

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

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**भारतीय मानक मसौदा**

**वस्त्रादि – हथकरघा निर्मित विस्कोस स्टेपल धागे की लुंगीयां – विशिष्ट**

*( आई एस 2158 का दूसरा पुनरीक्षण )*

*Draft Indian Standard*

**TEXTILES — HANDLOOM VISCOSE STAPLE FIBRE LUNGIES —  
SPECIFICATION**

*( Second Revision of IS 2158 )*

**ICS 59.080.30**

Handloom and khadi sectional committee,  
TXD 08

Last date for receipt of comment is  
03 May 2024

**FOREWORD**

*(Formal clauses will be added later)*

This standard was originally published in 1962 and subsequently revised in 1991. 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) Method of test for count of yarn along with its tolerance has been specified;
- d) Test method for identification of material has been incorporated; and
- e) 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 constructional particulars and other requirements for two varieties of handloom viscose staple fibre lungies.

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

## **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 editions of the standards indicated in Annex A.

## **3 ATMOSPHERIC CONDITIONS FOR TESTING**

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

## **4 MANUFACTURE**

### **4.1 Yarn**

The viscose staple fibre yarn used in manufacture of cloth shall be such that the cloth produced complies with the requirements of this standard.

**4.2** The cloth shall be of plain weave and free from substances liable to cause subsequent tendering.

## **5 REQUIREMENTS**

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

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

**Table 1 Constructional Particulars and Breaking Load Requirements for Handloom  
Viscose Staple Fibre Lungies**  
(Clause 5.1)

Sl No.	Variety No.	Count of Yarn (for guidance only) Universal Count (Cotton Count)		Ends/dm	Picks/dm	Mass g/m <sup>2</sup>	Breaking Load Newton	
		Warp	Weft				Warp	Weft
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)
i)	1	15 tex × 2 (40s/2)	20 tex (30s)	213	220	110	392	275
ii)	2	15 tex × 2 (40s/2)	15 tex (40s)	200	200	95	294	245
Tolerance, Percent	—	± 5	± 5	± 5	± 5	± 5	- 5 on average value and - 15 on individual reading	
Method of Test, Ref to	—	IS 3442		IS 1963		IS 1964 or Annex D	IS 1969 (Part 1)	

**Table 2 Other Requirements for Handloom Viscose Staple Fibre Lungies**  
(Clause 5.2)

Sl No.	Characteristic	Requirement	Method of Test, Ref to
(1)	(2)	(3)	(4)
i)	Dimensional change, percent, <i>Max</i> : a) Warp way b) Weft way	10 4	IS 1299
ii)	Scouring loss, percent, <i>Max</i>	2	IS 1383
iii)	Colour fastness to: a) Light  b) Washing Test 1: 1) Change in colour 2) Staining on fabric	5 or better  4 or better 4 or better	IS/ISO 105-B01 or IS/ISO 105-B02  IS/ISO 105-C10
iv)	Fiber identification	100 percent viscose	IS 667

### 5.3 Dimensions

Length and width of the lungies when determined in accordance with IS 1954 shall be as agreed to between the buyer and the seller or as declared by the seller subject to the tolerances specified in the Government of India, Ministry of Commerce and Industry Notification No. S. O. 2937 dated 20 September 1962 issued under Trade and Merchandise Marks Act 1958 (43 of 1958) (*see* Annex B).

**5.4** 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.

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

## **6 INSPECTION**

**6.1** The cloth when visually inspected should be free from the major flaws listed in Annex C.

**6.1.1** 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** The quantity of handloom viscose staple fibre lungies of the same variety delivered to a buyer against a despatch not 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 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 7.3*)

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

#### 7.4 Number of Tests and Criterion for Conformity

Sl No.	Characteristic(s)	No. of Tests	Criterion for Conformity
(1)	(2)	(3)	(4)
i)	Count, 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)	Colour fastness, dimensional change, scouring loss, breaking load and fibre identification	According to col (5) of Table 3	All the test specimens meet the relevant requirements

### 8 MARKING

**8.1** The lungie shall be suitably marked or labelled with the following information:

- a) Name of the material;
- b) Variety No.;
- c) Manufacturer's name, initials or trade-mark;
- d) Length and width;
- e) Count of warp and weft yarn;
- f) Indication of the source of manufacture; and
- g) Other declarations required as per law in force.

#### 8.2 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.

### 9 PACKING

Unless otherwise agreed upon by the buyer and the seller the lungies shall be preferably 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 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 1299 : 1984	Method for determination of dimension change on washing of fabrics woven from rayon and synthetic fibres ( <i>second revision</i> )
IS 1347 : 1972	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 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	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 3442 : 2023	Textiles method for determination of crimp and linear density of yarn removed from fabric
IS 14466 : : 1997/ ISO 8498 : 1990	Fabrics — Description of defects — Vocabulary
IS/ISO 105-B01 : 2014	Textiles — Tests for colour fastness — Part B01 Colour fastness to light: Daylight
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

**ANNEX B**  
*(Clause 5.3)*

**EXTRACTS FROM THE GOVERNMENT OF INDIA, MINISTRY OF COMMERCE  
AND INDUSTRY (TRADE AND MERCHANDISE MARKS ACT, 1958) NOTIFICATION  
NO. S. O. 2937, DATED 20 SEPTEMBER, 1962**

**B-1** A trade description of length of man-made fibre spun and, filament yarn pieces goods:

- a) In pieces stamped as of length 10 metres and below the stamped length shall not be greater or less than the actual length by more than 2 percent.
- b) In pieces stamped as of length above 10 metres the stamped length shall not be greater or less than the actual length by more than 1 percent.

**B-2** A trade description of width of man-made fibre spun and filament yarn piece goods:

In pieces stamped width shall not be greater or less than actual width at any point by more than 3 percent provided that the average width of the pieces in question is equal to or exceeds 98 percent of the stamped width.

**ANNEX C**  
*(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) Skewing of weft;
- h) Weft crack or two or more missing picks across the width of the fabric;
- j) Warp or weft bar due to the difference in raw material, count, twist, lustre, colour, shade or spacing of adjacent groups of yarns (starting mark);
- k) More than two adjacent ends running parallel, broken or missing and extending beyond 10 cm;
- m) Noticeable warp or weft float in the body of the fabric;
- n) Noticeable oil or other stain in the fabric;
- p) Oily weft in the fabric;
- q) Prominently noticeable slub;

- r) Conspicuous broken pattern;
- s) Gout due to foreign matter, usually lint or waste woven into the fabric;
- t) Prominent selvedge defect;
- u) Significant shading or listing in fabrics having a gradual change in tone or depth of shade of fabric (excluding selvedge or border running parallel to the selvedge);
- w) Coloured flecks;
- y) Blurred or dark patch;
- z) Patchy, streaky or uneven dyeing;
- aa) Dye bar; and
- bb) Fuzzy appearance.

## **ANNEX D**

*(Table 1)*

### **METHOD FOR DETERMINATION OF MASS OF FABRIC**

**D-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 °C ± 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.

**D-2** Calculate mass of fabric in g/m<sup>2</sup>.