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Ministry of Textiles

Office of the Jute Commissioner

3rd MSO Building, CGO Complex, DF-Block, E & F Wing, 4th Floor,
Sector-I, Salt Lake City, Kolkata – 700 064.

Dated December 9th 2015

NOTIFICATION

S.O In the interest of supply of quality jute products to all consignees / consumers and in exercise of the powers conferred under Clause 4 of the Jute & Jute Textiles Control Order 2000, I, Subrata Gupta, Jute Commissioner, hereby notify the following specifications for 50 Kg capacity B-Twill sacking bags. These specifications shall be read along with the relevant BIS standards (as amended till date) and in case of conflict, the following specifications would prevail.

A. Specification for Sampling & Criteria for Conformity of Bags :

[To be read with IS 9113: 2012 (Second Revision), Annex – E (Clause – 7)]

E-3 Sample Size for Bags -

For freedom from defects, length, width, Ends/dm, Picks/dm, number of Stitch/dm, mass per bag and moisture regain, 7 (Seven) Bags shall be selected at random from each Bale selected as per E-2 of IS 9113 : 2012. The total number of Bags to be tested from each lot for these is given in Column 5 of Table 4.

E-4 Criteria for conformity –

E-4.1 Criteria for conformity for Freedom from defects: -

Each bag selected in the sample shall be tested for freedom from defects. A bag shall be termed as defective if it contains two or more major defects (*see* Annexure C of IS 9113: 2012). A lot shall be considered conforming to this requirement, if the number of defectives is less than or equal to the acceptance number given in column 6 of Table 4. **Acceptance numbers given in Table 4 are on the basis of an AQL of 4.0 percent.**

E-4.1 (a) Additional Criteria for conformity for Bag Dimension (length & width) to be read with the existing standard (IS 9113: 2012), under clause E-4

“The dimension of at least 90% of the bags under test is in accordance with the requirement specified. Out of the remaining 10% bags, dimension of not a single bag is below specified nominal value by more than 1.5 cm & 1.0 cm in case of length & width respectively.”

E-4.2 Criteria for conformity Ends/dm, Picks/dm, No. of Stitches/dm and Moisture Regain.

The lot which meets requirements of E-4.1 & E-4.1 (a) shall be tested for Ends/dm, Picks/dm, Number of Stitches/dm and moisture regain as per the plan. A bag shall be termed as defective, if it fails to meet any one or more of these requirements. The lot shall be considered as conforming to the requirements of Ends/dm, Picks/dm, Number of Stitches/dm and moisture regain, if the total number of defects found in the sample is less than or equal to the corresponding acceptance number given in Column-6 of Table-4.

Table – 4 Sample Size and Acceptance Number

(Clause E-2, E-3, E-4.1, E4.1 (a) and E-4.2.)

SL No.	No. of bales in the lot	No. of bales in the Sample	For Ends/dm, Picks/dm, No. of Stitches/dm, Moisture regain.		
			No. of Bags in Each Bale	Total No. of Bags in Sample	Acceptance Number.
(1)	(2)	(3)	(4)	(5)	(6)
i)	Up to 25	5	7	35	5
ii)	26 – 90	8	7	56	6
iii)	91 – 300	12	7	84	8
iv)	301 - 500	18	7	126	10

E-4.3 Criteria for conformity for Mass per Bag

The lot, which meets the above requirements, shall then be tested for mass of bag. The lot shall be declared as conforming to this requirement, if

- the average value of mass per bag, as obtained for sampled bags is not less than the nominal value specified; and
- the corrected mass of at least 80% of the bags under test is in accordance with requirement specified. Out of the remaining bags (20 percent, *Max*), the corrected mass of not more than 10 percent of the bags under test is below the specified value by more than 12% of the specified nominal value.

E-5 Sample Size and Criteria for conformity for Breaking Strength Requirement

The lot, which meets the above requirements, shall then be tested for breaking strength requirements. For this purpose, one bag shall be selected at random for each bale selected in the sample. Suitable test specimens shall be taken from these bags and tested for warpway, weftway and seam strength. The lot shall be declared as conforming to these requirements, if –

- a) the average values of warpway, weftway and seam breaking strengths respectively, as obtained for all test specimens are not less than the corresponding values specified herein; and
- b) none of the individual value is less than 20% below the specified value.

B. Specification for Textiles – Jute Bags for Packing 50 Kg. Food Grains – Specifications

[To be read with IS 12650: 2003 (Second Revision)]

Table – 1 Requirement of Jute Bags (To be read with Clause 4.1 and 5.1 of the above specification).

SL No. (1)	Characteristic (2)	Requirement		Tolerance (5)
		Type A (3)	Type B (4)	
ii)	Ends / dm	46	76	Type A \pm 2 Type B + 4 - 3
v)	Average breaking strength of sacking (revelled-strip method, 10 cm X 20 cm), Min, N (kgf):			
	a) Warpway	1225 (125)	1225 (125)	
	b) Weftway	1225 (125)	1225 (125)	
vi)	Average seam strength (revelled-strip method, (5 cm X 20 cm), Min, N (kgf):	431 (44)	431 (44)	

(The requirement and tolerance for the other characteristics, i.e. Dimension, Picks/dm, Corrected mass/bag (g), Moisture Regain, percent (Max) and Oil content on dry de-oiled material basis, percent (Max) including Note therein, shall be as per IS 12650: 2003 (Second Revision) as amended till date. The method of testing for all the characteristics shall be as per IS 12650: 2003 (Second Revision) as amended till date).

Clause 8 Sampling and Criteria for Conformity to be read along with IS 9113: 2012 Annex E, Clause 7.

8.3 Sample Size for Bags

For freedom from defects, length, width, Ends/dm, Picks/dm, number of Stitch/dm, mass per bag and moisture regain, 7 (Seven) Bags shall be selected at random from each Bale selected as per 8.2 of IS:12650 – 2003 (Second Revision). The total number of Bags to be tested from each lot for these is given in Column 5 of Table 4.

8.4 Criteria for conformity

8.4.1 Criteria for conformity for Freedom from defects

Each bag selected in the sample shall be tested for freedom from defects. A bag shall be termed as defective if it contains two or more major defects (*see* Annexure A of IS 12650: 2003, Second Revision). A lot shall be considered conforming to this requirement, if the number of defectives is less than or equal to the acceptance number given in column 6 of Table 4. **Acceptance numbers given in Table 4 are on the basis of an AQL of 4.0 percent.**

8.4.1 (a) Additional Criteria for conformity for Bag Dimension (length & width) to be read with the existing standard (IS 12650: 2003), under clause 8.4

“The dimension of at least 90 percent of the bags under test will be in accordance with the requirement specified. Out of the remaining bags (10 percent, Max), dimension of not a single bag is below specified nominal value by more than 1.5 cm & 1.0 cm in case of length & width respectively.”

8.4.2 Criteria for conformity Ends/dm, Picks/dm, No. of Stitches/dm and Moisture Regain.

The lot which meets requirements of 8.4.1 & 8.4.1 (a) shall be tested for Ends/dm, Picks/dm, Number of Stitches/dm and moisture regain as per the plan. A bag shall be termed as defective, if it fails to meet any one or more of these requirements. The lot shall be considered as conforming to the requirements of Ends/dm, Picks/dm, Number of Stitches/dm and moisture regain, if the total number of defects found in the sample is less than or equal to the corresponding acceptance number given in Column-6 of Table-4.

Table – 4 Sample Size and Acceptance Number

(Clause 8.2, 8.3, 8.4.1, 8.4.1 (a) and 8.4.2.)

SL No.	No. of bales in the lot	No. of bales in the Sample	For Ends/dm, Picks/dm, No. of Stitches/dm, Moisture regain.		
			No. of Bags in Each Bale	Total No. of Bags in Sample	Acceptance Number.
(1)	(2)	(3)	(4)	(5)	(6)
i)	Up to 25	5	7	35	5
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8.4.3 Criteria for conformity for Mass per Bag

The lot, which meets the above requirements, shall then be tested for mass of bag. The lot shall be declared as conforming to this requirement, if

- a) the average value of mass per bag, as obtained for sampled bags is not less than the nominal value specified; and
- b) the corrected mass of at least 80% of the bags under test is in accordance with requirement specified. Out of the remaining bags (20 percent, *Max*), the corrected mass of not more than 10 percent of the bags under test is below the specified value by more than 12% of the specified nominal value.

8.5 Sample Size and Criteria for conformity for Breaking Strength Requirement

The lot, which meets the above requirements, shall then be tested for breaking strength requirements. For this purpose, one bag shall be selected at random for each bale selected in the sample. Suitable test specimens shall be taken from these bags and tested for warpway, weftway and seam strength. The lot shall be declared as conforming to these requirements, if –

- a) the average values of warpway, weftway and seam breaking strengths respectively, as obtained for all test specimens are not less than the corresponding values specified herein; and
- b) none of the individual value is less than 20% below the specified value.

C. Specification for Textiles – Light Weight Jute Sacking Bags for Packing 50 Kg. Food Grains -

[To be read with IS 16186: 2014]

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Clause 4 **Manufacture –**

- (1) 4.1 – The bags shall be made from single piece of twill weave sacking of uniform construction as given below having nominal mass of 504gm/m² with warp running along length of bag.

Type A – Single warp, double weft woven on modern shuttle-less loom.

Type B – Double warp, single weft woven on conventional shuttle loom.

There shall be a single blue stripe, or stripes woven along the length of the bag or the bag shall be without stripe as agreed to between the buyer and the seller. The constructional particulars

of sacking used in the fabrication of the bags shall be such that the bags meet the requirements specified in Table 1 of IS 16186: 2014, unless mentioned otherwise herein.

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Table – 1 Requirement of Jute Bags (to be read with Clause 4.1 and 5.1 of IS 16186: 2104)

SL No. (1)	Characteristic (2)	Requirement		Tolerance (5)
		Type A (3)	Type B (4)	
ii)	Ends / dm	46	64	Type A \pm 2 Type B +4 - 3
v)	Average breaking strength of sacking (revelled-strip method, 10 cm X 20 cm), Min, N (kgf):			
	c) Warpway	1225 (125)	1225 (125)	
	d) Weftway	1225 (125)	1225 (125)	
vi)	Average seam strength (revelled-strip method, 5 cm X 20 cm), Min, N (kgf):	431 (44)	431 (44)	

(The requirement and tolerance for the other characteristics, i.e. Dimension, Picks/dm, Corrected mass/bag (g), Moisture Regain, percent (Max) and Oil content on dry de-oiled material basis, percent (Max) including Note(s) 1 and 2 therein, shall be as per IS 16186: 2014. The method of testing for all the characteristics shall be as per IS 16186: 2014).

Clause 8 Sampling and Criteria for Conformity to be read along with IS 9113: 2012 Annex E, Clause 7.

8.3 Sample Size for Bags

For freedom from defects, length, width, Ends/dm, Picks/dm, number of Stitch/dm, mass per bag and moisture regain, 7 (Seven) Bags shall be selected at random from each Bale selected as per 8.2 of IS 16186 : 2014. The total number of Bags to be tested from each lot for these is given in Column 5 of Table 4.

8.4 Criteria for conformity

8.4.1 Criteria for conformity for Freedom from defects

Each bag selected in the sample shall be tested for freedom from defects. A bag shall be termed as defective if it contains two or more major defects (*see* Annexure A of IS 16186: 2014). A lot shall be considered conforming to this requirement, if the number of defectives is less than or equal to the acceptance number given in column 6 of Table 4. **Acceptance numbers given in Table 4 are on the basis of an AQL of 4.0 percent.**

8.4.1 (a) Additional Criteria for conformity for Bag Dimension (length & width) to be read with the existing standard (IS 16186: 2014), under clause 8.4

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- b) none of the individual value is less than 20 percent below the specified value.

(F. No. *Zute (C)-6/1/178/RE-3/2015*)


9/XII/2015
(Subrata Gupta)
Jute Commissioner