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Specification No. IND/AIR/TC/2647(b)

Correct copy of sealed specification at this date.

KANPUR
DATED

CHIEF INSPECTOR
CHIEF INSPECTORATE OF TEXTILES & CLOTHING

THIS SPECIFICATION or any patterns, drawings, or other information issued in connection therewith, MAY ONLY BE USED for a specific order placed by COMPETENT AUTHORITY, IT IS NOT TO BE USED FOR any other purpose, whatsoever, WITHOUT THE EXPRESS WRITTEN SANCTION OF THE DIRECTOR GENERAL OF INSPECTION.

Web Cotton, S.D., 44 mm
Undyed
O.G.

(Additional particulars required - see Clause 7)

SPECIFICATION TO GOVERN MANUFACTURE AND INSPECTION.

47005

C.G.(1-A)

Approved, 24.4.43.

1. GENERAL - The web, Cotton, S.D., 44 mm, shall comply in every respect with the terms of this specification. The sealed patterns held in the custody of the Chief Inspector, Chief Inspectorate of Textiles & Clothing, Post Box No. 294, Kanpur, represent the type and quality of the webbing required. The sealed patterns shall constitute the Standard as defined in the appropriate clauses of this specification.
2. MATERIALS - The web shall be manufactured from good quality long staple cotton yarn made from 'C' mixing. The breaking load of a single strand of the doubled yarn shall be 39N. The yarn shall be hard twisted and shall be equal in quality to that used the sealed patterns.
3. CONSTRUCTION, DIMENSIONS AND BREAKING-LOAD- The web shall be made to the design of the respective sealed pattern and shall conform to the following particulars :-

Maximum mass* 100 m in kg	No. of threads		Universal Counts of yarn		Minimum Breaking load of any one test** 300 cm between grips.) Newton(N)	Weave
	Ends (full width)	Picks per cm	Warp.	Weft.		
9.7	22	4/5	62Tex/5	62Tex/5	6669	2/2 Twill

Note:- 1 kg force = 9.80665 newton (N)

* The mass shall be determined after drying the sample in an oven at 100°C - 105°C, to constant weight and adding 8½ per cent. as allowance for regain.

** The breaking load shall be the result of tests made on five strips each of full width and of such length as to allow 66cm between the grips of the machine. No test strip shall break at less than 6669 N. The test strips shall be first conditioned in an atmosphere of 65/70 per cent. relative humidity and 21°C for 48 hours and shall be broken whilst so conditioned in a machine of the Goodbrand type in which the test piece is stretched at a constant rate of 15 cms per minute.

MANUFACTURE, WORKMANSHIP AND FINISH: The single and folded yarns shall be evenly spun and uniformly twisted. The web shall be uniformly woven with firm selvages and shall be free from weaving faults. The width shall not exceed 44 mm but a minus tolerance of 1.6 mm in width shall be permitted. The web shall contain no size or dressing.

The web shall be supplied Undyed or Olive Green as ordered. When the shade shall conform to that of the corresponding sealed pattern and dyes of vat class or their equivalents shall be used.

In the foregoing, and in general workmanship and finish the web shall be equal to the sealed pattern.

TESTS - The dyed web shall withstand the following dye fastness:-

- (i) **To light:**- A fastness of at least Class VI of the Classification adopted by the Society of Dyers and Colourists, Bradford, Yorkshire when determined by exposure to light from a high intensity Carbon Arc.
- (ii) **To washing:**- No change in shade or any signs of bleeding on to the attached piece of Cotton material shall take place when subjected to the washing treatment as described in the Appendix to this specification.

INSPECTION- (i) If, on examination of any sample from any portion of a consignment the material is found not to be fully in accordance with this specification the whole supply may be rejected.

(ii) If, on examination of 20% of any delivery, 20% of those examined are found not to conform with this specification in pattern, dimensions, workmanship and finish, the whole consignment may be rejected.

(iii) All pieces not fully in accordance with this specification shall be rejected.

7. MARKING OR STAMPING - The marking shall be legibly and indelibly carried out as follows :-

Roll - Each shall be clearly marked at both ends with the manufacturer's name, initials or recognised trade mark together with the month and year of manufacture and the length of the roll.

Bale - Each shall be marked in 25 mm character with the correct nomenclature of the store, as given on page 1 of this specification, the number of rolls and the total metreage it contains and the date on which baled.

8. DELIVERY- The webbing shall be delivered in a new, clean and dry condition in rolls of 45 metres each, or multiples thereof.

If ordered for delivery to a local General Stores Inspection Depot, where packing facilities exist, the rolls shall be delivered loose.

Otherwise, they shall be delivered securely packed in bales with one layer of "Cloth, 'C' Heavy" (in accordance with the latest issue of specification I.M./774 for "Jute Cloths").

If heavy 'C' cloth is not available, other new jute fabrics of equal mass and similar construction may be used only with the prior sanction of the Chief Inspector, Chief Inspectorate of Textiles & Clothing, Kanpur or the IGS concerned.

The gross mass of any one bale shall not exceed 40 Kg.

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APPENDIX

Determination of Fastness to Washing

Preparation of Test Liquor - The test liquor shall consist of a solution of 0.5% dry soap and 0.2% Sodium Carbonate in distilled water.

Preparation of Sample :- A sample of the dyed material 100 mm x full width in size shall be cut and to it shall be sewn with a white sewing cotton a piece of white unmercerised Limbric or Cambric of a similar size so as to entirely cover one side of the sample test piece.

Method of Test:- The test shall be carried out in a wash wheel carrying stainless steel covered jars. The prepared sample shall be placed in jar together with 250 c.c. of the test liquor previously heated to 50°C along with 10 monel metal balls of 6 mm diameter. The jar shall then be fixed to the wash wheel which shall be rotated at 40 r.p.m. in water bath maintained at 85°C. The test liquor shall be changed after first 10 minutes in order to minimise the effect of any finishing substances left in the material. The sample shall be removed from the jar after a total period of treatment of fortyfive minutes, well rinsed in warm water centrifuged or mangled and finally dried.

.B. The above is a Description of the Standard Test No. 3 as published in the report of the Fastness Committee of the Society of Dyers and Colourists. 1934 with modifications as recommended by the Standardisation Committee of the Textile Institute (J.T.I. Sept 1944).

LK/26.9.77

Checked by
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2. C.