SRI LANKA STANDARD 710:1985
UDC 677.01:677.06

METHOD FOR
NUMERICAL DESIGNATION OF FABRIC FAULTS BY VISUAL INSPECTION

SRI LANKA STANDARDS INSTITUTION

METHOD FOR NUMERICAL DESIGNATION OF FABRIC FAULTS BY VISUAL INSPECTION

SLS 710:1985

Gr. 3

SRI LANKA STANDARDS INSTITUTION
53, Dharmapala Mawatha,
Colombo 3,
Sri Lanka.

CONSTITUTION OF THE DRAFTING COMMITTEE

CHAIRMAN	*REPRESENTING*
Dr. L.D. Fernando	University of Moratuwa
MEMBERS	
Mr. M.S.J. Fernando	Textile Training and Services Centre
Mr. B.A. Kotuwegedera	Ceylon Silk Limited
Mr. M.A. Mack	Pugoda Textile Mills
Dr. P. Ovitigala	Open University
Mr. T. Rajasekaram	Government Analyst's Department
Mr. S. Wijetillake	Ceylon Institute of Scientific and Industrial Research

TECHNICAL SECRETARIAT

SRI LANKA STANDARDS INSTITUTION

Sri Lanka Standards are subject to periodical revision in order to accommodate the progress made by industry. Suggestions for improvement will be recorded and brought to the notice of the Committees to which the revisions are entrusted.

This standard does not purport to include all the necessary provisions of a contract.

SRI LANKA STANDARD

METHOD FOR NUMERICAL DESIGNATION OF FABRIC FAULTS BY VISUAL INSPECTION

FOREWORD

This Sri Lanka Standard was authorized for adoption and publication by the Council of the Sri Lanka Standards Institution on 1985-10-11, after the draft finalized by the Drafting Committee on Test Methods for Textiles, had been approved by the Textiles Divisional Committee.

A variety of differing methods of assessing and expressing fabrics faults is currently in use. This standard prescribes a single method which is applicable to a wide range of fabrics. It is hoped that this will be viewed as provision of a common language between fabric producers and fabric users.

This standard is intended to be used as a means for the numerical designation of fabric *quality* in so far as the occurrence of faults is concerned. The standard also allows the position of faults to be identified. No acceptance levels are given or suggested since these will depend on the end-use to which the fabric is to be put and should be agreed between the interested parties. The method is particularly useful for the comparison of similar fabrics for specific end-use from different batches or sources.

In the preparation of this standard, valuable assistance derived from the publications of the British Standards Institution is gratefully acknowledged.

1 SCOPE

This standard describes a method for the numerical designation of faults in finished fabrics by visual inspection and gives a means of indicating the position of faults.

2 REFERENCES

SLS 45 Determination of length of woven or knitted fabrics

SLS 46 Determination of width of woven or knitted fabrics

SLS 427 Sampling procedures and tables for inspection by attributes.

3 DEFINITION

For the purpose of this standard the following definition shall apply:

fabric fault : Any feature within the usable width of a fabric which, if it appeared in a finished product, would downgrade that product.

NOTE - This definition does not cover variations in length or width of fabrics which can be determined using **SLS 45** and **SLS 46**.

4 PRINCIPLE

The fabric is examined visually for faults and points are allocated, depending on the dimensions and location of the faults.

5 SAMPLING

If a system of sample inspection is required, the interested parties shall agree on AQL levels (see SLS 427). The pieces examined shall be identified.

6 PROCEDURE AND EXPRESSION OF RESULTS

6.1 Numerical designation of faults

The threshold limit for the minimum size of fault shall be agreed between the interested parties.

Examine the face side of the fabric unless otherwise requested by the purchaser. Use of an inspection machine sufficiently wide to enable the fabric to be examined full width is acceptable. Note the occurence of any fabric faults (see 3) and assign numerical values to each fault, depending on the size of the fault in any direction as follows:

from the agreed threshold limit up to 250 mm in any direction : 1 point;

for every further 250 mm or part thereof in any direction : add 1 further point.

In assigning points, no more than 4 points per m^2 shall be allocated regardless of the number or size of individual faults, and no account shall be taken of a fault within 500 mm on either side of an extended or running fault, or within 250 mm of a point fault.

Record the frequency of full width cuts and subject to agreement, any other major fault.

Record the length of the piece.

Express the result as the number of points per 100 m^2.

6.2 Indication of the position of faults

By agreement, if required, indicate the position of faults by inserting strings, tags or markers at the selvedge of the piece subject to the following.

(a) Two or more faults on the same lateral axis shall be shown by one indicator only; *

(b) Two or more faults within 250 mm on the longitudinal axis shall be shown by one indicator only.*

* In some cases this means that the number of indicators per piece will be less than the number of faults per piece.

7 REPORT

The report shall include the following information:

(a) Reference to this Sri Lanka Standard; that is SLS 710;

(b) The threshold limit for minimum fault size;

(c) The length of the piece;

(d) The fault ratings in points per 100 m^2;

(e) The number of full width cuts and if required, the number of any other major faults;

(f) If required, the number of faults of each point value; and

(g) If required, the number of strings per piece.

SLS CERTIFICATION MARK

The Sri Lanka Standards Institution is the owner of the registered certification mark shown below. Beneath the mark, the number of the Sri Lanka Standard relevant to the product is indicated. This mark may be used only by those who have obtained permits under the SLS certification marks scheme. The presence of this mark on or in relation to a product conveys the assurance that they have been produced to comply with the requirements of the relevant Sri Lanka Standard under a well designed system of quality control inspection and testing operated by the manufacturer and supervised by the SLSI *which includes surveillance inspection of the factory, testing of both factory and market samples.*

Further particulars of the terms and conditions of the permit may be obtained from the Sri *Lanka Standards Institution, 17, Victoria Place, Elvitigala Mawatha, Colombo 08.*

Printed at SLSI (Printing Unit)

SRI LANKA STANDARDS INSTITUTION

The Sri Lanka Standards Institution (SLSI) is the National Standards Organization of Sri Lanka established under the Sri Lanka Standards Institution Act No. 6 of 1984 which repealed and replaced the Bureau of Ceylon Standards Act No. 38 of 1964. The Institution functions under the Ministry of Science & Technology.

The principal objects of the Institution as set out in the Act are to prepare standards and promote their adoption, to provide facilities for examination and testing of products, to operate a Certification Marks Scheme, to certify the quality of products meant for local consumption or exports and to promote standardization and quality control by educational, consultancy and research activity.

The Institution is financed by Government grants, and by the income from the sale of its publications and other services offered for Industry and Business Sector. Financial and administrative control is vested in a Council appointed in accordance with the provisions of the Act.

The development and formulation of National Standards is carried out by Technical Experts and representatives of other interest groups, assisted by the permanent officers of the Institution. These Technical Committees are appointed under the purview of the Sectoral Committees which in turn are appointed by the Council. The Sectoral Committees give the final Technical approval for the Draft National Standards prior to the approval by the Council of the SLSI.

All members of the Technical and Sectoral Committees render their services in an honorary capacity. In this process the Institution endeavours to ensure adequate representation of all view points.

In the International field the Institution represents Sri Lanka in the International Organization for Standardization (ISO), and participates in such fields of standardization as are of special interest to Sri Lanka.

Printed at the Sri Lanka Standards Institution, 17, Victoria Place, Elvitigala Mawatha, Colombo 08.