



उत्पाद मैनुअल
Textiles- Gents Pullover, Knitted
IS 3617:2022 के अनुसार

PRODUCT MANUAL FOR
Textiles- Gents Pullover, Knitted
According to IS 3617:2022

विभिन्न उत्पादों के लिए भारतीय मानक ब्यूरो (अनुरूपता मूल्यांकन) विनियम 2018 की योजना- I के तहत प्रमाणन के संचालन में अभ्यास और पारदर्शिता के संचालन में पारदर्शिता सुनिश्चित करने के लिए इस उत्पाद मैनुअल का उपयोग सभी क्षेत्रीय / शाखा कार्यालयों और लाइसेंसधारियों द्वारा संदर्भ सामग्री के रूप में किया जाएगा। दस्तावेज़ का उपयोग बीआईएस प्रमाणन लाइसेंस/प्रमाणपत्र प्राप्त करने के इच्छुक संभावित आवेदकों द्वारा भी किया जा सकता है

This Product Manual shall be used as reference material by all Regional/Branch Offices & licensees to ensure coherence of practice and transparency in operation of certification under Scheme-I of Bureau of Indian Standards (Conformity Assessment) Regulations, 2018 for various products. The document may also be used by prospective applicants desirous of obtaining BIS certification licence/certificate.

1.	उत्पाद Product	:	IS 3617:2022
	शीर्षक Title	:	Textiles- Gents Pullover, Knitted - Specification
	संशोधनों की संख्या No. of amendments	:	0
2.	नमूना दिशानिर्देश Sampling Guidelines		
a)	कच्चा माल Raw material	:	Yarn shall comply to the requirements given in 4.1 and 4.2. Fabric shall comply to the requirements given in 4.3. Seams and Stitches shall comply to the requirement given in 4.4. Conformity of raw material to the requirements may be established through test certificate of supplier, or test report from BIS recognized/empanelled or NABL accredited lab or in-house testing
b)	समूहीकरण दिशानिर्देश Grouping Guidelines	:	कृपया Annex-A देखें Please see Annex-A
c)	नमूने का आकार Sample Size	:	2 Pullover

3.	परीक्षण उपकरण की सूची List of Test Equipment	:	कृ पया Annex-B देखें Please refer Annex –B
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4.	परीक्षण उपकरणों की सूची List of Test Equipment	:	कृ पया Annex-C देखें Please refer Annex - C
5.	एक दिन में संभावित परीक्षण Possible tests in a day	:	Dimension, Construction, pH
6.	लाइसेंस का दायरा /Scope of the Licence :		
	Licence is granted to use Standard Mark as per IS 3617:2022 with the following scope:		
	उत्पाद का नाम Name of the product	Textiles- Gents Pullover, Knitted	
	Class/Type	Woollen Pullover(Superfine/fine/medium)/ AcrylicPullover/ Blended Pullover	
	Sizes	75/80/85/90/95/100/105/110 cm	

ANNEX A
GROUPING GUIDELINES

IS 3617 mentions 3 classes of pullovers (woollen/Acrylic/Blended), any size from a class shall be tested to cover all the sizes for that particular class.

For woollen pullovers, separate samples of Superfine/fine/medium quality shall be drawn and tested

However, scope shall be restricted based upon the manufacturing and testing capability of the manufacturing unit.

During the operation of the licence, samples of each type and size covered in the licence shall be drawn and tested in rotation to the extent possible

ANNEX B
List of Test Equipment

Major test equipment required to test as per the Indian Standard

Sr. No.	Test Equipment	Tests used in with Clause Reference
1	Tape	DIMENSIONS(Clause 5.1)
2	Magnifying Glass/pick glass Horizontal surface	Construction(Clause 5.2)
3	APPARATUS • Cubex International Shrinkage Testing Apparatus or Wash Wheel or an Equivalent Machine • A Laboratory or Domestic Spin Drying Apparatus • Marking Equipment - As specified in 4.3 of IS : 10099-1982 • Make-Weights • Analytical balance • pH meter REAGENTS • Anhydrous sodium dihydrogen phosphate • Other laboratory reagents	Dimensional Change (due to relaxation) (Clause 5.2)
4	APPARATUS • Weighing Balance • Oven (capable of capable of maintaining temp of 105±3°C) • Soxhlet apparatus REAGENTS • Benzene • Methyl alcohol • Cotton wool • Petroleum ether	Scouring loss(Clause 5.2)
5	APPARATUS • Water bath capable of maintaining a temperature of 66±0.5°C. • Conical flask • Sintered Glass filter crucible • pH Meter • Soxhlet apparatus • Weighing balance • Dessicator	Alkali Solubility (Clause 5.2)

	REAGENTS • Sodium Hydroxide • Acetic acid • Light petroleum ether • Distilled water • Liquor	
6	Distilled or deionized water Mechanical shaker Potassium Chloride (KCl) solution Buffer solution Stoppered glass or polypropylene flasks Beaker Rod pH meter (LC 0.1 Ph) 1 ltr volumetric flask Balance accurate to 0.01 g	pH Value of Aqueous Extract (Clause 5.2)
7	a) Colour Fastness to light (IS/ISO 105-B02 : 2014): Xenon-arc apparatus as per IS/ISO 105-B02 : 2014 b) Colour Fastness to washing (IS/ISO 105-C10:2006) Suitable mechanical laundering device Balance accurate to 0.01 g Mechanical Stirrer Non corrodible (Stainless Steel) Balls Means of Heating soap solution Soap Sodium Carbonate Soap Solution Grade 3 Water Adjacent fabrics/Multifibre adjacent fabric c) Colour fastness to rubbing (IS/ISO 105-X12 : 2016) Suitable testing device Soft-back waterproof abrasive paper, or grating of stainless steel wire 1 mm in diameter and mesh width about 20 mm. Rubbing cotton cloth Grey Scale for evaluating staining d) Colour fastness to dry cleaning (IS 4802:1988) Suitable mechanical device Glass or stainless steel containers	Minimum Colour Fastness ratings (Clause 5.2)

	Non corrodible (Stainless Steel) Discs Undyed Cotton twill cloth Grey Scales Glass tubes Perchloroethylene or Any Other Solvent Used for Dry-Cleaning	
8	For identification of textile fibres as per IS 667:1981 - Compound microscope, dissecting needles, glass slides, cover glasses and a cross- sectioning device. The microscope should be equipped to permit examination from 100X to 500x Apparatus/reagents for quantitative chemical analysis of mixtures of fibres as per IS 11195-1985	Fibre Composition (Clause 5.2)
9	Projection microscope (500 X magnification), microtome, glass slide, cover glass, and mounting medium for calculation of diameter of wool fibre as per IS 744:2000 (referred in IS 5911:1977)	Fineness of wool (Clause 5.2)

The above list is indicative and may not be treated as exhaustive

ANNEX C

SCHEME OF INSPECTION AND TESTING

1. **LABORATORY** - A laboratory shall be maintained which shall be suitably equipped (as per the requirement given in column 2 of Table 1) and staffed, where different tests given in the specification shall be carried out in accordance with the methods given in the specification.

1.1 The manufacturer shall prepare and implement a calibration plan for the test equipments.

2. **TEST RECORDS** –The manufacturer shall maintain test records for the tests carried out to establish conformity.

3. **PACKING AND MARKING**– The Standard Mark, as given in the Schedule of the licence, shall be printed on the cloth label attached to each pullover on the inside of the neck portion (back side) or at the right side on the body of the seam in case of high neck pullover, provided always that the pullovers to which this mark is thus applied conforms to every requirement of the specification.

3.1 The pullovers shall be packed properly (see IS 3353 or IS 2518). A cloth label of suitable size shall be securely attached to each pullover on the inside of the neck portion (back-side) or at the right side on the body of the seam in case of high neck pullover, on which shall be indicated the following:

- a) Name of manufacture or trade mark;
- b) Batch/lot no and date of manufacture
- c) Size
- d) Class of pullover
- e) Designation for woollen pullover only
- f) Fibre/blend composition
- g) Care labeling
- h) Country of manufacture; and
- i) Any other information required by the buyer or law in force

3.2 The following shall be marked either on the cloth label or on the packaging of the pullover or on both

- j) BIS Licence No. CM/L_____.
- k) BIS website details i.e –“For details of BIS certification please visit www.bis.gov.in”.

4. **CONTROL UNIT** – For the purpose of this scheme, all pullovers of the same class (and category in case of woollen pullovers) manufactured in a day under similar conditions shall constitute a control unit.

5. **LEVELS OF CONTROL** – The test as indicated in column 1 of Table 1 and the levels of control in column 3 of table 1, shall be carried out on the whole production of the factory which is covered by this plan and appropriate records maintained in accordance with paragraph 2 above.

All the production which conforms to the Indian Standards and covered by the licence should be marked with Standard Mark

6. **REJECTIONS** - Disposal of non conforming product shall be done in such a way so as to ensure that there is no violation of provisions of BIS Act, 2016

TABLE 1: LEVELS OF CONTROL

(1)				(2)	(3)		
Test Details				Test equipment requirement R: required (or) S: Sub-contracting permitted	Levels of Control		
CI No	Requirement	Test Method			No. of Sample	Frequency	Remarks
		Clause	Reference				
4	Manufacture	4	IS 3617				
4.2	Conformity of Yarn	4.2	IS 3617	S	1	Each consignment	If received with test certificate of supplier, testing is not required
4.3	Conformity of Fabric	4.3	IS 3617	S	1	Each consignment	-do-
4.4	Seams and Stitches	4.4	IS 3617	S	1	Each consignment	-do-
4.5	Pullover – Shape, Welt (or tape), Border, High neck portion, reinforcements, freedom from defects	4.5.1 to 4.5.7	IS 3617	R	1	Each Control unit	
5.1	Dimension and Tolerance	C-1	IS 3617	R	1	Each Control unit	-
5.2	Requirements of Pullover						
i)	Construction	C-2	IS 3617	R	1	Each control unit	-
ii)	Dimensional change		IS 1313	S	1	Once in 3 months	Whenever raw material and construction is changed it should be done
iii)	Scouring loss	C-3	IS 3617	R	1	Once in a week	-
iv)	Alkali Solubility		IS 3429	R	1	Once in a week	-

v)	pH value of aqueous extract		IS 1390	R	1	Once a week	-
vi)	Minimum colour fastness ratings			S	1	Once in 3 months	These tests are type test and shall be carried out at the time of initial approval or whenever there is any change in the design, Shade and construction.
a)	Light		IS/ISO 105-B02				
b)	Washing: Test A(1) i) Change in colour ii) Staining of adjacent fabric		IS/ISO 105 C-10				
c)	Rubbing (Dry and wet)		IS/ISO 105 X-12				
d)	Dry-cleaning		IS/ISO 105-D01				
vii)	Fibre composition		IS 11195 or IS 667	S	1	Once in a year	These tests are type test and shall be carried out at the time of initial approval or whenever there is any change in the raw material.
viii)	Fineness grade of wool (woollen pullover)		IS 5911	R	1	Each control unit	For woollen pullover

Note-1: Whether test equipment is required or sub-contracting is permitted in column 2 shall be decided by the Bureau and shall be mandatory. Sub-contracting is permitted to a laboratory recognized by the Bureau or Government laboratories empaneled by the Bureau.

Note-2: Levels of control given in column 3 are only recommendatory in nature. The manufacturer may define the control unit/batch/lot and submit his own levels of control in column 3 with proper justification for approval to BO Head.