SRI LANKA STANDARD 283 : PART 1 : 1996

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SPECIFICATION FOR KNITTED VESTS

PART 1 : KNITTED VESTS FOR MALES
(FIRST REVISION)

SRI LANKA STANDARDS INSTITUTION

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SLS 283 : Part 1 : 1996

Gr. 9

SRI LANKA STANDARDS INSTITUTION
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Sri Lanka.

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
SPECIFICATION FOR KNITTED VESTS
PART 1 - KNITTED VESTS FOR MALES
(First Revision)

FOREWORD

This standard was approved by the Sectoral Committee on Textiles, Clothing and Leather and was authorized for adoption and publication as a Sri Lanka Standard by the Council of the Sri Lanka Standards Institution on 1996-08-15.

This standard consists of two parts. This part which covers knitted vests for males is the first revision of **SLS 283 : 1974** ; Plain knitted gents' cotton vests. In this revision, the scope of the standard has been widened to include gents' and boys' vests made of cotton, regenerated cellulose (viscose) or synthetic blends and manufactured from all types of knitted constructions including plain knitted, interlock, rib and their modifications. The second part covers knitted vests for females.

This standard is based on the manufacturing practices followed in the country. The dimensions given in this standard are in SI units.

Guidelines for the determination of compliance of a lot with the requirements of this standard based on statistical sampling and inspection are given in Appendix A.

For the purpose of deciding whether a particular requirement of this specification is complied with the final value, observed or calculated, expressing the result of a test or an analysis shall be rounded off in accordance with **CS 102**. The number of significant places retained in the rounded off value shall be the same as that of the specified value in this specification.

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

1 SCOPE

1.1 This standard prescribes the requirements and methods of test for bleached or dyed knitted vests of round neck or V-neck with or without sleeves for males.

1.2 It does not specify the general appearance, feel, lustre, nor does it specify degree of whiteness of vests.

2 REFERENCE

CS 16 Standard atmosphere for conditioning and testing textiles
CS 102 Presentation of numerical values
SLS 112 Cotton sewing threads
SLS 428 Random sampling methods
SLS 757 Spun polyester sewing threads
SLS 774 Methods of test for knitted fabric construction
SLS 837 Knitted fabrics for gents' and ladies' underwear

3 TYPES

The vests shall be any one of the following types ;

3.1 Round neck, short sleeve

3.2 Round neck, sleeveless

3.3 V-neck, short sleeve

3.4 V-neck, sleeveless

4 MANUFACTURE

4..1 Seams and stitches

4.1.1 The sewing threads for sewing shall be used as agreed to between the purchaser and the supplier and which is selected (see **4.1.2**) shall conform to the requirements of **SLS 112** or **SLS 757**

NOTES

1 The sewing threads which are deemed more suitable for the fabric of vest should be selected for sewing.

2 In the event of seeking a test certificate on this product from a testing authority either the purchaser, supplier or any third party is advised to produce to the testing authority the packages of different sewing threads used for stitching vests along with the samples.

4.1.2 The linear density of sewing thread in both needle and looper for stitching various portions of the vest shall be 20 tex or 30 tex.

A tolerance of ± 10 per cent shall be permitted on the nominal value of linear density of sewing thread selected.

4.1.3 The number of safety stitches and covering stitches shall be not less than 6 per cm while single needle lock stitches shall be not less than 7 per cm.

4.1.4 The types of stitches for various operations of sleeveless and with sleeve vests are given in Tables 1 and 2 respectively.

TABLE 1 - Seams and stitches for sleeveless vests

Sl. No. (1)	Operation to be performed (2)	Type of stitch (3)
(i)	Joining shoulder	3 -Thread safety stitch
(ii)	Taping (Rib) around the neck	3 -Thread top and bottom covering stitch (flat lock)
(iii)	Taping around the arm hole	3 -Thread top and bottom covering stitch (flat lock)
(iv)	Side Seams	4 -Thread safety stitch
(v)	Bottom hemming	3 -Thread safety stitch with folder
(vi)	Attaching label	Single needle lock stitch

TABLE 2 - Seams and stitches for vests with sleeve

Sl. No. (1)	Operation to be performed (2)	Type of stitch (3)
(i)	Joining shoulder	3 -Thread safety stitch
(ii)	Rib joining	Single needle lock stitch
(iii)	Neck attachment	
	a) Neck rib attaching	3 -Thread safety stitch
	b) Neck without rib	3 -Thread safety stitch
(iv)	Attaching Label	Single needle lock stitch
(v)	Sleeve edge	
	a) With hem	3 -Thread safety stitch with folder
	b) With rib	3 -Thread safety stitch
(vi)	Sleeve attaching	4 -Thread safety stitch
(vii)	Side seams	4 -Thread safety stitch
(viii)	Sleeve edge reinforcement	Single needle lock stitch
(ix)	Bottom hemming	3 -Thread safety stitch with folder

4.2 The width of bottom hem, neck opening and in case of sleeveless vests the width of hem at armholes shall be as given in Table 3. The width of bottom hem shall be agreed to upon between the purchaser and the supplier and which is agreed shall be within the range given in the Table.

For each measurement given above, a tolerance of ± 1 mm shall be permitted.

TABLE 3 - Requirements of hemming

Sl. No. (1)	Size of vest (2)	Width of bottom hem (mm) (3)	Width of hem at arm holes and neck (mm) (4)
(i)	Upto 70	12 to 16	6
(ii)	75 to 105	25 to 32	12

4.3 Freedom from defects

The vests shall be free from manufacturing defects such as mends, ladders, dropped stitches, holes, cuts, badly sewn neck and armholes, missed stitches and other damages caused by chemical reactions. They shall not be overboarded.

5 REQUIREMENTS

5.1 Fabric

The vests shall be tailored out of well and evenly knitted fabrics conforming to SLS 837.

NOTES

1 The type of construction of fabric shall be agreed to upon between the purchaser and the supplier and shall be derived by the methods prescribed in ***SLS 774.***

2 In case of tubular fabrics, the width of fabric from which the vests are to be tailored shall correspond to the size of vests for which it is required.

3 In order to illustrate or specify the indeterminable characters, such as general appearance, feel, lustre and degree of whiteness, a sealed reference sample which is agreed upon between the purchaser and the supplier shall be kept at the custody of at any party, as a matter of prior agreement, and the supply shall be in conformity with that reference sample in such respects.

5.2 Dimensions

The dimensions of vests of various types (see Figures 1 to 4) when measured by the method prescribed in Appendix B shall conform to the requirements given in Tables 4 to 7.

5.2.1 Width across chest of all types of vests shall be measured as given in 7.1.1.

5.2.2 In case of V-neck vests, the width of tape around arm holes and/or neck opening shall be 2.3 cm.

A tolerance of ± 0.1 cm shall be permitted on the width of tape.

NOTES

1 The size of vest is denoted by a number which is the numerical value of chest girth in centimetres. For example a size 80 vest represents a vest with chest girth of 80 cm.

2 The shape of sleeves and neck opening may be varied, if desired by the purchaser.

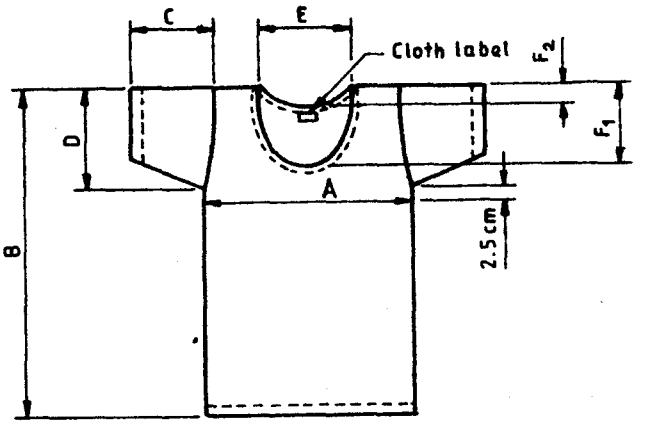

Figure 1

TABLE 4 - Dimensions of vests, round neck, short sleeve
(All dimensions in centimetres)

Size	Width across chest	Length of vest	Length of sleeve	Length of armhole	Width of neck opening	Depth of neck opening	
						Front	Back
	A	B	C	D	E	F_1	F_2
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)
60	30.0	52	14	16	8	10	3
65	32.5	55	14	17	8	10	3
70	35.0	58	15	18	8	11	4
75	37.5	61	15	18	8	11	4
80	40.0	64	16	19	8	12	4
85	42.5	67	16	20	9	12	4
90	45.0	72	17	22	9	13	5
95	47.5	74	17	23	9	13	5
100	50.0	76	18	24	9	14	5
105	52.5	79	18	26	9	14	5
Tolerance	± 1.0	+ 2 - 1	± 1	± 1	± 1	± 1	

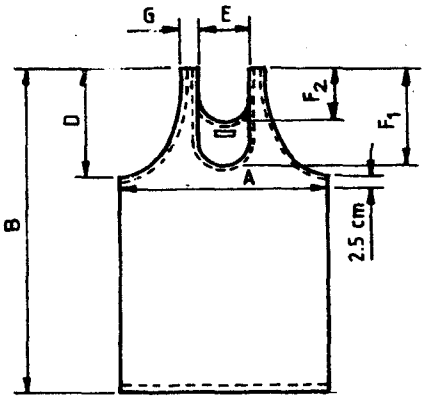

Figure 2

TABLE 5 - Dimensions of vests, round-neck, sleeveless
(All dimensions in centimetres)

Size	Width across chest	Length of vest	Length of armhole	Width of neck opening	Depth of neck opening		Width of shoulder strap
					Front	Back	
(1)	A (2)	B (3)	D (4)	E (5)	F1 (6)	F2 (7)	G (8)
60	30.0	52	16	12	14	6	3.5
65	32.5	55	17	12	14	6	3.5
70	35.0	58	19	12	16	6	4.0
75	37.5	61	20	13	16	6	4.0
80	40.0	64	22	13	17	7	4.0
85	42.5	67	23	14	17	7	4.0
90	45.0	72	24	14	19	8	4.5
95	47.5	74	25	15	19	8	4.5
100	50.0	76	26	15	21	9	4.5
105	52.5	79	27	15	21	9	4.5
Tolerance	± 1.0	+ 2 - 1	+ 2 - 1	± 1	± 1		± 0.5

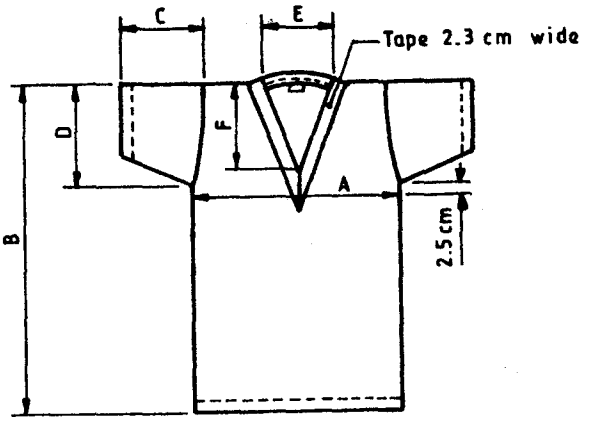

Figure 3

TABLE 6 - Dimensions of vests, V-neck, short sleeve
(All dimensions in centimetres)

Size	Width across chest	Length of vest	Length of sleeve	Length of armhole	Width of neck opening	Depth of neck opening
	A	B	C	D	E	F
(1)	(2)	(3)	(4)	(5)	(6)	(7)
60	30.0	52	14	16	10	13
65	32.5	55	14	17	11	14
70	35.0	58	15	18	12	15
75	37.5	61	15	18	12	16
80	40.0	64	16	19	13	18
85	42..5	67	16	20	14	19
90	45.0	72	17	22	15	20
95	47.5	74	17	23	16	21
100	50.0	76	18	24	17	23
105	52.5	79	18	26	17	24
Tolerance	± 1.0	+ 2 - 1	± 1	± 1	± 1	± 1

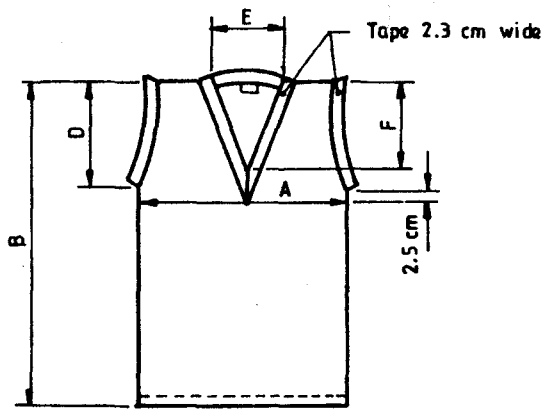

Figure 4

TABLE 7 - Dimensions of vests, V-neck, sleeveless
(All dimensions in centimetres)

Size (1)	Width across chest A (2)	Length of vest B (3)	Length of armhole D (4)	Width of neck opening E (5)	Depth of neck opening F (6)
60	30.0	52	16	10	13
65	32.5	55	17	11	14
70	35.0	58	19	12	15
75	37.5	61	20	12	16
80	40.0	64	22	13	18
85	42.5	67	23	14	19
90	45.0	72	24	15	20
95	47.5	74	25	16	21
100	50.0	76	26	17	23
105	52.5	79	27	17	24
Tolerance	± 1.0	+ 2 - 1	+ 2 - 1	± 1	± 1

6 MARKING AND PACKING

6.1 A suitable cloth label shall securely be attached to each vest at the inside of the neck portion of backside on which shall be indicated the following.

a) Size, in cm;
b) Manufacturer's name or initials of the name or Trade mark ; and
c) Type of material and material composition.

6.2 The vests shall be individually packed in polyethylene bags on which shall legibly and indelibly be marked the following.

a) Name of the product ;
b) Size, in cm ;
c) Type of material and material composition ;
d) Name and address of manufacturer and/or supplier (including the country of origin) ;
e) Brand name, if any ;
f) Registered trade mark , if any ; and
g) Batch identification mark.

6.3 The vests as in **6.2** shall be packed into bundles of any number as agreed to between the purchaser and the supplier and then may be packed in polyethylene bags or cardboard boxes. Each such package shall legibly and indelibly be marked or labelled with the following :

a) All requirements in **6.2** ; and
b) Number of vests in the package.

NOTES

1 When marking on cartons, number of vests (b of ***6.3****) refer to the total vests in the package..*

2 Attention is drawn to the certification marking facilities offered by the Sri Lanka Standards Institution. See inside back cover of this standard.

7 METHODS OF TEST

7.1 Tests for the requirements given in **4** and **5** shall be carried out as prescribed in relevant Sri Lanka Standards given therein and Appendix **B** of this specification.

7.1.1 In case of width across chest of vest, that measurement shall be made across the points 2.5 cm below the lowermost position of arm holes.

7.2 The conditioning and testing atmosphere shall be the standard atmosphere for conditioning and testing textiles as defined in CS 16 (for example, a relative humidity of 65 ± 2 per cent and a temperature of 27 ± 2°C).

APPENDIX A
COMPLIANCE OF A LOT

The sampling scheme given in this Appendix should be applied where compliance of a lot to the requirements of this standard is to be assessed based on statistical sampling and inspection.

Where compliance with this standard is to be assured based on manufacturer's control systems coupled with type testing and check tests or any other procedure an appropriate scheme of sampling and inspection should be adopted.

A.1 LOT

In any consignment all packages of vests of the same size, material composition and construction and belonging to one batch of manufacture or supply shall constitute a lot.

A.2 SCALE OF SAMPLING

A.2.1 Samples shall be tested from each lot for ascertaining its conformity to the requirements of this specification.

A.2.2 The number of vests to be selected from a lot shall be in accordance with Table 8.

A.2.3 The number of bundles or cartons to be selected shall be in accordance with Table 8. One vest shall be selected from each bundle or carton so selected to form a sample.

A.2.4 The bundles or cartons and individual packages shall be selected at random. In order to ensure randomness of selection, tables of random numbers as given in SLS 428 may be used.

A.3 NUMBER OF TESTS

A.3.1 Each vest selected as in A.2.2 or A.2.3 shall be inspected for marking and packing requirements given in 6.1 and 6.2.

A.3.2 Each bundle and/or carton selected as in A.2.3 shall be inspected for packing and marking requirements given in 6.3.

A.3.3 Each vest selected as in A.2.2 or A.2.3 shall be inspected/measured for the requirements given in 4.1.3, 4.1.4, 4.2, 4.3 and 5.2.

A.3.4 Each vest selected as in Column 4 of Table 8 shall be tested for the requirements given in 4.1.1, 4.1.2, and 5.1.

A.4 CRITERIA FOR CONFORMITY

A lot shall be declared as conforming to the requirements of this specification if the following conditions are satisfied.

A.4.1 Each vest inspected as in A.3.1 satisfies the marking and packing requirements.

A.4.2 Each bundle or carton inspected as in A.3.2 satisfies the packing and marking requirements.

A.4.3 The vests inspected/measured as in A.3.3 satisfy the requirements given therein in such a way that the number of nonconforming vests observed in the lot shall not exceed the permissible number allowed as given in Column 3 of Table 8.

A.4.4 All the vests tested as in A.3.4 satisfy all the requirements given therein.

TABLE 8 - Scale of sampling

Number of vests in the lot	Dimensions and visual inspection		Number of vests to be tested for the requirements related to A.3.4
	Number of vests to be inspected	Permissible number of non-conforming vests	
(1)	(2)	(3)	(4)
Up to 50	8	0	3
51 to 100	13	1	4
101 to 150	20	1	5
151 to 300	32	2	6
301 to 500	50	3	7
501 to 1 000	80	5	8
1 001 and above	125	7	10

APPENDIX B
METHOD OF MEASURING DIMENSIONS

B.1 PROCEDURE

B.1.1 Lay flat and allow the vest to relax, free from applied tension, in the standard atmosphere for at least 24 h and condition it until the differences between successive measurements, made at intervals of at least 24 h, of the appropriate measurements at three noted measuring points (if possible) is less than 0.25 per cent at each measuring point.

B.1.2 Take each measurement to the nearest millimetre with the steel rule resting in a direction parallel and close to the measuring points that are to be measured of the vest as shown in the Figures. In case when measurements cannot be taken by a ruler, an accurate measuring tape may be used.

B.1.3 Take the average of measurements obtained in **B.1.2** to calculate the final measurement.

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.*

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SRI LANKA STANDARDS INSTITUTION

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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.

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