

भारतीय मानक ब्यूरो
BUREAU OF INDIAN STANDARDS

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भारतीय मानक मसौदा

वस्त्रादि – हथकरघा सूती मद्रास रूमाल – विशिष्टि

(आई एस 1093 का दूसरा पुनरीक्षण)

Draft Indian Standard

**TEXTILES — HANDLOOM COTTON MADRAS HANDKERCHIEFS —
SPECIFICATION**

(Second Revision of IS 1093)

ICS 59.080.30

Handloom and Khadi Sectional Committee,
TXD 08

Last date for receipt of comment is
19 April 2024

FOREWORD

(Formal clauses will be added later)

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

This standard was originally published in 1957 and subsequently revised in 1981. The standard has again been revised 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 Indian Standards have been updated.

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.

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 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 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.

4.3.1 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 Madras Handkerchiefs
(Clause 3.1)

SI No.	Variety No.	Count of Yarn (See Note 1)		Ends/cm	Picks/cm	Length m	Width cm	Weave
		Warp	Weft					
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)
i)	1	60s (10 tex)	36s (16 tex)	30	34	7 or as declared	91 or as agreed	plain
ii)	2	60s (10 tex)	36s (16 tex)	32	38			
iii)	3	60s (10 tex)	40s (15 tex)	30	40			
iv)	4	60s (10 tex)	40s (15 tex)	36	44			
Tolerance, percent	—	± 5	± 5	± 5	± 5	see 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.

Table 2 Requirements of Handloom Cotton Madras Handkerchiefs
(Clause 3.2)

SI No.	Characteristic	Requirement	Method of Test
(1)	(2)	(3)	(4)
i)	Colour fastness to: a) Light b) Washing Test 1	4 or better (<i>see</i> Note)	IS/ISO 105-B02 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.

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 selvage 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.

5.1.1 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.

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 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 Tests and Criteria for Conformity

SI 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 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 cloth;
- 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 INDIAN STANDARDS

<i>IS No.</i>	<i>Title</i>
IS 171 : 1993	Textiles — Ring spun grey cotton yarn for weaving — Specification (<i>fourth revision</i>)
IS 293 : 1980	Code for seaworthy packaging of cotton yarn and cloth (<i>third revision</i>)
IS 667 : 1981	Methods for identification of textile fibres (<i>first revision</i>)
IS 1347 : 1972	Specification for inland packaging of cotton cloth and yarn (<i>first revision</i>)
IS 1383 : 2023	Methods for determination of scouring loss in grey and finished cotton textile materials (<i>second revision</i>)
IS 1954 : 1990	Determination of length and width of woven fabrics — Methods (<i>second revision</i>)
IS 1963 : 1981	Methods for determination of threads per unit length in woven fabrics (<i>second revision</i>)
IS 2977 : 1989	Fabrics (other than wool) — Method for determination of dimensional changes on soaking in water (<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 14466 : 1997/ ISO ISO 8498 : 1990	Fabrics — Description of defects — Vocabulary
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 for colour fastness — Part C10 Colour fastness to washing with soap or soap and soda