

वस्त्रादि — हथकरघा सूती क्रेप — विशिष्टि
(दूसरा पुनरीक्षण)

**Textiles — Handloom Cotton
Crepe — Specification**
(*Second Revision*)

ICS 59.080.30

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FOREWORD

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

Handloom cotton crepe is known for its lightweight and breathable texture, making it a popular choice for summer clothing and bandages.

The cloth covered by this standard is woven in plain weave with high twisted cotton yarn having twist multiplier around 8.25. The twist in warp and weft yarn shall be in the same direction. The cloth develops the crepe effect on processing it in caustic soda.

This standard was first published in 1957 and was subsequently revised in 1978. The standard has been revised to incorporate the following changes:

- a) Test method for identification of material has been incorporated;
- b) Marking clause has been modified;
- c) References to standards have been updated; and
- d) Sampling plan has been modified.

The composition of the Committee responsible for the formulation of this standard is given 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 — HANDLOOM COTTON CREPE —
SPECIFICATION**

(*Second Revision*)

1 SCOPE

1.1 This standard prescribes the constructional particulars and other requirements of three varieties of handloom cotton crepe, bleached, dyed, printed, striped or checked.

1.2 This standard does not specify the general appearance, feel, shade, finish, etc, of the cloth (*see* [4.3](#)).

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 edition of these standards.

3 MANUFACTURE

3.1 Yarn

The cotton yarn used in the manufacture of crepe shall be satisfactory in evenness and reasonably free from neps and spinning defects. The yarn shall be

highly twisted having twist multiplier of around 8.25.

3.2 Cloth

The cloth shall be woven in plain weave and shall be free from dressing and filling materials and from substances liable to cause subsequent tendering.

4 REQUIREMENTS

4.1 The constructional particulars of cloth shall conform to those given in [Table 1](#). The loomstate particulars, that is, ends and picks in the loomstate are also given in the table.

4.2 The colour fastness ratings and other requirements of the cloth shall conform to those given in [Table 2](#).

4.3 If in order to illustrate or specify the indeterminable characteristics, such as general appearance, lustre, feel and shade of the cloth, a sample has been agreed upon and sealed, the supply shall be in conformity with the sample in such respects. The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

Table 1 Constructional Particulars of Handloom Cotton Crepe

(Clause [4.1](#))

Sl No.	Variety No.	Count of Yarn Cotton Count (Universal Count)		Processed Cloth		Loomstate Cloth		Length m	Width cm
		Warp	Weft	Ends /cm	Picks/cm	Ends /cm	Picks/cm		
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)	(10)
i)	1	20s (30 tex)	20s (30 tex)	16	18	15	17	40 or as agreed	71, 102 or as agreed
ii)	2	40s (14.5 tex)	40s (14.5 tex)	24	29	23	27		
iii)	3	60s (10 tex)	60s (10 tex)	34	29	32	27		
Tolerance, Percent	-	± 5	± 5	± 5	± 5	± 5	± 5	—	± 2
Method of Test, Ref to	-	IS 3442		IS 1963		IS 1954			
NOTE — In case of crepe fabrics woven in rib, check or stripes, the number of ends and picks may vary due to the use of coarse yarn along with high twisted yarn.									

Table 2 Requirements of Handloom Cotton Crepe

(Clause 4.2)

SI No.	Characteristic	Requirement	Method of Test, Ref to
(1)	(2)	(3)	(4)
i)	Colour fastness to:		
	a) Light	5 or better	IS/ISO 105-B01 or IS/ISO 105-B02
	b) Washing Test 3	4 or better	IS/ISO 105-C10
ii)	Dimensional change, percent, <i>Max</i>	4.0	IS 2977
iii)	Scouring loss, percent, <i>Max</i>	2.5	IS 1383
iv)	pH value of aqueous extract	6.0 to 8.5	IS 1390
v)	Fibre identification	100 percent cotton	IS 667

5 INSPECTION

5.1 A reference may be made to IS 14466 for details of these defects. The cloth when visually inspected shall be reasonably free from the following defects:

- a) Weft crack of more than two missing picks across the width of the material;
- b) Prominently noticeable weft bar due to the difference in raw material, count, twist, lustre, colour, shade or pick spacing of adjacent groups of weft yarn;
- c) More than two adjacent ends running parallel, broken or missing and extending beyond 15 cm;
- d) Prominent selvage defects;
- e) Noticeable warp or weft float;
- f) Noticeable oil or other stains;
- g) Noticeable hole, cut or tear up to 3 mm in size;
- h) Smash rupturing the texture of the fabric; and
- j) Prominently noticeable printing or dyeing defect.

6 SAMPLING**6.1 Lot**

The quantity of handloom cotton crepe of the same

variety, width and colour delivered to a buyer at a time shall constitute a lot.

6.2 To ascertain the conformity of the lot to the requirements of this standard, sample shall be drawn and inspected from each lot separately.

6.3 The number of pieces to be selected at random for inspection shall be in accordance with [Table 3](#).

6.4 Number of Tests and Criteria for Conformity

Sl No.	Characteristic(s)	Number of Tests	Criteria for Conformity
(1)	(2)	(3)	(4)
i)	Visual inspection, ends, picks, count, length and width	According to col (3) of Table 3	Number of non-conforming pieces shall not exceed the corresponding number given in col (4) of Table 3
ii)	Dimensional change, colour fastness, fibre identification, pH value and scouring loss	According to col (5) of Table 3	All the pieces shall meet the requirement

Table 3 Sample Size and Permissible Number of Non-Conforming Pieces

(Clause 6.3)

Sl No.	Lot Size	Sample Size	Permissible No. of Non-conforming Pieces	Sub Sample Size
(1)	(2)	(3)	(4)	(5)
i)	Up to 90	5	0	3
ii)	91 to 150	8	0	3
iii)	151 to 500	13	1	5
iv)	501 to 1 200	20	1	5
v)	1 201 to 10 000	32	2	8
vi)	10 001 to 35 000	50	3	8
vii)	35 001 to 500 000	80	5	13
viii)	500 001 and above	125	7	13

7 MARKING

7.1 Each piece shall be suitably marked or labelled with the following information:

- a) Name of the material;
- b) Manufacturer's name, initials or trade mark;
- c) Length and width of the piece;
- d) Count of warp and weft yarn;
- e) Indication of the source of manufacture; and
- f) Other declarations required as per law in force.

7.2 BIS Certification Marking

The product 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.

8 PACKING

Unless otherwise agreed upon the buyer and the seller, the cloth shall preferably be packed in bales or cases in conformity with the procedure laid down either in IS 1347 or IS 293.

ANNEX A

(Clause 2)

LIST OF REFERRED STANDARDS

<i>IS No.</i>	<i>Title</i>	<i>IS No.</i>	<i>Title</i>
IS/ISO 105-B01 : 2014	Textiles — Tests for colour fastness: Part B01 Colour fastness to light: Daylight	IS 1390 : 2022	Textiles — Determination of pH of aqueous extract (<i>third revision</i>)
IS/ISO 105-B02 : 2014	Textiles — Tests for colour fastness: Part B02 Colour fastness to artificial light: Xenon arc fading lamp test	IS 1954 : 2024/ ISO 22198 : 2006	Textiles — Fabrics — Determination of width and length (<i>third revision</i>)
IS/ISO 105-C10 : 2006	Textiles — Tests for colour fastness: Part C10 Colour fastness to washing with soap or soap and soda	IS 1963 : 1981	Methods for determination of threads per unit length in woven fabrics (<i>second revision</i>)
IS 293 : 1980	Code for seaworthy packaging of cotton yarn and cloth (<i>third revision</i>)	IS 2977 : 1989	Fabrics (other than wool) — Method for determination of dimensional changes on soaking in water (<i>first revision</i>)
IS 667 : 1981	Methods for identification of textile fibres (<i>first revision</i>)	IS 3442 : 2023	Textiles method for determination of crimp and linear density of yarn removed from fabric (<i>second revision</i>)
IS 1347 : 1972	Specification for inland packaging of cotton cloth and yarn (<i>first revision</i>)	IS 14466 : 1997/ ISO 8498 : 1990	Fabrics — Description of defects — Vocabulary
IS 1383 : 2023	Methods for determination of scouring loss in grey and finished cotton textile materials (<i>second revision</i>)		

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ANNEX B

(Foreword)

COMMITTEE COMPOSITION

Handloom and Khadi Sectional Committee, TXD 08

<i>Organization</i>	<i>Representative(s)</i>
Weavers Service Centre, Delhi	SHRI VISHESH NAUTIYAL (<i>Chairperson</i>) SHRI VIKAS KUMAR (<i>Alternate</i>)
Center of Excellence for Khadi (COEK)- NIFT, New Delhi	REPRESENTATIVE
Central Pollution Control Board, New Delhi	SHRI P. K. MISHRA SHRI RISHABH SRIVASTAV (<i>Alternate</i>)
CRPF, New Delhi	SHRI D. P. UPADHYAY SHRI SANJEEV KUMAR SINGH (<i>Alternate</i>)
Department of Handlooms & Textiles, Chennai	SHRI THIRU R. RAGHUNATH SHRI THIRU K. MUNUSAMY (<i>Alternate</i>)
Fabindia, New Delhi	REPRESENTATIVE
Flag Foundation of India, New Delhi	SHRI ASHIM KOHLI
Gandhigram Rural Institute, Dindigul	DR B. SENTHIL KUMAR
Haryana Khadi Gramodyog Sangh, Karnal	SHRI PAWAN GARG SHRI R. S. YADAV (<i>Alternate</i>)
ICAR – Central Institute for Research on Cotton Technology, Mumbai (CIRCOT)	DR SUJATA SAXENA DR A. S. M. RAJA (<i>Alternate</i>)
Indian Institute of Handloom Technology, Jodhpur	DR J. SIVAGNANAM
Indian Institute of Handloom Technology, Salem	DR P. THENNARASU
Indian Institute of Handloom Technology, Varanasi	DR AMIN HIRENBHAI NAVINBHAI SHRI JITENDER TAK (<i>Alternate</i>)
Indian Institute of Technology, Delhi	DR BIPIN KUMAR DR WAZED ALI (<i>Alternate</i>)
Indo Tibetan Border Police, New Delhi	SHRI UTTAM KUMAR SHRI ANAND KUMAR (<i>Alternate</i>)
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Khadi and Village Industries Commission, Mumbai	SHRI VIJAYSRIDHAR DR SENTIL KUMAR C. B. (<i>Alternate</i>)
Khadi Dyers & Printers, Mumbai	SHRI D. N. BHATT SHRI V. D. JOSHI (<i>Alternate</i>)

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Kshetriya Khadi Gramodyog Samiti, Dausa	SHRI R. K. SINGH
Madhya Bharat Khadi Sangh, Gwalior	SHRIMATI NEELU MEKLE SHRI HARISH MEKLE (<i>Alternate</i>)
Mahatma Gandhi Institute for Rural Industrialization, Wardha	SHRI MAHESH KUMAR DR TAPAN RANJAN KAR (<i>Alternate</i>)
Metpalli Khadi Gramodyog Pratisthan, Metpalli	SHRI G. MADHAV
Ministries of Defence (DGQA), New Delhi	SHRI ARVIND COMPATHANE SHRI N. SENTHIL KUMAR (<i>Alternate</i>)
Ministries of Health, New Delhi	REPRESENTATIVE
National Handloom Development Corporation Ltd, Gautam Budh Nagar	DR SAKTHIVEL PERUMAL SAMY SHRI JITENDRA TOLAMBIYA (<i>Alternate</i>)
Northern India Textile Research Association, Ghaziabad	DR M. S. PARMAR SHRI SANJEEV SHUKLA (<i>Alternate</i>)
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SHRI SWAPNIL
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