

वस्त्रादि — हथकरघा सूती मद्रास
रूमाल — विशिष्टि
(दूसरा पुनरीक्षण)

**Textiles — Handloom Cotton
Madras Handkerchiefs —
Specification**
(*Second Revision*)

ICS 59.080.30

© BIS 2024



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
www.bis.gov.in www.standardsbis.in

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 madras handkerchiefs are used for wiping hands, faces, or noses.

This standard was first published in 1957 and subsequently revised in 1981. This revision has been brought out to incorporate the following changes:

- a) Test method for identification of material has been incorporated;
- b) Marking clause has been modified;
- c) Sampling clause has been modified; and
- d) References to standards have 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 COTTON MADRAS
HANDKERCHIEFS — SPECIFICATION***(Second Revision)***1 SCOPE**

1.1 This standard prescribes the constructional particulars and other requirements of four varieties of handloom cotton Madras handkerchiefs.

1.2 This standard does not specify the general appearance, feel, finish, shade, 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 cloth shall be satisfactory in evenness and reasonably free from neps and spinning defects. The yarn shall conform to IS 171.

4 REQUIREMENTS

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

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.

5 INSPECTION

5.1 The cloth 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 difference 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 snarls noticeable throughout the piece;
- k) Conspicuous gout due to foreign matter, usually lint or waste woven;
- m) Conspicuous broken pattern; and
- n) Any other flaw which would mar the appearance or affect the serviceability and/or durability of the cloth.

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

6 SAMPLING**6.1 Lot**

The quantity of handloom cotton madras handkerchiefs 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)	No. of Tests	Criteria for Conformity
(1)	(2)	(3)	(4)
i)	Visual inspection, weave, ends, picks, length and width	According to col (3) of Table 3	Number of non-conforming pieces not to exceed corresponding number given in col (4) of Table 3
ii)	Count of yarn, colour fastness, dimensional change, fibre identification and scouring loss	According to col (5) of Table 3	All the test specimens to meet the corresponding requirements

7 MARKING

7.1 The cloth shall be suitably marked or labelled with

Table 1 Constructional Particulars of Handloom Cotton Madras Handkerchiefs

(Clause [4.1](#))

Sl No.	Variety No.	Count of Yarn (<i>see</i> Note 1)		Ends/cm	Picks/cm	Length m	Width cm	Weave
		Warp	Weft					
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)
i)	1	60 s (10 tex)	36 s (16 tex)	30	34	7	91	Plain agreed
ii)	2	60 s (10 tex)	36 s (16 tex)	32	38	or as declared	or as agreed	
iii)	3	60 s (10 tex)	40 s (15 tex)	30	40			
iv)	4	60 s (10 tex)	40 s (15 tex)	36	44			
Tolerance, Percent	—	± 5	± 5	± 5	± 5	<i>see</i> Note 2	± 2	—
Method of Test, Ref to	—	IS 3442		IS 1963		IS 1954		Visual

NOTES

1 Count of yarn is given for guidance only.

2 The length shall be not less than the declared or marked value.

the following information:

- Name of the material and variety number;
- Manufacturer's name, initials or trade-mark;
- Length and width of the cloth;
- 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(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, the cloth shall preferably be packed in bales or cases in conformity with the procedure laid down in IS 1347 or IS 293.

Table 2 Requirements of Handloom Cotton Madras Handkerchiefs*(Clause 4.2)*

Sl No.	Characteristic	Requirement	Method of Test, Ref to
(1)	(2)	(3)	(4)
i)	Colour fastness to:	4 or better	IS/ISO 105-B02
	a) Light	(see Note)	
	b) Washing Test 1	4 or better	IS/ISO 105-C10
ii)	Dimensional change, percent, <i>Max</i>	4	IS 2977
iii)	Scouring loss, percent, <i>Max</i>	10	IS 1383
iv)	Fibre identification	100 percent cotton	IS 667

NOTE — The rating specified is in accordance with IS 6906, which is the basic document on colour fastness ratings to various agencies.

Table 3 Sample Size and Permissible Number of Non-Conforming Pieces*(Clause 6.3)*

Sl No.	Lot Size (No. of Pieces)	Sample Size	Permissible Number of Non- Conforming Piece	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

ANNEX A

(Clause 2)

LIST OF REFERRED STANDARDS

<i>IS No.</i>	<i>Title</i>	<i>IS No.</i>	<i>Title</i>
IS 171 : 1993	Textiles — Ring spun grey cotton yarn for weaving — Specification (<i>fourth revision</i>)	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>)	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

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 (IIHT), Salem	DR P. THENNARASU
Indian Institute of Handloom Technology, Jodhpur	DR J. SIVAGNAMAM
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>)
Karnatka Khadi Gramodyog Samyuktha Sangha, Hubli	SHRI K. V. PATTAR SHRI SHIVANANDA S. MATHAPATI (<i>Alternate</i>)

IS 1093 : 2024

<i>Organization</i>	REPRESENTATIVE(S)
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>)
Khadi Gramodyog Mandal, Rampur	SHRI RAKESH CHAUDHARY SHRI PRINCE CHAUDHARY (<i>Alternate</i>)
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>)
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 BURAGOHAJIN (<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)	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, I. A. S. SHRI K. KATHIRESAN (<i>Alternate</i>)
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

Bureau of Indian Standards

BIS is a statutory institution established under the *Bureau of Indian Standards Act, 2016* to promote harmonious development of the activities of standardization, marking and quality certification of goods and attending to connected matters in the country.

Copyright

BIS has the copyright of all its publications. No part of these publications may be reproduced in any form without the prior permission in writing of BIS. This does not preclude the free use, in the course of implementing the standard, of necessary details, such as symbols and sizes, type or grade designations. Enquiries relating to copyright be addressed to the Head (Publication & Sales), BIS.

Review of Indian Standards

Amendments are issued to standards as the need arises on the basis of comments. Standards are also reviewed periodically; a standard along with amendments is reaffirmed when such review indicates that no changes are needed; if the review indicates that changes are needed, it is taken up for revision. Users of Indian Standards should ascertain that they are in possession of the latest amendments or edition by referring to the website-www.bis.gov.in or www.standardsbis.in.

This Indian Standard has been developed from Doc No.: TXD 08 (23969).

Amendments Issued Since Publication

Amend No.	Date of Issue	Text Affected

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

Regional Offices:

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

Telephones

{ 2323 7617

Eastern : 8th 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 : 5th Floor/MTNL CETTM, Technology Street, Hiranandani Gardens, Powai
Mumbai 400076

{ 25700030
25702715

Branches : AHMEDABAD, BENGALURU, BHOPAL, BHUBANESHWAR, CHANDIGARH, CHENNAI, COIMBATORE, DEHRADUN, DELHI, FARIDABAD, GHAZIABAD, GUWAHATI, HARYANA (CHANDIGARH), HUBLI, HYDERABAD, JAIPUR, JAMMU, JAMSHEDPUR, KOCHI, KOLKATA, LUCKNOW, MADURAI, MUMBAI, NAGPUR, NOIDA, PARWANOO, PATNA, PUNE, RAIPUR, RAJKOT, SU AT, VIJAYAWADA.