

STORE HOLDER'S INABILITY SHEET

SIS NUMBER : 26270412

DATE : 08/09/2026

VETTED FOR

TECHNICAL PARTICULARS ONLY

Item Code : 2101290010

HDPE DOT COATED PRINTED FUSIBLE INTERLINING FABRIC 150 CMS
MINIMUM EXCLUDING SELVEDGES.SPECIFICATION : IND/TC/2089 (a) & APPENDIX 'E' OF PART - 1
OF IAFS 09149 (OVERALL GROUND CREW):2025 (MAY)

- 1) FABRIC IN ROLL FORM SHALL BE SUPPLIED 40 METERS IN
CONTINUOUS RUNNING LENGTH WITHOUT STITCHING/ BASTING
IN BETWEEN.
- 2) WEIGHT SHALL NOT BE MORE THAN 50 KGS PER ROLL.
- 3) EACH ROLL OF FABRIC SHALL BE WRAPPED SEPERATELY WITH
POLYPROPYLENE PLAIN SHEET.
- 4) FINAL PACKING OF 2 ROLLS IN WATER PROOF GUNNY/HDPE SHEETS

NOTE:

I. DIMENSION OF PAPER TUBE FOR WINDING THE FABRIC IN ROLL:

OUTER DIAMETER - 3.5 CM

INNER DIAMETER - 2.5 CM

THICKNESS - 0.5 CM

II. FABRIC SELVEDGES SHALL BE WOUND EVENLY AT ONE EDGE.

- 5) PACKING & MARKING : AS PER SCHEDULE NO. CQA(T&C)/PMS/35(D)
- 6) SAMPLING PLAN : AS PER RELEVANT CLAUSE OF SPECIFICATION.

IAFS 09149 (Overall Ground Crew) : 2025 (May)

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PROPERTY	REQUIRED VALUE	TEST METHOD	
		STD	STD NO
	(b) <u>For Hook Tape 25 mm wide:</u> White Colour (Note : Colour fastness to light and washing – both should be better than 4)		
FUSIBLE INTERLINING MATERIAL			
Interlining material (To be used for (a) 'Collar' (b) 'Collar Band' (c) Both shoulder flaps (d) Both thigh pocket flaps (e) Pen pocket flap (f) Both waistline adjustment flaps.)	Type : Fusible Base material : Either 100% Cotton OR 80% Cotton (pprox...) & 20 % Polyester (approx..) Coating : 100 % HDPE (i.e. High Density Poly Ethylene) powder resin (single coated) GSM : 160 g/m² (min.) to 180 g/m² (max.) Colour : White or Dull White	IS / ISO/ AATCC	IS 667 : 1981 (RA 2017) , AATCC 20 / 20 A : 2021 (For checking the base material as well as the coating material) ISO 13934-1 {For checking the bond strength . <u>Note 1</u> : For preparation of the test specimen for bond strength

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	<u>Bond strength</u> (a) <u>After fusing (before washing)</u> Tensile strength; required to peel off the fuzzed specimen of 20 cm x 5 cm strip size; should be 2000gf / 5cm (minimum) i.e. 20N / 5cm (minimum) (b) <u>After normal machine wash (at 40°C, 75 minutes washing cycle, line dry)</u> Tensile strength; required to peel off the fuzzed specimen of 20 cm x 5 cm strip size; should be 1800N / 5cm (minimum) i.e. 18N / 5cm (minimum) Wash shrinkage (Fabric + interlining) after single normal machine wash : + 0.5 % to 2.0 %		determination, cut the test specimens (fuzzed assembly of base fabric + interlining) of size 5 cm X 20 cm. Manually strip (i.e. separate both the fused films) the test specimen at one of the ends over a distance of 2.5 cm. Secure the base fabric evenly in the upper jaw and the interlining in the lower jaw. <u>Note 2</u> The required test specimens are to be provided by the firm along with the BPC sample / bulk production samples OR to the lab for testing at the time of

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	Heat shrinkage after fuzing (Fabric + interlining) : $\pm 0.5 \%$ Note-1 The interlining used, should have been procured with 'detailed fusing (i.e. process) instructions (procedure)'; issued by the 'original manufacturer'. Before procurement of interlining, the blend composition of the base fabric being used in the manufacturing of the OH Ground Crew also needs to be communicated clearly to the manufacturer of the interlining. The procedure (fusing instructions); shared by the manufacturer; should clearly spell out the following :- (e) 'Product details for which the		obtaining Lab test reports against technical bidding } IS 2977 :1989 (RA 2020) & IS 15370 : 2020 (at $41 \pm 3^{\circ}\text{C}$) (for wash shrinkage after normal machine wash) {Heat shrinkage after fusing can be calculated by following the procedure as enumerated in ISO 7771:1985 (disregarding the soaking part). <u>Note 3</u> The necessary test specimens as per ISO 7771:1985 (disregarding the soaking part); are to be provided by the firm along with the BPC sample / bulk

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	procedure is applicable'. (ii) The 'processing temperature range' at which fusing is to be carried out for optimum results <i>{In this regard the 'upper limit fusing temperature' as well as the ' lower limit fusing temperature' should be clearly specified}</i> (iii) The 'processing pressure' to be applied during the entire fusing time (kgf/cm²) <i>(with the fabric + fusing interlining sandwiched between moving heated rollers)</i> (iv) The fusing i.e. processing time (s) for which the interfacing layers are to be subjected to the specified 'processing temperature' and 'processing pressure'. (v) Process enforced cooling period (with		production samples OR to the lab for testing at the time of obtaining Lab test reports against technical bidding }

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	water cooled plates / forced air circulation vacuum) on the fused assemblies to achieve a consolidated bond, which enables the assembly to be handled immediately after cooling is completed. Note-2: The correspondence made with the manufacturer / authorised dealer of the manufacturer of the interlining as well as the 'fusing instructions furnished by the original manufacturer' should be produced along with the Technical bid documents as well as to the inspection agency of IAF. Note-3 The fusing should be carried out exactly as per the procedure shared / recommended by the original manufacturer of the 'fusible interlining' for reliability of the fused assembly, which would be evaluated by		

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	measuring the bond strength, specified above.		