DRAFT TANZANIA STANDARD

Textiles — A-Twill Jute Bags — Specification
**Foreword**

The objective of this second edition Draft Tanzania Standard is to assist trade between manufacturers, buyers and users of jute bags, by providing a mutual understanding basis for specifying the minimum requirements of jute bags for packing various food grains.

In the preparation of this Draft Tanzania Standard the views of consumers, manufacturers and traders have been taken into consideration. Assistance was also derived from:

1. **SCOPE**

This Draft Tanzania Standard mainly prescribes the technical requirements relating to the manufacture of A-Twill jute bags and does not purport/imply to include all the provisions of a contract.

2. **NORMATIVE REFERENCES**

The following referenced documents are indispensable for the application of this Draft Tanzania Standard.

- TZS 20, Textiles – Woven or knitted fabrics – Determination of number of threads per centimetre
- TZS 21, Textiles – Determination of mass per unit length and per unit area of woven or knitted fabrics
- TZS 22, Textiles – Determination of breaking load and extension of strips of woven fabrics
- TZS 44, Textiles – Woven or knitted fabrics – Determination of length and width

3. **TERMS AND DEFINITIONS**

For the purpose of this Draft Tanzania Standard the following terms and definitions shall apply:

3.1 **A-Twill bag**

A double warp hemmed twill bag of 112 cm × 67.5 cm size and weighing 1190 g with three blue stripes woven along the length of the bag

3.2 **Lot**

bales of jute bags bearing specified dimension and quality, containing one definite number of bags, delivered to one buyer against one dispatch note.

3.3 **Bale**

rectangular or square pressed, sized package, containing jute bags with outer layer stitched and bound by metal straps.

3.4 **Ends**

warp threads of the fabric

3.5 **Porter**

value obtained by counting the number of warp threads per full gauge length of 47 mm and dividing it by the number of warp threads per split. Picks (or shots) – The weft or filling thread of a fabric

   NOTE – Shots per inch = picks per decimetre x 0.254.

3.6 **Joined bag**

bag made out of one piece of jute sacking.

4. **GENERAL REQUIREMENTS**
4.1 Sacking

The bags shall be made from single pieces of double warp threads, 2/1 twill weave jute sacking of uniform construction having nominal mass of 750 g/m² with warp running along the length of the bag. There shall be three blue stripes or stripes as agreed between the manufacturer and supplier, woven along the length of the bag. The constructional particulars of sacking used in the fabrication of the bags shall be such that the bag meets the requirement specified in Table 1 or reverse twill weave i.e. single warp threads (porters) and double weft threads (shots).

The jute sacking shall be generally of uniform construction. Its selvedge should be firm and straight and shall have a single blue strip (or strips) of single or double warp, as agreed to between the buyer and the seller, woven along the length of the cloth.

4.2 Seam

The sides of the bags shall be sewn with overhead stitches on selvedge through two layers of sacking using two strands of 3-ply jute twine. The stitching shall be of even tension throughout with all the loose ends securely fastened. The number of stitches per 10 cm shall be between 9 and 11.

4.3 Safety stitch

A line of safety stitch shall be provided at the inner edges of the overhead stitches. The number of safety stitches per 10 cm shall be between 9 and 11.

4.4 Hemming at the mouth

At the mouth of the bag, the raw edges of the sacking shall be turned over first to a depth of about 1 cm and then to a depth of 2 cm and the three layers of sacking thus formed shall be hemmed with jute yarns.

4.5 Joined bag

The seam used to join the two pieces of cloth in a joined bag shall have the strength not less than the breaking strength of sacking as specified in Table 1 and the seam shall be tight enough to prevent leakage of the contents.

4.6 Freedom from defects

The bags shall be generally free from weaving and sewing defects such as missing picks, holes, cuts, tears, floats, crushed selvedge, sports, stains, gap stitches, loose ends and frayed ends which affect the performance of the bag.

5. SPECIFIC REQUIREMENTS

5.1 The bags shall conform to the requirements given in Table 1.

5.2 The bales containing the bags shall conform to the requirements specified in Table 1.

5.3 The moisture regain shall not be more than 20%
Table 1 – Particulars of bags

<table>
<thead>
<tr>
<th>S/N</th>
<th>Characteristic/test</th>
<th>Requirement</th>
<th>Test method</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Dimensions of bag</td>
<td>The dimensions should be upon agreement between buyer and seller. However, it shall be within the tolerance limit of ±2 of the declared nominal value.</td>
<td>TZS 44: 1981</td>
</tr>
<tr>
<td>2</td>
<td>Mass, g, min</td>
<td>1100</td>
<td>TZS 21</td>
</tr>
<tr>
<td>3</td>
<td>Mesh size, min</td>
<td>a) Ends per dm</td>
<td>TZS 20: 1979</td>
</tr>
<tr>
<td></td>
<td></td>
<td>b) Picks per dm</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>96</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>33</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>Breaking load, N, min</td>
<td>(Ravelled strip method 10 cm × 20 cm)</td>
<td>TZS 22</td>
</tr>
<tr>
<td></td>
<td></td>
<td>a) Warp way</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>b) Weft way</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>2000</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>1765</td>
<td></td>
</tr>
<tr>
<td>5</td>
<td>Average breaking load of seam</td>
<td>(ravelled strip method, 10 cm × 20 cm) min,</td>
<td>IS 9030: 1979</td>
</tr>
</tbody>
</table>

6. PACKING AND MARKING

6.1 Packing
The bags shall be packed in bales or as agreed between the buyer and the seller.

6.2 Marking
Each bag shall be marked with the name of the manufacturer/trade mark and size.
The bales shall be marked with the following information:

a) Address and/or trade name of manufacturer
b) Number of bags
c) Dimensions
d) Weight
e) Country of origin

6.3 The bales may also be marked with the standard mark of quality. The details of conditions under which the license for the use of standard mark of quality may be granted to manufacturers or producers may be obtained from Tanzania Bureau of Standards.
7. CRITERIA FOR CONFORMITY

The lot shall be deemed as conforming to the requirements of this Draft Tanzania Standard when the following conditions are met:

a) The average ends per decimetre of the bags under test are in accordance with the requirement specified in Table 1.

b) The average picks per decimetre of the bags under test are in accordance with the requirement specified in Table 1.

c) The breaking load values of the bags under test for both warp and weft directions shall be as requirements specified in Table 1.