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Series 4
Série des 4

WITHDRAWAL

December 2018

Selected standards in the series Textiles

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Décembre 2018

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CAN/CGSB-4.31-2014

Terry towels and towelling (ICS 59.080.30)

CAN/CGSB-4.69-2014

Terry washcloths (ICS 97.160)

CAN/CGSB-4.117-2014

Polyester/cotton plain fabric (105 g/m², 150 g/m² and 170 g/m²) (ICS 59.080.30)

CAN/CGSB-4.141-2014

Polyester/cotton twill fabric (170 g/m² and 245 g/m²) (ICS 59.080.30)

CAN/CGSB-4.157-2014

Generic names for man-made fibres (ICS 59.060.20)

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CAN/CGSB-4.31-2014

Serviettes et essuie-mains en tissu éponge, sur rouleau (ICS 59.080.30)

CAN/CGSB-4.69-2014

Débarbouillettes en tissu éponge (ICS 97.160)

CAN/CGSB-4.117-2014

Tissu de polyester et coton, armure unie (105 g/m², 150 g/m² et 170 g/m²) (ICS 59.080.30)

CAN/CGSB-4.141-2014

Tissu armure sergée polyester/coton (170 g/m² et 245 g/m²) (ICS 59.080.30)

CAN/CGSB-4.157-2014

Noms génériques des fibres chimiques (ICS 59.060.20)



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CAN/CGSB-4.31-2014

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Terry towels and towelling

ICS 59.080.30



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Terry towels and towelling

CETTE NORME NATIONALE DU CANADA EST DISPONIBLE EN VERSIONS
FRANÇAISE ET ANGLAISE.

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Conseil canadien des normes

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¹ General interest

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Withdrawn

Terry towels and towelling

1 Scope

This National Standard of Canada applies to terry towels and towelling. It states the requirements for cotton and cotton/polyester commercial towels and for cotton/polyester utility/institutional towels and towelling.

The testing and evaluation of a product against this standard may require the use of materials and/or equipment that could be hazardous. This standard does not purport to address all the safety aspects associated with its use. Anyone using this standard has the responsibility to consult the appropriate authorities and to establish appropriate health and safety practices in conjunction with any applicable regulatory requirements prior to its use.

2 Normative references

The following normative documents contain provisions that, through reference in this text, constitute provisions of this National Standard of Canada. The referenced documents may be obtained from the sources noted below.

NOTE The addresses provided below were valid at the date of publication of this standard.

An undated reference is to the latest edition or revision of the reference or document in question, unless otherwise specified by the authority applying this standard. A dated reference is to the specified revision or edition of the reference or document in question. However, parties to agreements based on this National Standard of Canada are encouraged to investigate the possibility of applying the most recent editions of the normative documents indicated below.

2.1 Canadian General Standards Board (CGSB)

CAN/CGSB-4.2 — *Textile test methods:*

No. 5.1 — *Unit mass of fabrics*

No. 9.2 — *Breaking strength of fabrics — Grab method — Constant-time-to-break principle*

No. 14 — *Quantitative analysis of fibre mixtures*

No. 15 — *Non-fibrous materials on textiles*

No. 17 — *Cuprammonium fluidity of textile cellulose* (withdrawn in 2008)

No. 18.3/ISO 105-B02 — *Textiles — Tests for colourfastness — Part B02: Colourfastness to artificial light: xenon arc fading lamp test*

No. 22 — *Colourfastness to rubbing (crocking)*

No. 24 — *Colourfastness and dimensional change in commercial laundering*

CAN/CGSB-4.131 — *Cotton-covered or polyester-covered polyester thread*

CAN/CGSB-4.139 — *Polyester staple thread.*

2.1.1 Source

The above may be obtained from the Canadian General Standards Board, Sales Centre, Gatineau, Canada K1A 1G6. Telephone 819-956-0425 or 1-800-665-2472. Fax 819-956-5740. E-mail ncr.cgsb-ongc@tpsgc-pwgsc.gc.ca. Web site www.tpsgc-pwgsc.gc.ca/ongc-cgsb.

2.2 International Organization for Standardization (ISO)

ISO 675 — *Textiles — Woven fabrics — Determination of dimensional change on commercial laundering near the boiling point.*

2.2.1 Source

The above may be obtained from IHS Global Canada Ltd., 200-1331 MacLeod Trail SE, Calgary, Alberta T2G 0K3, telephone 613-237-4250 or 1-800-267-8220, fax 613-237-4251, Web site www.global.ihs.com.

3 Classification

3.1 The towels and towelling shall be supplied in the following classes and types, as specified (see 8.1).

3.1.1 Classes

Class A — Commercial towels

Class B — Utility/institutional towels and towelling.

3.1.2 Types

Type 1 — Cotton

Type 2 — Cotton/polyester blend (minimum 80% cotton content).

4 General requirements

4.1 The towels and towelling covered by this standard shall be free from imperfections and blemishes that may adversely affect their appearance or serviceability.

4.2 For inspection purposes, imperfections and blemishes shall be considered defects when clearly visible at a normal distance of approximately 1 m under good lighting conditions.

5 Detailed requirements

5.1 Materials

5.1.1 Yarns

- a. **Pile Warp** — The pile warp yarns shall be singles, 100% cotton.
- b. **Ground warp** — The ground warp yarns shall be singles or 2-ply carded cotton yarns, or single yarns spun from a blend of polyester and cotton fibres. When tested in accordance with CAN/CGSB-4.2 No. 14, the polyester content shall not exceed 65%.

- c. **Weft** — The weft yarns shall be single carded cotton yarns or single yarns spun from a blend of polyester and cotton fibres. When tested in accordance with CAN/CGSB-4.2 No. 14, the polyester content shall not exceed 65%.

5.1.2 Sewing thread

Unless otherwise specified (see 8.1), the thread shall be R 40 tex in accordance with CAN/CGSB-4.131 or CAN/CGSB-4.139, Table 1. The colour of the sewing thread shall match the towel.

5.2 Construction

5.2.1 Weave

The weave shall be a 3-pick terry. The ratio of feed of the pile warp to the ground warp shall not be less than 4 to 1.

NOTE A ratio of 3.5 to 1 is acceptable for class B crested towels.

5.2.2 Selvages

The selvages shall be natural, pile-free and 6 mm wide on each side of the towel. Alternatively, towels may be multiwoven with a pile free strip separating each towel; this pile free strip when slit shall be turned in with the raw edges turned under (side hemmed) and securely lock-stitched or chain-stitched to form a 6 mm finished hem.

5.2.3 End hemming

The ends shall be pile free for approximately 3 cm. Each end shall be turned in and with the raw edge folded under, lock-stitched through 2 mm gauge to form a 1 cm finished hem.

5.2.4 Stitching

All stitchings shall not be less than two and not more than four stitches per centimetre. The ends of the stitchings, and any breaks in the thread during sewing operations, shall be securely backstitched.

5.3 Design

The design (cross stripes, pile-free areas, woven identifications, etc.) shall be as agreed between the purchaser and the supplier as specified (see 8.1).

5.4 Colour

The colour of the towels and towelling shall be as specified (see 8.1). When required to be white, the towels and towelling shall be given full commercial bleach and shall meet the requirements for Cuprammonium fluidity specified in Table 1.

5.5 Sizes

Unless otherwise specified (see 8.1), the dimensions of the finished towels and towelling shall be as specified below. The measurements shall be taken with the towel and towelling placed on a flat surface in a relaxed position.

5.5.1 Tolerances

The tolerances apply to the widths and lengths of the towels and to the width of the towelling. There is no restriction to tolerances on the plus (+) side, but there is a tolerance of 3% on the minus (-) side of the dimensions specified below.

5.5.2 Class A Towels

- a. Bath: width 55 cm x length 120 cm
- b. Hand: width 38 cm x length 70 cm

5.5.3 Class B towels and towelling

- a. Bath: width 55 cm x length 110 cm
- b. Hand: width 38 cm x length 63 cm
- c. Towelling: width 55 cm x 50 to 75 m per roll

5.6 Fabric

When tested in accordance with the specified test methods, the fabric shall comply with the requirements of Tables 1 and 2.

5.7 Marking

Any required marking of towels and towelling other than the design marking indicated in 5.3 shall be as specified (see 8.1).

6 Preparation for delivery

6.1 Packaging and labelling

Unless otherwise specified (see 8.1) normal commercial practice of packaging and labelling shall be acceptable. It is the manufacturer's responsibility to see that goods are packaged in a suitable manner to be delivered in an undamaged condition.

7 Inspection

7.1 Sampling

Sampling shall be left to the discretion of the purchaser, unless a specific sampling plan is specified (see 8.1).

7.2 The inspection authority reserves the right to perform any inspections considered necessary to ensure that material and services conform to the specified requirements.

8 Notes

8.1 Options

The following options shall be specified in the application of this standard:

- a. Class and type of towels and towelling (see 3.1)
- b. Sewing thread, if other than as specified (see 5.1.2)
- c. Design (see 5.3)

- d. Colour (see 5.4)
- e. Sizes (see 5.5)
- f. Marking, if required (see 5.7)
- g. Packaging and labelling details, if normal commercial practice is not suitable (see 6.1)
- h. Sampling, if a specified plan is required (see 7.1).

Withdrawn

Table 1 — Type 1 and type 2 terry towels — Class A (Commercial)

Property	Test method	Requirements					
		Specified			Acceptable minimum		Acceptable maximum
Mass per unit area, g/m ²	CAN/CGSB-4.2 No. 5.1	470			450		—
Breaking strength, N, terry portion	CAN/CGSB-4.2 No. 9.2		Cotton	Cotton/ polyester		Cotton	Cotton/ polyester
		Warp	230	230	Warp	210	210
		Weft	245	245	Weft	223	223
Colourfastness:							
— to rubbing	CAN/CGSB-4.2 No. 22	Grey Scale 4			Grey Scale 3		
— to light	CAN/CGSB-4.2 No. 18.3/ ISO105-B02	Standard L7			Standard L6		—
— to laundering	CAN/CGSB-4.2 No. 24	No appreciable change in colour, Grey Scale 5			No appreciable change in colour, no appreciable staining, Grey Scale 4		
Dimensional change in washing, %	ISO 675	—			—		Warp 8.0 Weft 4.0
Cuprammonium fluidity (Type 1 white only), (Pa·s) ⁻¹	CAN/CGSB-4.2 No. 17	—			—		80
Non-fibrous materials, %	CAN/CGSB-4.2 No. 15	—			—		3.0

Table 2 — Type 1 and type 2 terry towels and towelling – Class B (Utility/institutional)

Property	Test method	Requirements			
		Specified		Acceptable minimum	Acceptable maximum
Mass per unit area, g/m ²	CAN/CGSB-4.2 No. 5.1	340		340	—
Breaking strength, N, terry portion	CAN/CGSB-4.2 No. 9.2		Cotton/ polyester		Cotton/ polyester
		Warp	230	Warp	210
		Weft	245	Weft	223
Colourfastness:					
— to rubbing	CAN/CGSB-4.2 No. 22	Grey Scale 4		Grey Scale 3	
— to light	CAN/CGSB-4.2 No. 18.3/ ISO105-B02	Standard L7		Standard L6	
— to laundering	CAN/CGSB-4.2 No. 24	No appreciable change in colour, Grey Scale 5		No appreciable change in colour, no appreciable staining, Grey Scale 4	
Dimensional change in washing, %	ISO 675	—		—	Warp 8.0 Weft 4.0
Non-fibrous materials, %	CAN/CGSB-4.2 No. 15	—		—	3.0