

- Chapter 1 Fundamentals of Yarns and Yarn Production p. 1
- 1.1 Early History and Developments p. 1
- 1.2 Yarn Classification and Structure p. 2
- 1.2.1 Classification of Yarns p. 3
- 1.2.2 The Importance of Yarns in Fabrics p. 4
- 1.2.3 A Simple Analysis of Yarn Structure p. 5
- 1.2.3.1 The Simple Helix Model p. 6
- 1.3 Yarn Count Systems p. 8
- 1.3.1 Dimensions of a Yarn p. 8
- 1.4 Twist and Twist Factor p. 12
- 1.4.1 Direction and Angle of Twist p. 12
- 1.4.2 Twist Insertion, Real Twist, Twist Level, and False Twist p. 13
- 1.4.2.1 Insertion of Real Twist p. 13
- 1.4.2.2 Twist Level p. 14
- 1.4.2.3 Insertion of False Twist p. 14
- 1.4.3 Twist Multiplier/Twist Factor p. 15
- 1.4.4 Twist Contraction/Retraction p. 17
- 1.5 Fiber Parallelism p. 18
- 1.6 Principles of Yarn Production p. 18
- 1.7 Raw Materials p. 22
- 1.7.1 The Global Fiber Market p. 22
- 1.7.2 The Important Fiber Characteristics and Properties for Yarn Production p. 25
- 1.7.2.1 Cotton Fibers p. 27
- 1.7.2.1.1 Fiber Length (UHM) p. 30
- 1.7.2.1.2 Length Uniformity Index (LUI) p. 30
- 1.7.2.1.3 Fiber Strength p. 30
- 1.7.2.1.4 Micronaire p. 30
- 1.7.2.1.5 Color p. 31
- 1.7.2.1.6 Preparation p. 32
- 1.7.2.1.7 Leaf and Extraneous Matter (Trash) p. 33
- 1.7.2.1.8 Stickiness p. 33
- 1.7.2.1.9 Nep Content p. 34
- 1.7.2.1.10 Short Fiber Content (SFC) p. 35
- 1.7.2.2 Wool Fibers p. 36
- 1.7.2.2.1 Fineness p. 39
- 1.7.2.2.2 Fiber Length Measurements p. 40
- 1.7.2.2.3 Tensile Properties p. 41
- 1.7.2.2.4 Color p. 42
- 1.7.2.2.5 Vegetable Content, Grease, and Yield p. 42
- 1.7.2.2.6 Crimp, Bulk, Lustre, Resilience p. 43
- 1.7.2.2.7 Medullation p. 43
- 1.7.2.3 Speciality Hair Fibers p. 44
- 1.7.2.3.1 Mohair p. 44
- 1.7.2.3.2 Types of Fleeces p. 45
- 1.7.2.3.3 Physical Properties p. 45
- 1.7.2.3.4 Cashmere p. 46

- 1.7.2.3.5 Physical Properties p. 47
- 1.7.2.4 Silk Fibers p. 47
- 1.7.2.4.1 Waste Silk p. 47
- 1.7.2.5 Manufactured Fibers [Man-Made Fibers (MMFs)] p. 48
- 1.7.2.5.1 Viscose Rayon and Lyocell p. 49
- 1.7.2.5.2 Polyamide (Nylon) p. 49
- 1.7.2.5.3 Polyester p. 49
- 1.7.2.5.4 Acrylic p. 49
- 1.7.2.5.5 Polypropylene p. 50
- References p. 50
- Appendix 1A Derivation of Equation for False-Twist Insertion p. 53
- 1A.1 Twist Equation for Zone AX p. 53
- 1A.2 Twist Equation for Zone XB p. 54
- Appendix 1B Fiber Length Parameters p. 55
- 1B.1 Staple Length p. 55
- 1B.2 Fiber Length Distributions p. 55
- 1B.3 CFD by Suter-Webb p. 55
- Chapter 2 Materials Preparation Stage I: Opening, Cleaning, and Scouring p. 59
- 2.1 Introduction p. 59
- 2.2 Stage I: Opening and Cleaning p. 60
- 2.2.1 Mechanical Opening and Cleaning p. 60
- 2.2.2 Striking from a Spike p. 67
- 2.2.3 Beater and Feed Roller p. 67
- 2.2.4 Use of Air Currents p. 70
- 2.2.5 Estimation of the Effectiveness of Opening and Cleaning Systems p. 74
- 2.2.5.1 Intensity of Opening p. 74
- 2.2.5.2 Openness Value p. 76
- 2.2.5.3 Cleaning Efficiency p. 76
- 2.2.6 Wool Scouring p. 77
- 2.2.7 Wool Carbonizing p. 85
- 2.2.8 Tuft Blending p. 86
- 2.2.8.1 Basic Principles of Tuft Blending p. 87
- 2.2.8.2 Tuft Blending Systems p. 89
- 2.2.9 Opening, Cleaning, and Blending Sequence p. 92
- Chapter 3 Materials Preparation Stage II: Fundamentals of the Carding Process p. 101
- References p. 96
- Appendix 2A Lubricants p. 99
- Reference p. 100
- 3.1 Introduction p. 101
- 3.2 The Revolving Flat Card p. 103
- 3.2.1 The Chute Feed System p. 103
- 3.2.2 The Taker-in Zone p. 106
- 3.2.3 Cylinder Carding Zone p. 107
- 3.2.4 Cylinder-Doffer Stripping Zone p. 109
- 3.2.5 Sliver Formation p. 109
- 3.2.6 Continuity of Fiber Mass Flow p. 109

- 3.2.7 Drafts Equations p. 110
- 3.2.8 Production Equation p. 111
- 3.2.9 The Tandem Card p. 111
- 3.3 Worsted and Woolen Cards p. 112
- 3.3.1 Hopper Feed p. 114
- 3.3.2 Taker-in and Breast Section p. 115
- 3.3.3 Intermediate Feed Section of the Woolen Card p. 115
- 3.3.3.1 Carding Section p. 115
- 3.3.4 Burr Beater Cleaners and Crush Rollers p. 116
- 3.3.5 Sliver and Slubbing Formation p. 118
- 3.3.5.1 Tape Condenser p. 118
- 3.3.5.2 Ring-Doffer Condenser p. 119
- 3.3.6 Production Equations p. 120
- 3.4 Sliver Quality p. 120
- 3.4.1 Cleaning Efficiency p. 121
- 3.4.1.1 Short-Staple Carding p. 121
- 3.4.1.2 Worsted and Woolen Carding p. 123
- 3.4.2 Nep Formation and Removal p. 123
- 3.4.2.1 Nep Formation p. 125
- 3.4.2.2 The Effect of Fiber Properties p. 127
- 3.4.2.3 Effect of Machine Parameters p. 129
- 3.4.2.4 Short Fiber Content p. 132
- 3.4.3 Sliver and Slubbing Regularity p. 133
- 3.5 Autoleveling p. 138
- 3.6 Backwashing p. 141
- References p. 142
- Recommended Readings on the Measurement of Yarn Quality Parameters p. 144
- Appendix 3A Card Clothing p. 145
- 3A.1 Metallic Wires: Saw-Tooth Wire Clothing p. 145
- 3A.1.1 Tooth Depth p. 145
- 3A.1.2 Tooth Angles p. 147
- 3A.1.3 Point Density p. 147
- 3A.1.4 Tooth Point Dimension p. 148
- 3A.2 Front and Rear Fixed Flats p. 148
- 3A.3 Wear of Card Clothing p. 148
- Appendix 3B Condenser Tapes and Rub Aprons p. 149
- 3B.1 Tape Threadings p. 149
- 3B.1.1 The Figure 8 Threading p. 149
- 3B.1.2 Series Threading p. 150
- 3B.1.3 Endless Threading p. 150
- 3B.2 Rubbing Aprons p. 150
- Appendix 3C Minimum Irregularity and Index of Irregularity p. 153
- Chapter 4 Carding Theory p. 155
- 4.1 Opening of Fiber Mass p. 155
- 4.1.1 Taker-in Action p. 155
- 4.1.2 Feed-Roller, Feed-Plate Systems p. 155

- 4.1.2.1 Feed-Roller Systems p. 158
- 4.2 Carding Actions p. 159
- 4.2.1 Cylinder-Flat Action p. 159
- 4.2.2 Swift-Worker-Stripper Action p. 162
- 4.3 Web Formation and Fiber Configuration p. 170
- 4.3.1 Cylinder-Doffer Action p. 170
- 4.3.1.1 Fiber Configuration and Mechanism of Fiber Transfer p. 170
- 4.3.1.2 Effect of Machine Variables on Fiber Configuration p. 175
- 4.3.1.3 Recycling Layer and Transfer Coefficient p. 176
- 4.3.1.4 Factors that Determine the Transfer Coefficient, K p. 179
- 4.3.1.5 The Importance of the Recycling Layer p. 184
- 4.3.2 Blending-Leveling Action p. 189
- 4.3.2.1 Evening Actions of a Card p. 189
- 4.3.2.1.1 Step Change in Feed p. 192
- 4.3.2.1.2 General or Random Irregularities p. 194
- 4.3.2.1.3 Periodic Irregularities p. 194
- 4.4 Fiber Breakage p. 195
- 4.4.1 Mechanism of Fiber Breakage p. 195
- 4.4.2 State of Fiber Mass and Fiber Characteristics p. 197
- 4.4.3 Effect Residual Grease and Added Lubrication p. 197
- 4.4.4 Effect of Machine Parameters p. 199
- 4.4.4.1 Tooth Geometry p. 199
- 4.4.4.2 Roller Surface Speed/Setting/Production Rate p. 199
- 4.4.4.2.1 The Taker-in Zone p. 199
- 4.4.4.2.2 Effect of Cylinder-Flats and Swift-Worker Interaction p. 201
- References p. 202
- Appendix 4A p. 205
- 4B.3 Micro-Damage of Fibers Caused by the Opening Process p. 211
- Appendix 4B The Opening of a Fibrous Mass p. 207
- 4B.1 Removal of Fibers when Both Ends are Embedded in the Fiber Mass p. 207
- 4B.2 Behavior of a Single Fiber Struck by High-Speed Pins p. 208
- References p. 212
- Chapter 5 Materials Preparation Stage III p. 215
- 5.1 Drawing p. 215
- 5.1.1 Principles of Doubling p. 216
- 5.1.2 Principles of Roller Drafting p. 216
- 5.1.2.1 Ideal Drafting p. 217
- 5.1.2.2 Actual Drafting p. 221
- 5.1.2.2.4 Drafting Force p. 224
- 5.1.2.2.1 Effect of Input Material Characteristics p. 221
- 5.1.2.2.2 Drafting Wave p. 222
- 5.1.2.2.3 Observations of Floating Fiber Motion p. 223
- 5.1.2.3 Factors Influencing Drafting Wave Irregularity p. 227
- 5.1.2.3.1 Size of Draft p. 227
- 5.1.2.3.2 Input Count p. 228
- 5.1.2.3.3 Doubling p. 228

- 5.1.2.3.4 Fiber Straightness, Parallelism, Fineness, and Length p. 229
- 5.1.2.3.5 Roller Settings p. 230
- 5.1.3 Effect of Machine Defects p. 231
- 5.1.3.1 Roller Eccentricity p. 231
- 5.1.3.2 Roller Slip p. 232
- 5.1.4 The Drawing Operations p. 232
- 5.1.4.1 The Drawframe p. 233
- 5.1.4.2 The Gill Box p. 235
- 5.1.5 Production Equation p. 237
- 5.2 Combing p. 238
- 5.2.1 The Principles of Rectilinear Combing p. 238
- 5.2.1.1 Nasmith Comb p. 239
- 5.2.1.1.1 The Cylinder Comb p. 239
- 5.2.1.1.2 The Feed Roller/Top and Bottom Nipper Plates/Top Comb p. 240
- 5.2.1.1.3 Detaching Rollers and Delivery Rollers p. 240
- 5.2.1.1.4 The Combing Cycle p. 240
- 5.2.1.2 French Comb p. 241
- 5.2.2 Production Equation p. 244
- 5.2.3 Degrees of Combing p. 244
- 5.2.4 Factors Affecting Noil Extraction p. 245
- 5.2.4.1 Comber Settings p. 245
- 5.2.4.2 Preparation of Input Sliver p. 245
- 5.3 Conversion of Tow to Sliver p. 247
- 5.3.1 Cutting Converters p. 248
- 5.3.2 Stretch-Breaking Converters p. 248
- 5.3.3 Production Equation p. 250
- 5.4 Roving Production p. 250
- 5.4.1 The Speed-Frame (Twisted Rovings) p. 252
- 5.4.1.1 Production Equation p. 254
- 5.4.2 Rub Rovers (Twistless Rovings) p. 256
- 5.4.2.1 Production Equation p. 256
- 5.5 Environmental Processing Conditions p. 256
- References p. 257
- Chapter 6 Yarn Formation Structure and Properties p. 261
- 6.1 Spinning Systems p. 261
- 6.1.1 Ring and Traveler Spinning Systems p. 265
- 6.1.1.1 Conventional Ring Spinning p. 265
- 6.1.1.2 Spinning Tensions p. 267
- 6.1.1.3 Twist Insertion and Bobbin Winding p. 269
- 6.1.1.3.1 Spinning End Breaks p. 272
- 6.1.1.4 Compact Spinning and Solo Spinning p. 274
- 6.1.1.5 Spun-Plied Spinning p. 278
- 6.1.1.6 Key Points p. 282
- 6.1.1.6.1 Advantages p. 282
- 6.1.1.6.2 Disadvantages p. 282
- 6.1.2 Open-End Spinning Systems p. 282

- 6.1.2.1 OE Rotor Spinning p. 284
- 6.1.2.1.1 Twist Insertion p. 285
- 6.1.2.1.2 End Breaks during Spinning p. 287
- 6.1.2.2 OE Friction Spinning p. 287
- 6.1.3 Self-Twist Spinning System p. 290
- 6.1.4 Wrap Spinning Systems p. 295
- 6.1.4.1 Surface Fiber Wrapping p. 296
- 6.1.4.1.1 Dref-3 Friction Spinning p. 296
- 6.1.4.1.2 Air-Jet Spinning p. 296
- 6.1.4.1.3 Single- and Twin-Jet Systems: Murata Vortex, Murata Twin Spinner, Suessen Plyfil p. 300
- 6.1.4.2 Filament Wrapping p. 302
- 6.1.5 Twistless Spinning Systems p. 302
- 6.1.5.1 Continuous Felting: Periloc Process p. 302
- 6.1.5.2 Adhesive Bonding: Bobtex Process p. 304
- 6.1.6 Core Spinning p. 304
- 6.1.7 Doubling Principles p. 307
- 6.1.7.1 Down Twisting p. 309
- 6.1.7.2 Two-for-One Twisting p. 309
- 6.1.8 Economic Considerations p. 310
- 6.2 Yarn Structure and Properties p. 313
- 6.2.1 Yarn Structure p. 314
- 6.2.1.1 Surface Characteristics and Geometry p. 315
- 6.2.1.2 Fiber Migration and Helix Model of Yarn Structures p. 316
- 6.2.2 Formation of Spun Yarn Structures p. 320
- 6.2.2.1 Conventional Ring-Spun Yarns p. 320
- 6.2.2.3.1 Cyclic Aggregation p. 323
- 6.2.2.1.1 Mechanism of Fiber Migration p. 321
- 6.2.2.2 Compact Ring-Spun Yarns p. 323
- 6.2.2.3 Formation of Rotor Yarn Structure p. 323
- 6.2.2.3.2 Theory of Spun-in Fibers in Yarns p. 330
- 6.2.2.4 Formation of Friction-Spun Yarn Structures p. 333
- 6.2.2.5 Formation of Wrap-Spun Yarn Structures p. 341
- 6.2.2.5.1 Air-Jet Spun Yarns p. 341
- 6.2.2.5.2 Hollow-Spindle Wrap-Spun Yarns p. 344
- 6.2.3 Structure Property Relation of Yarns p. 346
- 6.2.3.1 Compression p. 350
- 6.2.3.2 Flexural Rigidity p. 355
- 6.2.3.3 Tensile Properties p. 359
- 6.2.3.3.1 Effect of Twist p. 362
- 6.2.3.3.2 Effect of Fiber Properties and Material Preparation p. 366
- 6.2.3.3.3 Fiber Blends p. 373
- 6.2.3.4.2 Effect of Spinning Machine Variables p. 385
- 6.2.3.3.4 Effect of Spinning Machine Variables p. 374
- 6.2.3.4 Irregularity Parameters p. 378
- 6.2.3.4.1 Effect of Fiber Properties and Material Preparation p. 381

- 6.2.3.4.3 Yarn Blends p. 393
- 6.2.3.4.4 The Ideal Blend p. 395
- 6.2.3.5 Hairiness Profile p. 397
- 6.2.3.6 Moisture Transport p. 400
- 6.2.3.7 Friction p. 402
- 6.3 Quality Criteria p. 404
- 6.3.1 Post-Process Performance Criteria p. 404
- 6.3.1.1 Knitting p. 404
- 6.3.1.2 Weaving p. 404
- 6.3.1.3 Fabric Quality p. 405
- References p. 406
- Chapter 7 The Principles of Package Winding p. 415
- 7.1 Basic Principles p. 416
- 7.1.1 Winding Parameters p. 416
- 7.2 Types of Winding Machines p. 420
- 7.2.1 Drum-Winding Machines p. 420
- 7.2.1.1 Wing Cam p. 420
- 7.2.1.2 Grooved Drum p. 421
- 7.2.1.3 Patterning/Ribboning p. 422
- 7.2.1.4 Sloughing-Off p. 422
- 7.2.1.5 Anti-patterning Devices p. 422
- 7.2.1.5.1 Variation of Traverse Frequency, N_t p. 422
- 7.2.1.5.2 Variation of Drum Speed, N_d p. 423
- 7.2.1.5.3 Lifting of Bobbin to Reduce N_b p. 423
- 7.2.1.5.4 Rock-and-Roll Method p. 423
- 7.2.2 Precision Winding Machines p. 423
- 7.2.3 Advantages and Disadvantages of the Two Methods of Winding p. 426
- 7.2.4 Combinational Methods for Pattern-Free Winding p. 426
- 7.2.4.1 Stepped Precision Winding (Digicone) p. 426
- 7.2.4.2 Ribbon Free Random Winding p. 427
- 7.3 Random-Wound Cones p. 428
- 7.3.1 Package Surface Speed p. 428
- 7.3.2 Abrasion at the Nose of Cones p. 430
- 7.3.3 Traverse Motions p. 431
- 7.4 Precision Open-Wound and Close-Wound Packages p. 431
- 7.4.1 Theory of Close-Wound Packages p. 432
- 7.4.2 Patterning or Ribboning p. 433
- 7.4.3 Hard Edges p. 433
- 7.4.4 Cobwebbing (Webbing or Stitching or Dropped Ends) p. 434
- 7.4.5 Twist Displacement p. 434
- 7.5 Yarn Tensioning and Tension Control p. 434
- 7.5.1 Characteristics of Yarn Tensioning Devices p. 435
- 7.5.1.1 The Dynamic Behavior of Yarns p. 435
- 7.5.1.2 The Capstan Effect p. 435
- 7.5.1.3 Multiplicative and Additive Effects p. 438
- 7.5.1.4 Combination Tensioning Devices p. 439

- 7.6 Yarn Clearing p. 439
- 7.7 Knotting and Splicing p. 440
- 7.7.1 Knotting p. 440
- 7.7.2 Splicing p. 441
- 7.8 Yarn Waxing p. 444
- References p. 445
- Chapter 8 Yarn Tensions and Balloon Geometry in Ring Spinning and Winding p. 447
- 8.1 Introduction p. 447
- 8.1.1 Circularly Polarized Standing Waves p. 448
- 8.2 Yarn Tensions in Ring Spinning p. 449
- 8.2.1 Yarn Formation Zone p. 449
- 8.2.2 Winding Zone p. 450
- 8.2.2.1 Yarn Tensions in the Absence of Air Drag p. 451
- 8.2.3 Balloon Zone p. 454
- 8.2.3.1 Balloon Tension in the Absence of Air Drag p. 456
- 8.2.3.2 Spinning Tension in the Absence of Air Drag p. 458
- 8.2.4 The Effect of Air Drag on Yarn Tensions p. 459
- 8.3 Balloon Profiles in Ring Spinning p. 462
- 8.3.1 Balloon Profiles in the Absence of Air Drag p. 463
- 8.3.2 The Balloon Profile in the Presence of Air Drag p. 467
- 8.3.3 Determination of Ring Spinning Balloon Profiles Based on Sinusoidal Waveforms p. 470
- 8.3.4 Effect of Balloon Control Rings p. 471
- 8.4 Tensions and Balloon Profiles in the Winding Process p. 472
- 8.4.1 Yarn Tensions during Unwinding from a Ring-Spinning Package p. 472
- 8.4.2 Unwinding Balloon Profiles p. 478
- References p. 478
- Chapter 9 Fancy Yarn Production p. 481
- 9.1 Classification of Fancy Yarns p. 481
- 9.2 Basic Principles p. 484
- 9.3 Production Methods p. 485
- 9.3.1 Plying Techniques for the Production of Fancy Yarns p. 485
- 9.3.1.1 The Profile Twisting Stage p. 486
- 9.3.1.2 The Binding Stage p. 488
- 9.3.1.3 The Plied Chenille Profile p. 488
- 9.3.2 Spinning Techniques for the Production of Fancy Yarns p. 488
- 9.4 Design and Construction of the Basic Profiles p. 492
- 9.4.1 Spiral p. 492
- 9.4.5 Knop p. 495
- 9.4.2 Gimp p. 493
- 9.4.3 Loop p. 494
- 9.4.4 Snarl p. 494
- 9.4.6 Cover p. 496
- 9.4.7 Slub p. 496
- 9.4.8 Chenille p. 497
- 9.4.9 Combination of Profiles p. 498

- Index p. 501
- 9.5 Analysis of Fancy Yarns p. 498
- References p. 499