

First edition
2007-02-15

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

*Chaussures — Exigences de performance pour les composants des
chaussures — Semelles d'usure*



Reference number
ISO/TR 20880:2007(E)

© ISO 2007

PDF disclaimer

This PDF file may contain embedded typefaces. In accordance with Adobe's licensing policy, this file may be printed or viewed but shall not be edited unless the typefaces which are embedded are licensed to and installed on the computer performing the editing. In downloading this file, parties accept therein the responsibility of not infringing Adobe's licensing policy. The ISO Central Secretariat accepts no liability in this area.

Adobe is a trademark of Adobe Systems Incorporated.

Details of the software products used to create this PDF file can be found in the General Info relative to the file; the PDF-creation parameters were optimized for printing. Every care has been taken to ensure that the file is suitable for use by ISO member bodies. In the unlikely event that a problem relating to it is found, please inform the Central Secretariat at the address given below.

© ISO 2007

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office
Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 749 09 47
E-mail copyright@iso.org
Web www.iso.org

Published in Switzerland

Contents

Page

Foreword	iv
1 Scope	1
2 Normative references	1
3 Terms and definitions	2
4 Requirements	2
4.1 General	2
4.2 Performance requirements for outsoles components for general purpose sports footwear	2
4.3 Performance requirements for outsoles components for school footwear	4
4.4 Performance requirements for outsoles components for casual footwear	6
4.5 Performance requirements for outsoles components for men's town footwear	8
4.6 Performance requirements for outsoles components for cold weather footwear	9
4.7 Performance requirements for outsoles components for women's town footwear	10
4.8 Performance requirements for outsoles components for fashion footwear	11
4.9 Performance requirements for outsoles components for infants' footwear	13
4.10 Performance requirements for outsoles components for indoor footwear	14
5 Marking and labelling	15

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 20880 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 — Outsoles

1 Scope

This Technical Report establishes the performance requirements for outsoles 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 outsoles for all kind 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 ISO 5404, *Leather — Physical and mechanical tests — Determination of the water resistance of heavy leathers*

EN ISO 17707, *Footwear — Test methods for outsoles — Flex resistance*

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

EN ISO 19952, *Footwear — Vocabulary*

ISO 20865, *Footwear — Test methods for outsoles — Compression energy*

ISO 20869, *Footwear — Test methods for outsoles, insoles, lining and insoles — Water soluble content*

ISO 20871, *Footwear — Test methods for outsoles — Abrasion resistance*

ISO 20872, *Footwear — Test methods for outsoles — Tear strength*

ISO 20873, *Footwear — Test methods for outsoles — Dimensional stability*

ISO 20874, *Footwear — Test methods for outsoles — Needle tear strength*

ISO 20875, *Footwear — Test methods for outsoles — Determination of split tear strength and delamination resistance*

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 13287, *Personal protective equipment — Footwear — Test method for slip resistance*

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 the subclauses 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 outsoles 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 method and properties for general sports footwear — Essential requirements

Test method	Property	Requirement
EN ISO 17707	Flex resistance	cut growth $\leq 4,0$ mm, and no spontaneous crack
ISO 20871	Abrasion resistance	$0,9 \text{ g/cm}^3 \leq d \leq 200 \text{ mm}^3$ $0,9 \text{ g/cm}^3 > d \leq 150 \text{ mg}$
ISO 20875	Delamination resistance or split tear ^a	$0,9 \text{ g/cm}^3 \leq d \geq 3,0 \text{ N/mm}$ $0,9 \text{ g/cm}^3 > d \geq 1,7 \text{ N/mm}$
EN 13287	Slip resistance ^b	$\geq 0,30$ (flat slip) $\geq 0,28$ (heel slip) In both cases must be tested using ceramic tiles (floor) and water and detergent (lubricant)
^a	This requirement is considered essential only in multilayer outsoles.	
^b	This test method is only applicable for finished footwear.	

4.2.2 Additional requirements

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

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

Subclause	Test method	Property	Requirement
4.2.2.1	ISO 20873	Dimensional stability	$\leq 2,5 \%$
4.2.2.2	ISO 20865	Compression energy	$\geq 15 \text{ J}$
4.2.2.3	EN 1392	Bondability ^{a, b, c}	$0,9 \text{ g/cm}^3 \leq d \leq 4,0 \text{ N/mm}$ $0,9 \text{ g/cm}^3 > d \geq 3,0 \text{ N/mm}$
4.2.2.4	ISO 20869	Water soluble substances content	water soluble matter $\leq 18 \%$ sulfated ashed water soluble $\leq 3 \%$ (applicable only for leather)
4.2.2.5	ISO 20872	Tear strength	$0,9 \text{ g/cm}^3 \leq d \leq 8,0 \text{ N/mm}$ $0,9 \text{ g/cm}^3 > d \geq 6,0 \text{ N/mm}$
4.2.2.6	EN/ISO 5404	Water resistance	a) Water resistant Penetration time $\geq 30 \text{ min}$ and after 30 min water absorption $\leq 25 \%$ b) Highly water resistant Penetration time $\geq 60 \text{ min}$ and after 60 min water absorption $\leq 15 \%$ (only applicable for leather and porous materials)
4.2.2.7	ISO 20874	Needle tear strength ^d	$\geq 40 \text{ N/mm}$
^a A value below the established will be considered as negative independent of the type of failure. ^b Reference adhesives and reference material shall comply with EN 1391. ^c The dimensions and number of test pieces for this test method shall be those included in ISO 17709. ^d This requirement is applicable only for sewn footwear.			

4.3 Performance requirements for outsoles components for school footwear

4.3.1 Essential requirements

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

Table 3 — Test method and properties for school footwear — Essential requirements

Test method	Property	Requirement
EN ISO 17707	Flex resistance	cut growth $\leq 4,0$ mm, and no spontaneous crack
ISO 20871	Abrasion resistance	$0,9 \text{ g/cm}^3 \leq d \leq 200 \text{ mm}^3$ $0,9 \text{ g/cm}^3 > d \leq 150 \text{ mg}$
ISO 20875	Delamination resistance or split tear ^a	$0,9 \text{ g/cm}^3 \leq d \geq 3,0 \text{ N/mm}$ $0,9 \text{ g/cm}^3 > d \geq 1,7 \text{ N/mm}$
EN 13287	Slip resistance ^b	$\geq 0,30$ (flat slip) $\geq 0,28$ (heel slip) In both cases must be tested using ceramic tiles (floor) and water and detergent (lubricant)
^a	This requirement is considered essential only in multilayer outsoles.	
^b	This test method is only applicable for finished footwear.	

4.3.2 Additional requirements

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

Table 4 — Test method and properties for school footwear — Additional requirements

Subclause	Test method	Property	Requirement
4.3.2.1	ISO 20873	Dimensional stability	$\leq 2,5 \%$
4.3.2.2	ISO 20865	Compression energy	$\geq 15 \text{ J}$
4.3.2.3	EN 1392	Bondability ^{a, b, c}	$0,9 \text{ g/cm}^3 \leq d \leq 4,0 \text{ N/mm}$ $0,9 \text{ g/cm}^3 > d \geq 3,0 \text{ N/mm}$
4.3.2.4	ISO 20869	Water soluble substances content	water soluble matter $\leq 18 \%$ sulfated ashed water soluble $\leq 3 \%$ (applicable only for leather)
4.3.2.5	ISO 20872	Tear strength	$0,9 \text{ g/cm}^3 \leq d \leq 8,0 \text{ N/mm}$ $0,9 \text{ g/cm}^3 > d \geq 6,0 \text{ N/mm}$
4.3.2.6	EN ISO 5404	Water resistance	a) Water resistant Penetration time $\geq 60 \text{ min}$ and after 60 min water absorption $\leq 15 \%$ b) Highly water resistant Penetration time $\geq 30 \text{ min}$ and after 30 min water absorption $\leq 25 \%$ (applicable only for leather and porous materials)
4.3.2.7	ISO 20874	Needle tear strength ^d	$\geq 35 \text{ N/mm}$
<p>^a A value below the established will be considered as negative independent of the type of failure.</p> <p>^b Reference adhesives and reference material shall comply with EN 1391.</p> <p>^c The dimensions and number of test pieces for this test method shall be those included in ISO 17709.</p> <p>^d This requirement is applicable only for sewn footwear.</p>			

4.4 Performance requirements for outsoles components for casual footwear

4.4.1 Essential requirements

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

Table 5 — Test method and properties for casual footwear — Essential requirements

Test method	Property	Requirement
EN ISO 17707	Flex resistance	cut growth $\leq 5,0$ mm, and no spontaneous crack
ISO 20871	Abrasion resistance	$0,9 \text{ g/cm}^3 \leq d \leq 250 \text{ mm}^3$ $0,9 \text{ g/cm}^3 > d \leq 170 \text{ mg}$
ISO 20875	Delamination resistance or split tear ^a	$0,9 \text{ g/cm}^3 \leq d \geq 3,0 \text{ N/mm}$ $0,9 \text{ g/cm}^3 > d \geq 1,7 \text{ N/mm}$
EN 13287	Slip resistance ^b	$\geq 0,30$ (flat slip) $\geq 0,28$ (heel slip) In both cases must be tested using ceramic tiles (floor) and water and detergent (lubricant)
^a This requirement is considered essential only in multilayer soles. ^b This test method is only applicable for finished footwear.		

4.4.2 Additional requirements

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

Table 6 — Test method and properties for casual footwear — Additional requirements

Subclause	Test method	Property	Requirement
4.4.2.1	ISO 20873	Dimensional stability	$\leq 2,5 \%$
4.4.2.2	ISO 20865	Compression energy	$\geq 15 \text{ J}$
4.4.2.3	EN 1392	Bondability ^{a, b, c}	$0,9 \text{ g/cm}^3 \leq d \leq 3,5 \text{ N/mm}$ $0,9 \text{ g/cm}^3 > d \geq 3,0 \text{ N/mm}$
4.4.2.4	ISO 20869	Water soluble substances content	water soluble matter $\leq 18 \%$ sulphated ashed water soluble $\leq 3 \%$ (applicable only for leather)
4.4.2.5	ISO 20872	Tear strength	$0,9 \text{ g/cm}^3 \leq d \leq 8,0 \text{ N/mm}$ $0,9 \text{ g/cm}^3 > d \geq 6,0 \text{ N/mm}$
4.4.2.6	EN ISO 5404	Water resistance	a) Water resistant Penetration time $\geq 30 \text{ min}$ and after 30 min water absorption $\leq 25 \%$ b) Highly water resistant Penetration time $\geq 60 \text{ min}$ and after 60 min water absorption $\leq 15 \%$ (only applicable for leather and porous materials)
4.4.2.7	ISO 20874	Needle tear strength ^d	$\geq 35 \text{ N/mm}$
<p>^a A value below the established will be considered as negative independent of the type of failure.</p> <p>^b Reference adhesives and reference material shall comply with EN 1391.</p> <p>^c The dimensions and number of test pieces for this test method shall be those included in ISO 17709.</p> <p>^d This requirement is applicable only for sewn footwear.</p>			

4.5 Performance requirements for outsoles 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 method and properties for men's town footwear — Essential requirements

Test method	Property	Requirement
EN ISO 17707	Flex resistance	cut growth $\leq 6,0$ mm, and no spontaneous crack
ISO 20871	Abrasion resistance	$0,9 \text{ g/cm}^3 \leq d \leq 350 \text{ mm}^3$ $0,9 \text{ g/cm}^3 > d \leq 200 \text{ mg}$
ISO 20875	Delamination resistance or split tear ^a	$0,9 \text{ g/cm}^3 \leq d \geq 3,0 \text{ N/mm}$ $0,9 \text{ g/cm}^3 > d \geq 1,7 \text{ N/mm}$
EN 13287	Slip resistance ^b	$\geq 0,30$ (flat slip) $\geq 0,28$ (heel slip) In both cases must be tested using ceramic tiles (floor) and water and detergent (lubricant)
<p>a This requirement is considered essential only in multilayer outsoles.</p> <p>b This test method is only applicable for finished footwear.</p>		

4.5.2 Additional requirements

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

Table 8 — Test method and properties for men's town footwear — Additional requirements

Subclause	Test method	Property	Requirement
4.5.2.1	ISO 20873	Dimensional stability	$\leq 2,5 \%$
4.5.2.2	ISO 20865	Compression energy	$\geq 15 \text{ J}$
4.5.2.3	EN 1392	Bondability ^{a, b, c}	$0,9 \text{ g/cm}^3 \leq d \geq 3,5 \text{ N/mm}$ $0,9 \text{ g/cm}^3 > d \geq 3,0 \text{ N/mm}$
4.5.2.4	ISO 20869	Water soluble substances content	water soluble matter $\leq 18 \%$ sulphated ashed water soluble $\leq 3 \%$ (applicable only for leather)
4.5.2.5	ISO 20872	Tear strength	$0,9 \text{ g/cm}^3 \leq d \geq 7,0 \text{ N/mm}$ $0,9 \text{ g/cm}^3 > d \geq 4,0 \text{ N/mm}$
4.5.2.6	EN ISO 5404	Water resistance	a) Water resistant Penetration time $\geq 30 \text{ min}$ and after 30 min water absorption $\leq 25 \%$ b) Highly water resistant Penetration time $\geq 60 \text{ min}$ and after 60 min water absorption $\leq 15 \%$ (only applicable for leather and porous materials)
4.5.2.7	ISO 20874	Needle tear strength ^d	$\geq 30 \text{ N/mm}$
<p>^a A value below the established will be considered as negative independent of the type of failure.</p> <p>^b Reference adhesives and reference material shall comply with EN 1391.</p> <p>^c The dimensions and number of test pieces for this test method shall be those included in ISO 17709.</p> <p>^d This requirement is applicable only for sewn footwear.</p>			

4.6 Performance requirements for outsoles 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 method and properties for cold weather footwear — Essential requirements

Test method	Property	Requirement
EN ISO 17707	Flex resistance	cut growth $\leq 6,0 \text{ mm}$ and no spontaneous crack, at $-10 \text{ }^\circ\text{C}$
ISO 20871	Abrasion resistance	$0,9 \text{ g/cm}^3 \leq d \leq 200 \text{ mm}^3$ $0,9 \text{ g/cm}^3 > d \leq 150 \text{ mg}$
ISO 20875	Delamination resistance or split tear ^a	$0,9 \text{ g/cm}^3 \leq d \geq 3,0 \text{ N/mm}$ $0,9 \text{ g/cm}^3 > d \geq 1,7 \text{ N/mm}$
EN 13287	Slip resistance ^b	$\geq 0,30$ (flat slip) $\geq 0,28$ (heel slip) In both cases must be tested using ceramic tiles (floor) and water and detergent (lubricant)
<p>^a This requirement is considered essential only in multilayer outsoles.</p> <p>^b This test method is only applicable for finished footwear.</p>		

4.6.2 Additional requirements

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

Table 10 — Test method and properties for cold weather footwear — Additional requirements

Subclause	Test method	Property	Requirement
4.6.2.1	ISO 20873	Dimensional stability	$\leq 2,5 \%$
4.6.2.2	ISO 20865	Compression energy	$\geq 15 \text{ J}$
4.6.2.3	EN 1392	Bondability ^{a, b, c}	$0,9 \text{ g/cm}^3 \leq d \geq 3,5 \text{ N/mm}$ $0,9 \text{ g/cm}^3 > d \geq 3,0 \text{ N/mm}$
4.6.2.4	ISO 20869	Water soluble substances content	water soluble matter $\leq 18 \%$ sulfated ashed water soluble $\leq 3 \%$ (applicable only for leather)
4.6.2.5	ISO 20872	Tear strength	$0,9 \text{ g/cm}^3 \leq d \geq 8,0 \text{ N/mm}$ $0,9 \text{ g/cm}^3 > d \geq 6,0 \text{ N/mm}$
4.6.2.6	EN ISO 5404	Water resistance	Penetration time $\geq 60 \text{ min}$ and after 60 min water absorption $\leq 15 \%$ (only applicable for leather and porous materials)
4.6.2.7	ISO 20874	Needle tear strength ^d	$\geq 35 \text{ N/mm}$
^a A value below the established will be considered as negative independent of the type of failure. ^b Reference adhesives and reference material shall comply with EN 1391. ^c The dimensions and number of test pieces for this test method shall be those included in ISO 17709. ^d This requirement is applicable only for sewn footwear.			

4.7 Performance requirements for outsoles 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 method and properties for women's town footwear — Essential requirements

Test method	Property	Requirement
EN ISO 17707	Flex resistance	cut growth $\leq 8,0 \text{ mm}$, and no spontaneous crack
ISO 20871	Abrasion resistance	$0,9 \text{ g/cm}^3 \leq d \leq 400 \text{ mm}^3$ $0,9 \text{ g/cm}^3 > d \leq 250 \text{ mg}$
ISO 20875	Delamination resistance or split tear ^a	$0,9 \text{ g/cm}^3 \leq d \geq 3,0 \text{ N/mm}$ $0,9 \text{ g/cm}^3 > d \geq 1,7 \text{ N/mm}$
EN 13287	Slip resistance ^b	$\geq 0,30$ (flat slip) $\geq 0,28$ (heel slip) In both cases must be tested using ceramic tiles (floor) and water and detergent (lubricant)
^a This requirement is considered essential only in multilayer outsoles. ^b This test method is only applicable for finished footwear.		

4.7.2 Additional requirements

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

Table 12 — Test method and properties for women's town footwear — Additional requirements

Subclause	Test method	Property	Requirement
4.7.2.1	ISO 20873	Dimensional stability	$\leq 2,5 \%$
4.7.2.2	ISO 20865	Compression energy	$\geq 10 \text{ J}$
4.7.2.3	EN 1392	Bondability ^{a, b, c}	$\geq 3,0 \text{ N/mm}$
4.7.2.4	ISO 20869	Water soluble substances content	water soluble matter $\leq 18 \%$ sulphated ashed water soluble $\leq 3 \%$ (applicable only for leather)
4.7.2.5	ISO 20872	Tear strength	$0,9 \text{ g/cm}^3 \leq d \leq 7,0 \text{ N/mm}$ $0,9 \text{ g/cm}^3 > d \geq 4,0 \text{ N/mm}$
4.7.2.6	EN ISO 5404	Water resistance	a) Water resistant Penetration time $\geq 30 \text{ min}$ and after 30 min water absorption $\leq 25 \%$ b) Highly water resistant Penetration time $\geq 60 \text{ min}$ and after 60 min water absorption $\leq 15 \%$ (only applicable for leather and porous materials)
4.7.2.7	ISO 20874	Needle tear strength ^d	$\geq 30 \text{ N/mm}$
<p>^a A value below the established will be considered as negative independent of the type of failure.</p> <p>^b Reference adhesives and reference material shall comply with EN 1391.</p> <p>^c The dimensions and number of test pieces for this test method shall be those included in ISO 17709.</p> <p>^d This requirement is applicable only for sewn footwear.</p>			

4.8 Performance requirements for outsoles components for fashion footwear

4.8.1 Essential requirements

These essential requirements shall be fulfilled in all cases. See Table 13.

Table 13 — Test method and properties for fashion footwear — Essential requirements

Test method	Property	Requirement
EN ISO 17707	Flex resistance	cut growth $\leq 12 \text{ mm}$, and no spontaneous crack
ISO 20871	Abrasion resistance	$0,9 \text{ g/cm}^3 \leq d \leq 450 \text{ mm}^3$ $0,9 \text{ g/cm}^3 > d \leq 300 \text{ mg}$
EN 13287	Slip resistance ^a	$\geq 0,30$ (flat slip) $\geq 0,28$ (heel slip) In both cases must be tested using ceramic tiles (floor) and water and detergent (lubricant)
<p>^a This test method is only applicable for finished footwear.</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 method and properties for fashion footwear — Additional requirements

Subclause	Test method	Property	Requirement
4.8.2.1	ISO 20875	Delamination resistance or split tear ^a	0,9 g/cm ³ ≤ <i>d</i> ≥ 3,0 N/mm 0,9 g/cm ³ > <i>d</i> ≥ 1,7 N/mm
4.8.2.2	ISO 20873	Dimensional stability	≤ 2,5 %
4.8.2.3	ISO 20865	Compression energy	≥ 10 J
4.8.2.4	EN 1392	Bondability ^{b, c, d}	≥ 2,5 N/mm
4.8.2.5	ISO 20869	Water soluble substances content	water soluble matter ≤ 18 % sulphated ashed water soluble ≤ 3 % (applicable only for leather)
4.8.2.6	ISO 20872	Tear strength	0,9 g/cm ³ ≤ <i>d</i> ≥ 5,0 N/mm 0,9 g/cm ³ > <i>d</i> ≥ 4,0 N/mm
4.8.2.7	EN ISO 5404	Water resistance	penetration time ≥ 30 min and after 30 min water absorption ≤ 25 % (applicable only for leather and porous materials)
4.8.2.8	ISO 20874	Needle tear strength ^e	≥ 20 N/mm
^a This requirement is considered essential only in multilayer outsoles. ^b A value below the established will be considered as negative independent of the type of failure. ^c Reference adhesives and reference material shall comply with EN 1391. ^d The dimensions and number of test pieces for this test method shall be those included in ISO 17709. ^e This requirement is applicable only for sewn footwear.			

4.9 Performance requirements for outsoles components for infants' footwear

4.9.1 Essential requirements

These essential requirements shall be fulfilled in all cases. See Table 15.

Table 15 — Test method and properties for infants' footwear — Essential requirements

Test method	Property	Requirement
ISO 20872	Tear strength	$0,9 \text{ g/cm}^3 \leq d \leq 5,0 \text{ N/mm}$ $0,9 \text{ g/cm}^3 > d \geq 4,0 \text{ N/mm}$
ISO 20871	Abrasion resistance	$0,9 \text{ g/cm}^3 \leq d \leq 400 \text{ mm}^3$ $0,9 \text{ g/cm}^3 > d \leq 250 \text{ mg}$
ISO 20875	Delamination resistance or split tear ^a	$0,9 \text{ g/cm}^3 \leq d \geq 3,0 \text{ N/mm}$ $0,9 \text{ g/cm}^3 > d \geq 1,7 \text{ N/mm}$
EN 13287	Slip resistance ^b	$\geq 0,30$ (flat slip) $\geq 0,28$ (heel slip) In both cases must be tested using ceramic tiles (floor) and water and detergent (lubricant)
<p>a This requirement is considered essential only in multilayer outsoles.</p> <p>b This test method is only applicable for finished footwear.</p>		

4.9.2 Additional requirements

These additional requirements should be agreed by both component supplier and footwear manufacturer. See Table 16.

Table 16 — Test method and properties for infants' footwear — Additional requirements

Subclause	Test method	Property	Requirement
4.9.2.1	ISO 20873	Dimensional stability	$\leq 2,5 \%$
4.9.2.2	ISO 20865	Compression energy	$\geq 8 \text{ J}$
4.9.2.3	EN 1392	Bondability ^{a, b, c}	$\geq 3,0 \text{ N/mm}$
4.9.2.4	ISO 20869	Water soluble substances content	water soluble matter $\leq 16 \%$ sulfated ashed water soluble $\leq 3 \%$ (applicable only for leather)
4.9.2.5	ISO 20874	Needle tear strength ^d	$\geq 20 \text{ N/mm}$
<p>a A value below the established will be considered as negative independently of the type of failure.</p> <p>b Reference adhesives and reference material shall comply with EN 1391.</p> <p>c The dimensions and number of test pieces for this test method shall be those included in ISO 17709.</p> <p>d This requirement is applicable only for sewn footwear.</p>			

4.10 Performance requirements for outsoles components for indoor footwear

4.10.1 Essential requirements

These essential requirements shall be fulfilled in all cases. See Table 17.

Table 17 — Test method and properties for indoor footwear — Essential requirements

Test method	Property	Requirement
EN ISO 17707	Flex resistance	cut growth ≤ 12 mm, and no spontaneous crack
ISO 20871	Abrasion resistance	$0,9 \text{ g/cm}^3 \leq d \leq 450 \text{ mm}^3$ $0,9 \text{ g/cm}^3 > d \leq 300 \text{ mg}$
EN 13287	Slip resistance ^a	$\geq 0,30$ (flat slip) $\geq 0,28$ (heel slip) In both cases must be tested using ceramic tiles (floor) and water and detergent (lubricant)
a This test method is only applicable for finished footwear.		

4.10.2 Additional requirements

These additional requirements should be agreed by both component supplier and footwear manufacturer. See Table 18.

Table 18 — Test method and properties for indoor footwear — Additional requirements

Subclause	Test method	Property	Requirement
4.10.2.1	ISO 20873	Dimensional stability	$\leq 2,5 \%$
4.10.2.2	ISO 20875	Delamination resistance or split tear ^a	$0,9 \text{ g/cm}^3 \leq d \geq 3,0 \text{ N/mm}$ $0,9 \text{ g/cm}^3 > d \geq 1,7 \text{ N/mm}$
4.10.2.3	EN 1392	Bondability ^{b, c, d}	$\geq 2,5 \text{ N/mm}$
4.10.2.4	ISO 20869	Water soluble substances content	water soluble matter $\leq 16 \%$ sulphated ashed water soluble $\leq 3 \%$ (applicable only for leather)
4.10.2.5	ISO 20872	Tear strength	$0,9 \text{ g/cm}^3 \leq d \geq 5,0 \text{ N/mm}$ $0,9 \text{ g/cm}^3 > d \geq 4,0 \text{ N/mm}$
4.10.2.6	ISO 20874	Needle tear strength ^e	$\geq 20 \text{ N/mm}$
a This requirement is considered essential only in multilayer outsoles.			
b A value below the established will be considered as negative independent of the type of failure.			
c Reference adhesives and reference material shall comply with EN 1391.			
d The dimensions and number of test pieces for this test method shall be those included in ISO 17709.			
e This requirement is applicable only for sewn footwear.			

5 Marking and labelling

Marking and labelling is optional.

If a reference to this Technical Report is done, only outsoles complying with all the essential requirements can be marked.

In this case, this shall be clearly marked by the manufacturer either directly on the product or by a label with the following additional information:

- a) The manufacturer's name, trade mark or identification mark.
- b) The type of footwear for which the outsole shall be used as indicated in Table 19.
- c) Reference to this Technical Report.
- d) If the component complies, additional requirements agreed between the component supplier and the footwear manufacturer may be specified in the marking or label making reference to the correspondent subclause.

Any reference to the compliance with this Technical Report shall not be put in a part of the outsole which could be visible when the footwear is finished.

Table 19 — Codes for various types of footwear

Type of footwear	Code
General sports footwear	SP
School footwear	SC
Casual footwear	CS
Men's town footwear	MT
Cold weather footwear	CW
Women's town footwear	WT
Fashion footwear	FS
Infants' footwear	IF
Indoor footwear	IN



ICS 61.060

Price based on 15 pages