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वस्त्रादि — मशीनरी कपड़े, ऊन — विशिष्टि  
भाग 5 लैपिंग कपड़ा  
( पहला पुनरीक्षण )

**Textiles — Machinery Fabrics, Wool  
— Specification  
Part 5 Lapping Cloth  
( First Revision )**

ICS 59.080.30

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## FOREWORD

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

This standard was first published in 1976. The present revision has been made in the light of experience gained since its publication and to incorporate the following major changes:

- a) Title of the standard has been modified; and
- b) References to Indian Standards have been updated.

Lapping cloth is a twill woven fabric made of wool fibres only or blends of wool with natural or man-made fibres. Lapping cloth is used mainly in industrial upholstery.

This series of standards on machinery fabrics is published in the following parts:

- Part 1 General
- Part 2 Clearer cloth
- Part 3 Sizing flannel
- Part 4 Plaiding cloth
- Part 5 Lapping cloth

Part 1 covers the general requirements and other particulars regarding marking, packaging, sampling and criteria for conformity of machinery fabrics.

The composition of the committee responsible for the formulation of this standard is listed in Annex B.

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 —MACHINERY FABRICS, WOOL —**  
**SPECIFICATION**

**PART 5 LAPPING CLOTH**  
*( First Revision )*

**1 SCOPE**

This standard (Part 5) prescribes the manufacturing particulars and other requirements of lapping cloth.

**2 REFERENCES**

The standards listed in Annex A 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.

**3 MANUFACTURING PARTICULARS**

The manufacturing particulars of lapping cloth are given in Table 1.

**Table 1 Manufacturing Particulars of Lapping Cloth**  
*(Clause 3)*

SI No. (1)	Particulars (2)	Requirements (3)	Methods of Test (4)
i)	Composition of yarn		IS 7610 (Part 1)
	a) Warp	All wool or blends of wool with synthetic fibres/flax containing wool content of not less than 80 percent.	
	b) Weft	All wool or blends of wool with synthetic fibres/flax containing wool content of not less than 80 percent.	
ii)	Nominal count of basic yarn (Warp and weft)	80 to 250 tex (Nm 4 to 12.5)	IS 1315
iii)	Threads per dm		IS 1963
	a) Ends	150 to 250	
	b) Picks	125 to 175	
iv)	Weave	Plain or twill	Visual
v)	Type of finish	Milled/raised	-

NOTE — The constructional particulars of cloth are left to the choice of the manufacturer subject to the range specified for counts of yarn and number of ends and picks.

**Table 2 Requirements of Lapping Cloth**  
(Clause 4)

SI No.	Characteristic	Requirement	Method of Test
(1)	(2)	(3)	(4)
i)	Mass, g/m <sup>2</sup> <i>Tolerance</i>	500 to 800 ± 5 percent on the specified value	IS 1964
ii)	Breaking strength on 5 cm x 20 cm IS 1969 (Part 1) strips N (kgf), <i>Min</i>		
	a) For fabrics made of wool or blends containing at least 80 percent of wool fibres in warp yarn		
	1) Warpway	1725 (176)	
	2) Weftway	975 (99.5)	
	b) Other fabrics		
	1) Warpway	3925 (400.4)	
	2) Weftway	975 (99.5)	
ii)	Length, m, <i>Min</i>	25 or as agreed between buyer and seller	IS 1954
iii)	Width, cm	137, 160 or as between buyer and seller	IS 1954
	<i>Tolerance</i>	± 2.5 cm	

**ANNEX A**  
(Clause 2)

**LIST OF REFERRED STANDARDS**

<i>IS No.</i>	<i>Title</i>	<i>IS No.</i>	<i>Title</i>
IS 1315 : 1977	Method for determination of linear density of yarns spun on cotton system ( <i>first revision</i> )		per unit length and mass per unit area of fabrics ( <i>second revision</i> )
IS 1954 : 1990	Determination of length and width of woven fabrics — Methods ( <i>second revision</i> )	IS 7610 (Part 1) : 2022	Textiles — Machinery fabrics, wool — Specification: Part 1 General ( <i>first revision</i> )
IS 1963 : 1981	Methods for determination of threads per unit length in woven fabrics ( <i>second revision</i> )	IS 1969 (Part 1) :2018/ISO 13934-1 : 2013	Textiles — Tensile properties of fabrics: Part 1 Determination of maximum force and elongation at maximum force using the strip method ( <i>fourth revision</i> )
IS 1964 : 2001	Textiles — Methods for determination of mass		

**ANNEX B**

(Foreword)

**COMMITTEE COMPOSITION**

Technical Textiles for Industrial Fabrics Sectional Committee, TXD 33

<i>Organization</i>	<i>Representative(s)</i>
PSG College of Technology, Coimbatore	DR G. THILAGAVATHI ( <i>Chairperson</i> )
Ahmedabad Textile Research Association, Ahmedabad	SHRIMATI DEEPALI PLAWAT SHRI JIGAR DAVE ( <i>Alternate</i> )
Central Coir Research Institute, Alappuzha	DR ANITA JACOB SHRIMATI SUMI SABESTIAN ( <i>Alternate</i> )
DKTE Centre of Excellence in Non wovens, Kolhapur	SHRI ANIKET SBHUTE
Director General of Quality Assurance, Mumbai	SHRI PURUSOTTAM DE
Entermonde Polycoaters Ltd, Nashik	DR K. M. S. REDDY SHRI AJEY GODBOLE ( <i>Alternate</i> )
Garware Technical Fibres Ltd, Pune	SHRI S. J. CHITNIS SHRI RAJENDRA GHADGE ( <i>Alternate</i> )
ICAR- National Institute of Natural Fibre Engineering and Technology, Kolkata	DR MANIK BHOWMICK DR SANJOY DEBNATH ( <i>Alternate</i> )
Indian Technical Textile Association, Mumbai	DR ANUP RAKSHIT SHRIMATI RUCHITA GUPTA ( <i>Alternate</i> )
Kirti Filtration and Automation Pvt Ltd, Vadodara	SHRI KULIN MASTURLAL SHRIMATI KIRTI MASTURLAL ( <i>Alternate</i> )
Kusumgar Corporates Pvt Ltd, Mumbai	SHRI Y. K. KUSUMGAR DR M. K. TALUKDAR ( <i>Alternate</i> )
Masturlal Pvt Ltd, Mumbai	SHRI SHRAMIK MASTURLAL
Office of the Textile Commissioner, Mumbai	SHRI NAROTTAM KUMAR SHRI AMAR K. CHAPHPEKAR ( <i>Alternate</i> )
Ordnance Equipment Factory, Kanpur	SHRI V. K. CHOUDHARY
Pacific Harish Industries Ltd, Mumbai	SHRI MUNJAL UDESHI SHRI S. VENKATESH ( <i>Alternate</i> )
Patel Polypack, Ahmedabad	SHRI KALPESH PATEL
Plast India Foundation, Mumbai	SHRI SURENDER CHOUDHARY DR E. SUNDARESAN ( <i>Alternate</i> )
PSG College of Technology, Coimbatore	SHRI V. MUTHUKUMAR
Reliance Industries Ltd, Navi Mumbai	SHRI MAHESH C SHARMA SHRI RAJENDREN SUBRAMANIAN ( <i>Alternate</i> )
Salva Laminates Ltd, Vapi	SHRI NIMESH SALVA

<i>Organization</i>	<i>Representative(s)</i>
SRF Ltd, Gurugram	SHRI A. R. RAJESH SHRIMATI ANGELINA DIVYA ( <i>Alternate</i> )
Textiles Committee, Mumbai	SHRI J. D. BARMAN SHRI GANESH P. BANGAR ( <i>Alternate</i> )
The Bombay Textile Research Association, Mumbai	DR PRASANTA KUMAR PANDA DR SREE KUMAR ( <i>Alternate</i> )
The Synthetic and Art Silk Mills Research Association, Mumbai	DR MANISHA MATHUR SHRIMATI ASHWINI SUDAM ( <i>Alternate</i> )
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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 'C'/DEPUTY DIRECTOR  
(TEXTILES), BIS







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### Amendments Issued Since Publication

Amend No.	Date of Issue	Text Affected

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