

It's A Big, Big Textile First

own capacity to turn out good yarn. They are aware, he said, that the Har-Ray plant is being watched closely, and they are proud of its leadership role.

Yarn now being spun at Har-Ray is 100 percent synthetic. While it is available for that purpose, the mill is using its blending grab on cut rayon fiber; but it will be moved, once awaited units of equipment arrive, to a separate cotton spinning line. At that time, an old picker which is the only piece of old equipment still in use will be retired, and two Fiber Controls synthetic opening lines will take over the work now handled by the picker and the blending grab.

"The oldest piece of equipment that will leave us is our RK-10 open-end frames," said Jim Harry, with a nod toward spinning so new many mills still consider it the wave of the future.

As part of the planned cotton processing line, the Ingolstadt blending grab will select, weigh, and blend cotton from 30 bales, automatically depositing fibers in a hopper in a predetermined mix. Fiber will then be chute fed to the

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system's high-speed cards, as rayon fiber is at present. The tuft-feeding units are designed to maintain a reservoir of blended fibers at an even level by remote control of blending machines.

According to Schmidt, visitors almost comment favorably on the yellow, orange, turquoise and blue jumbo-sized card sliver cans that brighten Har-Ray's card room. In addition to eye appeal, the color-coded cans assist in keeping track of sliver flow, he said. Each 40" x 42" can holds 95 lbs. of sliver so that, despite continuous 100 lb. per hr. delivery from cards, a single employee can doff all twelve, with time left over for general card room monitoring.

Har-Ray's RSB drawframes are now running at 1,200 ft. per minute on 75 gr. rayon sliver. A plus-or-minus 25 percent correction for sliver variation is performed at each frame by what amounts to a small solid-state computer, Schmidt said. "It may not look exciting, but to me, the fact that it is actually part of the drawframe, taking on this important

assignment with such accuracy, is very impressive," he said.

The mill's RK-10 spinning frames are operating at 330 ft. per min. and producing three times the yarn obtained from former ring spinning frames. The Ingolstadt system was praised by Har-Ray spokesmen for easy piecing up without knots. All that is required is that the operator present the yarn end to a rotor operating at speeds as high as 45,000 rpm where a vacuum draws it back into the fiber ring without evidence of a break.

Vacuum for the entire frame is independent of rotor speed. Air flow, which prevents dust accumulation in the spinning chamber, is maintained even if a rotor stops, which means that fibers that might otherwise form slubs are automatically drawn away.

Control of the spinning frame is from a head-end cabinet which contains all drive elements and change points. Motor, fan and filter box are in the foot-end cabinet. Since cans stand under the frame, they add no width to the 60" required for the frame itself. With 36" cans, and with adequate clearance to place them on trucks if desired, the two-sided frame, measured to the center of the winding roll, is only slightly more than 5 ft. tall.

Doffing is perhaps the easiest function required of the spinner, who simply pulls a lever to tilt the full package onto a conveyor belt running the length of the frame and slips a new yarn tube into position.

What has \$2.3 million of new open-end spinning brought Har-Ray Mills when considered in terms of customer needs and yarn sales? Three times its former yarn production, with six times that level just around the corner, for one thing, says Lowrance Harry, the mill's treasurer. It has also resulted in yarn that is more attractive to mill customers because it is uniform, knot-free, almost entirely free of slubs and thin places, and less likely to shed lint in subsequent processing.

In a sentence, says Lowrance Harry, "We have more and better yarn to sell, and we're really enjoying the competitive edge Ingolstadt spinning gives us."

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