

DEPARTMENT OF COMMERCE

BUREAU OF STANDARDS  
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UNITED STATES GOVERNMENT MASTER SPECIFICATION FOR  
SHADE CLOTH

FEDERAL SPECIFICATIONS BOARD SPECIFICATION No. 555b

This specification was officially promulgated by the Federal Specifications Board on December 24, 1925, for the use of the departments and independent establishments of the Government in the purchase of shade cloth.

[The technical requirements of this revision of this specification shall become mandatory for all departments and independent establishments of the Government not later than August 22, 1928. They may be put into effect, however, at any earlier date after promulgation.]

CONTENTS

	Page
I. General specifications.....	1
II. Types.....	1
III. Materials and workmanship.....	2
IV. General requirements.....	2
V. Detail requirements.....	2
VI. Methods of sampling and test.....	3
VII. Packing and marking of shipments.....	3
VIII. Notes.....	4

I. GENERAL SPECIFICATIONS

United States Government general specifications for textile materials, Federal Specifications Board specification No. 345 (methods of physical and chemical tests), in effect on date of invitation for bids, shall form a part of this specification wherever applicable.

II. TYPES

Shade cloth shall be furnished in four types as specified:

- A. Translucent cambric, handmade tinted shade cloth.
- B. Opaque cambric, handmade shade cloth. (See Notes, Section VIII, 5.)
- C. Holland shade cloth.
- D. Pyroxylin-impregnated shade cloth.

### III. MATERIALS AND WORKMANSHIP

1. The shade cloth shall be what is known to the trade and accepted as commercially first quality shade cloth. It shall be made of cotton, be evenly woven, and be free from an excessive number of avoidable imperfections of manufacture.

2. Cambric shade cloth, types A and B, shall be painted with the best linseed oil and pigment material.

3. Holland shade cloth, type C, shall be sized, mangled, or beetled to produce the required stiffness and smooth finish.

4. Pyroxylin shade cloth, type D, shall be impregnated with pyroxylin. No loading of any kind shall be used.

### IV. GENERAL REQUIREMENTS

1. COLOR.—(a) For all types of shade cloth the following solid colors shall be furnished as specified: Dark écreu, light écreu, white, medium green, dark green. (See Notes, Section VIII, 3.)

(b) Except in the case of Holland shade cloth (type C), the following two-color combinations, having the dark color on one side and the light color on the reverse shall be furnished as specified:

(1) Dark colors, dark green, medium green.

(2) Light colors, white, light écreu, dark écreu.

(c) The colors of all types shall show fair fastness to light.

(d) The pyroxylin impregnated shade cloth, type D, shall show no streakiness nor loss of color when washed.

2. TREATMENT.—The shade cloth, all types, shall be properly treated to resist pinholing, cracking, and breaking when folded or in service.

### V. DETAIL REQUIREMENTS

1. THREAD COUNT.—The count or number of threads per inch, warp and filling, shall not be uniformly less than shown in Table 1. They may be exceeded in the discretion of the manufacturer. The allowable variation from the manufacturer's standard count shall not exceed, within a roll, plus or minus, two threads for either warp or filling.

2. BREAKING STRENGTH (STRIP METHOD, MODIFIED (See SECTION VI, 2)).—The minimum breaking strength in pounds per inch shall be as shown in Table 1.

TABLE 1.—Thread count and strength requirements

Type of shade	Width	Threads per inch		Breaking strength (minimum)	
		W	F	W	F
	<i>Inches</i>			<i>Pounds</i>	<i>Pounds</i>
A. Translucent cambric.....	To 54	72	72	50	40
B. Opaque cambric.....	To 54	72	72	50	40
A. Translucent cambric.....	Over 54	64	60	50	40
B. Opaque cambric.....	Over 54	64	60	50	40
C. Holland.....	All.	60	60	60	50
D. Pyroxylin.....	All.	72	72	50	40

3. The width specified shall be considered the average width and shall come within the tolerance specified in Table 3. Commercial standard widths are given in Table 2. (See Notes, Section VIII, 2.)

TABLE 2.—Commercial standard shade cloth widths

Type	Width (in inches)															
	A. Translucent cambric.....				36	38		42		45	48	54	58		63	72
B. Opaque cambric.....				36	38		42		45	48	54	58		63	72	82
C. Holland.....	28	30	32	36	38	40	42	44	48	54		60		72	82	
D. Pyroxylin.....				36	38		42		45	48	54		63	72		

TABLE 3.—Tolerances for width

Width (in inches)	Tolerance	
	Plus	Minus
To 38, inclusive.....	<i>Inch</i> $\frac{3}{8}$	<i>Inch</i> $\frac{3}{8}$
38 to and including 60.....	$\frac{3}{8}$	$\frac{1}{2}$
Over 60.....	1	1

4. LENGTH OF ROLL OR PIECE.—A roll or piece shall be a continuous length of from 40 to 70 yards.

VI. METHODS OF SAMPLING AND TEST

1. SAMPLING.—At least 1 yard from each 1,000 yards or fraction thereof shall be taken at random for test purposes.

2. TESTING.—Federal Specifications Board specification No. 345 shall be followed with the following deviations: Change the width of specimen in the breaking-strength test (strip method) from 1 inch to 2 inches and do not fray. The maximum capacity of machines shall be 300 pounds.

VII. PACKING AND MARKING OF SHIPMENTS

Shall be in accordance with the best commercial practice unless otherwise specified.



## VIII. NOTES

1. The proposal and order should state for shade cloth the type, color, width, and length.

2. It is customary trade practice when an intermediate width is specified to charge at the rate of the next larger width; for example, if a 46-inch width is specified the rate is on the basis of the 48-inch width.

3. To avoid any misunderstanding, it should be noted by the purchaser that the colors do not match for the translucent cambric, opaque cambric, holland, and pyroxylin types; for example, dark green cambric cloth is different from dark green holland cloth.

4. Opaque cambric shade cloth should not be confused with opaque shade cloth which has a lower thread count. Opaque shade cloth is not included in this specification.

NOTE.—Shades, window, rollers, slats, cords, and accessories are covered by United States Government master specification, Federal Specifications Board specification No. 367b.

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