

TEXTILES COMMITTEE

(GOVERNMENT OF INDIA, MINISTRY OF COMMERCE)

A Scheme for Inspection of Cotton Textiles Meant for Export

'Itex' Inspection Regulations—Part II

1. PRE-INSPECTION OF MATERIAL BY MILL:

The Mill is responsible for carrying out pre-inspection of all supplies of material, prior to offering the same for inspection by Government Inspectors, so as to eliminate any material which is not upto the required standard and to rectify the rectifiable defects such as loose threads, snarls, removable stains etc. The Mill will flag all major defects in accordance with the relevant instructions contained in these Regulations.

It will be the further responsibility of the Mills to ensure that—(a) on the total number of pieces offered for inspection, the total number of flags do not exceed the number which is arrived as follows—

Permissible No. of flags on the particular piece length (refer to para 6 at page 3) \times 25 percent of the total number of pieces offered:

and—(b) that the two-part pieces do not exceed 5 percent of the total number of pieces.

2. INSPECTION BY THE INSPECTOR:

The Inspector will give general inspection to the material tendered by the Mills and will select at his discretion, a certain percentage of the total material, for detailed inspection. The percentage may vary according to the quality standard the Mill has been consistently maintaining but will not be less than 5 percent for construction particulars and 20 percent for quality (presence of weaving and other flaws).

3. GENERAL INSPECTION:

General inspection will mainly consist of examination for—

- (a) General appearance including excessive neppiness, reediness, kitty, missing threads, snarls, slubs, surface impurities, and removable stains and dressing of defects, etc.
- (b) Uniformity and accuracy of shade or design.
- (c) Standard of Mill's pre-inspection.
- (d) The number of flagged and two-part pieces in the lot offered for inspection.

The Inspector may reject the whole lot if he considers that the tendered material is of such poor quality as not merit detailed inspection. If the standard of pre-inspection is very poor the inspector may return the tendered material to the Mill for re-inspection.

If the total number of flags and the two-part pieces in the lot exceed the limits as shown in para 1, such pieces resulting in excess either in flags or in two-part pieces will be rejected without further detailed inspection.

4. DETAILED INSPECTION:

- (i) For Construction Particulars:

Each piece selected will be examined for the details given below:

- (a) General appearance.
- (b) Uniformity and accuracy of shade and/or design.

- (c) Width at four different places.
- (d) Length of full piece.
- (e) Weight of full piece.
- (f) Ends per inch at not less than two different places across the width of the material.
- (g) Picks per inch at intervals of 10 yards.
- (h) Counts of warp and weft (one test for every 10,000 yards offered. The test will be carried out by means of templets after desizing in the case of warp).
- (ii) For quality: (presence of weaving and other flaws):

Each piece selected will be examined yard by yard for presence of weaving flaws as detailed below and for standard of flagging.

Major flaws:

- (1) More than one adjacent ends missing along the piece or more than three ends missing at a place and running over 24 inches,
- (2) Undressed snarls due to loose weft throughout the piece,
- (3) Shuttle traps (unmended) resulting in smashes on cloth,
- (4) Holes in the body of the cloth over $\frac{1}{4}$ " in size,
- (5) Reediness throughout the piece,
- (6) Weft cracks where the missing picks are more than two,
- (7) When there are more than 3 ends missing running parallel for more than 8",
- (8) More than 3 ends missing at a place for more than 6" even if combed by the weaver,

(9) Warp and weft floats, and

(10) Undressed oil stains.

For dyed, printed goods, in addition to items (1) to (10) mentioned above the following faults shall be considered as major flaws:—

- (a) Doctor's stain or line,
- (b) Printing defect caused by material cloth being wrinkled,
- (c) Warp stained,
- (d) Dye stuff stain,
- (e) Printing faults (surface and back with blurred or dark patches),
- (f) Off side printing stain,
- (g) Printing defects caused by bad starch or starching,
- (h) Selvedge crease,
- (i) Bad printing or dyeing on selvedge,
- (j) Hanging threads,
- (k) Fly waste or nep yarn (woven) showing a patch or a streak,
- (l) Wrinkled when calendered,
- (m) Dye bars,
- (n) Colour blurred etc.

(any of these defects too prominent will render the pieces unacceptable).

Minor flaws:

Any other surface defect not included in the above list of major flaws.

5. INSPECTION OF GOODS:

All defects in the material will be classified major and minor in accordance with the standard mentioned above. The location of every major defect shall be indicated by the

insertion of a red coloured thread (flag) in one of the selvages of the cloth opposite to the defect. The flags should be allowed to remain even after inspection unless otherwise required by the foreign buyers.

6. REJECTIONS:

- (a) Pieces found to be not in accordance with the constructional and other particulars given in the specification shall be rejected.
- (b) The presence of any of the Major flaws detailed at (1) to (5) in para 4(ii) above in any piece of cloth will render the piece unacceptable.
- (c) Pieces 10 yards and less in length containing any of the major flaws detailed at (6) to (10) of para 4(ii) above, shall be rejected.
- (d) Pieces of lengths more than 10 yards but not more than 20 yards, containing 3 or more major flaws detailed at (6) to (10) of para 4(ii) above, shall be rejected.
- (e) Pieces of lengths more than 20 yards but not more than 40 yards, containing 4 or more major flaws detailed at (6) to (10) of para 4(ii) above, shall be rejected.
- (f) Pieces of lengths more than 40 yards containing more than 4 major flaws detailed at (6) to (10) of para 4(ii) above plus one such major flaw for every 10 yards in excess of 40 yards shall be rejected.
- (g) While normally pieces containing minor flaws shall not be unacceptable, it would be in the discretion of the Inspector to reject any piece where presence of a large number of such minor flaws renders it, in the opinion of

the Inspector unacceptable, being of a very poor quality.

- (h) If more than 20 percent of the total number of pieces inspected for construction particulars and/or for quality are found unacceptable for any of the reasons stated at (a) to (g) above, or if the number of flags and two-part pieces are found to exceed the limits for flags (viz. the number of permissible flags on one piece length \times 25% of the pieces inspected) and two-part pieces (viz. 5% of the total No. of pieces inspected), either of the following procedures will be adopted:—

- (i) If the defects can be eliminated by further pre-inspection by the Mill, the Inspector will suspend inspection and return the material to the Mill.

- (ii) If, in the opinion of the Inspector, the defects cannot be rectified, 100 percent inspection of the entire lot offered for inspection will be carried out, and only such pieces which pass the test will be accepted and the balance rejected, provided that number of flags and two-part pieces do not exceed the limit for that quantity as indicated in para 1 on page 1.

7. MARKING OF GOODS:

If, out of the total number of pieces inspected, 80 percent or more is found acceptable, as stated in para 6 above, then, the Inspector will mark all the pieces in the lot offered for inspection, except those which have been rejected in accordance with para 6 with the official brand or mark. All those pieces actually inspected for

quality, and found acceptable will be further stamped with a second mark (representing Inspector's seal) indicating that the pieces have been individually examined. In the case where 100 percent inspection has been carried out, in accordance with para 6(h) above, all pieces found acceptable will be stamped with both the official brand or mark as also the second mark indicating individual examination of the pieces.

8. ALLOWANCE OF FLAGS:

No allowance in the form of extra yardage need be claimed from the Mills on account of flags in the pieces inspected and accepted. In order, however, to enable the buyer to assess the general quality of the lot passed after inspection, the Inspector will state the total number of flags allowed and the total number of pieces actually inspected and passed.

APPENDIX "A"

SPECIFICATION FOR STANDARD COTTON TEXTILES FOR EXPORT

Standard Quality No.	Description of cloth	Dimension		Counts		Ends	Picks	Weight of piece including 20% size on the weight of cotton used.
		Width Inches	Length Yard	Warp	Weft			
1001	Sheeting Grey Calendered	36	33	14s	14s	44	40	9 $\frac{1}{4}$
1002	" " "	36	30	14s	14s	48	44	10 $\frac{1}{4}$
1211	Shirting " "	36	40	18s	18s	52	44	11
1212	" " "	36	40	18s	22s	52	44	10
1213	" " "	36	40	18s	24s	52	48	10
1214	" " "	36	40	20s	20s	52	48	10 $\frac{1}{4}$
1215	" " "	36	40	20s	20s	65	60	13
1216	" " "	44	40	24s	24s	60	56	12
1217	" " "	44	40	30s	30s	69	60	10 $\frac{3}{4}$
1411	" " "	36	40	36s	40s	69	60	7
1412	" " "	42	40	40s	40s	69	60	7 $\frac{1}{2}$
2411	" Bleached	36	40	36s	40s	65	48	6 $\frac{1}{4}$
1421	Mull Grey Uncalendered	44	30	36s	40s	47	40	4 $\frac{1}{2}$
1026	Drill " Calendered	29	40	10s	12s	64	40	16 $\frac{3}{4}$
1027	" " "	29	40	14s	14s	82	44	15 $\frac{1}{4}$
1241	Bedticking " "	56	40	18s	18s	70	44	20 $\frac{1}{4}$
1242	" " "	56	40	20s	24s	64	40	15 $\frac{3}{4}$
1003	Grey Sheetting	36	60	12s	14s	44	40	Lbs. 21.10
1004	" " "	35	60	12s	14s	48	44	22.9
1005	" " "	36	30	14s	14s	48	40	10.9
1201	" " "	35	30	18s	16s	48	44	8.8
1202	" " "	37	60	18s	18s	56	48	19.14
1203	" " "	40	60	18s	24s	48	40	15.10
1204	" " "	37	60	20s	20s	52	44	16.5
1205	" " "	32	40	20s	24s	56	48	9.3
1028	Grey Drill	36	40	12s	14s	66	42	18.11
1029	" " "	54	40	14s	18s	78	44	26.12
1243	Bedticking	35	30	18s	24s	72	40	9.1
1244	"	58	50	20s	20s	78	44	26.12

N.B. (1) Dimension can vary according to the requirement of the buyer.

(2) Tolerance for length and width will be allowed as admissible under the Merchandise Marks Act.

(3) Weights shown are for the given dimensions. When dimensions are altered from those shown above proportionate alterations will be made in the weight of piece.

(4) For counts upto 24s the warp and weft counts can be made coarser or finer by one count provided that average count of warp and weft (combined) remains unchanged. For counts above 24s the counts of warp and weft can be similarly varied upto a maximum of 2 counts.

(5) A maximum tolerance of ± 1 is allowed for the average number of ends and picks per inch.

(6) A maximum tolerance of + 5% and -2 $\frac{1}{2}$ % will be allowed in respect of weight of pieces.

NOTE: The specification of grey calendered cloth given above will also hold good for cloth in uncalendered state except that the number of ends per inch will be reduced by 2% in the latter case.