

Yield Performance ver 2.0

by ITRU GROUP Ltd.

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Table of Contents

1.Introduction.....	3
1.1 Data Input and Save Dbf.....	6
2.1 Filtering Records.....	7
3-Production Control.....	8
4-Waste Analyses.....	8
5- Reports.....	8
6- Charts	9
7- Saving to Spread Sheet to Excel File.....	10
8 Reducing Waste and Increasing Production.....	11

1.Introduction

Production control in spinning mills is very significant if one takes amount of waste at each stage of processing.

Waste in spinning mill is classified according to end use . Waste categorization is defined as follows which also includes the input of the software.

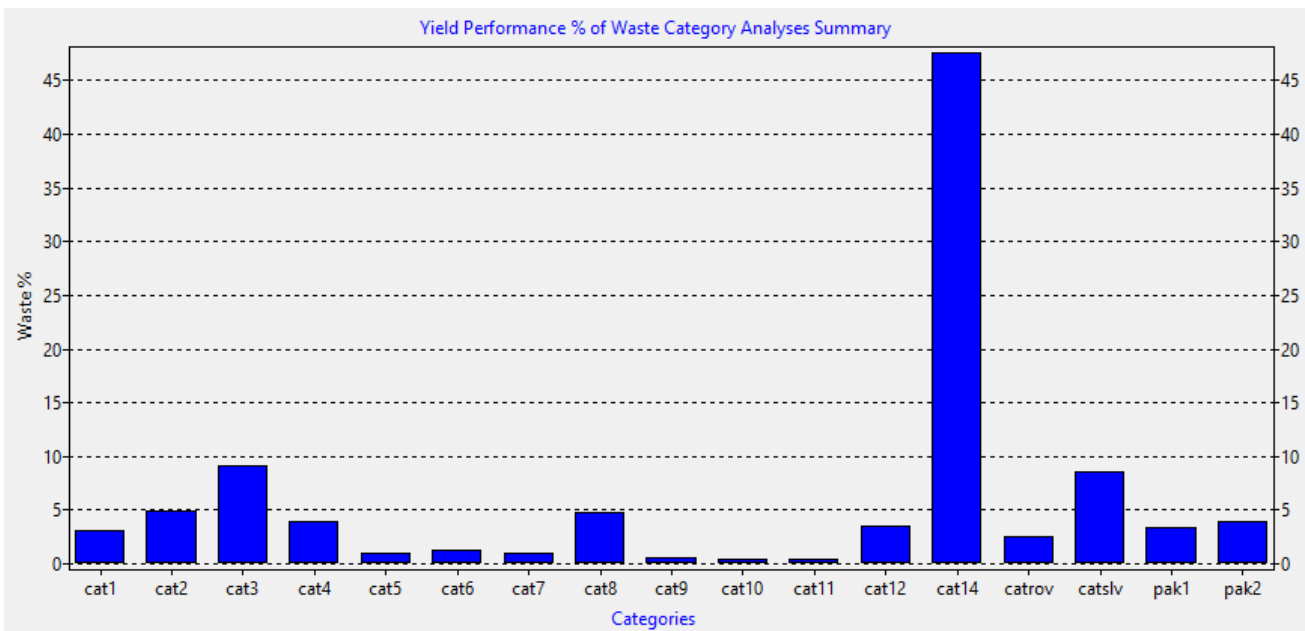
The program input of waste of Ring Yarn Production

Single Report

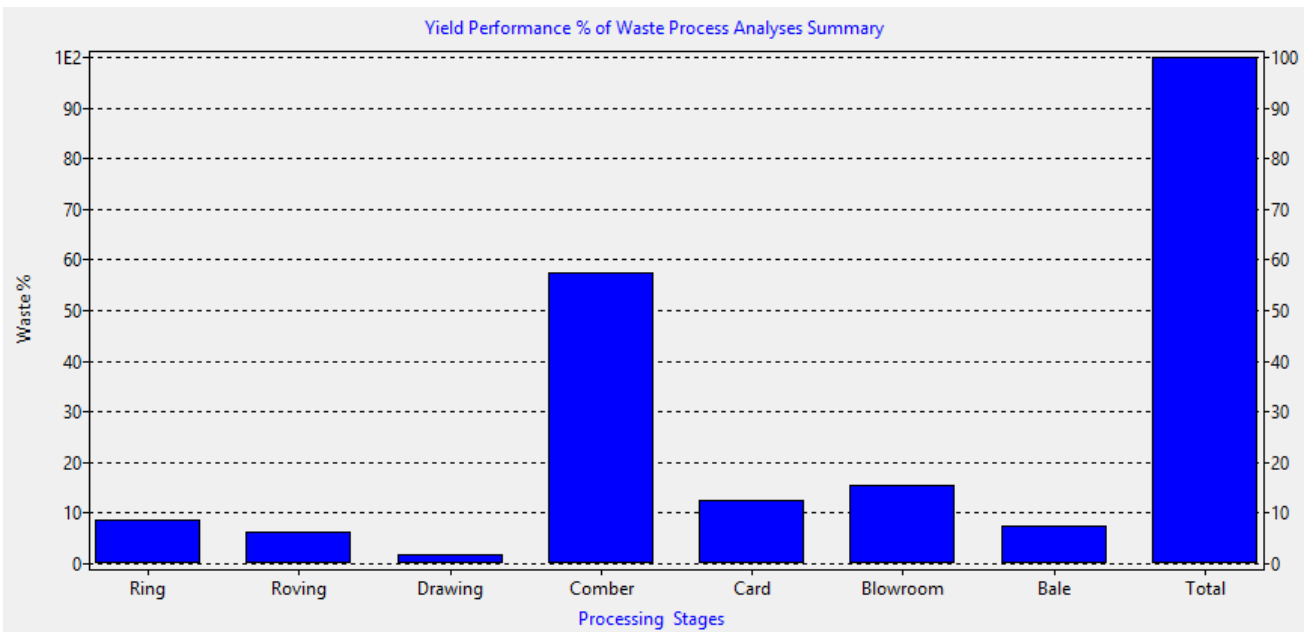
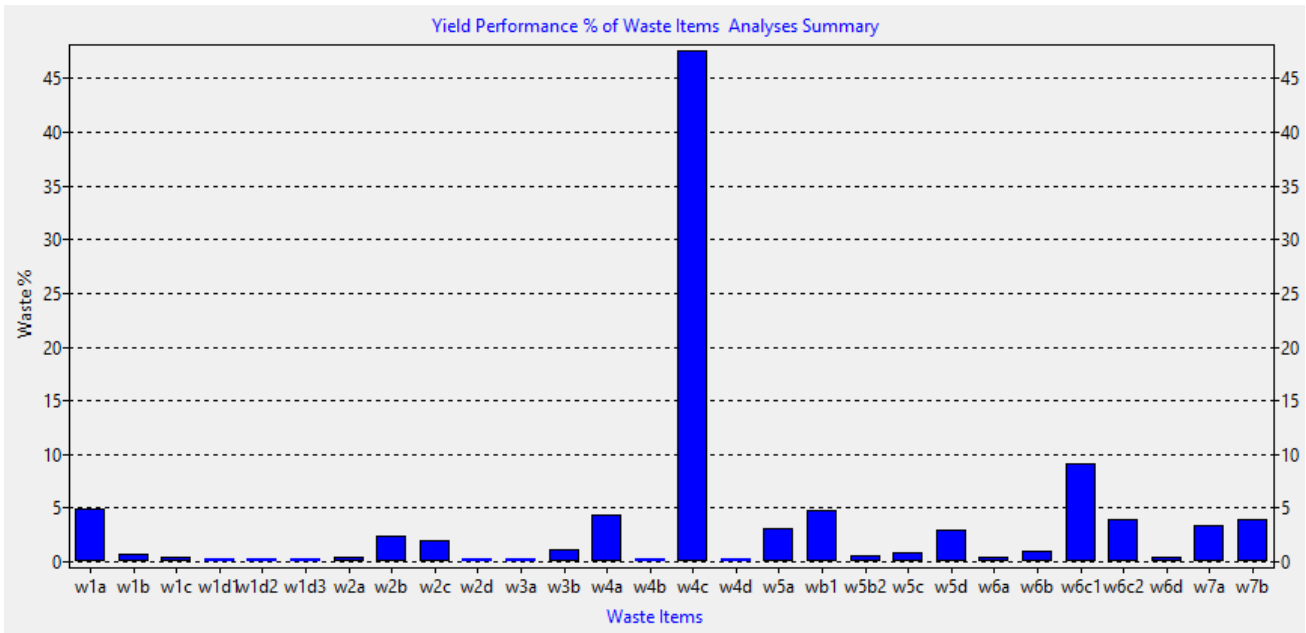
Blend No.....=:	1	
LotNo.....=:		A-1:
Machine Type.....=:		COT:
Date	11.11.2001:	
RING Yarn Production KG/day.....P1.=:	1250,00:	
RINGPNOMOFILCAT-2.....W1A.=:	19,00:	1,49
RINGRoving SliverCAT-Roving.... W1B =:	6,00:	0,47
RINGThread remnants.....CAT-10.....W1C=:	0,50:	0,04
RINGFloor sweepings dirty.CAT-7.....W1D1=:	0,40:	0,03
RINGFloor sweepings clean.CAT-6.....W1D2=:	0,80:	0,06
RINGUnder frame dirty . CAT-7.....W1D3=:	0,50:	0,04
ROVING....PNOMOFIL.....CAT-11.....W2A =:	1,00:	0,08
ROVING....Feed sliver..... CAT-sliver....W2B =:	15,00:	1,15
ROVING....ROVING sliver..... CAT-ROVING....W2C =:	12,00:	0,92
ROVING....Floor.....CAT-6.....W2D =:	0,80:	0,06
Drawframe.PNOMOFIL.....CAT-12.....W3A =:	1,50:	0,11
Drawframe.Sliver.....CAT-Sliver....W3B =:	8,00:	0,61
Comber....Sliver+LapCAT-Sliver....W4A =:	29,00:	1,85
Comber....PNOMOFIL.....CAT-12.....W4B =:	0,60:	0,04
Comber....NoilCAT-14.....W4C =:	224,00:	14,27
Comber....FloorCAT-6.....W4D =:	0,80:	0,05
Card.....-Flate strips.....CAT-1.....W5A =:	17,00:	1,04
Card.....Taker-in Clean.....CAT-8.....W5B1=:	26,00:	1,59
Card.....-Taker-in dirty.....CAT-9.....W5B2=:	2,00:	0,12
Card.....-Sliver+Web.....CAT-Sliver....W5C =:	4,00:	0,24
Card.....-PNOMOFIL.....CAT-12.....W5D =:	18,00:	1,10
Blorroom Dirty fibre.....CAT-7.....W6A =:	2,00:	0,12
Blowroom Filtered dusts.....CAT-5.....W6B =:	6,50:	0,37
Blowroom Waste -Clean.....CAT-3.....W6C1=:	54,00:	3,11
Blowroom Waste-Dirty.....CAT-4.....W6C2=:	32,00:	3,11
Blowroom Floor.....CAT-6.....W6D =:	3,00:	0,17
Blowroom SucksPAK-1W7A =:	23,00:	1,29
Blowroom Steel.....PAK-2.....W7B =:	24,00:	1,35

```

=CATEGORY ANALYSES =====
Card.....-Flate strips.....CAT-1.....W5A.... =: 17,00
RING .....PNOMOFIL .....CAT-2      W1A     =: 19,00
Blowroom Waste -Clean.....CAT-3.....W6C1... =: 54,00
Blowroom Waste-Dirty.....CAT-4.....W6C2... =: 32,00
Blowroom Filtered dusts.....CAT-5.....W6B.... =: 6,50
W1D2+W2D+W4D+W6D          .....CAT-6.....=: 5,40
W1D1+W1D3+W6A.....CAT-7.....=: 2,90
Card.....-Sliver+Web.....CAT-8.....W5B1... =: 26,00
Card.....-Taker-in dirty.....CAT-9.....W5B2.... =: 2,00
.....CAT-10.....W1C.... =: 0,50
.....CAT-11.....W2A.... =: 1,00
W3A+W4B+W5D.....CAT-12.....=: 20,10
.....CAT-14.....W4C.....=: 224,00
W1B+W2C .....CAT-Roving..... =: 18,00
W2B+W3B+W4A+W5C ;.....CAT-Sliver..... =: 56,00
.....PAK1..... =: 23,00
W2B+W3B+W4A+W5C ;.....PAK2..... =: 24,00
    
```

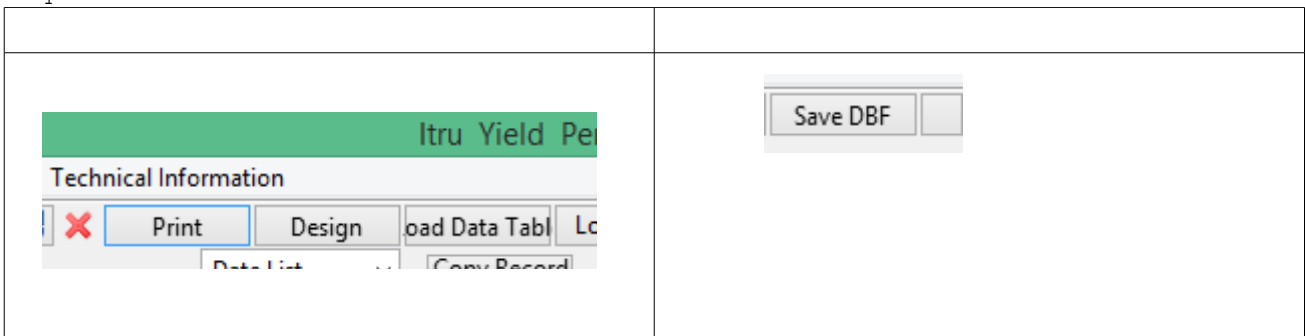


With this category chart it is possible to take remedial actions to minimize the waste .



1.1 Data Input and Save Dbf

Click on < Load Data Table > and Load DBF file for data insert .
And enter the information .
Records are saved in that table named. If you make use of Yield.dbf data base you get performance data. Performance Data is calculated data base of Yield.dbf . If you want to save yield.dbf you can save you make use of save dbf button. Therefore , you can make use of many databases as you require.



you have to make use of load data table to insert new records to the data base.

2.1 Filtering Records

Write Filtering expression in the box as shown

`DTOS(Workingdate)="20171211"` filters the date = 11.112017

`DTOS(Workingdate)>="20171111"` filters record `>=11.11.2017`

the press Apply button

`DTOS(Workingdate)>="20171110" AND DTOS(Workingdate)<="20171112"`

filters record between dates 10.11.2017 and 10.12.2017

You can filter records

`Blendno =12` filters the record Blend No=12

`lotno="A-12"` filters the record `Lotno="A-12"` and you can add logical function "and" "or" other parameters to get more filtering . When you filter the records. Yield Performance runs on this filtered data.

Clear button clears the filtered data.

3-Production Control

```

=====
YIELD PERFORMANCE ANALYSES =====
Roving Production .....P2.....=: 1277,20
Drawing production .....P3.....=: 1306,00
Roving Production .....P2.....=: 1277,20:
Drawing production .....P3.....=: 1306,00:
Comber Production.....P4.....=: 1315,50:
Card Production.....P5.....=: 1569,90:
Blowroom Production .....P6.....=: 1636,90:
Blend Required.....P7.....=: 1734,40:
Bale Required.....P8.....=: 1781,40:
=====

```

4-Waste Analyses

This gives the percentages of waste and their kg for each processing.

```

=====WASTE % ANALYSES=====
Ring Frame Total Waste %.....WP1T.....=: 2,13: 27,20
Roving Frame Total Waste %.....WP2T.....=: 2,21: 28,80
Drawing.....WP3T.....=: 0,72: 9,50
Combing Total Waste.....WP4T.....=: 16,20: 254,40
Card.....WP5T.....=: 4,09: 67,00
Blowroom.....WP6T.....=: 5,62: 97,50
Blend.....WP7T.....=: 2,64: 47,00
Total Waste.....WPT.....=: 29,83: 531,40

```

5- Reports

There are several reports in the list that works according to Filtered data.

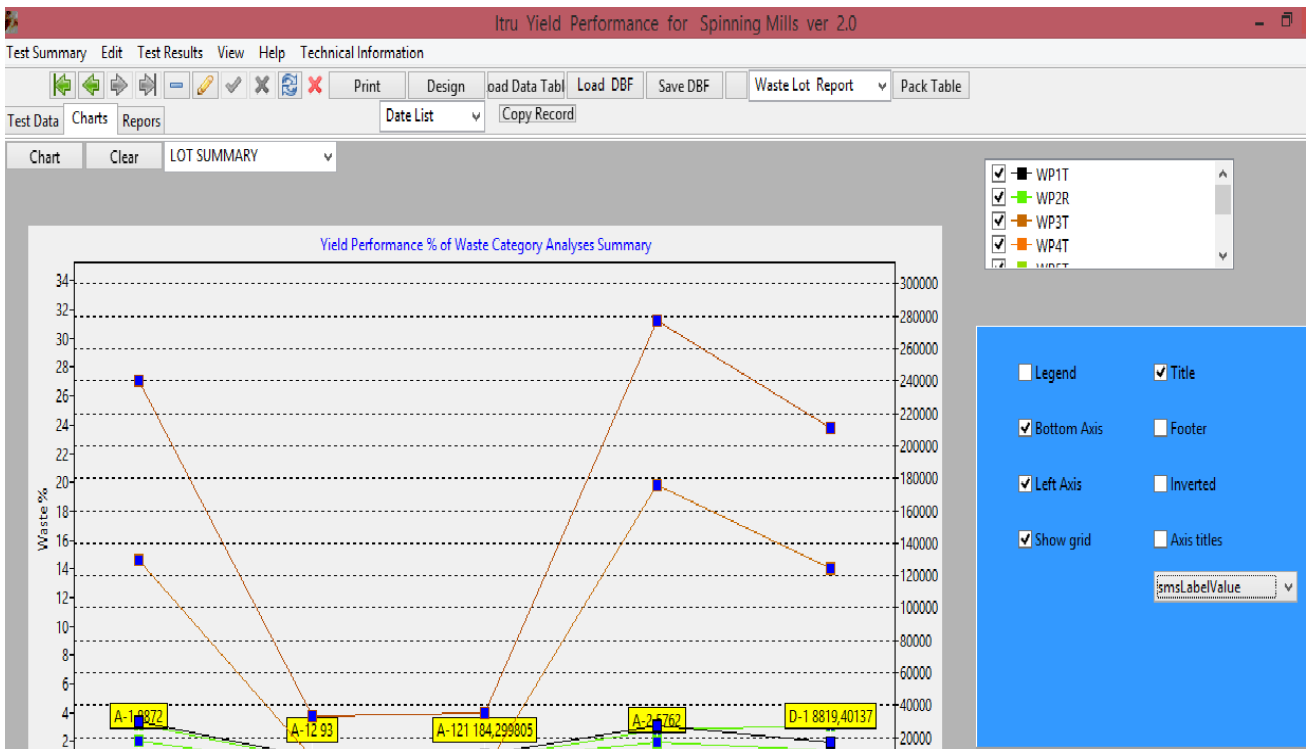
Charts can be copied to editor of program and can be saved as rich text format .You use right click on mouse to copy chart go to editor report page and ctrl +V or right click on the editor window and use paste and charts will be inserted and right click on the editor window and click on write to save the file as rtf extension.

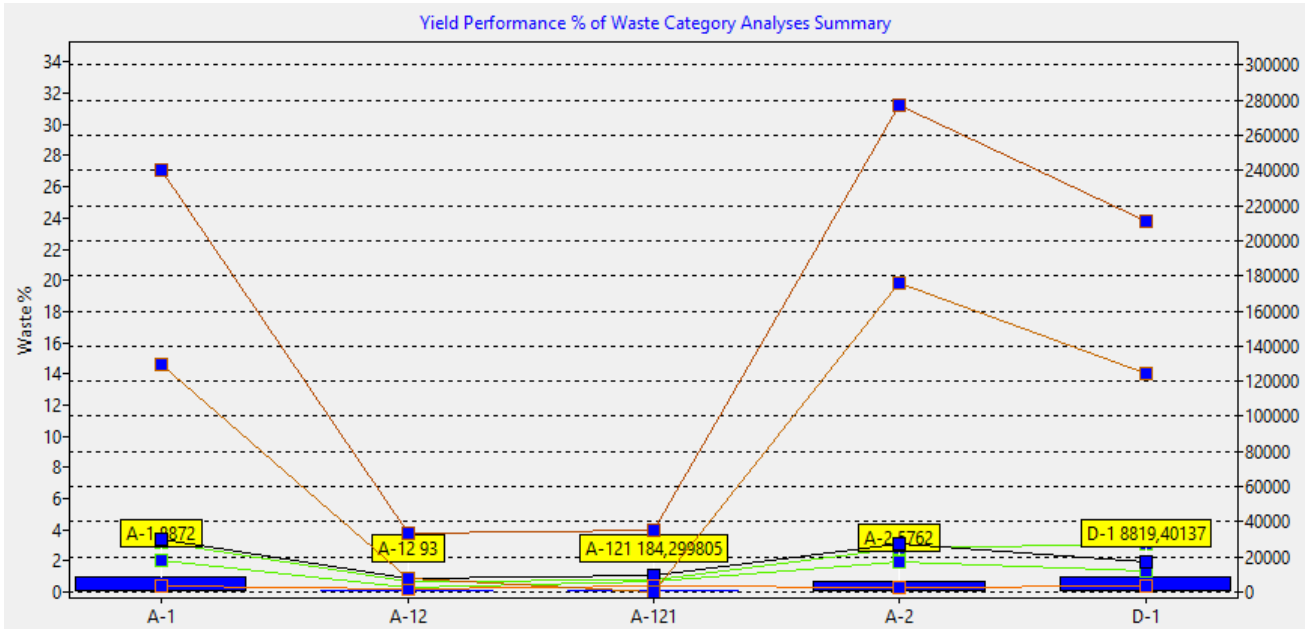
Waste Analyses												
Blend No	LotNo	Machine	Date	WP1T	WP2T	WP3T	WP4T	WP5T	WP6T	WP7T	WPT	Waste Total
1	A-2	COT	10.11.2017	2.13	2.21	.72	16.2	4.09	5.62	2.64	29.83	531.40
2	A-121	PV	10.11.2017	1.04	.7	.35		.76	.86	.3	3.93	184.30
3	A-12	POLY	10.11.2017	.91	.33	.16	.86	.69	.6	.24	3.73	93.00
4	D-1	M-1	10.11.2017	2.18	1.54	.51	11.93	3.05	4.24	2	23.22	544.40
5	D-1	M-1	11.11.2017	1.63	1.5	.48	15.86	3.46	3.84	1.77	26.01	675.70

6- Charts

There are charts for filtered or non filtered data. Rightclick on the chart to copy print etc.

Select item from the box and click chart button to see the charts.





7- Saving to Spread Sheet to Excel File

Load DataBase Export Button loads the Yield Performace data to Work sheet and you Use test summary click menu and Saveas and save this to openoffice or excel file.

You can add worksheets to spreadsheet and filtered records will be loaded to selected work sheet and save this spreadsheet to excel file.

BLENDNO	LOTNO	MACHINETYPE	WORKINGDATE	P1	W1A	W1B	W1C	W1D1	W1D2	W1D3	W2A	W2B
38	A-2	A2	12.11.2017	1400	35	4	4	3	2	2	2	2
39	A-2	A2	12.11.2017	1400	35	4	4	3	2	2	2	2
39	A-2	A2	12.11.2017	1400	35	4	4	3	2	2	2	2

	A	B	C	D	E	F	G	H	I
1		Cat1	Cat2	Cat3	Cat4	Cat5	Cat6	Cat7	Cat8
2	Ave	20,27	31,73	47,17	22,2	4,34	9,55	7,31	
3	Total	831	1301	1934	910	178	391,4	299,7	
4	%	0,8	1,25	1,86	0,88	0,17	0,38	0,29	
5	Cat/Waste%	3,5	5,48	8,15	3,83	0,75	1,65	1,26	
6	Yam kg	80160							
7	Req.Blend kg	103890,7							
8	Waste %	22,84							

8 Reducing Waste and Increasing Production

Ring Frame Waste :

It is better to make use of Itru Ring Spinning Performance to test pc-program to reduce end break rate and minimise waste.

Comber Waste : Comber Data Pc-PROGRAM itru.net/comber.htm

Card Waste : Card Fibre Transfer Test

Blowroom and card Waste : Itru UAK-S2 Non-Lint Analyser System