

**VARIOUS POLYESTER VISCOSE BLENDED DOPE DYED FABRICS**

This document list out the essential plant and machinery requirement of various polyester viscose blended dope dyed fabrics. This document also list out the essential test equipment requirement of various polyester viscose blended dope dyed fabrics.

**Plant & Machinery Requirement for spinning:** (Essential for Uniform fabrics and Optional for Non-uniform fabrics)

1. Blending Machine (If blending carried out at Blow Room stage)
2. Blow Room Line
3. Carding Machines
4. Draw Frames
5. Speed Frames/Roving Frames
6. Ring Frames
7. Autoconer or equivalent Cone Winding Machine with electronic yarn cleaner device and splicing arrangement.
8. Parallel Winding
9. Two For One Twisters (TFO)
10. Steam Chamber / Autoclave

Note:-

1. In addition to above, controlled atmosphere of production shop for Humidity & Temperature is an essential requirement.

**Essential Plant & Machinery Requirement for Weaving:** (Essential for Uniform fabrics and Legal Tie up permitted for Non-uniform fabrics)

1. High Speed Warping Machine.
2. Sizing Machine (Must necessary for fabric produced with single ply warp yarn and may not be mandatory for the same with double/multi fold yarns.
3. Shuttle less looms.

Note:-

1. Controlled atmosphere of Production Shop for humidity & temperatures is an essential requirement.

**Essential Plant and Machinery Requirement for Processing:-**

1. Grey Fabric Inspection Machine
2. Singeing
3. Stenter
4. Padding mangle (If required)
5. Desizing machine/unit (If sizing has been carried out during weaving preparatory)
6. Kier Decatising Machine (If required)
7. Sanforising or Zero-Zero Machine (If required)

Note:-

1. For weaving process, legal tie up with other firm is permitted, but it must be valid for at least 03 years. Legal agreement documents shall be submitted by the firm applying for registration. Spinning process shall be optional.
2. An undertaking by the firm having legal agreement for the weaving facilities will be submitted in the requisite format to agree that in the case of securing the order against a tender enquiry, firm will submit the documentary evidence in the form of invoices/e-way bills for utilizing the weaving facility with the legal tie up firm.
3. If the firm does not possess any of the essential Plant & Machinery, then it should not be recommended for registration.

4. Firm must possess valid pollution consent/clearance certificate from respective State Pollution Control Board.

**Essential Test Equipments:-**

1. Measuring Scale/Tape for length/width measurement.
2. Pick Glass/Counter for End/Picks.
3. Weighing Balance for GSM and miscellaneous works.
4. Template for Shrinkage Test for relaxation shrinkage.
5. Twist Tester for turn per dm.
6. Tensile Strength Tester for Breaking Load.
7. Digital PH Meter for pH value of aqueous extract.
8. Scouring Loss Test Apparatus (Soxhlet Apparatus, Oven & Glassware) for scouring loss/various chemical tests.
9. Crock meter for dye fastness to rubbing.
10. Perspirometer for colour fastness to perspiration.
11. Laundrometer for Colour fastness to washing.
12. Colour fastness to Light Test
13. Blend Composition Test Apparatus (Chemical Balance, Oven & Glassware) for blend Composition.
14. Nature of Dye Testing Facility for dye identification (Hydro, Chloro & Levelling test).
15. Spectrophotometer (wherever applicable) for L, C, H and Delta values.
16. Heat shrinkage testing facility.
17. Tearing Strength tester.
18. Crease Recovery tester.
19. Abrasion resistance tester.
20. Drape meter (Where ever Applicable)
21. Pilling Tester (Where ever Applicable)

Note: -

1. Outsourcing arrangement with NABL accredited lab is allowed only for the test parameter such as Colour fastness to Light /Spectrophotometer Tester. In this regard, registering firm shall submit a letter issued from NABL accredited lab to the firm that they are undertaking testing of samples received from the firm and the test parameter is within their scope of accreditation. If the firm does not possess any of the essential test equipments as per requirement of specification except the parameters for which outsourcing from NABL accredited lab has been permitted, then it should not be recommended for registration.
2. Controlled Atmosphere of Laboratory for humidity & temperatures is an essential requirement.
3. The above list of test equipment is illustrative in nature which may or may not be relevant for certain type of fabric. Therefore at the time of registration process, the requirement of test equipment in accordance with test parameters in the specification and the test equipment shall have required range to test the required parameters, to be checked from the firm's submitted documents.
4. Firms to give the declaration for supplying the materials with the same legal tie up firm (Wherever legal tie-up has been permitted) having validity of legal tie up for minimum 03 years.
5. At the time of supply of material by the firm having secured a contract, firm should forward the necessary documents like e-way bill, commercial invoice issued by legal tie up firm along with the firm's own invoice so as to authenticate/verify the receipt of material from the same legal tie up firm.
6. Vendor shall also give an undertaking in the prescribed format regarding complete understanding of specification requirement and other requirement as mentioned in the item.
7. In case of falsification of documents and other instances, firm will be De-registered for the period of 03 years for entire range of products for any category.
8. CV norms are generic in nature and are to be used as criteria for consideration of any firm registered for any item of a particular category. Therefore, if a firm is registered for any item, it will be considered as registered for all the similar items (as notified) falling under that CV norms category.