

Section T.1

Weaving Standards

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T. WEAVING TECHNOLOGY

T.1 Weaving Standards

When starting up a new style fabric, the motions and units will have to first have their conditions set on the function panel, and then have their adjustments made, based on the following:

- “Weaving Condition Table” (See the sample given below.)
- Settings and adjustments in each chapter

“Weaving Condition Table” sample

Main specifications				Textile name: P/C 208-yarn poplin		Plant name (country):	
Let-off <input checked="" type="checkbox"/> Electric <input type="checkbox"/> Mechanical	Take-up <input type="checkbox"/> Spray forming <input type="checkbox"/> Rubber <input checked="" type="checkbox"/> Steel	Surface roller <input type="checkbox"/> Slow motor <input checked="" type="checkbox"/> Centralized INV. <input type="checkbox"/> Individual INV.	Starting <input type="checkbox"/> Slow motor <input checked="" type="checkbox"/> Centralized INV. <input type="checkbox"/> Individual INV.	Machine type: JA 2S 190TN-MF T710	Machine speed: 800 RPM	Date: Apr. 1, 2002	Written by: Service Sect.
<input checked="" type="checkbox"/> TAPO	<input type="checkbox"/> APC	<input type="checkbox"/> APC-M	<input type="checkbox"/> Tucker selvage	<input type="checkbox"/> Leno selvage	<input type="checkbox"/> Constant tension	<input type="checkbox"/> Hold-down temple	<input type="checkbox"/> Separate take-up
1. Weaving specifications		3. Warp line and warp tension		6. Shedding		7. ★Weft insertion	
Textile formation: 1/1 Plain weave	PC45 X PC45 136 X 72	Back: Height: +2, (0) -2	Textile: Front twill, (Plain weave) Back twill	Heald frame No.	Number of notches	Heald frame height mm	Number of springs
Total number of warp yarns: 8372	Reed space: 1650 mm	Front and rear: 3	Easing and dropper box: Height: +2, (0) -2	1	17 (13)	69	12
Width of gray cloth: 1610 mm	Number of dents per reed: 2 dents / reed	Front and rear: Leno cover - guide bar=53mm Time : 290° Amount : (Plain weave=8) Twill textile=1	Shim: Plain weave, back twill=4mm, (Front twill=3mm)	2	13 (11)	66	12
#, Reed thickness: # 132 x 0.14 t	Type: (High speed), Ordinary	Warp tension: ★ 150 kg	Fell plate: 2mm	3	9 (6)	63	13
Manufacturer: TOS	Heald frame: Manufacturer: NANKAI	4. ★Stop-start connection		4	5 (2)	60	13
Heald: Dimensions: 331 X 5 center up	Type: Simplex, (Duplex)	WARP	WEFT	5			
Dropper: 145 X 11 X 0.2	Sample: 90 X Thin	0	5	6			
		0	0	10	0	0	0
		0	0	20	0	0	0
		0	0	40	0	0	0
		0	0	0	0	0	170
		0	0	0	0	0	170
		START ANGLE: WARP 300°		7			
				6-1 Crank shedding			
				Heald frame height for cloth: 1,2= 34			
				Mechanism: Stripple, Articulated			
				Lower yarn height: 21 mm			
				Shedding angle: 32° (34°)			
				Shedding timing: 1,2 310°, 1,4 290°			
						1) TO= 90° TW= 230° P-OPEN= 80 TM= 100 to 160	
						2) TO= 90° TW= 230° P-OPEN= 80 TM= 100 to 160	
						3) TO= ° TW= ° P-OPEN= to TM= to	
						4) TO= ° TW= ° P-OPEN= to TM= to	
						Sub-1 timing: 90 to 150	
						TENSIONER: to	
						*For timing change, set the transfer to VALVE and EDP modes after changing TO and TW by ICS.	
						8. Air pressure and flow rate graduation	
						Nozzle	Height + (1)
						PM	Jet angle [5°]
							1) 3.2 kg/cm ²
							3) 4)
							1) 2)
							(Same as PM as the standard)

T.1.1 Startup Flowchart for New Style Fabrics



