



Recommendations to Restart Spinning Mill Machinery

How to Restart Your Spinning Mill Activities?

Tips and Hints

After a prolonged period of reduced business activity, certain measures are necessary in order to restart spinning machinery in a sustainable manner. Based on their experience, Rieter experts have collected a few tips and hints to facilitate the process of restarting the machines and get mill activities smoothly back on track.

Important

Material that is in the process for several days must be used up completely. The material contains more moisture and would create quality variation if it would become mixed. Consequently, the yarn produced from this material should be sold separately.

Safety

1. Clean and disinfect the work area.
2. Provide your employees with masks and hand sanitizers.
3. Clean frequently touched surfaces on a regular basis.
4. Inform all employees about COVID-19 measures to prevent infections.
5. Obey the work safety instructions.
6. Let only authorized technicians and electricians do the respective work.

Electricity

1. Before main switch becomes set to the position ON, the power at the plant must be restored. Wait for a stable power supply. Make sure that the voltage is in the permissible range.
2. Make sure that no wires and no electronic modules became damaged during the standstill of the machine.
3. Make sure that the main switch is set to the position ON or OFF before connecting the power supply to the machine. When the voltage is stable, start the machines to minimize failures of the electronic components.
4. Check the permissible voltage range before starting up machines one after the other.
5. Monitor the capacitor bank in the power house to detect any variable demand during the shutdown and the start-up of the machines, especially the input voltage range.

Humidity

1. Start the air-conditioning plant two hours before the production starts.
2. Maintain the recommended humidity and temperature levels for a smooth running of the machines.

Machine

Recommendations

UNIcontrol

1. If the UNIcontrol is still on and there is no error message on the UNIcontrol display, the machine is ready to start.
2. If the UNIcontrol was off, check the 230-V supply to the UNIcontrol and switch on the machine. If the machine reboots as usual and no error is shown on its display, the machine is ready to start.
3. Check the machine settings and parameters.
4. Once the blowroom check is completed, start the UNIcontrol without material and let it operate for 30 minutes.

UNIfloc

1. If the UNIfloc is still on and there is no error message, the UNIfloc is ready to start.
2. Make sure that all safety doors are properly closed and switch on the machine. If a fault occurs after the rebooting, do the remedy of the fault.
3. If any electrical work was done during the lockdown, check the direction of rotation of the motor.
4. Start a new scanning procedure of the bales while starting the UNIfloc. Obey the blowroom recommendations before putting the UNIfloc into production. before putting UNIfloc in production

Blowroom Fans

1. Tension all drive belts.
2. If any electrical work was done during the lockdown, check the direction of rotation of the fans.

Blowroom

1. Tension all drive belts.
2. Check the chain tension and correct the chain tension if necessary.
3. Switch the blowroom machines on and check the technological parameters.
4. Make sure that the spark detection system and the metal detection system work correctly.
5. If any electrical work was done during the lockdown, check the direction of rotation of the motor.
6. Check the filter as per the manufacturer's recommendation and start the blowroom exhaust and waste collection system for 30 minutes prior to starting up the blowroom.

Too much waste? Raw material saving is a key focus of Rieter Performance Optimization Services, leading to extra revenues.



Machine

Recommendations

Draw Frame SB/RSB

1. Tension all drive belts.
2. Check the chain tension and correct the chain tension if necessary.
3. Switch the machine on and check the technological parameters.
4. If any electrical work was done during the lockdown, check the direction of rotation of the motor.
5. Clean the complete machine and check the running behavior of the machine without sliver.
6. Start the machine with material and check the sliver weight after the start-up.
7. Check U% and 1 m CV after one hour of smooth operation. In case of quality deviations, adjust the leveling action point (LAP) and the leveling intensity (LI) and perform the cot grinding.
8. Make sure that all quality monitors are switched on.
9. Make sure that the sliver test is done correctly.

UNIlap/ OMEGAlap

1. Tension all drive belts.
2. Switch the machine on and check the technological parameters.
3. If any electrical work was done during the lockdown, check the direction of rotation of the motor.
4. Perform one manual doffing at both machines.
5. Do the belt centering on the OMEGAlap.
6. Check the lap buildup.

Comber

1. Tension all drive belts.
2. Switch the machine on and check the technological parameters.
3. If any electrical work was done during the lockdown, check the direction of rotation of the motor.
4. Turn the machine pulley manually and make sure that the parts move freely.
5. Remove the web when the top comb is not installed. Then, install the top comb.
6. Run the machine and check for unwanted noises.
7. Check the sliver weight and the noils.
8. Check AFIS when new laps put onto machine.

Order genuine spare parts via ESSENTIALorder, Rieter webshop. Register to ESSENTIAL and manage spare parts with one click.



Machine

Recommendations

Air-Jet Spinning

9. Check the centering of the opening roller belt and the rotor drive belt.
10. In fully automatic machines, allow the robot to move freely for two to three rounds without piecing.
11. Check the yarn count.
12. Remove old packages that are on the machine and start with a new lot to ensure a better quality from the first layer.
13. Adjust the tension draft accordingly.
14. Check the piecing and adjust the piecing procedure if necessary.
15. Weigh the package and examine the yarn quality.

1. Tension all drive belts.
2. Check the technological parameters on the operating unit.
3. If any electrical work was done during the lockdown, check the direction of rotation of the motor.
4. Remove two to three layers of the sliver from the top of the can.
5. Drain the compressed air and check the air quality prior to setting the main switch to the position ON.
6. Install the top roller cots.
7. Remove old packages that are on the machine and start with a new lot to ensure a better quality from the first layer.
8. Allow the robot to move freely for two to three rounds without piecing.

ISM/ SPIDERweb

1. After all machines are started up in the spinning mill, start ISM/SPIDERweb.
2. In case of missing communication, check the IP address.

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SERVOLap

1. Clean the complete drive rail.
2. Clean the carbon brush and switch the machine on.
3. Check the bridge unit movement when the machine is in the service mode.
4. Check the machine configuration on the operating unit.
5. Keep the conveyor belt empty.

