Property                         | Requirement  |
|--------------|---|----------------------------------|--|
| 4.2.2.1      | EN ISO 17693  | Lastability                      | These figures will be influenced by the shape of the footwear<br>$\geq 7,0$ mm (for leather grain crack)<br>$\geq 6,0$ mm (for other materials first damage)<br>NOTE This test method is only applicable for component before lasting. |
| 4.2.2.2      | ISO 17697   | Seam strength                    | $\geq 10$ N/mm (method A)  |
| 4.2.2.3      | EN 1392   | Bondability <sup>a, b</sup>      | $\geq 4$ N/mm  |
| 4.2.2.4      | ISO 17699   | WVP and WVA                      | WVP $\geq 0,8$ mg/cm <sup>2</sup> .h<br>If WVP < 2,0 mg/cm <sup>2</sup> .h then WVA $\geq 8,0$ mg/cm <sup>2</sup>  |
| 4.2.2.5      | ISO 17701   | Colour migration                 | 24 h, colour change and staining $\geq 4$ (grey scale)   |
| 4.2.2.6      | ISO 17702   | Water resistance                 | Penetration time $\geq 60$ min, absorption after 60 min $\leq 20$ % (water resistant)<br>Penetration time $\geq 180$ min, absorption after 180 min $\leq 25$ % (highly water resistant)  |
| 4.2.2.7      | ISO 17703   | High temperature resistance      | The material must keep $\geq 80$ % of its original tensile strength and elongation   |
| 4.2.2.8      | ISO 17704   | Abrasion resistance              | dry wet<br>25 600 12 800<br>No worse than moderate abrasion degree   |
| 4.2.2.9      | EN ISO 4098<br>EN ISO 4047  | Water soluble substance content  | $\leq 3$ % sulfated ashed water soluble (SAWS)<br>$\leq 18$ % total water soluble (TWS)  |
| 4.2.2.10     | ISO 17706   | Breaking strength and elongation | $\geq 10$ N/mm, elongation $\geq 15$ % (across) and $\geq 7$ % (along)   |
| 4.2.2.11     | ISO 17698   | Delamination resistance          | dry $\geq 0,5$ N/mm (for leather)<br>wet $\geq 0,3$ N/mm (for leather)<br>dry $\geq 1,0$ N/mm (for other materials)<br>wet $\geq 0,7$ N/mm (for other materials)   |
| <sup>a</sup> | Reference adhesives and reference material shall comply with EN 1391.                               |                                  |  |
| <sup>b</sup> | The dimensions and number of test pieces for this test method shall be those included in ISO 17709. |                                  |  |

### 4.3 Performance requirements for uppers components for school footwear

#### 4.3.1 Essential requirements

These essential requirements shall be fulfilled in all cases. See Table 3.

**Table 3 — Test methods and properties for uppers components for school footwear — Essential requirements**

| Test method                                   | Property        | Requirement  |   |   |
|---|-----------------|--|---|---|
| ISO 17694                                     | Flex resistance | For leather,<br>dry 100 000 cycles<br>(w.v.d.) <sup>a</sup><br>wet 20 000 cycles<br>(w.v.d.)   | For coated leather,<br>dry 100 000 cycles<br>(w.v.d.)<br>wet 20 000 cycles<br>(w.v.d.)<br>at – 5 °C 20 000 cycles<br>(w.v.d.) | For other materials,<br>dry 100 000 cycles<br>(w.v.d.)<br>at – 5 °C 20 000 cycles<br>(w.v.d.) |
| ISO 17696                                     | Tear strength   | ≥ 40 N average tear force  |   |   |
| EN ISO 17700                                  | Colour fastness | Inside staining<br>method A: if unlined footwear, must comply ≥ 2/3 after 50 cycles with perspiration solution<br>Outside surface colour change and staining<br>method A: ≥ 3 (grey scale) after 150 cycles dry and 50 cycles wet<br>method B: ≥ 3 to 4 (grey scale) after 512 cycles dry and 128 cycles wet |   |   |
| <sup>a</sup> w.v.d. = without visible damage. |                 |  |   |   |

4.3.2 Additional requirements

These additional requirements should be agreed by both component supplier and footwear manufacturer. See Table 4.

**Table 4 — Test methods and properties for uppers components for school footwear — Additional requirements**

| Subclause  | Test method                | Property                         | Requirement  |  |
|--|----------------------------|----------------------------------|--|--|
| 4.3.2.1  | EN ISO 17693               | Lastability                      | These figures will be influenced by the shape of the footwear<br>≥ 7,0 mm (for leather grain crack)<br>≥ 6,0 mm (for other materials first damage)<br>NOTE This test method is only applicable for component before lasting. |  |
| 4.3.2.2  | ISO 17697                  | Seam strength                    | ≥ 10 N/mm (method A)   |  |
| 4.3.2.3  | EN 1392                    | Bondability <sup>a, b</sup>      | ≥ 4 N/mm   |  |
| 4.3.2.4  | ISO 17699                  | WVP and WVA                      | WVP ≥ 0,8 mg/cm <sup>2</sup> .h<br>If 0,8 mg/cm <sup>2</sup> .h ≤ WVP < 2,0 mg/cm <sup>2</sup> .h then<br>WVA ≥ 8,0 mg/cm <sup>2</sup>   |  |
| 4.3.2.5  | ISO 17701                  | Colour migration                 | 4 h, colour change and staining ≥ 4 (grey scale)   |  |
| 4.3.2.6  | ISO 17702                  | Water resistance                 | Penetration time ≥ 60 min, absorption after 60 min ≤ 20 % (water resistant)<br>Penetration time ≥ 180 min, absorption after 180 min ≤ 25 % (highly water resistant)  |  |
| 4.3.2.7  | ISO 17703                  | High temperature resistance      | The material must keep ≥ 80 % of its original tensile strength and elongation  |  |
| 4.3.2.8  | ISO 17704                  | Abrasion resistance              | dry            wet<br>25 600        12 800   | No worse than moderate abrasion degree |
| 4.3.2.9  | ISO 17706                  | Breaking strength and elongation | ≥ 10 N/mm, elongation ≥ 15 % (across) and ≥ 7 % (along)  |  |
| 4.3.2.10   | EN ISO 4098<br>EN ISO 4047 | Water soluble substance content  | ≤ 3 % sulfated ashed water soluble (SAWS)<br>≤ 18 % total water soluble (TWS)  |  |
| 4.3.2.11   | ISO 17698                  | Delamination resistance          | dry ≥ 0,5 N/mm (for leather)   |  |
|  |                            |                                  | wet ≥ 0,3 N/mm (for leather)   |  |
|  |                            |                                  | dry ≥ 1,0 N/mm (for other materials)<br>wet ≥ 0,7 N/mm (for other materials)   | No worse than moderate abrasion degree |
| <sup>a</sup> Reference adhesives and reference material shall comply with EN 1391.                               |                            |                                  |  |  |
| <sup>b</sup> The dimensions and number of test pieces for this test method shall be those included in ISO 17709. |                            |                                  |  |  |

#### 4.4 Performance requirements for uppers components for casual footwear

##### 4.4.1 Essential requirements

These essential requirements shall be fulfilled in all cases. See Table 5.

**Table 5 — Test methods and properties for uppers components for casual footwear — Essential requirements**

| Test method                                   | Property        | Requirement  |   |   |
|---|-----------------|--|---|---|
| ISO 17694                                     | Flex resistance | For leather,<br>dry 80 000 cycles<br>(w.v.d.) <sup>a</sup><br>wet 20 000 cycles<br>(w.v.d.)  | For coated leather,<br>dry 80 000 cycles (w.v.d.)<br>wet 20 000 cycles<br>(w.v.d.)<br>at – 5 °C 20 000 cycles<br>(w.v.d.) | For other materials,<br>dry 80 000 cycles (w.v.d.)<br>at – 5 °C 20 000 cycles<br>(w.v.d.) |
| ISO 17696                                     | Tear strength   | ≥ 40 N average tear force  |   |   |
| EN ISO 17700                                  | Colour fastness | Inside staining<br>method A: if unlined footwear, must comply ≥ 2/3 after 50 cycles with perspiration solution<br>Outside surface colour change and staining<br>method A: ≥ 3 (grey scale) after 150 cycles dry and 50 cycles wet<br>method B: ≥ 3 to 4 (grey scale) after 512 cycles dry and 128 cycles wet |   |   |
| <sup>a</sup> w.v.d. = without visible damage. |                 |  |   |   |

4.4.2 Additional requirements

These additional requirements should be agreed by both component supplier and footwear manufacturer. See Table 6.

**Table 6 — Test methods and properties for uppers components for casual footwear — Additional requirements**

| Subclause  | Test method                | Property                         | Requirement  |
|--|----------------------------|----------------------------------|--|
| 4.4.2.1  | EN ISO 17693               | Lastability                      | These figures will be influenced by the shape of the footwear<br>$\geq 7,0$ mm (for leather grain crack)<br>$\geq 6,0$ mm (for other materials first damage)<br>NOTE This test method is only applicable for component before lasting. |
| 4.4.2.2  | ISO 17697                  | Seam strength                    | $\geq 8$ N/mm (method A)   |
| 4.4.2.3  | EN 1392                    | Bondability <sup>a, b</sup>      | $\geq 3$ N/mm  |
| 4.4.2.4  | ISO 17699                  | WVP and WVA                      | WVP $\geq 0,8$ mg/cm <sup>2</sup> .h<br>If $0,8$ mg/cm <sup>2</sup> .h $\leq$ WVP $< 2,0$ mg/cm <sup>2</sup> .h<br>then WVA $\geq 8,0$ mg/cm <sup>2</sup>  |
| 4.4.2.5  | ISO 17701                  | Colour migration                 | 24 h, colour change and staining $\geq 4$ (grey scale)   |
| 4.4.2.6  | ISO 17702                  | Water resistance                 | Penetration time $\geq 60$ min, absorption after 60 min $\leq 20$ % (water resistant)<br>Penetration time $\geq 180$ min, absorption after 180 min $\leq 25$ % (highly water resistant)  |
| 4.4.2.7  | ISO 17703                  | High temperature resistance      | the material must keep $\geq 80\%$ of its original tensile strength and elongation   |
| 4.4.2.8  | ISO 17704                  | Abrasion resistance              | dry                      wet<br>12 800                  6 400                  not worse than moderate abrasion degree   |
| 4.4.2.9  | ISO 17706                  | Breaking strength and elongation | $\geq 10$ N/mm, elongation $\geq 15$ % (across) and $\geq 7$ % (along)   |
| 4.4.2.10   | EN ISO 4098<br>EN ISO 4047 | Water soluble substance content  | $\leq 3$ % sulphated ashed water soluble (SAWS)<br>$\leq 18$ % total water soluble (TWS)   |
| 4.4.2.11   | ISO 17698                  | Delamination resistance          | dry $\geq 0,3$ N/mm (for leather)<br>wet $\geq 0,2$ N/mm (for leather)<br>dry $\geq 0,8$ N/mm (for other materials)<br>wet $\geq 0,6$ N/mm (for other materials)   |
| <sup>a</sup> Reference adhesives and reference material shall comply with EN 1391.<br><sup>b</sup> The dimensions and number of test pieces for this test method shall be those included in ISO 17709. |                            |                                  |  |

#### 4.5 Performance requirements for uppers components for men's town footwear

##### 4.5.1 Essential requirements

These essential requirements shall be fulfilled in all cases. See Table 7.

**Table 7 — Test methods and properties for uppers components for men's town footwear — Essential requirements**

| Test method                                   | Property        | Requirement  |   |   |
|---|-----------------|--|---|---|
| ISO 17694                                     | Flex resistance | For leather,<br>dry 80 000 cycles<br>(w.v.d.) <sup>a</sup><br>wet 20 000 cycles<br>(w.v.d.)  | For coated leather,<br>dry 80 000 cycles (w.v.d.)<br>wet 20 000 cycles<br>(w.v.d.)<br>at – 5 °C 20 000 cycles<br>(w.v.d.) | For other materials,<br>dry 80 000 cycles (w.v.d.)<br>at – 5 °C 20 000 cycles<br>(w.v.d.) |
| ISO 17696                                     | Tear strength   | ≥ 40 N average tear force  |   |   |
| EN ISO 17700                                  | Colour fastness | Inside staining<br>method A: if unlined footwear, must comply ≥ 2/3 after 50 cycles with perspiration solution<br>Outside surface colour change and staining<br>method A: ≥ 3 (grey scale) after 100 cycles dry and 50 cycles wet<br>method B: ≥ 3 to 4 (grey scale) after 256 cycles dry and 128 cycles wet |   |   |
| <sup>a</sup> w.v.d. = without visible damage. |                 |  |   |   |

## 4.5.2 Additional requirements

These additional requirements should be agreed by both component supplier and footwear manufacturer. See Table 8.

**Table 8 — Test methods and properties for uppers components for men's town footwear — Additional requirements**

| Subclause    | Test method   | Property                         | Requirement   |
|--------------|---|----------------------------------|---|
| 4.5.2.1      | EN ISO 17693  | Lastability                      | These figures will be influenced by the shape of the footwear<br>$\geq 7,0$ mm (for leather grain crack)<br>$\geq 6,0$ mm (for other materials first damage)<br>NOTE: This test method is only applicable for component before lasting. |
| 4.5.2.2      | ISO 17697   | Seam strength                    | $\geq 8$ N/mm (method A)  |
| 4.5.2.3      | EN 1392   | Bondability <sup>a, b</sup>      | $\geq 3,5$ N/mm   |
| 4.5.2.4      | ISO 17699   | WVP and WVA                      | WVP $\geq 0,8$ mg/cm <sup>2</sup> .h<br>If $0,8$ mg/cm <sup>2</sup> .h $\leq$ WVP $< 2,0$ mg/cm <sup>2</sup> .h then<br>WVA $\geq 8,0$ mg/cm <sup>2</sup>   |
| 4.5.2.5      | ISO 17701   | Colour migration                 | 24 h, colour change and staining $\geq 4$ (grey scale)  |
| 4.5.2.6      | ISO 17702   | Water resistance                 | Penetration time $\geq 60$ min, absorption after 60 min $\leq 20$ %<br>(water resistant)<br>Penetration time $\geq 180$ min, absorption after 180 min $\leq 25$ %<br>(highly water resistant)   |
| 4.5.2.7      | ISO 17703   | High temperature resistance      | The material must keep $\geq 80$ % of its original tensile strength and elongation  |
| 4.5.2.8      | ISO 17704   | Abrasion resistance              | dry            wet<br>12 800        6 400<br>No worse than moderate abrasion degree   |
| 4.5.2.9      | ISO 17706   | Breaking strength and elongation | $\geq 10$ N/mm, elongation $\geq 15$ % (across) and $\geq 7$ % (along)  |
| 4.5.2.10     | EN ISO 4098<br>EN ISO 4047  | Water soluble substance content  | $\leq 3$ % sulfated ashed water soluble (SAWS)<br>$\leq 18$ % total water soluble (TWS)   |
| 4.5.2.11     | ISO 17698   | Delamination resistance          | dry $\geq 0,3$ N/mm (for leather)<br>wet $\geq 0,2$ N/mm (for leather)<br>dry $\geq 0,8$ N/mm (for other materials)<br>wet $\geq 0,6$ N/mm (for other materials)  |
| <sup>a</sup> | Reference adhesives and reference material shall comply with EN 1391.                               |                                  |   |
| <sup>b</sup> | The dimensions and number of test pieces for this test method shall be those included in ISO 17709. |                                  |   |

## 4.6 Performance requirements for uppers components for cold weather footwear

### 4.6.1 Essential requirements

These essential requirements shall be fulfilled in all cases. See Table 9.

**Table 9 — Test methods and properties for uppers components for cold weather footwear — Essential requirements**

| Test method                                   | Property           | Requirement  |  |  |
|---|--------------------|--|--|--|
| ISO 17694                                     | Flex resistance    | For leather,<br>dry 100 000 cycles<br>(w.v.d.) <sup>a</sup><br>wet 20 000 cycles<br>(w.v.d.)   | For coated leather,<br>dry 100 000 cycles<br>(w.v.d.)<br>wet 20 000 cycles<br>(w.v.d.)<br>at – 20 °C 30 000 cycles<br>(w.v.d.) | For other materials,<br>dry 100 000 cycles<br>(w.v.d.)<br>at – 20 °C 30 000 cycles<br>(w.v.d.) |
| ISO 17696                                     | Tear strength      | ≥ 40 N average tear force  |  |  |
| EN ISO 17700                                  | Colour fastness    | Inside staining<br>method A: if unlined footwear, must comply ≥ 2/3 after 50 cycles with perspiration solution<br>Outside surface colour change and staining<br>method A: ≥ 3 (grey scale) after 150 cycles dry and 50 cycles wet<br>method B: ≥ 3 to 4 (grey scale) after 512 cycles dry and 128 cycles wet |  |  |
| ISO 17702                                     | Water resistance   | Penetration time ≥ 240 min, absorption ≤ 20 %  |  |  |
| ISO 17705                                     | Thermal insulation | ≥ 24·10 <sup>-3</sup> m <sup>2</sup> ·°C/W   |  |  |
| <sup>a</sup> w.v.d. = without visible damage. |                    |  |  |  |

4.6.2 Additional requirements

These additional requirements should be agreed by both component supplier and footwear manufacturer. See Table 10.

**Table 10 — Test methods and properties for uppers components for cold weather footwear — Additional requirements**

| Subclause  | Test method                | Property                         | Requirement  |  |
|--|----------------------------|----------------------------------|--|--|
| 4.6.2.1  | EN ISO 17693               | Lastability                      | These figures will be influenced by the shape of the footwear<br>≥ 7,0 mm (for leather grain crack)<br>≥ 6,0 mm (for other materials first damage)<br>NOTE This test method is only applicable for component before lasting. |  |
| 4.6.2.2  | ISO 17697                  | Seam strength                    | ≥ 10 N/mm (method A)   |  |
| 4.6.2.3  | EN 1392                    | Bondability <sup>a, b</sup>      | ≥ 4 N/mm   |  |
| 4.6.2.4  | ISO 17699                  | WVP and WVA                      | WVP ≥ 0,8 mg/cm <sup>2</sup> .h<br>If 0,8 mg/cm <sup>2</sup> .h ≤ WVP < 2,0 mg/cm <sup>2</sup> .h then<br>WVA ≥ 5,0 mg/cm <sup>2</sup>   |  |
| 4.6.2.5  | ISO 17701                  | Colour migration                 | 24 h, colour change and staining ≥ 4 (grey scale)  |  |
| 4.6.2.6  | ISO 17703                  | High temperature resistance      | The material must keep ≥ 80 % of its original tensile strength and elongation  |  |
| 4.6.2.7  | ISO 17704                  | Abrasion resistance              | dry            wet<br>25 600        12 800   | No worse than moderate abrasion degree |
| 4.6.2.8  | 17706                      | Breaking strength and elongation | ≥ 10 N/mm, elongation ≥ 15 % (across) and ≥ 7 % (along)  |  |
| 4.6.2.9  | EN ISO 4098<br>EN ISO 4047 | Water soluble substance content  | ≤ 3 % sulfated ashed water soluble (SAWS)<br>≤ 18 % total water soluble (TWS)  |  |
| 4.6.2.10   | ISO 17698                  | Delamination resistance          | dry ≥ 0,5 N/mm (for leather)<br>wet ≥ 0,3 N/mm (for leather)<br>dry ≥ 1,0 N/mm (for other materials)<br>wet ≥ 0,7 N/mm (for other materials)   |  |
| <sup>a</sup> Reference adhesives and reference material shall comply with EN 1391.<br><sup>b</sup> The dimensions and number of test pieces for this test method shall be those included in ISO 17709. |                            |                                  |  |  |

## 4.7 Performance requirements for uppers components for women's town footwear

### 4.7.1 Essential requirements

These essential requirements shall be fulfilled in all cases. See Table 11.

**Table 11 — Test methods and properties for uppers components for women's town footwear — Essential requirements**

| Test method                                   | Property        | Requirement  |   |   |
|---|-----------------|--|---|---|
| ISO 17694                                     | Flex resistance | For leather,<br>dry 50 000 cycles<br>(w.v.d.) <sup>a</sup><br>wet 10 000 cycles<br>(w.v.d.)  | For coated leather,<br>dry 50 000 cycles (w.v.d.)<br>wet 10 000 cycles<br>(w.v.d.)<br>at – 5 °C 20 000 cycles<br>(w.v.d.) | For other materials,<br>dry 50 000 cycles (w.v.d.)<br>at – 5 °C 20 000 cycles<br>(w.v.d.) |
| ISO 17696                                     | Tear strength   | ≥ 40 N average tear force  |   |   |
| EN ISO 17700                                  | Colour fastness | Inside staining<br>method A: if unlined footwear, must comply ≥ 2/3 after 50 cycles with perspiration solution<br>Outside surface colour change and staining<br>method A: ≥ 3 (grey scale) after 100 cycles dry and 50 cycles wet<br>method B: ≥ 3 to 4 (grey scale) after 256 cycles dry and 128 cycles wet |   |   |
| <sup>a</sup> w.v.d. = without visible damage. |                 |  |   |   |

## 4.7.2 Additional requirements

These additional requirements should be agreed by both component supplier and footwear manufacturer. See Table 12.

**Table 12 — Test methods and properties for uppers components for women's town footwear — Additional requirements**

| Subclause    | Test method   | Property                         | Requirement  |
|--------------|---|----------------------------------|--|
| 4.7.2.1      | EN ISO 17693  | Lastability                      | These figures will be influenced by the shape of the footwear<br>$\geq 7,0$ mm (for leather grain crack)<br>$\geq 6,0$ mm (for other materials first damage)<br>NOTE This test method is only applicable for component before lasting. |
| 4.7.2.2      | ISO 17697   | Seam strength                    | $\geq 4$ N/mm (method A)   |
| 4.7.2.3      | EN 1392   | Bondability <sup>a, b</sup>      | $\geq 3$ N/mm  |
| 4.7.2.4      | ISO 17699   | WVP and WVA                      | WVP $\geq 0,8$ mg/cm <sup>2</sup> .h<br>If $0,8$ mg/cm <sup>2</sup> .h $\leq$ WVP $< 2,0$ mg/cm <sup>2</sup> .h then<br>WVA $\geq 8,0$ mg/cm <sup>2</sup>  |
| 4.7.2.5      | ISO 17701   | Colour migration                 | 24 h, colour change and staining $\geq 4$ (grey scale)   |
| 4.7.2.6      | ISO 17702   | Water resistance                 | Penetration time $\geq 60$ min, absorption after 60 min $\leq 20$ % (water resistant)<br>Penetration time $\geq 180$ min, absorption after 180 min $\leq 25$ % (highly water resistant)  |
| 4.7.2.7      | ISO 17703   | High temperature resistance      | The material must keep $\geq 80$ % of its original tensile strength and elongation   |
| 4.7.2.8      | ISO 17704   | Abrasion resistance              | dry            wet<br>12 800        6 400            not worse than moderate abrasion degree   |
| 4.7.2.9      | ISO 17706   | Breaking strength and elongation | $\geq 8$ N/mm, elongation $\geq 15$ % (across) and $\geq 7$ % (along)  |
| 4.7.2.10     | EN ISO 4098<br>EN ISO 4047  | Water soluble substance content  | $\leq 3$ % sulfated ashed water soluble (SAWS)<br>$\leq 18$ % total water soluble (TWS)  |
| 4.7.2.11     | ISO 17698   | Delamination resistance          | dry $\geq 0,3$ N/mm (for leather)<br>wet $\geq 0,2$ N/mm (for leather)<br>dry $\geq 0,8$ N/mm (for other materials)<br>wet $\geq 0,6$ N/mm (for other materials)   |
| <sup>a</sup> | Reference adhesives and reference material shall comply with EN 1391.                               |                                  |  |
| <sup>b</sup> | The dimensions and number of test pieces for this test method shall be those included in ISO 17709. |                                  |  |

## 4.8 Performance requirements for uppers components for fashion footwear

### 4.8.1 Essential requirements

These essential requirements shall be fulfilled in all cases.

**Table 13 — Test methods and properties for uppers components for fashion footwear — Essential requirements**

| Test method  | Property        | Requirement  |
|--------------|-----------------|--|
| ISO 17694    | Flex resistance | dry 15 000 cycles without visible damage   |
| ISO 17696    | Tear strength   | ≥ 30 N average tear force  |
| EN ISO 17700 | Colour fastness | <p>Inside staining</p> <p>method A: if unlined footwear, must comply ≥ 2/3 after 50 cycles with perspiration solution</p> <p>Outside surface colour change and staining</p> <p>method A: ≥ 2 (grey scale) after 100 cycles dry and 20 cycles wet</p> <p>method B: ≥ 2 to 3 (grey scale) after 256 cycles dry and 64 cycles wet</p> |

### 4.8.2 Additional requirements

These additional requirements should be agreed by both component supplier and footwear manufacturer. See Table 14.

**Table 14 — Test methods and properties for uppers components for fashion footwear — Additional requirements**

| Subclause | Test method                | Property                        | Requirement   |
|-----------|----------------------------|---------------------------------|---|
| 4.8.2.1   | EN ISO 17693               | Lastability                     | <p>These figures will be influenced by the shape of the footwear</p> <p>≥ 7,0 mm (for leather grain crack)</p> <p>≥ 6,0 mm (for other materials first damage)</p> <p>NOTE This test method is only applicable for component before lasting.</p> |
| 4.8.2.2   | ISO 17697                  | Seam strength                   | ≥ 3 N/mm (method A)   |
| 4.8.2.3   | EN 1392                    | Bondability <sup>a, b</sup>     | ≥ 2,5 N/mm  |
| 4.8.2.4   | ISO 17701                  | Colour migration                | 24 h, colour change and staining ≥ 4 (grey scale)   |
| 4.8.2.5   | ISO 17698                  | Delamination resistance         | <p>dry ≥ 0,2 N/mm (for leather)</p> <p>wet ≥ 0,1 N/mm (for leather)</p> <p>dry ≥ 0,7 N/mm (for other materials)</p> <p>wet ≥ 0,5 N/mm (for other materials)</p>   |
| 4.8.2.6   | EN ISO 4098<br>EN ISO 4047 | Water soluble substance content | <p>≤ 3 % sulfated ashed water soluble (SAWS)</p> <p>≤ 18 % total water soluble (TWS)</p>  |

<sup>a</sup> Reference adhesives and reference material shall comply with EN 1391.

<sup>b</sup> The dimensions and number of test pieces for this test method shall be those included in ISO 17709.