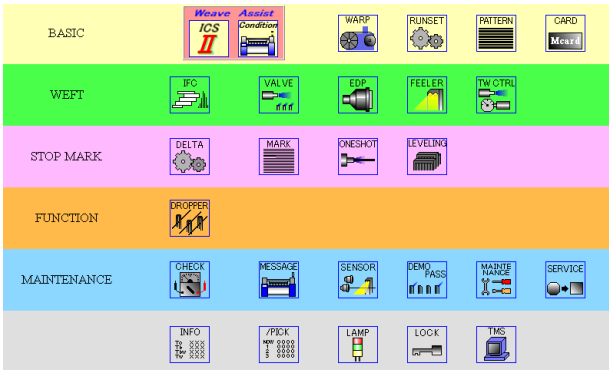
Appendix 11.
WA (Weaving Assist)

Appendix 11. WA (Weaving Assist)

This system is to improve and assist weaving operations by displaying (as set values), saving and managing all weaving conditions including mechanical adjustments.

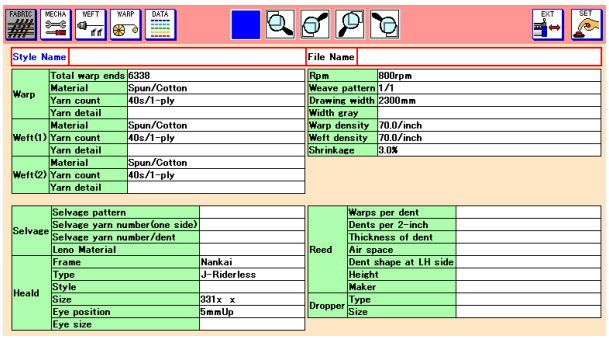
It also assists operation efficiency improvement by means of the following functions:

- Recommending the optimum mechanical adjustment values by weaving condition input
- Recommending the optimum stop mark setting by weaving condition input
- Inducing the points to be improved easily by comparison of weaving conditions with other looms
- Reproducing fabric weaving easily by saving and reading the fixed weaving conditions



ICSII : Compared with the old ICS, mechanical adjustment value assist, recommended value list, and stop mark adjustment functions are added.

Condition : All weaving conditions can be referred to and set.



[1] Explanation on Each Switch in the Condition (List of Weaving Conditions) Mode

Fabric condition (FABRIC) switch
Switches to the input screen for weaving conditions and accessories.

Mechanical adjustment (MECHA) switch
Switches to the input screen for mechanical adjustment values.

Weft insertion setting (WEFT) switch
Switches to the input screen for weft insertion setting.

Warp tension setting (WARP) switch
Switches to the input screen for setting warp tension and stop mark.

Operation rate display (DATA) switch
Displays the operation rate, warp stop times/hr. and operation data.

External connection (EXT) switch
Switches to the screen for external connection with the card, other looms, host and memory.

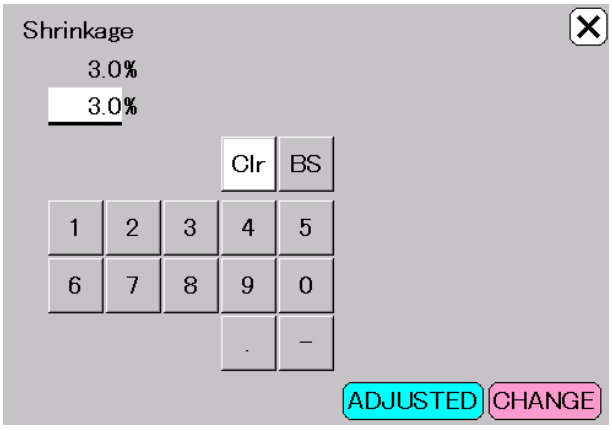
Set/cancel (SET) switch
Use this switch to set or cancel the setting on each screen.

Screen zoom-in switch
Since the weaving condition screen displays small characters because of a large display data volume per screen, use these switches for zoom-in.
These are for zooming in the whole screen, left-top quarter, left-bottom quarter, right-top quarter, and right-bottom quarter in the order from the left.

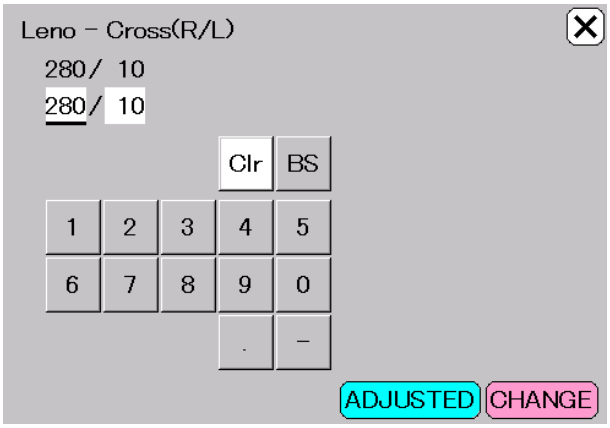
[2] Keyboard Explanation

Clicking each item setting value will display the keyboard matching the setting of each item.

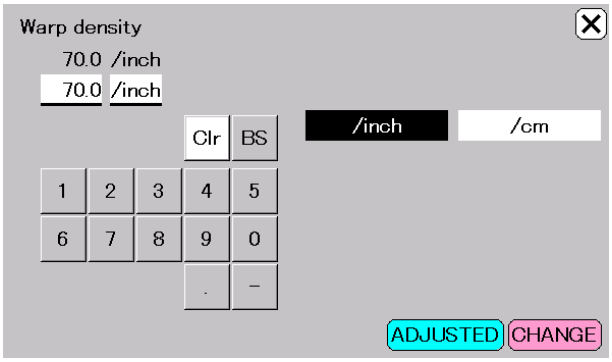
(1) Selection keyboard
Keyboard for setting the weft type above, for example. Select from the displayed items.
The selection keyboard appears when the memory is involved even in the case of numerical input.



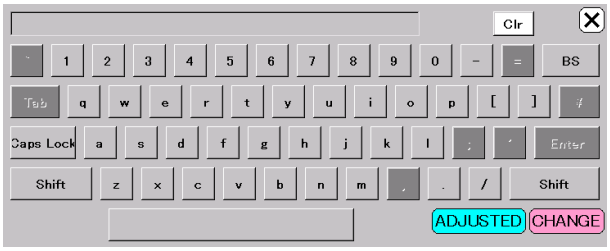
(2) Numerical input keyboard
Directly input a numerical value.
If the decimal point is included, input it, too.
The value above the input field is the present adjustment value.



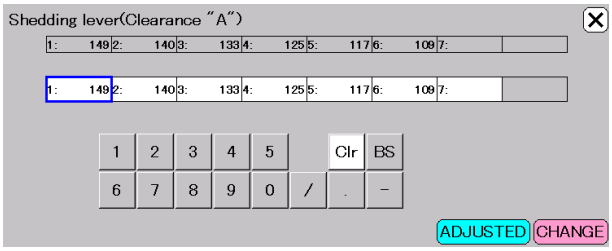
(3) Multiple numerical input keyboard
If an item requires input of multiple numerical values, select the input item by clicking, and shift the cursor (underline) for input value selection.



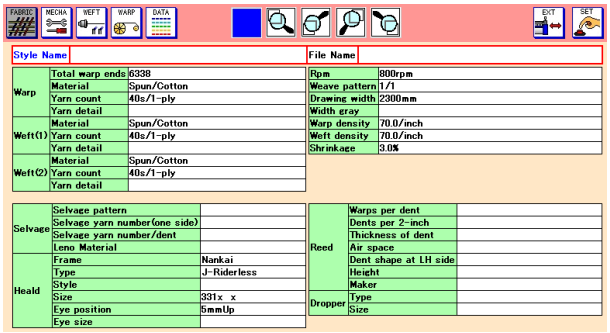
(4) Numerical + selection input keyboard
The numerical value is displayed on the left side, and the selection on the right side.
Cursor shifting is unnecessary.



(5) Name input keyboard
The layout is the same as on the standard keyboard, but blackened keys cannot be used (because of the restriction for use in file names).
Click Shift to enable one capital letter or special character to be input.
Click Caps Lock for switching to consecutive capital letter input.



(6) Heald frame value input keyboard
Framed values can be input as many as the number of heald frames installed on the loom.
The selected item is enclosed in a blue frame.
Always click the desired frame item and input after the blue frame cursor appears.



[3] Fabric Condition Switch

Clicking this switch displays the screen at left.
Input necessary data.

[3.1] Display Explanation

Style name : Input the name representing the fabric to be woven.

File name : The file name upon reading from the host or a card is displayed.
When the file name is displayed, it means that the loom weaving conditions are based on the conditions for the file name.

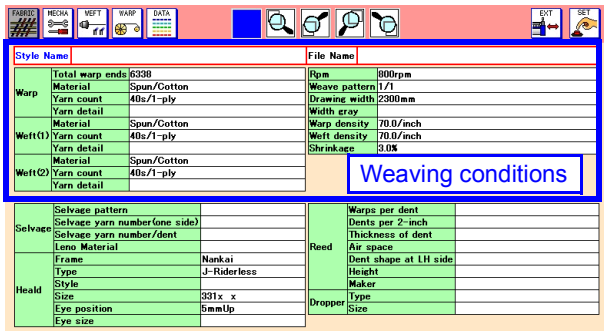
Upper block on the setting screen:
Input screen for fabric texture.
The yarn material, yarn count, etc. that were set on the ICS screen are changed when the settings here are changed.
Upon transfer from the ICS, the weaving condition table data are replaced with the ICS data values.

Lower block on the setting screen:
Input screen for accessories (selvage, heald, reed and dropper).

This weaving condition screen is for auxiliary management by input of the yarn type and accessory data. Omission of input does not affect the existing mechanical adjustment values and control values.

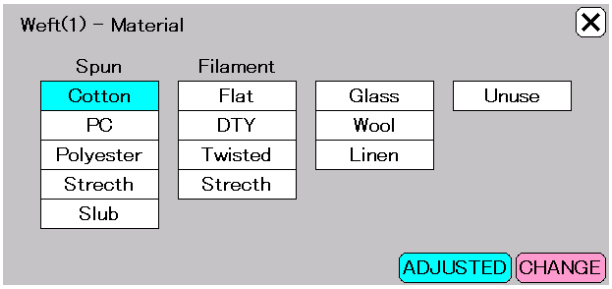
[3.2] Changing the Set Values of Weaving Conditions

Click the input item data display area.
The selection and keyboard screen appears for each item.



■ EXAMPLE: Weft yarn type change

(1) When “Weft (1)” – “Material” is clicked



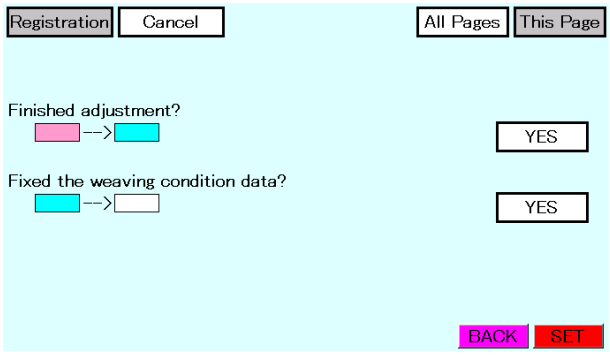
(2) The selection screen shown at left appears.
The blue item is the one set at present.
For example, select [PC] and click [CHANGE].

Warp	Total warp ends	6338
	Material	Spun/Cotton
	Yarn count	40s/1-ply
	Yarn detail	
Weft(1)	Material	Spun/PC
	Yarn count	40s/1-ply
	Yarn detail	
Weft(2)	Material	Spun/Cotton
	Yarn count	40s/1-ply
	Yarn detail	

(3) The selection screen disappears, and “Weft (1)” – “Material” on the fabric screen turns red.

(4) After the end of inputting all other items, click 

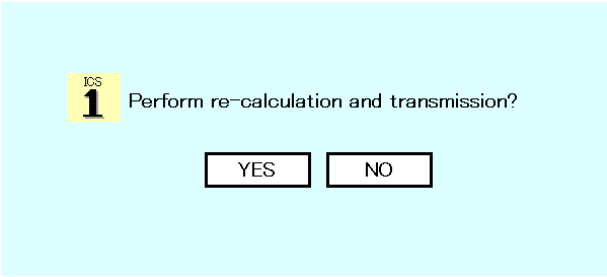
.



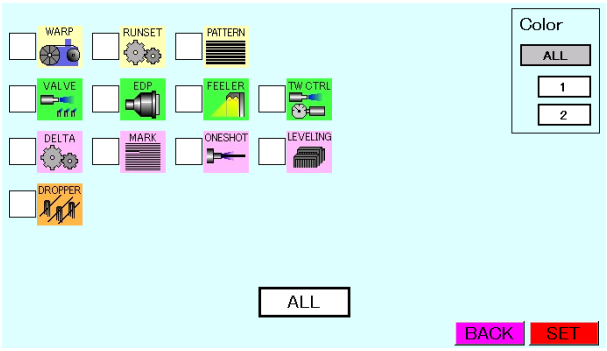
(5) The screen shown at left appears.
If the changed value is correct, click [YES] for “Finished adjustment?” and click [SET] then.

NOTE:

- Only the screen displayed at present is valid as the (initial value) upon selection of [This Page].
- When [All Pages] is selected, this screen setting applies to all of the setting screens for fabric, mechanical adjustment, weft insertion, warp and other weaving conditions.
- When [Cancel] and [SET] are clicked in this order:
The changed ▭ item is cancelled to return to the set values before the change.
▭ items cannot be cancelled since they are reflected in control.



(6) Only when [YES] and [SET] are clicked in response to “Finished adjustment?” on the weaving condition screen, the ICS transfer selection screen at left appears.
Click [YES] when use of the ICS function is required to change a condition such as yarn type related to the fabric.



(7) When ICS transfer is done (when [YES] is clicked in response to “Perform re-calculation and transmission?” upon ICS transfer in (6)), the ICS transfer screen shown at left appears.

Select the item for re-calculation, and click [SET].

NOTE: To perform calculation and transmission for any individual color for weft insertion, use the color select switch at top right for change and click [SET].

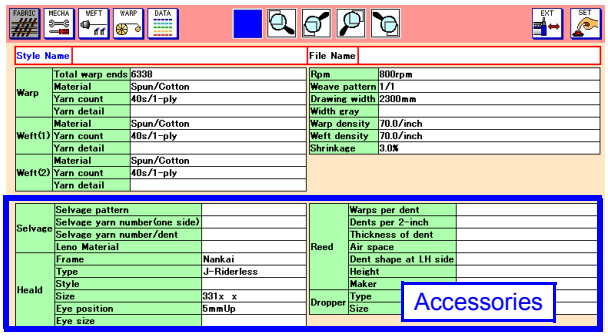
(8) Returns to the original screen.

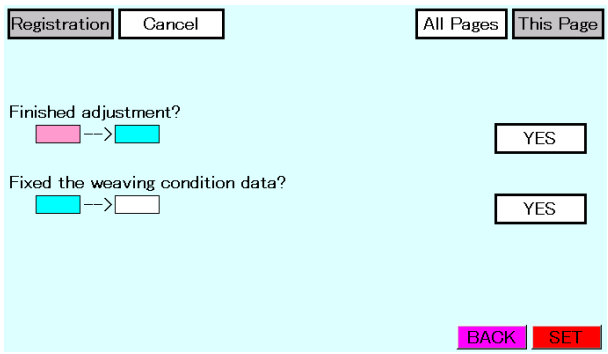
REFERENCE: Directly inputting [ADJUSTED] in a procedure other than above may omit the 

procedure.
When the fabric or a part has been replaced, click [ADJUSTED] without the [CHANGE] procedure.

[3.3] Accessory Setting Value Modification

(1) Click the data display potion of the input item. Carry out setting in the same way as in [3.2].

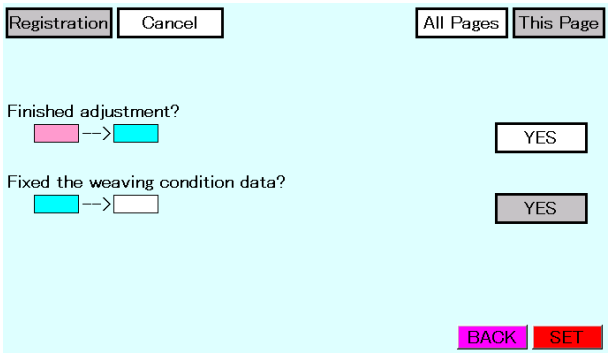




(2) For accessory input, check replacement and adjustment of the actual part. Click [YES] in response to “Finished adjustment?”, and click [SET].

(3) The original screen reappears.

Warp	Total warp ends	6338
	Material	Spun/Cotton
	Yarn count	40s/1-ply
	Yarn detail	
Weft(1)	Material	Spun/PC
	Yarn count	40s/1-ply
	Yarn detail	
Weft(2)	Material	Spun/Cotton
	Yarn count	40s/1-ply
	Yarn detail	



[3.4] Changed Value Check

The changed set value portion is colored for distinction.

(1) Color for set value display
The WA set values are indicated with three background colors as follows:

: Set value desired to be changed (or mechanical adjustment value desired to be changed)

: Changed value (or mechanically adjusted value)

: Unchanged value

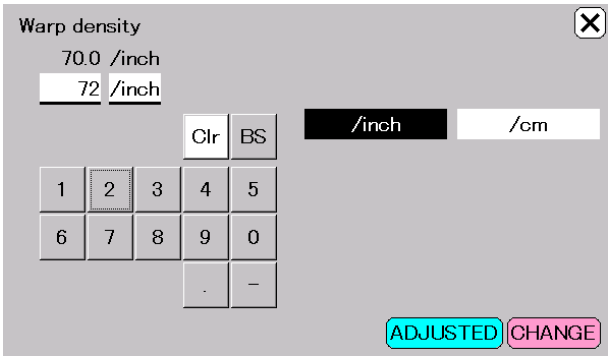
REFERENCE: As the result of machine data comparison, different set values are indicated with .
For details of the comparison function, see Subsection 8.2, (5).

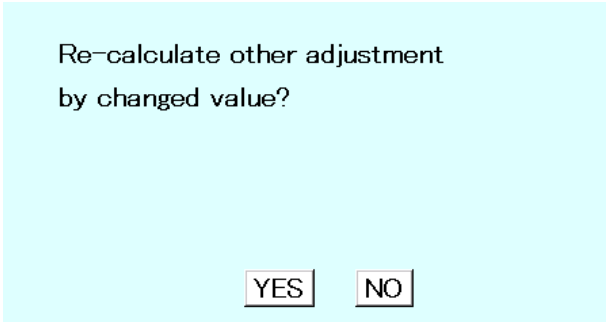
(2) Method for erasing the displayed color
After confirming no problem with the weaving condition or other changed value, return the set value indication color to .
The display color does not automatically return to .
Immediately operate as follows after changing the set value and setting the condition.

1) Click 

to display the screen shown at left.

2) Click [YES] in response to “Fixed the weaving condition data?”, and click [SET] then.





[3.5] If the Set Value Change is Related to Multiple Items

(1) Since the items below are closely related to each other, changing either setting causes the other setting to be re-calculated.

1) Items displaying re-calculation check screen:

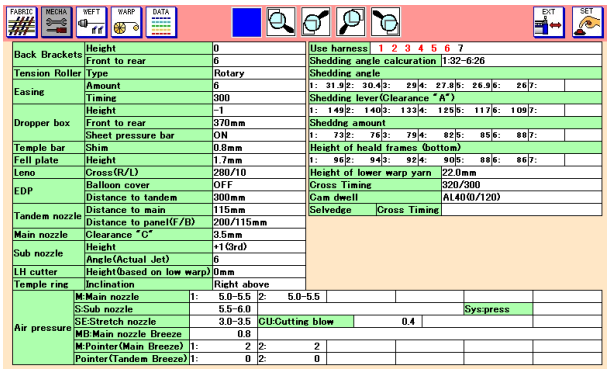
Weaving condition screen →
Total number of warp yarns and warp yarn density
Machine adjustment screen →
CW for machine take-up and density
Weft insertion screen →
To-Tw and valve injection angle

When the warp density is changed, for example: The message shown at left appears.

Click [YES] and the total number of warp yarns is recalculated.

2) Item to be re-calculated automatically:
If any set value of the following machine adjustment screen is changed, set values of other items are automatically calculated.

- Heald frame in use
- Shedding angle
- Shedding lever
- Shedding opening
- Heald frame height



[4] Mechanical Adjustment Switch

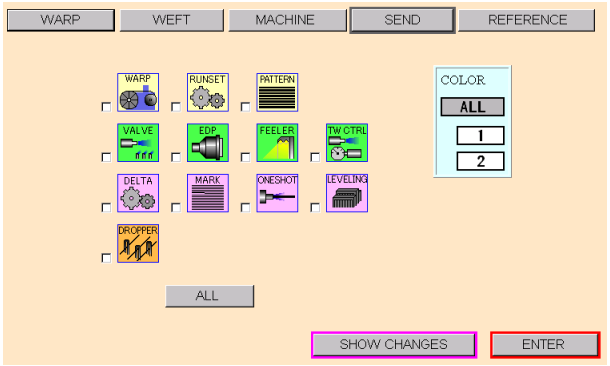
[4.1] Display Explanation

When the fabric is changed, all necessary mechanical adjustment items are displayed.

Upper left portion : Around the back portion
Upper right portion : Around the shedding motion
Bottom center portion : Around the weft inserting portion

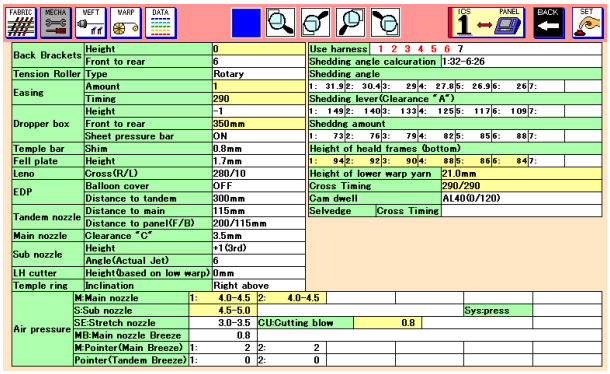
Always make sure that the mechanical adjustment values displayed here agree with the actual machine adjustment values.

[4.2] Operation Method



Although individual setting is possible, ordinary operation example from ICSII is explained here.

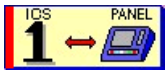
(1) After weaving condition setting by ICSII, select [ALL] on the [SEND] screen.
(In case of adjusting weft insertion only or stop mark only, select the respective icon. For fabric change, etc., click [ALL].)



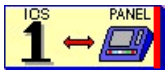
Back Brackets	Height	0	Use harness	1 2 3 4 5 6 7
	Front to rear	6	Shedding angle calcuration	1:32-6:26
Tension Roller	Type	Rotary	Shedding angle	
Easing	Amount	1	1: 31.9 2: 30.4 3: 29 4: 27.8 5: 26.9 6: 26 7:	
	Timing	290	Shedding lever(Clearance "A")	
Dropper box	Height	-1	1: 149 2: 140 3: 133 4: 125 5: 117 6: 109 7:	
	Front to rear	350mm	Shedding amount	
	Sheet pressure bar	ON	1: 73 2: 76 3: 79 4: 82 5: 85 6: 88 7:	
Temple bar	Shim	0.8mm	Height of heald frames (bottom)	
Fell plate	Height	1.7mm	1: 94 2: 92 3: 90 4: 88 5: 86 6: 84 7:	
Leno	Cross(R/L)	280/10	Height of lower warp yarn	21.0mm
EDP	Balloon cover	OFF	Cross Timing	290/290
	Distance to tandem	300mm	Cam dwell	AL40(0/120)
Tandem nozzle	Distance to main	115mm	Selvedge	Cross Timing
	Distance to panel(F/B)	200/115mm		
Main nozzle	Clearance "C"	3.5mm		
Sub nozzle	Height	+1(3rd)		
	Angle(Actual Jet)	6		
LH cutter	Height(based on low warp)	0mm		
Temple ring	Inclination	Right above		
Air pressure	M:Main nozzle	1: 4.0-4.5	2: 4.0-4.5	
	S:Sub nozzle	4.5-5.0		Sys:press
	SE:Stretch nozzle	3.0-3.5	CU:Cutting blow	0.8
	MB:Main nozzle Breeze	0.8		
	M:Pointer(Main Breeze)	1: 2	2: 2	
	Pointer(Tandem Breeze)	1: 0	2: 0	

(2) For referencing before reflecting ICSII recommended values in control, click [SHOW CHANGES].

The mechanical adjustment screen of the list of weaving appears automatically.
The adjustment values different from the present machine settings are displayed with yellow background .



The ICS value is displayed.



The current value is displayed.

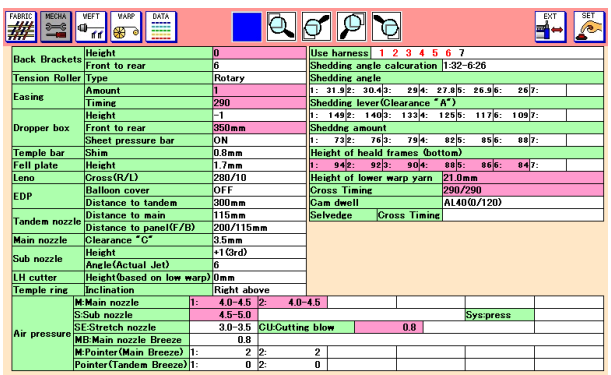
(3) Click the above switch to change over the display.
The compare mode is set while this SW is displayed.
Screen selection by each of 

switches enable the ICS value and present value of each item to be displayed with comparison.
In the comparison mode with the ICSII values, 

screen comparison is excluded.

(4) Click 

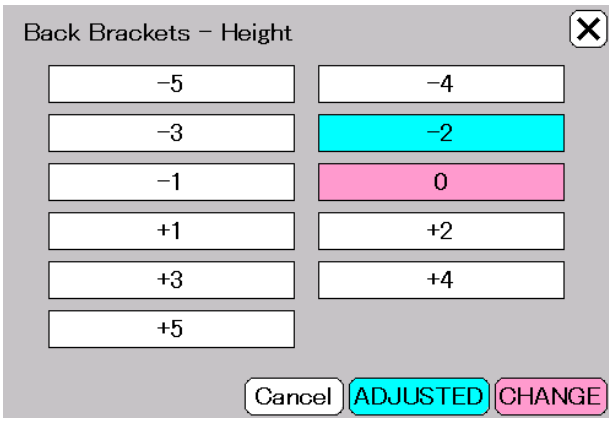
to return to the original ICSII screen.



Back Brackets	Height	0	Use harness	1 2 3 4 5 6 7
	Front to rear	6	Shedding angle calcuration	1:32-6:26
Tension Roller	Type	Rotary	Shedding angle	
Easing	Amount	1	1: 31.9 2: 30.4 3: 29 4: 27.8 5: 26.9 6: 26 7:	
	Timing	290	Shedding lever(Clearance "A")	
Dropper box	Height	-1	1: 149 2: 140 3: 133 4: 125 5: 117 6: 109 7:	
	Front to rear	350mm	Shedding amount	
	Sheet pressure bar	ON	1: 73 2: 76 3: 79 4: 82 5: 85 6: 88 7:	
Temple bar	Shim	0.8mm	Height of heald frames (bottom)	
Fell plate	Height	1.7mm	1: 94 2: 92 3: 90 4: 88 5: 86 6: 84 7:	
Leno	Cross(R/L)	280/10	Height of lower warp yarn	21.0mm
EDP	Balloon cover	OFF	Cross Timing	290/290
	Distance to tandem	300mm	Cam dwell	AL40(0/120)
Tandem nozzle	Distance to main	115mm	Selvedge	Cross Timing
	Distance to panel(F/B)	200/115mm		
Main nozzle	Clearance "C"	3.5mm		
Sub nozzle	Height	+1(3rd)		
	Angle(Actual Jet)	6		
LH cutter	Height(based on low warp)	0mm		
Temple ring	Inclination	Right above		
Air pressure	M:Main nozzle	1: 4.0-4.5	2: 4.0-4.5	
	S:Sub nozzle	4.5-5.0		Sys:press
	SE:Stretch nozzle	3.0-3.5	CU:Cutting blow	0.8
	MB:Main nozzle Breeze	0.8		
	M:Pointer(Main Breeze)	1: 2	2: 2	
	Pointer(Tandem Breeze)	1: 0	2: 0	

(5) To reflect the ICSII recommended values in control, click [SET].
The mechanical adjustment value screen of the list of weaving conditions appears automatically.
Adjustment values different from the present machine settings are displayed on .
(If mechanical adjustment values do not require any change)
Mechanically adjust each item according to the displayed adjustment value.

NOTE: The air pressure values are guidelines and not optimum. Input the final adjustment value after trial running at the recommended level.



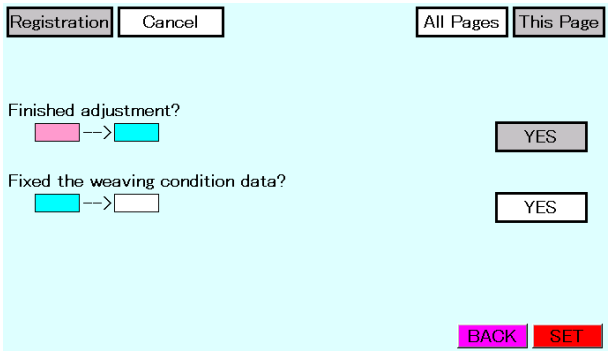
(6) Click the back bracket height input field to display the individual input screen below.

−2 indicates the old back bracket height.

After adjustment to 0, click [ADJUSTED].

Back Brackets	Height	0
	Front to rear	6
Tension Roller	Type	Rotary
Easing	Amount	1
	Timing	290
Dropper box	Height	−1
	Front to rear	350mm
	Sheet pressure bar	ON

The Back Bracket - Height item display changes to ADJUSTED.
Adjust all items in this way.

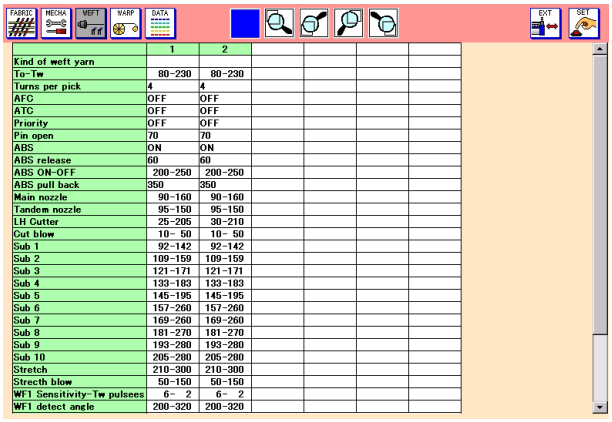


(7) To turn all items into adjusted collectively, click 

. Then, click [YES] in response to “Finished adjustment” at left, and click [SET].

[5] Weft Insertion Setting Switch

[5.1] Display Explanation

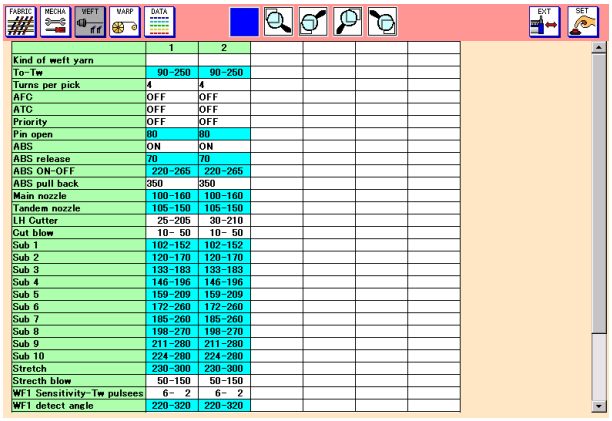


	1	2
Kind of weft yarn		
To-Tw	80-230	80-230
Turns per pick	4	4
AFC	OFF	OFF
ATC	OFF	OFF
Priority	OFF	OFF
Pin open	70	70
ABS	ON	ON
ABS release	60	60
ABS ON-OFF	200-250	200-250
ABS pull back	350	350
Main nozzle	90-160	90-160
Tandem nozzle	95-150	95-150
LH Cutter	25-205	30-210
Cut blow	10- 50	10- 50
Sub 1	92-142	92-142
Sub 2	109-159	109-159
Sub 3	121-171	121-171
Sub 4	133-183	133-183
Sub 5	145-195	145-195
Sub 6	157-260	157-260
Sub 7	169-260	169-260
Sub 8	181-270	181-270
Sub 9	193-280	193-280
Sub 10	205-280	205-280
Stretch	210-300	210-300
Stretch blow	50-150	50-150
WF1 Sensitivity-Tw pulsees	6- 2	6- 2
WF1 detect angle	200-320	200-320

Electrical setting values concerning weft insertion are displayed collectively. Since there are too many items for display on one screen, a scroll bar appears. Representative weft setting values for weaving are displayed, but extended settings such as drum and pin control methods are not displayed. This is because most fabrics do not need extended settings.

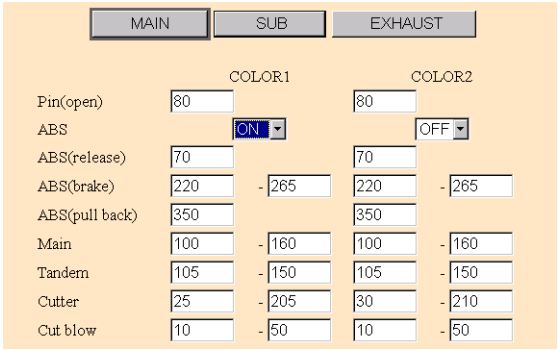
This weft insertion screen and the next warp setting screen involve electrical setting values, and do not require no mechanical adjustment for the desired changes.

The items on this weft insertion and the next warp setting screens can be set on other than the WA-Condition (list of weaving conditions) screen.



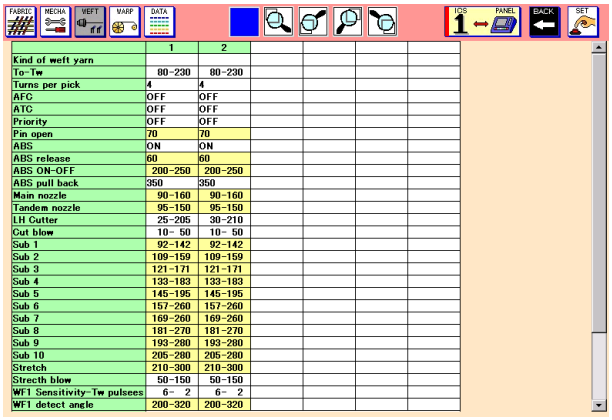
	1	2
Kind of weft yarn		
To-Tw	90-250	90-250
Turns per pick	4	4
AFC	OFF	OFF
ATC	OFF	OFF
Priority	OFF	OFF
Pin open	80	80
ABS	ON	ON
ABS release	70	70
ABS ON-OFF	220-265	220-265
ABS pull back	350	350
Main nozzle	100-160	100-160
Tandem nozzle	105-150	105-150
LH Cutter	25-205	30-210
Cut blow	10- 50	10- 50
Sub 1	102-152	102-152
Sub 2	120-170	120-170
Sub 3	133-183	133-183
Sub 4	146-196	146-196
Sub 5	159-209	159-209
Sub 6	172-260	172-260
Sub 7	185-260	185-260
Sub 8	198-270	198-270
Sub 9	211-280	211-280
Sub 10	224-280	224-280
Stretch	230-300	230-300
Stretch blow	50-150	50-150
WF1 Sensitivity-Tw pulsees	6- 2	6- 2
WF1 detect angle	220-320	220-320

Changing the ABS setting below on the valve screen, for example,



automatically changes the condition list weft insertion screen items to .

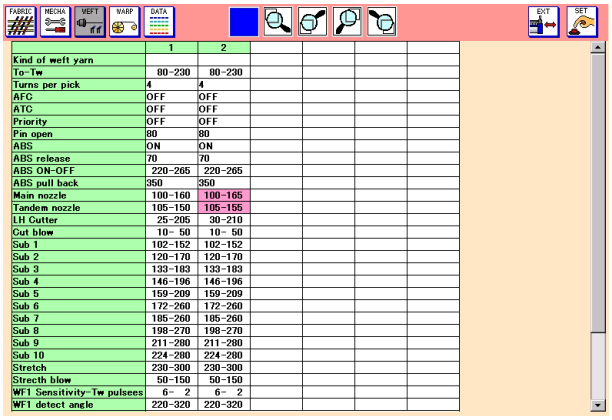
To-Tw	80-230	80-230
Turns per pick	4	4
AFC	OFF	OFF
ATC	OFF	OFF
Priority	OFF	OFF
Pin open	80	80
ABS	ON	OFF
ABS release	70	70
ABS ON-OFF	220-265	220-265
ABS pull back	350	350



	1	2
Kind of weft yarn		
To-Tw	80-230	80-230
Turns per pick	4	4
AFC	OFF	OFF
ATC	OFF	OFF
Priority	OFF	OFF
Pin open	70	70
ABS	ON	ON
ABS release	60	60
ABS ON-OFF	200-250	200-250
ABS pull back	350	350
Main nozzle	90-160	90-160
Tandem nozzle	95-150	95-150
LH Cutter	25-205	30-210
Cut blow	10- 50	10- 50
Sub 1	92-142	92-142
Sub 2	109-159	109-159
Sub 3	121-171	121-171
Sub 4	133-183	133-183
Sub 5	145-195	145-195
Sub 6	157-260	157-260
Sub 7	169-260	169-260
Sub 8	181-270	181-270
Sub 9	193-280	193-280
Sub 10	205-280	205-280
Stretch	210-300	210-300
Stretch blow	50-150	50-150
WF1 Sensitivity-Tw pulsees	6- 2	6- 2
WF1 detect angle	200-320	200-320

Also, transfer by ICS will turn the automatically changed value to .

Comparative display between the ICS values and present values is possible by “Changed value list” on the ICS transfer screen.



	1	2
Kind of weft yarn		
To-Tw	80-230	80-230
Turns per pick	4	4
AFC	OFF	OFF
ATC	OFF	OFF
Priority	OFF	OFF
Pin open	80	80
ABS	ON	ON
ABS release	70	70
ABS ON-OFF	220-265	220-265
ABS pull back	350	350
Main nozzle	100-160	100-165
Tandem nozzle	105-150	105-155
LH Cutter	25-205	30-210
Cut blow	10- 50	10- 50
Sub 1	102-152	102-152
Sub 2	120-170	120-170
Sub 3	133-183	133-183
Sub 4	146-196	146-196
Sub 5	159-209	159-209
Sub 6	172-260	172-260
Sub 7	185-260	185-260
Sub 8	198-270	198-270
Sub 9	211-280	211-280
Sub 10	224-280	224-280
Stretch	230-300	230-300
Strecth blow	50-150	50-150
WF1 Sensitivity-Tw pulsees	6- 2	6- 2
WF1 detect angle	220-320	220-320

[5.2] Operation Method

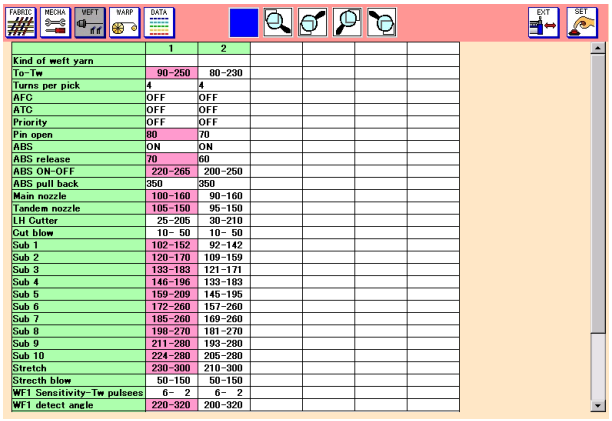
The operation method for electrical setting values is the same as on other screens.
Any desired changed items turn red as shown at left.

Click 

to turn “ ” to “ ”, and click [YES] for reflection in control.

ABS	ON	ON
ABS release	70	70
ABS ON-OFF	220-265	220-265
ABS pull back	350	350
Main nozzle	100-160	100-165
Tandem nozzle	105-150	105-155
LH Cutter	25-205	30-210
Cut blow	10- 50	10- 50

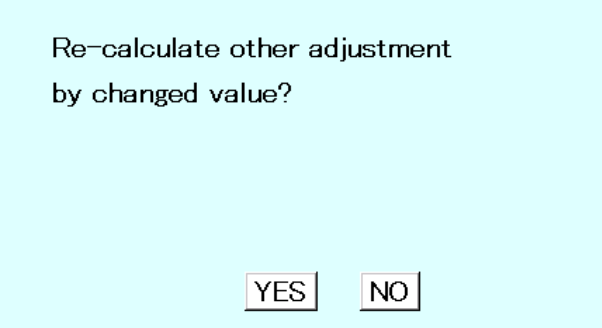
The display changes as shown above since normal functioning is often obtained by reflecting multiple items collectively in control.



	1	2
Kind of weft yarn		
To-Tw	90-250	80-230
Turns per pick	4	4
AFC	OFF	OFF
ATC	OFF	OFF
Priority	OFF	OFF
Pin open	80	70
ABS	ON	ON
ABS release	70	60
ABS ON-OFF	220-265	200-250
ABS pull back	350	350
Main nozzle	100-160	90-160
Tandem nozzle	105-150	95-150
LH Cutter	25-205	30-210
Cut blow	10- 50	10- 50
Sub 1	102-152	92-142
Sub 2	120-170	109-159
Sub 3	133-183	121-171
Sub 4	146-196	133-183
Sub 5	159-209	145-195
Sub 6	172-260	157-260
Sub 7	185-260	169-260
Sub 8	198-270	181-270
Sub 9	211-280	193-280
Sub 10	224-280	205-280
Stretch	230-300	210-300
Strecth blow	50-150	50-150
WF1 Sensitivity-Tw pulsees	6- 2	6- 2
WF1 detect angle	220-320	200-320

[5.3] Special Items

In case of changing the “To-Tw” item:



Clicking [YES] in response to the above message display will change the related setting values to change desired items as shown at left.

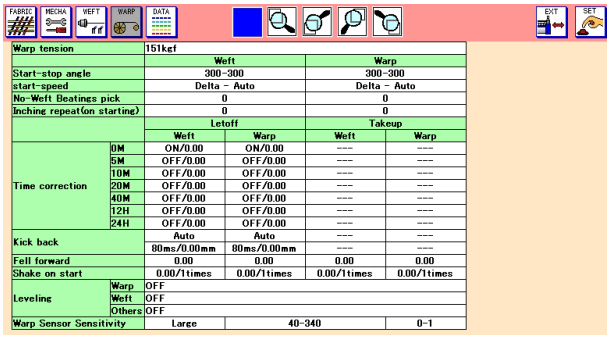
Click 

to change from “ ” to “ ” and click [YES] for reflection in control.

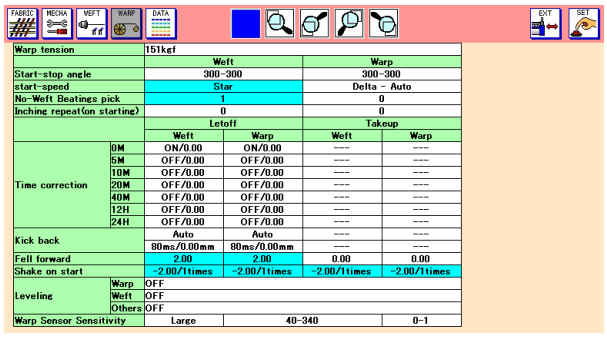
[6] Warp Tension Setting Switch

[6.1] Display Explanation

WARP screen



Warp tension		151kgf			
		Weft		Warp	
Start-stop angle		300-300		300-300	
start-speed		Delta - Auto		Delta - Auto	
No-Weft Beatings pick		0		0	
Inching repeat(on starting)		0		0	
		Letoff		Takeup	
		Weft	Warp	Weft	Warp
Time correction	0M	ON/0.00	ON/0.00	----	----
	5M	OFF/0.00	OFF/0.00	----	----
	10M	OFF/0.00	OFF/0.00	----	----
	20M	OFF/0.00	OFF/0.00	----	----
	40M	OFF/0.00	OFF/0.00	----	----
	12H	OFF/0.00	OFF/0.00	----	----
	24H	OFF/0.00	OFF/0.00	----	----
Kick back		Auto	Auto	----	----
		80ms/0.00mm	80ms/0.00mm	----	----
Fell forward		0.00	0.00	0.00	0.00
Shake on start		0.00/1times	0.00/1times	0.00/1times	0.00/1times
Leveling	Warp	OFF			
	Weft	OFF			
	Others	OFF			
Warp Sensor Sensitivity		Large	40-340		0-1

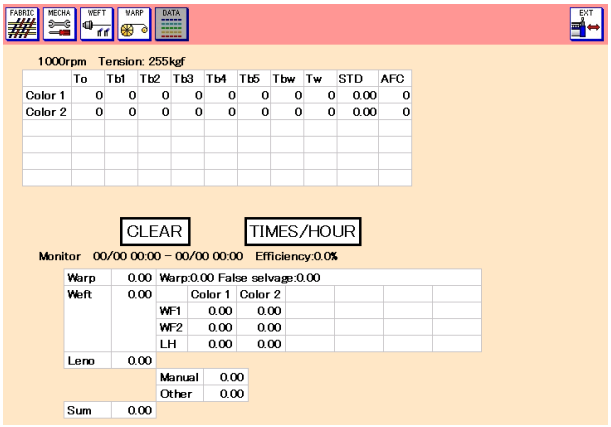


Warp tension		151kgf			
		Weft		Warp	
Start-stop angle		300-300		300-300	
start-speed		Star		Delta - Auto	
No-Weft Beatings pick		1		0	
Inching repeat(on starting)		0		0	
		Letoff		Takeup	
		Weft	Warp	Weft	Warp
Time correction	0M	ON/0.00	ON/0.00	----	----
	5M	OFF/0.00	OFF/0.00	----	----
	10M	OFF/0.00	OFF/0.00	----	----
	20M	OFF/0.00	OFF/0.00	----	----
	40M	OFF/0.00	OFF/0.00	----	----
	12H	OFF/0.00	OFF/0.00	----	----
	24H	OFF/0.00	OFF/0.00	----	----
Kick back		Auto	Auto	----	----
		80ms/0.00mm	80ms/0.00mm	----	----
Fell forward		2.00	2.00	0.00	0.00
Shake on start		-2.00/1times	-2.00/1times	-2.00/1times	-2.00/1times
Leveling	Warp	OFF			
	Weft	OFF			
	Others	OFF			
Warp Sensor Sensitivity		Large	40-340		0-1

Select DELTA and MARK on the ICS transfer screen, and the set vales related to the stop mark are automatically set to the recommended values from the yarn material, texture, rpm, and fabric width.

[7] Operation Rate Display Switch

[7.1] Display Explanation



	To	Tb1	Tb2	Tb3	Tb4	Tb5	Tbw	Tw	STD	AFC
Color 1	0	0	0	0	0	0	0	0	0.00	0
Color 2	0	0	0	0	0	0	0	0	0.00	0

This is the operation data display screen for each weaving condition.
This operation data is saved when the weaving conditions are saved for use in comparison between weaving conditions and comparison with other looms.

[7.2] Operation Method

There are only two operation items related to the operation monitor.

When [CLEAR] is clicked:

The operation monitor is cleared and re-measurement starts.

When [TIMES/HOUR] is clicked:

The stop rate is changed over between times/hr and times/100,000 times each time.

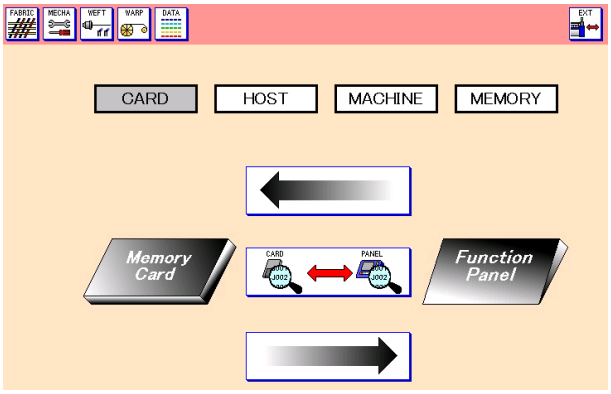
When settings related to weaving conditions are changed, the operation monitor is automatically cleared and re-measurement starts.
The final purpose is to save the operation data always under the fixed conditions.

[8] External Connection Switch

[8.1] Display Explanation

This screen is for saving to, reading from, and comparison with the external devices (including the loom internal memory).

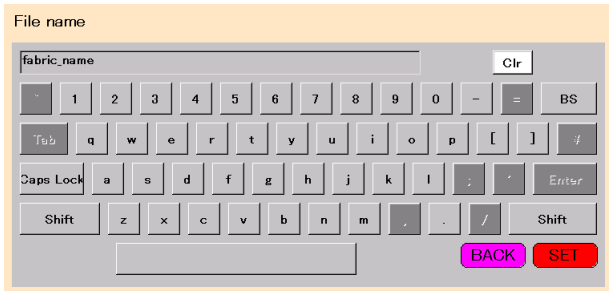
[8.2] Card Screen Explanation



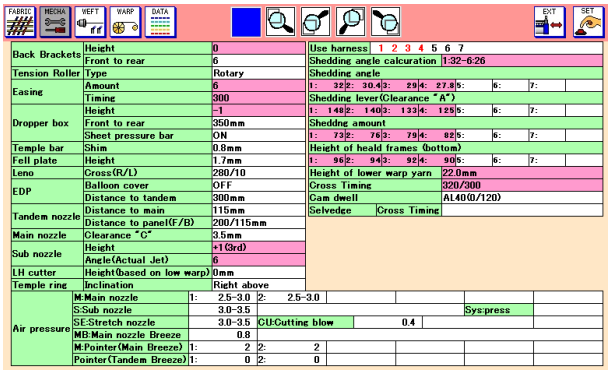
(1) The screen at left is for saving to, reading from and comparison with the memory card.

Saves the list of weaving conditions onto the card.

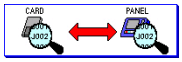
Clicking the  button displays the file name input keyboard.
As the initial file name, the style name in the fabric screen appears.
Click [SET] to write the weaving conditions onto the card.

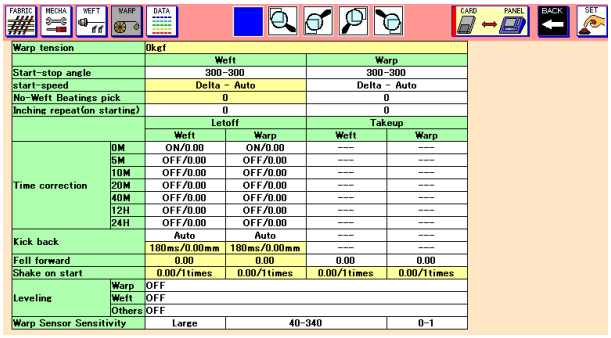


(2) Click the  button to display the card contents.
After selecting the file name to be read, click [SEND].

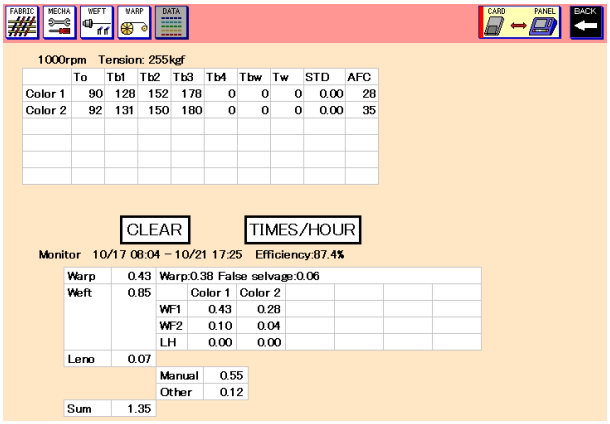


(3) After the end of reading, click on the mechanical adjustment value screen and adjust the valued desired to be changed.
For electrical setting value on other screens, the read values are reflected in control and setting value different from the past are displayed on .

(4) The button operation  will display the card contents.
After selecting the reading file name, click [SEND].



Warp tension		0kgf			
		Weft		Warp	
Start-stop angle		300-300		300-300	
start-speed		Delta - Auto		Delta - Auto	
No-Weft Beatings pick		0		0	
Inching repeat(on starting)		0		0	
		Letoff		Takeup	
		Weft	Warp	Weft	Warp
Time correction	0M	ON/0.00	ON/0.00	---	---
	5M	OFF/0.00	OFF/0.00	---	---
	10M	OFF/0.00	OFF/0.00	---	---
	20M	OFF/0.00	OFF/0.00	---	---
	40M	OFF/0.00	OFF/0.00	---	---
	12H	OFF/0.00	OFF/0.00	---	---
	24H	OFF/0.00	OFF/0.00	---	---
Kick back		Auto	Auto	---	---
		180ms/0.00mm	180ms/0.00mm	---	---
Fell forward		0.00	0.00	0.00	0.00
Shake on start		0.00/1times	0.00/1times	0.00/1times	0.00/1times
Leveling	Warp	OFF			
	Weft	OFF			
	Others	OFF			
Warp Sensor Sensitivity		Large	40-340		0-1



1000rpm Tension: 255kgf

	To	Tb1	Tb2	Tb3	Tb4	Tbw	Tw	STD	AFC
Color 1	90	128	152	178	0	0	0	0.00	28
Color 2	92	131	150	180	0	0	0	0.00	35

CLEAR TIMES/HOUR

Monitor 10/17 08:04 - 10/21 17:25 Efficiency:87.4%

Warp	0.43	Warp:0.38 False selvage:0.06						
Weft	0.85		Color 1	Color 2				
		WF1	0.43	0.28				
		WF2	0.10	0.04				
		LH	0.00	0.00				
Leno	0.07							
		Manual	0.55					
		Other	0.12					
Sum	1.35							

(5) It is possible to compare the reference data on the card with the machine data similarly as in the “Changed value list” on the ICS transfer screen.

Display of the specified file data on the card

Display of adjusted machine data

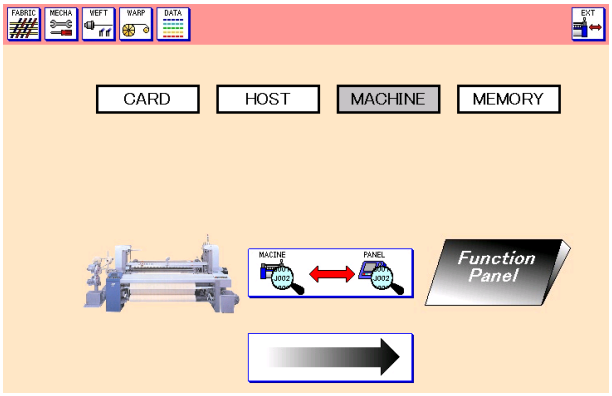
Item displayed with ▭ indicates the data different between the card and machine.

(6) In the external comparison mode, the 

screen is also subject to comparison unlike recommended value reference on the ICS SEND screen.
Since the data values are mot always identical, different values are not indicated with ▭.

[8.3] Loom Screen Explanation

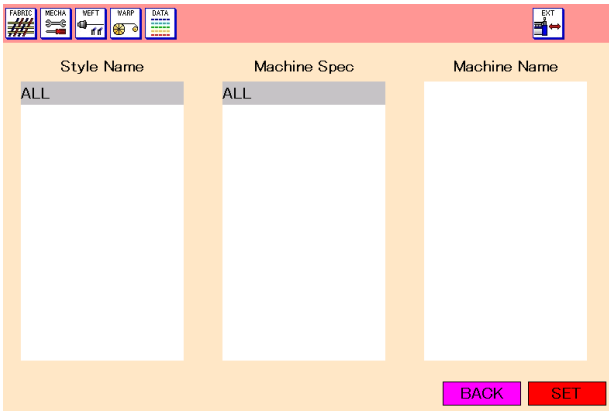
It is possible to read and compare the weaving conditions from other looms.
Transmission to any other machine is impossible.



(1) It is necessary to select the object loom before reading and comparison.

For selection, first click the 

[Loom icon].

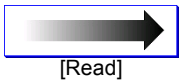


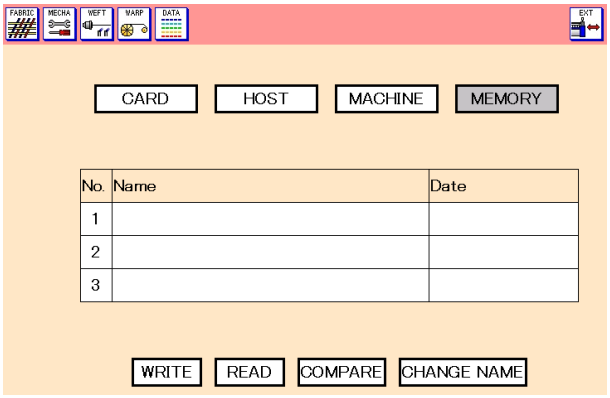
(2) The screen changes as shown at left.
When the function IP table is set:
The screen at left displays the style name, machine spec. and machine name for all set looms.

If ALL is selected for both the style name and machine spec., all registered machine names are displayed.
Upon selection of the style name and machine spec., the selected machine names appear.

Click the machine name of the object loom.

(3) After the selection, click [SET].
The display returns to the original machine screen, and the machine name appears on the machine icon.


[Read] and 
[Compare] operational are the same as those explained for the card screen.



[8.4] Memory Screen Explanation

The memory screen can save three lists of weaving conditions to the machine internal memory.
With regard to the saved list of weaving conditions, reading and comparison are possible as for the card screen.

(1) First select (click) one of Nos. 1, 2 and 3.

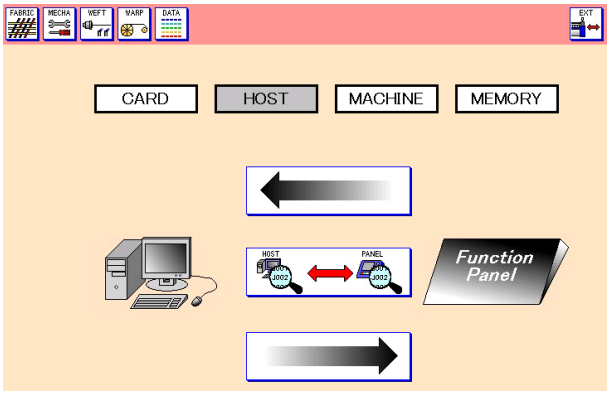
No.	Name	Date
1		
2		
3		

(2) The selected No. line is blackened (reverse display).
Select [WRITE] and click [YES] in response to “Do you want to save”.
The present machine weaving conditions are written into the memory, and the date is registered.

No.	Name	Date
1	fabric-1	2006-11-20 15:08
2		
3		

To change the name, click [CHANGE] and input from the keyboard.

(3) “Reading” and “comparison” become possible for the written (dated) weaving conditions.



[8.5] Host Screen Explanation (Optional)

The host function is optional.
For detailed explanation, refer to the instruction manual contained in the WAS software CD-ROM.