

CREEL

1. **Type:**
Stationary, Side to Side, Side to Side and Front to Back, Rotating
2. **Number of beams:**
8, 12, 16, 20, 24, 28, 32
3. **Beam widths:**
1,800, 2,000, 2,200, 2,400mm
4. **Brakes:**
Pneumatic band (5 to 20kg. per beam)
5. **Tension control:**
by load cell (\pm 1.0 GPE)
6. **Beam flange diameter:**
1,000, 1,100, 1,250mm
7. **Beam type:**
Euro gear or journal type
8. **Loom Beam Let-off Stand (LBL):**
Up to 2,200mm working width
9. **LBL tension:**
10kg to 300kg.

SIZE BOX

10. **Number of size boxes::**
1 or 2 Vertical Exit DDDS
11. **Working width:**
1,800, 2,000, 2,200, 2,400mm
12. **Draw Roll Assy. (tension controlled):**
Motor driven
13. **#1 Squeeze roll rubber covered:**
150mm \varnothing x working width + 200mm
14. **Size Rock driven roll:**
230mm \varnothing working width + 200mm
15. **#2 Squeeze roll rubber covered:**
230mm \varnothing uni-squeeze x working width + 200mm
16. **Squeeze roll rubber coverings:**
65 durometer

GENERAL SPECIFICATIONS: GSSM-100-A SIZING MACHINE (Apparel)

17. **#1 Squeeze roll loading:**
0-20kN
18. **#2 Squeeze roll loading:**
0-40kN
19. **Seal-less pan design:**
Roll journals are above the size level which eliminate the need for shaft seals
20. **Sheet exit:**
Single or wet-split
21. **Tension control:**
by load cell rolls (\pm 1.0 GPE)
22. **Stretch:**
Monitored to within 0.01% stretch
23. **Pan capacity (Teflon coated):**
180, 200, 220, 240 liters
24. **Filtration:**
Screen type
25. **Size temperature control:**
RTD/on-off steam valve
26. **Size heating:**
direct steam heating
27. **Size level control:**
by Over-flow weir
28. **Size add-on:**
by continuous calculation from size consumption and speed/yarn throughput, size add-on control using PLEVA (optional)
29. **Storage kettle:**
Closed steam coil, 1,200, 1,500, 2,000 liter
30. **Cooking kettle:**
Open steam coil, 1,000 liter
31. **Kettle pumps:**
From cooker to storage and storage to sizer
32. **Controls:**
Temperature control for each kettle

DRYING SECTION

- 33. **Dry Cylinder specifications:**
800mmØ x working width + 200mm
- 34. **Working steam pressure:**
5 Bar
- 35. **Temperature control:**
RTD, controlled in 2-can groups
- 36. **Drying section drive system:**
Tension controlled by load cell (± 1.0 GPE)
- 37. **Stretch:**
Monitored (within 0.01% stretch)
- 38. **Drive type:**
Self-lub chain (final stack only)
- 39. **Over-oiler/waxer:**
Steam heated
- 40. **Cut marker**
Style programmable
- 41. **Hood:**
Buyer to arrange hood locally as per UKIL design
- 42. **Exhaust fans:**
16,000m³/hr. per fan

HEAD END

- 43. **Winding head type:**
Conventional
- 44. **Loom beam width:**
2,200mm to 5,400mm
- 45. **Loom beam diameter:**
1,000mm, 1,100mm, 1,250mm, 1,400mm
- 46. **Maximum mechanical speed:**
150 MPM
- 47. **Maximum winding tension:**
900 Kg
- 48. **Tension control:**
by load cell (± 1.0 GPE)
- 49. **Stretch**
Monitored (within 0.01 stretch)
- 50. **Delivery roll (urethane covered):**
260mm Ø working width + 200mm

- 51. **Nip roll/load cell roll:**
160mm Ø working width + 200mm
- 52. **Doffing:**
Hydraulic operation 3,200kg max. capacity
- 53. **Dual Press Roll Assembly:**
pneumatically controlled 100kg - 600kg
- 54. **Comb:**
Zig Zag, motorized movement
- 55. **Taping device**
Motorized movement
- 56. **Final moisture (full width of sheet):**
Resistive rod sensor

DRIVE AND CONTROL SYSTEM

- 57. **Human Machine Interface (HMI):**
480mm color touchscreen utilizing MS Visual Basic
- 58. **PC based:**
2Gb Compact Flash card stores all programs/style information, reliable diskless technology
- 59. **Maximum ambient operating temp:**
50° C, AC unit is required for higher temperatures
- 60. **Operating system (embedded):**
Microsoft Windows 7 with real time extension
- 61. **Control software:**
IEC 61131-3 compliant
- 62. **Style recipe storage:**
Up to 999 styles
- 63. **Communication:**
High speed Ethercat to drives and I/O
- 64. **Drives:**
Yaskawa A1000 AC Vector/Servo
- 65. **I/O:**
Beckhoff Ethercat distributed I/O with direct strain gauge interface, RTD, current, voltage, relay, etc. mounted close to the device for easy installation and troubleshooting
- 66. **Motors:**
SEW with encoder feedback for speed control

67. Control cabinets:

3C labeling on all wiring

68. eXpert Service Link:

Offers remote diagnoses for hardware status, sensor status, calibrate sensors as required and help with style setup issues.

69. Remote access:

Through Teamviewer and plant provided CAT5 internet connection 3C labeling on all wiring

Controls:

- a) Creel tension control in grams per end.
- b) Draw roll tension control in grams per end.
- c) Size box tension control in grams per end with % stretch monitored.
- d) Lease tension control in grams per end with % stretch monitored.
- e) Loom beam winding tension control in grams per end.
- f) Size temperature control of the size box.
- g) Size level control and low level alarm in the size box.
- h) Squeeze roll pressure control of the size box, linear step less type.
- i) Dry can temperature control in six zones.
- j) Overoiler speed and temperature control
- k) Moisture control of delivered yarn by speed.
- l) Loom beam length control.
- m) Cooking and storage kettle temperature controls
- n) Internet connection, eXpert Service Link for remote assistance.
- o) Clear annunciation of warnings and fault