

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

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*भारतीय मानक मसौदा*

**वस्त्रादि – हथकरघा सूती डस्टर – विशिष्टि**

*( आई एस 859 का दूसरा पुनरीक्षण )*

*Draft Indian Standard*

**TEXTILES — HANDLOOM COTTON DUSTERS — SPECIFICATION**

*( Second Revision of IS 859 )*

**ICS 59.080.30**

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Handloom and khadi sectional committee,  
TXD 08

Last date for receipt of comment is  
27 April 2024

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**FOREWORD**

*(Formal clauses will be added later)*

Handloom cotton dusters are popular for wiping surfaces in households, offices, and industries. Their effectiveness in dusting without leaving lint or scratches is a key preference.

This standard was originally published in 1956 and subsequently revised in 1978. 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) Test method for identification of material has been incorporated;
- d) Tolerances for ends/cm and picks/cm have been specified; 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, 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 dusters, grey, bleached, striped or checked.

**1.2** This standard does not specify the general appearance, feel, 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 dusters shall be satisfactory in evenness and reasonably free from neps and spinning defects. The yarn shall conform to IS 171. In case of varieties 1, 2 and 3, two-fold yarn of equivalent count may be used in the warp.

### **3.2 Cloth**

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

### **3.3 Dusters**

If specifically required by the buyer, the dusters shall be manufactured with 10 mm wide stripes at a distance of 25 mm from the selvages.

**3.3.1** Each cut end of the dusters 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. Cotton sewing thread of 60s/6 (10 tex × 6) count conforming to IS 1720 shall be used in hemming and the number of stitches shall not be less than 40 per decimetre.

## 4 REQUIREMENTS

**4.1** The constructional particulars of dusters shall conform to those given in Table 1.

**4.2** The colour fastness ratings and other requirements of the dusters 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 and feel of dusters, 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 Dusters**

(Clause 4.1)

Sl No.	Variety No.	Count of Yarn [Cotton Count (Universal Count )]		Ends/cm	Picks/cm	Length cm	Width cm	Weave
		Warp	Weft					
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)
i)	1	10s (59 tex)	10s (59 tex)	13	10	55 or	55 or	Plain
ii)	2	14s ( 42 tex )	14s (42 tex)	12 (Double)	11 (Double)	60 or 68 or	60 or 68 or	or Twill
iii)	3	20s ( 30 tex )	6s (100 tex)	17	13	90 or	90 or	(2/2 or
iv)	4	20s/2 (30 tex × 2)	10s (59 tex)	16	14	as agreed	as agreed	2/1)
Tolerance	—	± 5 percent	± 5 percent	± 5 percent	± 5 percent	± 1 cm		—
Method of test, Ref to	—	IS 3442		IS 1963		IS 1954		Visual

**Table 2 Requirements of Handloom Cotton Dusters**  
(Clause 4.2)

Sl No.	Characteristic	Requirement	Method of Test, Ref to
(1)	(2)	(3)	(4)
i)	Colour fastness (in case of striped varieties) to: a) Light  b) Washing Test 3	4 or better  3 or better	IS/ISO 105-B01 or IS/ISO 105-B02  IS/ISO 105-C10
ii)	Dimensional change, percent, <i>Max</i>	4.0	IS 2977
iii)	Scouring loss, percent, <i>Max</i> : a) Grey b) Bleached	10 2.5	IS 1383
iv)	Fiber identification	100 percent cotton	IS 667

## 5 INSPECTION

**5.1** The dusters when visually inspected shall be reasonably free from the following defects:

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

**5.1.1** A reference may be made to IS 14466 for details of these defects.

## 6 SAMPLING

**6.1** The quantity of handloom cotton duster 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 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 Tests and Criterion for Conformity**

Sl No.	Characteristic(s)	No. of Tests	Criterion for Conformity
(1)	(2)	(3)	(4)
i)	Count of yarn, ends, picks, length, width, and weave	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 changes, scouring loss and fibre identification	According to col (5) of Table 3	All the test specimens meet the relevant requirements

### **7 MARKING**

**7.1** The cloth shall be suitably marked or labelled 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(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, the dusters 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 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 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 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 forecolor fastness — Part C10 Colour fastness to washing with soap or soap and soda