

भारतीय मानक ब्यूरो
BUREAU OF INDIAN STANDARDS

Draft for comments only

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भारतीय मानक मसौदा

वस्त्रादि – हथकरघा सूती टेबल कपड़ा और नैपकिन – विशिष्ट

(आई एस 858 का दूसरा पुनरीक्षण)

Draft Indian Standard

**TEXTILES — HANDLOOM COTTON TABLE CLOTH AND NAPKINS —
SPECIFICATION**

(Second Revision of IS 858)

ICS 59.080.30

Handloom and khadi sectional committee,
TXD 08

Last date for receipt of comment is
23 April 2024

FOREWORD

(Formal clauses will be added later)

This standard was originally published in 1956 and subsequently revised in 1981. The standard has again been revised 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) Method of test for count of yarn along with its tolerance has been specified; and
- f) 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 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 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 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 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.

3.3.1 Cotton sewing thread of 60s/6 (100 dtex \times 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>Table Cloth</i>	<i>Napkin</i>
(1)	(2)
Length × Width cm cm	Length × Width cm cm
90 × 90	40 × 40
115 × 115	45 × 45
137 × 137	50 × 50
150 × 150	60 × 60
215 × 170	
365 × 170	

Table 1 Constructional Particulars of Handloom Cotton Table Cloth and Napkins
(Clause 4.1)

Sl 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 × 2)	20s/2 (30 tex × 2)	16	16	Plain, matt, honeycomb or huckaback
ii)	2	30s/2 (20 tex × 2)	30s/2 (20 tex × 2)	19	19	
iii)	3	40s/2 (15 tex × 2)	40s/2 (15 tex × 2)	24	24	
iv)	4	40s/2 (15 tex × 2)	30s/2 (20 tex × 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.						

4.2.1 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 2 Requirements of Handloom Cotton Table Cloth and Napkins
(Clause 4.3)

Sl No.	Characteristic	Requirement	Method of Test
(1)	(2)	(3)	(4)
i)	Colour fastness to (<i>see</i> Note): a) Light b) Washing Test 4 c) Bleaching	4 or better 3 or better 4 or better	IS/ISO 105-B01 or IS/ISO 105-B02 IS/ISO 105-C10 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)	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.

4.4.1 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 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 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.

5.1.1 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
(Clause 6.3)

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

6.4 Number of Samples and Criteria for Conformity

Sl No.	Characteristic(s)	No. of Tests	Criterion for Conformity
(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 and fibre identification	According to col (5) of Table 3	All the test specimens meet the relevant requirements
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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 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 material (<i>second revision</i>)
IS 1720 : 1978	Specification for cotton sewing threads (<i>first 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
IS 12646 : 1991	Textiles — Colour fastness ratings — Specification (<i>first revision</i>)
IS/ISO 105-B01 : 2014	Textiles — Tests for colour fastness — Part B01 Colour fastness to light: Daylight
IS 14466 : 1997/ 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 forecolor fastness — Part C10 Colour fastness to washing with soap or soap and soda
IS/ISO 105-N01 : 1993	Textiles — Tests for colour fastness — Part N01 Colour fastness to bleaching: Hypochlorite