**IS 858 : 2024**

**Doc.No: TXD 08 (24030)**

***भारतीय मानक***

**वस्त्रादि — हथकरघा सूती टेबल कपड़ा और नैपकिन — विशिष्टि**

*( दूसरा पुनरीक्षण )*

*Indian Standard*

**Textiles** — **Handloom Cotton Table Cloth and Napkins** — **Specification**

*( Second Revision )*

ICS 59.080.30

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**B U R E A U OF I N D I A N S T A N D A R D S**

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**August 2024 Price Group**

Handloom and Khadi Sectional Committee, TXD 08

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.

This standard was originally published in 1956 and subsequently revised in 1981. The standard has again been revised to incorporate the following changes:

a) Marking clause has been modified;

b) References to Indian Standards have been updated;

c) Amendment has been incorporated;

d) Test method for identification of material has been incorporated;

e) *p*H value of aqueous extract has been incorporated;

f) Method of test for count of yarn along with its tolerance has been specified; and

g) Sampling clause 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 TABLE CLOTH AND NAPKINS** — **SPECIFICATION**

*(Second Revision)*

**1 SCOPE**

**1.1** This standard prescribes the constructional particulars and other requirements of four varieties of handloom cotton table cloth and napkins, bleached, striped, check or dyed.

**1.2** This standard does not specify the general appearance, feel, finish, shade, etc of the cloth (*see also* **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 the standards indicated in Annex A.

**3 MANUFACTURE**

**3.1 Yarn**

The cotton yarn used in the manufacture of table cloth and napkins shall be satisfactory in evenness and reasonably free from neps and spinning defects. The yarn shall conform to IS 171.

**3.2 Cloth**

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

**3.3** Each transverse end of the table cloth shall be hemmed to a depth of not less than 13 mm, the raw edges having a turn-in of 10 mm before the hem is formed. In the case of napkins, each cut end shall be hemmed to a depth of not less than 10 mm, the raw edges having a turn-in of 5 mm before the hem is formed.

**3.3.1** Cotton sewing thread of 60s/6 (100 dtex × 6) count conforming to IS 1720 shall be used and the number of stitches shall be not less than 4 per centimetre.

**3.4** The table cloth or napkins may have fringes instead of hemming. The length of the fringe, with or without knot, shall not be less than 35 mm.

**4 REQUIREMENTS**

**4.1** The constructional particulars of table cloth and napkins shall conform to those given in Table 1.

**4.2** The dimensions of table cloth and napkins shall be as agreed to. The dimensions shall exclude fringes, if any. The common dimensions of table cloth and napkins are given below:

|  |  |
| --- | --- |
| *Table Cloth* | *Napkin* |
| (1) | (2) |
| Length × Width  cm cm | Length × Width  cm cm |
| 90 × 90 | 40 × 40 |
| 115 × 115 | 45 × 45 |
| 137 × 137 | 50 × 50 |
| 150 × 150 | 60 × 60 |
| 215 × 170 |  |
| 365 × 170 |  |

**Table 1 Constructional Particulars of Handloom Cotton Table Cloth and Napkins**

(*Clause* 4.1)

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| **Sl No.** | **Variety**  **No.** | **Count of Yarn (*see* Note)**  **[Cotton Count (Universal Count)]** | | **Ends/**  **cm** | **Picks/**  **cm** | **Weave** |
| **Warp** | **Weft** |
| (1) | (2) | (3) | (4) | (5) | (6) | (7) |
|  |  | 20s/2 (30 tex × 2) | 20s/2 (30 tex × 2) | 16 | 16 | Plain, matt,  honeycomb or  huckaback |
|  |  | 30s/2 (20 tex × 2) | 30s/2 (20 tex × 2) | 19 | 19 |
|  |  | 40s/2 (15 tex × 2) | 40s/2 (15 tex × 2) | 24 | 24 |
|  |  | 40s/2 (15 tex × 2) | 30s/2 (20 tex × 2) | 26 | 22 | Damask |
| Tolerance, percent | — | ± 5 | ± 5 | ± 5 | ± 5 | — |
| Method of test, Ref to | — | IS 3442 | | IS 1963 | | Visual |
| NOTE **—** Count of yarn is given for guidance only. | | | | | | |

**4.2.1** A tolerance of ± 2 percent shall be permitted on length and width of the table cloth and napkins subject to a minimum of ± 1 cm, when determined by the method given in IS 1954.

**4.3** The colour fastness ratings and other requirements of the table cloth and napkins shall conform to those given in Table 2.

**Table 2 Requirements of Handloom Cotton Table Cloth and Napkins**

(*Clause* 4.3)

|  |  |  |  |
| --- | --- | --- | --- |
| **Sl No.** | **Characteristic** | **Requirement** | **Method of Test, Ref to** |
| (1) | (2) | (3) | (4) |
| i) | Colour fastness to (*see* Note):  a) Light  b) Washing Test 4  c) Bleaching | 4 or better  3 or better  4 or better | IS/ISO 105-B01  or  IS/ISO 105-B02  IS/ISO 105-C10 IS/ISO 105-N01 |
| ii) | Dimensional change, percent, *Max* | 4 | IS 2977 |
| iii) | Scouring loss, percent, *Max* | 2.5 | IS 1383 |
| iv) | *p*H value of aqueous extract | 6.0 to 8.5 | IS 1390 |
| v) | Fibre identification | 100 percent cotton | IS 667 |
| NOTE — The rating specified is in accordance with IS 12646, which is the basic document on colour fastness ratings to various agencies. | | | |

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

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

**5 INSPECTION**

**5.1** The table cloth and napkins when visually inspected shall be reasonably free from the following defects:

a) More than two adjacent ends running parallel, broken or missing and extending beyond 20 cm;

b) Weft crack or more than two missing picks across the width of the material;

c) Prominently noticeable weft bar due to the unevenness in raw material, count twist, lustre, etc;

d) Noticeable selvedge defects;

e) Noticeable warp or weft float in the body;

f) Noticeable oil or other stains;

g) Noticeable hole, cut or tear of up to 3 mm size;

h) Smash rupturing the texture of the fabric;

j) Undressed snarl noticeable throughout the piece;

k) Conspicuous gout due to foreign matter, usually lint or waste woven into cloth;

m) Absence of heading (where heading is required) or defective heading;

n) Conspicuous broken pattern;

p) Defective hemming extending over 2 cm in length; and

q) Any other flaw which would mar the appearance or affect the serviceability and/or durability of the cloth.

**5.1.1** A reference may be made to IS 14466 for details of these defects.

**6 SAMPLING**

**6.1 Lot**

The quantity of cotton table cloth or napkins of the same variety and dimensions 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 table cloth or napkins to be selected at random for inspection shall be in accordance with Table 3.

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

(*Clause* 6.3)

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **Sl No.** | **Lot Size** | **Sample Size** | **Permissible No. of Non-Confirming 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 1200 | 20 | 1 | 5 |
| v) | 1201 to 10000 | 32 | 2 | 8 |
| vi) | 10001 to 35000 | 50 | 3 | 8 |
| vii) | 35001 to 500000 | 80 | 5 | 13 |
| viii) | 500001 and above | 125 | 7 | 13 |

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

|  |  |  |  |
| --- | --- | --- | --- |
| *Sl No.* | *Characteristic(s)* | *No. of Tests* | *Criterion for Conformity* |
| (1) | (2) | (3) | (4) |
| i) | Ends, picks, length, width, weave and visual inspection | According to col (3) of Table 3 | Permissible number of non-conforming piece does not exceed the corresponding number given in co1 (4) of Table 3 |
| ii) | Dimensional change, scouring loss, count, colour fastness, *p*H value and fibre identification | According to col (5) of Table 3 | All the test specimens meet the relevant requirements |

**7 MARKING**

**7.1** The table cloth and napkins shall be suitably marked or labelled with the following information:

a) Name of the material and variety number;

b) Manufacturer's name, initials or trade-mark;

c) Length and width of the napkins;

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(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.

**8 PACKING**

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

**ANNEX A**

(*Clause* 2)

**LIST OF REFERRED STANDARDS**

|  |  |
| --- | --- |
| *IS No.* | *Title* |
| IS 171 : 1993 | Textiles — Ring spun grey cotton yarn for weaving — Specification (*fourth revision*) |
| IS 293 : 1980 | Code for seaworthy packaging of cotton yarn and cloth (*third revision*) |
| IS 667 : 1981 | Methods for identification of textile fibres (*first revision*) |
| IS 1347 : 1972 | Specification for inland packaging of cotton cloth and yarn (*first revision)* |
| IS 1383 : 2023 | Methods for determination of scouring loss in grey and finished  cotton textile material (*second revision*) |
| IS 1390 : 2022/  ISO 3071 : 2020 | Textiles — Determination of *p*H of aqueous extract (*third revision*) |
| IS 1720 : 1978 | Specification for cotton sewing threads (*first revision*) |
| IS 1954 : 2024/  ISO 22198 : 2006 | Textiles — Fabrics — Determination of width and length (*third* *revision*) |
| IS 1963 : 1981 | Methods for determination of threads per unit length in woven fabrics (*second revision*) |
| IS 2977 : 1989 | Fabrics (other than wool) — Method for determination of dimensional changes on soaking in water (*first revision*) |
| IS 3442 : 2023 | Textiles method for determination of crimp and linear density  of yarn removed from fabric |
| IS 12646 : 1991 | Textiles — Colour fastness ratings — Specification (*first revision*) |
| IS 14466 : 1997/  ISO 8498 : 1990 | Fabrics — Description of defects — Vocabulary |
| IS/ISO 105-B01 : 2014 | Textiles — Tests for colour fastness — Part B01 Colour fastness to light: Daylight |
| IS/ISO 105-B02 : 2014 | Textiles — Tests for colour fastness — Part B02 Colour fastness to artificial light: Xenon arc fading lamp test |
| IS/ISO 105-C10 : 2006 | Textiles — Tests forecolor fastness — Part C10 Colour fastness to washing with soap or soap and soda |
| IS/ISO 105-N01 : 1993 | Textiles — Tests for colour fastness — Part N01 Colour fastness to bleaching: Hypochlorite |

**ANNEX B**

(*Foreword*)

**COMMITTEE COMPOSITION**

Handloom and Khadi Sectional Committee, TXD 08

|  |  |
| --- | --- |
| *Organization* | *Representative(s)* |
| Weavers Service Centre, Delhi | Shri Vishesh Nautiyal (***Chairperson***)  Shri Vikas Kumar (*Alternate*) |
| Central Pollution Control Board, New Delhi | Shri P. K. Mishra  Shri Rishabh Srivastav (*Alternate*) |
| Center of Excellence for Khadi (COEK)-NIFT, New Delhi | Representative |
| CRPF, New Delhi | Shri D. P. Upadhyay  Shri Sanjeev Kumar Singh (*Alternate*) |
| Department of Handlooms & Textiles, Chennai | Representative |
| Fabindia, New Delhi | Representative |
| Flag Foundation of India, New Delhi | Representative |
| Gandhigram Rural Institute, Dindigul | Dr B. Senthil Kumar |
| Haryana Khadi Gramodyog Sangh, Karnal | Shri Pawan Garg  Shri R. S. Yadav (*Alternate*) |
| ICAR – Central Institute for Research on Cotton Technology, Mumbai (CIRCOT) | Dr Sujata Saxena  Dr A.S.M. Raja (*Alternate*) |
| Indian Institute of Handloom Technology, Jodhpur | Dr J. Sivagnanam |
| Indian Institute of Handloom Technology, Salem | Dr P Thennarasu |
| Indian Institute of Handloom Technology, Varanasi | Representative |
| Indian Institute of Technology, Delhi | Representative |
| Indo Tibetan Border Police, New Delhi | Shri Uttam Kumar  Shri Anand Kumar (*Alternate*) |
| Jan Sewa Ashram, Aligarh | Shri R. K. Sharma  Shri Akhilesh Kumar Awasthi (*Alternate*) |
| Karnatka Khadi Gramodyog Samyuktha Sangha, Hubli | Shri K. V. Pattar  Shri Shivananda S. Mathapati (*Alternate*) |
| Khadi Dyers & Printers, Mumbai | Shri D. N. Bhatt  Shri V. D. Joshi (*Alternate*) |
| Khadi Gramodyog Mandal, Rampur | Shri Rakesh Chaudhary  Shri Prince Chaudhary (*Alternate*) |
| Kshetriya Khadi Gramodyog Samiti, Dausa | Shri R. K. Singh |
| Khadi and Village Industries Commission, Mumbai | Representative |
| Madhya Bharat Khadi Sangh, Gwalior | Shrimati Neelu Mekle  Shri Harish Mekle (*Alternate*) |
| Mahatma Gandhi Institute for Rural Industrialization, Wardha | Shri Mahesh kumar  Dr Tapan Ranjan Kar (*Alternate*) |
| Metpalli Khadi Gramodyog Pratisthan, Metpalli | Shri G. Madhav |
| Ministries of Defence (DGQA), New Delhi | Shri Arvind Compathane  Shri N. Senthil Kumar (*Alternate*) |
| Ministries of Health, New Delhi | Representative |
| National Handloom Development Corporation Ltd., Gautam Budh Nagar | Dr Sakthivel Perumal Samy  Shri Jitendra Tolambiya (*Alternate*) |
| Northern Railways, New Delhi | Shri Sanjeev Kumar Jain  Shri Rajesh Kumar (*Alternate*)  Shri Sandeep Kumar Singh  (Young Professional) |
| Northern India Textile Research Association, Ghaziabad | Dr M. S. Parmar  Shri Sanjeev Shukla (*Alternate*) |
| Office of the Development Commissioner for Handlooms, New Delhi | Shri Siddharth Singh  Shri Vinay Kumar (*Alternate*) |
| Orient Processes Pvt. Ltd., Guwahati | Shri Robin Chandra Goswami  Shri Raj Buragohain |
| Rastriya Khadi Gramodyog Federation, Moradabad | Shri Anil Kumar Singh  Shri Kuldeep Singh (*Alternate*) |
| Swastik Gramodyog Samiti, Delhi | Shri M. L. Pathak  Shri Abhishek Dixit (*Alternate*) |
| The Cotton Textiles Export Promotion Council (TEXPROCIL) | Dr Siddhartha Rajagopal  Shri Rajesh Satam (*Alternate*) |
| The Handloom Export Promotion Council, Chennai | Dr M. Sundar  Shri N. Sreedhar (*Alternate*) |
| The Tamil Nadu Handloom Weavers' Cooperative Society Ltd, Chennai | Shri T. N. Venkatesh, I.A.S.  Shri K. Kathiresan (*Alternate*) |
| BIS Directorate General | Shri J. K. Gupta, Scientist ‘E’/ Director and Head (Textiles) [Representing Director General (*Ex-officio*)] |

*Member Secretary*

SHRI SWAPNIL

Scientist ‘B’/ Assistant Director

(Textiles), BIS