

**भारतीय मानक ब्यूरो**  
**BUREAU OF INDIAN STANDARDS**

*Draft for comments only*

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*भारतीय मानक मसौदा*

**वस्त्रादि – हथकरघा सूती गदा कपड़ा – विशिष्ट**

*( आई एस 1094 का दूसरा पुनरीक्षण )*

*Draft Indian Standard*

**TEXTILES — HANDLOOM COTTON GADA CLOTH —  
SPECIFICATION**

*( Second Revision of IS 1094 )*

**ICS 59.080.30**

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Handloom and khadi sectional committee,  
TXD 08

Last date for receipt of comment is  
14 April 2024

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**FOREWORD**

*(Formal clauses will be added later)*

This standard was originally published in 1957 and subsequently revised in 1976. 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 incorporated;
- d) Amendment has been incorporated; and
- e) 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, shall be rounding 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 ten varieties of handloom cotton gada cloth, grey.

**1.2** This standard does not specify the general appearance, feel, finish, etc, of the gada 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 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

Gada cloth shall be woven in plain weave using yarn conforming to IS 171. The constructional particulars shall conform to those given in Table 1.

**Table 1 Constructional Particulars of Handloom Cotton Gada Cloth**  
(Clause 3)

Sl No.	Variety No.	Count of Yarn		Ends/cm	Picks/cm
		Warp	Weft		
(1)	(2)	(3)	(4)	(5)	(6)
i)	1	10s (59 tex)	6s (100 tex)	14	11
ii)	2	10s (59 tex)	10s (59 tex)	14	14
iii)	3	16s (36 tex)	16s (36 tex)	17	17
iv)	4	20s (30 tex)	30s (20 tex)	19	19
v)	5	20s (30 tex)	20s (30 tex)	20	19
vi)	6	30s (20 tex)	30s (20 tex)	24	21
vii)	7	34s (17.5 tex)	34s (17.5 tex)	24	22
viii)	8	40s (14.5 tex)	40s (14.5 tex)	25	24
ix)	9	60s (10 tex)	40s (14.5 tex)	34	38
x)	10	60s (10 tex)	60s (10 tex)	28	25
Tolerance	—	± 5 percent	± 5 percent	± 5 percent	± 5 percent
Method of Test, Ref to	—	IS 1315		IS 1963	

## 4 REQUIREMENTS

Other requirements of gada cloth shall conform to those given in Table 2.

## 5 INSPECTION

The gada cloth when visually inspected should be reasonably free from the following defects (*see* IS 14466):

- a) Weft crack of more than 2 missing picks across the width of the material;
- b) Prominently noticeable weft bar due to the difference in raw material, count, twist, or pick spacing of adjacent groups of weft yarn;
- c) More than two adjacent ends running parallel, broken or missing and extending beyond 15 cm;
- d) Prominent selvedge defect;
- e) Noticeable warp or weft float in the body of the material;
- f) Noticeable oil or other stain in the material;
- g) Noticeable hole, cut or tear up to 3 mm in size in the body of the fabric; and
- h) Smash definitely rupturing the texture of the material.

**Table 2 Other Requirements of Handloom Cotton Gada Cloth**  
(Clause 4)

Sl No.	Characteristic	Requirement	Method of Test, Ref to
(1)	(2)	(3)	(4)
i)	Dimensional changes, percent, <i>Max</i>	6.0	IS 2977
ii)	Scouring loss, percent, <i>Max</i>	5.0	IS 1383
iii)	Fibre identification	100 percent cotton	IS 667

## 6 SAMPLING

**6.1** The quantity of handloom cotton gada 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.

**Table 3 Sample Size and Permissible Number of Non-Conforming Pieces**  
(Clause 6.3)

Sl 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 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 Criterion for Conformity

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

### 7 MARKING

**7.1** Gada cloth shall be suitably marked with the following information:

- a) Name of the material;
- b) Manufacturer's name, initials or trade-mark;
- c) Length and width;
- 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 either 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 1315:1977	Method for determination of linear density of yarns spun on cotton system ( <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 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 14466 : 1997/ ISO 8498 : 1990	Fabrics — Description of defects — Vocabulary