

वस्त्रादि — हथकरघा सूती डंगरी कपड़ा —
विशिष्टि

(दूसरा पुनरीक्षण)

Textiles — Handloom Cotton *Dungri*
Cloth — Specification

(Second Revision)

ICS 59.080.30

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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

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

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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.

Handloom cotton *Dungri* cloth is commonly used to create traditional Indian attire such as kurtas, salwar suits, and dresses.

This standard was first published in 1955 and subsequently revised in 1978. 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 *DUNGRI* CLOTH —
SPECIFICATION
(Second Revision)

1 SCOPE

1.1 This standard prescribes the constructional particulars and other requirements of three varieties of handloom cotton *Dungri* cloth, grey, bleached or dyed.

1.2 This standard does not specify the general appearance, feel, finish, 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 *Dungri* cloth shall be satisfactory in evenness and

reasonably free from neps and spinning defects. The yarn shall conform to Grade C of IS 171.

3.2 Cloth

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

4 REQUIREMENTS

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

4.2 The colour fastness ratings and other requirements of cloth shall conform to those given in [Table 2](#).

4.3 If 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.

Table 1 Constructional Particulars of Handloom Cotton *Dungri* Cloth

(*Clause* [4.1](#))

Sl No.	Variety No.	Count of yarn [Cotton Count (Universal Count)]		Ends/cm	Picks/cm	Length	Width	Weave
		Warp	Weft					
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)
i)	1	20s (30 tex)	20s (30 tex)	20	16	20 or as agreed	46, 90 or as agreed	2/2 Twill
ii)	2	20s/2 (30 tex × 2)	20s (30 tex)	12	9 (double)			Plain
iii)	3	20s/2 (30 tex × 2)	10s (59 tex)	10	11			plain
Tolerance Percent	—	± 5	± 5	± 5	± 5	—	± 2	—
Method of Test, Ref to	—	IS 3442		IS 1963		IS 1954		Visual

Table 2 Requirements of Handloom Cotton *Dungri* Cloth

(Clause 4.2)

SI No.	Characteristic	Requirement	Method of Test, Ref to
(1)	(2)	(3)	(4)
i)	Colour fastness to:		
	a) Light	5 or better	IS/ISO 105-B01 or IS/ISO B02
	b) Washing Test 4	4 or better	IS/ISO 105-C10
ii)	Dimensional change, percent, <i>Max</i>	4.0	IS 2977
iii)	Scouring loss, percent, <i>Max</i> :		IS 1383
	a) Grey	10	
	b) Bleached or dyed	2.5	
iv)	pH value of aqueous extract	6.0 to 8.5	IS 1390
v)	Fibre identification	100 percent cotton	IS 667

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

(Clause 6.3 and 6.4)

SI 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

5 INSPECTION

5.1 The cloth when visually inspected shall be reasonably free from the following defects:

- a) Weft crack or more than two missing picks across the width of the materials;
- b) Prominently noticeable weft bar due to the fineness in raw material, count, twist, lustre etc;
- c) More than two adjacent ends running parallel, broken or missing and extending beyond 15 cm;
- d) Prominent selvage defects;
- e) Noticeable warp or weft float in the body;
- f) Noticeable oil or other stains;
- g) Noticeable cut or tear up to 3 mm in size; and

- h) Smash rupturing the texture of the fabric.

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

6 SAMPLING

6.1 The quantity of handloom cotton *Dungri* cloth of the same variety delivered to a buyer against a despatch not shall constitute a lot.

6.2 To ascertain the conformity of the lot to the requirements of this standard, samples 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 Criterion for Conformity

<i>Sl No.</i>	<i>Characteristic(s)</i>	<i>No. of Tests</i>	<i>Criterion for Conformity</i>
(1)	(2)	(3)	(4)
i)	Visual examination, ends, picks, weave, length and width	According to col (3) of Table 3	Permissible number of non-conforming piece does not exceed the corresponding number given in col (4) of Table 3
ii)	Count of yarn, dimensional change, scouring loss and pH value, colour fastness and fibre identification	According to col (5) of Table 3	All the test specimens meet the relevant requirements

7 MARKING

7.1 The cloth shall be suitably marked or labelled with the following information:

- a) Name of the material;
- b) Manufacturer's name, initials or trade-mark;
- c) Length and width of the piece;
- 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 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.

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 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 1070 : 2023	Reagent grade water — Specification (<i>fourth 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>)
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>)
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>)
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>
Khadi and Village Industries Commission, Mumbai	SHRI VIJAYSRIDHAR DR SENTIL KUMAR C. B. (<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>)
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Orient Processes Pvt Ltd, Guwahati	SHRI ROBIN CHANDRA GOSWAMI SHRI RAJ BURAGOHAIN (<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>)]

Member Secretary
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

Regional Offices:

	Telephones
Central : 601/A, Konnectus Tower -1, 6 th Floor, DMRC Building, Bhavbhuti Marg, New Delhi 110002	{ 2323 7617
Eastern : 8 th 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 th Floor/MTNL CETTM, Technology Street, Hiranandani Gardens, Powai Mumbai 400076	{ 25700030 25702715

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