

Table 7.3 Guidelines for optimum levels of combing waste for different length distributions

Nature of fibre length distribution of mixing	Short fibres % by number		Mean length	Approximate level of optimum combing waste % by weight in relation to yarn quality
	Base sorter	Fibres <15 mm		
Triangular	<20%	<20%	< 26 mm	No optimum; increasing waste continuously improves quality
Flat	<18%	< 18 % < 18 %	> 26 mm Any	0.5 × short fibre (%) 0.5 × short fibre (%)

of combing waste may not always ensure better removal of short fibres and neps, and therefore will not enhance yarn quality or performance beyond a certain level. To ascertain the level of required waste is therefore a case of optimisation, balancing the improvement of quality against the higher cost involved in the removal of combing waste.

It therefore follows that the removal of short fibres and neps alongside retention of the longer fibres holds the key to efficient combing. The following points are worth noting (Gardé and Subramanian, 1978):

- Card trailing hooks usually prevail over leading ones. They are removed when fed as leading hooks by keeping an even number of passages between the card and the comb.
- A higher level of pre-combing draft can ensure lower level of combing waste without affecting the resultant yarn quality. However, there are risks associated with high pre-combing draft which undermine the inter-fibre cohesion, including problems such as lap licking and frequent sliver breaks.
- The strategic place to counteract neps is during the carding rather than the combing process. It is more economical to operate cards at a low production rate than to extract high combing waste. Since neps escape easily through needle spacing, their elimination is only possible with fibre removal, which is expensive.

The nature of fibre length distribution in the cotton or mix dictates the optimum level of combing waste to give the desired yarn quality, yarn appearance and end breaks at ring frames. A study conducted at ATRIA regarding this optimisation is summarised in Table 7.3.

Steady improvement in yarn quality can be achieved with an increase in combing waste to a point where most fibres below 15 mm length are removed (Gardé and Subramanian, 1978). As a rule of thumb, one can assess the combing waste level as 0.5 × short fibres (%). For large scale production,

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Table of Contents Process Control In Spinning Atira Fagity

1. Understanding the eBook Process Control In Spinning Atira Fagity
 - The Rise of Digital Reading Process Control In Spinning Atira Fagity
 - Advantages of eBooks Over Traditional Books
2. Identifying Process Control In Spinning Atira Fagity
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Process Control In Spinning Atira Fagity
 - User-Friendly Interface
4. Exploring eBook Recommendations from Process Control In Spinning Atira Fagity
 - Personalized Recommendations
 - Process Control In Spinning Atira Fagity User Reviews and Ratings
 - Process Control In Spinning Atira Fagity and Bestseller Lists
5. Accessing Process Control In Spinning Atira Fagity Free and Paid eBooks
 - Process Control In Spinning Atira Fagity Public Domain eBooks
 - Process Control In Spinning Atira Fagity eBook Subscription Services
 - Process Control In Spinning Atira Fagity Budget-Friendly Options
6. Navigating Process Control In Spinning Atira Fagity eBook Formats

- ePub, PDF, MOBI, and More
 - Process Control In Spinning Atira Fagity Compatibility with Devices
 - Process Control In Spinning Atira Fagity Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Process Control In Spinning Atira Fagity
 - Highlighting and Note-Taking Process Control In Spinning Atira Fagity
 - Interactive Elements Process Control In Spinning Atira Fagity
 8. Staying Engaged with Process Control In Spinning Atira Fagity
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Process Control In Spinning Atira Fagity
 9. Balancing eBooks and Physical Books Process Control In Spinning Atira Fagity
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Process Control In Spinning Atira Fagity
 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
 11. Cultivating a Reading Routine Process Control In Spinning Atira Fagity
 - Setting Reading Goals Process Control In Spinning Atira Fagity
 - Carving Out Dedicated Reading Time
 12. Sourcing Reliable Information of Process Control In Spinning Atira Fagity
 - Fact-Checking eBook Content of Process Control In Spinning Atira Fagity
 - Distinguishing Credible Sources
 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
 14. Embracing eBook Trends
 - Integration of Multimedia Elements
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