

GENERAL PHYSICAL TEST SPECIFICATIONS FOR R. M. WILLIAMS PTY. LTD.

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UPPER LEATHER as at the 30/09/2021

- **SUBSTANCE** (Thicker end of the scale is a must for all leather types)
 1. Black, Chestnut, Rum, Sandstone, Suedes, Crust, Croc, Ostrich and other yearling leathers - 1.4/1.6mm thick.
 2. Kangaroo – 0.7/0.9mm thick
 3. Greasy kips and other heavy leathers – 2/2.2mm thick
- **LASTOMETER** – [SATRA TM 24:1992] Distension of 7mm, Load of 20kg (specifications are for grain / finish crack).
- **TEAR STRENGTH** – [AS/NZS 2210.2:2009, 6.3] Baumann for 1.4/1.6mm leather thickness. The preferred tear strength of 100N is desired. Less than 70N will be rejected.
- **TENSILE STRENGTH** – [AS/NZS 2210.5:2009, 5.4.4] minimum 10N/mm².
- **ADHESION OF FINISH** – [SATRA TM408:1993]. For full grained leather 250gms dry and 125gms wet.
- **ABRASION RESISTANCE** – [AS/NZS 2210.5:2009, 5.5.4], Dry 25.6kc & Wet 12.8kc.
- **FLEXING ENDURANCE** – [SATRA TM 55:1999] No cracking is to occur after 100 000 dry flexes and 10 000 wet flexes.
- **FINISHED MOISTURE CONTENT** – 12-14%
- **BLOCKING FINISH** – Must withstand blocking/ crimping process for 35 seconds @ 135-145 degrees C.
- **BREAK & PIPINESS SCALE** – [SATRA TM 36:1999], must be no greater than 3 on the Satra scale.
- **pH VALUE** [AS/NZS 2210.5:2009, 5.4.7] – The pH value must not be less than 3,2.
- **CHROMIUM VI** [AS/NZS 2210.5:2009, 5.4.9] – Chromium VI should not be detectable.
- **CHEMICAL SUBSTANCES & RMW RESTRICTED SUBSTANCE LIST (RSL)** – All leathers must comply with the RM Williams RSL and the European REACH Regulation (European chemical regulations).
- **FINISHING REQUIREMENTS** – No excessive finish as scars need to be detected before cutting. Excessive finishing used to cover scars and other imperfections will be removed by our blocking process and result in rejects.
- **LEATHER SOFTNESS** – [SATRA ST300 METHOD]. Softness required is 3 – 4.

- **GRAIN / CORIUM RATIO** – A 30% Grain / 70% Corium ratio.
- **CUTTING YIELD** – RM Williams expects a minimum overall cutting yield of 0.5m²/pair of boots for each PO. *This means if the PO received is 1000m², we expect to cut 2000 pairs of first quality uppers. To maximise the yield please send only grade 1 leather.* Grades 2 & 3 leathers can be considered by RM Williams upon appropriate price negotiation.
- **GRADING & SELECTION** – MUST use **RM Williams Visual Guidelines for Leather Grading/Selection**. Please do not use SATRA or ISO grading standards as this will result in false selectin/grading when excessive finishing is applied. We MUST see the scars and other imperfections when cutting one-piece uppers. Please make sure the Visual guidelines are followed and understood correctly. If in doubt, please let our team know.

These specifications are our minimum requirements

Batches may be returned if specifications do not reach these standards