

60~70%

3 18 , 18 (Weaver), 9
(over-looker:)

가 30's~35's 가 104~120
/inch, 가 60 /inch Cotton poplin ,
80~82% (loom hour) 1.0

12 Beam
Beam 2 (1 2, 3 4,.....
) 6 2 nd Beam

2 Beam
Beam

- (a) : (Woven Waste), , , , ,
- (b) : (lashing-in), , , , ,
(less pick).

7.5mm , 25mm-75mm, 25mm

○ 0.5 :

○ 1.0 :

○ 2.0 :

○ 3.0 : (가 4)

2 ,
4
250m, 500m, 500~700m

Table 1 100m , 100m

Data (beam, 100m, shift)

Table

<Table > Weaver-wise and over looker-wise give mean, range, and CV.

Mill	Weaver-wise				Over looker-wise			
	Mean	Range	CV, %	Overall	Mean	Range	CV, %	Overall
A	121	21- 436	48	49	107	3-442	48	54
B	196	25- 688	52	61	131	8-892	95	95
C	88	32- 255	43	52	38	3-222	82	82
Overall	135	21- 688	48	54	92	3-892	75	77

<Table > Percentage contribution of loom, beam, and shift to total points per 100meters.

Mills	Weaver-wise			Over looker-wise		
	A	B	C	A	B	C
Between looms	4	29	9	10	2	5
Between beams	1	1	20	9	7	5
Between shifts	15	7	5	18	16	6
Within shift) within beam)	80	63	66	63	75	85
Overall	70			74		

Table

가

가

(Data가)

Table

70% 74%

. Zero Defect

Q.C circle