

Men's and boys' trousers — Specification

Part 1:

Making up requirements

Public review Draft

DKS 559-1: 2019

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Bedi Investments
Kenyatta University
University of Nairobi
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DKS 559-1: 2019

Foreword

This Kenya Standard was prepared by the Technical Committee on Ready Made Garments under the guidance of the Standards Projects Committee, and it is in accordance with the procedures of Kenya Bureau of Standards

This standard was formulated with a view to help manufacturers in producing goods of satisfactory quality. Manufacturers and others concerned are urged to label the men's and boys' trousers in accordance with KS 412, Specification for size designation for men's and boys' ready-to-wear clothing and KS ISO 3758, Textiles — Care labelling code using symbols.

In this third edition of this Kenya Standard, the following changes have been made:

- i) Clause 4.7 on hems has been reviewed.
- ii) The title of Clause 4.9 has been changed to 'securing belt loops'. The word 'or securely stitched added'
- iii) The parameter of pockets clause 4.4 has been updated
- iv) The number of seam of stiches per cm has been reviewed to 4
- v) The minimum requirements of outlet allowance have been reviewed to 4

During the preparation of this standard, reference was made to the following document:

IS 7414, Specification for men's trousers' — General requirements.

Acknowledgement is hereby made for the assistance received from this source.

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Part 1:

Making up requirements

1 Scope

This Kenya Standard prescribes materials and making-up requirements for uniform coats including jackets and blazers.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies:

KS 412, *Specification for size designation for men's and boys' ready to wear clothing*

KS 479-1, *Specification for sewing threads Part 1: Cotton sewing threads*

KS 479-2, *Specification for sewing threads Part 2: Sewing threads made wholly or partly from synthetic fibres*

KS 520, *Specification for woven fabrics used for suits, jackets and trousers*

KS 585, *Specification for zippers*

KS 665, *Specification for textile labels*

KS 688, *Glossary of terms used by the clothing industry*

KS 697-1, *Code of practice for grading of textile materials Part 1: Fabrics*

KS 2234, *Denim fabrics — Specification*

KS ISO 3758, *Textiles — Care labelling code using symbols*

3 Terms and Definitions

For the purposes of this standard, the definitions given in KS 688 shall apply:

4 Requirements

4.1 Size designation

The trousers shall be designated by three numbers denoting three dimensions in the order of waist girth, hip and outside leg length as given in KS 412.

4.2 Fabric materials

4.2.1 The fabrics for the manufacture of trousers shall comply with the requirements of KS 520 and KS 2234.

DKS 559-1: 2019

4.2.2 Fabric grade

4.2.2.1 The quality grade of fabric shall be of at least grade 2 when assessed in accordance with KS 697-1.

4.2.2.2 The fabrics shall also be free from the objectionable flaws including the following:

- a) Float.
- b) Bar due to difference in raw material, count, twist, lustre, colour, shade or spacing of adjacent group of threads.
- c) Slub or slubby yarn or gout.
- d) Printing or dyeing defect or broken pattern.
- e) Missing threads extending over 10 cm.
- f) Any other defect which would significantly mar the appearance or affect the serviceability or durability of the garment.

4.3 Standards of manufacture

4.3.1 Components

All components of the trousers namely, front side, back side, waist band, button stand, button catch and belt loops shall be cut longitudinally (warp wise direction).

4.3.2 Top side and Under side

4.3.2.1 Pleats

The pleats, if any shall be provided on each top side of the trousers at waist spaced evenly and facing towards the side seam.

4.3.2.2 Darts

Each back side of the trousers shall have one or two darts.

The front and backside of trousers shall be assembled with plain split (pressed open) seams at sides, leg and seat when made from polyester, woollen or blended fabrics. In case of trousers made from cotton fabrics, assembling of the top and the underside shall be done by lapped seams.

4.3.2.3 Front and back side

The front and backside of trousers shall be assembled with plain split (pressed open) seams at sides, leg and seat when made from polyester, woollen or blended fabrics. In case of trousers made from cotton fabrics, assembling of the top and the underside shall be done by lapped seams.

4.4 Pockets

The pocket lining material shall conform to KS 214-2. Raw edges of pockets shall be properly secured to prevent fraying.

4.5 Waistband

The waistband shall be made of double thickness of body material or the body material on the outside and the same material as that used for pockets under 4.3 above shall be used as facing on the inside. A shirt gripper shall be attached to the centre of the facing of the waistband. The left front of the waistband shall extend for 6 cm beyond the centre front seamline.

4.6 Fly and button stand

The button catch and stand shall be lined with either body material or lining of tightly woven cotton poplin or blend fabric. The button end or the fly shall be either bartacked or tacked with 3 rows of machine stitching. Four buttons/buttonholes shall be provided in the fly in addition to those provided in the waistband for men's trousers and three button/buttonholes for boys' trousers. As an alternative to buttons, zippers may be used.

4.7 Hems

The bottoms of the regular trousers may be hemmed. The hem shall be sewn in place with a slip-stitch or hemming stitch for turned under or seam binding finishes and a blind stitch for overcast finishes. The completed hem shall be inconspicuous from the outside and the raw edges finished securely without bulk.

4.8 Cuffs

The upper edge of cuffs shall be a bit wider than pants leg; cuffs in fabrics such as knits shall be interfaced to prevent them from collapsing.

4.9 Securing Belt loops

If the trousers are provided with belt loops, the ends of loops shall be reinforced with three rows of stitches or securely stitched.

4.10 Buttons and buttonholes

4.10.1 The buttons shall be stitched with not less than 12 stitches through each pair of hole when sewn by machine or 11 stitches of single thread and five stitches of double thread when sewn on by hand. The thread shall be wound round the stitches six times when single threads or three times when using double threads to form a neck. All ends shall be securely fastened.

NOTE In case of button stitching by machine, the winding of thread around the button to form a neck is not possible.

4.10.2 The number of stitches on buttonholes shall be not less than 8 per cm when stitching is carried out manually and not less than 9 per cm when stitched on machine. Buttonholes shall be bartacked with not less than 5 stitches or fish tailed and shall be cleanly cut. All ends of threads shall be securely fastened. The length of the buttonhole shall be 0.3 cm greater than the diameter plus the thickness of the button.

4.11 Seams and stitches

4.11.1 The trousers shall be assembled with lock/chain stitches regulated at not less than 4 stitches per cm.

4.11.2 Seam width

All seams shall be not less than 1 cm.

4.11.3 Stitch finishing and quality

The ends of all seams and stitchings, and all breaks in the thread shall be securely backstitched. Stitches shall present a regular even appearance without fabric pucker and shall be free from skips that may result from faulty machine thread tension or other stitching malfunction.

4.11.4 All raw edges shall be turned under and stitched.

4.12 Outlet allowance

An outlet allowance of 4 cm in addition to the seam allowance shall be provided at the back seat seam near the waistline.

DKS 559-1: 2019

4.13 Trouser defects

4.13.1 The trousers shall be free from the following fabrication defects:

- a) Stains.
- b) Defective stitching.
- c) Loose ends of sewing thread getting easily frayed.
- d) Hole, cut or tear.
- e) None-alignment of pockets, buttons and buttonholes.
- f) Any other defect which would significantly mar the appearance or affect the serviceability of the garment.

5 Ancillaries

5.1 Buttons

The buttons shall be of good quality and conform to the relevant Kenya Standards for buttons. The shade of buttons shall match with that of the fabric.

5.2 Eyelets and hooks

Eyelets and hooks shall be rust-proof.

5.3 Linings and interlinings

Linings and interlinings used for pockets and waistbands shall have characteristics of colourfastness and dimensional stability similar to those of the base cloth. The characteristics of the interlinings and linings shall conform to KS 214 for interlinings and linings.

5.4 Sewing threads

Synthetic fabrics shall be sewn only with synthetic threads, and synthetic natural fibre blend fabrics in which the synthetic is the majority shall be sewn only with synthetic blend threads in which synthetic is the majority. Natural fibre fabrics shall be sewn with mercerized cotton threads. Buttons and buttonholes shall be sewn with blends, cotton (polished), nylon or polyester or any other appropriate synthetic stronger than cotton. The sewing thread shall conform to the requirements of KS 479. The shade of sewing thread shall match with that of the fabric.

5.5 Zippers

Zippers shall conform to the requirements of KS 585. The shade of zippers shall match with that of the base cloth.

6 Marking and labelling

6.1 Each garment shall bear a permanent label complying with KS 665 including the following information:

- i) The manufacturer's name or identification mark;
- ii) Care labelling in accordance with KS ISO 3758;
- iii) The size code and size designation in accordance with KS 412;
- iv) Fibre composition of the fabric;

v) The inscription “Country of Manufacture”.

6.2 The size designation may be put on a detachable swing ticket.

6.3 The permanent label or swing ticket shall be securely attached to the garment and so positioned as to be easily readable.

7 Packaging

Each pair of trousers shall be packaged in such a way so as to avoid soiling in storage as well as transit.

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