
हथकरघा निर्मित रेशमी धोतियां और छपी
साड़ियां — विशिष्टि
(दूसरा पुनरीक्षण)

**Handloom Silk *Dhoti* and Printed
Sari — Specification**
(*Second Revision*)

ICS 59.080.30

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FOREWORD

This Indian Standard was adopted by the Bureau of Indian Standards, after the draft finalized by the Silk and Silk Products Sectional Committee had been approved by the Textile Division Council.

This standard was first published in 1960 and subsequently revised in 1991. The second revision has been made in the light of experience gained since its last revision and to incorporate the following major changes:

- a) Test for banned azo colorants has been incorporated;
- b) Packing and marking clauses have been updated; and
- c) References to the Indian standards have been updated.

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

**HANDLOOM SILK *DHOTI* AND
PRINTED *SARI* — SPECIFICATION**

(*Second Revision*)

1 SCOPE

1.1 This standard prescribes constructional particulars and other requirements for ten varieties of silk *dhoti* and printed *sari* woven in handlooms.

1.2 This standard does not specify the general appearance, colour or feel of the fabrics.

2 REFERENCES

The standards listed in Annex A contain provisions which through reference in this text, constitute provision 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 ATMOSPHERIC CONDITIONS FOR TESTING

Test specimens may be conditioned and tested in the prevailing atmosphere for determining the conformity of fabric to this standard. However, in all cases of disputes, specimens shall be conditioned and tested in the standard atmosphere as specified in the referred Indian Standards on test methods (*see IS 6359*).

4 GENERAL REQUIREMENTS**4.1 Yarn**

4.1.1 The yarn shall be identified as silk by the method prescribed in IS 667.

4.1.2 The yarn used in the manufacture of fabric shall be evenly reeled and reasonably free from flaws so that the fabric produced complies with the requirements of this standard.

5 SPECIFIC REQUIREMENTS

5.1 The fabric shall conform to the requirements specified in Table 1.

5.2 The fabric shall also conform to the requirements specified in Table 2.

5.3 In order to illustrate or specify the indeterminable characteristics, such as general

appearance, luster, feel and shade, a sample has been agreed upon and sealed, the supply shall be in conformity with the sample in such respects.

5.3.1 If agreed between buyer and seller the presence of banned azo colorants in dyed silk *dhoti* and printed *sari* shall be tested as per method prescribed in IS 15570.

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

6 INSPECTION

6.1 The fabric when visually inspected should be free from the major flaws.

6.1.1 The number of permissible major flaws per unit length shall be as agreed to between the buyer and the seller.

6.2 For details of the flaws mentioned in **6.1**, a reference may be made to IS 14466.

7 MARKING

7.1 The fabric shall be suitably marked with the following information:

- a) Manufacturer's name, initials, or trade-mark;
- b) Name of the material and variety No.;
- c) Length (m) and width (cm); and
- d) Indication of the source of manufacture.

7.1.1 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 there under, and the products may be marked with the Standard Mark.

8 PACKING

Unless otherwise agreed upon by the buyer and seller the fabric shall preferably be packed in conformity with the procedure laid down in IS 2194 or IS 2195.

Table 1 Constructional Particulars for Silk *Dhoti* and *Sari*

(Clause 5.1)

Variety No.	Count of Yarns		Ends/dm, <i>Min</i>	Picks/dm, <i>Min</i>	Mass g/m ² , <i>Min</i>	Breaking Load on 15 cm × 20 cm Strip kgf, <i>Min</i>		Weave	Length m (see Note)	Width cm, <i>Min</i>
	Warp, tex (denier)	Weft, tex (denier)				Warp	Weft			
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)	(10)	(11)
1	3.1 to 3.6 (27.9 to 32.4) (single)	2.2 to 2.4 (19.8 to 21.6) (3 ply)	390	410	40	16	44	Plain	As declared	115 or as declared
2	2.2 to 2.4 (19.8 to 21.6) (2 ply)	2.2 to 2.4 (19.8 to 21.6) (3 ply)	390	350	45	25	34			
3	- do -	- do -	470	440	50	30	50			
4	3.6 to 3.8 (32.4 to 34.2)	2.4 to 2.6 (21.6 to 23.4) (2 ply)	418	418	35	18	20			
5	3.2 to 3.6 (28.8 to 32.4)	3.2 to 3.6 (28.8 to 32.4)	394	456	25	16	18			
6	2.4 to 2.6 (21.6 to 23.4)	2.8 to 3.2 (25.2 to 28.8)	410	410	20	14	16			
7	2.4 to 2.6 (21.6 to 23.4) (2 ply)	2.2 to 2.4 (19.8/21.6) (3 ply)	394	394	35	18	20			
8	-do-	2.4 to 2.6 (21.6 to 23.4) (2 ply)	418	418	45	20	20			
9	-do-	-do-	425	378	40	18	18			
10	1.4 to 1.7 (12.6 to 15.3) (2 ply)	2.4 to 2.6 (21.6 to 23.4)	434	434	25	16	16			
Method of Test, Ref to	IS 15090 (Part 5)		IS 1963		IS 1964 and Annex B	IS 1969 (Part 1)		—	IS 1954	

NOTE — The average length of fabric shall not be less than the declared length.

Table 2 Other Requirements for Silk *Dhoti* and Printed *Sari*

(Clause 5.2)

SI No.	Characteristics	Requirement	Method of Test, Ref to
(1)	(2)	(3)	(4)
i)	Dimensional change, percent, <i>Max</i>	4	IS 3561
ii)	Degumming loss, percent, <i>Max</i>	1.5	IS 1582
iii)	Colour fastness:		
	a) Light	4 or better	IS/ISO 105-B01 or IS/ISO 105-B02
	b) Washing:		
	1) Change in colour	4 or better	IS/ISO 105-C10
	2) Staining on fabric	4 or better	IS/ISO 105-A03
	c) Dry cleaning	4 or better	IS/ISO 105-D01

9 SAMPLING**9.1 Lot**

The quantity of the fabric of the same variety delivered to one buyer against one dispatch note shall constitute a lot.

9.2 The conformity of the lot to the various requirements specified in the standard shall be determined on the basis of tests carried out on the samples selected from the lot.

9.3 Unless otherwise agreed, the number of pieces selected at random for inspection shall be in accordance with Table 3.

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

(Clause 9.3)

SI No.	Lot Size	Sample Size	Permissible Number of Non-Conforming Pieces	Sub-Sample Size
(1)	(2)	(3)	(4)	(5)
i)	Up to 25	3	0	2
ii)	26 to 50	5	0	2
iii)	51 to 150	8	0	3
iv)	151 to 300	13	1	3
v)	301 to 500	20	1	5
vi)	501 to 1 000	32	2	5
vii)	1 001 and above	50	3	8

9.3.1 For selection of samples at random from the lot, procedure given in IS 4905 may be followed.

9.4 Number of Samples and Criteria for Conformity

9.4.1 Number of test specimens and criteria for conformity shall be as given in Table 4.

Table 4 Number of Test Specimens and Criteria for Conformity

(Clause 9.4.1)

Sl No.	Characteristics	Number of Samples	Criteria for Conformity
(1)	(2)	(3)	(4)
i)	Ends, picks, mass, length, width and visual inspection	According to col1 (3) of Table 3	Number of non-conforming pieces shall not exceed the corresponding number given in col1 (4) of Table 3
ii)	Dimensional change, colour fastness and degumming loss	According to col1 (5) of Table 3	All that test pieces shall meet the requirement

ANNEX A

(Clause 2)

LIST OF REFERRED STANDARDS

<i>IS No</i>	<i>Title</i>	<i>IS No</i>	<i>Title</i>
IS 1582 : 2017	Textiles — Silk yarn and fabrics — Determination of degumming loss (<i>first revision</i>)	IS 4905 : 2015/ ISO 24153 : 2009	Random sampling and randomization procedures (<i>first revision</i>)
IS 1954 : 1990	Determination of length and width of woven fabrics — Methods (<i>second revision</i>)	IS 6359 : 2023	Method for conditioning of textiles (<i>first revision</i>)
IS 1963 : 1981	Methods for determination of threads per unit length in woven fabrics (<i>second revision</i>)	IS 14466 : 1997	Fabrics — Description of defects — Vocabulary
IS 1964 : 2001	Textiles — Methods for determination of mass per unit length and mass per unit area of fabrics (<i>second revision</i>)	IS 15090 (Parts 1 to 11) : 2002	Raw silk — Grading and methods of tests: Parts 1 to 11
IS 1969 (Part 1) : 2018/ISO 13934 -1 : 2013	Textiles — Tensile properties of fabrics: Part 1 Determination of maximum force and elongation at maximum force using the strip method (<i>fourth revision</i>)	IS/ISO 105-A03 : 2019	Textiles — Tests for colour fastness: Part A03 Grey scale for assessing staining (<i>first revision</i>)
IS 2194 : 1963	Code for seaworthy packaging of man-made fibre fabrics	IS/ISO 105-B01 : 2014	Textiles — Tests for colour fastness: Part B01 Colour fastness to light: Daylight
IS 2195 : 1964	Code for inland packaging of man-made fibre fabrics and man-made fibre yarns	IS/ISO 105-B02 : 2014	Textiles — Tests for colour fastness: Part B02 Colour fastness to artificial light: Xenon arc fading lamp test
IS 3561 : 1989	Silk fabrics — Dimensional changes on washing — Method for determination (<i>first 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/ISO 105-D01 : 2010	Textiles — Tests for colour fastness: Part D01 Colour fastness to drycleaning using perchloroethylene solvent

ANNEX B

[Table 1, col (6)]

METHOD FOR DETERMINATION OF MASS OF FABRIC

B-1 Cut four specimens of 100 mm × 100 mm from a sample. Condition all the specimens in the desiccator charged with saturated solution of sodium nitrate at (27 ± 2) °C for a period of 24 hours. Remove all the specimens from the desiccator and

immediately determine their collective mass in weighing balance to the nearest milligram.

B-2 Calculate mass of fabric in g/m².

ANNEX C

(Foreword)

COMMITTEE COMPOSITION

Silk and Silk Products Sectional Committee, TXD 28

<i>Organization</i>	<i>Representative(s)</i>
Central Silk Board, Bengaluru	DR Y. C. RADHLAKSHMI (Chairperson)
Anwar Silk Industries, Sidlaghatta, Karnataka	SHRI MOHAMMED HASEEB
Association of Corporations and Apex Societies of Handlooms, New Delhi	SHRI PALLAB TALUKDAR
Central Silk Technological Research Institute, Bengaluru	DR S. NIVEDITA DR PRAKASH N. BHAT (<i>Alternate</i>)
Chamundi Textiles Silk Mills Limited, Bengaluru	SHRI A. L. MUTHIAH
Directorate of Handicraft and Handloom, Kashmir	SHRI IMTIYAZ AHMAD DAR ZAHOR AHMAD KHAN (<i>Alternate</i>)
Directorate of Handlooms and Textiles, Government of Tamilnadu, Chennai	SHRI THIRU C. MUNIANATHAN DR K. KARNAN (<i>Alternate</i>)
Directorate of Handlooms and Textiles, Guwahati	SHRI ATAUR RAHMAN SHRI NAREN MALAKAR (<i>Alternate</i>)
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Indian Silk Export Promotion Council, New Delhi	SHRI SANJEEV KUMAR SHARMA
Jaipuria Silk Mills, Bangalore	SHRI VIKRAM JAIPURIA
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Karnataka Silk Industries Corporation, Bengaluru	SHRI SIDDALINGA PRASAD S. G. SHRI D. S. SANGAM (<i>Alternate</i>)
Karnataka State Sericulture Development Institute, Thalaghattapura	SHRI A. JAMBUNATH
Khadi and Village Industries Commission, Mumbai	SHRI D. DHANPAL SHRI J. K. GUPTA (<i>Alternate</i>)
National Handloom Development Corporation Limited, Greater Noida	SHRI SAKTHIVEL PERUMALSAMY SHRI JITENDRA TOLAMBIYA (<i>Alternate</i>)
Office of Director of Handlooms and Textiles, New Delhi	JOINT DIRECTOR (TEXTILES) DY DIRECTOR (HANDLOOMS) (<i>Alternate</i>)
Office of the Development Commissioner for Handlooms, New Delhi	DR AMIN HIRENBHAI NAVINBHAI
Office of the Textile Commissioner, Mumbai	SHRI PRANAV PARASHAR N. K. GUPTA (<i>Alternate</i>)
Savanadurgha narashimma swamy silk reeling factory, Ramanagara, Karnataka	SHRI NAGANNA
Shriram Institute for Industrial Research, Delhi	SHRI VINAY KUMAR SAMANIA SHRI BHUVNESHWAR RAI (<i>Alternate</i>)
Silk Mark Organisation of India, Bengaluru	SHRI K. S. GOPAL SHRI A. SUBBARAJ (<i>Alternate</i>)

<i>Organization</i>	<i>Representative(s)</i>
Tamil Nadu Co-operative Silk Producers Federation Limited (TANSILK), Kancheepuram	SHRI P. MURUGAN P. ARULMOZHI (<i>Alternate</i>)
Textiles Committee, Mumbai	DR P. RAVICHANDRAN SHRI KARTIKAY DHANDA (<i>Alternate</i>)
The Bombay Textile Research Association, Mumbai	SHITAL PALASKAR SHRI AMOL THITE (<i>Alternate</i>)
The Tamil Nadu Handloom Weavers Co-operative Society Limited, Chennai	SHRI G. GUNASEKARAN
Vinegar Exports Private Limited, Bengaluru	BIMAL MAWANDIA
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Member Secretary
SHRI BANOTHU RANGA
SCIENTIST 'B'/ASSISTANT DIRECTOR
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