

# Supertex

cots & aprons



product catalog

*Spin Superior with Super Tex*

X





enter

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### *Detailed Super Tex Products*

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### *Specialised Super Tex Products*

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### *Contact Us*



### Plain Cots

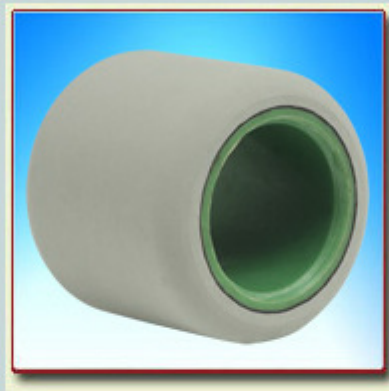
The features of various Super Tex cots are best explained by explaining the comparative features of the cots



#### COMPARATIVE FEATURES

Description	Single compound Cot
Interference fit ( BRD - ID )	Minimum 1.5 mm (Depending on Shore Hardness of Cots )
Stress on the cots	High
Mounting Cycle	24 hours (Adhesive Required)
Use of Cone for mounting	Yes
Cot slippage	Possible if mounting not done carefully
Bursting	Likely to burst if knife used to remove laps.

PVC Core Cots



**COMPARATIVE FEATURES**

Description	A Cot with PVC Core
Interference fit ( BRD - ID )	0.3 mm
Stress on the cots	Almost NIL
Mounting Cycle	10 minutes (Adhesive not required)
Use of Cone for mounting	No
Cot slippage	Almost NIL
Bursting	Less likely to burst compared to Plain

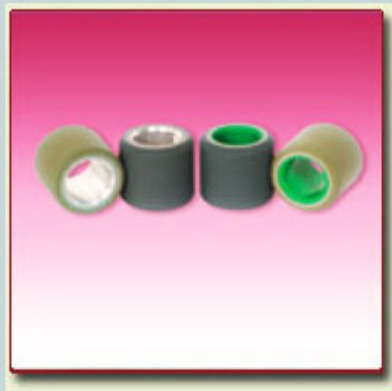
### Alugrip Cots



#### COMPARATIVE FEATURES

<b>Description</b>	A cot with an Aluminium Core
<b>Interference fit ( BRD - ID )</b>	0.12 mm
<b>Stress on the cots</b>	Almost Nil
<b>Mounting Cycle</b>	10 minutes (Adhesive not required)
<b>Use of Cone for mounting</b>	No
<b>Cot slippage</b>	Nil
<b>Bursting</b>	Almost Nil

## Multiply Cots



### COMPARATIVE FEATURES

<b>Description</b>	A cot with an Aluminium Core or SSD Core
<b>Interference fit ( BRD - ID )</b>	0.12 mm ( for Aluminium ) or 0.5mm ( for SSD )
<b>Stress on the cots</b>	Almost Nil
<b>Mounting Cycle</b>	10 minutes (Adhesive not required)
<b>Use of Cone for mounting</b>	No
<b>Cot slippage</b>	Nil
<b>Bursting</b>	Almost Nil



## COTTON & IT'S BLENDS

### COTS

DRAW FRAME	COMBER DRAW BOX	SPEED FRAME (Front & Back Roller)	RING FRAME (Front Roller) (100% Cotton)	RING FRAME (Front Roller) (Cotton Blends)
<p>Alugrip</p>  <p>Quality: SGY-83 Hardness: 83°</p>	<p>Alugrip</p>  <p>Quality: SGY-83 Hardness: 83°</p>	<p>Alugrip</p>  <p>Quality: STN-75 Hardness: 75°</p>	<p>Alugrip</p>  <p>Quality: SR-66 Hardness: 66°</p>	<p>Alugrip</p>  <p>Quality: COM-68 Hardness: 68°</p>
<p>Spring Grip</p>  <p>Quality: SGY-83 Hardness: 83°</p>	<p><b>COMBER DETACHING ROLLER</b> Alugrip</p>  <p>Quality: SGN-65 Hardness: 65°</p>	<p>PVC</p>  <p>Quality: SRD-80 Hardness: 80°</p>	<p>PVC</p>  <p>Quality: SGN-65 Hardness: 65°</p>	<p>PVC</p>  <p>Quality: SLG-70 Hardness: 70°</p>
<p>Clearer Tube</p>  <p>Quality: SCT-70</p>	<p>STK - Double Layer</p>  <p>Quality: STK-65 Hardness: 65°</p>	<p>Alugrip</p>  <p>Quality: SGY-83 Hardness: 83°</p>	<p>Alugrip-Multiply</p>  <p>Quality: SR-66 Hardness: 66°</p>	<p>PVC</p>  <p>Quality: SLD-72 Hardness: 72°</p>

• All speed frame & Ring frame cots are available in Alugrip & PVC execution  
 • For Ring frame back Roller we recommend 83° Shore cots

cont

### APRONS

#### TOP APRON



Quality: SHKE-40

#### BOTTOM APRON



Quality: SHKE

#### BOTTOM APRON



Quality: BKB-2060

#### TOP APRON (Short Cradle)



Quality: JSHK-T  
(Premium)

#### OPEN APRON (Normal & Pre-glued)



Quality: SHKE



Quality: LGG-4080



Quality: LGB-4060

#### BOTTOM APRON (Short Cradle)



Quality: NSHK  
(Premium)

#### BOTTOM APRON (Short Cradle)



Quality: JSHK  
(Premium)



Quality: LGB-4060

- SHKE-40/SHKE Aprons are normally recommended for 100% Cotton & LGG / LGB aprons for Cotton blends.
- JSHK-T/JSHK Aprons are normally recommended for Short Cradle 100% Cotton & LGG / NSHK aprons for Cotton blends.



## SYNTHETIC & BLENDS

### COTS

#### DRAW FRAME

Alugrip



Quality: SGY-83  
Hardness: 83°

Spring Grip



Quality: SGY-83  
Hardness: 83°

Clearer Tube



Quality: SCT-70

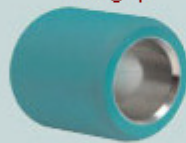
#### SPEED FRAME (Front & Back Roller)

Alugrip



Quality: SGY-83  
Hardness: 83°

Alugrip



Quality: STB-85  
Hardness: 85°

PVC



Quality: SYL-90  
Hardness: 90°

#### RING FRAME (Front & Back Roller)

Alugrip



Quality: STN-75  
Hardness: 75°

Alugrip



Quality: SRD-80  
Hardness: 80°

Alugrip



Quality: SRD-83  
Hardness: 83°

#### RING FRAME (Front & Back Roller)

Alugrip



Quality: STB-85  
Hardness: 85°

PVC



Quality: SYL-90  
Hardness: 90°

· All speed frame & Ring frame cots are available in Alugrip & PVC execution

cont

### APRONS

#### TOP APRON



Quality: LGG-4080

#### BOTTOM APRON



Quality: LGB-4060

#### BOTTOM APRON



Quality: BKB-2060

#### TOP APRON (Short Cradle)

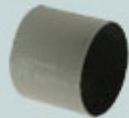


Quality: LGG-4080

#### BOTTOM APRON (Normal & Pre-glued)



Quality: BKG



Quality: SBT



Quality: SBB



Quality: SYS

#### BOTTOM APRON (Short Cradle)



Quality: NSHK  
(Premium)



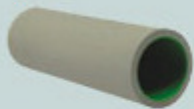
Quality: LGB-4060

## WOOL, ACRYLIC & BLENDS

### COTS

#### GILL BOX

SSD  
(Special Inner Core)



Quality: SGY-83  
Hardness: 83°

#### ROVING & RUBBING FRAME Plain



Quality: Ballon Cot  
Awl Thickness: 1.7-2.5

#### RING FRAME

Alugrip



Quality: SGY-83  
Hardness: 83°

#### RING FRAME

PVC



Quality: STB-85  
Hardness: 85°

#### RING FRAME

Alugrip



Quality: SYL-90  
Hardness: 90°

• All above ring frame cots are suitable for Front & Back Roller.  
• All Ring frame cots are available in Alugrip & PVC execution

### APRONS

#### RUBBING FRAME

Draft Aprons



Quality:  
LGB-4060-Corded/  
LB-400-Cordless

#### RUBBING FRAME

Grooved Aprons



Quality: SRA-10  
(Double Layer)

#### RING FRAME TOP APRONS



Quality: LGG-4080



Quality: SBT

#### RING FRAME BOTTOM APRONS



Quality: LGB-4060



Quality: BHK

#### RING FRAME BOTTOM APRONS



Quality: SAH



Quality: LGB-4060

cont

**SPECIAL PURPOSE COTS & APRONS**

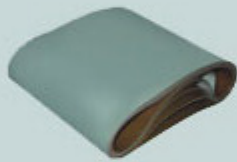
**WET LINEN  
SPINNING**

Spring Grip



Quality: SVN-83  
Hardness: 83°

**WET LINEN  
SPINNING**



Quality: VHK

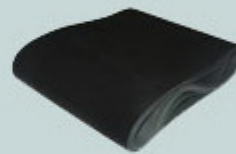
**JUTE SPINNING**

Plain (Knurled Inside)



Quality: SYL-90  
Hardness: 90°

**JUTE SPINNING**



Quality: BKG-2080

**GLASS FIBER  
SPINNING**



Quality: SGF-400



## TECHNOLOGICAL ITEMS

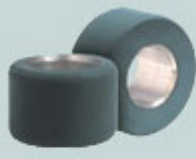
### COMPACT SPINNING

#### RIETER COM - 4



Front Line:  
SR-66/COM-68  
Nip Roller: COM-68  
Back Roller:  
SGY-83/SRD-83

#### SUESSEN ELITE



Front Line:  
SR-66/COM-68  
Nip Roller:  
SR-66/COM-68  
Back Roller:  
SGY-83/SRD-83

#### ROCOS



Front Line:  
SR-66/COM-68  
Nip Roller:  
SR-66/COM-68  
Back Roller:  
SGY-83/SRD-83

#### TOP APRON



Quality: SHKE-40

#### BOTTOM APRON



Quality: SHKE

Bottom Aprons available  
in inside Plain as well  
as Knurled execution

### AIRJET SPINNING

#### AIRJET



Quality: STN-75/SGY-83

STN-75 is recommended  
for Polyester / Cotton  
blends & SGY-83 for  
100% Polyester

- Special packing provided for Airjet Cots & Aprons
- Airjet Aprons also available in Plain execution on request.
- More details on Pg no. 17

#### AIRJET APRONS



Quality: SMP-T/SMP-B  
(Knurled)  
SMP Aprons are  
recommended for MJS  
& MTS to process  
100% Polyester

#### AIRJET APRONS



Quality: SPP-T/SPP-B  
(Knurled)  
SPP Aprons are  
recommended for high  
speed MVS to process  
P/C, PV, Viscose

### OPEN END

#### TAKE UP ROLLER COTS



Quality: STN-75/SGY-83

Suitable for Rieter,  
Schlafhorst Autocoro,  
Elitex, etc.

### TFO

#### CORDLESS APRONS



Quality: VG-400  
(Plain Knurled)

Suitable for  
Veejay Lakshmi,  
Volkman, Elitex, etc.



## SUPER TEX MULTIPLY COTS \*Patented

It is the search for innovations that motivate us and the desire to reassess our products, to develop better solutions for the Spinning Industry. Supertex is pleased to serve the Textile Spinning Industry with in house Developed & Researched Double Layer Multiply\* Cots. Supertex offers this cot in Alugrip as well as PVC execution



A special soft rubber layer between the Aluminum / PVC core and outer layer, making it a three layer Multiply cot.

### THE PRINCIPLE

- These Cots have an additional soft, specially formulated rubber layer between the hard Inner core and the synthetic rubber outer working layer.
- As a general principle, after every grinding the surface hardness of the cot increases, which is also known as marching hardness.
- To avoid this, we have introduced a soft layer between the two layers, which acts as cushion and compensates for the apparent increase in surface hardness of cot.
- In short, the shore hardness of Supertex Multiply \*Cots will remain within limits upto the end of life of cots, resulting in consistent yarn results and will not deteriorate with age.
- As per spinners choice, this type of cots could be offered in 65°, 68° & 70° shore hardness.

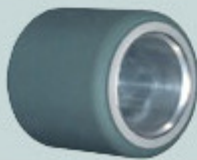
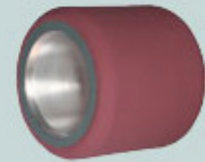


### RANGE OF OUTER LAYER SHORE HARDNESS AS PER SPINNER'S CHOICE



**SGN 65**  
Shore Hardness - 65

**COM 68**  
Shore Hardness - 68



**SR 66**  
Shore Hardness - 66

**SLG 70**  
Shore Hardness - 70





## SUPER TEX TEXTURISING COTS

The Super Tex Texturising cots are manufactured with anti static properties with greater abrasion & heat resistance. This is essential in order to meet demands of new generation machines with ever increasing speeds. Super Tex cots enables perfect control on the filament yarn, even after repeated grinding, thanks to its highly resilient & elastic chemical composition alongwith the optimum stage of cure.


Quality	Type	Hardness	Colour	Application
 SXP - 65	Plain	65°	Pink	Nip Roller cot for all kind of medium speed Texturising machine suitable for spinning fine mono filament denier
 SXP - 65	Spring Grip (SG)	65°	Pink	Nip Roller cot for all kind of medium speed Texturising machine suitable for spinning fine mono filament denier
 SXP - 72	Alugrip	72°	Brick Red	Nip Roller cot for all kind of medium speed Texturising machine suitable for spinning fine coarse multi filament denier

\*Cots for all kind of high speed Texurising machines.  
 All Cots are available in Plain, Spring grip & Alugrip execution.

cont

## SUPER TEX TEXTURISING APRONS

Super Tex aprons meet the demands of high speed Texturising machines such as Barmag, Murata & others. The surface texture is design to provide good holding power, which is necessary to control the filament at high speeds. The specially developed resilient rubber compound is suitable for twisting fine as well as heavy denier filament. The high tenacity, reinforced cord prevents aprons breakage during start-ups and in running, at the same time controlling elongation. The aprons are engineered to precise dimensional accuracy and stringent inspection eliminates operational problem such as apron vibration, tracking, etc.

Quality	Colour	Application
 TP-1100	Outside - Pink Inside - Pink	For High Speed Barmag Machines
 MIT	Outside - Green Inside - Grey	For High Speed Murata Machines
 TR-5080	Outside - Orange Inside - Green	For Medium Speed Machines such as Alidhara, Himson, etc

## Special Purpose Supertex AIRJET Cots & Aprons

Airjet spinning is the technology, which uses an air current to spin out the yarn. It offers high productivity to achieve knotless yarn with high spinning speeds upto 400m/min.

Airjet spinning is suitable for 100% carded cotton, blended yarn and yarns of manmade fibres & melange.

Supertex offers special type of Cots & aprons for various Jet spinning and twin spinning, which is working on Air Vortex Spinning System.

Supertex Aprons for Airjet spinning are manufactured by special compound having knurled inner surface to provide adequate grip at high speed.

Due to high spinning speed Top & Bottom aprons wear out fast, hence they are made with special polymer to achieve maximum possible life & the outer layer is highly abrasive to withstand tough working conditions.

### FOR P/C, P/V, 100% VISCOSE, MELANGE & CARDED COTTON

#### SINGLE RECESS COT



Quality: STN-75  
Hardness: 75° - 78°

#### DOUBLE RECESS COT



Quality: STN-75  
Hardness: 75° - 78°

#### TOP / BOTTOM APRON



Quality: SPP-T/SPP-B (Knurled)

### FOR 100% POLYESTER

#### SINGLE RECESS COT



Quality: SGY-83  
Hardness: 80° - 83°

#### DOUBLE RECESS COT



Quality: SGY-83  
Hardness: 80° - 83°

#### TOP / BOTTOM APRON



Quality: SMP-T/SMP-B  
(Knurled)

· Without Recess Cots are also available on request

· Softer shore hardness Cots could be supplied on request

· Airjet Aprons also available in Plain execution on request

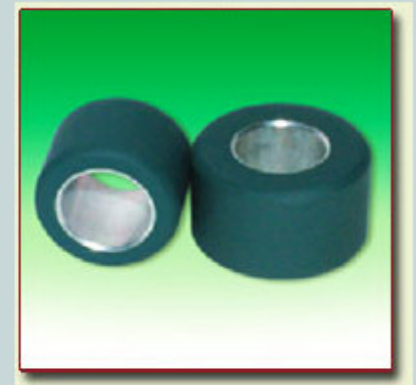
· Special packing provided for Airjet Cots & Aprons

The purpose of all spinning methods is to condense a fiber strand leaving the drafting system immediately before twist is imparted, so that the spinning triangle at the delivery clamping line of the drafting system is practically eliminated.

Broadly there are two methods of compacting the yarn ;

**(a)** The Pneumatic (compressed air) compacting e.g. Comforspin by Rieter (K44) & Elite & Elite Twist by Suessen.

**(b)** The Magnetic - Mechanical, Principle of compacting e.g. Rotorcraft, Germany - RoCoS 1 & RoCoS 2 (Super Tex is the only Indian recommended supplier among their Compact spinning list).



The Super Tex Cots & Aprons for these two systems have been specially formulated keeping in view the special needs of these systems & manufactured the product with customized machines under strict supervision of skilled technicians.

Super Tex can offer Cots & Aprons for all fibers i.e. 100% Cotton, Cotton blends with Synthetic Fibers, 100% Wool, Blends of wool with Synthetic Fibers, and 100% Synthetics. The cots can be supplied in the shore hardness of 65 to 90° as per the processing parameter and spinners demand.

The Pneumatic System has a special perforated apron which Super Tex is in the process of developing.

Super Tex have developed a special mounting tool plate design for easy mounting of cot and thus reduces damage of cots during the mounting.

Super Tex can offer special side angles (edges) cots for magnetic system thus reduces damage of cots and consumption.

In case of any query please ask or write to us. We can also offer plant trials.



*Super Tex Draw Frame Cots*



We use special raw material for manufacturing these cots. Due to the high speeds and stress that these cots are subjected to. Also, we have to make sure that there is minimal lap formation and these cots are abrasion resistant.

Our Special SG/CL Cots can withstand medium loading and speeds and are very cost effective. For modern very high speed machines we strongly recommend our Alugrip Cots.

## STK (SPECIAL) COMBER DETACHING ROLLER COTS

Super Tex has developed one more addition to their range of cots.

This comber detaching roller cot for high speed combers has been developed with many special features which distinguishes it from the normal comber detaching roller cot.

1. Extremely good Anti-Lapping Properties. Stoppage Time of the comber is reduced drastically.
2. Very good control of the fibers which results in improved quality of the comber sliver.
3. Reduced grinding frequency.
4. The polymers used have a high resistance to ozone and oil.
5. The mounting and buffing of these cots has to be done very carefully.

### Technical Highlights :

1. Shore hardness (outer compound) 65°.
2. Double compound –easy fit cordless type
3. Colour : Outer compound – orange brown  
Inner core – black.

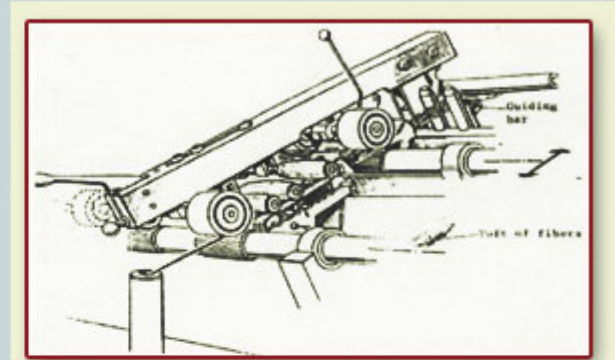
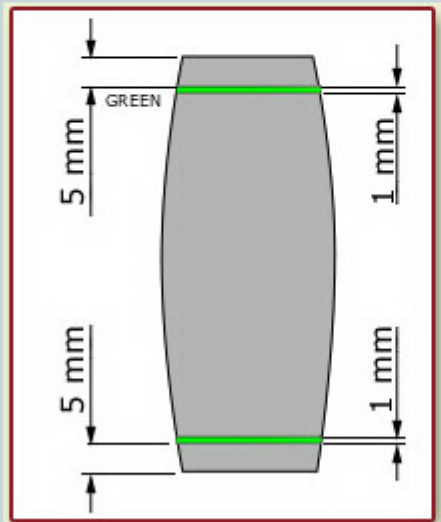




### Balloon Cots

On some worsted spinning frames processing very long fibers, the machinery manufacturers supply a drafting system with balloon cots as shown in the following picture

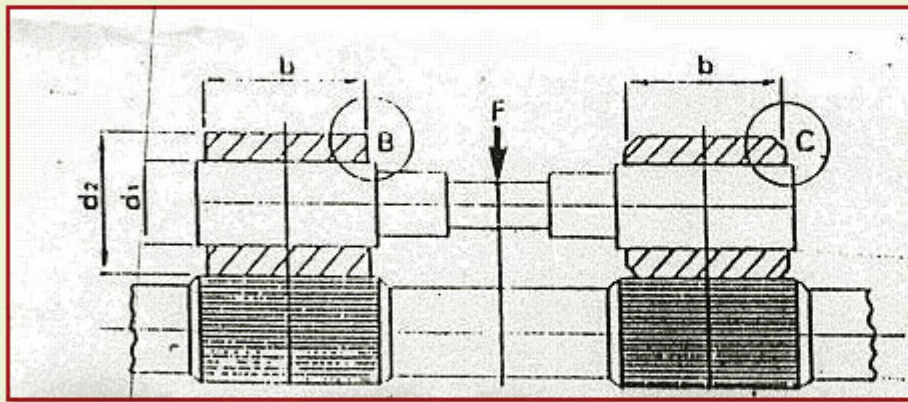
An enlarged picture of the balloon cot is shown below:



The Balloon Cots exercise some degree of control over the long fibers when they pass from the feed roller to the delivery roller.

The purpose of this section is to clearly set out what we need to know in order that we supply you with the correct **Super Tex** cot .

All our products are tailor-made to demanding specifications so as to provide you with the best product available. To achieve this, and to ensure no undue delivery delays, it is essential you supply the following details with your order :-



**Figure = Diameters & covering widths for top rollers.**

**d1** = bare roller diameter in millimeters,  
**d2** = diameter with covering (finished ground),  
**b** = width of covering (finished ground),  
**F** = saddle pressure,  
**B** = covering without bevelled sides,  
**c** = covering with round sides.

**Designation of order for Super Tex Cot :**

**d1 x d2 x b** Shore A, Hardness  
 Execution **B** or **C**  
 Saddle Pressure **F**

**Example of Order :**

**19 x 28 x 25 - A82 Execution B.**

**Warning :** Do not measure or order cots by trying to measure internal diameters of cots.

**Super Tex** Cots are manufactured in different compounds for various applications. If you are in doubt about the possible cot for your particular application, consult your nearest **Super Tex** representative or Agent with the following information.

1. Type of frame. 2. Drafting System. 3. Types of fibres being processed. 4. Average counts being spun. 5. Temperature and humidity. 6. Position of rollers.



## **MOUNTING OF COTS**

### Preparation of Metal Rollers

To be sure of strong bonds of the COTS to the arbors, the metal shells must be thoroughly clean & dry before adhesives is applied. This is important if the cots are mounted on old rollers and equally important if the cots are mounted on brand new rollers. New rollers have protective coating to prevent rust, which must be removed completely before mounting. The roller surface should be degreased with a suitable solvent such as METHYL ETHYL KETONE.

### **MOUNTING OF PLAIN COTS (GLUE TYPE COTS)**

Take the rollers in small lots, to prevent the adhesive applied to the rollers from drying before the cots are mounted. We recommend the use of **SUPER TEX** Adhesive. A thin coat of adhesive mixture is evenly applied on the roller surface. The inside surface of the COT is also applied with a thin coat and the COT should be mounted on the roller after a period of about 10 to 20 minutes. Use of the taper steel cone and pneumatic COT mounting machine is recommended. Any excess adhesive should be wiped off with a piece of cloth. The adhesive should be consumed within its pot life of about 3 to 4 hours. The adhesive should be allowed to set for 20 to 24 hours prior to buffing of cots.

### **MOUNTING OF LONG COTS (ABOVE 100 MM LENGTH)**

For mounting these worst cots, it is very important that pneumatic mounting equipment is used. Immediately after mounting, while the adhesive is still, the cot should be calendared under pressure, to drive out any air-pockets and even out the adhesive.

### **MOUNTING INSTRUCTIONS FOR SUPER TEX RING FRAME SSD COTS**

1. Clean the steel rollers thoroughly. There should be no trace of adhesive, oil or rust on the rollers.
2. Push the Cot on the roller using a hand press.
3. PLEASE DO NOT USE A CONE WHEN MOUNTING THE COTS. The Cot bore should not be expanded before mounting.



### **MOUNTING INSTRUCTIONS FOR SUPER TEX GILL BOX (SSD) COTS**

1. The roller surface should be degreased with a suitable solvent .
2. A thin coating of an adhesive should be applied to the roller surface and the cot should be immediately mounted on a pneumatic machine. The main purpose of the application of the adhesive is to lubricate the entry of the COTS on the roller.
3. The mounted COT should be calendared to drive out any air pockets.
4. The mounted COT should be kept aside for 20 to 24 hours before buffing

### **MOUNTING INSTRUCTIONS FOR SUPER TEX SG/CL SPECIAL DRAWING FRAME COTS**

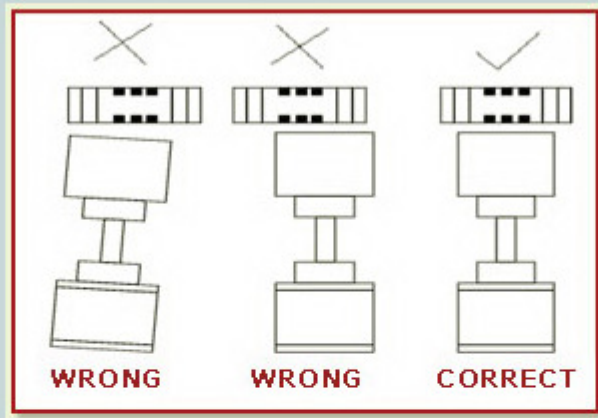
1. The roller surface should be thoroughly cleaned and degreased to remove all traces of old adhesive, grease and all foreign particles from the surface of the roller with a suitable solvent.
2. A uniform coating of SUPER TEX two components adhesive or a similar adhesive should be applied to the roller and the bore of the cot.
3. The cot should be mounted immediately on a pneumatic mounting machine, making sure that the adhesive is moist and has not dried up.
4. The mounted COT should be calendared immediately to drive out any air pockets and even out any lumps of adhesive between the cot and roller. This should be done when the adhesive is still moist.
5. The mounted cots should be kept aside for 20 to 24 hours before buffing.

### **MOUNTING INSTRUCTIONS FOR SUPER TEX ALUGRIP COTS**

1. Clean the steel rollers thoroughly. There should be no trace of adhesive, oil or rust on the rollers.
2. A vertical mounting machine is extremely important for mounting these Alugrip Ring Frame & Speed frame Cots . An hydraulic machine is preferable.
3. Use a Centering pin for guiding the Cot on to the roller correctly. If the Cot is not properly guided, it will either burst or will not sit correctly on the roller.  
See the diagram given below.
4. Taper Cones should on no account be used for mounting Alugrip Cots .



## CENTERING THE COTS



## BUFFING

### AIMS

The Top roller cover is a technology component which has a direct impact on the quality of yarn, especially on evenness and imperfections. With the choice of the right cover you can minimize lap formation and end breakages while simultaneously optimizing the productivity of your main operation.

Super Tex considers buffing to be one of the most important operations, which would have a direct result on the yarn quality.

### The main reasons for buffing are :-

1. To make the cots concentric to the rollers on which the cots are mounted and taper free and to get a surface which is smooth and uniform.
2. To remove any cuts and nicks on the cots and to remove the effects of oxidation.
3. After working for sometime, the cots will be polished by the rubbing action of the bottom rollers and the fibres that are being processed.



## SURFACE RESISTIVITY OF COTS

After a cot has run for an extended period of time, the fibers emerging from the front cot nip will contain higher levels of electrical charges resulting in more clearer waste and, in the case where clearers are not used, more loose fly in the air which can effect Classimat results and yarn appearance. Cot surfaces being less conductive after extended running builds up static charges, releases them to the fibers, and results in hairy yarn. If the end comes down, this less conductive surface will result in a lap. Buffing the cot restores Surface Resistivity and improves running conditions.

The regular grinding of top roller covers ensures the quality of yarn.

### GRINDING WHEEL

This is the heart of the Grinding Machine. To make sure that the cots are buffed efficiently, it is important that wheels of the following specifications are used.

- (a) White Aluminum Oxide Stone (AA)
- (b) Grains Size (46 or 60 or 80)
- (c) Grade Range (J)
- (d) Wheel Structure (5)
- (e) Bond Type (Vitrified bond - V) e.g. AA60J5V (Carborundum)

Generally, for rough buffing a grinding wheel of 24 or 36 grit (grain) size would be suitable. For final buffing, 46 or 60 or 80 grit stone would be suitable.

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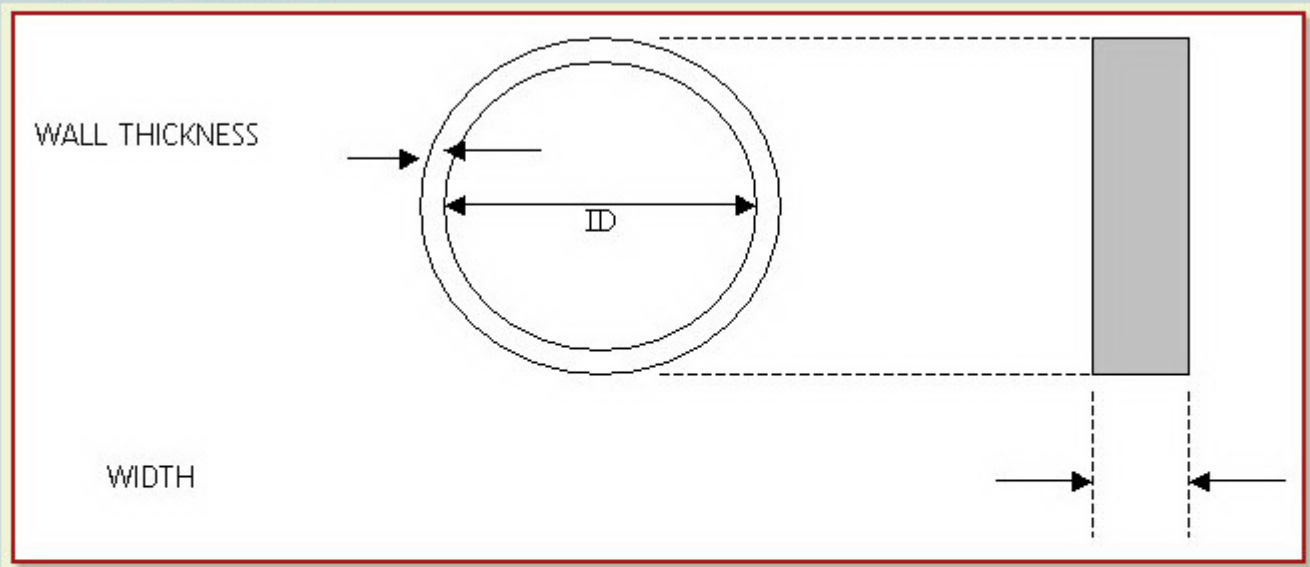
### ECCENTRICITY AND TAPER TESTER

The eccentricity and taper should be checked with dial indicators. The maximum eccentricity of Ring and Speed frame cots should not exceed 3 thou (0.08 m.m.) T.I.R. and taper 2 thou per inch of length.

### SET UP A BUFFING CYCLE

For maximum efficiency, a definite programme should be followed for installing and rebuffing of Cots.





The size of the Apron is normally specified as follows :-

**ID x WIDTH x WALL THICKNESS**

1. The ID (Internal Diameter) can be measured with a plug gauge. Alternatively, measure the circumference of the Apron on the inside and then divide by 3.142 to get the approximate ID .
2. The width of the Apron can be measured with a Vernier Calliper.
3. The wall thickness can be measured with a thickness gauge or vernier.

It is always advisable to ask the machinery manufacturer for the dimensions of the Apron. If in doubt send a sample Apron for measurement to Super Tex Industries

## APRON MAINTENANCE

Mill conditions vary so widely that no general rules can be set up regarding the frequency or the extent of apron maintenance. Under today's operating conditions, however, apron service conditions are becoming more severe. In the interest of keeping yarn quality high, schedules for apron maintenance should be based on the production per spindle rather than the less reliable scheduling by calendar intervals.

An obvious starting point is to step up the routine inspection of aprons as they are operating on the frame. Worn or damaged aprons should be replaced, even if the end appears to be running normally.

Where mills have fixed schedules for cleaning apron cradles, the intervals should be reexamined from time to time to see if they are realistic in terms of the mills' current operation. For example, a change of fibre or change of yarn count may result in the accumulation & can distort the apron drafting forces and impair yarn quality.

In the interest of maintaining uniform yarn quality, it is strongly recommended that aprons be re-placed in frame lots. Where new aprons are being installed, this of course presents no problem.

In some mills, however, it is the practice to salvage usable aprons from frames that are being scoured, and to replace only those that are obviously worn or damaged. This mixes old and new aprons on the same frame. This results in yarn of different qualities from spindle to spindle. This is not normally acceptable.

The alternative is to keep reasonable accurate records of apron service. Then, when frames are down for scouring, salvaged aprons can be grouped according to their approximate length of service and installed on the same frame.

## **SUPER TEX SKIVED APRONS**

The importance of good quality Skived Aprons to a Spinner cannot be over Emphasized. Super Tex can supply any of the above Aprons Skived. A properly joined Super Tex Skived Apron will give as good results as an Endless Aprons.

### **JOINING OF SKIVED APRONS**

Quick - setting adhesive of cyanoacrylate type (e.g. Loctite 406) is recommended for bonding of the skived ends. Super Tex clamping device greatly facilitates the bonding operation.



The skived surfaces should be made free from any foreign particles or dirt using a clean cloth.

The skived edges should be so inserted in the clamp that the arrows should point towards yourself. The arrow lines of one end should match the corresponding arrow lines of the other end.

A drop of the adhesive should be applied on the lower edge and it should be spread uniformly.

Care should be exercised so that the adhesive does not come in contact with the skin. We recommend use of rubber Finger tips for this.

The upper edge need not be applied with the adhesive.

The clamp should be closed and the adhesive should be allowed to set for two to three minutes.

The joint should be inspected after removing the clamp. The apron is now ready for use.





## PREGLUED SKIVED APRONS

These Skived Aprons have been developed mainly to facilitate the replacement of broken Bottom Aprons during working. The steps to be followed for fitting these Aprons on a running machine are as follows.

01. These Aprons are already pre-glued with an adhesive.
02. Insert the Aprons into its working position on the machine with its lower skived edge opposite to the direction of rotation. Make sure that the arrow printed on apron, point in the direction of rotation.
03. The skived portion of the aprons are already preglued with on adhesive. Activate this adhesive by applying a single drop of the activator liquid. A single light coat with a thin brush is sufficient. The brush is similar to the one used by an artist. The main purpose of this light coat is to only to reactivate the adhesive already preglued to the skived aprons.
04. Align the edge of the aprons very precisely, so that the arrow lines printed on the aprons match perfectly.
05. Stick the end carefully by applying uniform pressure for one or two minutes.
06. Leave the aprons to set for ten to fifteen minutes. The adhesive will acquire sufficient initial strength to enable the apron to be put into use and to restart the spindle. The strength of the joint progressively increases with time. It gains its full strength after 24 hrs.
07. Put the Aprons into use.

## PRECAUTIONS

01. Pre-glued skived aprons should be stored away from dirt, heat, light, or any possible contaminations.
02. Avoid touching the skived surface. A soiled joint will not adhere correctly.
03. Higher initial setting times (i.e. more than 15 minutes) may be necessary before putting the aprons in use This can be best judged by actual trials to suit the prevailing atmospheric conditions, speeds and working forces involved.



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