

भारतीय मानक ब्यूरो
BUREAU OF INDIAN STANDARDS

For comments purpose only

Doc. No: TXD 08 (27410)
January 2025

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भारतीय मानक मसौदा

वस्त्रादि – नेपकिन्स एवं मेज का कपडा, विरंजित सूती खादी – विशिष्टि

(आई एस 3773 का दूसरा पुनरीक्षण)

Draft Indian Standard

**TEXTILES — NAPKINS AND TABLE CLOTH, BLEACHED COTTON
KHADI — SPECIFICATION**

(Second Revision of IS 3773)

ICS 59.080.30

Handloom and khadi sectional committee, TXD 08

Last date for receipt of comment is
22 March 2025

FOREWORD

(Formal clauses will be added later)

These dining textiles are crafted from handspun and handwoven cotton khadi, renowned for its durability and eco-friendly qualities. The napkins and tablecloth are bleached to a bright, crisp white, giving them a refined look ideal for various occasions.

This standard was originally published in 1966 and was revised in 1994. This standard has been again revised to incorporate the following changes:

- a) Method for fiber identification has been incorporated;
- b) References to Indian Standards have been updated;
- c) Marking clause has been modified; and
- d) Sampling clause has been modified.

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, 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 constructional particulars and other requirements of two varieties of napkins and table cloth, cotton, khadi, bleached.

1.2 This standard does not specify the general appearance, feel, shade, etc, of the cloth.

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 subjected to revision, and parties to agreements based on this standard are encourage to investigate the possibility of applying the most recent editions of the standards indicated in Annex A.

3 ATMOSPHERIC CONDITIONS FOR TESTING

Test specimens may be conditioned and tested in the prevailing atmospheric conditions for checking the conformity of the cloth to the standard. However, in case of dispute, specimens shall be conditioned and tested in the standard atmosphere as specified in the referred Indian Standards on test methods.

4 GENERAL REQUIREMENTS

4.1 Yarn

The yarn used in the manufacture of cloth shall be hand-spun from clean carded cotton. It shall be reasonably even and free from leaf particles, slubs, neps and other spinning defects. The approximate count of warp and weft yarn is given in Table 1.

4.2 Cloth

4.2.1 The selvages shall be firm and well woven.

4.2.2 Each transverse end of the table cloth shall be hemmed to a depth of not less than 12 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. The table cloth and napkins may have fringes instead of hemming. The length of fringes, with or without knot, shall be 35 mm, minimum.

Table 1 Constructional Particulars and Breaking Load Requirements for Napkins and Table Cloth, Bleached Cotton Khadi
(Clause 4.1 and 5.1)

SI No.	Variety No.	Count of Yarn (for Guidance only) Universal Count (Cotton Count)		Ends/ dm	Picks/ dm	Mass g/m ²	Breaking Load (on 10.0 cm × 20 cm Strips) N	
		Warp	Weft				Warp	Weft
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)
i)	1	37 tex (16s)	37 tex (16s)	142 Double	126 Double	205	760	660
ii)	2	37 tex (16s)	49 tex (12s)	174	174	160	390	370
iii)	Tolerance, percent (<i>see</i> Note)	—	—	± 5	± 5	± 5	-10	-10
iv)	Method of Test, Ref to	IS 3442		IS 1963		IS 1964 or Annex C	IS 1969 (Part 1)	

NOTE — Any increase in values of ends/dm, picks/dm or mass (g/m²) beyond positive tolerance shall not be a cause of rejection of the fabric.

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

4.2.4 The cloth, when visually examined, shall be reasonably free from spinning, weaving and processing defects.

5 REQUIREMENTS

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

5.2 The napkins and table cloth shall also conform to the requirements specified in Table 2.

Table 2 Other Requirements for Napkins and Table Cloth, Bleached Cotton Khadi
(Clause 5.2)

SI No.	Characteristics	Requirement	Method of Test, Ref to
(1)	(2)	(3)	(4)
i)	Dimensional change, percent, <i>Max</i>	5	IS 2977
ii)	Scouring loss, percent, <i>Max</i>	2.5	IS 1383
iii)	pH value of the aqueous extract	6.0 to 8.5	IS 1390
iv)	Fiber identification	100 percent cotton	IS 667

5.3 The cloth shall be woven in plain weave.

5.4 Dimensions

Length and width of the napkins and table cloth when determined in accordance with IS 1954 shall be as agreed to between the buyer and the seller or as declared by the seller. However, a tolerance of ± 2 cm shall be permitted on length and width.

5.5 Sealed Sample

5.5.1 In order to illustrate or specify the indeterminable characteristics, such as general appearance, lustre, feel and shade, 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.

6 INSPECTION

6.1 The napkins and table cloth when visually inspected shall be free from the major flaws listed at Annex B.

However, the number of permissible major flaws per piece 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 SAMPLING

7.1 Lot

The quantity of handloom cotton cloth of the same variety, width and colour delivered to a buyer at a time shall constitute a lot.

7.2 To ascertain the conformity of the lot to the requirements of this standard, samples shall be drawn and inspected from each lot separately.

7.3 The number of pieces selected at random for inspection in accordance with Table 3.

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

Table 3 Sample Size and Permissible Number of Non-conforming pieces
(Clause 7.3 and 7.5)

Sl No.	Lot Size	Sample Size	Permissible No. of Non-Conforming 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 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

7.5 Number of Samples and Criteria for Conformity

Sl No.	Characteristics	Number of Samples	Criteria of Conformity
(1)	(2)	(3)	(4)
i)	Ends, picks, mass, length, width 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 sourcing loss, pH value, breaking load, and fiber identification	According to col (5) of Table 3	All the test specimens shall meet the corresponding requirements

8 MARKING

8.1 The napkins and table cloth shall be suitably marked with the following information:

- a) Name of the material, and variety number;
- b) Manufacturer's name, initials or trade-mark;
- c) Month and year of manufacture;
- d) Length (cm) and width (cm);
- e) Indication of the source of manufacture; and
- f) Other declarations required as per law in force.

8.1.1 The napkins and table cloth may also be marked with the Standard Mark.

8.2 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.

9 PACKING

9.1 Fold each piece of napkin and table cloth into a suitable size and arrange a suitable number of pieces into a bundle. Wrap each bundle in a material such as strong paper, polyethylene sheet, etc., which will not cause any stain on the cloth. Unless otherwise agreed, pack these bundles in the form of 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>
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 1390 : 2022/ ISO 3071 : 2020	Textiles — Determination of pH of aqueous extract (<i>third revision</i>)
IS 1954 : 2024/ ISO 22198 : 2006	Textiles — Fabrics — Determination of width and length (<i>third revision</i>)
IS 1963 : 1981	Methods for determination of threads per unit length in woven fabrics (<i>second revision</i>)
IS 1964 : 2001	Textiles — Methods for determination of mass per unit length and mass per unit area of fabrics (<i>second revision</i>)
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 2977 : 1989	Fabrics (other than wool) — Methods for determination of dimensional changes of woven fabrics (other than wool) on soaking in water (<i>first revision</i>)
IS 4905 : 2015/ ISO 24153 : 2009	Random sampling and randomization procedures (<i>first revision</i>)
IS 14466 : 1997// ISO 8498 : 1990	Fabrics — Description of defects — Vocabulary

ANNEX B
(*Clause 6.1*)

LIST OF MAJOR FLAWS

- a) One or more ends missing in the body of the material throughout its length, more than three ends missing at a place and running over 60 cm, or prominently noticeable double end running throughout the piece;
- b) Undressed snarls noticeable over a length exceeding 5 percent of the length of the piece;
- c) Smash definitely rupturing the texture of the fabric;
- d) Hole, cut or tear;
- e) Reed marks prominently noticeable over a length exceeding 5 percent of the piece;
- f) Defective or damaged selvedge noticeable over a length exceeding 5 percent of the length of the piece;
- g) Weft crack of two or more missing picks across width of the fabric;
- h) Warp or weft bar due to the difference in raw material, count, twist, lustre, or spacing of adjacent groups of yarns (starting mark);
- j) More than two adjacent ends running parallel, broken or missing and extending beyond 10 cm;
- k) Noticeable warp or weft float in the body of the fabric;
- m) Noticeable oil or other stain in the fabric;
- n) Oily weft in the fabric;
- p) Prominently noticeable slub;
- q) Gout due to foreign matter usually lint or waste woven into the fabric;
- r) Prominent selvedge defect; and
- s) Fuzzy appearance.

ANNEX C

(Table 1)

METHOD FOR DETERMINATION OF MASS OF FABRIC

C-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 $27\text{ }^{\circ}\text{C} \pm 2\text{ }^{\circ}\text{C}$ 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.

C-2 Calculate mass of fabric in g/m^2 .