

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 (Garde 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-comber draft can ensure lower level of combing waste without affecting the resultant yarn quality. However, there are risks associated with high pre-comber 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 (Garde and Subramanian, 1978). As a rule of thumb, one can assess the combing waste level as 0.5 × short fibres (%). For large scale production,

# Process Control In Spinning Atira Fagity

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