

TEXTILES COMMITTEE

(GOVERNMENT OF INDIA, MINISTRY OF FOREIGN TRADE)

Regulation for Pre-shipment inspection of Woollen/Worsted Yarn for export.

1. PRE-INSPECTION OF MATERIAL BY MILLS:

The Mills are responsible for carrying out pre-shipment inspection of all supplies of material prior to offering the same for inspection by the inspecting authority so as to eliminate any material which is not upto the required standard.

2. The material should be arranged in suitable lots of 5 bales/cases or the entire quantity of the order, whichever is less. Where more than one quality/count of yarn is involved in the consignment each such quality/count of yarn shall be arranged in separate lots.

3. It will be the responsibility of the mill to ensure that the total quantity offered for inspection is in accordance with the declared specifications and is upto the standards stipulated in the contracts or laid down hereunder.

4. Lots should be arranged in a well lighted shed near a table with one attendant to assist the Inspector. Following equipment should also be provided:—

1. Balance for weighing bundles of about 5 kg. weight.
2. Black card board of size 15" × 12".

5. It is also necessary to issue an offering letter to the inspection authority at least one week prior to the inspection date stating therein the following details:—

(a) Contract No. and the mills sort Nos., the quantity of each count/quality of yarn.

(b) Full constructional particulars indicating by percentage of weight the constituent fibres in the yarn, the counts, quality of raw material, type of yarn (whether woollen/worsted/shoddy or mixed), twist per inch etc.

(c) in the case of dyed yarn, the nature (class) of dye used.

6. METHOD OF SAMPLING:

(i) Sample to test conformity of a lot to a specification shall be selected so as to be representative of the lot.

(ii) Sample to evaluate the different characteristics of the yarn drawn in accordance with agreement between the buyer and the seller, shall be taken to be representative of the lot.

(iii) In the absence of any agreement between the buyer and the seller about the method of drawing representative samples, the sample to represent the lot shall be drawn from bales (or cases) constituting the lot as far as possible, in order of serial number of bales (or cases). The total number of bales (or cases) to be taken at random from the various parts of the lot shall be as under:—

No. of bales (or cases) in a lot	No. of bales (or cases) to be taken
2	1
3 to 4	2
5 to 6	3
7 to 24	4
25 to 50	5
More than 50	at least 10 percent.

(iv) The number of packages to be selected from each selected bale (or case) shall be as under:—

No. of packages in a bale (or case)	No. of packages to be taken
Up to 25	1
26 to 50	2
51 to 75	3
76 to 100	4
101 to 125	5
More than 125	6

(v) However if the yarn is on pirns, the number of packages to be taken shall be doubled.

(vi) If the above procedure provides fewer than 15, or in the case of pirns, fewer than 30 packages from the whole lot further packages shall be taken from the selected bales (or cases) to bring the number of selected packages to 15 or in the case of pirns to 30.

The packages selected as above shall constitute the test samples.

7. METHOD OF INSPECTION:

(i) A general inspection of the test samples will be carried out for:—

(a) General appearances, including snarls, slubs, surface impurities, removable stain, general regularity etc. wherever necessary with the assistance of a (black board) contrasting colour trace board.

(b) Uniformity and accuracy of shade (in the case of dyed yarn).

(c) Standard of mills pre-inspection.

(ii) The inspector may reject the whole lot if he considers that the tendered material as represented by the test sample is of such poor quality as not to merit detailed inspection.

The test sample will then be duly labelled, signed by the representative of the mill and the Inspector and sealed. The inspector will keep a record of the test sample in the prescribed form.

8. DETAILED TESTS:

(i) For carrying out the detailed tests, specimens will be drawn from the test samples as under:

(a) Except when the yarn is on pirns/leas (skeins), one from the top portion and one from the middle

portion of each package shall be reeled on a standard wrap reel in accordance with the standard reeling method. Each such lea shall constitute a test specimen.

- (b) When the yarn is on pirns, only one lea shall be so reeled off each pirn. Each such lea shall constitute the test specimen.

The test sample will be subjected to the following laboratory test in accordance with the standard test method:—

(i) (a) Weight per bundle or package (woven dry Wt + 18½% Moisture regain.)

(b) In the case of worsted yarn spun from oil-combed tops the oil content shall not exceed 2¼% by weight of the yarn determined at (a) above.

(ii) Counts of yarn, single thread-breaking strength, turns per inch/10 cms.,

(iii) In case of dyed yarn:—

** (a) Correctness of shade.

(b) Fastness to light (at least Class IV), in accordance with I.S.I. specification.

(c) Fastness to washing (wash wheel test No. 1) in accordance with I.S.I. classification.

(iv) Nature of fibre composition and percentage of different constituent fibres by weight.

(v) Extractable matter-not more than 10% by weight.

9. TOLERANCES:

After receipt of the test report the same will be compared with the standards as specified in the contract:

Weight : -2%

Count—

Woollen : ±7.5%

Worsted : ±5%

Strength : -7.5%

Turns per inch : +7.5%

Evenness : Grade-as per A.S.T.M. standard for worsted and woollen yarn.

**Material falling below the above standards shall be rejected.