

वस्त्रादि — जूट कैनवास डाक बैग —
विशिष्टि
(पहला पुनरीक्षण)

Textiles — Jute Canvas Postal
Bags — Specification
(First Revision)

ICS 55.080, 59.060;67.060

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FOREWORD

This Indian Standard (First Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by the Jute and Jute Products Sectional Committee had been approved by the Textiles Division Council.

This standard was originally published in 1984. The first revision has been made in the light of experience gained since its publication and to incorporate the following major changes:

- a) BIS certification marking has been updated;
- b) Sampling clause has been updated; and
- c) References to Indian standard have been updated.

The composition of the Committee responsible for the formulation of this standard is given in Annex A.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 2022 'Rules for rounding off numerical values (*second revision*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

Indian Standard

**TEXTILES — JUTE CANVAS POSTAL BAGS —
SPECIFICATION**

(*First Revision*)

1 SCOPE

This standard prescribes the constructional details and other requirements of four sizes of jute canvas postal bags, proofed and unproofed.

2 REFERENCES

The standards given below contain provisions which, through reference in this text, constitute provisions of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent editions of these standards:

<i>IS No.</i>	<i>Title</i>
IS 1670 : 1991	Textile — Yarn — Determination of breaking load and elongation at break of single strand (<i>second revision</i>)
IS 1720 : 1978	Specification for cotton sewing threads (<i>first revision</i>)
IS 10036	Specification for jute canvas:
Part 1 : 1982	General requirements
Part 2 : 1982	Fine, 660 g/m ²

3 MANUFACTURE

3.1 Fabric

The bags shall be made out of jute canvas, proofed or unproofed, conforming to IS 10036 (Part 2).

3.1.1 Cotton Sewing Thread

Cotton sewing thread used for stitching shall be 27 tex × 9 tex and shall conform to the variety no. 35 of IS 1720. Alternatively, flax threads of 165 tex × 3 tex having a minimum breaking load of 8 kgf when tested as per IS 1670 shall be used.

3.1.2 Rim Cord

Jute cord of about 22 mm circumference made of 4 strands, each strand of minimum 2 ply, should be used for the rim cord.

3.1.3 Iron Loops

Iron loops of 3.7 mm ± 0.1 mm diameter galvanized iron wire shall be used. The details of the dimensions and the makeup shall be as shown in Fig. 1. The ends of the iron loops shall be butt jointed and welded. Lap joints with minimum overlapping of 15 mm and welded at both the cut edges soldered on the entire overlapped portion may also be used. For lap-jointed iron loops, the cut edges shall be properly finished to avoid cutting actions.

3.1.4 Tabs for Fixing Iron Loops

The tabs shall be made from jute canvas proofed/unproofed fabric for the fabrication of the bags. The tabs shall be made of two folds of canvas length with a turn-in of 15 mm at both sides and having a finished width of 35 mm. The position and the finished length of the tabs at each side of the bags shall be as shown in Fig. 1 and shall be 90 mm, *Min.*

3.1.5 Whip Cord

Whip cord of 5 ply cotton twine 1 000 × 5 d tex conforming to variety no. 26 of IS 1720 shall be used.

3.2 Construction

3.2.1 Shape and Construction

The shape and construction of the bags shall be as shown in Fig. 1.

3.2.2 Bags of size no. 1 and 2 shall be made of three pieces of canvas, two for the sides and the other one for the bottom. The bottom piece shall be of square or rectangular shape. The perimeter of the base of bags of both the sizes shall be 172 cm, *Min.* In both the sizes, the length of the bags 'B' (that is, the height), shall be in the warp direction of the fabric.

3.2.3 Bags of size no. 3 and 4 shall also be made of two pieces of canvas, one for the sides and the other for the bottom, which shall be of square shape. The perimeter of the base of the fabric of both the sizes shall be 142 cm, *Min.* In both the sizes, the length of the bags, that is, the height 'B' of the bag may be in warp or weft direction of the fabric.

3.2.4 Fixing of Bottom Piece

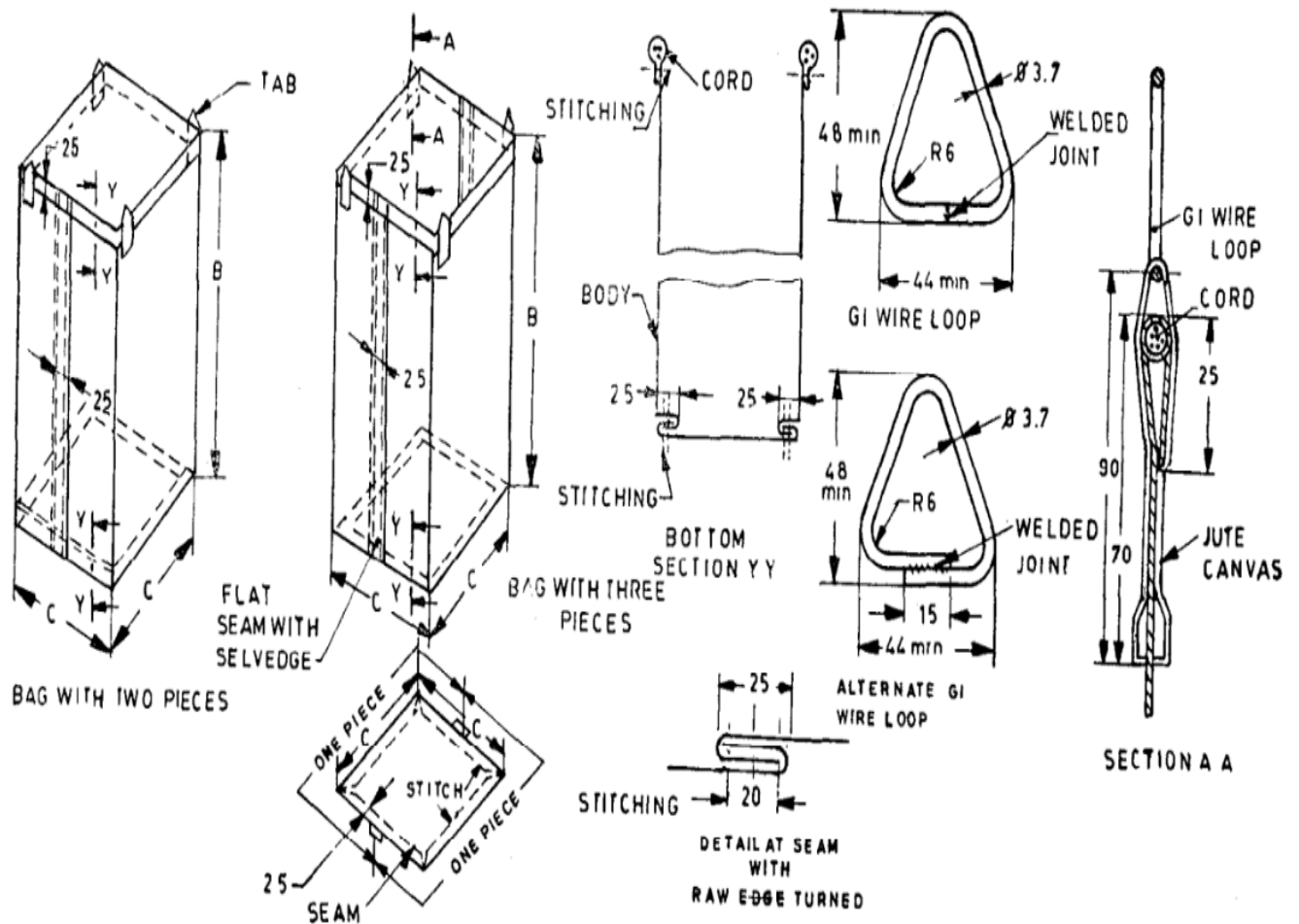
The bottom piece for all the sizes of bags shall be joined with the sides and the inside of the bags to prevent fraying. The two pieces shall be jointed with two rows of stitches. The first row of stitches shall not be visible from outside the bags after joining. The second row of the stitches shall be put at a distance of not less than 25 mm away from the first row of stitches, over a turn of 13 mm, *Min* of the side pieces. The bottom piece shall remain up to the edge of the turn-in so that the second row of stitches falls over 4 layers of canvas, for example, two layers of bottom piece, one layer of side piece and the turn-in of the side piece. All the four corners of the bottom piece shall be stitched in continuation of the second row of stitches as shown in Fig. 1.

3.2.5 Fixing of Rim Cord

The jute rim cord as specified in 3.1.2 is to be fixed inside the top hemming. It shall be in one length only. The rim cord shall be neatly tied with an overlap of 50 mm of the two ends and whipped properly with cord as specified in 3.1.5 before being placed inside the rim. Alternatively, the ends may be whipped and then stitched with the body of the bag with minimum three rows of stitches.

3.2.6 Fixing of Iron Loops

Four iron loops according to 3.1.3 shall be fixed with tabs. The ends of the tab shall be turned-in to a depth of 13 mm, *Min* and sewn with the sides with the position of the loops opposite to each other as shown in Fig. 1.



All dimensions in millimetres.

FIG. 1 JUTE CANVAS MAIL BAG

3.2.7 Seam

The sides of the postal bags shall be machine stitched with an overlapping of 25 mm, *Min* and with two rows of stitches, approx 20 mm apart. In case of any raw edge, the same shall be turned to a depth of 13 mm, *Min* and then stitched with an overlapping of 25 mm, *Min*. The stitches should be of uniform tension throughout with all the loose ends securely fastened. The number of stitches per dm shall be not less than 24.

3.2.8 Hemming

The top of the bags shall be hemmed to a depth of 25 mm, *Min* with a turning on the outside of the bag and the raw edge, if any, are to be initially turned into a depth of 13 mm, *Min*. The stitches shall not be less than 3 mm away from the edge of the turning.

3.2.9 Stitches other than Seam

The stitching shall be done by machine. The stitches should be of uniform tension throughout with all the loose ends securely fastened. The number of stitches per dm shall be not less than 24.

4 REQUIREMENTS

4.1 The bags shall conform to the manufacturing particulars given in **3**.

4.2 The dimensions and tolerances of the bags shall be as given in Table 1.

4.3 The bags should be free from sewing and other fabrication defects.

5 MARKING

5.1 The marking on the bags shall be as required by the buyer and it shall be done neatly by using indelible ink on both the sides of the bags.

5.2 BIS Certification Marking

The product(s) conforming to the requirements of this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act, 2016* and the Rules and Regulations framed thereunder, and the product may be marked with the Standard Mark.

6 PACKING

The bags shall be packed as agreed to between the buyer and the seller.

7 SAMPLING

7.1 The quantity of postal bags of same designation delivered to a buyer against a dispatch note shall constitute a lot.

7.2 The conformity of the lot shall be determined on the basis of the tests carried out on the samples selected from it.

7.3 Unless otherwise agreed to between the buyer and the seller, the number of bags to be selected from a lot shall be according to col (1) and (2) of Table 2.

7.4 The number of bags selected according to **7.3** shall be examined for all the manufacturing details as per clause **3** and also the requirements as given in **4**.

7.5 Criteria for Conformity

The lot shall be declared as conforming to the requirements of the specification if the following condition is satisfied:

The number of bags found not in conformity with the requirements for anyone or more of the characteristics mentioned in **7.4** is less than or equal to the corresponding number given in col (3) of Table 2.

Table 1 Dimensions and Tolerances of Postal Bags*(Clauses 4.2)*

SI No.	Size No.	Height 'B'	Base	
			Length 'C'	Width 'C'
		<i>Min</i> mm	mm	mm
(1)	(2)	(3)	(4)	(5)
i)	1	1 220	430 or 385	430 480
ii)	2	1 070	430 or 385	430 480
iii)	3	810	355	355
iv)	4	710	355	355
v)	Tolerance		± 10 mm	± 10 mm

Table 2 Sample Size and Permissible Number of Non-conforming Bags*(Clause 7)*

SI No.	Lot Size	Sample Size	Permissible No. or Non-conforming Bags
(1)	(2)	(3)	(4)
i)	Up to 100	13	1
ii)	101 to 150	20	2
iii)	151 to 300	32	3
iv)	301 to 500	50	5
v)	501 to 1 000	80	7
vi)	1 001 to 3 000	125	10
vii)	3 001 and above	200	14

ANNEX E

(Foreword)

COMMITTEE COMPOSITION

Jute and Jute Products Sectional Committee, TXD 03

<i>Organization</i>	<i>Representative(s)</i>
Office of Jute Commissioner, Kolkata	SHRI MOLOY CHANDAN CHAKRABORTHY, IDAS (Chairperson)
Caledonian Jute & Industries Limited, Kolkata	SHRI PANKAJ KUMAR CHATTERJEE
CSIR - Indian Institute of Toxicology Research, Lucknow	DR V. P. SHARMA
Department of Jute & Fibre Technology, Institute of Jute Technology	PROF A. CHOUDHURY PROF S. K. GHOSH (<i>Alternate</i>)
Eskaps (India) Private Limited, Kolkata	SHRI SATYAJIT CHAKRABORTY SHRI LABA KUMAR DAS (<i>Alternate</i>)
Food Corporation of India, New Delhi	DR RAJESH GULIA SHRIMATI VEMULA SRIDEVI (<i>Alternate</i>)
Food, Civil Supplies & Consumer Protection Department, Govt of Chhattisgarh	SHRI SANTOSH KUMAR PATHAK
Food, Civil Supplies & Consumer Protection Department, Govt of Punjab, Chandigarh	SHRI GHANSHYAM THORI DR ANJUMAN BHASKER (<i>Alternate</i>)
Food Supplies & Consumer Welfare, Govt of Orissa, Bhubaneswar	SHRI SOMEN NAYAK
Gloster Limited, Kolkata	SHRI TANMOY SINGHA
Hukumchand Jute Mills, Kolkata	SHRI R. K. SRIVASTAV SHRI BIJAN SARKAR (<i>Alternate</i>)
ICAR-Central Research Institute for Jute and Allied Fibers (CRIJAF), Kolkata	DR GOURANGA KAR
ICAR - National Institute of Natural Fibre Engineering and Technology (NINFET), Kolkata	DR SURAJIT SENGUPTA SHRI MANIK BHOWMICK (<i>Alternate</i>)
Indian Jute Industries Research Association, Kolkata	SHRI PARTHA SANYAL SHRIMATI SOUMITA CHOWDHURY (<i>Alternate</i>)
Indian Jute Mills Association, Kolkata	SHRI S. K. CHANDRA SHRI J. K. BEHERA (<i>Alternate I</i>) SHRI BHUDIPTA SAHA (<i>Alternate II</i>)
Indian Sugar Mills Association, New Delhi	SHRI GIRISH KUMAR THAKUR SHRI DEEP MALIK (<i>Alternate</i>)
Ministry of Consumer Affairs, Food & Public Distribution, New Delhi	SHRI VISHWAJEET HALDER SHRI RAKESH KUMAR MEENA (<i>Alternate</i>)

<i>Organization</i>	<i>Representative(s)</i>
Murlidhar Ratanlal Exports, Kolkata	SHRI AVIJIT DAS
National Agricultural Cooperative	SHRIMATI ANINDITA GUHA
National Jute Board, Kolkata	SHRI MAHADEB DUTTA
National Jute Manufacturers Corporation Limited Kolkata	SHRI I. A. MONDAL
Office of the Jute Commissioner, Kolkata	SHRI SOUMYADIPTA DATTA
SGS India, Gurgaon	SHRI SHAILESH SHARMA SHRI BHASKER SEN (<i>Alternate</i>)
The Jute Corporation of India Limited, Kolkata	SHRI KALYAN MAJUMDAR SHRI A. MAJUMDAR (<i>Alternate</i>)
West Bengal Pollution Control Board, Kolkata	SHRI SUBRATA GHOSH SHRI QAZI HASAN (<i>Alternate</i>)
BIS Directorate General	SHRI J. K. GUPTA, SCIENTIST 'E'/DIRECTOR AND HEAD (TEXTILES) [REPRESENTING DIRECTOR GENERAL (<i>Ex-officio</i>)]

Member Secretary
SHRI DHARMBEER
SCIENTIST 'D'/JOINT DIRECTOR
(TEXTILES), BIS

Bureau of Indian Standards

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Amendments Issued Since Publication

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