

वस्त्रादि — कपास, इंटरलॉक बुना हुआ
कपड़ा — विशिष्टि
(पहला पुनरीक्षण)

**Textiles — Cotton, Interlock Knitted
Fabric — Specification**
(*First Revision*)

ICS 59.060.10; 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 Hosiery Sectional Committee had been approved by the Textile Division Council.

Interlock fabric is a double 1×1 rib-knitted fabric with crossed sinker wales. The wales on one side of the fabric are immediately behind the wales of the other side of the fabric. The appearance of this fabric is same on both the sides.

This standard was first published in 1991. This revision has been brought out in the light of experience gained since its publication and to incorporate the following major changes:

- a) Title of the standard has been modified;
- b) The amendment issued has been incorporated;
- c) References to standard has been updated;
- d) BIS certification marking clause has been updated; and
- e) Sampling and criteria for conformity has been modified.

The composition of the Committee responsible for the formulation of this standard is given in [Annex C](#).

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 — COTTON, INTERLOCK KNITTED FABRIC —
SPECIFICATION***(First Revision)***1 SCOPE**

1.1 This standard prescribes the requirements of grey, scoured, bleached, dyed or printed interlock fabric knitted on circular machines.

1.2 This standard also covers coloured interlock knitted fabric produced by knitting with dyed yarn.

1.3 This standard does not specify the general appearance, feel, lustre, degree of whiteness or shade of the knitted fabric (*see* [5.4](#)).

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 TERMINOLOGY

For the purpose of this standard, the definitions given in IS 3596 shall apply (*see* SP 45).

4 MANUFACTURE

4.1 The tubular fabric shall be evenly knitted on interlock machine. The width of the tubular fabric shall be uniform throughout and shall correspond to the diameter of the knitting machine. The fabric shall not be over boarded or pulled in length while calendaring. If required by the buyer, the bleached fabric may also be treated with optical whitening agents.

4.2 The fabric shall be reasonably free from knitting defects such as ladders, dropped stitches, holes, cuts and mends and chemical defects such as defective bleaching in case of bleached fabric or streaks, stains and uneven dyeing in case of dyed fabric and defective printing in case of printed fabric.

5 REQUIREMENTS

5.1 The yarn used in knitting the fabric shall conform

to IS 834. medium 'C', fine and superfine fabrics (*see* [Table 1](#)) shall be knitted from combed yarn only.

5.2 The construction requirements of the fabric shall be as specified in [Table 1](#).

5.3 The fabric shall also conform to the requirements specified in [Table 2](#).

5.4 Sealed Sample

In order to illustrate or specify the indeterminable characteristics such as general appearance, degree of whiteness, colour, shade or print design of fabric, 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.

6 MARKING

6.1 Each roll of fabric shall be marked with the following information:

- a) Count of yarn and type (carded or combed);
- b) Designation of fabric (*see* [Table 1](#));
- c) Hundred percent cotton, if required by the buyer;
- d) Diameter of the knitting machine;
- e) Indication of the source of manufacture; and
- f) Any other information/instruction provided by the manufacturer/required under law.

6.2 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.

7 PACKING

Unless otherwise agreed to between the buyer and the seller, the fabric shall be well packed and supplied in a clean and dry state free from stains, greases, etc.

8 SAMPLING AND CRITERIA FOR CONFORMITY

8.1 Lot

In any consignment, all rolls knitted of a particular diameter of knitting machine of the same designation and of the same quality (type) and count of yarn and delivered to a buyer against one dispatch note shall constitute a lot.

The conformity of a lot to the requirements of this specification shall be determined on the basis of the tests carried out on the samples selected from the lot.

8.2 Unless otherwise agreed to between the buyer and the seller, number of rolls depending upon the size of the lot shall be selected at random from the lot to constitute the gross sample. The number of rolls so selected shall be in accordance with col (3) of [Table 3](#).

Table 1 Construction Requirements of Interlock Knitted Cotton Fabric

(Clauses [5.1](#), [5.2](#) and [6.1](#))

| SI No. | Designation | Gauge of Machine (see Note) | Nominal Count of Yarn Cotton Count, Ne (Tex) | Wales/dm, <i>Min</i> | Courses/dm, <i>Min</i> |
|---|-------------|---|--|-------------------------|---------------------------|
| (1) | (2) | (3) | (4) | (5) | (6) |
| i) | Coarse 'A' | 18 | 18s (33), 20s (30) | 98 | 102 |
| ii) | Coarse 'B' | 20 | 22s (27), 24s (25) 26s (22.5) | 106 | 110 |
| iii) | Medium 'A' | 20 | 28s (21), 30s (20), 34s (17.5) | 114 | 118 |
| iv) | Medium 'B' | 20 | 34s (17.5), 36s (16.5), 38s (15.5), 39s (15), 40s (14.5) | 122 | 134 |
| v) | Medium 'C' | 22 | 40s (14.5), 42s (14), 44s (13.5), 45s (13), 50s (12) | 138 | 164 |
| vi) | Fine | 24 | 50s to 60s (12 to 9.8) | 152 | 180 |
| vii) | Superfine | 26 | 60s to 80s (9.8 to 7.4) | 168 | 196 |
| Method of test, ref to | | — | IS 1315 | B-2 | B-2 |
| NOTE — As determined by the number of needles per 2.5 cm. | | | | | |

Table 2 Requirements of Interlock Knitted Cotton Fabric

(Clause [5.3](#) and [B-3.1](#))

| SI No. | Characteristic | Requirement | Method of Test, Ref to |
|--------|--------------------|---|------------------------|
| (1) | (2) | (3) | (4) |
| i) | Length, <i>Min</i> | As agreed to between the buyer and the seller | IS 1954 |

Table 2 (Concluded)

| SI No. | Characteristic | Requirement | Method of Test, Ref to |
|---|--|--|--|
| (1) | (2) | (3) | (4) |
| ii) | Width | | |
| | a) Grey fabric b) Scoured, bleached, calendared, dyed or printed fabric | ± 2 cm of the size (see Note) ± 1 cm of the size (see Note) | IS 1954 |
| iii) | Dimensional change (due to relaxation) percent, <i>Max</i> | | B-3 |
| | a) Grey fabric: | | |
| | i) Wales direction; and | 10.0 | |
| | ii) Courses direction. | 12.0 | |
| b) Scoured, bleached, calendared, dyed or printed fabric: | | | |
| i) Wales direction; and | 5.0 | | |
| ii) Courses direction. | 10.0 | | |
| iv) | pH value | 6 to 8 | IS 1390 |
| v) | Minimum colour fastness rating of dyed or printed fabric: | | |
| | a) Light, change in colour | 5 | IS/ISO 105-B01 or IS/ISO 105-B02 IS/ISO 105-C10 |
| | b) Washing: Test A (1) | | |
| | i) Change in colour; and | 4 | |
| | ii) Staining of adjacent fabric. | 4 | |
| | c) Perspiration: | | IS/ISO 105-E04 |
| i) Change in colour; and | 4 | | |
| ii) Staining of adjacent fabric. | 4 | | |
| NOTE — Diameter of the knitting machine. | | | |

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

(Clauses [8.2](#) and [8.3](#))

| SI No. | Number of Rolls in the Lot | Physical Characteristics | | Number of Rolls to be Tested |
|--------|----------------------------|---------------------------------|--|------------------------------|
| | | Number of Rolls to be Inspected | Permissible Number of Non-conforming Rolls | |
| (1) | (2) | (3) | (4) | (5) |
| i) | Up to 50 | 5 | 0 | 2 |
| ii) | 51 to 90 | 5 | 0 | 3 |
| iii) | 91 to 150 | 8 | 0 | 3 |

Table 3 (Concluded)

| SI No. | Number of Rolls in the Lot | Physical Characteristics | | Number of Rolls to be Tested |
|--------|----------------------------|---------------------------------|--|------------------------------|
| | | Number of Rolls to be Inspected | Permissible Number of Non-conforming Rolls | |
| (1) | (2) | (3) | (4) | (5) |
| iv) | 151 to 280 | 13 | 1 | 3 |
| v) | 280 to 500 | 20 | 1 | 3 |
| vi) | 500 and above | 32 | 2 | 5 |

8.3 The number of rolls to be tested and criteria for conformity for each of the characteristics shall be as follows:

| Sl No. | Characteristic | Number of Rolls to be Tested | Criterion for Conformity |
|--------|--|---|---|
| (1) | (2) | (3) | (4) |
| i) | Physical | | |
| | Visual inspection, construction and width/diameter | see col (3) of Table 3 | Non-conforming rolls not to exceed the corresponding number given in col (4) of Table 3 |
| ii) | Other requirements | | |
| | a) Dimensional change and pH value; and | see col (5) of Table 3 | All rolls to satisfy the requirements |
| | b) Colour fastness. | 1 specimen each of the same colour, shade and/or print for lot size up to 150 and 2 above 150 | All the test satisfies the requirements specimens relevant |

ANNEX A

(Clause 2)

LIST OF REFERRED STANDARDS

| <i>IS No./Other Standard</i> | <i>Title</i> | <i>IS No./Other Standard</i> | <i>Title</i> |
|------------------------------|--|-------------------------------------|---|
| IS/ISO 105-B01 : 2014 | Textiles — Tests for colour fastness: Part B01 Colour fastness to light:Daylight | (Part 2) : 2003 | Control charts for attributes (<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 834 : 2006 | Textiles — Ring spun grey cotton yarn for hosiery — Specification (<i>fifth 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 1315 : 1977 | Method for determination of linear density of yarns spun on cotton system (<i>first revision</i>) |
| IS/ISO 105-E04 : 2013 | Textiles — Tests for colour fastness: Part E04 Colour Fastness to Perspiration (<i>first revision</i>) | IS 1390 : 2022/ ISO 3071 : 2020 | Textiles — Determination of pH of aqueous extract (<i>third revision</i>) |
| IS 394 : 1985 | Specification for ink, cloth marking (<i>second revision</i>) | IS 1954 : 2024/ ISO 22198 : 2006 | Textiles — Fabrics — Determination of width and length (<i>third revision</i>) |
| IS 397 | Method for statistical quality control during production: | IS 3596 : 1967 | Glossary of terms relating to hosiery |
| (Part 1) : 2003 | Control charts for variables (<i>second revision</i>) | IS 6359 : 2023 | Method for conditioning of textiles (<i>first revision</i>) |
| | | SP 45 : 1988 | Handbook on glossary of textile terms |

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ANNEX B

(Table 1 and Table 2)

METHODS OF TEST

B-1 CONDITIONING OF TEST SPECIMENS AND ATMOSPHERIC CONDITIONS FOR TESTING

The test specimens shall be tested in prevailing atmospheric conditions. In case of dispute, the samples shall be conditioned and tested in standard atmosphere as given in IS 6359.

B-2 WALES AND COURSES

Take one of the rolls and lay it flat on a table. Remove all creases and wrinkles without distorting it. On one side of the test specimen, count with the help of a pick glass or magnifying glass, the number of wales and courses in 10 cm at three different places in the roll and calculate the average number of wales and courses per dm.

B-3 DIMENSIONAL CHANGE (DUE TO RELAXATION)**B-3.1 Marking of Test Specimens**

Take one of the rolls from the lot cut a piece measuring approximately 30 cm in length \times full width. Mark centrally on it by means of indelible ink (*see* IS 394 and Note) an area 15 cm \times 15 cm with two of its sides in the direction of wales and the other two in the direction of courses. Spread this test specimen on a flat smooth surface, carefully removing by hand all creases and wrinkles. Within this area, mark six pairs of marks, three pairs each in the wales and courses direction in such a way that the distance between each pair of marks is the same.

NOTE — If marking ink is not available, dyed cotton sewing thread having a minimum colour fastness rating as given in SI No. (v) (b) of [Table 2](#) may be used.

B-3.2 Procedure

Take the test specimen and spread it on a flat smooth surface. Carefully remove by hand all creases and wrinkles without stretching the test specimen.

B-3.2.1 Measure correct to the nearest mm the distance between each pair of marks separately.

B-3.2.2 Lay the test specimen flat in a watertight tray of suitable size, having depth of minimum 10 cm. Soak it under a head of 25 mm of water containing 0.5 percent suitable wetting agent at 30 °C to 35 °C for 2 h. Drain out the water and remove the test specimen carefully so that it is not stretched and lay it flat on a smooth surface. Remove the excess of water by absorbent material and dry it at room temperature.

B-3.2.3 After drying, condition the test specimen to moisture equilibrium in a standard atmosphere, if needed (*see* [B-1](#)). Place it on the glass plate, carefully remove all wrinkles and creases and place the other glass plate on the test specimen. Measure correct to the nearest mm, the distance between each pair of marks separately.

B-3.2.4 Calculate, separately, the percentage of dimensional change both in the direction of wales and courses by the following formula:

$$S = \frac{(a - b)}{a \times 100}$$

where

S = dimensional change, percent;

a = the distance between a pair of marks (along the wales of courses, as the case may be) before soaking; and

b = the distance between the same pair of marks after soaking.

B-3.2.5 Calculate separately the dimensional change of all the three lines in the direction of wales and in the direction of courses and calculate average dimensional change in each direction.

ANNEX C

(Foreword)

COMMITTEE COMPOSITION

Hosiery Sectional Committee, TXD 10

| <i>Organization</i> | <i>Representative(s)</i> |
|--|---|
| The South India Textile Research Association, Coimbatore | DR PRAKASH VASUDEVAN (<i>Chairperson</i>) |
| Apparel Export Promotion Council, Gurugram | SHRI K. S. BISHT |
| Central Reserve Police Force, New Delhi | SHRI SANJEEV KUMAR SINGH SHRI RANDHIR KUMAR JHA (<i>Alternate</i>) |
| Defence Materials and Stores Research and Development Establishment, Kanpur | SHRI ASHOK KUMAR YADAV |
| Directorate General of Quality Assurance, Ministry of Defence, New Delhi | SHRI ARVIND KAMTHANE SHRI J. K. YADAV (<i>Alternate</i>) |
| DKTE Centre of Excellence in Nonwovens, Ichalkaranji | PROF UDAY J. PATIL SHRI ANIL U. USAWARE (<i>Alternate</i>) |
| Essa Garments Private Limited, Tiruppur | SHRI DURGADEVI |
| JKR Garments, Tiruppur | SHRI JAILANI |
| Knitwear & Apparel Manufacturers Association, Ludhiana | SHRI SUDARSHAN KUMAR JAIN SHRI ARUN AGGARWAL (<i>Alternate</i>) |
| National Institute of Fashion Technology, New Delhi | PROF ASHOK PRASAD PROF AMRITA ROY (<i>Alternate</i>) |
| NIFT-TEA College of Knitwear Fashion, Tiruppur | DR K. P. BALAKRISHNAN DR P. P. BALAKRISHNAN (<i>Alternate</i>) |
| Office of Development Commissioner (SSI), New Delhi | SHRI KULDEEP SINGH SHRI S. SURESH BABUJI (<i>Alternate</i>) |
| Office of the Textile Commissioner, Mumbai | SHRI HUMAYUN K. SHRI SATISH KUMAR N (<i>Alternate</i>) |
| SGS India Private Limited, Mumbai | DR KARTHIKEYAN K. SHRI MICHEL FRANCIS (<i>Alternate</i>) |
| South Indian Hosiery Manufactures Association, Tiruppur | SHRI M. TYAGRAJAN SHRI R. BALASARAVANAN (<i>Alternate</i>) |
| Textiles Committee, Mumbai | SHRI R. CHANDRAN SHRI J. PARAMESWARAN (<i>Alternate</i>) |
| The Southern India Mills Association, Coimbatore | DR K. SELVARAJU DR SURESH ANAND KUMAR (<i>Alternate</i>) |
| The Synthetic and Rayon Textiles Export Promotion Council, Mumbai | SHRI ANIL RAJVANSHI SHRI BHADRESH M. DHODIA (<i>Alternate</i>) |

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| <i>Organization</i> | <i>Representative(s)</i> |
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| Veermata Jijabai Technological Institute, Mumbai | SHRI S. P. BORKAR DR ARVIND BHONGADE (<i>Alternate</i>) |
| Wool Research Association, Thane | DR MRINAL CHOUDHARI SHRI MAYUR BASUK (<i>Alternate</i>) |
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Member Secretary
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SCIENTIST 'B'/ASISTANT DIRECTOR
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This Indian Standard has been developed from Doc No.: TXD 10 (20558).

Amendments Issued Since Publication

| Amend No. | Date of Issue | Text Affected |
|-----------|---------------|---------------|
| | | |
| | | |
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| | | |

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