

1.

10 ,

, ,

. 가

가 .

가

가

가

.

.

가

£400,000(33,360)

60%가

.

500

1

$15 \times 10^6 \text{yd}$

2

가 4%

가

2

600,000yd가

.

yd 15p(52)

£90,000(75,060)

.

4%

3%

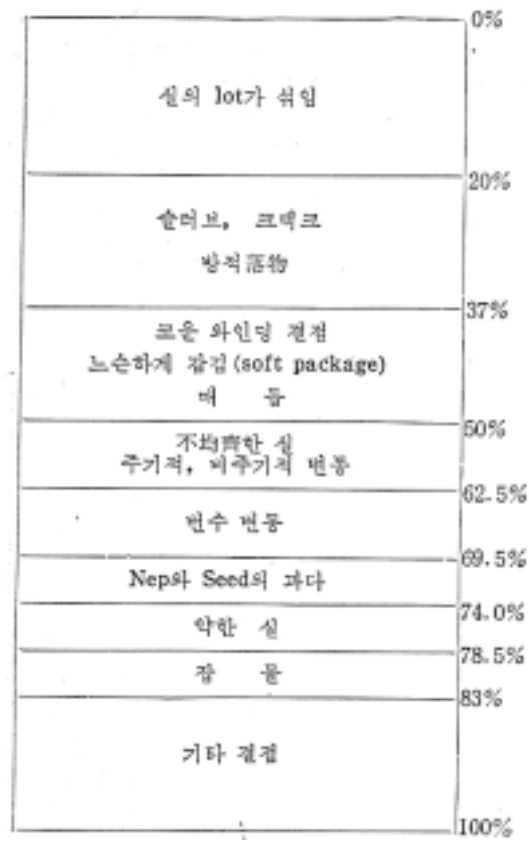
£22,500(1776.5)

.

가

가 . , ,

가
가



< 1> 가 1

(electronic yarn clearing)

1 가 1 가
(complaints)

(crackers), (spun waste)

17% .

가

(fly), (fluff)

(loose fiber)

(latch)가 .

가 .

가

1, 2, 3

1,000yd

(,)

< 1>

	Woven	Woven (suits)
()	28%	61%
가	가 19%	가 57%
(100yd)	13p(45)	85p(295)
1,000yd 가	£1.30(1,084)	£8.50(7,089)

< 2>

	Woven	Woven
()	16.5%	31%
가	가 15%	가 22.4%
(1,000yd)	£3.5(2,910)	£12(10,008)

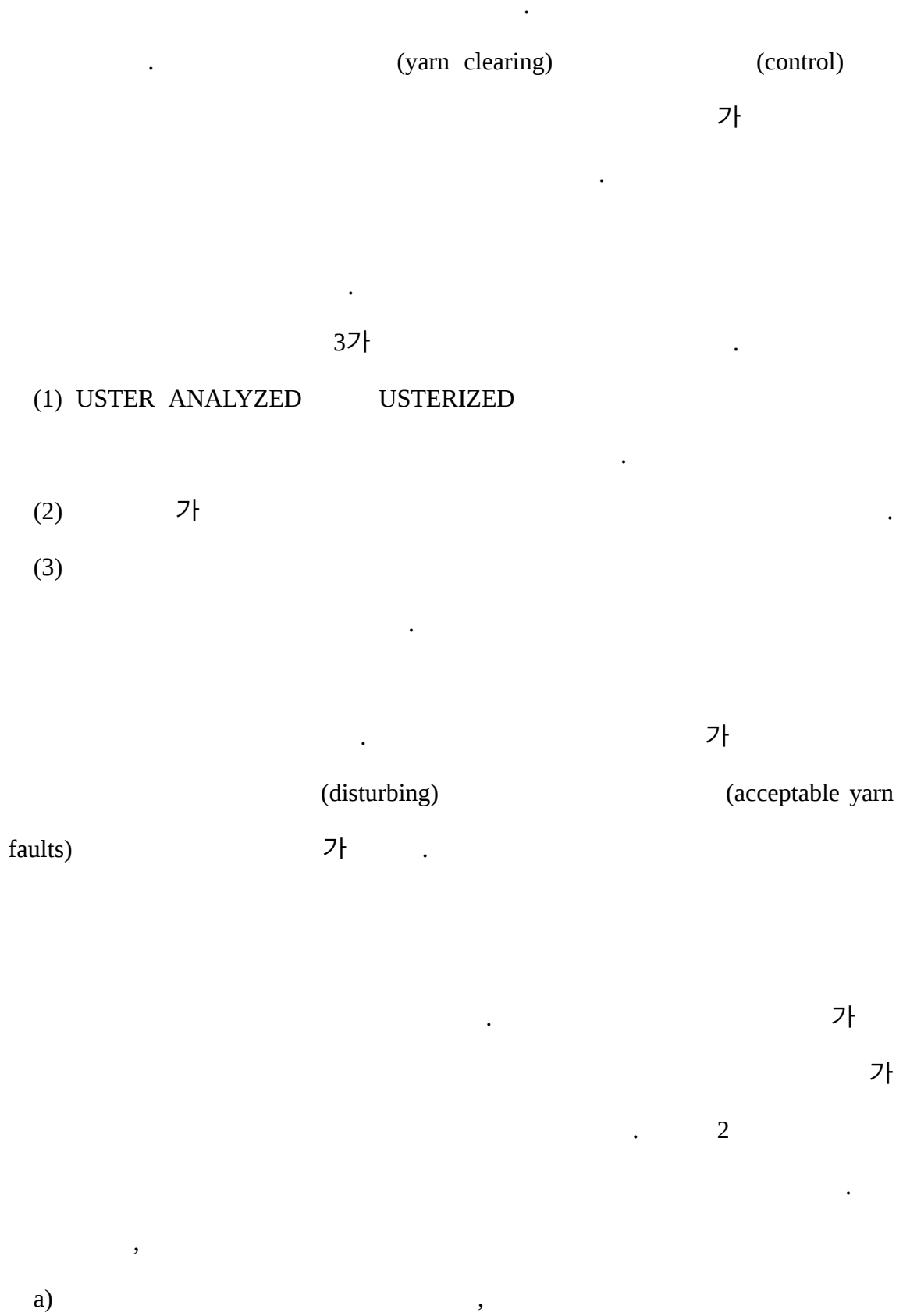
< 3>

(m)	7,457	5,781	9,175	1,279
	3,873	4,611	69	191

2.

가

(cop)

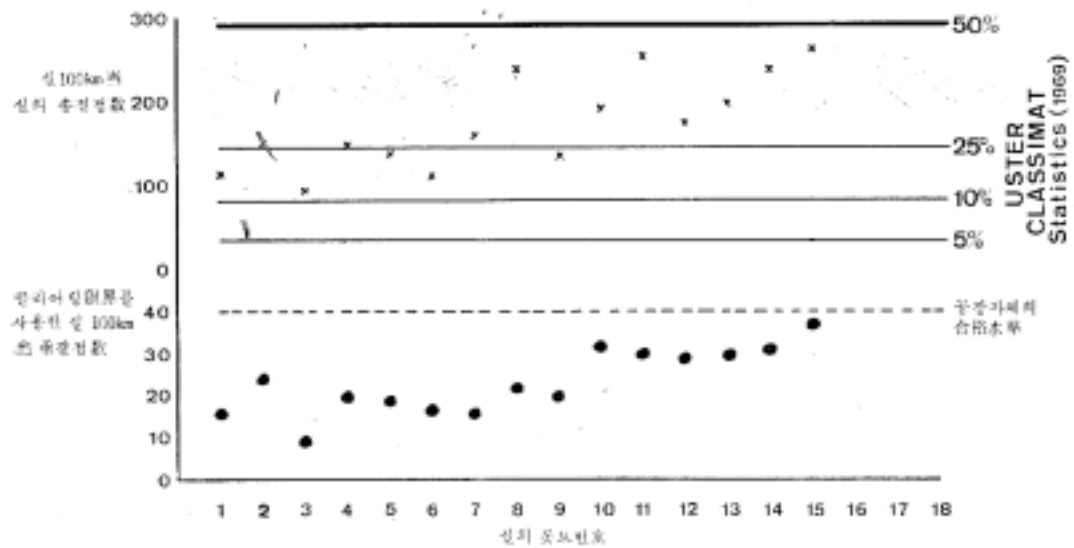


b) 2 (),

c) 2 .

3 가

(changes)



< 2> 15가

2 가 Nm50(Tex 20.2)

USTER CLASSIMAT

. USTER CLASSIMAT

가

가 .

. [

(: sensitivity) ; + 170%, (REF. Length) ;
2.6cm]

가

가?

가 .

(Uster Classimat Statistic) ,

.

가

. , ,

, ,

가 . , , 가

(limit)

.

.

(limit) 가

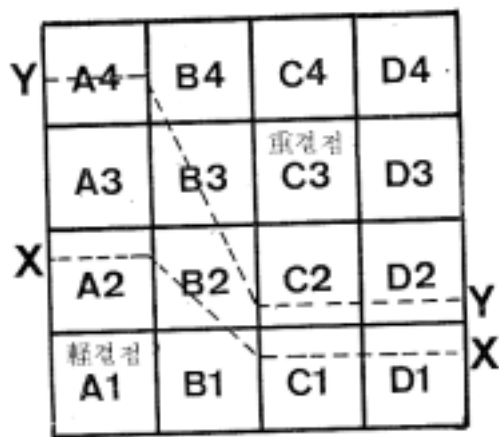
.

.

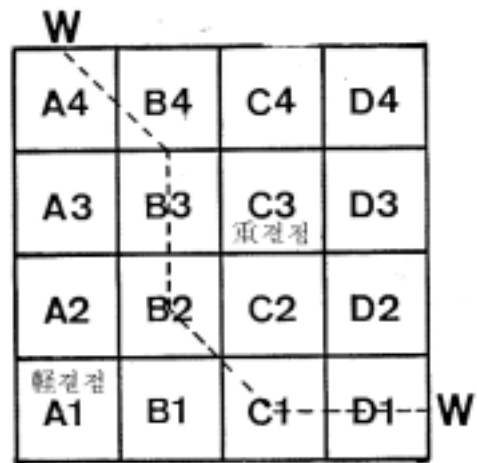
.

가 ,

stringing burling(, , ,
.)



수정하지 않는 織物用



수정하는 織物用

< 3>

3

(limit)

A

“WW”

A (+600%)

. B

가

C D

(ideal

clearing curve)

3

2

XX

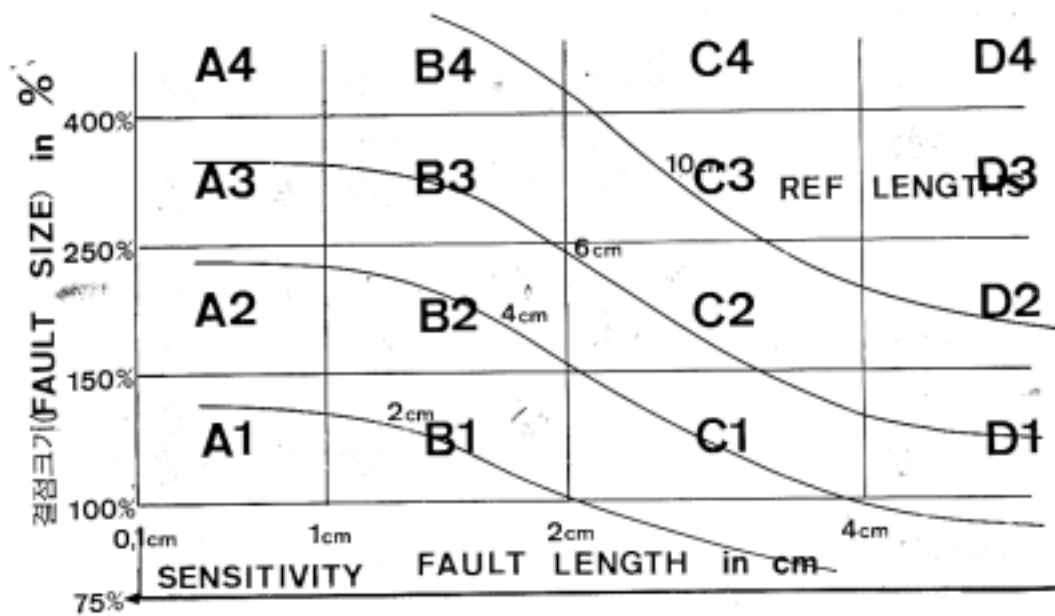
A ()

(fly)

YY

XX, YY

B



< 4> CORRELATOR

(Reference Length)

WW A
10cm (reference length)
XX YY 2cm , 4cm
6cm correlator

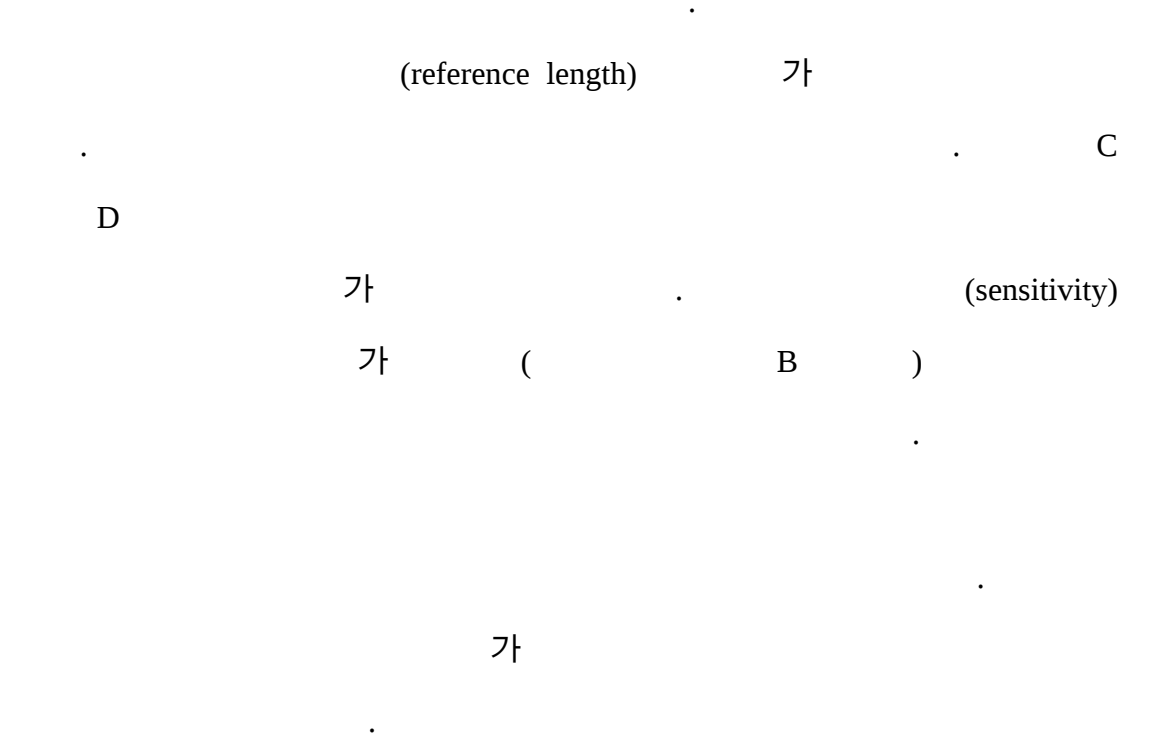
< 4>

CLASSIMAT			(Sensitivity)	(Reference length)
Nm	Nec	Tex		
12-25	8-15	75-40	184%	2.0cm
25-50	15-30	40-20	173%	2.2cm
50-100	30-60	20-10	177%	2.4cm
100-200	60-120	10-5	169%	2.1cm

< 5>

CLASSIMAT			(Sensitivity)	(Reference length)
Nm	Nec	Tex		
12-20	11-18	80-48	182%	2.3cm
20-33	18-30	48-30	175%	2.2cm
33-60	30-55	30-16	177%	2.2cm

, ,
(sensitivity) (reference
length) 4,5



1. ()	Nec32-36 (18.5~16.5Tex)	100%	+170%~+200%	1cm~2cm
2. ()	Ne20(30Tex)	67%PES/33%	+190%~+200%	1cm~3cm
3.	New30-34 (30~26Tex)	100% Wool	+170%~+200%	1.5cm~3cm
4.	New32-40 (27-22Tex)	55%PES /45%Wool	+170%~+200%	2cm~3cm
5. (Knitted Underwear)	Nec26-50 (23-12Tex)	100% and 67%PES /33%	+170%~+200%	2cm~2.6cm

< 5>

(yarn)

. 5 4 5

가 가

. (sensitivity)

가

(setting

.

.

3.

3.1

?

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1)

가?

가

2)

?

가?

.

Schlafhorst

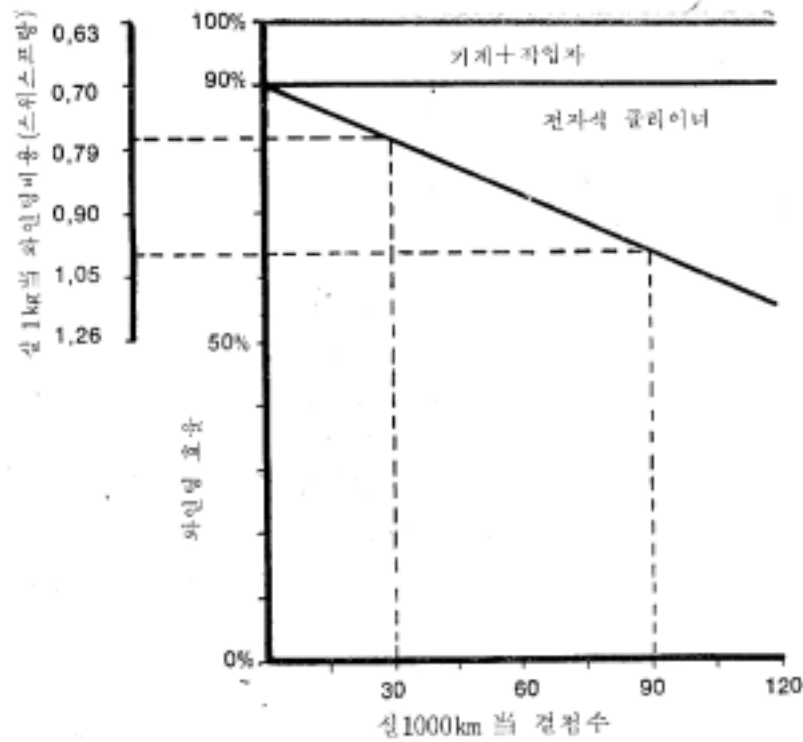
.(

6)

6

. , , , (magazine) ,

10% 가



< 6>

가 가

가

가

2

S. Fr()

100%

90% 1kg 0.70S. Fr(140)

가 600~1,200m/

0.60~0.80 S.Fr/kg(120 ~180)

100kg 30 90 가

) ; Nm36(Ne_w32, Tex 27.8)

; 30 /100km

; 82%

; 0.78 S.Fr/kg(6)

= 0.78~0.70=0.08 S.Fr/kg

Nm 36 100km ; 30=30 /2.78kg

1 ; $\frac{0.08}{30} \times 2.78 = 0.0074 \text{S.Fr.}$

1.48 .

30 90 가

가 .

$$\frac{0.089 - 0.074}{0.074} \times 100 = 20\%$$

가

3.2

burling, thinning, mending

6 가 ()
 170%, 2cm
 0.45mm
 (Nm27, Tex 37).

< 6>

			A	B
			100% Nm27(Tex 37) (/1000m) 370	100% Nm27(Tex 370) 260
20	(60m)	Burling	16h.	28.3h
20	(60m)		2.15h	6.3h
Burling	Mending	/	55	105

Burling
 (piece : 60m) (mending) 1/3 burling mending
 55:105
 가 가
 가 [4.00 S.Fr(800)]
 ;
 100,000m 370 A
 $\frac{55}{60} \times 4 = 7.0 \text{ S.Fr/}$ (734 /)

100,000m 260 B

$$\frac{105}{60} \times 4 = 7.0 \text{ S. Fr/ (1,400 /)}$$

WIRA Lumb 가

(64m) 13.75 . 10

90 2,277 .

44%

. 44% × 13.75

6 .(6 ×

$$\text{S.Fr.4.00} = 24 \text{ S.Fr/ } = 4,800 \text{ / }$$

3.3

가 .

1) 가

. 가 .

2) 100%

가 .

가

.

-

- 가

-

- 2 (sub-standard)

100% , Terylene/wool , Terylene/wool,

14.2P(49.3) trouser 11.9P(41.4) .

		MMF
	23.9P	13.2P
(weft bar)	43.9P	16.2P
Thick	22.4P	14.4P

	MMF/	MMF
	30.6P	26.3P
(weft bar)	11.6P	4.8P
Thick	14.9P	16.7P
	16.7P	9.3P

	1.71P
	1.67P
	3.54P

	1.41P
	3.24P
	48.9P

7,8,9,10 trouser 가

. Trouser

1/3 .

.

. 1

.

100% /

.

. 2.5P(8.69)

5.6P(19.46) .

.

. Type

가 .

4.

1) .

2) 가

.

3) .

가 .

