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विशिष्टि

(दूसरा पुनरीक्षण)

Textiles — Handloom Cotton
Lungies — 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.

Lungies are garments of traditional and regional culture found in many states and provinces of India. The south Indian states and portions of the eastern and northern states exhibit the most usage of *Lungies*. *Lungi* is a kind of cloth white or coloured, usually wrapped around the waist the two ends of which are knotted together. It is worn as a draping around the body.

This standard was first published in 1956 and was subsequently revised in 1976. The revision has been brought out to incorporate the following changes:

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

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 *LUNGIES* —
SPECIFICATION
(Second Revision)

1 SCOPE

1.1 This standard prescribes the constructional particulars and other requirements of 16 varieties of handloom cotton *lungies*, striped, checked or printed.

1.2 This standard does not specify the general appearance, feel, finish, etc, of *lungies*.

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 subjected 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

Lungies shall be woven in plain weave using yarn conforming to IS 171.

4 REQUIREMENTS

4.1 The constructional particulars shall conform those given in [Table 1](#).

4.2 Other requirements of *lungies* shall conform to those given in [Table 2](#).

Table 1 Constructional Particulars of Handloom Cotton *Lungies*

(Clause 4.1)

SI No.	Variety No.	Count of Yarn		Ends/cm	Picks/cm
		Warp	Weft		
(1)	(2)	(3)	(4)	(5)	(6)
i)	1	20s (or 30 tex)	20s (or 30 tex)	17	17
ii)	2	20s (or 30 tex)	20s (or 30 tex)	19	21
iii)	3	20s (or 30 tex)	20s (or 30 tex)	21	19
iv)	4	20s (or 30 tex)	30s (or 20 tex)	20	25
v)	5	30s (or 20 tex)	30s (or 20 tex)	21	23
vi)	6	40s (or 14.5 tex)	40s (or 14.5 tex)	25	28
vii)	7	40s (or 14.5 tex)	40s (or 14.5 tex)	32	32
viii)	8	40s (or 14.5 tex)	40s (or 14.5 tex)	32	36
ix)	9	60s (or 10 tex)	40s (or 14.5 tex)	34	38
x)	10	60s (or 10 tex)	40s (or 14.5 tex)	36	35
xi)	11	60s (or 10 tex)	40s (or 14.5 tex)	36	40
xii)	12	60s (or 10 tex)	40s (or 14.5 tex)	40	38
xiii)	13	60s (or 10 tex)	60s (or 10 tex))	34	40
xiv)	14	80s (or 7.4 tex)	80s (or 7.4 tex)	44	49
xv)	15	80s (or 7.4 tex)	80s (or 7.4 tex)	46	44
xvi)	16	80s (or 7.4 tex)	80s (or 7.4 tex)	50	47
Tolerance, Percent	—	± 5	± 5	± 5	± 5
Method of Test, Ref to	—	IS 3442		IS 1963	

Table 2 Other Requirements of Handloom Cotton Lungies

(Clause 4.2)

SI No.	Characteristic	Requirement	Method of Test, Ref to
(1)	(2)	(3)	(4)
i)	Dimensional changes, percent, <i>Max</i>		IS 2977
	a) Loom state <i>lungies</i>	6	
	b) Other <i>lungies</i>	4	
ii)	Scouring loss, percent, <i>Max</i>		IS 1383
	a) Loom state <i>lungies</i>	6	
	b) Other <i>lungies</i>	2.5	
iii)	Colour fastness to:		
	a) Light	4 or better	IS/ISO 105-B01 or IS/ISO 105-B02
	b) Washing, Test 4	3 or better	IS/ISO 105-C10
	c) Bleaching	4 or better	IS/ISO 105-N01
	d) Perspiration	4 or better	IS/ISO 105 E04
iv)	Length	1.8 m to 2.25 m or 4 m or as agreed	IS 1954
v)	Width	90 to 127 cm or as agreed	IS 1954
vi)	Fibre identification	100 percent cotton	IS 667

5 INSPECTION

The *lungies* when visually inspected should be reasonably free from the following defects (*see* IS 14466):

- a) Weft crack of more than 2 missing picks across the width of the material;
- b) Prominently noticeable weft bar due to the difference in raw material, count, twist, 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 defect;
- e) Noticeable warp or weft float in the body of the material;
- f) Noticeable oil or other stain in the material;
- g) Noticeable hole, cut or tear up to 3 mm in size in the body of the fabric;

h) Smash definitely rupturing the texture of the material; and

j) Extensive printing or dyeing defect.

6 SAMPLING**6.1 Lot**

The quantity of cloth of the same variety delivered to one buyer against one despatch note shall constitute a lot.

6.2 The conformity of the lot to the various requirements specified in the standard shall be determined on the basis of tests carried out on the samples selected from the lot.

6.3 Unless otherwise agreed, the number of pieces to be selected at random for inspection shall be in accordance with the [Table 3](#). For random selection of samples, IS 4905 may be followed.

6.4 Number of Samples and Criteria for Conformity

The number of samples to be drawn and the criteria for conformity of the material for various characteristics shall be as follows:

<i>Sl No.</i>	<i>Characteristic(s)</i>	<i>Number of Samples</i>	<i>Criterion for conformity</i>
(1)	(2)	(3)	(4)
i)	Count, ends, picks, length, width, and visual inspection	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

(Clauses [6.3](#) and [6.4](#))

Sl No.	Lot Size	Sample Size	Permissible No. of Non-Conforming Blankets	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 *Lungi* shall be suitably marked or labelled with the following information:

- Name of the material;
- Manufacturer's name, initials or trade-mark;
- Length (m) and width (cm);
- Count of warp and weft yarn;
- Indication of the source of manufacture; and
- 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 by the buyer and the seller, the *lungies* 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 1383 : 2023	Methods for determination of scouring loss in grey and finished cotton textile materials (<i>second 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 1390 : 2022/ ISO 3071 : 2020	Textiles — Determination of pH of aqueous extract (<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 1954 : 2024/ ISO 22198 : 2006	Textiles — Fabrics — Determination of width and length (<i>third revision</i>)
IS/ISO 105-N01 : 1993	Textiles — Tests for colour fastness: Part N01 Colour fastness to bleaching: Hypochlorite	IS 1963 : 1981	Methods for determination of threads per unit length in woven fabrics (<i>second revision</i>)
IS/ISO 105-E04 : 2013	Textiles — Tests for Colour Fastness: Part E04 Colour Fastness to Perspiration	IS 2977 : 1989	Fabrics (other than wool) — Method for determination of dimensional changes on soaking in water (<i>first revision</i>)
IS 171 : 1993	Textiles — Ring spun grey cotton yarn for weaving — Specification (<i>fourth revision</i>)	IS 3442 : 2023	Textiles method for determination of crimp and linear density of yarn removed from fabric (<i>second revision</i>)
IS 293 : 1980	Code for seaworthy packaging of cotton yarn and cloth (<i>third revision</i>)	IS 4905 : 2015/ ISO 24153 : 2009	Random sampling and randomization procedures (<i>first revision</i>)
IS 667 : 1981	Methods for identification of textile fibres (<i>first revision</i>)	IS 14466 : 1997/ ISO 8498 : 1990	Fabrics — Description of defects — Vocabulary
IS 1347 : 1972	Specification for inland packaging of cotton cloth and yarn (<i>first 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 (Chairperson) 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>)
Jan Sewa Ashram, Aligarh	SHRI R. K. SHARMA SHRI AKHILESH KUMAR AWASTHI (<i>Alternate</i>)
Karnataka Khadi Gramodyog Samyuktha Sangha, Hubli	SHRI K. V. PATTAR SHRI SHIVANANDA S. MATHAPATI (<i>Alternate</i>)
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>)

<i>Organization</i>	<i>Representative(s)</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>)
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>)
Northern Railways, New Delhi	SHRI SANJEEV KUMAR JAIN SHRI RAJESH KUMAR (<i>Alternate</i>)
Office of the Development Commissioner for Handlooms, New Delhi	SHRI SIDDHARTH SINGH SHRI VINAY KUMAR (<i>Alternate</i>)
Orient Processes Pvt Ltd, Guwahati	SHRI ROBIN CHANDRA GOSWAMI SHRI RAJ BURAGOHAIN (<i>Alternate</i>)
Rastriya Khadi Gramodyog Federation, Moradabad	SHRI ANIL KUMAR SINGH SHRI KULDEEP SINGH (<i>Alternate</i>)
Swastik Gramodyog Samiti, Delhi	SHRI M. L. PATHAK SHRI ABHISHEK DIXIT (<i>Alternate</i>)
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>)]

Member Secretary
SHRI SWAPNIL
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