



The Industry Voice for Workplace Solutions

Standard For Woven Textile Characteristics

BIFMA International
Date: March 9, 2005

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BIFMA Tex4.1-2005

Proposed Standard for Woven Textile Characteristics

1 Scope/Background

This standard is intended to define “policies” established for textile flaws, bow and skew, directionality, and fractional measurement; and to provide a common basis for differentiating the face from the back of a woven textile fabric roll and the top of the pattern. This document applies to all woven textile fabric materials unless otherwise noted as exceptions.

This document is based on the actual experience of BIFMA International members and their suppliers. The Textiles Subcommittee of BIFMA’s Supply Chain Management Committee analyzed the textile supply process for both standard fabrics that office furniture manufacturers buy directly from textile manufacturers, as well as direct or indirect supply of textiles supplied by the jobber members of the Association for Contract Textiles.

The subcommittee initiated their work by identifying areas for improvement and polling office furniture manufacturers (OFM) to determine whether inconsistencies existed, both for standard fabrics as well as for the COM (Customer’s Own Material) fabrics supplied by jobbers. Then textile suppliers were polled to determine their capabilities. Meetings were held to discuss discrepancies and work towards harmonizing the standards where possible. Every effort was made to come to agreement on the highest possible standard requirements. In addition, the commitment was made by the subcommittee to regularly review the standards, with the goal of continuously improving them wherever possible.

Please note, the buyer and seller reserve the right to negotiate an agreement that could differ from this standard as dictated by the service, product, or application.

2 Definitions

Note: Refer to BIFMA PD-1 Industry Product Definitions for related terms not included in this standard. Otherwise, the common dictionary definition shall be used for terms not defined in this section or in BIFMA PD-1.

- 2.1 Bow:** The greatest distance, measured parallel to the selvages, between a filling or course yarn, stripe, or dominant line and a straight line perpendicular to the selvages.

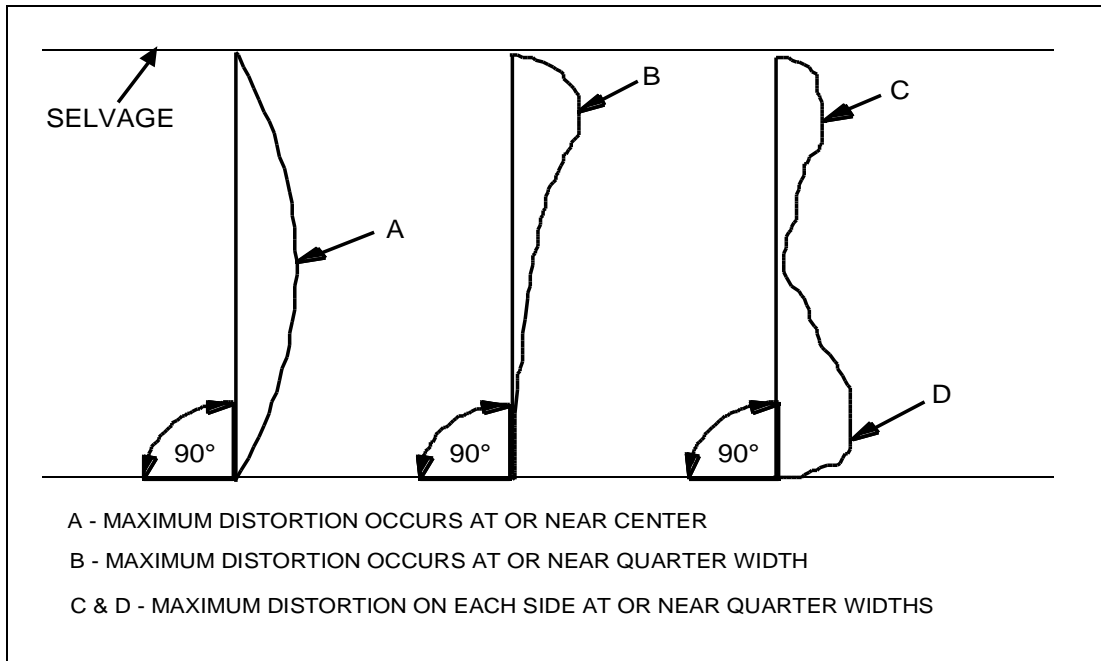


Figure 1 - Method of measurement for maximum distortion due to bow

- 2.2 COM:** Customer's Own Material
- 2.3 Filling Yarn:** In a woven fabric, the yarn running from selvage to selvage at right angles to the warp. Each crosswise length is called a "pick".
- 2.4 Flaw:** An imperfection in the design intent of the textile pattern, or a soiling of the fabric.
- 2.5 Floats:** The portion of a warp or filling yarn that extends over two or more adjacent filling picks or warp ends in weaving for the purpose of forming certain designs.

- 2.6 **Identification Cord:** The contrasting yarn woven into the edge of a pattern, also known as a Leno Cord.
- 2.7 **OFM:** Office Furniture Manufacturer
- 2.8 **Selvage:** The finished edge of a fabric that is woven so that it will not fray or ravel.
- 2.9 **Skew:** The distance measured parallel to and along a selvage between the point at which a filling or course yarn, stripe, or dominant line meets this selvage and a perpendicular line to the selvage from the point at which the same filling yarn, stripe, or dominant line meets the other selvage.

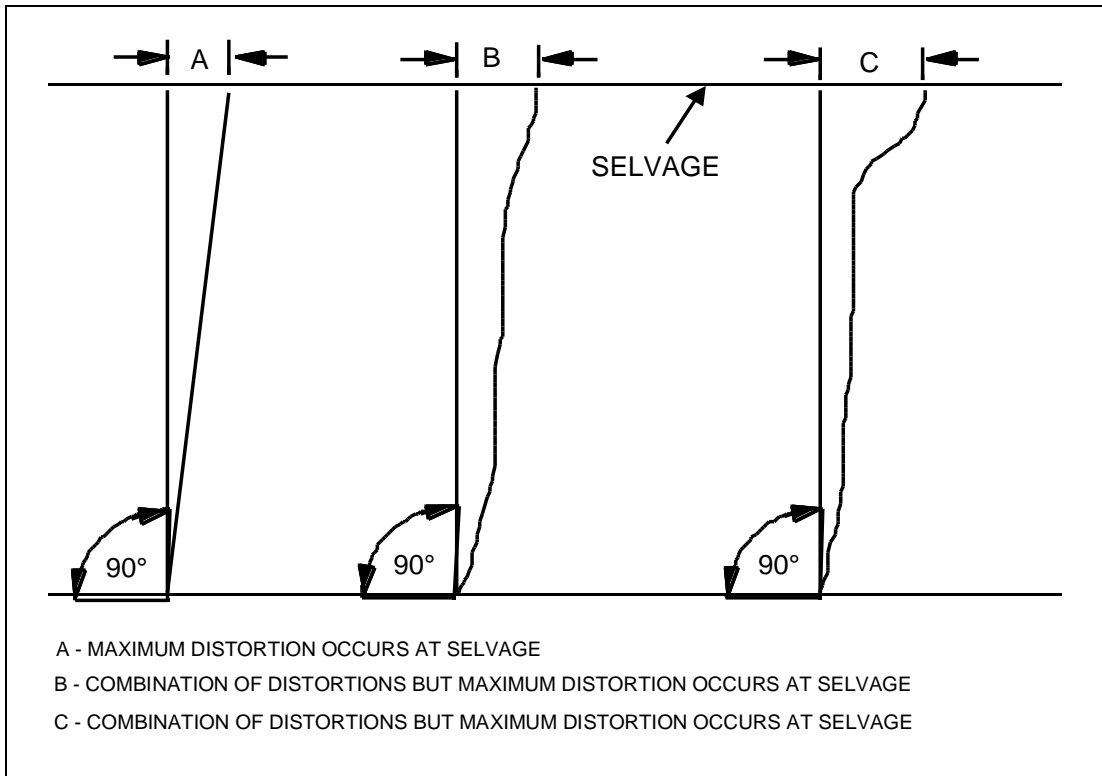


Figure 2 - Method of measurement for maximum distortion due to skew (bias)

- 2.10 Textile Supplier:** The source of the woven textile material.
- 2.11 Warp Yarn:** The set of yarn in all woven fabrics, that runs lengthwise and parallel to the selvage and is interwoven with the filling.
- 2.12 Warp Horizontal:** The width direction of a woven piece.
- 2.13 Warp Vertical:** The length direction of a woven piece.

3 Identification Cord

3.1 Placement of the Identification Cord

The textile supplier will be responsible to insure the fabric pattern identification cord is running down the right side of the roll as one would face the roll and pull yardage off face up. (See Figure 1 and Figure 2) The identification cord may be any color, and should be distinct from other yarns comprising the body of the fabric. The identification cord should be woven in such a way that the floats on the face of the fabric (inside of roll) are substantially longer than the floats on the backside. This will serve to determine the face from the back of a fabric roll and the top of a pattern from the bottom.

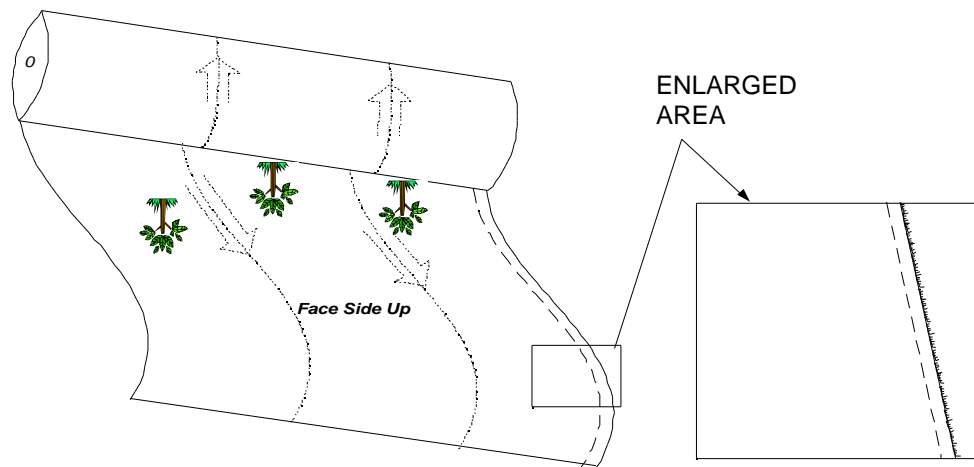


Figure 3 – Fabric Roll with Identification Cord, top of the pattern is running warp vertical away from the roll as the leading edge is pulled out.

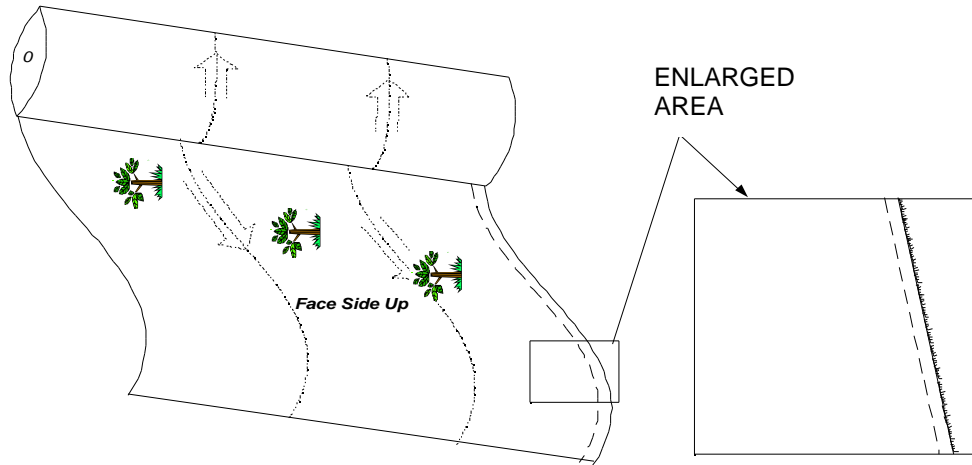


Figure 4 – Fabric Roll with Identification Cord, top of the pattern running warp horizontal and to the left as the leading edge is pulled out.

Note: Exceptions to this standard are the responsibility of the Textile Supplier to determine and provide an acceptable alternative method to identify the directionality of the fabric that is agreed to by the furniture manufacturer. Examples: Knit materials, non-woven, reversible fabrics, etc.

4 Textile Policies

4.1 Spot Flaw Policy

4.1.1 COM Fabrics – the minimum requirement for COM fabrics for both upholstery and panel use is an average of one flaw per seven (7) yards of fabric.

4.1.2 Standard Fabrics - the minimum requirement for standard fabrics for both upholstery and panel use is an average of one flaw per ten (10) yards of fabric.

4.1.3 Allowance – a minimum of one eighth (.125) of a yard will be credited per spot flaw.

Note: A description of flaws and defects will be agreed to between the furniture manufacturer and the supplier.

4.2 Running Flaw Policy

For both COM and standard fabrics, yardage equal to the length of the flaw will be credited.

4.3 Bow and Skew Policy

For both COM and standard fabrics, the bow and skew tolerance will be no more than 1" across the roll for 66" width fabric or below.

4.4 Yardage Accuracy Policy

For both COM and standard fabrics the requirement will be plus or minus 1% from the stated yardage on the invoice.

4.5 Face Directionality Policy

The face of the fabric will always be rolled toward the inside of the roll.

4.6 Fractional Measurement Policy

Fractional measurements for all fabrics will be standardized at one tenth of a yard as opposed to the current one eighth of a yard. For many textile suppliers and OFM's this will be a future goal they will work toward as they upgrade their measurement equipment.

5 Shipping Label/Packaging List Required Information

- 5.1** It is important that the Purchasing Company and the Supplier make sure that all pertinent information is entered when the order is placed. The shipping label supplied with the roll of fabric shall contain the following information:
- 5.1.1** Supplier Name/Address
 - 5.1.2** Ship To Name/Address
 - 5.1.3** Purchasing Company Name/Address
 - 5.1.4** Ship Date
 - 5.1.5** Purchase Order Number (from Purchasing Company)
 - 5.1.6** Customer Reference Number/Name (this could be the Purchasing Company reference, the Ship To Company reference, or both-many Office Furniture Manufacturers require that their part number is noted, regardless of whether or not the Purchaser requires it) (example: Part Number/Name)
 - 5.1.7** Supplier Reference Number/Name (example: Pattern, Color Number/Name)
 - 5.1.8** Gross Yards
 - 5.1.9** Net Yards
 - 5.1.10** Lot Number
 - 5.1.11** Piece Number
 - 5.1.12** Sidemark (example: Job Number, End User's Purchase order Number, etc.)
 - 5.1.13** Barcode is required by some Office Furniture Manufacturers
- 5.2** The Packaging List shall include the same information, with the addition of the Carrier Name.

End of Document