

*Oeko-Tex® International*

## **Oeko-Tex® Standard 1000**

(Chinese Simplified / English)

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# 前言

## 1 纺织行业及环境

纺织及服装行业是一个举足轻重的行业，全球 70 亿人口的衣服及家用面辅料都跟纺织服装行业息息相关。纺织及服装行业是一个举足轻重的行业，全球 70 亿人口的衣服及家用面辅料都跟纺织服装行业息息相关。

纺织品原材料主要涵盖植物纤维如棉，麻等，动物纤维如蚕丝，羊毛以及其他动物皮毛等，另外，石油冶炼及林木业的残留物可加工为人造纤维及其他化学纤维。这些纤维经纺丝，织造，针织，后整理及制造等方式加工成为消费品。纺织品原材料主要涵盖植物纤维如棉，麻等，动物纤维如蚕丝，羊毛以及其他动物皮毛等，另外，石油冶炼及林木业的残留物可加工为人造纤维及其他化学纤维。这些纤维经纺丝，织造，针织，后整理及制造等方式加工成为消费品。

任何纺织品生产过程 - 从纤维到制成品，都在或大或小的程度上对环境产生着影响。纺织业是有责任和义务为其对环境造成的影响负责，并必须对减少环境污染问题有着正确的观念。

## 2 环境影响

以下是纺织品生产过程对不同环境领域造成的影响：

### • 能源消耗

能源消耗本身不会产生环境问题，但是能源的生产和运输过程却对环境造成冲击，特别是燃油的生产在不断消耗着非再生资源及污染大气层。

### • 非再生资源

最重要的非再生资源包括石油，天然气和煤。它们不仅用作燃料，在生产合成纤维和辅助的化学过程中亦会使用。

### • 可再生资源

所有天然纤维及用于加工纤维胶的木材都属于可再生资源。由于水资源可于全球环流（海洋→云层→雨水→河流→海洋）原则上也属于可再生资源。然而，值得关注的是饮用水在很多地方都是极为有限的资源。

### • 土地占用

任何工业生产过程都需要占用空间资源。原则上，这些空间资源是可再用的。但种植天然纤维需要占用大片土地，而这些土地就不能生产日常

# Introduction

## 1 Textile Industry and Environment

The textile and clothing industry is a very important field of industry. It produces not only the second skin clothing for about 7 billion people but also contributes to human's third skin housing quite a lot.

Raw materials for textile products are vegetable fibres such as cotton, flax etc., animal fibres such as silk, wool, and other animal hair. Additionally the residual products of the oil refinery and forestry were used for the production of viscose and chemical fibres. The fibres are processed to consumable products by textile industry by means of spinning, weaving, knitting, finishing and making-up.

Any textile production - from fibre to confection - influences the environment to a higher or lesser degree. Textile industry has responsibility for the impacts of their activities to the environment. There is needed a clear concept of reducing those environmental problems.

## 2 Environmental Impact

The following gives a glimpse of the impacts of textile production processes on different environmental fields:

### • Energy consumption

Consumption of energy is not by itself an environmental problem. But energy production and transport cause environmental impacts. Especially fossil fuels use up non renewable resources and cause emissions to air.

### • Non renewable resources

Most important non renewable resources are oil, gas and coal used as fuels and in producing synthetic fibres and auxiliary chemicals.

### • Renewable Resources

All natural fibres and the wood for viscose production are renewable resources. Water is due to the global circulation (ocean → clouds → rain → rivers → ocean) in principle a renewable resource. On the other hand it has to be taken into account, that drinking quality water is a very limited resource at many places.

### • Space consumption

Any industrial production uses up space for the production site. This area in principle is reusable. Harvesting of natural fibres uses big fields,

所需食粮（饲料类作物除外），同时土地由于受杀虫剂和肥料的频繁使用而受到了污染。实际上，堆放废料之地方造成土地损失，亦使土地成为非再生资源。

which are no longer available to the more basic need of food production (exception sheep breeding and the use of cotton seed for feeding). Fields become at the same time contaminated with pesticides and manures for a long time. A practically non reusable loss of area is the building of waste deposition sites.

## 2.1 全球范围影响

### • 温室效应

纺织行业唯一能与温室效应挂钩的是燃料的消耗。纺织行业唯一能与温室效应挂钩的是燃料的消耗。

### • 臭氧耗竭

导致臭氧层耗竭的原因是氟氯烃类及氯化烃类化合物，正常情况下此类化合物不会应用在纺织行业。导致臭氧层耗竭的原因是氟氯烃类及氯化烃类化合物，正常情况下此类化合物不会应用在纺织行业。

棉花种植过程中使用的溴化甲烷，会将大部分的溴元素挥发到平流层。

## 2.1 Global Aspects

### • Green house effect

The only relevant influence of the textile industry to the green house effect results of the use of fossil fuels.

### • Ozone depletion

The most important ozone depleting substances are fluorochloro-hydrocarbons and chlorinated hydrocarbons, which are not used in textile industry on a regular basis.

Methylbromide, used during cotton growing, introduces most of the bromine content into the stratosphere.

## 2.2 区域性影响

### • 水体富营养化

由于河流及近海区域养分含量过高，以致水中含氧量下降。加上海草及其他水生植物的大量繁殖，亦导致鱼类的数量下降。

### • 水源污染

纺织品生产过程中的湿处理过程如退浆、在废水中洗涤等会产生竭氧物质。

### • 有机卤素化合物的释放

有机卤素化合物的降解速度较慢，其毒性可污染水质多年。

纺织行业生产中与有机卤素化合物使用相关的环节是用次氯酸钠和亚氯酸钠来进行织物漂白的工序。应达到以过氧化物作取替品。

### • 酸化

只有使用高硫化物含量的矿物燃料才会显著地增加空气及土壤的酸化。

### • 挥发性有机化合物及基层臭氧

臭氧表层(O<sub>3</sub>)组分是氮氧化合物及受光照影响的挥发性有机化合物 (VOC's)。人为 VOC's 及氮氧化合物的来源，主要是石油化工行业，燃烧过程及燃气机和有机溶剂的挥发。

## 2.2 Regional Aspects

### • Eutrophication

Due to excess introduction of nutrients to rivers and coastal waters lack of oxygen and fish death can arise due to excess growth of sea weeds and vegetation.

### • Cleanness of water

Main textile sources are wet treatments like de-sizing and scouring in waste water which use oxygen depleting substances

### • AOX - emission

Halogenated organic compounds as being lowly biodegradable and toxic can spoil water for many years.).

Most important sources for AOX in textile production are bleaching processes with chlorine containing substances like sodium chlorite or sodium hypochlorite. A replacement with peroxide should be achieved.

### • Acidification

Only the use of fossil fuels with high sulphur content adds significantly to the acidification of air and soil.

### • Volatile organic compounds and ground ozone

Surface ozone (O<sub>3</sub>) is formed of NO<sub>x</sub> compounds and volatile organic compounds (VOC's) under the influence of sunlight. Main sources of anthropogenic VOC's and NO<sub>x</sub> compounds are oil industry, burning processes in heating and

### 2.3 对当地的影响

- 排放
- 工作环境污染
- 噪音
- 有害物质通过产品接触消费者

- 使用危险化学品物质

化学物质可直接，或通过化学反应，降解等，对人体及环境产生危害。

## 3 对环境影响的改善

一般而言，有两个信念可以使企业在环境保护方面做出改进。一方面是外在的环保要求压力，如强制性的环保法规或明确了节能减排目标的规定，另一方面是采用一套管理体系，利用现有的资源使企业环境保护方面做出持续改进。

为使环保方向不断前进且得到社会的关注和认可，企业可参加一些权威的环保审核及认证体系如 Oeko-Tex® Standard 1000，ISO 14000 或欧盟的 EMAS 系统。

## 4 当地生产商/进口货物

环境和对环境的破坏是无分国界的，每个人都有义务在环境保护方面尽一分力。对于消费者，以及零售商和生产商而言，仅仅以产品质量和价格作为评估各供应商的标准是不够的，供应商在环境保护上的表现亦该被重视。环境和对环境的破坏是无分国界的，每个人都有义务在环境保护方面尽一分力。对于消费者，以及零售商和生产商而言，仅仅以产品质量和价格作为评估各供应商的标准是不够的，供应商在环境保护上的表现亦该被重视。环境和对环境的破坏是无分国界的，每个人都有义务在环境保护方面尽一分力。对于消费者，以及零售商和生产商而言，仅仅以产品质量和价格作为评估各供应商的标准是不够的，供应商在环境保护上的表现亦该被重视。

尽管目前低收入国家的环保排放要求及环保指标普遍偏低，但对具体单一企业而言，其在环保方面所应该采取的措施与那些受严格环保指标限制的公司不应该有太大差别。进一步加强节能减排方面的努力是非常必要的，尤其是对那些处在发达国家，受先进环境保护体系限制的公司而言。

combustion engines and the evaporation of organic solvents.

### 2.3 Local effects

- Emissions
- Work place contamination
- Noise
- Harmful substances reaching the consumer with the product.
- Use of dangerous chemical substances

Chemical substances can - through themselves or after reaction or degradation - pose a risk to humans or any of the environmental compartments.

## 3 Improve of environmental performance

There are two philosophies how to achieve a better environmental performance of a company. On the one hand improvements can be achieved by external pressure applied, i.e. legal requirements or other regulations defining exact goals for environmental protection. On the other hand systems can be promoted, which yield a permanent improvement of the environmental performance of a company using the resources at hand.

A possibility to achieve such environmental improvements, to verify them and show them to the public, is the participation in environmental auditing and certification schemes like this Oeko-Tex® Standard 1000, the ISO-standard 14000 series or the EMAS-system of the European Union.

## 4 Local Producers / Imported Goods

As environment and environmental destruction obey no borders, it should be in every single mans interest to contribute to an improvement of the global environmental situation. A possibility open to the consumer but also to the retailer and the producer is an evaluation of his suppliers not only regarding quality and price criteria but also regarding their respective environmental performance.

Although the legal environmental requirements and the overall environmental standards are lower in the low wage countries, the range of environmental performance of the single companies differs from no environmental measures at all to such at the highest levels. Furthermore at-

把节能减排等因素纳入对供应商的考核体系中可以从侧面加强公司在这方面的努力,使公司在环保方面的表现为公众所知并进一步深化。尽管目前低收入国家的环保排放要求及环保指标普遍偏低,但对具体单一企业而言,其在环保方面所应该采取的措施与那些受严格环保指标限制的公司不应该有太大差别。进一步加强节能减排方面的努力是非常必要的,尤其是对那些处在发达国家,受先进环境保护体系限制的公司而言。把节能减排等因素纳入对供应商的考核体系中可以从侧面加强公司在这方面的努力,使公司在环保方面的表现为公众所知并进一步深化。

## 5 标签系统分类

当评估一种工业活动对环境的影响时,应考虑两个基本因素。

一是生产过程,二是产品本身。

### 5.1 生产现场评估

评估生产过程及生产现场对环境影之影响较为简单直接,可将其划分为地点、时间及技术等各因素。要量化生产过程对环境影响,必然牵涉到部分制品及其后不同成品之生命周期,各方面因素就会因而被一拼连结考虑。评估生产过程及生产现场对环境影之影响较为简单直接,可将其划分为地点、时间及技术等各因素。要量化生产过程对环境影响,必然牵涉到部分制品及其后不同成品之生命周期,各方面因素就会因而被一拼连结考虑。

如果对生产现场的环境影响评级为“环保优秀级”,不但意味着生产过程的环保标准非常高,而且该公司已经建立了一套完善的环保产品评估体系。如果对生产现场的环境影响评级为“环保优秀级”,不但意味着生产过程的环保标准非常高,而且该公司已经建立了一套完善的环保产品评估体系。

### 5.2 产品评估

产品整个生命周期的评估,可以使不同产品之间形成横向对比。然而,评估的研究基础以及实际的操作方法都比较费时费力。尤其困难的是,要定义对结果非决定性,但大量而必要的细节及评估因素。

## 6 Oeko-Tex® Standard 1000 的概念

国际环保纺织协会的 Oeko-Tex® Standard 1000 之目标,是独立地认证生产现场及产品在环境保护上的表面,并证实申请机构已采取及达到一定程度的环境保护措施。

tempts to improve the situation are as intense, or even more intense, as in countries with developed environmental protection systems. An evaluation of suppliers in respect to their environmental performance helps such efforts, as the ones willing get an opportunity to demonstrate and exploit their achievements.

## 5 Kinds of labelling systems

When evaluating the environmental impact of industrial activities, two fundamental approaches are possible.

On the one hand the production process can be taken into account, on the other hand there is the product itself to be evaluated.

### 5.1 Production site evaluation

The evaluation of production processes and production sites is more straightforward, as there are defined modules in respect of place, time and technology. Quantifying such an approach for the amount of products crossing this process there are also included a part of the life circle of this product and all differing later final products formed out of it. Such modules can then be joined together brick by brick.

The assessment of the environmental impact of the production site and a classification as „environmentally sound“ not only shows the high environmental standards in production, but it also forms an integrated part of a product evaluation.

### 5.2 Product evaluation

An evaluation of the complete life of a product from „cradle to grave“, a „life cycle assessment“, enables in principle a comparison between different products. Nevertheless the scientific basis and the practical approach are rather laborious. Especially difficult is the definition of the amount of details necessary and the evaluation of the factors which are insignificant for the result.

## 6 The Oeko-Tex® Standard 1000 concept

The aim of the Standard 1000 of the Oeko-Tex® International is an evaluation of the environmental performance of textile production sites and products and to document independently that



certain environmental measures are undertaken and a certain level is achieved.

## 6.1 生产现场及产品认证

Oeko-Tex® Standard 1000 体系同时包含对纺织品生产现场表现, 及纺织品本身质素在环境保护方面的审核及评估 Oeko-Tex® Standard 1000 体系同时包含对纺织品生产现场表现, 及纺织品本身质素在环境保护方面的审核及评估

A 部分包含的是对生产现场认证的要求, B 部分是授权产品使用标签的要求。

## 6.1 Production site and product certification

The system of Oeko-Tex® Standard 1000 consists in auditing the environmental performance of textile production sites as well as evaluating textile products for their environmental sound production.

Part A of the Standard contains the requirements for certification of production sites, Part B covers the requirements for labelling of textile products.

## 6.2 环境管理及评级

环保型生产最显著的特质, 是能持续地借助新研究成果及科技机遇, 藉以自我提升 环保型生产最显著的特质, 是能持续地借助新研究成果及科技机遇, 藉以自我提升

对公司而言, 实施管理体系将有效提升整体产品的环保表现。 对公司而言, 实施管理体系将有效提升整体产品的环保表现。

除了环保管理措施以外, Oeko-Tex® Standard 1000 还列出了为达最低环保排放指标的详细技术要求。 除了环保管理措施以外, Oeko-Tex® Standard 1000 还列出了为达最低环保排放指标的详细技术要求。

某些化学物及技术, 因危害健康或环境而不再被接受为环保生产, 就可能被划入禁止范围, 并依据限定值被持续监控。 某些化学物及技术, 因危害健康或环境而不再被接受为环保生产, 就可能被划入禁止范围, 并依据限定值被持续监控。

以上提及的要求, 不单为最低限度参考, 更可以被企业采用为环保措施方面的首要指引。

## 6.2 Environmental management and grading

An essential feature of environmentally sound production is its continuous redefinition based on new research results and new technological opportunities.

An efficient possibility to improve the overall environmental performance of produced goods of a company is the implementation of an environmental management system.

In addition to environmental management measure, detailed technical requirements for the achievement of a common environmental minimal standard are given.

These requirements may be divided in prohibitions, when some chemicals and production techniques are no longer acceptable in terms of an environmental friendly production due to health as well as environmental risks, and in values that have to be controlled continuously.

These requirements do not only give a minimum basis but they may also be used by the company as a guide to find out the priority fields for environmental action.

## 6.3 Oeko-Tex® Standard 1000 的优势

Oeko-Tex® Standard 1000 与欧盟 EMAS 体系和 ISO 14001 体系相比, 有一定优势。

Oeko-Tex® Standard 1000 不但在欧洲范围内适用, 全世界范围都可以应用。

- 其他标准相比, Oeko-Tex® Standard 100+ 明确规定了纺织品、服装及辅料生产商关于测试和审核的相关标准及限值。

## 6.3 Advantages of the Oeko-Tex® Standard 1000

The Oeko-Tex® Standard 1000 system has advantages compared to certification systems for environmental management like the EU EMAS System or ISO 14001.

The Oeko-Tex® Standard 1000 is available not only for Europe but for the whole world.

- The Oeko-Tex® Standard 100plus gives in comparison with other standards clear criteria and limiting values for testing and auditing of

- Oeko-Tex® Standard 1000 乃揉合 Oeko-Tex® Standard 100，并加入生产现场审查，从而延伸出的一套人类生态的测试标准。
  - Oeko-Tex® Standard 1000 认证涉及生产线的各个环节，因而能评估成品的整体构造过程，EMAS 体系只对单独的生产现场进行评估。
  - 根据 Oeko-Tex® Standard 1000 B 产品证书部分而获认证的原材料，可用于各样纺织品的生产。
  - Oeko-Tex® Standard 1000 阐明有关产品由获证工厂生产，并符合有害物质限量的人类生态要求，故此能进一步保障消费者。
  - Oeko-Tex® Standard 1000 的审核覆盖纺织品的各生产环节，并以标签识别消费者手中的成品。
- textile, clothing companies and ancillary industries.
- The Oeko-Tex® Standard 1000 extends the human-ecological testing in conformity with the Oeko-Tex® Standard 100 by the inspection of the ecology of production.
  - The product certification according to Oeko-Tex® Standard 1000 extends to all links of the production chain and therefore allows an evaluation of the formation of the product. The EMAS system only evaluates a single production site.
  - The product certificates given for preliminary products according to Oeko-Tex® Standard 1000, Part B, are certificates that are accepted for the production of a variety of textile products leaving a site.
  - The Oeko-Tex® Standard 1000 states an increased level of protection for the consumer as the products of a certified production site also correspond to the requirements of human ecology with regard to toxic substances.
  - The Oeko-Tex® Standard 1000 permits - on general examination of all units of production which participate in the production of a textile product - an according labelling at the final product, which reaches the consumer.

# 定义

# Definitions

## 1 生产商

纺织品及/或纺织品辅料的制造商是指产品的生产公司或代理公司。

## 1 Manufacturer

The manufacturer of a textile product and/or of accessories for the textile product is the company producing the product or the company on behalf of which the product is being manufactured.

## 2 分销商

纺织品及/或纺织品辅料的分销商是指批发或零售销售产品的公司。(如百货公司, 邮购商店等等)

## 2 Distributor

The distributor of a textile product and/or of accessories for the textile product refers to the company selling the product as wholesale dealer or retailer (department stores, mail-order houses, etc.).

## 3 产品命名

产品名称是指制造商或分销商其所认证产品之名称。

## 3 Designation of product

The designation of the product is the name given by the manufacturer or distributor for his to be labelled product.

## 4 产品组或物件组

一组产品或一组物件原则上概括了多种单一的产品及/或物件。此等产品及物件皆以分明的原材料, 人类生态观念下相似的化学物料及配方所制成。

## 4 Product group or article group

A product group or article group is basically a summary of several single products and/or articles which are made from defined raw materials, produced on production units with the similar chemicals and recipes in the sense of human ecology.

## 5 Oeko-Tex® 标签

Oeko-Tex® Standard 1000 有两种标签, 这两种标签皆列于附录 2。

纺织品生产场所必须符合 A 部分之组织及技术条件, 方能获受 Oeko-Tex® 生产场所标签。

产品必须达到 B 部份标准的具体条件, 方能获受 Oeko-Tex® Standard 1000 中的产品标签。根据国际环保纺织协会(纺织生态领域), 此产品标签只能附加于现有的 Oeko-Tex® Standard 100 上, 并仅可与 Oeko-Tex® Standard 100 标签一起使用。

## 5 Oeko-Tex® marks

There exist two labels for Oeko-Tex® Standard 1000. Both labels are listed in the Appendix 2.

The Oeko-Tex® mark for production sites can be granted for a textile production site fulfilling the conditions and organizational and technical requirements of part A of this standard.

The Oeko-Tex® Standard 1000 mark for products only can be issued if the marked product fulfils the conditions, specified in part B of this standard. The mark can only be granted as an addition to an existing mark according to Oeko-Tex® Standard 100 of the International Association for Research and Testing in the Field of Textile Ecology. This additional marking may also only be used on the products together with the label according to Oeko-Tex® Standard 100.

此标签并非质量标签。此标签并没说明任何产品属性 (例如: 适用性, 对清洗过程的反应度, 穿衣方面的物生理行为, 建筑物内使用的属性, 燃烧行为) 或生产场所属性。此标签并非质量标签。此标签并没说明任何产品属性 (例如: 适用性, 对清洗过程的反应度, 穿衣方面的物生理行为, 建

The marks are no quality label. The mark says nothing about other properties of the product (e.g., fitness for use, reaction to cleaning processes, physiological behaviour in respect of clothing, properties relating to use in buildings, burning behaviour) or the production site.

筑物内使用的属性，燃烧行为) 或生产场所属性。

纺织品之个别样本若因运输或储存 ( 及经不当清洗程序 ) 而受损、因促销操作而被污染 ( 例如: 加入香水 )、及因不当的展销 ( 如: 户外展示 ) 而为有害物质所影响，则不属此标签涵概范围内。纺织品之个别样本若因运输或储存 ( 及经不当清洗程序 ) 而受损、因促销操作而被污染 ( 例如: 加入香水 )、及因不当的展销 ( 如: 户外展示 ) 而为有害物质所影响，则不属此标签涵概范围内。

## 6 企业

企业指单一法定共同体，涵概其下所有生产场所、组织单位及部门。

## 7 生产场所

企业所有的单位形成的一个空间实体。严格来说，生产场所是唯一实际生产的地点。

## 8 生产线

生产线指一个整体，涵概在生产场所及/或整个纺织生产链上，为制作某类产品的所有工厂安排。其中包括所有实体或组织性安排比如采购，供应，机器，附件，废物排放，配方等等，当然这一切只是在当下的空间中发生。然而，这些安排仅在各自的空间及时间上连结。

## 9 环境

企业开展运作的外界环境和条件，包括其中的生态系统 ( 人类的以及其他 )。环境范围自工作地点延伸至全球系统。

## 10 环境影响

企业的活动、产品以及服务对环境造成的任何直接或间接影响。这些影响包括有利和有害方面。

## 11 环境管理系统

整体管理系统部分决定环境政策，包括组织结构、责任、程序、过程，资源以及环境政策的实施。

The mark also says nothing about harmful substances affecting single specimens of the marked textile as a result of damage during transportation or storing (and improper cleaning procedures after), contamination caused by manipulation for sales promotion (e. g. perfuming) and inadequate sales display (e. g. outdoor presentation).

## 6 Enterprise

The enterprise is the sum of all production sites, organisational units and plants forming one common legal entity.

## 7 Production Site

All units of an enterprise forming a spatial entity. Production sites in strict sense are only sites with production.

## 8 Line of Production

The line of production signify the entirety of all arrangements factories, which are used for the manufacture of a certain product in a production site and/or the whole textile chain. Among them are all necessary real and organisational arrangements like purchase, supply, machines, auxiliaries, emissions, recipes, etc., however only in the respective spatial and temporal connection.

## 9 Environment

The surroundings and conditions in which the enterprise operates, including living systems (human and other) therein. The environment extends from within the workplace to the global system.

## 10 Environmental Effect

Any direct or indirect impact of the activities, products and services of the enterprise on the environment. Such impacts include adverse and beneficial ones.

## 11 Environmental management system

The part of the overall management system which determines the environmental policy, and includes the organisational structure, responsibilities, procedures, processes and resources for implementing the environmental policy.

**12 环境管理项目**

此文件描述了实现环境目标的途径。

**13 环境管理手册**

此文件描述了实施环境项目的程序。

**14 危害物质**

Oeko-Tex® Standard 1000 所指的物质，为化学元素及化合物，其中包含市场营销必须的化学杂质。Oeko-Tex® Standard 1000 所指的物质，为化学元素及化合物，其中包含市场营销必须的化学杂质。

Oeko-Tex® Standard 1000 所指的调剂，为各物质的混合物，其中包含市场营销必须的化学杂质。

Oeko-Tex® Standard 1000 所指的危险物质及调剂（简列如下），有以下其中一项属性：Oeko-Tex® Standard 1000 所指的危险物质及调剂（简列如下），有以下其中一项属性：

- 易爆

遇火易爆，或较二硝基苯对震动或摩擦更为敏感之物质。

- 易氧化

有机过氧化，或遇其他物质易起强烈放热反应，以及尤其易燃的物质。

- 极易燃

液体，燃点在零度以下沸点在 35°C 以下。

- 高度易燃

其物质定义为

- 常温在无外界能量影响下，自身发热并最终会在空气中自燃的物质

- 以固体呈现时，短时间与火源接触后，可能易于点燃，并在离开火源后持续燃烧或闷烧。

**12 Environmental management program**

A documented description of the means of achieving environmental objectives and targets.

**13 Environmental management manual**

The documentation describing the procedures for implementation of the environmental program.

**14 Dangerous substances**

Substances in accordance with Oeko-Tex® Standard 1000 are chemical elements and compounds including the contained impurities and help chemicals necessary for marketing.

Preparations in accordance with Oeko-Tex® Standard 1000 are all mixtures of substances including the contained impurities and help chemicals necessary for marketing.

Dangerous substances or dangerous preparations in accordance with Oeko-Tex® Standard 1000 are substances or preparations (in the following shortly substances) having one of the following dangerous properties:

- "explosive"

Substances that may be brought to explosion by flame ignition, or substances that are more sensitive to shock or rubbing than dinitrobenzene.

- "oxidising"

Substances that are organic peroxides or may react strongly exothermic on contact with other substances, especially flammable ones.

- "extremely flammable"

Liquid substances with a flash point below 0°C and a boiling point not higher than 35°C.

- "highly flammable"

substances that

- may heat themselves and finally ignite at open air without external energy at normal temperature

- as solids, may be easily ignited by a short contact to an ignition source and continue to

<ul style="list-style-type: none"> <li>• 以液体, 燃点在 21°C 以下。</li> <li>• 以气体呈现时, 燃烧范围(爆炸范围)为: 遇压力达 1 巴, 加上气温达摄氏二十度。</li> <li>• 与水源或潮湿空气接触后, 会形成大量易燃气体。</li> <li>• 以尘埃或气雾呈现时, 可通过气体传播, 并有其燃烧范围 ( 爆炸范围 )。</li> </ul>	<ul style="list-style-type: none"> <li>• burn or smoulder after the removal of the ignition source.</li> <li>• as liquids, have a flash point below 21°C</li> <li>• as gases, have an ignition range (explosion range) when mixed with air at 1 bar and 20°C</li> <li>• form flammable gases in dangerous amount when in contact with water or wet air</li> <li>• as dusts or aerosols, may be transported by air and have an ignition range (explosion range) in that form.</li> </ul>
<ul style="list-style-type: none"> <li>• 易燃</li> </ul> <p>燃点在 21°C 到 55°C 之间。</p>	<ul style="list-style-type: none"> <li>• "flammable"</li> </ul> <p>Substances that have a flash point between 21°C and 55°C</p>
<ul style="list-style-type: none"> <li>• 强毒性</li> </ul> <p>少量及短暂接触、吸入、吞噬或渗入皮肤, 则会引致严重或慢性健康问题, 甚或导致死亡之物质。</p>	<ul style="list-style-type: none"> <li>• "very toxic"</li> </ul> <p>Substances that already at short contact times and in small amounts may cause severe acute or chronic health hazards or even lead to death, when inhaled, swallowed or brought in contact with skin.</p>
<ul style="list-style-type: none"> <li>• 有毒性</li> </ul> <p>仅少量及短暂接触、吸入、吞噬或渗入皮肤, 则会引致严重或慢性健康问题, 甚或导致死亡之物质。</p>	<ul style="list-style-type: none"> <li>• "toxic"</li> </ul> <p>Substances that in small amounts may cause severe acute or chronic health hazards or even lead to death, when inhaled, swallowed or brought in contact with skin.</p>
<ul style="list-style-type: none"> <li>• 有害性</li> </ul> <p>吸入、吞噬或与皮肤接触后可能对身体造成一定的健康危害之物质。</p>	<ul style="list-style-type: none"> <li>• "harmful"</li> </ul> <p>Substances that may cause limited health hazards when inhaled, swallowed or brought in contact with skin.</p>
<ul style="list-style-type: none"> <li>• 腐蚀性</li> </ul> <p>可能对活组织造成损害之物质。</p>	<ul style="list-style-type: none"> <li>• "corrosive"</li> </ul> <p>Substances that may cause damage to living tissue.</p>
<ul style="list-style-type: none"> <li>• 刺激性</li> </ul> <p>无腐蚀性, 可引起皮肤炎症, 短暂、较长时间或反复接触会引起粘膜之物质。</p>	<ul style="list-style-type: none"> <li>• "irritant"</li> </ul> <p>Substances that, without being corrosive, may cause inflammations on skin and mucous membranes at immediate, longer or repeated contact.</p>
<ul style="list-style-type: none"> <li>• 危害环境</li> </ul> <p>在使用或处理后, 立即或期后对环境 ( 水、空气、土壤 ) 或生物 ( 植物、动物、微生物 ) 及其相互联系造成危害之物质。</p>	<ul style="list-style-type: none"> <li>• "environmentally dangerous"</li> </ul> <p>Substances that, when used or disposed, hold immediate or later dangers for the environment (water, air, soil) or for living beings (plants, animals, micro-organisms) in particular, their inter-relationship or their relationship to humans.</p>
<ul style="list-style-type: none"> <li>• 致癌性</li> </ul> <p>吸入、吞噬或与皮肤接触后, 可能致癌, 或增加致癌的几率之物质。</p>	<ul style="list-style-type: none"> <li>• "carcinogenic"</li> </ul> <p>Substances that may cause cancer or increase frequency of cancer when inhaled, swallowed or brought in contact with skin.</p>
<ul style="list-style-type: none"> <li>• 致畸胎性</li> </ul> <p>吸入、吞噬或与皮肤接触后, 可危害胎儿之物质: 影响胎儿在子宫内的发育, 而导致胎儿死亡或影响其出生后的身心发展。吸入、吞噬或与皮肤接触后, 可危害胎儿之物质: 影响胎儿在子宫内的发育。</p>	<ul style="list-style-type: none"> <li>• "teratogenic"</li> </ul> <p>Substances that may cause damage of the foetus or embryo during his development in the womb, his death or the impairment of his physical or mental development after birth, when inhaled, swallowed or brought in contact with skin</p>

育，而导致胎儿死亡或影响其出生后的身心发展。

- 突变性（基因毒性）

吸入、吞噬或与皮肤接触后，可导致基因变异之物质 吸入、吞噬或与皮肤接触后，可导致基因变异之物质

- 慢性危害

持续少量吸入、吞噬或与皮肤接触后，可导致之前所述以外的其他健康问题之物质 持续少量吸入、吞噬或与皮肤接触后，可导致之前所述以外的其他健康问题之物质

- 过敏性

接触或渗入皮肤后，可使免疫系统产生强烈过敏之物质 接触或渗入皮肤后，可使免疫系统产生强烈过敏之物质

- "mutagenic (genotoxic)"

Substances that may cause a change in the genetic material when inhaled, swallowed or brought in contact with skin

- "chronic hazardous"

Substances that at prolonged contact and in small amounts may cause other damages to health than previous listed, when inhaled, swallowed or brought in contact with skin.

- "sensibilizing"

Substances that can cause hyper-sensitivity reactions promoted by the immune system when inhaled or brought in contact with skin.

# Oeko-Tex® Standard 1000

## A 部分

### 生产现场

#### 1 范围

Oeko-Tex® Standard 1000 是 Oeko-Tex 国际环保纺织协会制定的规范性文件。

此标准的 A 部分阐明授权使用环保型生产标签的相关条件和要求。若 90% 以上的生产场所均通过认证，该公司则获准使用指定的注册标签（参见附录）。

#### 2 应用范围

此标准适用于纺织品及其辅料的生产现场（参照 DIN 60000 “纺织品，基本术语及定义”）。

#### 3 颁发条件

##### 3.1 生产现场的标签

若整体生产场地均通过 Oeko-Tex® 标准相关的审核及评估，该生产现场则获准使用附录中专属的文字/图像标签。若整体生产场地均通过 Oeko-Tex® 标准相关的审核及评估，该生产现场则获准使用附录中专属的文字/图像标签。

若非整个生产场地均通过认证（如：原有生产大楼已通过，而新盖部分未进行审查），则至少整体的 90% 部分须符合标准规定的相关条件，该生产现场方能获准使用标签。

##### 3.2 申请

申请授权使用 Oeko-Tex® 标签，须递交申请表至 Oeko-Tex® 国际环保纺织协会注册的测试机构。测试机构名单详见附录。

# Oeko-Tex® Stand- ard 1000

## Part A

### Production Sites

#### 1 Scope

Oeko-Tex® Standard 1000 is a normative document issued by Oeko-Tex® International, Association for the Assessment of Environmentally Friendly Textiles.

This standard's part A specifies the conditions and requirements for a licensed use of the registered mark for environmentally sound production. If at least 90% of the production site is certified the company are granted the rights to use the registered mark as per Appendix 2.

#### 2 Applicability

This standard is to be applied to production sites for textile products specified (see DIN 60000 "Textiles, basic terms and definitions"), their pre-products and textile accessories.

#### 3 Conditions of issuance

##### 3.1 Labelling of a production site

If a complete production site is evaluated according to the criteria in this Oeko-Tex® Standard observing all requirements of the audit a labelling of the production site with the text/picture-mark in appendix 2 can be granted.

If there are certified only parts of a production site (e.g. old building-NO, new building -YES) the mark only can be applied if 90% of the production site fulfil the conditions of the standard.

##### 3.2 Application

The application for the granting of authorisation to use the Oeko-Tex® mark is to be made on the application form to a licensed Institute of the Oeko-Tex® International, Association for the Assessment of Environmentally Friendly Textiles. The institutes are listed in appendix 2.



### 3.3 调查表

申请者需完成一份调查表，并交回相关测试机构，以作日后审核之用。

调查表有助厘定认证原则是否适用于该生产现场，或预测申请前必需采取之改进措施，更有助提高后期审核工作之效率。调查表有助厘定认证原则是否适用于该生产现场，或预测申请前必需采取之改进措施，更有助提高后期审核工作之效率。

另外，调查表含有一份工厂责任声明。

### 3.4 签署责任声明

申请人签署的责任声明，连同调查表需要一拼递交到测试机构，其中涵盖以下几点：

- 声明中规定的相关责任；
- 当技术要求改变时，申请人有义务通知进行现场审核的测试机构。
- 申请者须受权审查的测试机构随时进入生产场所、审阅相关文件、查问工作人员，以及抽取各类样品。
- 在使用权限被撤销期或结束后，申请人有责任确保其生产现场不再使用 Oeko-Tex® 标签。

### 3.5 审核

#### 3.5.1 文件审核

在于审核首阶段，测试机构透过申请者呈交之相关文件，评估该公司在技术上及组织上能否符合标准要求。在于审核首阶段，测试机构透过申请者呈交之相关文件，评估该公司在技术上及组织上能否符合标准要求。

审核的范围取决于公司组织规模大小以及相关文档的齐全程度。审核的范围取决于公司组织规模大小以及相关文档的齐全程度。

#### 3.5.2 现场审核

最后阶段为强制性现场探访，目的是审核申请表上提及的各项细节是否与日常生产操作相符。

### 3.3 Questionnaire

For the preparation of the audit the applicant is provided with a questionnaire, which has to be completed and returned to the test institute.

The questionnaire helps determining, whether the production site is suitable in principle for the certification or which measures and improvements are beforehand necessary. In addition an efficient handling of the examination is made possible.

Furthermore the questionnaire contains a declaration of obligation.

### 3.4 Issuing of liability declaration

The applicant's liability declaration legally binding signed together with the questionnaire are to be sent to one of the test institutes with the following points:

- Liability for the details specified in the statements.
- Obligation to notify the institute, which performs the audit, of changes to the technical statements.
- Consent that deputies of the institute, which performs the audit, may visit at any time the organisation's place, view documents, which are in connection with the certification, question staff members and take samples of each kind.
- Obligation, to ensure that no further marking of the production site takes place after the expiration or withdrawal of the authorisation to use the Oeko-Tex® label.

### 3.5 Audit

#### 3.5.1 Evaluation of documentation

To start with the fulfilment of the technical and organisational demands is evaluated, using available documents, which are made available to the test institute.

The extent of the audit depends on the size and the production of the organisation as well as on the quality of the prepared documents.

#### 3.5.2 Site inspection

For a final assessment and to check the conformity of details in the application form with everyday practice a visitation on the production site is mandatory.

### 3.5.3 产品

使用 Oeko-Tex® 生产现场标签的前提，是其产品亦必须符合人类生态环保要求。故此，

### 3.5.4 测试

倘若某些技术细节不能以文档概述呈阅，审核小组有权测试相关产品。尤其是对某些特定的限量值而言，要求工厂必须提供经过国家认可的或符合 ISO 17025 / EN 45000 标准的实验室所发出的相关测试报告。

另外，审核小组有权要求进行抽样测试。

### 3.5.5 报告

审核完成后，测试机构会传交现场审核报告予申请方。倘若发现不完备之处而未能颁发证书，审核报告会包含相关改善方法及要求，务求使申请方能配合采纳，而最终达到有关标准。审核完成后，测试机构会传交现场审核报告予申请方。倘若发现不完备之处而未能颁发证书，审核报告会包含相关改善方法及要求，务求使申请方能配合采纳，而最终达到有关标准。

### 3.5.6 复审

若申请者若在环方面有所改善，并提出相关证据，则可申请复审。

## 3.6 一致性

### 3.6.1 责任声明

使用有效标签期间，该公司有责任独力遵从相关要求。使用有效标签期间，该公司有责任独力遵从相关要求。

### 3.6.2 一致性审核

已获 Oeko-Tex® Standard 1000，A 部分标签的公司，须每年准备一份相关审核表现报告予测试机构。

持证人若未能按时提交完整的相关报告，其证书有效期可被提前取消。

持证人如何及以何种程度达到既定目标、最终未能遵守某些指令的原因，以及下年度的环保目标计划，均须要详述于该报告。持证人如何及以何种程度达到既定目标、最终未能遵守某些指令的原因，以及下年度的环保目标计划，均须要详述于该报告。

提及的信息都能有文档依据可循。

### 3.5.3 Products

For a marking of the production site the fulfilment of human-ecological requirements of the products is required.

### 3.5.4 Tests

If certain technical details can not be proven with documents, the auditing team is entitled to order tests or perform such themselves. This is specially true for the specific limiting values, which have to be proven by reports from nationally authorised laboratories or such accredited according ISO 17025 / EN 45000.

Furthermore the auditing team is entitled to perform or order spot-tests.

### 3.5.5 Report

After the audit an audit report is prepared and transmitted to the applicant. In case of imperfections which exclude a certification the audit report contains measures and requirements, which have to be fulfilled to reach a positive result or the next certification grading.

### 3.5.6 Re-audit

If measures are taken and documented to improve the environmental performance an additional re-audit can be performed and evaluated.

## 3.6 Conformity

### 3.6.1 Liability declaration

The company is in its sole responsibility obliged to be in compliance with the requirements during time of marking.

### 3.6.2 Compliance audit

The company, having received an Oeko-Tex® Standard 1000 label, part A, annually prepares a report and delivers it to the testing institutes, that performed the audit.

If there doesn't exist a report or only an insufficient one or one submitted not in space of time the certificate can be withdrawn before expiring.

This report has to put down, how and to what extent the objectives and goals were achieved. Reasons for an eventual non-compliance have to be detailed. New adopted environmental objectives and goals for the next year have to be prepared and added.

All information given has to be verified by appropriate documents.

一年为期之证书，须每年进行现场审核，并每年以报告为据。三年为期之证书，首次之续证，须每年进行现场审核；期后之续证，只须三年内进行一次现场审核。一年为期之证书，须每年进行现场审核，并每年以报告为据。三年为期之证书，首次之续证，须每年进行现场审核；期后之续证，只须三年内进行一次现场审核。

### 3.7 评估

生产现场的评估标准全球统一，与企业的所属区域及国家规定无关。

各环境标准，乃采取分数制度及加权因子作为衡量基准，籍以统一评估各生产程序。

企业评估及现场审核同时达到最低分值或以上，该生产现场方能获取证书。

若未能达到 Oeko-Tex® Standard 1000 的级别限值，或/及不符合豁免标准，则不能授予证书。

若 Oeko-Tex® 测试机构认为因不符合豁免标准而未能颁发证书，则必须立即通知申请方。

一经递交申请表，申申请人等同答应承担现场审核及相关费用。若於現場審核時發若于现场审核时发现该生产场所未能符合豁免标准，则暂时不能获得证书。

#### 3.7.1 监控权利

除测试机构的现场审核权利，以及秘书处签发证书之权利以外，组织有权就投诉按此文件所述之要求，抽取样板检测，而有关费用由申请人承担。

## 4 标签

### 4.1 授权许可

若申请方呈交的资料无误，并通过现场审核被证实符合此标准之条件及生态要求，则可获 Oeko-Tex® 国际环保纺织协会秘书处颁授 Oeko-Tex® 环保证书，并获准使用其标签之权利。

If the validity of the certificate is one year, a compliance audit is taking place every year and the yearly report is used as support. If the validity of the certificate is three years, up to the first renewal every year and after renewal of the certificate only one compliance audit is taking place until next renewal.

### 3.7 Assessment

The criteria of assessment are the same for all production sites all over the world independent from the location of the enterprise and national regulations.

The assessment of the individual criteria's of environment is uniformly ensured for all production steps using a point system with an additional weighting factor for the individual criteria.

A production site receives only a certificate if the same kind of given minimum score is achieved according to the analyses of the enterprise and the audit.

If the grading limit of the Oeko-Tex® Standard 1000 are not met and/or the given exclusion criteria are not fulfilled a certification is not possible.

In case the Oeko-Tex® institute realises that at the moment a certification is not possible because of non-fulfilment of the exclusion criteria, it is compelled to inform the applicant immediately

When handing in the application form the applicant is liable to take upon the rising costs of the institute during the auditing, also then, when it is realised during the procedure of auditing that according to exclusion criteria a certification of the production site for the time being is not possible.

#### 3.7.1 Control Rights

In addition the institute that performed the audit and the secretariat issuing the licence is allowed, and in case of found complaints obliged to perform spot test of the compliance with the requirements in this document on the expense of the applicant.

## 4 Marking

### 4.1 Issuing of the licence

If the conditions and ecological requirements of this standard are met and the on site audit did not show deviations from the information given by the applicant, he is provided with a certificate granting the Oeko-Tex® label applied for by the body of certification at the secretariat of Oeko-Tex® International, Association for the Assessment of Environmentally Friendly Textiles.

#### 4.2 授权使用期限

Oeko-Tex® Standard 1000 标签使用期限最高为三年；特殊情况下，使用期限仅为一年。标签有效期内，其测试要求及级别值以证书签发时为准。

当该公司不再符合标准要求，（例如：技术及/或生产条件改变），组织有权提前结束证书有效期。

若持证方没有按规定呈交年度报告或违反此标准的其他条例，组织可特别就此提前结束其证书。

若申请方没有达到人类生态学的最低要求或者其获证产品没有达到 Oeko-Tex® 标准 100 的各种限定条件，标签使用授权也可以被提前收回。

#### 4.3 标签使用续期

标签有效期过后，若该公司仍符合此标准的各项要求，则可申请续期一年或三年。

续期的审核工作一般较少，因为大部分资料及文件已有存档及已经过审核，而且各条款要求亦曾经被核查过；但虽如此，仍有必须进行一次全新的出现场审核。续期的审核工作一般较少，因为大部分资料及文件已有存档及已经过审核，而且各条款要求亦曾经被核查过；但虽如此，仍有必须进行一次全新的出现场审核。

#### 4.4 撤销使用授权

若经过现场审核或其他途径，发现持证人的申报材料不实或过时，又或并未即时通知测试机构有关生产程序上的改变，一经证实，其标签使用权将会被撤销。此外，若违反标准定明的使用条件，其标签使用权亦会被撤销。

使用权被撤销后，若企业被再三警告下，仍继续不正当地使用标签。国际环保纺织协会有权于相关渠道公布撤销其证书之详情。使用权被撤销后，若企业被再三警告下，仍继续不正当地使用标签。国际环保纺织协会有权于相关渠道公布撤销其证书之详情。

法院诉讼需于苏黎世。法院诉讼需于苏黎世。

#### 4.5 标签的种类

一经授权，申请方即可使用附录 2 中的相关 Oeko-Tex® 标签。一经授权，申请方即可使用附录 2 中的相关 Oeko-Tex® 标签。

#### 4.2 Duration of licence

The right, to use a label according to Oeko-Tex® Standard 1000, is limited to a maximum of three years. Under special conditions the validity is also possible only for one year. During the validity of the license the test criteria and grading values at the time of licensing stay in operation.

As soon as the conditions of the company are no longer valid, e.g. through change of the technical condition and/or the conditions of production, the right for the labelling expires premature.

Particularly the licence expires, if the obligation to deliver an annual compliance report is not followed or there exist other offences against the conditions of the Standard.

The licence expires as well when the human ecological conditions are not fulfilled or the minimum constituent for the products certified with Oeko-Tex® Standard 100 not come up to the estimate.

#### 4.3 Renewal of authorisation

If the conditions for labelling are still fulfilled after expiration of the licence, the applicant can apply for an extension of the licence for further 3 years, alternatively 1 year.

The renewal requires less auditing work, as most information and documents are already present and most requirements are already checked. Nevertheless a new site inspection is mandatory.

#### 4.4 Withdrawal of the Licence

If it is ascertained, through control of the production site or by other means, that made statements are not or no more correct, or that changes in the production processes were not announced to the organisation immediately, the right for the labelling will be withdrawn. A withdrawal of the licence results also, if the labelling is not performed according to the conditions of this standard.

If after withdrawal of the licence further improperly labelling occurs, the Oeko-Tex® International, has the right, after twice-repeated invitation for the omission, to publish the withdrawal of the certification in suitable form.

Competency of a court is Zurich

#### 4.5 Type of marking

With the issuing of the licence the company is entitled to mark the production site with the Oeko-Tex® mark displayed in appendix 2.

必須列明報告編號，以作為現場審核之依據。必須列明報告編號，以作為現場審核之依據。

As test number the number of the test report has to be entered, under which the audit was performed.

必須遵從以下 Oeko-Tex® 對標籤設計的色彩創建規則：

In the design of the mark the following creation rules regarding the colouring of the Oeko-Tex must be respected:

- 以下定明的標籤顏色不可任意更改，以保持標籤的獨立及可識別性。
- 特殊情況下，標籤可以使用單一顏色（如該公司顏色代碼）。此種情況下，僅能使用以下四種版本標籤，並請確保標籤為清晰易辨。

- A consistent use of the Oeko-Tex® mark in the below-defined colors is desired, independent of the designated use, to keep the recognition value of the certification mark
- In exceptional cases a single color in the mark is accepted with a differing color (e.g. own company color). For cases like that only the below listed version 4 shall be used! Please note that in such cases the certification mark shall have clearly recognizable value at first sight.

版本 1-CMYK 顏色，用於打印版標示：

Version 1 – CMYK-Color space, in favour for all printing matters:

綠: 92C/0M/100Y/7K  
黃: 0C/43M/100Y/0K  
藍: 85C/25M/0Y/0K  
黑: 0C/0M/0Y/100K

Green: 92C/0M/100Y/7K  
Yellow: 0C/43M/100Y/0K  
Blue: 85C/25M/0Y/0K  
Black: 0C/0M/0Y/100K

版本 2-RGB 顏色，用於顯示器及網頁版標示：

Version 2 – RGB- Color space, in favour for monitors and web:

綠: R0/G140/B50  
黃: R255/G145/B0  
藍: R0/G144/B230  
黑: R0/G0/B0

Green: R0/G140/B50  
Yellow: R255/G145/B0  
Blue: R0/G144/B230  
Black: R0/G0/B0

版本 3- 灰色版，如果以上彩色無法實現時：

Version 3 – Grey scales, if demonstration is otherwise not possible:

綠色變為  
黃色變為 44%黑  
藍色變為 54%黑  
黑色為 100%黑

Green becomes 70% black  
Yellow becomes 44% black  
Blue becomes 54% black  
Black is 100% black

版本 4 - 黑/白版，用於極小尺寸和單色印刷時

Version 4 – b/w, for strong downsizing and application of single(!) foreign colours:

標示顯示全黑 標示顯示全黑

All surfaces 100% black  
Typo: VAG Rounded

除以上外不可以使用其他版本。

The use of any other form of the mark is not allowed.

只要標籤能明確代表認證的生產地點，該標籤便可用於其生產現場、信件及公司的宣傳物料等。

The marking can be used on the production site, on letters, public relation materials, etc. as long as the connection between the mark and the production site is clear.

不允許使用 A 部分規定範圍外的標籤。

Not permitted is the mark according to part A with products and the corresponding sample material.

如果在某種語言中需要使用元音變音字母進行印刷出版，允許使用 "Øko-Tex®" 來替代 "Oeko-Tex®"，兩者指的都是 Oeko-Tex® 標準 100。

If in a particular language the use of umlaut is in use for printing or writing, it is permissible to use, for example, "Øko-Tex®" instead of "Oeko-Tex®" and in reference to "Oeko-Tex® Standard 100".

## 5 公司组织要求

### 5.1 质量管理

申请者须具备并维系一套有效的品质管理措施，以确保其生产程序以及所生产及/或销售之产品，均符合审核时之相当要求。

良好的品质管理措施，乃生产无害产品的必要条件。长时间维系固定的管制措施有助满足技术性要求、及使产品能一贯地符合限量值要求。

质量管理体系，根据 ISO 9000 体系的描述，包含与环境管理体系类似的相关要求。特别是文档记录的重要性，权责的明确性及生产工艺记录准确性等，都要做到可以追根溯源。

品质管理措施乃申请 Oeko-Tex® 标签之基本要求，而此部分亦可为现场审核的其中一环。

达到 ISO 9000 标准要求为最有力证明该公司的品质管理系统。公司只需提供证书即可。

### 5.2 环境管理体系

根据 Oeko-Tex® Standard 1000 的规定，拥有并且已经实施广为接受的环境管理体系（如 ISO 14000、EMAS）将作为申请标签使用权的有利条件。

得到 Oeko-Tex® 标签使用授权的前提，以下环境管理规则必须遵循：

必须根据附录 1 规定进行环境管理评估。

环境管理评估的相关细节必须与环境管理的目标和计划相贴合。

通过评估必须明确制定出环境管理的目标和计划。

在不同领域内实施环境管理体系需要在相关监管下执行。

有效的环境管理体系需要企业持续执行。

## 5 Organisational requirements

### 5.1 Quality management

The applicant shall operate and maintain an effective quality management system to ensure that production processes and products manufactured and/or sold are in conformity with the conditions during audit.

Sufficient quality management measures are a prerequisite to produce environmentally sound products in the same manner and quality over a extended period of time, such fulfil the technical requirements and limiting values at any time of production.

Quality management systems, as for instance described in ISO-series 9000, contain formal requirements quite similar to those in an environmental management system. Especially necessity of documentation, clear responsibilities and defined working procedures has the same aim of trace ability.

The basis requirements for the quality system for achieving an Oeko-Tex® mark can be checked as part of the environmental auditing process.

A quality management system fulfilling the requirements of ISO 9000 standard series is presenting a maximum solution. Proof by existing certificate is possible.

### 5.2 Environmental management system

An already implemented and maintained environmental management system certified according to a widely accepted system (ISO 14000, EMAS) is going to be taken into consideration for the certification according to Oeko-Tex® Standard 1000.

For the marking of production sites with the Oeko-Tex® mark the following requirements concerning environmental management exist.

A primary environmental assessment according to appendix 1 is required.

The detailedness of the primary assesement must be appropriate for the preparation of environmental objectives and plans.

From this assessment environmental objectives and plans have to be prepared and defined.

Further steps in the different fields in implementing an environmental management system are to be watched over.

The implementation of an effective environmental management system has to be continually aimed.

**5.3 法规要求**

待认证之生产场所必须达到法律的相关要求。

**5.3 Legal requirements**

The legal requirements that are applicable to the production site to be certified have to be met.

**6 技术要求****6 Technical requirements****6.1 人类生态学要求**

真正的环保型生产必须满足人类生态学的要求及预防措施，产品不会对人体产生任何危害。

**6.1 Human-ecological requirements**

Environmentally sound production must include precautions for human ecological sound products posing no health risk.

因此,必须有策略去使用相应措施和工具,以确保产品不会为使用者构成健康风险。此策略也必须考虑终端市场的法律要求, 以及品牌和零售商的期望。根据 OEKO-TEX® Standard 100 认证产品, 正是一个有效及符合成本效益的方法, 以满足此要求。

So there must exist a strategy and the corresponding measures and tools must be installed to ensure that the produced articles do not impose any health risk to the end-user. This strategy must consider also legal requirements of the final end-user market as well as expectations from the buying brands and retailers. A certification of the produced articles according to OEKO-TEX® Standard 100 is an efficient and cost effective way to meet this requirement.

**6.2 生产过程中的化学品及工艺****6.2 Chemicals and Technologies in the Production**

纺织品生产过程中, 有若干工序中使用的化学品及工艺从健康和环境危害角度讲, 是不被信任的。当有更好的技术工艺路径时, 落后的技术便会逐渐被淘汰。

In textile production several processes, chemicals and techniques are discredited due to health or environmental hazards. Such methods can no longer be accepted if more environmental sound alternatives are available to achieve.

**6.2.1 禁用化学品**

以下化学品为禁用

**6.2.1 Prohibited Chemicals**

The use of the following chemicals products is not allowed:

**染料和涂料**

偶氮染料和偶氮涂料分为以下致癌芳香胺：

**Dyes and Pigments**

Azo-dyestuffs and azo pigments that can be reduced to the following carcinogenic arylamines

**第一类别**

- 4-氨基联苯
- 联苯胺;4, 4'-二氨基联苯
- 4-氯-邻-氨基甲苯
- 2-萘胺

**MAK III. 第二类别**

- 邻氨基偶氮甲苯
- 2-氨基-4-硝基甲苯
- 对-氯苯胺
- 2,4'-二氨基苯甲醚
- 4,4'-二氨基联苯甲烷
- 3,3'-二氯联苯氨
- 3,3'-甲氧基联苯胺; 联大茴香胺
- 
- 3,3'-二甲基-4,4'-二氨基联苯甲烷

- 3-氨基对甲苯甲醚
- 4, 4'-并甲基-二(2-氯苯胺)
- 4,4'-二氨基二苯醚
- 4,4'-二氨基二苯硫醚
- 邻氨基甲苯
- 2,4-二氨基甲苯
- 2,4,5-三甲基苯胺
- 邻氨基苯甲醚
- 2,4-二甲基苯胺
- 2,6-二甲基苯胺
- 4-氨基偶氮苯

**MAK III. category 1**

- 4-Aminobiphenyl
- Benzidine
- 4-Chloro-o-toluidine
- 2-Naphthylamine

**MAK III. category 2**

- o-Aminoazotoluene
- 2-Amino-4-nitrotoluene
- p-Chloroaniline
- 2,4-Diaminoanisole
- 4,4'-Diaminobiphenylmethane
- 3,3'-Dichlorobenzidine
- 3,3'-Dimethoxybenzidine
- 3,3'-Dimethylbenzidine
- 3,3'-Dimethyl-4,4'-diaminobiphenylmethane
- p-Cresidine
- 4,4'-Methylene-bis- (2-chloroaniline)
- 4,4'-Oxydianiline
- 4,4'-Thiodianiline
- o-Toluidine
- 2,4-Toluyldiamine
- 2,4,5-Trimethylaniline
- o-Anisidine (2-Methoxyanilin)
- 2,4-Xylidine
- 2,6-Xylidine
- 4-Aminoazobenzene

**致癌染料及涂料****Carcinogenic dyestuffs and pigments**

<u>C.I. Generic Name</u>	<u>C.I. Structure number</u>	<u>CAS-Nr.</u>
C.I. Acid Red 26	C.I. 16 150	3761-53-3
C.I. Basic Red 9	C.I. 42 500	569-61-9
C.I. Basic Violet 14	C.I. 42 510	632-99-5
C.I. Direct Black 38	C.I. 30 235	1937-37-7
C.I. Direct Blue 6	C.I. 22 610	2602-46-2
C.I. Direct Red 28	C.I. 22 120	573-58-0
C.I. Disperse Blue 1	C.I. 64 500	2475-45-8
C.I. Disperse Orange 11	C.I. 60 700	82-28-0
C.I. Disperse Yellow 3	C.I. 11 855	2832-40-8

**致敏染料及涂料****Allergenous dyestuffs and pigments**

<u>C.I. Generic Name</u>	<u>C.I. Structure number</u>	<u>CAS-Nr.</u>
C.I. Disperse Blue 1	C.I. 64 500	2475-45-8
C.I. Disperse Blue 3	C.I. 61 505	2475-46-9
C.I. Disperse Blue 7	C.I. 62 500	3179-90-6
C.I. Disperse Blue 26	C.I. 63 305	
C.I. Disperse Blue 35		12222-75-2
C.I. Disperse Blue 102		12222-97-8
C.I. Disperse Blue 106		12223-01-7
C.I. Disperse Blue 124		61951-51-7
C.I. Disperse Brown 1		23355-64-8
C.I. Disperse Orange 1	C.I. 11 080	2581-69-3
C.I. Disperse Orange 3	C.I. 11 005	730-40-5
C.I. Disperse Orange 37	C.I. 11 132	
C.I. Disperse Orange 76	C.I. 11 132	
C.I. Disperse Red 1	C.I. 11 110	2872-52-8
C.I. Disperse Red 11	C.I. 62 015	2872-48-2
C.I. Disperse Red 17	C.I. 11 210	3179-89-3
C.I. Disperse Yellow 1	C.I. 10 345	119-15-3
C.I. Disperse Yellow 3	C.I. 11 855	2832-40-8
C.I. Disperse Yellow 9	C.I. 10 375	6373-73-5
C.I. Disperse Yellow 39		
C.I. Disperse Yellow 49		



**其他禁用染料****Other banned dyestuffs**

C.I. Generic Name  
C.I. Disperse Orange 149  
C.I. Disperse Yellow 23

C.I. Structure number  
C.I. 26 070

CAS-Nr.  
85136-74-9  
6250-23-3

含重金属铅和镉的染料及涂料。

Dyestuffs and pigments with an acute toxicity  
LD50 < 100 mg/kg

Dyestuffs and pigments containing the heavy  
metals lead or cadmium.

对环境有潜在危害的染料。

Dyestuffs, with a high potential risk to the envi-  
ronment:

- 蓝色染料, 索引编号 611-070-00-2  
(EG 405-665-4)
- Blue dyestuff Index No 611-070-00-2  
(EG 405-665-4)

**载体****Carriers**

有机氯载体 (氯化苯, 氯化甲苯, 氯代苯酚)

Chlorinated organic carriers (chlorobenzene,  
chlorotoluene, chlorophenole)

- 二氯苯
- 三氯苯
- 四氯苯
- 五氯苯
- 六氯苯
- 氯甲苯
- 二氯甲苯
- 三氯甲苯
- 四氯甲苯
- 五氯甲苯
- Dichlorobenzenes
- Trichlorobenzenes
- Tetrachlorobenzenes
- Pentachlorobenzenes
- Hexachlorobenzene
- Chlorotoluenes
- Dichlorotoluenes
- Trichlorotoluenes
- Tetrachlorotoluenes
- Pentachlorotoluene

**中间体****Additionally**

- 邻苯二甲酰亚胺
- Phthalimides

**杀虫剂****Pesticides**

禁止于贮藏及运输过程中使用杀虫剂 (参见  
Oeko-Tex® 标准 100)

The use of Pesticides for storing and transporta-  
tion is not allowed (see also Oeko-Tex® Stand-  
ard 100).

**阻燃剂****Flame Retardants**

含有锑或砷的阻燃剂

Flame retardants containing the toxic metals an-  
timony, or arsenic.

溴化物阻燃剂, 如:

Brominated flame retardants, for example:

- 多溴联苯
- 六溴环十二烷
- 多溴二苯醚
- 三(2,3-二溴丙基)磷酸酯
- Polybromodiphenylether (PBB)
- hexabromocyclododecane
- bromated diphenylether (PBDE)
- Tri-(2,3-dibromopropyl)-phosphate  
(TRIS)

含有氯化石蜡或氟化物的阻燃剂。

Flame retardants with chloroparaffines or fluo-  
rides.

以下阻燃成分:

The following flame retardant agents:

- 三吡啶基氧化磷
- Tris-(aziridiny)-phosphinooxide  
(TEPA)

**表面活性剂****Tensides**

- 乙氧烷基酚
- 乙二胺四乙
- 二乙烯三胺五乙酸
- 壬基苯酚

- Alkylphenolethoxylate (APEO)
- EDTA
- DTPA
- Nonylphenol

**纺织品水洗剂****Textile washing detergents**

纺织品水洗助剂不可以含有以下成分：

Textile washing detergents shall not contain following ingredients:

- 二氧甲烷
- 三氯乙烯
- 四氯乙烯
- > 0.5%磷
- 磷酸盐

- Dichloromethane
- Trichloroethylene
- Tetrachloroethylene
- >0.5% Phosphor
- Phosphates

**清洁或去油剂****Cleaning and degreasing agents**

清洁或去油剂

Cleaning and degreasing agents (e.g. for machine maintenance) shall not contain following ingredients:

- 
- 三氯乙烯
- 四氯乙烯

- Dichloromethane
- Trichloroethylene
- Tetrachloroethylene

**其他****Others**

- |   |  |
|---|--|
| <ul style="list-style-type: none"> <li>• 石棉纤维</li> <li>• 氯仿</li> <li>• 氰化钠, 氰化钾</li> <li>• 硫化钠</li> <li>• 芳香烃溶剂</li> <li>• 二氯甲烷(CAS-Nr. 75-09-2)</li> <li>• 1,1-二氯乙烷(CAS-Nr. 75-34-3)</li> <li>• 1, 2-二氯乙烷 (CAS-Nr. 107-06-2)</li> <li>• 三氯乙烯(CAS-Nr. 79-01-6)</li> <li>• 四氯乙烯 (CAS-127-18-4)</li> <li>• 1,1,1-三氯乙烷 (CAS-Nr. 71-55-6)</li> <li>• 1,1,2-三氯乙烷 (CAS-79-00-5)</li> <li>• 1,1,2,2-四氯乙烷(CAS-Nr.79-34-5)</li> <li>• 1,1,1,2-四氯乙烷(CAS-Nr.630-20-6)</li> <li>• 四氯化碳 (CAS-Nr. 56-23-5)</li> <li>• 五氯乙烷(CAS-Nr. 76-01-7)</li> <li>• 1,1-二氯乙烷 (CAS-Nr. 75-35-4)</li> <li>• 六氯乙烷 (CAS-Nr. 67-72-1)</li> <li>• 氯化三联苯</li> <li>• 氯化萘</li> <li>• 甲基四氯二苯甲烷 (CAS-Nr. 76253-60-6)</li> <li>• 甲基二氯二苯甲烷</li> <li>• 单甲基二溴二苯基甲烷 (CAS-Nr. 99688-47-8)</li> <li>• 单甲基二溴二苯基甲烷</li> <li>• 三氯苯氧乙酸及其盐类和 2,4,5-三氯苯氧基醋酸之化合物</li> <li>• 2,4,5-涕丙酸(CAS-Nr. 93-72-1)及其盐类和 2,4,5-涕丙酸之化合物</li> <li>• 五氯硝基苯 (CAS-Nr. 82-68-8)</li> <li>• 作为生产三烷基锡、三芳基锡、砷和砷化合物之保护剂</li> <li>•</li> <li>• 全氟辛酸磺酰基化合物 (PFOS)</li> <li>• 富马酸二甲酯 (DMF)</li> </ul> | <ul style="list-style-type: none"> <li>• Asbestos</li> <li>• Chloroform</li> <li>• Sodiumcyanide, potassiumcyanide</li> <li>• Sodumsulfide</li> <li>• Aromatic hydrocarbons as solvents</li> <li>• Dichloromethane(CAS-Nr. 75-09-2)</li> <li>• 1,1-Dichloroethane(CAS-Nr. 75-34-3)</li> <li>• 1,2-Dichloroethane(CAS-Nr. 107-06-2)</li> <li>• Tri Chloroethylene(CAS-Nr. 79-01-6)</li> <li>• Tetrachloroethylene(CAS-Nr. 127-18-4)</li> <li>• 1,1,1-Trichloroethane(CAS-Nr. 71-55-6)</li> <li>• 1,1,2-Trichloroethane(CAS-Nr. 79-00-5)</li> <li>• 1,1,2,2-Tetrachloroethane(CAS-Nr. 79-34-5)</li> <li>• 1,1,1,2-Tetrachloroethane(CAS-Nr. 630-20-6)</li> <li>• Tetrachlorocarbonate(CAS-Nr. 56-23-5)</li> <li>• Pentachloroethane(CAS-Nr. 76-01-7)</li> <li>• 1,1-Dichloroethylene(CAS-Nr. 75-35-4)</li> <li>• Hexachloroethane(CAS-Nr. 67-72-1)</li> <li>• Halogenated Terphenyles</li> <li>• Halogenated Naphthalins</li> <li>• Monomethyltetrachlorodiphenylmethane (CAS-Nr. 76253-60-6)</li> <li>• Monomethyldichlorodiphenylmethane</li> <li>• Monomethyldibromdiphenylmethane (CAS-Nr. 99688-47-8)</li> <li>• Trichlorophenoxy fatty acid and derivatives</li> <li>• 2,4,5-Trichlorophenoxy fatty acid (CAS-Nr. 93-76-5) and their salts and 2,4,5-Trichlorophenoxyacetyl compounds</li> <li>• 2-(2,4,5-Trichlorophenoxy)-propionate acid (CAS-Nr. 93-72-1) and their salts as well as 2-(2,4,5-Trichlorophenoxy)-propionyl compounds</li> <li>• Quintolen (CAS-Nr. 82-68-8)</li> <li>• Protective agents as Trialkyltin-, Triaryl tin-, Arsenic- and Arsenic compounds for production water</li> <li>• TBT, DBT &amp; MBT</li> <li>• Perfluorooctane sulfonates (PFOS)</li> <li>• Dimethylfumarate (DMF)</li> </ul> |
|---|--|

**破坏臭氧层的物质, 例如:****Ozone layer reducible substances like...**

- |   |  |
|---|--|
| <ul style="list-style-type: none"> <li>• 全氢化的氟氯烃 (HCFC's)</li> <li>• 半氢化的氟氯烃</li> <li>• 全氢化含溴氟氯烃</li> <li>• 半氢化含溴氟氯烃</li> </ul> | <ul style="list-style-type: none"> <li>• Complete halogenated Fluoro-hydrocarbons (HCFC's)</li> <li>• Partly halogenated Fluoro-hydrocarbons (HFCKW)</li> <li>• Complete halogenated Fluoro-hydrocarbons containing bromine</li> <li>• Partly halogenated Fluorohydrocarbons containing bromine</li> </ul> |
|---|--|

**6.2.2 禁用工艺****6.2.2 Prohibited Technologies**

使用以下生产技术则不能通过认证: 使用以下生产  
技术则不能通过认证:

The use of the following production techniques  
is not certifiable.

**重苯印花技术。**

以重铬酸盐作为氧化剂以提高色牢度。若无法使用先进技术取替重铬酸钾(黑羊毛染料), 则要确保有完善的废水处理。

在开放式系统中使用氯化油剂溶剂和氟化氯化有机溶剂。

**6.2.3 其他**

使用磷光体作为阻燃剂时, 磷光体在废水中的含量(公共或公司内部的废水处理厂)须减少至80%。

**6.2.4 声明要求**

必须向买家通报所用的整理和防腐剂之剂量及物质(贸易名称、化学品名称)。

必须向买家通报所用的纺纱油剂量及物质(贸易名称、化学品名称)。

若产品含 REACH 条例提及的 SVHC (高度关注物质) 清单之其中一项, 而且含量超过 0.1%, 则必须通知买家。SVHC 列表公布于以下网站: 若产品含 REACH 条例提及的 SVHC (高度关注物质) 清单之其中一项, 而且含量超过 0.1%, 则必须通知买家。SVHC 列表公布于以下网站:

[http://echa.europa.eu/chem\\_data/authorisation\\_process/candidate\\_list\\_table\\_en.asp](http://echa.europa.eu/chem_data/authorisation_process/candidate_list_table_en.asp)

**6.2.5 目标**

将用过的浆料回收或将使用根据 OECD 测试 301 A-F 易降解(平均降解时间≤28 天)以及使用根据 OECD 测试 305 A-E 不累积型(生物累积因子≤100)浆料作为升级目标。

以避免使用不容易为生物降解(根据 OECD 测试 301A-F 平均降解时间≥28 天)及生物累积达 OECD 测试 305 A-E (生物累积因子≥100) 的表面活性剂如 DTDMAC, DSDMAC 及 DHTDMAC 为目标。以避免使用不容易为生物降解(根据 OECD 测试 301A-F 平均降解时间≥28 天)及生物累积达 OECD 测试 305 A-E (生物累积因子≥100) 的表面活性剂如 DTDMAC, DSDMAC 及 DHTDMAC 为目标。

须以避免使用非永久性阻燃剂为目标。须以避免使用非永久性阻燃剂为目标。

须以避免使用卤化烃类化合物(如某些防垢剂、溶剂、阻燃剂及染料等)为目标。

须以避免使用高甲醛含量的纯棉织物抗皱整理交联剂, 如: 二羟甲基脲、二羟甲基乙烯脲等为目标。

Printing systems based on heavy benzene.

Dichromate as oxidising agent to improve colour fastness. If, at best available technique a replacement of potassium dichromate is not possible (very dark shades on wool) a sufficient waste water treatment has to be done.

Chlorinated organic solvents and fluoro chlorinated organic solvents in open systems.

**6.2.3 Other**

When using phosphor-based flame retardants the phosphor content in the waste water (public or company sewage cleaning plant) is to be reduced by 80%.

**6.2.4 Declaration requirements**

Used size including conserving agents has to be notified to the buyer with amount and substance (trade name, chemical name).

Used spinning oils have to be notified to the buyer with amount and substance (trade name).

It has to be declared to the buyer if the goods contain more than 0.1% of one of the substances mentioned in the candidate list of SVHC (Substances of Very High Concern) of the REACH regulation. The list is published under:

**6.2.5 Aims**

Recycling of used size or the use of easily biodegradable to OECD test 301 A-F (mean time ≤ 28 days) and non bioaccumulation to OECD test 305 A-E (bioaccumulation factor ≤ 100) is to be set as a goal.

The avoidance of tensides and complexing agents like DTDMAC, DSDMAC and DHTDMAC being not easily biodegradable (to OECD test 301 A-F mean time ≥ 28 days) and bio accumulated to OECD test 305 A-E (bioaccumulation factor ≥ 100) is to be set as a goal.

The avoidance of non permanent flame retardants should be set as a goal.

The avoidance of multiple-halogenated hydrocarbons (e.g., certain biocides, solvents, flame retardants and dye-stuffs) should be set as a goal.

The avoidance of cross linking agents with a high content of formaldehyde for anti crease finish of cotton like dimethylol urea, dimethylethylene urea or dimethyloldihydroxyethylene urea should be set as a goal.

### 6.3 工业用水/废水

用水量该尽可能节约。

每项工序的用水量该被注册记录，而组织亦须订明内部要求，并建立完善文档记录和相关评估。  
每项工序的用水量该被注册记录，而组织亦须订明内部要求，并建立完善文档记录和相关评估。

必须符合地方政府及国家法规对废水处理之有关要求。

纺织过程所生产的废水必须经私营或公共净化厂分阶段处理。

必须确保污水净化厂之有效运作。

若没有相关法规约束，工厂须遵循“尽善生产”原则。

### 6.3 Water/Waste water

Water is to be used as thrifty as possible.

The measuring strategy for the registration of individual water consumption and the organisational requirements to the documentation and evaluation are to be created.

The local and national legal requirements for waste water treatment have to be fulfilled

The waste water of processes of textile production has to clean in a private or public sewage multiple stages cleaning plant.

The functional ability of the sewage treatment plant has to be ensured.

If no legal requirements exist the principles of „Good Manufacturing practice“ have to be observed.

#### 6.3.1 废水的级别参数

#### 6.3.1 Classification table for Effluents to Waters

等级 / Grade	-3	-2	-1	0	+1
参数 / parameter					
pH 值 / pH-value	5.5 - 10	6.0 - 10	6.5 - 9.5	6.5 - 9.0	6.5 - 8.5
最大注入温度 / maximum effluent temperature	50 °C	45 °C	40 °C	35 °C	30 °C
光谱吸收系数 / colour / spectral absorption coefficient at					
436 nm	20 m-1	15 m-1	11 m-1	9 m-1	6 m-1
525 nm	15 m-1	12 m-1	9 m-1	7 m-1	4 m-1
620 nm	10 m-1	8 m-1	6 m-1	4 m-1	3 m-1
铬含量 / chromium total (as Cr)	2.0 mg/l	1.5 mg/l	1.0 mg/l	0.4 mg/l	0.1 mg/l
六价铬含量 / chromium VI (as Cr)	0.7 mg/l	0.4 mg/l	0.2 mg/l	0.1 mg/l	0.02 mg/l
钴含量 / cobalt (as Co)	2.0 mg/l	1.5 mg/l	1.0 mg/l	0.4 mg/l	0.1 mg/l
铜含量 / copper (as Cu)	2.0 mg/l	1.5 mg/l	1.0 mg/l	0.4 mg/l	0.1 mg/l
镍含量 / nickel (as Ni)	2.0 mg/l	1.5 mg/l	1.0 mg/l	0.4 mg/l	0.1 mg/l
总有机碳含量 / total organic carbon TOC (as C)	200 mg/l	150 mg/l	100 mg/l	70 mg/l	40 mg/l
气味 / or					
化学需氧量 / chemical oxygen demand COD (as O <sub>2</sub> )	400 mg/l	300 mg/l	250 mg/l	180 mg/l	120 mg/l
可吸附有机卤化物含量 / adsorbable organic halogens AOX (as Cl)	5.0 mg/l	2.0 mg/l	1.0 mg/l	0.4 mg/l	0.1 mg/l

<sup>1</sup> 参见 part A, 3.7 部分 / see part A, Chapter 3.7

## 6.3.2 废水处理厂的级别参数

## 6.3.2 Classification table for Effluents to a public sewage treatment plant

等级 / Grade	-3	-2	-1	0	+1
参数 / parameter					
/ pH 值 / pH-value	5.5 - 10	6.0 - 10	6.5 - 9.5	6.5 - 9.0	6.5 - 8.5
最大注入温度 / maximum insertion temperature	55 °C	50 °C	45 °C	40 °C	35 °C
铬总含量 / chromium total (as Cr)	2.0 mg/l	1.5 mg/l	1.0 mg/l	0.4 mg/l	0.1 mg/l
六价铬含量 / chromium VI (as Cr)	0.7 mg/l	0.4 mg/l	0.2 mg/l	0.1 mg/l	0.02 mg/l
钴含量 / cobalt (as Co)	2.0 mg/l	1.5 mg/l	1.0 mg/l	0.4 mg/l	0.1 mg/l
铜含量 / copper (as Cu)	2.0 mg/l	1.5 mg/l	1.0 mg/l	0.4 mg/l	0.1 mg/l
镍含量 / nickel (as Ni)	2.0 mg/l	1.5 mg/l	1.0 mg/l	0.4 mg/l	0.1 mg/l
可吸附有机卤化物含量 / adsorbable organic halogens AOX (as Cl)	5.0 mg/l	2.0 mg/l	1.0 mg/l	0.4 mg/l	0.1 mg/l
羊毛防毡缩整理 / for antifelt finishing of wool	20 mg/l	15 mg/l	10 mg/l	4 mg/l	1 mg/l
通过回收和净化减少耗氧物质含量 / Reduction of oxygen depleting substances (as TOC or COD) by recycling and cleaning	70 %	75 %	80 %	85 %	90 %

<sup>1</sup> 参见 part A, 3.7 部分 / see part A, Chapter 3.7

如果发现有排放超标的情况，应立即采取改进措施。

Corrective action on faulty conditions leading to exceeding of limiting values has to be initiated immediately.

## 6.4 废气排放

工厂废气排放的相关指标须在以下参数之控制范围内。

## 6.4 Exhaust air

The exhaust air of firing plants and steam plants will be judged according to the following parameters:

## 6.4.1 一氧化碳

对于使用常规固、液及气体燃料的工厂，排热值超过两兆瓦，其一氧化碳排放量分级如下：

## 6.4.1 Carbon Monoxide

For plants with a thermal value exceeding 2 MW for conventional solid, liquid and gaseous fuels the grading for the emission of CO (carbon monoxide) is as follows

(等级以 6% 的固体燃料和 3% 的液态燃料的氧气体积含量来划分。)

(The grading refers to a volumetric oxygen content of 6% for solid fuels and 3 % for liquid fuels.)

等级 / Grade	-3	-2	-1	0	+1
参数 / parameter	mg / m³	mg / m³	mg / m³	mg / m³	mg / m³
固态燃料 / solid fuel	1500	1000	500	200	120
液体燃料 / liquid fuel	1000	500	250	150	80
气态燃料 / gaseous fuel	1000	500	250	150	80

<sup>1</sup> 参见 part A, 3.7 部分 / see part A, Chapter 3.7

## 6.4.2 灰尘

对供热量超过 10 兆瓦的工厂，释效废尘含量须遵循以下分级标准。

## 6.4.2 Dust

For the emission of dust for all firings above 10 MW the following grading is applied:

等级 / Grade	-3	-2	-1	0	+1
参数 / parameter	mg / m³	mg / m³	mg / m³	mg / m³	mg / m³
参数 / all fuels	150	110	80	50	30

<sup>1</sup> 参见 part A, 3.7 部分 / see part A, Chapter 3.7

## 6.4.3 二氧化硫

对于以传统的固、液及气态燃料为供热源的，供热当量介于 2 兆瓦和 50 兆瓦之间的工厂，其二氧化硫的排放分级如下：

(等级以 6% 的固态燃料和 3% 的液态燃料的氧气体积含量来划分)

等级 / Grade	-3	-2	-1	0	+1
参数 / parameter	mg / m <sup>3</sup>	mg / m <sup>3</sup>	mg / m <sup>3</sup>	mg / m <sup>3</sup>	mg / m <sup>3</sup>
所有燃料 / all fuels	3000	2500	2000	1500	1200

<sup>1</sup> 参见 part A, 3.7 部分 / see part A, Chapter 3.7

对于以传统的固、液及气态燃料为供热源的，当供热量超过 50 兆瓦之间的工厂，其二氧化硫的排放分级如下：

(等级以 6% 的固态燃料和 3% 的液态燃料的氧气体积含量来划分)

等级 / Grade	-3	-2	-1	0	+1
参数 / parameter	mg / m <sup>3</sup>	mg / m <sup>3</sup>	mg / m <sup>3</sup>	mg / m <sup>3</sup>	mg / m <sup>3</sup>
参数 / all fuels	2500	2000	1700	1200	400

<sup>1</sup> 参见 part A, 3.7 部分 / see part A, Chapter 3.7

6.4.3 SO<sub>2</sub>

For plants with a thermal value between 2 MW and 50 MW for conventional solid, liquid and gaseous fuels the grading for the emission of SO<sub>2</sub> (sulphur dioxide) is as follows:

(The grading refers to a volumetric oxygen content of 6% for solid fuels and 3 % for liquid fuels.)

For plants with a thermal value exceeding 50 MW for conventional solid, liquid and gaseous fuels the limiting values for the emission of SO<sub>2</sub> (sulphur dioxide) are as follows:

(The grading refers to a volumetric oxygen content of 6% for solid fuels and 3 % for liquid fuels.)

## 6.4.4 氮氧化物

对于以传统的固、液及气态燃料为供热源的，当供热量超过 2 兆瓦的工厂，氮氧化合物（一氧化氮 + 二氧化氮）都计为二氧化氮其排放分级如下：

(等级以 6% 的固态燃料和 3% 的液态燃料的氧气体积含量来划分)

等级 / Grade	-3	-2	-1	0	+1
参数 / parameter	mg / m <sup>3</sup>	mg / m <sup>3</sup>	mg / m <sup>3</sup>	mg / m <sup>3</sup>	mg / m <sup>3</sup>
参数 / all fuels	1200	900	600	450	300

<sup>1</sup> 参见 part A, 3.7 部分 / see part A, Chapter 3.7

6.4.4 NO<sub>x</sub>

For plants with a thermal value exceeding 2 MW for conventional solid, liquid and gaseous fuels the grading for the emission of NO<sub>x</sub> (nitrogen monoxide + nitrogen dioxide) calculated as nitrogen dioxide (NO<sub>2</sub>) is as follows:

(The grading refers to a volumetric oxygen content of 6% for solid fuels and 3 % for liquid fuels.)

## 6.4.5 附加要求

垃圾只可以在合适的焚烧厂进行焚毁。焚烧厂必须有空气净化装置，以减少未烧尽的烃类，二恶英，卤素化合物及重金属等，防止排入大气中。

如果工厂的供热当量超过 50 兆瓦的话，有必要对一氧化碳、二氧化硫和氮氧化物的排放进行连续性监测。

## 6.4.5 Additional requirements

Garbage may be fired only in suitable plants, which have a suitable gas purification plant for the reduction of the emission of unburned hydrocarbons, dioxins, halogen compounds and heavy metals.

Continuous emission measurements of the parameters CO, SO<sub>2</sub> and NO<sub>x</sub> at firing plants are necessary, if the thermal value exceeds 50 MW.

如果通过对工厂的气体净化装置进行连续监测, 证明其有足够能力使各种排放达标, 也可省略对其排放物的监测。

排放物质量浓度的连续性监测一般是测半小时内的排放平均值。排放烟气温度以及烟气中二氧化碳的含量或氧气的含量必须进行连续性监测。

废气排放的监测值, 须在固定的监测点连续监测半小时的排放平均值。

如果发现排放超标, 须立即采取措施改进。

### 6.5 噪音

如果噪音值超过 85 分贝(A)时, 必须提供适当指示及有效的防护措施。及必须在该噪音污染范围内长期标贴清晰的显示。如果噪音值超过 85 分贝(A)时, 必须提供适当指示及有效的防护措施。及必须在该噪音污染范围内长期标贴清晰的显示。

### 6.6 能源

必须对已使用的能源善加利用。一些节能处理或能源回收 (例如: 工厂 - 废热回收, 多单元冷却循环系统, 蒸汽泵等) 均可达到此目的。

须发展一套完善监控政策, 使能监控不同产品在各个生产环节的耗能情况。

按个别的生产模式, 实地能源使用将作为今后详细规定的指标。

### 6.7 工作场所

须遵循国家关于工作和接触有害化学品的相关防护规定。工厂须努力达到相关法规的最低要求。须遵循国家关于工作和接触有害化学品的相关防护规定。工厂须努力达到相关法规的最低要求。

关于危险化学物质的操作 (根据第三段的定义), 工厂须提供个人防护用品并对工人进行相关指导培训。

实地工作环境将作为今后详细规定的指标。

工人的最小年龄应符合国际劳工组织公约第 138 条的相关规定。

Continuous emission measurements can be avoided, if other tests, e.g. continuous testing of functions of gas purification plants, can ascertain with sufficient safety the compliance with the emissions limits.

Continuous emission measurements of the mass concentration of an emission have normally been done as half-hour mean values. The exhaust fume temperature as well as the content of CO<sub>2</sub> or of O<sub>2</sub> of the dry exhaust fume must be recorded continuously.

For the measurement of gaseous air pollutants the judgement value is to be formed from the half-hour mean values measured at stationary operation.

Corrective action on faulty conditions leading to exceeding of limiting values has to be initiated immediately.

### 6.5 Noise

Above a noise level of 85 dB (A) effective ear protections are to be provided and their application directed. Areas with such a noise pollution are to be marked clearly lasting.

### 6.6 Energy

The used energy must be utilised optimally. Energy-saving handling of the processes or energy recovery (e.g. plants - waste heat, multi-sectional cooling circles, heat pumps etc.) serves for this purpose.

Measurement strategies are to be developed enabling the measuring of energy consumption for different products at parts of production units.

The field of energy use is considered for future detailed regulations, based on single production modules.

### 6.7 Workplace

The national legislative requirements for the protection of the working of dangerous and unhealthy chemicals are to be observed. The minimisation of the burden clear under such limits is to be striven for.

On handling of dangerous materials (according to the definition in paragraph 3) personal protection equipment is to be provided and its application to be directed.

The field of work place atmosphere is considered for future detailed regulations.

The minimum age shall comply with the ILO-Convention No. 138 of the „International Labour Organisation“.



国际劳工组织公约第 155 及 164 条规定：工厂须提供安全健康的工作环境；采取临时性措施避免工伤；对员工进行有关保持健康和安全的培训；建立完善措施监测安全隐患；有权使用盥洗室及饮用水。

Provide a safe and healthy work environment; introduce provisional measures to prevent injuries; occupational training to sustain health and safety; system to detect threats to health and safety; access to bathrooms and potable water. These requirements are given by ILO No. 155 and No. 164.

## 6.8 社会标准

国际劳工组织公约第 100 条及 101 条规定：不可对员工有任何歧视，包括种族、社会等级、背景、宗教、残疾、性别、性取向、政治信仰、年龄及不可性骚扰。

## 6.8 Social criteria

No discrimination based on race, caste, origin, religion, disability, gender, sexual orientation, union or political affiliation, or age; no sexual harassment. These regulations refer to ILO No. 100 and No. 101.

公司不可有体罚手段，不能对员工施以精神或肉体虐待及言语的侮辱。

No corporal punishment, mental or physical coercion or verbal abuse.

根据国际劳工组织公约第 29 条及第 105 条的规定，不可强制员工进行劳动。雇主及外部的招聘人员不可以向员工收取保证金或要求员工提供身份证明文件。

According to ILO No. 29 and No. 105 forced labour is not allowed. No lodging of deposits or identity papers by employers or outside recruiters.

国际劳工组织公约第 87 条及 98 条规定：公司须尊重员工自行组织及加入工会，以及集体诉求的权利。如果有相关法律对以上权利进行限制，须准予员工成立其他组织及争取权益的自由。

Respect the right to form and join labour unions and collective bargaining; where law prohibits these freedoms, facilitate parallel means of free association and bargaining. These regulations refer to ILO No. 87 and No. 98.

国际劳工组织公约第 1 条及第 146 条规定：公司须遵从适用法律关于工作时间的规定，在任何情况下，每周工作时间不可超过 48 小时，同时每 7 个工作日必须至少休假一天；自愿加班时间一周不可超过 12 小时；根据集体诉求原则，加班可以是自愿性的。

Comply with the applicable law regarding working time but, in any event, no more than 48 h per week with at least one day off for every 7 day period; voluntary overtime paid at a premium rate and not exceed 12 h per week on regular basis; overtime may be voluntary if part of a collective bargaining agreement. These requirements are given by ILO No. 1 and No. 146.

国际劳工组织公约第 100 条及 131 条规定：员工的每周工资必须符合相关法律及行业标准，不可以因纪律问题而强行克扣工资。

ILO No. 100 and No. 131 states that wages paid for a standard work week must meet the legal and industry standards; no disciplinary deductions.

# Oeko-Tex® Standard 1000

## B 部分

### 产品标签

#### 1 范围

Oeko-Tex® Standard 1000 是由 Oeko-Tex® 国际环保纺织协会就针对评估纺织品与环境保护而颁发的标准规范文件。

此标准的 B 部分明确了对已注册商标的环保纺织产品进行许可使用的条件和要求。

#### 2 适用性

此标准仅适用于纺织类产品，及其半制成品、辅料。（参见 DIN 60000 “纺织品，基本条件和定义”）

Oeko-Tex® Standard 1000 的 B 部分同样也适用于从事市场营销的公司。

#### 3 条件

##### 3.1 产品标签

以下情形下，产品可以配以文字/图片标签（参照附录 2）：

- 产品获国际环保纺织协会颁发授权使用“信心纺织品-通过 Oeko-Tex® Standard 100 有害物质检测”的标签。
- 如产品的生产场地已符合 Oeko-Tex® Standard 1000 A 部分标准。但若产品的生产场地并未符合 Oeko-Tex® Standard 1000 A 部分，此种情况下，所涉及之生产线就必须进行评估。

# Oeko-Tex® Stand- ard 1000

## Part B

### Product marking

#### 1 Scope

*Oeko-Tex® Standard 1000 is a normative document published by the Oeko-Tex® International, Association for the Assessment of Environmentally Friendly Textiles.*

This standard's part B specifies the conditions and requirements for a licensed use of the registered mark for environmentally sound produced textiles.

#### 2 Applicability

This standard is to be applied to textile products (see DIN 60000 "Textiles, basic terms and definitions", their pre-products and accessories.

The Oeko-Tex® Standard 1000, part B can also be applied for marketing companies without production.

#### 3 Conditions

##### 3.1 Labelling of products

A product may be marked with the text/picture mark (according to appendix 2 under the following conditions:

- for the product exists a valid authorisation to use the label „Confidence in Textiles, - Passed for harmful substances according to Oeko-Tex® Standard 100“ given by the International Community for Research and Development of textile ecology.
- if the product is manufactured in a production site which is certified with Oeko-Tex® Standard 1000, part A. If this is not the case an assessment, according to Oeko-Tex® Standard 1000, part A, of the production lines involved has to be done.

- 以纤维材料为原材料之产品并不包括在 Oeko-Tex® Standard 100+ - B 部分之认证规定内。

未经认证于 Oeko-Tex® Standard 1000 - B 部分的单一成分, 若少于产品整体重量的 5%, 可允许使用。然而, 产品总重量的 85%或以上, 必须已通过 Oeko-Tex® Standard 1000 - B 部分的认证。

此方法的优势在于为最终成品贴上标签, 使其达到最终用户的需求, 及保证所有涉及生产过程中的生产线都属环保生产。

### 3.2 申请

申请授权使用 Oeko-Tex® Standard 100+ 环保产品标签需要填写相关申请表格, 然后递交给其中一个所属 Oeko-Tex® 国际环保纺织协会的机构作评估。机构名单在附录 2 中列出。

每个申请者都会被分配其特有的申请号码, 以作进一步的处理。

### 3.3 责任声明

申请表格在递交给其中一个检验机构时, 申请者的法律责任声明也随之产生, 包含以下几个方面:

- 对申请表上所列出的细节负责。
- 有义务通知授权使用此标签的机构任何有关原材料、技术程序以及配方的变动情况。
- 有义务保证标签使用权到期或撤销之后, 不再使用该标签。
- 经销商无需填写问卷, 提交申请表即可。

### 3.4 一致性

申请人制造或销售 Oeko-Tex® Standard 100+ 产品, 将对其生产或销售的产品符合 Oeko-Tex® Standard 1000 - B 部分的限量值要求负责。

- the used starting material to produce the product to be labelled is certified according to Oeko-Tex® Standard 100plus, part B. Not included in this regulation are fibre materials used as primary material.

It is allowed to use single components for the making up of articles that are not certified according to Oeko-Tex® Standard 1000, part B which weigh less than 5% of the overall article. However, at least 85% of the weight of the made up article have to be certified according to Oeko-Tex® Standard 1000, part B.

The advantage of this method is a labelling of the end product which reaches the end user and grant a environmental friendly production of the whole production line an of all involved production processes.

### 3.2 Application

For the granting of authorisation to use the Oeko-Tex® Standard 100plus mark on textile products, the respective application form has to be sent to an Institute of Oeko-Tex® International, Association for the Assessment of Environmentally Friendly Textiles. The institutes are listed at appendix 2

The applicant is assigned a unique identification number of his application, which serves the further order processing and handling.

### 3.3 Issuing of liability declaration

The applicant's liability declaration legally binding signed together with the application are to be sent to one of the test institutes with the following indication:

- liability for the details specified in the application.
- obligation to notify the institute, which granted the authorization to use the mark, of any alteration regarding raw materials, technical procedures and recipes.
- obligation to ensure that no further marking of the product takes place after the expiration or withdrawal of the authorization to use the mark.
- Trading companies are excluded from filling in the questionnaire and therefore only application form is required.

### 3.4 Conformity

The applicant who is either manufacturing or selling goods with an Oeko-Tex® Standard 100plus mark shall take sole responsibility as long as he uses the mark in declaring that the product manufactured or sold complies with the

申请人需要对被检定的产品质量负责。申请人可以将部分质量责任委派给制造商，供销商和进口商。

#### 3.4.1 监控权利

申请人须允许有关机构进行审查，如发现有投诉的情况，应接受依据此文件中的要求作抽查，及承担有关费用。

## 4 标签

### 4.1 授权许可

如果符合 B 部分条件，而且审查结果与申请人所提供细节没有偏离，会颁发一个证书给申请人，申请人则有权在其产品上使用 Oeko-Tex® Standard 100+ 商标，有效期一年。

### 4.2 授权使用期限

标签授权时间最长限期为一年。基于组织理由，Oeko-Tex® Standard 100+ 证书与 Oeko-Tex® Standard 100 证书该同时发出。在证书有效期内，授权使用认证要求同样生效。

如果已申报资料有改变，比如：技术质量、制造条件的变更，或没有更新已过期的 Oeko-Tex® Standard 100 证书，根据 Oeko-Tex® Standard 100+ - B 部分，该产品的标签使用权亦会随即终止。

### 4.3 标签使用续期

授权一年之后，如认证条件仍适用，申请人可拥有申请证书延期一年之权利。

### 4.4 撤销使用授权

如果生产控制、市场控制、或申请人最初所申报的资料与事实不符，或生产技术、制造条件变更却没有及时上报时，标签的使用权将被撤销。

limit values and requirements according to Oeko-Tex® Standard 1000, part B.

The applicant is responsible for assuring the quality of the certified product. He can delegate parts of the quality assurance to manufacturers, suppliers and importers.

#### 3.4.1 Control rights

In addition the institute that performed the audit is allowed, and in case of found complaints obliged to perform spot test of the compliance with the requirements in this document on the expense of the applicant.

## 4 Marking

### 4.1 Granting of authorization

If the conditions in this standard part B are fulfilled, and the audit shows no deviations from the details provided by the applicant, a certificate will be issued giving the applicant the right to label his products with the Oeko-Tex® Standard 100plus mark valid for the duration of one year.

### 4.2 Limit of authorization

The authorization to mark a product with the 100plus label is limited to a maximum of one year. Due to organisational reasons, the certificate according to Oeko-Tex® Standard 100plus, is issued at the same time as the certificate according to Oeko-Tex® standard 100. During the validity of the certificate the requirements at time of authorization are valid.

As soon as the conditions stated do not prove any longer, e. g. due to amendment of the technical quality and/or manufacturing conditions or after expiration without renewing the Oeko-Tex® Standard 100, the authorization to use the label according to Oeko-Tex® Standard 100plus, part B, at a product expires.

### 4.3 Renewal of authorization

If the granted conditions still apply after one year of authorization, the applicant is entitled to apply for an extension of certificate for a further period of one year at the time.

### 4.4 Withdrawal of authorization

The authorization to use the mark will be withdrawn, when it is determined by means of production controls, market controls or other methods that the details given by the applicant are not or are no longer correct or that amendment of the applied production techniques and/or manufacturing conditions were not reported immediately.

如果标签与此标准的要求不符，同样会撤销授权。

如果生产商在撤销授权后继续使用该标签，Oeko-Tex® 国际环保纺织协会将在发出第二次停止使用该标签的警告后，会以合适渠道发布被撤销授权的生产商名称。

有此执行能力的法庭在苏黎世。

#### 4.5 标签的种类

允许申请者在收到授权后，根据附录 2 中描述的 Oeko-Tex® Standard 100plus, 在商品上的标签。

检验号码必须是授权检验报告号码。检测机构必须是制定检测报告的机构。

不允许使用任何其他形式的标签。必须根据 Oeko-Tex® Standard 100 中，商品标签的各种条件。

Authorization will also be withdrawn when the marking does not comply with the conditions in this standard.

Oeko-Tex® International, Association for the Assessment of Environmentally Friendly Textiles is authorized to publish the withdrawal in a suitable form after the second warning to stop marking, when a producer continues to use the mark after the withdrawal of authorization.

Competency of a court is Zurich.

#### 4.5 Type of marking

The applicant is allowed after received authorization to complete the product marking according to Oeko-Tex® standard 100plus as described in the appendix 2

The test number indicated must be the number of the test report granting authorization. The testing institute indicated must be the institute which elaborated the test report.

The use of any other form of inscription is not allowed. Conditions for marking according to Oeko-Tex® Standard 100 have to be fulfilled.

**附录 / Appendix 1****环境管理制度****Environmental Management System****1 环境管理制度的基本组成部分**

随着人们环保意识的提高，各种类型的公司都开始关注产品生产过程对环境所造成的后果，而且在其公司内部进行环境检验或审查。

1993 年 6 月 29 日，欧洲联盟理事会达成一致协议：允许各个企业自由参与拥有共同体制的环境管理和审查。

这些文件描述了一个完整的环境管理制度，它们都非常相似。

**1.1 实施环境管理系统的阶段**

完整的实施环境管理制度包括很多阶段，大体上来说，它分为实施阶段和改善阶段。

实施阶段最重要的目标是：

- 为成功实施环境管理制度创造企业需求条件
- 首先，进行环境检测，获取当前环境的情况。
- 制定必要的措施，设立环境目标和计划。
- 开始准备文件，手册以及建立程序指引。

**1.2 环境管理制度的好处**

只要一引入环境管理制度，对公司来说，它最基本的优势就开始显现。企业的责任不仅在于创造经济效益，也要创造环境效益。

**1 Basics of Environmental Management Systems**

With increasing consciousness for the conservation and improvement of the environment many organisations of all sizes have directed their attention at the consequences of their activities and accomplished environment tests or audits in their organisations.

The Council of the European Union agreed on 29th of June 1993 on a free participation of enterprises in a common system for environmental management and audit.

Many standardisation institution of single countries and also the ISO cover the topic of environmental management (ISO 14000 ff., GB: BS 7750, F: AFNOR X 30-200, IRL NSAI N150 A&B, CAN: CSA Z750, J: Keidanren GEC).

All those documents describe a complete environmental management system quite similar.

**1.1 Phases of Implementation of an environmental management system**

The complete implementation of an environmental management system is a multi-stage process. It is in principal separated into an implementation phase and an improvement phase.

Most important goals of the implementation phase are:

- Creating organisational requirements for successful implementation of an environmental management system.
- First environmental examination to gain knowledge of current state of environmental performance.
- Concluding of necessary measures and setting of environmental goals and plans.
- Start of preparation of documentation, handbook and instructions for setting up procedure.

**1.2 Benefits of Environmental Management Systems**

From the introduction of an environmental management system essential advantages for the organisation can emerge. The enterprise is in the position to bring economic interests in the scale with environment interests.

如公司建立一套较积极进取的环境管理制度，便能从生产效率，减少废物及改善产品在市场上的竞争力等方面，体验出这管理制度的好处。可是，这需要全新的思考模式，环境管理不是增加成本因素，而是提供了一个市场机遇。

Companies having installed a proactive instead of a reactive environmental management system enjoy competition advantages through production efficiency, waste minimisation and improved acceptance of the products on the market. However this requires a new scheme of thinking, that environmental management is not a further cost element but a market chance.

## 2 实施环境管理制度

## 2 Implementation of an Environmental Management System

实施环境管理制度是取得 Oeko-Tex® Standard 1000 证书的前提。

The implementation of an environmental management system is a prerequisite for achieving the Oeko-Tex® Standard 1000 certification.

要成功实施环境管理制度，首先要完成三个前提条件：

For the successful implementation of an environmental management system three prerequisites exist.

- 创造企业需求
- 首先，进行环境检测，获取环境的当前情况。
- 制定必要的措施，设定环境目标和计划。
- 开始准备文件，手册以及实施程序。

- Creation of organisational requirements
- First environmental examination to gain knowledge of current state of environmental performance.
- Determination of necessary measures and elaboration of environmental goals and plans.
- Preparation of documentation, handbook and operating procedures.

### 2.1 环境管理制度

### 2.1 Environmental management system

企业在制定实施环境管理系统时，必须保证其业务所造成的结果要与已制定的环保政策拥有相同目标。

The enterprise must arrange and maintain an environmental management system in a form that the consequences of the activities of the organisation are in harmony with the determined environmental policy and the corresponding objectives and goals.

### 2.2 环保政策

### 2.2 Environmental policy

要引入或改进环境管理制度，首先要发布一个严格的管理声明。此声明中包含企业通过不同活动、生产线、产品和运营方面，对改善环境负有责任。

The first step into the introduction or improvement of an environmental management system is a declaration of the supreme management. This declaration contains a self-obligation for the improvement of the environmental performance of the enterprise in his activities, production, products and performances.

要明确环境政策，制定成文件

The environmental policy shall be defined and documented ensuring that it

- 企业活动，产品，服务以及环境影响息息相关。
- 包括承诺符合所有的相关规定
- 致力于阻止/减少环境的负面影响，促进可持续发展。

- is relevant to its activities, products and services, and their environmental effects;
- includes a commitment to meet all regulatory;
- is oriented towards the prevention/minimisation of adverse environmental effects, and towards sustainable development;

**2.3 公司和人事****2.3.1 授权环境专员**

企业必须委任一个专员，而专员拥有授权和责任保证完成环境管理制度的要求。

企业要制定内部检验程序，提供必要的人事培训。

**2.3.2 资格**

企业必须引入启动员工培训程序，确保信息能传递给各员工。

- 环境政策的重要性
- 其活动对环境造成的潜在影响。
- 改善运作对环境带来的好处。
- 从果断的程序变化得出的后果。

**2.3.3 对员工的宣传**

引入环境管理制度，环境政策，环境目标以及相应的企业结构都要通知员工。

**2.4 实施环境评估**

企业必须于活动、产品和运营方面制定出相关的环境保护程序以符合所有法规。

企业必须制定程序，检测评估活动、产品、以及运作对环境所造成的所有直接间接影响。

- 在正常的运营条件下
- 在非正常的运营条件下
- 意外或紧急情况下
- 过去，当下和将来的活动

**2.3 Organisation and personnel****2.3.1 Authorisation of an Environment Commissioner**

The enterprise must appoint a commissioner, who owns the authority and responsibility, to ensure, that the demands on the environmental management system are fulfilled.

The enterprise shall define the procedures for the internal verification and provide the necessary, trained personnel and the means.

**2.3.2 Qualification**

The enterprise shall introduce and maintain procedures for the training of the staff members, which ensure, that all staff members are informed about:

- the importance of the environmental policy
- potential consequences of their activity for the environment,
- advantages of improved performance for the environment,
- consequences of deviations from the determined procedures.

**2.3.3 Publication to Staff**

The introduction of an environmental management system, the environmental policy, the environment objectives as well as the resulting organisational structures are to make known to all staff members.

**2.4 Performing an environmental assessment**

The enterprise must have procedures for the registration of all legislative, regulatory and other policy requirements pertaining to the environmental aspects of the activities, products and performances.

The enterprise must have procedures for the examining and assessment of all direct and indirect influences of their activities, products and performances on the environment

- under regular operating conditions,
- under irregular operating conditions,
- at accidents and emergency situations
- as well as at past, running and future activities.



记录应该包含

- 向大气中排放的可控制和非可控制排放物
- 向水中排放的可控制和非可控制排放物
- 向陆地排放的可控制和非可控制排放物
- 固体以及其他废料
- 使用陆地，水源，燃料，能源以及其他自然资源
- 噪音，灰尘，臭味，振动和光源
- 对生态环境和特定的环境领域造成的后果

第一轮检测的结果要制定成文件，以被评估。

检测须包含及完全符合以下几点：

#### 2.4.1 法律

企业必须熟悉和理解有关生产场地的法规，政府条例及其他的要求，并确实执行。相关法规如下：

- 生产场地的特定工作（企业工厂授权，工作要求，...）
- 特定的产品和运作
- 对受影响的特定工业领域
- 或总体上对环境领域有法律效力的。

公司要制定相关国家的、当地的以及国际性的法律和法规清单。

必须指定一个员工（如环保专员）或指定一个外部的顾问，他必须了解这些法律法规，这样他至少可以决定是否需要应用环保条例于企业，及引入相关的措施。

#### 2.4.2 法律依据

收集保存所有能证明企业有法律依据，依法经营的文件。如果没必要对工厂进行授权时，法律的根据是非常重要的。

#### 2.4.3 运输和存储

企业的地面规划必须包含材料运输，储存及使用的区域。须注明如何完成最重要的结构问题。

The record shall contain

- controlled and uncontrolled emissions to the atmosphere
- controlled and uncontrolled emissions to water
- controlled and uncontrolled contamination of land
- solid and other wastes
- use of land, water, fuels, energy and other natural resources
- noise, dust, smell, vibration and light
- consequences for ecosystems and specific environment areas

The results of this first examination are to be documented and to be subjected to an appraisal.

The examination especially has to include and fulfil among other things the following points.

#### 2.4.1 Laws

The enterprise must know all legislative, governmental and other demands, which apply to the production site, have access to them and understand them. This affects regulations that are

- specific for the work at the production site (organisation- and plant authorisations, job demands, ...)
- specific for the products and performances
- specific for the affected industry field
- or valid generally for the environmental area.

A listing of the relevant national, local and international laws and ordinances available in the organisation is to be made.

A staff member (e.g. environmental protection commissioner) or an external consultant has to be named, which knows the content of these laws and ordinances at least in a way, that he can decide on the necessity of an application in the organisation and introduce suitable measures.

#### 2.4.2 Legal Existence

A collection of all documents, which found the legal existence and the lawful operation of the organisation, has to be kept. Also the legal basis is important, when no authorisation for the plants are necessary..

#### 2.4.3 Delivery and Storage

A plan of the organisation's terrain should contain areas, in which materials are delivered, stored and provided to the consumption. The most

另外, 要保存运输材料、运输地点、储存地点、消费地点以及相关资料的清单或数据库。

必须遵从运输和存储的法律文件。

储存危险气体的设施(见定义)必须保证不能让有害气体进入环境。只有指定受过特别训练的人员才可以移除这些化学物质。在生产上, 只能使用技术上要求的必须数量。所有应用于化学品的容器必须贴有相应的警告标示及紧急营救措施(以国际上通用的图标来标签。R-sentences and S-sentences)

如检测过程中发现产品可能对生态环境造成潜在威胁, 则要对此产品的原材料进行监督检查。

要对涉及环境方面的供货商进行评估。

#### 2.4.4 材料

要保留企业所使用的材料或准备材料清单或数据库。这些应该包括公司内部产品类别、正确化学产品类别、一般存储数量参考、包括顾及工作安全之余, 也要留意对环境所造成的影响(水源威胁, 可燃性, R S Sentence 工地密集性)。要对危险物质进行相应的分类。

对所有化学物质来说, 当前的安全数据手册是必要的。

#### 2.4.5 生产方式

保存一份包括现存生产单位名称, 机器使用年限(制造, 最初启动)的清单或数据库, 记录可能的生态危险和工作危险资料。

#### 2.4.6 能源

生产中的能源消耗是经济效率的一个中心议题, 也是一个重要的环境因素。

节约使用能源对无污染生产来说是必须的。

节约使用能量的第一步就是制定一个使用能量的特定单位或特定一个以生产过程特定单位平衡表, 找寻薄弱环节。

important structural completion are to be captured.

In addition a list or data base of delivered materials, the delivery place, the storage place and the consumption place as well as of the kind of the delivery and storage, has to be kept.

Legal instructions about delivery and storage have to be obeyed.

Storing facilities for dangerous chemicals (see definitions) have to be designed in such a way, that the chemicals can not get into the environment. The removal of chemicals is to make possible only to a limited, specially instructed category of persons. In the production area only the technically unavoidably necessary quantities are allowed. All containers with such chemicals must be furnished with the corresponding warning signs and first aid - measures (in form of the internationally acknowledged pictograms, R-sentences and S-sentences).

At the check of received goods potential ecological risks due to pollutants in the raw products are to be supervised.

An evaluation of the suppliers under environment aspects is to be accomplished.

#### 2.4.4 Materials

Lists or data bases of substances and preparations used in the organisation are to be kept. These should contain the companies internal product designation, the exact chemical designation and references to the average storage quantity. Possible environment threats and references to the work safety should be included (water threat, combustibility, R - and S - sentences, work place concentrations). Dangerous materials are to be classified accordingly.

For all chemicals current safety data sheets are necessary.

#### 2.4.5 Means of production

A list or data base is to be kept, containing existing production units with designation, the age of the machine (manufacture, initial start-up), statements about possible particular ecological risks and work dangers.

#### 2.4.6 Energy

The energy consumption in the production is an economic central issue and an important environment element.

A thrifty use of energy is imperative for a non-polluting production.

The first step to an economic energy use is an unit specific or process specific balance sheet of

每年的数量 — 必须申报各种单一能源的支出平衡, 当中包括生产过程用量是否恰当或更适合使用在大型生产模式, 如需要时, 亦须提供细节。

在单一的平衡表中要提及已经使用的节约能源的可能性。

只要环境允许, 尽量使用可替代能源, 特别是非化石能源, 可再生能源。

the inserted energy for the inquiry of weak points.

An annual quantities - and cost balance of the individual energy types is to be presented. Balances, which contain processed quantities, are to be recorded for suitable, larger production modules and to detail if required.

Already used energy savings possibilities are to mentioned in such single balance sheets.

The employment of energy alternatives, particularly non fossil, renewable energy sources should be, as far as they are ecologically unobjectionable, preferred.

#### 2.4.7 噪音

为了开发防止噪音污染源措施, 在企业以及个别工厂内部制定噪音地图以识别噪音来源。命名的地图必须要包含明显的单一噪音污染源, 实施减弱噪音污染的措施, 描述受影响工人的工作范围。

#### 2.4.7 Noise

For the development of noise prevention measures a noise map is to be prepared for the organisation terrain and its individual plants in case of existing noise sources. The named map has also to contain striking single sources of noise, already met noise decrease measures and job descriptions of affected workers.

#### 2.4.8 灰尘

为了杜绝灰尘来源, 灰尘覆盖图要明确所有的灰尘区域, 灰尘来源和灰尘类型。

#### 2.4.8 Dust

In case of dust sources a map of dust sources shall contain dusty areas, dust sources and the kind of dust.

#### 2.4.9 气体排放物

气体排放图上, 所有带有风管单一排放物源, 包括相应的烟窗高度和直径都要记录下来。要提供当前排放气体测量结果和有限价值。

#### 2.4.9 Gaseous Emissions

In an emission map all single emission sources with own ducts to the outside air, along with corresponding chimney height and diameter, are to be recorded. Reference to existing exhaust air measuring findings and limiting values should be given.

确认进一步的生产步骤, 不可控制源, 以及减少的排放物。

Furthermore production steps and sources of uncontrolled, inducted emissions should be identified.

#### 2.4.10 水源

在污水管道排放图上, 运送路线, 污水处理以及运输地点都要在整个企业图上记录下来。要标出转入公共运河的点以及/或者支流。

#### 2.4.10 Water

In a map of sewage plumbing the introduction places, the canal routes, the sewage treatment as well as the delivery place are to be recorded for the entire organisation terrain. The point of transfer to the public canal and/or stretch of water should be given.

在进程图表上, 引入地点以及水源类型 (地下水, 地表水, 循环水), 单独的进程步骤要记录下来。水源的运送地方要标签出来。

In a process diagram the introduction places along with kind of the water (groundwater, surface water, recycled water) for individual process steps are to be recorded. The water departures to canal should be marked on the map.

另外要准备水源移除和处理的费用结算。

In addition a cost balance is to be prepared for water removal and disposal.

#### 2.4.11 废弃物

要记录废弃物的种类、数量、来源、地点分布以及剩余材料记录。要准备清除和使用费用, 包括其他可能的或可替换的清除方式。在制定涉及到废弃物领域的所有措施时, 首先追求的是避免造成废弃物的策略。

#### 2.4.12 包装和运输

尽量少用包装。内部处理中要尽可能地避免使用单一途径的包装材料。

包装材料优先考虑可重复使用或可循环使用材料。

要记录包装材料的数量和地点分布。

#### 2.4.13 产品

运输产品时, 除了产品本身外, 必须要附加标有正确材料组成的文件。

要让消费者知道产品可能含有对人体造成伤害的潜在物质(人类生态), 通过适当的程序和化学物质挑选, 减低伤害。

#### 2.4.14 紧急情况应急措施

所有已发生的紧急事件都应该记录在案, 包括类型、范围、原因以及采取的措施。

对于防火问题, 须指派一个有能力的员工负责。防火计划包括火灾预防措施、警报、火灾防备以及雇用火灾部门人员, 公开信息。

确定灾难计划领域以及其中涉及的紧急事件会对环境造成后果。企业应采取危险情况的安全措施, 比如控制和保持安全设备的记录。

#### 2.4.15 工作场所和社会事件

遵从国家法律规定, 使工作人员远离危险不健康的化学物品。要将此危害减到最小化。

#### 2.4.11 Waste

About kind, quantity, form of creation and whereabouts of waste and remainder materials notes are to be led. A balance of the disposal costs and utilisation costs, including possible, alternative ways of disposal, is to be prepared. At all measures, which touch the area of waste, an avoidance strategy is to be pursued primarily.

#### 2.4.12 Packing and Transport

All packing should be undertaken only in the technically unavoidable extent. The use of one-way packaging material during the internal handling has, as far as possibly, to be avoided completely.

Packing systems, that are reusable or that are made of recycled material should be preferred.

Over quantity and whereabouts of the packing materials notes are to be led.

#### 2.4.13 Products

Delivered products have to contain at the product or in the accompanying papers the correct material composition.

The potential injurious consequences of desired and undesirable substances in the products to humans (human ecology) should be known and reduced through suitable selection of processes and chemicals.

#### 2.4.14 Emergency Precautions

All happened disturbances, should be documented with kind, extent, cause and measures.

For problems of fire protection a staff member is to be denominated and to be provided with competence. Fire protection plans with measures of burning prevention, alarming, the burning defence and the fire department employment are to be worked out and disclosed.

In a disaster plan areas are to be identified, in which disturbances can have environmental consequences. Organisational measures for the danger defence, like controls and maintenance of safety devices are to be documented.

#### 2.4.15 Working Places and Social Affairs

The national legal instructions for the protection of the working from dangerous and unhealthy chemicals are to be observed. The minimisation of the burden clear under such limits is to be striven for.

**2.4.16 教育和持续教育**

员工的环保意识要靠相应的教育措施来不断提高。教育可以给员工提供专业知识，有助于正确实施环保措施。

要对已完成的内外部教育措施记录在案。

**2.4.17 公共关系**

一般可理解的公共关系措施，公共关系会让所有利益相关的群体（员工、居民、环保团体、政府当局）了解运行的环境项目和措施。

对已完成的措施，要记录其类型和目标群。

**2.5 环保目标**

企业必须制定措施，明确相关的环保目标和派生目标。

企业必须写下其环保政策目标，在内部发行。企业需记录如何达成及取得已定政策的成果。

目标必须要超出法律的要求。要考虑所带来的环境影响和生产场地的商业要求。

目标必须要和环境政策相一致。

目标必须要尽可能地量化及有时间性的，以符合改善环境的承诺。

**2.6 环境管理**

制定详细的措施计划和责任。它们应该能够改善环境，完成环保目标。

制定有关达到环境要求的控制过程的文件。

记录已完成的环境管理程序所采用的措施。制定时间、地点、测量精度、设定点、以及不能完成任务的措施。

**2.4.16 Education and Continued Education**

The environmental awareness of the staff members is formed through corresponding education measures. Education mediates the specialised competence for the right implementation of environmental measures.

Over the accomplished internal and external education measures notes are to be led

**2.4.17 Public Relations**

As public relations measures are understood, which inform all interested circles (staff member, resident, environment associations, authorities) about operational environment projects and measures.

Over accomplished measures notes are to be led about kind and target group.

**2.5 Environmental objectives**

The enterprise must have procedures to specify environmental relevant objectives and derived goals.

The environmental goals of the enterprise have to be written down and published internally. The organisational measures, which were met, to achieve those goals, are to be documented.

The objectives and goals must exceed the fulfilment of the laws. The raised records of environment influences and the commercial demands of the production site are to be considered.

The objectives must be consistent with the environmental policy.

The objectives must present as far as possibly a quantitatively and time-fixed determined commitment for the constant improvement of the environment performance.

**2.6 Environmental management program**

Detailed measures with schedules and responsibilities have to be worked out. They should give improvement of the environment performance and approach the environmental goals.

Processes for the control of fulfilment regarding set environmental demands and their documentation have to be worked out.

There are to be led down the measurements to be accomplished for the examination of the fulfilment of the environmental management program. Time, place, measuring precision, set points and measures on non-fulfilment are to be set.

企业必须有特定的程序管理，新的开发项目包括：

- 要完成的环境管理目标
- 完成目标的机制
- 改变项目的程序
- 所采用的措施都应有纠正的方案，以确保能控制其合适性。

The enterprise must have special programs for the management of projects for new developments, which contain

- environmental objectives to be accomplished
- mechanisms for the accomplishment of the objectives,
- procedures for project changes
- correction measures along with measures to the controls of their appropriateness

## 2.7 环境管理手册

足够的文件说明执行环境保护及其措施对一个成功的环境管理制度来说尤其重要。

要想快速、系统地取得环境管理系统资料，就要准备一个环境管理手册。

手册必须包括环保政策，目标和程序。

手册必须规定关键人物和责任。

手册必须提供相关及足够的参考资料。

企业必须对要求凡的文件制定措施及控制，保证：

- 由授权员工作检查核实
- 可参考其功能或活动
- 与第一版中的拥有相同功能及已授权的员工进行常规检查和修改
- 存在于所有相关的场地，特别是对环境造成影响的活动。
- 预防使用过期的文件。
- 如经常变动则须重新发行。

在手册或文件中，企业除了考虑正常的情况外，也要考虑非正常的运作情况、事故和紧急事件、以及相应的环境特定信息和法规。

企业必须有记录系统，要证明与环境管理制度的要求一致。

记录必须清晰可辨认，可查阅与活动相关的产品。

企业必须有程序记录对企业内外部所造成的影响，有应对损伤损害的记录。

## 2.7 Environmental management manual

Sufficient documentation of performed actions and measures is an essential requirement for an successful environmental management system.

To achieve a quick and structured access to the elements of the environmental management system is to be prepared and maintained an environmental management manual.

This manual must assemble the environmental policy with objectives, goals and programs.

The manual must document key roles and responsibilities.

The manual must deliver sufficient references to the pertinent documentation.

The enterprise must have procedures for the control of the demanded documents, ensuring:

- review and approval by authorised staff members
- possibility to reference to function or activity
- regulars examination and revision through authorised staff member of equal function like at the first edition
- existence at all relevant places, particularly at activities with environmental impacts
- prevention of the use of outdated documents by means of removal.
- re-issuing after frequent changes

The enterprise must consider in the manual or documentation beside regular conditions also irregular operating conditions, accidents and emergency situations and contain corresponding environmental specific information and instructions.

The enterprise must have recording system, which proves the compliance with the demands on an environmental management system.

The records must be legible and referred to activities respectively products.

The enterprise must have procedures for the accessibility of the records to affected parties inside and outside the enterprise and take care against loss and damage of records.

确定好并记录存储的期限。在使用 Oeko-Tex® 标签期间，文件必须保存最少五年。

The duration of the storage is to be determined and documented. The documents to be kept for the duration of the use of the Oeko-Tex® mark, however at least 5 years.

## 2.8 运作控制

## 2.8 Operational control

### 2.8.1 总述

明确各级的责任，保证合作协调，有效率。

### 2.8.1 General

Responsibilities shall be defined at all levels to ensure co-ordination and efficient performance.

### 2.8.2 控制

企业必须明确这些对环境造成影响的功能、活动或过程，以及其相关的环境政策。企业要保证这些政策在接受监督下执行。

### 2.8.2 Control

The enterprise must identify those functions, activities and processes having environmental consequences and are relevant for the environmental policy. The enterprise must plan them in such a way that they are executed under checked conditions.

必须达到这些要求：

To achieve this requires:

- 纪录根据环保政策内公司员工有关活动的工作指引：
- 处理采购和合同活动的程序，保证与政策要求一致。
- 监督控制相关的过程特征（废水，废弃物处理）
- 批准已计划的过程和设备
- 以书面文件的形式写下运作标准。

- Documented work instructions for activities with reference to the environmental policy for own personnel and such, acting on its behalf.
- procedures dealing with procurement and contracted activities, which ensure compliance with policy requirements.
- supervision and control of relevant process characteristics (effluent streams, waste disposal)
- approval of planned processed and equipment
- establishment of performance criteria in written documents.

### 2.8.3 验证、测量和检测

企业必须制定程序，按照特定的要求进行验证，并且记录保存这些结果。对任何一个相关的活动或领域来说，企业都要在文件内详述。

### 2.8.3 Verification, measurement and testing

The organisation must have procedures for verification of compliance with specified requirements and for establishing and maintaining records of the results. For each relevant activity or area, the organisation shall specify and document:

- 保存验证信息
- 要使用的验证程序
- 正确的标准和否定结果的应对措施
- 对已验证的失误事件再评估其有效性

- the verification information to be obtained;
- the verification procedures to be used;
- criteria for positive and measures for negative results
- evaluation of the validity of previous verification information on malfunctioning.

### 2.8.4 不合规规定及改正举动

企业必须明确责任，授权引进此程序，调查和改正不符合要求的规定。管理功能负责相关的行为，管理代表必须：

### 2.8.4 Non-compliance and corrective action

The enterprise must define, at determined responsibility and authority for the introduction of such, procedures for the investigation and correction for non-compliance with defined demands. The management function responsible

- 明确原因
  - 决定是否要修订已成文件的程序
  - 根据遇到的相关风险，制定行动计划
  - 有效控制预防性的行动
  - 记录所有由正确行动所导致的任何程序的改变
  - 记录所发生的不合规的情况，以及随之环境管理系统的任何决定和任何改变。
- for the concerned action along with the management representative must
  - determine the cause;
  - decide whether documented procedures should be amended;
  - draw up a plan of action corresponding to the risks encountered
  - apply effective controls for preventive actions
  - record any changes in procedures resulting from corrective action;
  - record the occurrence of the non-compliance, the following decisions and any changes to the environmental management system.

## 2.9 环境管理审计

企业必须要有程序，尤其审计计划：

- 决定环境管理制度的合适性
- 根据环境管理制度和有效实施情况，检测环境管理行为
- 检测在实施环境政策的过程中，环境管理制度的有效性。

审计计划必须包含特定的活动，领域以及地点，涉及到：

- 组织结构
- 行政和运作程序
- 工作领域、运作和程序
- 文件、报告和记录
- 环境表现

考虑到环境的相关性和之前的审计结果，审计计划必须明确个体活动的审计频率。

审计计划必须针对相关领域的执行措施订明责任制。

审计计划必须明确人事资格能够从事审计，即：

- 审计尽量作为一项独立的活动
- 对相关领域要经验丰富
- 如有需要，可寻求专家的支持

审计计划必须明确记录审计实施情况

审计计划必须明确报告审计结果的程序。

## 2.9 Environmental Management Audit

The enterprise must have procedures particularly an audit plan for the

- determination of the suitability of the environmental management system
- Examination of environmental management activities in reference to the environmental management system and their effective implementation
- Examination of the efficiency of the environmental management system in fulfilling the environmental policy.

The audit plan must contain the specific activities, areas and locations with regard to

- organisational structures
- administrative and operational procedures
- work areas, operations and processes
- documentation, reports and records
- environmental performance

The audit plan must define the audit frequency for individual activities and areas considering of the environmental relevance and the results of earlier audits.

The audit plan must define the responsibility for the implementation in the respective areas.

The audit plan must define the qualification of the personnel, that performs the audit, that it is

- as independent of the activities under audit as far as possible
- is experienced in the respective field
- is supported, if required, by specialists

The audit plan must define the record for the implementation of the audit.

The audit plan must define procedures for the reporting of the audit result.



**2.10 外部交流**

企业必须设立机制与相关环境团体交流业内的环保政策、执行等问题。

企业必须每隔一段时间就公开发行人环境报告。

根据上次报告结果，重新的环境报告必须展示一个正确真实的环境情况，包括

- 活动、生产过程、产品和服务
- 环境管理制度的大体框架，环境政策和环境目标。
- 环境表现，特别是环境目标

环境报告必须包括记录、程序、手册以及其他的环境管理系统文件。

环境报告必须基于环境管理系统审计检测评估的基础上而建立。

环境报告必须包含企业的全称和完整地址。

环境报告必须包含地点、活动、产品和服务的描述。

报告必须指出评估的基础。

**2.10 External communication**

The organisation must have procedures to communicate with interested parties on matters related to its environmental management policy, performance and effects.

The enterprise must prepare and make publicly available an environmental report in regular intervals

The environmental report must give a true and correct picture for the time since the last report of

- the activities, production processes, products and services;
- the main outline environmental management system, the environmental policy and its environmental objectives;
- the environmental performance, with particular regard to its environmental objectives.

The environmental report must rest on the records, programs, manuals and other documentation of the environmental management system.

The environmental report must rest on the appraisal of the efficiency of the environmental management system through audits and reviews.

The environmental report must contain the full name and the full address of the enterprise.

The environmental report must contain the description of the locations, activities, products and services it refers to.

The report must indicate the bases, on which it is prepared.

**附录 / Appendix 2****其他****Various****生产场地的标签**

符合 Oeko-Tex® 标准 1000, A 部分的生产场地可以悬挂以下标签。标签使用必须清晰可见 (例如信纸、官方文件、展会宣传以及其他用途)。该标签只能用于生产场地, 产品不得使用该标签。

**Marking of Production Sites**

Production sites fulfilling the requirements of the Oeko-Tex® Standard 1000, Part A, and correspondingly certified, can be marked with the following label. The direct connection of the label with the production site must clearly appear (e.g. on letter papers, official documents, exhibition stands, on the enterprise areas etc.). The label can only be used for production sites and not for products.

**产品标签**

符合 Oeko-Tex® 标准 1000 B 部分的产品能够悬挂以下标签。该标签只能用于已获得 Oeko-Tex® 标准 100 的产品上。

**Product marking**

Products fulfilling the requirements of the Oeko-Tex® Standard 1000, Part B, and correspondingly certified, can be marked with the following label. This label can only be used on products that have already been certified according to Oeko-Tex® Standard 100.



**Oeko-Tex® 国际环保纺织协会成员**

目前, 以下成员属于国际环保纺织协会, 专为评估对环境友好的纺织品:

**Members of Oeko-Tex® International**

At present the following members belong to Oeko-Tex® International, Association for the Assessment of Environmentally Friendly Textiles:

<b>AR</b>	<b>CITEVE Argentina</b> Av. Córdoba 612, 5° P. "A" - (C1054AAS), Ciudad de Buenos Aires, Argentina
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<b>AU</b>	<b>TESTEX Swiss Textile-Testing Ltd.</b> Level 19, 644 Chapel Street, VIC 3141 South Yarra, Australia
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**秘书处**

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**Secretariat**

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