



NOTICE

This documentation has been reviewed by the technical authority and does not contain controlled goods. Disclosure notices and handling instructions originally received with the document must continue to apply.

AVIS

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**SPECIFICATION  
FOR  
TAPE, TEXTILE, BIAS, SINGLE FOLD**

1.1 Scope

This specification covers the requirements for two types of single fold bias tape.

1.2 Classification

The tape must be classified as follows:

- (a) Type I: Bias tape for disposable items; and
- (b) Type II: Bias tape for non-disposable items.

1.3 Applicable Documents

The following documents form part of this specification to the extent specified, and are supportive of this specification when referenced; all other document references are to be considered supplemental information only. In the event of a conflict between the documents referenced and the contents of this specification, then the contents of this specification must take precedence:

CAN/CGSB Standards (email: [ncr.cgsb-ongc@pwgsc.gc.ca](mailto:ncr.cgsb-ongc@pwgsc.gc.ca))

- CAN/CGSB-4.2-M Textile Test Methods

American Association of Textile Chemists and Colorists Standards ([www.aatcc.org](http://www.aatcc.org))

- AATCC Test Method 16 Colourfastness to Light

FED Standards (Download Documents: <http://assist.daps.dla.mil/quicksearch/>)

- FED-STD-595C - Colors Used in Government Procurement

1.4 Order of Precedence

In the event of any inconsistency in contract documents such as contract, specification and sealed patterns, the order of precedence must be contract, specification, and sealed pattern. In the event of a conflict between the text of this specification and the references cited herein, the text of this specification must take precedence. For any inconsistency in technical details between languages, the language of the original document, which in this case is English, must take precedence. Nothing in this document supersedes applicable laws and regulations, unless a specific exemption has been obtained.

## 2.0 REQUIREMENTS

### 2.1 Fabric

The fabric must be a plain weave. When tested in accordance with the specified test methods, the finished fabric must comply with the following:

- (a) Type I with the requirements of Table 2; and
- (b) Type II with the requirements of Table 3.

### 2.2 Workmanship

The material covered by the Specification must be free of imperfections or blemishes such as may adversely affect its appearance or serviceability. For inspection purposes, imperfections and blemishes will be considered defects when clearly visible at a normal inspection distance of approximately 1 meter (3.3 ft) under good, preferably North light, lighting conditions.

### 2.3 Yarns

Yarns in both the warp and weft must be singles, 100% carded cotton or a blend of polyester and cotton with a maximum polyester content of 65%.

### 2.4 Colour

The tape must be a non-florescent earth-tone colour that matches the material that is being bound. By definition, earth tone is considered a color scheme that draws from a color palette of browns, tans, grays, greens, oranges, whites and some reds. The colors in an earth tone scheme are muted and flat in an emulation of the natural colors found in soils, moss, trees and rocks. For the purpose of this specification, the earth tone color must be based on the predominantly brown, tan and gray color series (lusterless) within FED STD-595C, where those colors do not include any elements of orange, red and white.

### 2.5 Bias Tape

Single fold bias tape must be made by cutting strips of the finished fabric on the bias (45 degree minimum and 55 degree maximum). Both edges of the fabric strip must be folded towards the center to give the finished tape widths at Table 1.

Table 1: Required widths of tape

Width, cut (± 0.8 mm)	Width, finished (± 0.8 mm)
25.4 mm	12.7 mm
38 mm	19 mm
51 mm	25.4 mm

Table 2: Type I Tape Requirements

Property	Test Method	Specified Requirement	Minimum Acceptable	Maximum Acceptable
Fabric Count (yarns per cm)	CAN/CGSB-4.2 Test Method 6		Warp: 24 Weft: 19	
Mass (g/m <sup>2</sup> )	CAN/CGSB-4.2 Test Method 5.1	102	85	119
Breaking Strength	CAN/CGSB-4.2		Warp: 178	

(N)	Test Method 9.1 (Test 6.1)		Weft: 110	
Dimensional Change in Washing	CAN/CGSB-4.2 Test Method 58 (III.E.3)			Warp: 5% Weft: 5%
Non-fibrous Material	CAN/CGSB-4.2 Test Method 15 (Note 1)			3%
The following colourfastness requirements are applicable to dyed fabrics only.				
Colourfastness to Light	AATCC Test Method 16 (Option E)		Sample Grey Scale 4 after 20 AATCC Fading Units	
Colourfastness to Crocking	CAN/CGSB-4.2 Test Method 22 (Tests 6.1 & 6.2)	Dry: GS 5 Wet: GS 5		Dry: GS 4 Wet: GS 3
Colourfastness to Washing	CAN/CGSB-4.2 Test Method 19.1 (Test No. 3)	Colour Change: GS 5 Staining: GS 5		Colour Change: GS 4 Staining: GS 4
Colourfastness to Perspiration	CAN/CGSB-4.2 Test Method 23	Colour Change: GS 5 Staining: GS 5		Colour Change: GS 4 Staining: GS 4
Colourfastness to Water	CAN/CGSB-4.2 Test Method 20	Colour Change: GS 5 Staining: GS 5		Colour Change: GS 4 Staining: GS 4

Note:

1. Aqueous and enzyme treatments only.

Table 3: Type II Tape Requirements

Property	Test Method	Specified Requirement	Minimum Acceptable	Maximum Acceptable
Fabric Count (yarns per cm)	CAN/CGSB-4.2 Test Method 6	(Note 2)		
Mass (g/m <sup>2</sup> )	CAN/CGSB-4.2 Test Method 5.1	136	102	186
Breaking Strength (N)	CAN/CGSB-4.2 Test Method 9.2	(Note 3)		
Dimensional Change in Washing	CAN/CGSB-4.2 Test Method 58 (III.E.3)			Warp: 5% Weft: 5%
Non-fibrous Material	CAN/CGSB-4.2 Test Method 15 (Note 1)			3%
The following colourfastness requirements are applicable to dyed fabrics only.				
Colourfastness to Light	AATCC Test Method 16 (Option E)		Sample Grey Scale 4 after 20 AATCC Fading Units	
Colourfastness to Crocking	CAN/CGSB-4.2 Test Method 22	Dry: GS 5 Wet: GS 5		Dry: GS 4 Wet: GS 3

	(Tests 6.1 & 6.2)		
Colourfastness to Washing	CAN/CGSB-4.2 Test Method 19.1 (Test No. 3)	Colour Change: GS 5 Staining: GS 5	Colour Change: GS 4 Staining: GS 4
Colourfastness to Perspiration	CAN/CGSB-4.2 Test Method 23	Colour Change: GS 5 Staining: GS 5	Colour Change: GS 4 Staining: GS 4
Colourfastness to Water	CAN/CGSB-4.2 Test Method 20	Colour Change: GS 5 Staining: GS 5	Colour Change: GS 4 Staining: GS 4

## Note:

2. A fabric with a total thread count of 59 minimum would be acceptable, providing the weft thread count is not less than 22.
3. A fabric with a combined warp and weft breaking strength of 445 N minimum would be acceptable, providing the weft tensile strength is not less than 110 N.