

वस्त्रादि — हथकरघा सूती टेबल कपड़ा और
नैपकिन — विशिष्टि

(दूसरा पुनरीक्षण)

Textiles — Handloom Cotton Table
Cloth and Napkins — 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.

This standard was first published in 1956 and subsequently revised in 1981. The standard has been revised again 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) pH 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* [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.

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.

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:

<i>Sl No.</i>	<i>Table Cloth</i>	<i>Napkin</i>
	Length (cm) × Width (cm)	Length (cm) × Width (cm)
(1)	(2)	(3)
i)	90 × 90	40 × 40
ii)	115 × 115	45 × 45
iii)	137 × 137	50 × 50
iv)	150 × 150	60 × 60
v)	215 × 170	—
vi)	365 × 170	—

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 1 Constructional Particulars of Handloom Cotton Table Cloth and Napkins

(Clause [4.1](#))

SI No.	Variety No.	Count of Yarn (<i>see Note</i>) [Cotton Count (Universal Count)]		Ends/ cm	Picks/ cm	Weave
		Warp	Weft			
(1)	(2)	(3)	(4)	(5)	(6)	(7)
i)	1	20s/2 (30 tex \times 2)	20s/2 (30 tex \times 2)	16	16	Plain, matt, honeycomb or huckaback
ii)	2	30s/2 (20 tex \times 2)	30s/2 (20 tex \times 2)	19	19	
iii)	3	40s/2 (15 tex \times 2)	40s/2 (15 tex \times 2)	24	24	
iv)	4	40s/2 (15 tex \times 2)	30s/2 (20 tex \times 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.						

Table 2 Requirements of Handloom Cotton Table Cloth and Napkins

(Clause [4.3](#))

SI No.	Characteristic	Requirement	Method of Test, Ref to
(1)	(2)	(3)	(4)
i)	Colour fastness to (<i>see Note</i>):		
	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
ii)	Dimensional change, percent, <i>Max</i>	4	IS 2977
iii)	Scouring loss, percent, <i>Max</i>	2.5	IS 1383
iv)	pH 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.

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.

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

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

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 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

6.4 Number of Samples and Criteria 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)	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 col (4) of Table 3
ii)	Dimensional change, scouring loss, count, colour fastness, pH 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

<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 1390 : 2022/ ISO 3071 : 2020	and finished cotton textile material (<i>second revision</i>) Textiles — Determination of pH of aqueous extract (<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 1720 : 1978	Specification for cotton sewing threads (<i>first revision</i>)
IS/ISO 105-C10 : 2006	Textiles — Tests forecolor 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 171 : 1993	Textiles — Ring spun grey cotton yarn for weaving — Specification (<i>fourth revision</i>)	IS 2977 : 1989	Fabrics (other than wool) — Method for determination of dimensional changes on soaking in water (<i>first revision</i>)
IS 293 : 1980	Code for seaworthy packaging of cotton yarn and cloth (<i>third revision</i>)	IS 3442 : 2023	Textiles — Method for determination of crimp and linear density of yarn removed from fabric
IS 667 : 1981	Methods for identification of textile fibres (<i>first revision</i>)	IS 12646 : 1991	Textiles — Colour fastness ratings — Specification (<i>first 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		

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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 (<i>Chairperson</i>) 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>)
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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
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>)

<i>Organization</i>	<i>Representative(s)</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
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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 Railways, New Delhi	SHRI SANJEEV KUMAR JAIN SHRI RAJESH KUMAR (<i>Alternate</i>)
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Office of the Development Commissioner for Handlooms, New Delhi	SHRI SIDDHARTH SINGH SHRI VINAY KUMAR (<i>Alternate</i>)
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The Cotton Textiles Export Promotion Council (TEXPROCIL), Mumbai	DR SIDDHARTHA RAJAGOPAL SHRI RAJESH SATAM (<i>Alternate</i>)
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The Tamil Nadu Handloom Weavers' Cooperative Society Ltd, Chennai	SHRI T. N. VENKATESH SHRI K. KATHIRESAN (<i>Alternate</i>)
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