

## LRT at DTG - 2023, Dhaka, Bangladesh



## Felicitation



Mr. V. Angamuthu, General Manager, Kutti Spinners Private Limited receiving LRT Best Reply Award from their Director Mr. Sridharan



Mr. B.P. Sankarbalaji, General Manager, Sasi Anand Spinning Mills receiving LRT Best Reply Award from their Executive Directors Mr. D. Anand and Mr. D. Sasikumar

Visit us at

ITMA 2023

8 - 14 June, 2023

Milan, Italy

Hall No. H2, Stall No. A202

## Do you know

### Interesting Facts on Fabrics

Here are some interesting facts about fabric that we think are cool and even useful

Flax is the earliest known natural textile fabric seen used in about 5000 BC. It is used to make linen which is seeing a huge come back today in drapery and upholstery. There is evidence that cotton and wool were used to create natural fabrics in about 3000 BC and evidence of silk use in 2500 BC in China



China is still the largest maker and exporter of silk in the world and has been for 100's of years. The earliest evidence of fabric textiles has been found in Turkey, Egypt and Israel

The creation of man-made fibers has only been within the last 100 years. Rayon was the first man-made fiber created in 1910 and it was called as Artificial silk. Viscose is the most common form of Rayon

Microfibre or Ultrasuede was invented over 20 years ago in Japan. Microfibre is the thinnest of all man-made fibres, even finer than silk. It is 100 times finer than a human hair

Acrylic is a man-made fibre that has a soft, wool-like hand, is machine washable and has excellent colour retention. It is often an additive to textiles to take advantage of these properties

Nylon is also man-made and was first produced in 1938. It has high strength, excellent resilience and superior abrasion resistance. Nylon replaced silk stockings for women in the early part of the 20th century

Bamboo is a grass that has been used to create a fabric that hangs much like a heavy linen. Interestingly, it has natural wicking ability that pulls moisture away from the skin, so it can be useful in reducing moisture related odour. It also has natural anti-bacterial qualities and it is sustainable as bamboo grows quickly and doesn't need pesticides to thrive

Source: [janelockhart.com](http://janelockhart.com)

## Market News

### Increasing Demand for Luxury Fashion

Humanity is full of contradictions. On the one hand there are many consumers who are focused on reducing the amount they pay for clothing, on the other there has been a dramatic increase in the demand for luxury fashion. In 2023, this change in demand will force fashion designers and producers to re-think their strategies

After facing two years of strict limits on international travel, some fashion designers have changed their focus to their home countries. Some innovators in the world of fashion have done this out of necessity. Others have done it out of a sense of national solidarity and pride. In both cases, it results in innovation and novel forms of luxury



In many cases, these novel forms of luxury feed into the circularisation of the global economy. Some luxury designers are turning to 3D printing and seaweed-based fabrics, while others are recycling cashmere from off-cuts

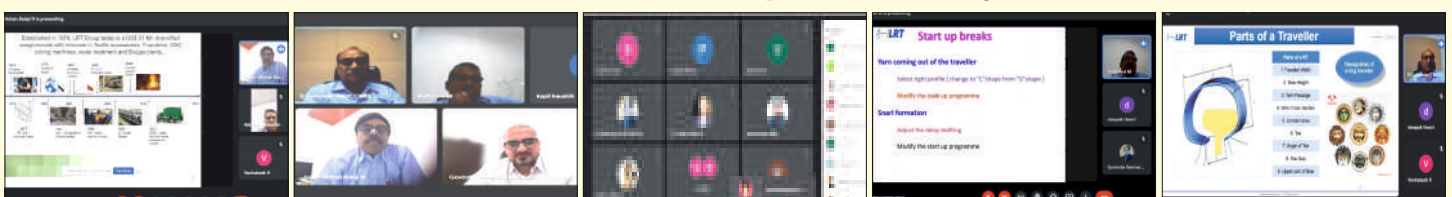
Advancements in technology have also allowed the popularisation of complex garments that were formerly the sole purview of the rich. Improvements in knitting machines, for example, have speeded up the production of knitwear that used to be knitted by humans

Between 2020 and 2022, the global focus shifted to local designers and creators. The disruption to global shipping brought people's attention to what they could acquire at home. With the dawn of the new year, these designers have started to utilise their newfound audience in hopes of growing their brands internationally

High-end textile and fashion providers are being forced to reformulate their strategies yet again as the world reopened its borders. As people begin to travel to fashion hubs such as Milan once again, these cities need to prepare for the influx of shoppers

Source: [fibre2fashion](http://fibre2fashion)

## LRT Virtual Seminar at Vardhman Group of Mills, Madhya Pradesh, India



## Replies from the Readers

### How to control end breaks in spinning related to ring Traveller?

**Mr.S.Srinivasan, Assistant Manager – Maintenance, Adwaith Textiles Private Limited, Coimbatore**

Selection of Traveller depends upon ring life, if rings life is more than 4 years, we should choose one number heavier than normal. RH% maintain in spinning perfectly 50 – 55%. Traveller clearer setting should be 1.4mm, 1.6mm and 1.8mm depend upon the Traveller profile. Select M - type Traveller clearer for better performance. Traveller speed should be as recommended by OEM. Traveller change should be done at 80% of cop stage. After Traveller change, machines should be run at 90% speed for one hour. If yarn CSP is lesser, lighter Travellers should be used

**Mr.G.K.Senthilkumar, Manager-Technical, Sri Balaganesan Spinners, Srivilliputtur, Tamilnadu**

Traveller life optimisation and clearer setting against count also decide the life of the Traveller and end breakage, very crucial attention to be given to Traveller loading. M-Type Traveller clearer gives extended life of another 2 to 3 days. New method of Traveller insertion tools also reduces the breakages, because no de-shape during insertion of the Traveller against conventional method. Reduction of 2% speed in first doff will improve the life of Traveller as well as end breakages for every new Traveller change. The habit of used Traveller insertion should be prohibited, because it leads end breakages. Used Travellers must be collected from floor by using magnet trolley

**Mr.M. Salaudeen, Quality Manager, Sumati Spintex Pvt Ltd, Vapi, Gujarat**

When spindle speed is increased, use lighter Traveller with low bow height. At higher speeds, lighter Traveller gives lesser yarn tension. When low bow height Traveller are used center of gravity will be closest to the ring, which aids in running of Traveller. The reduction in friction between ring and Traveller will reduce the peak tension during the rotation of the Traveller. Upgradation in the quality of Express plus Travellers by improving surface treatment as well as improvement metallurgical properties to meet the recent requirement of higher spindle speed as well as control end breaks

**Mr.Rm.Lakshmanan, Freelance Textile Consultant, Pudukkottai, Tamilnadu**

For any chosen ring Traveller, they have to settle down in the path way track of rings to perform well that demands a short duration, say 15 to 30 minutes of slower speed whenever they got replaced. In case of new rings, they have to undergo a perfect and precious running-in. In all the production positions, there should not be any ends down throughout the full doff. This is paramount not only for due life of rings, but also to minimise the quicker wearing of Travellers that could have a control over the end breaks besides facilitating quicker settling time in the race away of rings

**Mr.Krishnamoorthy.S, Vice President, Murugaraj.S, Factory Manager, Vaibhav Ginning and Spinning Mills Private Limited, Rajkot, Gujarat**

Every new count change, put three adjacent ring Traveller numbers on each 10 spindles, in which the Traveller gives stability balloon will be continued on all other ring frame. Traveller life time to be fixed on ring frame wise online breakage trend and daily basis. Hairiness index checking on same 10 spindles. This will support consistent breaks and quality. Also, life to be fixed on scientific method for all ring frame individually, i.e., like count spun, rings life, location of ring frame and should not fix same life time for all ring frames. Minimising too frequent or at least too coarser and finer count in a ring frame will leads Traveller and ring life and consistent breaks and quality

**Mr.R.Jayaramaraju, Deputy General Manager, Rajsamidhiyala Spintex Pvt Limited, Rajkot, Gujarat**

Traveller running-in procedure should be followed as per recommendations. Ring Traveller should be changed as per schedule. Ring frame department RH% should be maintained as per standard to avoid Traveller loading and fly generation. Overhead travelling blower should be in working conditions to avoid fluff accumulation on Traveller. Speed patterns should be with parabolic curve mode for gradually increasing spindle speed. Traveller speed and Traveller clearer setting should be maintained as per standard to reduce end breaks and Traveller loading

**Mr.Sudhakar Kodela, Vice President, Sri Venkata Siva Parvati Spinning Mills, Chebrolu, Andhra Pradesh**

Use cop bottom formation settings in ring frame by which  $\epsilon$  can be increased to reduce yarn tension. Till cop bottom formation, spindle speed should be at lesser speed to control the breakages. Use correct size of Traveller and profile for the given count and application. For warp counts with higher spindle speeds, use low bow height Travellers. For hosiery application, yarn diameter will increase due to less twist for the same count and hence medium bow height Travellers are to be used. For synthetics, Traveller clearance has to be increased further as the diameter of yarn will be more

**Mr.Purnawasi Prasad Gupta, Chief Manager – Production, Arihant Spinning Mills, Malerkotla, Punjab**

Selection of speed pattern is also very important for smooth working performance. Speed curve should be gradually in increasing mode. Rotary pneumatic drum to stationary fan conversion kit will be beneficial to avoid choking problem and improve working performance. Proper suction system modification increases in suction pressure and give lower lapping tendency. Bottom roller settings may wider back zone depending on the time, process and fibre length. Ring rail setting should be lower in coarser yarn and higher in finer yarn, i.e. 32mm for 15-20s, 35mm for 30s and 42mm for 40s. In low RKM dyed material, break draft should be reduced by one step for better performance. 5mm lappet hook is most suitable for compact spinning for better running performance

**Mr.D.Nageswara Rao, Manager - QAD, Iduppulapadu Cotton Mills Pvt Limited, Ganapavaram, Andhra Pradesh**

When the ring diameter is less, balloon diameter will be small, which leads to more yarn tension, hence use lighter Traveller. When the ring diameter is bigger, balloon diameter will be more, which leads to less yarn tension and the balloon touches the separator, hence use heavier Traveller. When the tube length is short, the yarn tension will be more, hence use lighter Traveller. When the tube length is long, the yarn tension will be less, hence use heavier Traveller. When the yarn contact area and ring contact area in Traveller is closer, fiber lubrication is better especially in cotton for this use heavier Traveller

**Mr.Angamuthu.V, General Manager, Kutti Spinners P Ltd, Tiruchengode, Tamilnadu**

A small ring Traveller is very important part of spinning mills, which may impact huge on yarn quality and productivity as well as in downstream process. If mass of Traveller is too low, the balloon becomes too large, the cop too soft and the amount of material taken up on the cop too small. If the mass is too high, high thread tension and frequent ends down take place. The mass of Traveller must be adjusted exactly to the yarn count, tenacity and the spindle speed. When spindle speed is increased use lighter Traveller with low bow height

**Mr.V.Kannan, Senior Manager-Technical, Viswateja Spinning Mills Pvt Limited, Boyapalem, Andhra Pradesh**

Most of cases, Traveller mix-up collapse studies and decision of Traveller selection. Because after completion of Traveller change, initial running of machine little bit chance of Traveller missing and fly-out is there, at the time sider mix-up other type of Traveller or old Traveller. Maintaining a consistent temperature in spinning area will help end breaks. Extreme temperature changes will cause the Traveller and the yarn to expand and contract, leading to increased stress and potential breakage

**Mr.Amzad Khan.P, AGM – Maintenance, GTN Engineering India Limited, Chitkul, Telangana**

The theory of ring and Traveller is the retardation of the Traveller relating to spindle and bobbing diameter increase. As per our count, TPI and spindle speed we should check and feel proper yarn tension and to choose suitable Traveller. Difference between minimum spindle speeds to maximum spindle speed limit should not be more than 25%. Between one step to another step spindle speed limit should be lesser than 1000 RPM. We should not allow too high/low yarn balloon formation to control end breaks in spinning

We have edited replies received to fit the page available

The greater the difficulty, the more the glory in surmounting it

## Know your Product

### U1 ML UDR Profile Travellers

When spinners increased the speed in medium counts, mills had used low clearance Travellers to withstand the higher speed without Traveller fly. But, when the yarn clearance is too less, which reflected in the yarn quality. To overcome this issue, LRT had introduced its **U1 ML UDR Profile Travellers** in the year 2004 and fine tuned it time to time to accommodate the changes in spinning with optimum yarn passage to spin medium counts at higher speed



Recently, LRT has started supplying this **U1 ML UDR Profile Travellers** with improvement in this by incorporating tribological properties to withstand still higher speed with more life without effecting the yarn quality. Available from 1/0 to 13/0 and 1 to 4 in Sapphire Plus, Hitech, Ruby and Express Plus finishes. The following are the benefits of this modified profile

- **Increased life due to improved wear resistance capacity**
- **Smoother running due to reduction in surface friction**
- **Improvement in yarn quality due to change in the design**
- **Suitable for all type of materials**

## Congratulations

We are happy to announce privilege cards from Reliance Trends to the following winners for their best reply

### Mr.S.Srinivasan

Assistant Manager – Maintenance  
Adwaith Textiles Private Limited  
Coimbatore, Tamilnadu

### Mr.M.Salaudeen

Quality Manager  
Sumati Spintex Private Limited  
Vapi, Gujarat

### Mr.G.K.Senthilkumar

Manager – Technical  
Sri Balaganesan Spinners  
Srivilliputtur, Tamilnadu

## Win Exciting Prizes

Explain the effect of Spindle speed and TPI on the yarn quality? Kindly send your reply with case studies

## Technocrat of the Issue



**Mr.Sudip Nandy** is a well-known Technologist in the Indian Textile Industry for the past three decades and is presently working as Chief Technical Officer in DCM Textiles, a unit of DCM Nouvelle Limited Hisar, Haryana, India. DCM Textiles is a leading manufacturer and exporter of 100% Cotton Karded, Combed, Compact yarn, Slub and CCY yarn has a spindleage of 1,58,824 with 3350 MT of monthly production. Over a long period of history, DCM has built its corporate philosophy synonymous with dynamism and business integrity

After passing his B Tech – Textile Technology from Government College of Engineering and Textile Technology, Berhampur, West Bengal in the year 1993, he started his career at Arihant Spinning Mills, a unit of Vardhman Textiles, Malerkotla, Punjab as a Textile Graduate Trainee and had been gradually elevated to Chief Manager

In the year 2008, he joined at DCM Textiles as General Manager – Production and at present working as Chief Technical Officer. Here, he has involved in the successful modernisation of Unit 1 and expansion of projects in 2014 with 39168 spindles and another in 2022 with 43776 spindles

In tune with organisation’s philosophy of continuous improvement, he has continuously evolved and improved through learning and received various certifications in Quality, Management and Leadership development programmes, TQM and Green Belt in Six Sigma. Further, he had passed his MBA – Finance in 2019 from Guru Jambheshwar University of Technology and Sciences, Hisar. Also, he is a Certified Auditor in ISO 9001:2008 Systems

At present he is highly focusing on quality excellence through promotion of brands and exporting their products in many countries include Portugal, Egypt, South Korea, Brazil, Hong Kong, China, Bangladesh, Italy, USA and Peru

Mr.Sudip Nandy says, **“Our focus is always in building a good team with high capability and resilience. Our Honourable Managing Director Shri Hemant Bharat Ram Ji’s thought of data driven management, PDCA approach and innovative solution to the problems has always motivated us to learn and improve continuously”**. We wish Mr. Sudip Nandy for his further growth and services to the industry

For further details please contact :

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