

वस्त्रादि — हथकरघा बकरम कपड़ा —  
विशिष्टि  
(दूसरा पुनरीक्षण)

**Textiles — Handloom Buckram  
Cloth — Specification**  
( *Second Revision* )

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भारतीय मानक ब्यूरो  
BUREAU OF INDIAN STANDARDS  
मानक भवन, 9 बहादुर शाह ज़फर मार्ग, नई दिल्ली - 110002  
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG  
NEW DELHI - 110002

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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.

Buckram cloth is generally used for interlining of garments to give stiffness. It is also used in millinery to give hats shape and structure.

This standard was first published in 1957 and subsequently revised in 1968. The standard has again been revised to incorporate the following changes:

- a) All amendments have been incorporated;
- b) Marking clause has been modified;
- c) References to standards have been updated; and
- d) Sampling plan has been updated.

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 BUCKRAM CLOTH —  
SPECIFICATION**

( *Second Revision* )

**1 SCOPE**

**1.1** This standard prescribes the constructional details and other particulars of four varieties of handloom buckram cloth.

**1.2** This standard does not specify the indeterminable characteristics like general appearance, feel and shade of the cloth (see [5.1](#)).

**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 yarn used in the manufacture of cloth should be reasonably free from defects and shall be such that the cloth produced complies with the requirements of this standard. The warp yarn used in the manufacture of cloth shall be of two fold cotton. The weft yarn shall be of single worsted in case of Variety 1 and of single jute in case of other varieties. The approximate count of warp and weft yarn used in the manufacture of cloth is given below.

<i>Sl No.</i>	<i>Variety No.</i>	<i>Warp Universal Count (Cotton Count)</i>	<i>Weft Universal Count (Metric Count or Grist)</i>
(1)	(2)	(3)	(4)
i)	1	30 tex × 2 (20s/2)	40 tex (25 Nm)
ii)	2	30 tex × 2 (20s/2)	140 tex (4s)
iii)	3	15 tex × 2 (40s/2)	140 tex (4s)
iv)	4	30 tex × 2 (20s/2)	140 tex (4s)

NOTES — To convert universal count in tex to:

- a) cotton count, divide 590.5 by the universal count;
- b) metric count, divide 1 000 by the universal count; and
- c) grist, multiply 0.029 03 by the universal count.

**3.2 Cloth**

**3.2.1** The cloth shall be woven in plain weave.

**3.2.2** The selvages shall be firm and well-woven.

**3.2.3** The cloth conforming to Variety No. 1 shall be mothproofed. The cloth conforming to other varieties may also be mothproofed, if specified by the buyer.

NOTE — Copper naphthenate is a suitable mothproofing agent. The amount of copper content calculated as copper in the cloth, if treated with copper naphthenate shall be not less than 0.65 percent when tested by the relevant method given in IS 3522 (Part 3). The amount of proofing agents present in the cloth, when treated with materials other than copper naphthenate shall be not less than the values as specified by the buyer.

**3.2.4** Either of warp or weft of the cloth may be dyed to the shade as specified by the buyer. However, sulphur black dyes shall not be used.

**3.2.4.1** The dyed cloth shall conform to the colour fastness requirements of [Table 2](#).

**3.2.5** The cloth when visually examined should be reasonably free from spinning and weaving defects.

**4 REQUIREMENTS****4.1 Construction**

The cloth shall comply with the particulars given in [Table 1](#).

**4.2 Requirements**

The cloth shall comply with the requirements given in [Table 2](#).

**5 SEALED SAMPLE**

**5.1** If, in order to illustrate or specify the indeterminable characteristics, such as general appearance, feel and shade of cloth, a sample has been agreed upon and sealed, the supply shall be in conformity with the sample in such respects.

**5.1.1** The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

**6 SAMPLING****6.1 Lot**

The quantity of handloom buckram cloth 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](#).

**Table 1 Particulars of Handloom Buckram Cloth**

(Clause 4.1)

SI No.	Variety No.	Ends/dm	Picks/dm	Weight g/m <sup>2</sup>	Breaking Load on 10 × 20 cm Strips		Length m	Width cm
					Warp kg	Weft kg		
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)
i)	1	212	166	230	175	30	as agreed	as agreed
ii)	2	174	102	270	115	180		
iii)	3	174 (Double)	94	270	135	145		
iv)	4	174	126	320	145	200		
Tolerance, Percent	—	± 5	± 5	± 5	- 5	- 5	—	—
Method of Test, Ref to	—	IS 1963		IS 1964	IS 1969 (Part 1)		IS 1954	

**Table 2 Requirements of Handloom Buckram Cloth**

(Clauses 3.2.4 and 4.2)

SI No.	Characteristic	Requirement	Method of Test, Ref to
(1)	(2)	(3)	(4)
i)	Scouring loss, percent	10 to 15	IS 1383
ii)	Relaxation shrinkage, percent, <i>Max</i>	2.5	IS 2977
iii)	Colour fastness to washing	4 or better	IS/ISO 105-C10

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

(Clause 6.3)

SI 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

**6.4 Number of Tests and Criteria for Conformity**

<i>Sl No.</i>	<i>Characteristic(s)</i>	<i>Number of Tests</i>	<i>Criteria for Conformity</i>
(1)	(2)	(3)	(4)
i)	Visual inspection, ends, picks, length and width	According to col1 (3) of <a href="#">Table 3</a>	Number of non-conforming pieces shall not exceed the corresponding number given in col1 (4) of <a href="#">Table 3</a>
ii)	Relaxation shrinkage, weight, breaking load, colour fastness to washing, and scouring loss	According to col1 (5) of <a href="#">Table 3</a>	All the pieces shall meet the requirement

**7 MARKING**

**7.1** The cloth shall be marked with the following:

- a) Name of the material;
- b) Variety No.;
- c) Width and length of piece;
- d) Manufacturer's name, initials or trade-mark;
- e) Month and year of manufacture;
- f) Indication of the source of manufacture; and
- g) 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**

The cloth shall be packed in bales or cases in conformity with the procedure laid down either in IS 293 or IS 1347.

## 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-C10 : 2006	Textiles — Tests for colour fastness: Part C10 Colour fastness to washing with soap or soap and soda	IS 1964 : 2001	Textiles — Methods for determination of mass per unit length and mass per unit area of fabrics ( <i>second revision</i> )
IS 293 : 1980	Code for seaworthy packaging of cotton yarn and cloth ( <i>third revision</i> )	IS 1969 (Part 1) : 2018	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 1347 : 1972	Specification for inland packaging of cotton cloth and yarn ( <i>first revision</i> )	IS 2977 : 1989	Fabrics (other than wool) — Method for determination of dimensional changes on soaking in water ( <i>first revision</i> )
IS 1383 : 2023	Methods for determination of scouring loss in grey and finished cotton textile materials ( <i>second revision</i> )	IS 3522 (Part 3) : 1983	Methods for estimation of common preservatives used in textile industry: part 3
IS 1954 : 2024/ ISO 22198 : 2006	Textiles — Fabrics — Determination of width and length ( <i>third revision</i> )		
IS 1963 : 1981	Methods for determination of threads per unit length in woven fabrics ( <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 ( <b>Chairperson</b> ) SHRI VIKAS KUMAR ( <i>Alternate</i> )
Central Pollution Control Board, New Delhi	SHRI P. K. MISHRA SHRI RISHABH SRIVASTAV ( <i>Alternate</i> )
Center of Excellence for Khadi (COEK)-NIFT, New Delhi	REPRESENTATIVE
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> )
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Khadi Dyers & Printers, Mumbai	SHRI D. N. BHATT SHRI V. D. JOSHI ( <i>Alternate</i> )
Khadi Gramodyog Mandal, Rampur	SHRI RAKESH CHAUDHARY SHRI PRINCE CHAUDHARY ( <i>Alternate</i> )
Kshetriya Khadi Gramodyog Samiti, Dausa	SHRI R. K. SINGH
Khadi and Village Industries Commission, Mumbai	SHRI VIJAYSRIDHAR DR SENTIL KUMAR C. B. ( <i>Alternate</i> )

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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> )
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Northern India Textile Research Association, Ghaziabad	DR M. S. PARMAR SHRI SANJEEV SHUKLA ( <i>Alternate</i> )
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The Cotton Textiles Export Promotion Council (TEXPROCIL), Mumbai	DR SIDDHARTHA RAJAGOPAL SHRI RAJESH SATAM ( <i>Alternate</i> )
The Handloom Export Promotion Council, Chennai	DR M. SUNDAR SHRI N. SREEDHAR ( <i>Alternate</i> )
The Tamil Nadu Handloom Weavers Cooperative Society Ltd, Chennai	SHRI T. N. VENKATESH SHRI K. KATHIRESAN ( <i>Alternate</i> )
BIS Directorate General	SHRI J. K. GUPTA, SCIENTIST 'E'/ DIRECTOR AND HEAD (TEXTILES) [REPRESENTING DIRECTOR GENERAL ( <i>Ex-officio</i> )]

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SHRI SWAPNIL  
SCIENTIST 'B'/ ASSISTANT DIRECTOR  
(TEXTILES), BIS





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## BUREAU OF INDIAN STANDARDS

### Headquarters:

Manak Bhavan, 9 Bahadur Shah Zafar Marg, New Delhi 110002

Telephones: 2323 0131, 2323 3375, 2323 9402

Website: [www.bis.gov.in](http://www.bis.gov.in)

### Regional Offices:

Central : 601/A, Konnectus Tower -1, 6<sup>th</sup> Floor,  
DMRC Building, Bhavbhuti Marg, New  
Delhi 110002

Telephones

{ 2323 7617

Eastern : 8<sup>th</sup> Floor, Plot No 7/7 & 7/8, CP Block, Sector V,  
Salt Lake, Kolkata, West Bengal 700091

{ 2367 0012  
{ 2320 9474

Northern : Plot No. 4-A, Sector 27-B, Madhya Marg,  
Chandigarh 160019

{ 265 9930

Southern : C.I.T. Campus, IV Cross Road, Taramani, Chennai 600113

{ 2254 1442  
{ 2254 1216

Western : 5<sup>th</sup> Floor/MTNL CETTM, Technology Street, Hiranandani Gardens, Powai  
Mumbai 400076

{ 25700030  
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