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IS 1720 (1978): Cotton Sewing Threads [TXD 31: Man-Made Fibres, Cotton and their Products]



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Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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Indian Standard
SPECIFICATION FOR
COTTON SEWING THREADS

(*First Revision*)

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BUREAU OF INDIAN STANDARDS
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

Indian Standard

SPECIFICATION FOR
COTTON SEWING THREADS
(*Second Revision*)

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Indian Standard
SPECIFICATION FOR
COTTON SEWING THREADS
(*Second Revision*)

0. FOREWORD

0.1 This Indian Standard (Second Revision) was adopted by the Indian Standards Institution on 15 November 1978, after the draft finalized by the Cotton and Cotton Products Sectional Committee had been approved by the Textile Division Council.

0.2 This standard, originally published in 1960, was first revised in 1969. In the present revision the count of sewing thread has been expressed in cotton count and decitex to align with the international practice. In addition to the varieties of sewing threads generally required by the official agencies, such as Defence and the Directorate General of Supplies and Disposals, the other varieties used in the garment, hosiery and footwear industries have also been covered.

0.3 Appendix A, which gives the general end uses of each variety of sewing thread to assist the users of this standard in the proper choice of sewing threads, has also been made up to date.

0.4 Experiments are being carried out at the initiative of the technical committee to find out the substitutes for linen sewing threads and on successful completion of the same, the required information would be added to the standard.

0.5 To familiarize the industry with International System of Units (SI Units), the basic SI Units as well as the recommended SI Units for use in the textile industry are given in Appendix C.

0.5.1 Standards of Weights and Measures Act 1976 also stipulates use of SI Units.

0.6 For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated,

IS : 1720 - 1978

expressing the results of a test, shall be rounded off in accordance with IS : 2-1960*. 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 details and other particulars of 43 varieties of cotton sewing threads, unbleached, bleached or dyed.

1.2 This standard does not specify the type of finish and feel of the sewing thread, nor does it specify the degree of whiteness of the bleached thread or the colour of the dyed threads.

2. MANUFACTURE

2.1 Yarn — Cotton yarn used in the manufacture of the sewing thread shall be evenly spun with suitable number of turns per metre so that a balanced thread is produced. It shall be reasonably free from spinning defects.

2.2 Sewing Thread — The sewing thread shall be reasonably free from knots, snarls and doubling defects.

2.3 Direction of Twist — Unless agreed otherwise, the direction of twist in the singles and the finished sewing thread shall be at the discretion of the manufacturer.

2.4 Finish — White sewing thread shall have a uniform bleached finish. The dyed sewing threads shall have the required shade and free from all dyeing defects.

NOTE — Sulphur dyes shall not be used when specifically required by the buyer. In case of supplies to the Ministry of Defence establishments, the black shade shall not be obtained by using sulphur dyes.

2.4.1 The threads shall be finished soft, mercerized or polished as required. The finishing and dressing materials liable to cause subsequent tendering shall not be used.

2.5 Working — The sewing threads shall work satisfactorily on all appropriate types of hand and power driven sewing machines.

3. REQUIREMENTS

3.1 Length (m/kg) and Breaking Load — The sewing threads shall comply with the requirements given in Table 1.

*Rules for rounding off numerical values (*revised*).

TABLE 1 REQUIREMENTS OF COTTON SEWING THREADS

(Clause 3.1)

VARIETY No.	NOMINAL COUNT	CONSTRUCTION	LENGTH, Min	SINGLE THREAD BREAKING LOAD, Min
(1)	(2)	(3)	(4)	(5)
	Cotton Count (Decitex)		m/kg	Newtons (kgf)
1	12s/2 (500 dtex × 2)	2 ply (2 strands, each single)	9 530	16·2 (1·65)
2	28s/2 (210 dtex × 2)	2 ply (2 strands, each single)	22 020	6·9 (0·70)
3	30s/2 (200 dtex × 2)	2 ply (2 strands, each single)	24 560	6·4 (0·65)
4	38s/2 (155 dtex × 2)	2 ply (2 strands, each single)	31 340	6·7 (0·68)
5	40s/2 (145 dtex × 2)	2 ply (2 strands, each single)	33 030	6·4 (0·65)
6	6s/3 (1 000 dtex × 3)	3 ply (3 strands, each single)	3 100	68·6 (7·00)
7	10s/3 (590 dtex × 3)	3 ply (3 strands, each single)	5 220	40·2 (4·10)
8	12s/3 (500 dtex × 3)	3 ply (3 strands, each single)	6 340	27·0 (2·75)
9	16s/3 (370 dtex × 3)	3 ply (3 strands, each single)	8 200	20·1 (2·05)
10	24s/3 (250 dtex × 3)	3 ply (3 strands, each single)	12 900	15·7 (1·60)
11	32s/3 (185 dtex × 3)	3 ply (3 strands, each single)	16 940	13·7 (1·40)
12	40s/3 (145 dtex × 3)	3 ply (3 strands, each single)	21 510	9·8 (1·00)
13	50s/3 (120 dtex × 3)	3 ply (3 strands, each single)	27 100	7·6 (0·78)
14	50s/3 (120 dtex × 3) mercerised	3 ply (3 strands, each single)	27 100	8·8 (0·90)

(Continued)

TABLE 1 REQUIREMENTS OF COTTON SEWING THREADS — *Contd*

VARIETY No.	NOMINAL COUNT	CONSTRUCTION	LENGTH, Min	SINGLE THREAD BREAKING LOAD, Min
(1)	(2) Cotton Count (Decitex)	(3)	(4) m/kg	(5) Newtons (kgf)
15	60s/3 (100 dtex × 3)	3 ply (3 strands, each single)	32 690	6.6 (0.67)
16	80s/3 (74 dtex × 3)	3 ply (3 strands, each single)	43 520	5.1 (0.52)
17	100s/3 (59 dtex × 3)	3 ply (3 strands, each single)	53 680	4.0 (0.41)
18	6s/4 (1 000 dtex × 4)	4 ply (4 strands, each single)	2 330	98.0 (10.00)
19	12s/4 (500 dtex × 4)	4 ply (4 strands, each single)	4 725	19.6 (2.00)
20	24s/4 (250 dtex × 4)	4 cord (2 strands, each 2 fold)	9 310	20.6 (2.10)
21	32s/4 (185 dtex × 4)	4 cord (2 strands, each 2 fold)	11 750	17.2 (1.75)
22	40s/4 (150 dtex × 4)	4 cord (2 strands, each 2 fold)	15 120	12.7 (1.30)
23	50s/4 (120 dtex × 4)	4 cord (2 strands, each 2 fold)	19 050	9.8 (1.00)
24	60s/4 (100 dtex × 4)	4 ply (4 strands, each single)	24 200	8.8 (0.90)
25	80s/4 (74 dtex × 4)	4 ply (4 strands, each single)	32 180	6.9 (0.70)
26	6s/5 (1 000 dtex × 5)	5 ply (5 strands, each single)	1 780	113 (11.5)
27	32s/6 (185 dtex × 6)	6 cord (3 strands, each 2 fold)	7 910	25.5 (2.60)
28	36s/6 (165 dtex × 6)	6 cord (3 strands, each 2 fold)	9 070	22.1 (2.25)
29	40s/6 (145 dtex × 6)	6 cord (3 strands, each 2 fold)	10 720	21.1 (2.15)
30	50s/6 (120 dtex × 6)	6 cord (3 strands, each 2 fold)	13 550	16.7 (1.70)

(Continued)

TABLE 1 REQUIREMENTS OF COTTON SEWING THREADS — *Contd*

VARIETY No.	NOMINAL COUNT	CONSTRUCTION	LENGTH, <i>Min</i>	SINGLE THREAD BREAKING LOAD, <i>Min</i>
(1)	(2)	(3)	(4)	(5)
	Cotton Count (Decitex)		m/kg	Newtons (kgf)
31	60s/6 (100 dtex × 6)	6 cord (3 strands, each 2 fold)	15 120	13.2 (1.35)
32	80s/6 (74 dtex × 6)	6 cord (3 strands, each 2 fold)	21 170	10.8 (1.10)
33	100s/6 (59 dtex × 6)	6 cord (3 strands, each 2 fold)	26 250	8.8 (0.90)
34	6s/8 (1 000 dtex × 8)	8 ply (8 strands, each single)	1 100	165 (16.8)
35	22s/9 (270 dtex × 9)	9 cord (3 strands, each 3 fold)	3 600	54.9 (5.60)
36	24s/9 (250 dtex × 9)	9 cord (3 strands, each 3 fold)	4 050	49.0 (5.00)
37	32s/9 (185 dtex × 9)	9 cord (3 strands, each 3 fold)	5 250	40.2 (4.10)
38	40s/9 (145 dtex × 9)	9 cord (3 strands, each 3 fold)	6 550	31.4 (3.20)
39	50s/9 (120 dtex × 9)	9 cord (3 strands, each 3 fold)	8 280	26.0 (2.65)
40	6s/10 (1 000 dtex × 27)	10 ply (10 strands, each single)	800	191 (19.5)
41	20s/27 (300 dtex × 27)	27 cord (3 strands, each 9 fold)	1 130	169 (17.25)
42	36s/27 (165 dtex × 27)	27 cord (3 strands, each 9 fold)	2 020	98.0 (10.0)
43	24s/45 (250 dtex × 45)	45 cord (3 strands, each 15 fold)	805	255 (26.0)
METHOD OF TEST	—	—	B-3	IS : 1670-1970*

NOTE 1 — 1 dtex (Decitex) = 0.1 tex.

NOTE 2 — The values specified for length (m/kg) and breaking load are minimum for all sewing threads irrespective of the type of finish.

*Method for determination of breaking load, elongation at break and tenacity of yarns (*first revision*).

3.2 Colour Fastness — The dyed threads shall conform to the following requirements:

<i>Sl No.</i>	<i>Agency</i>	<i>Rating</i>	<i>Method of Test, Ref to</i>
i)	Light (<i>see Note</i>)	5 or better	IS : 2454-1967*
ii)	Washing	4 or better	IS : 765-1966†
iii)	Perspiration	4 or better	IS : 971-1966‡

NOTE— In case of supplies to the Ministry of Defence establishments, the colour fastness to light shall be 6 or better.

3.3 Cuprammonium Fluidity — The cuprammonium fluidity of sewing thread shall not be more than 8 rhes when determined by the method given in IS : 244-1969§.

3.4 Length/Mass of Sewing Thread — The average length and mass of sewing thread in a tube, reel or cone shall not be less than that marked on the label. However, a tolerance of minus two percent shall be permitted on an individual package.

3.4.1 The length/mass of sewing thread shall be determined by the method given in **B-4**.

3.5 Special Proofed Threads — In case the sewing threads are required to be used in the manufacture of ammunition, armaments, etc, these shall be specially proofed and shall comply with the additional requirements given in Table 2.

4. PACKAGING

4.1 Sewing thread shall be compactly wound in the form of tubes, reels, cones or in any other form as required. The free end of the thread shall be securely fastened to prevent unravelling.

5. MARKING

5.1 Each unit package of sewing thread shall be marked, preferably on a label, with the following information:

- a) Name of the material;
- b) Nominal count (in the case of goods supplied to government agencies) or TICKET NUMBER;

*Method for determination of colour fastness of textile materials to artificial light (xenon lamp).

†Method for determination of colour fastness of textile materials to washing: Test 4.

‡Method for determination of colour fastness of textile materials to perspiration.

§Method for determination of viscosity (or fluidity) of solutions of cotton and regenerated cellulose in cuprammonium hydroxide (*first revision*).

- c) Nominal length or mass;
 d) Year of manufacture (in the case of goods supplied to government agencies); and
 e) Manufacturer's name, initials or trade-mark, if any.

**TABLE 2 REQUIREMENTS OF SPECIAL PROOFED
 COTTON SEWING THREADS**

(Clause 3.5)

SL No.	CHARACTERISTIC	REQUIREMENT	METHOD OF TEST, REF TO
(1)	(2)	(3)	(4)
<i>A) Chemical Requirements</i>			
i)	pH value of water extract	5.5 to 7.5	IS : 1390-1961*
ii)	Water soluble matter:		IS : 3456-1963†
	a) Unproofed	0.5 percent, <i>Max</i>	
	b) Proofed	1.0 percent, <i>Max</i>	
iii)	Water soluble chlorides calculated as NaCl	0.05 percent, <i>Max</i>	IS : 4202-1967‡
iv)	Water soluble sulphates calculated as Na ₂ SO ₄	0.25 percent, <i>Max</i>	IS : 4203-1967§
v)	Ash on incineration (in excess of ash due to proofing agents)	0.20 percent, <i>Max</i>	IS : 199-1973
<i>B) Requirements Related to Proofing</i>			
vi)	Salicylanide content (for salicylanide processed)	0.1 percent, <i>Min</i>	} IS : 3522 (Part I)-1966¶ and IS : 3522 (Part II)-1970**
vii)	Copper content (for copper cutch processed)	0.7 percent, <i>Min</i>	
viii) a)	Chromium content } for chrome copper processed	0.5 to 1.5 percent	
b)		Copper content } 0.2 percent, <i>Min</i>	
ix)	Chromium content (for chrome processed)	0.7 to 1.0 percent	
x)	Chromium and iron	1.5 percent, <i>Min</i>	

*Methods for determination of pH value of aqueous extracts of textile materials.

†Method for determination of water soluble matter of textile materials.

‡Method for determination of chloride content of textile materials.

§Method for determination of sulphate content in textile materials.

||Methods for estimation of moisture, total size or finish, ash and fatty matter in grey and finished cotton textile materials (*second revision*).

¶Method for estimation of common preservatives used in textile industry, Part I.

**Methods for estimation of common preservatives used in the textile industry, Part II.

5.1.1 Each unit package may also be marked with the Standard Mark.

5.2 The use of the Standard Mark is governed by the provisions of *Bureau of Indian Standards Act, 1986* and the Rules and Regulations made thereunder. The details of conditions under which the licence for the use of Standard Mark may be granted to manufacturers or producers may be obtained from the Bureau of Indian Standards.

6. PACKING

6.1 Unless otherwise specified, sewing threads shall be packed according to the method laid down in IS : 1066-1969*.

7. SAMPLING AND CRITERIA FOR CONFORMITY

7.1 Lot — The quantity of cotton sewing thread of the same variety delivered to a buyer against a despatch note shall constitute the lot.

7.2 The conformity of the lot to the requirements of this standard shall be determined on the basis of tests carried out on the samples selected from the lot.

7.3 Unless otherwise agreed to between the buyer and the seller, the number of packs to be selected at random from a lot shall be as follows:

<i>Number of Packs in the Lot</i>	<i>Number of Packs to be Selected</i>
Up to 15	5
16 „ 30	7
31 „ 50	10
51 „ 100	15
101 „ 300	25
301 and above	30

7.4 One tube or reel shall be selected at random from each of the pack selected according to **7.3**. The tube thus selected shall constitute the test sample for determining:

- a) length in m/kg,
- b) breaking load, and
- c) length per tube or reel (subject to a minimum of 20 tubes or reels).

*Code for packaging of sewing threads.

7.4.1 For testing colour fastness, cuprammonium fluidity and requirements for special proofed threads, two specimens for a lot size of 30 packs or less and 3 specimens for a lot size of more than 30 packs shall be taken from the tubes drawn in accordance with 7.4 and tested individually.

7.5 Criteria for Conformity — The lot shall be declared as conforming to the requirements of this standard if the following conditions are satisfied:

- a) From the test results for lengths in m/kg or breaking load the average \bar{X} and the range R or average range \bar{R} shall be calculated and the value of the expression $\bar{X} - kR$ or $\bar{X} - k\bar{R}$ is greater than or equal to the relevant value specified.

NOTE 1 — Average \bar{X} is the value obtained by dividing the sum of the observed values by the number of tests.

NOTE 2 — Range \bar{R} is the difference between the maximum and the minimum in a set of observed values.

NOTE 3 — When the number of test results is 10 or more, they shall be grouped in groups of five. The mean range \bar{R} is the value obtained by taking the average of the ranges of the groups.

NOTE 4 — The value of the constant k is equal to 0.4.

- b) All the test specimens tested for colour fastness and cuprammonium fluidity and requirements for special proofed threads satisfy the relevant requirements.
- c) The average of the length/mass measurements is not less than the marked length.

APPENDIX A

(Clause 0.3)

GENERAL END USES

<i>Variety No.</i>	<i>General End Uses</i>
1	Embroidery of emblems, insignia, etc
2	Basting, hemming and stitching of light clothing and cables
3	do
4	Clothing and hosiery
5	Clothing, hosiery and cables
6	Heavy leather and canvas material, such as tarpaulins, canopies, ankle boot uppers, harness and saddlery, bag closing, harness for jacquard looms and page-cord

Variety No.

General End Uses

7	Gloves, tents, harness and saddlery
8	Light leather materials and for repair work
9	Light leather materials, selvedge yarn in jute cloth
10	Woollen jerseys, woollen pullovers, caps, wool-cotton short-drawers and wool-cotton vests
11	Chappal uppers, shoes and book-binding
12	Clothing, towels, household linen and hosiery
13	do
14	Synthetic and blended fabrics
15	Clothing, handkerchiefs, towels and hosiery
16	do
17	Handkerchiefs, hosiery and clothing
18	Heavy leather, canvas, tarpaulin, canopies, boot uppers, harness and saddlery, bag closing and harness for jacquard looms
19	Hand stitching of tentage and repair of door curtains
20	Umbrellas, healds, fishnets, book-binding, carpets, and woven and knitted heavy fabrics
21	Umbrellas, book-binding, healds and bags
22	Umbrella, chappal uppers, bags, book-binding, clothing and healds
23	Clothing, umbrellas, chappal uppers and healds
24	Clothing
25	Clothing and jari trade
26	Boot uppers, sole and welt
27	Book-binding, bags, tents, carpets, fishnets, healds and selvedging
28	Book-binding, bags, tents, carpets, fishnets, healds, selvedging, canvas and footwear uppers
29	Leather footwear uppers
30	do
31	Leather footwear uppers, piece-end joining and clothing
32	Footwear and clothing
33	Clothing
34	Sole, welt and shoes uppers

<i>Variety No.</i>	<i>General End Uses</i>
35	Boots and shoe uppers, sole and welt, sports and travel goods, upholstery, spindle tape, book-binding, jari-making, harness for jacquards and light tarpaulins
36	do
37	Leather and canvas material, spindle tape, upholstery, sports goods and jari
38	Shoe uppers, upholstery, light leather and canvas materials and book-binding
39	Book sewing, upholstery, spindle tape and light leather materials
40	Sole stitching of heavy boots
41	Healds, tarpaulins and canopies
42	do
43	Healds and meteorological radiosonde/Rawin balloons

APPENDIX B

(Clause 3.4.1, and Table 1)

METHODS OF TEST

B-1. CONDITIONING OF TEST SPECIMENS AND ATMOSPHERIC CONDITIONS FOR TESTING

B-1.1 The test specimens shall be conditioned and tested in the standard atmosphere of 65 ± 2 percent relative humidity and $27 \pm 2^\circ\text{C}$ temperature (see IS : 6359-1971*).

B-2. APPARATUS

B-2.1 Wrap Reel — having a perimeter of $1 \text{ m} \pm 0.4$ percent. Determine the actual perimeter of the reel with a strip of gummed paper passed tightly around the reel and secured by adhesion at the overlap. Cut the paper strip and measure its length to an accuracy of 0.1 percent.

B-2.2 Adjustable Yard Tensioning Device — capable of giving a reeling tension that will result in skeins of the specified length when measured under a load of 0.5 gf/tex.

*Method for conditioning of textiles.

B-2.3 Weighing Balance — capable of weighing skeins in grams and with a sensitivity of 1 part in 500.

B-3. DETERMINATION OF LENGTH (m/kg)

B-3.1 Place the package constituting the test specimen on the wrap reel (see **B-2.1**) and wind 100 m of thread under a suitable reeling tension (see **B-2.2**). Remove the thread so wound from the wrap reel and determine the mass on the weighing balance (see **B-2.3**).

B-3.2 Calculation — Calculate the length, m/kg, by the following formula:

$$\text{Length, m/kg} = \frac{100 \times 1\,000}{W_1}$$

where

W_1 = mass in g of 100 m of sewing thread.

B-3.3 Similarly determine the length (m/kg) of other test specimens.

B-4. DETERMINATION OF LENGTH/MASS OF SEWING THREAD ON REEL/TUBE/CONE OR ANY PACKAGE

B-4.1 Place the package constituting the test specimen on the wrap reel and wind it into skein till the whole test specimen is exhausted. Remove the skein and determine the mass on the weighing balance.

B-4.2 Similarly determine the mass of other test specimens.

B-4.3 Determine the length of sewing thread of reel/tube/cone or any package by the following formula:

$$\text{Length, m} = \frac{a \times W_2}{1\,000}$$

where

a = Length in m/kg (see **B-3.2**), and
 W_2 = mass of sewing thread on the package (see **B-4.1**).

APPENDIX C*(Clause 0.5)***SI UNITS****TABLE 3 INTERNATIONAL SYSTEM OF UNITS****Base Units**

QUANTITY	UNIT	SYMBOL
Length	metre	m
Mass	kilogram	kg
Time	second	s
Electric current	ampere	A
Thermodynamic temperature	kelvin	K
Luminous intensity	candela	cd
Amount of substance	mole	mol

Supplementary Units

QUANTITY	UNIT	SYMBOL
Plane angle	radian	rad
Solid angle	steradian	sr

Derived Units

QUANTITY	UNIT	SYMBOL	CONVERSION
Force	newton	N	1 N = 0.101 972 kgf
Energy	joule	J	1 J = 1 N.m
Power	watt	W	1 W = 1 J/s
Flux	weber	Wb	1 Wb = 1 V.s
Flux density	tesla	T	1 T = 1 Wb/m ²
Frequency	hertz	Hz	1 Hz = 1 c/s (s ⁻¹)
Electric conductance	siemens	S	1 S = 1 A/V
Pressure, stress	pascal	Pa	1 Pa = 1 N/m ²

TABLE 4 RECOMMENDED SI UNITS FOR TEXTILES

Sl No.	CHARACTERISTIC	SI UNIT		APPLICATION
		Unit	Abbreviation	
(1)	(2)	(3)	(4)	(5)
1)	Length	Millimetre	mm	Fibre
		Millimetre, centimetre	mm, cm	Samples and test specimens (as appropriate)
		Metre	m	Yarns, ropes and cordages, fabrics
2)	Width	Millimetre	mm	Narrow fabrics
		Centimetre	cm	Other fabrics
		Millimetre, centimetre	mm, cm	Samples and test specimen (as appropriate)
		Centimetre, metre	cm, m	Carpets, druggets, durries (as appropriate)
3)	Thickness	Micrometre (micron)	μm	Delicate fabrics
		Millimetre	mm	Other fabrics, carpets, felts
4)	Linear density	Tex	tex	Yarns
		Millitex	mtex	Fibres
		Decitex	dtex	Filament and filament yarns
		Kilotex	ktex	Slivers, ropes and cordages
5)	Diameter	Micrometre (micron)	μm	Fibres
		Millimetre	mm	Yarns, ropes, cordages
6)	Circumference	Millimetre	mm	Ropes, cordages
7)	Threads in cloth :			Woven fabrics (as appropriate)
a)	Length	Number per centimetre	ends/cm	
		Number per decimetre	ends/dm	
b)	Width	Number per centimetre	picks/cm	
		Number per decimetre	picks/dm	
8)	Warp threads in loom	Number per centimetre	ends/cm	Reeds
9)	Stitches in knitted cloth:			Knitted fabrics (as appropriate)
a)	Length	Courses per centimetre	courses/cm	
		Courses per decimetre	courses/dm	
b)	Width	Wales per centimetre	wales/cm	
		Wales per decimetre	wales/dm	

(Continued)

TABLE 4 RECOMMENDED SI UNITS FOR TEXTILES — *Contd*

Sl. No.	CHARACTERISTIC	SI UNIT		APPLICATION
		Unit	Abbreviation	
(1)	(2)	(3)	(4)	(5)
10)	Stitch length	Millimetre	mm	Knitted fabrics, made-up fabrics
11)	Mass per unit area	Grams per square metre	g/m ²	Fabrics
12)	Mass per unit length	Grams per metre	g/m	Fabrics
13)	Twist	Turns per centimetre Turns per metre	turns/cm turns/m	Yarns, ropes (as appropriate)
14)	Test or gauge length	Millimetre, centimetre	mm, cm	Fibres, yarns and fabric specimens (as appropriate)
15)	Breaking load	Millinewton	mN	Fibres, delicate yarns (skeins or individual)
		Newton	N	Strong yarns (indi- vidual or skeins), ropes and corda- ges, fabrics
16)	Breaking length	Kilometre	km	Yarns
17)	Tenacity	Millinewton per tex	mN/tex	Fibres, yarns (in- dividual or skeins)
18)	Twist factor or twist multiplier	Turns per centimetre × square root of tex	turns/cm × $\sqrt{\text{tex}}$	Yarns (as appro- priate)
		Turns per metre × square root of tex	turns/m × $\sqrt{\text{tex}}$	
19)	Bursting strength	Newton per square centimetre	N/cm ²	Fabrics
20)	Tear strength	Millinewton	mN	Fabrics (as appro- priate)
		Newton	N	
21)	Pile height	Millimetre	mm	Carpets
22)	Pile density	Mass of pile yarn in grams per square metre per millimetre pile height	g/m ² /mm pile height	Pile carpet
23)	Elastic modulus	Millinewton per tex per unit deformation	mN/tex/unit deformation	Fibres, yarns, strands

(Continued from page 2)

Members

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Ahmadabad

BUREAU OF INDIAN STANDARDS

Headquarters:

Manak Bhavan, 9 Bahadur Shah Zafar Marg, NEW DELHI 110002

Telephones: 323 0131, 323 3375, 323 9402

Fax : 91 11 3234062, 91 11 3239399, 91 11 3239382

Telegrams : Manaksanstha
(Common to all Offices)

Central Laboratory:

Plot No. 20/9, Site IV, Sahibabad Industrial Area, SAHIBABAD 201010

Telephone

8-77 00 32

Regional Offices:

Central : Manak Bhavan, 9 Bahadur Shah Zafar Marg, NEW DELHI 110002 323 76 17

*Eastern : 1/14 CIT Scheme VII M, V.I.P. Road, Maniktola, CALCUTTA 700054 337 86 62

Northern : SCO 335-336, Sector 34-A, CHANDIGARH 160022 60 38 43

Southern : C.I.T. Campus, IV Cross Road, CHENNAI 600113 235 23 15

†Western : Manakalaya, E9 Behind Marol Telephone Exchange, Andheri (East),
MUMBAI 400093 832 92 95

Branch Offices:

'Pushpak', Nurmohamed Shaikh Marg, Khanpur, AHMEDABAD 380001 550 13 48

†Peenya Industrial Area, 1st Stage, Bangalore - Tumkur Road,
BANGALORE 560058 839 49 55

Gangotri Complex, 5th Floor, Bhadbhada Road, T. T. Nagar, BHOPAL 462003 55 40 21

Plot No. 62-63, Unit VI, Ganga Nagar, BHUBANESHWAR 751001 40 36 27

Kalaikathir Buildings, 670 Avinashi Road, COIMBATORE 641037 21 01 41

Plot No. 43, Sector 16 A, Mathura Road, FARIDABAD 121001 8-28 88 01

Savitri Complex, 116 G. T. Road, GHAZIABAD 201001 8-71 19 96

53/5 Ward No. 29, R. G. Barua Road, 5th By-lane, GUWAHATI 781003 54 11 37

5-8-58C, L. N. Gupta Marg, Nampally Station Road, HYDERABAD 500001 20 10 83

E-52, Chitaranjan Marg, C-Scheme, JAIPUR 302001 37 29 25

117/418 B, Sarvodaya Nagar, KANPUR 208005 21 68 76

Seth Bhawan, 2nd Floor, Behind Leela Cinema, Naval Kishore Road,
LUCKNOW 226001 23 89 23

Patliputra Industrial Estate, PATNA 800013 26 23 05

T. C. No. 14/1421, University P. O. Palayam,
THIRUVANANTHAPURAM 695034 6 21 17

NIT Building, Second Floor, Gokulpat Market, NAGPUR 440010 52 51 71

Institution of Engineers (India) Building, 1332 Shivaji Nagar, PUNE 411005 32 36 35

*Sales Office is at 5 Chowringhee Approach, P. O. Princep Street,
CALCUTTA 700072 27 10 85

†Sales Office is at Novelty Chambers, Grant Road, MUMBAI 400007 309 65 28

†Sales Office is at 'F' Block, Unity Building, Narashimaraja Square,
BANGALORE 560002 222 39 71