

Table 7.3 Guidelines for optimum levels of combing waste for different length distributions

Nature of fibre length distribution of mixing	Short fibres % by number		Mean length	Approximate level of optimum combing waste % by weight in relation to yarn quality
	Base sorter	Fibres <15 mm		
Triangular	<20%	<20%	< 26 mm	No optimum; increasing waste continuously improves quality
Flat	<18%	< 18 % < 18 %	> 26 mm Any	0.5 × short fibre (%) 0.5 × short fibre (%)

of combing waste may not always ensure better removal of short fibres and neps, and therefore will not enhance yarn quality or performance beyond a certain level. To ascertain the level of required waste is therefore a case of optimisation, balancing the improvement of quality against the higher cost involved in the removal of combing waste.

It therefore follows that the removal of short fibres and neps alongside retention of the longer fibres holds the key to efficient combing. The following points are worth noting (Gardé and Subramanian, 1978):

- Card trailing hooks usually prevail over leading ones. They are removed when fed as leading hooks by keeping an even number of passages between the card and the comb.
- A higher level of pre-combing draft can ensure lower level of combing waste without affecting the resultant yarn quality. However, there are risks associated with high pre-combing draft which undermine the inter-fibre cohesion, including problems such as lap licking and frequent sliver breaks.
- The strategic place to counteract neps is during the carding rather than the combing process. It is more economical to operate cards at a low production rate than to extract high combing waste. Since neps escape easily through needle spacing, their elimination is only possible with fibre removal, which is expensive.

The nature of fibre length distribution in the cotton or mix dictates the optimum level of combing waste to give the desired yarn quality, yarn appearance and end breaks at ring frames. A study conducted at ATRIA regarding this optimisation is summarised in Table 7.3.

Steady improvement in yarn quality can be achieved with an increase in combing waste to a point where most fibres below 15 mm length are removed (Gardé and Subramanian, 1978). As a rule of thumb, one can assess the combing waste level as 0.5 × short fibres (%). For large scale production,

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William Scott Taggart



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Process Control in Spinning A. R. Garde, T. A. Subramanian, 1987 **Process Control and Yarn Quality in Spinning**
G. Thilagavathi, T. Karthik, 2016-01-05 The book outlines the concepts of raw material selection control of various process parameters in the preparatory processes like blow room carding combing preparatory and comber to optimize the process conditions and analysis and interpretation of various types of test reports to find out the source of fault **Process Control in Cotton Spinning** A. R. Garde, 1978 **Process Management in Spinning** R. Senthil Kumar, 2014-09-23 A
Straightforward Text Summarizing All Aspects of Process Control Textile manufacturing is one of the largest industries in the world second only to agriculture Spinning covers a prominent segment in textile manufacturing and this budding industry continues to thrive and grow Process Management in Spinning considers aspect of process management and offers insight into the process control procedures and methods of spinning Focusing on the technology as well as the management of the process it examines both the economic and technological advancements currently taking place in the spinning industry This text takes a close look at the advancing technology in manufacturing and process and product quality control It provides a basic overview of the subject and also presents applications of this technology for practicing engineers Incorporates Industry Based Real World Examples The book contains 15 chapters that specifically address the stages of process control energy management methods humidification and ventilation systems basics pollution management process management tools productivity waste control material handling and other aspects of spinning mills It also includes real time case studies involving typical problems that arise in spinning processes and strategies used to contain them The author provides a broad outlook on various topics including mixing winding raw material and optimizing raw material properties bale management yarn engineering systems processing and process management systems He also details the defects associated with each and every process with causes effects and control measures The book addresses process management as it relates to productivity quality and costs as well as process control as it relates to man machine and material Provides the scientific method for optimization optimizing the properties of the fibers Familiarizes the reader with remedial measures to enhance the quality of the product Addresses productivity measurement and its role in controlling the cost of the manufacturing process Contains detailed examples as well as linear programming and optimization techniques and statistical applications Covers the areas of process control methods in spinning defect analysis and rectification improving productivity and quality and using statistical tools Process Management in Spinning establishes the various process management measures required to help improve the process efficiency in spinning mills and the textile industry overall Aimed at professionals in the textile industry this text is a perfect resource for textile engineers technologists manufacturers spin quality control engineers spin quality assurance personnel and other industry professionals *Process Control in Ring Spinning* R. Senthilkumar, 2016-05-19 Spinning is the process of producing continuous twisted strands yarn of a desired size from fibrous materials Spinning can be categorized

based on staple length as long staple spinning and short staple spinning Short staple spinning machines process fibres such as cotton polyester viscose and its blends thereof The yarn formation is usually accomplished by any one of the spinning systems Spinning systems presently employed include ring rotor self twist friction air jet twistless and wrap spinning with the first mentioned two systems by far the most important for cotton spinning together accounting for far over 90% of the cotton yarn produced globally The ring spinning invented by John Thorpe in 1830 has been very successful in producing yarns from staple fibres Since its inception ring spinning had remained unchallenged for almost 150 years Ring spinning accounts for some 75% of global long and short staple yarn production The main reason attributed for the success of ring spinning over other spinning systems is the superior quality notably strength and evenness of ring spun yarns over those produced by other systems

Process Control in Winding R. Senthilkumar,2016-05-20 Yarn winding is the final stage of the yarn forming process and the starting point for various subsequent processes from weaving or knitting to textile finishing Yarns manufactured and packaged from ring spinning are not in the optimum condition to be used to form fabrics Package size build and other factors make it necessary for the yarn to be further processed to prepare it to be handled efficiently during fabric formation Yarn winding can be viewed as a packaging process forming a link between the last few elements of yarn manufacturing and the first element of fabric manufacturing process This interface function of winding is what makes the winding process so important

Process Control in Rotor Spinning R. Senthilkumar,2016-05-20 Open end spinning is a process in which fibrous material is highly drafted ideally to the individual fiber state creating a break in the continuum of the fiber mass The individual fibers are subsequently collected onto the open end of a yarn that is rotated to twist the fibers into the yarn structure to form a continuous yarn length Rotor spinning usually referred to as open end spinning was commercially introduced during the late 1960s and is second only to ring spinning in terms of short staple yarn production The rotor spinning machine is fed with draw frame sliver which transform the yarn directly into packages eliminating the roving process With this spinning method twisting and package building are separated by employing the false twist principle The first rotor spinning machine suitable for industrial use was presented in 1967 with the name BD200 in ITMA exhibition The current share of rotor spun yarn is around 20% of total staple fiber yarn production and it is increasing steadily

Control Systems in Textile Machines G. Nagarajan,G. Ramakrishnan,2024-12-05 This book details the mechanics of textile machines and covers the fundamental concepts and advanced applications of their control systems It presents conceptual information discusses practical equipment and analyses the machines used in various stages of the spinning process Print edition not for sale in South Asia India Sri Lanka Nepal Bangladesh Pakistan or Bhutan

Principles of Process Control D. Patranabis,2012

Advanced Practical Process Control Brian Roffel,Ben Betlem,2004 This text and reference offers an application oriented approach to process control It systematically explains process identification control and optimization the three key steps needed to solve a multivariable control problem Theory is discussed as far as it is

needed to understand and solve the defined problem while numerous examples written in MATLAB illustrate the problem solving approach

Plant-Wide Process Control Kelvin T. Erickson, John L. Hedrick, 1999-04-29 The complete control system engineering solution for continuous and batch manufacturing plants This book presents a complete methodology of control system design for continuous and batch manufacturing in such diverse areas as pulp and paper petrochemical chemical food pharmaceutical and biochemical production Geared to practicing engineers faced with designing increasingly more sophisticated control systems in response to present day economic and regulatory pressures Plantwide Process Control focuses on the engineering portion of a plant automation improvement project It features a full control design information package Control Requirements Definition or CRD and guides readers through all steps of the automation process from the initial concept to design simulation testing implementation and operation This unique and practical resource Integrates continuous batch and discrete control techniques Shows how to use the methodology with any automation project existing or new simple or complex large or small Relates recent ISO and ISA standards to the discipline of control engineering Illustrates the methodology with a pulp and paper mill case study Incorporates numerous other examples from single loop controllers to multivariable controllers

A Practical Guide to Quality Management in Spinning B. Purushothama, 2011 This book provides an introduction to quality management in spinning operations Chapters discuss the impact of yarn parameters on spinning and the causes of quality and other problems related to spinning Provides an introduction to quality management and an overview of product quality objectives Discusses the impact of yarn parameters from a customer's perspective reasons for poor quality and various fine aspects and problems related to spinning Examines the causes of yarn defects featuring process control studies and the role of technicians in quality management

Process Control in Blow Room R. Senthilkumar, 2016-05-19 The main tasks of blow room process are opening cleaning and blending of cotton fiber tufts without over stressing of fibers One important function of the blow room is to disintegrate the fiber bales into a flow of very small clumps of fiber which are sufficiently small in size to be digested by the cards The intensity of fiber treatment is different because the tufts continually become smaller as they pass from stage to stage Cotton bale have non lint content apart from cotton that have to be removed in the initial stages of spinning process itself About 40% to 70% trash is removed in blow room section Blender equipped in the blow room sequence reduces the lot to lot variability existing in the raw material by homogenous blending

Principles and Practice of Automatic Process Control Richard G. Smith, 1986-01-03

Cotton Spinning William Scott Taggart, 1896 **A Manual on Quality Control in Spinning** Tarakad Vedamurthy Ratnam, G. Srikantaiah, 1976

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Table of Contents Process Control In Spinning Atira Fagity

1. Understanding the eBook Process Control In Spinning Atira Fagity
 - The Rise of Digital Reading Process Control In Spinning Atira Fagity
 - Advantages of eBooks Over Traditional Books
2. Identifying Process Control In Spinning Atira Fagity
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Process Control In Spinning Atira Fagity
 - User-Friendly Interface
4. Exploring eBook Recommendations from Process Control In Spinning Atira Fagity
 - Personalized Recommendations
 - Process Control In Spinning Atira Fagity User Reviews and Ratings
 - Process Control In Spinning Atira Fagity and Bestseller Lists
5. Accessing Process Control In Spinning Atira Fagity Free and Paid eBooks
 - Process Control In Spinning Atira Fagity Public Domain eBooks
 - Process Control In Spinning Atira Fagity eBook Subscription Services
 - Process Control In Spinning Atira Fagity Budget-Friendly Options

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 - ePub, PDF, MOBI, and More
 - Process Control In Spinning Atira Fagity Compatibility with Devices
 - Process Control In Spinning Atira Fagity Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Process Control In Spinning Atira Fagity
 - Highlighting and Note-Taking Process Control In Spinning Atira Fagity
 - Interactive Elements Process Control In Spinning Atira Fagity
8. Staying Engaged with Process Control In Spinning Atira Fagity
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Process Control In Spinning Atira Fagity
9. Balancing eBooks and Physical Books Process Control In Spinning Atira Fagity
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Process Control In Spinning Atira Fagity
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Process Control In Spinning Atira Fagity
 - Setting Reading Goals Process Control In Spinning Atira Fagity
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Process Control In Spinning Atira Fagity
 - Fact-Checking eBook Content of Process Control In Spinning Atira Fagity
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements

- Interactive and Gamified eBooks

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