

Picks-Plus Monitor

INDICATING CONTROLLER, MODEL 1665
FOR WOVEN FABRIC FINISHING



CONSTANT
RESIDUAL SHRINKAGE
AND PICK COUNT
YOU CAN CALL UP
BY STYLE NUMBER!

Picks-Plus Monitor
INDICATING CONTROLLER, MODEL 1665

*An economical solution
for all your process
control needs.*



LASER PICK/COURSE SENSOR
TYPE 6307

A dynamic shrinkage control that takes into account loom-state picks by style number minus an exact measure of the ones you inconsistently lose in processing. It gives you the *right* pick count at *constant* residual shrinkage.

Automatic moisture control at rubber belt entry ensures optimal shrinkage retention.

Expansion monitoring possibilities include fabric width and density, skew, surface temperature, wet pickup, final moisture plus many more!



STRANDBERG ENGINEERING LABORATORIES, INC.
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-GENERAL INFORMATION-

If you apply a constant percentage of shrinkage to fabric that has been stretched various percentages since it was woven, you will get various percentages of residual shrinkage and pick counts in your finished fabric.

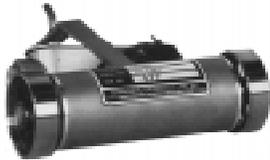
But, if you apply a variable percentage of shrinkage based on the running difference between loom-state and on-line pick counts, you will achieve virtually constant pick count in your finished fabric and residual shrinkage at standard deviations of 0.5 down to 0.3. The difference is phenomenal, like night and day!

The fact that you can set-point control these qualities and even call them up by style number is even more phenomenal. It absolutely maximizes your yield, while it gives your customer an advantage he has never had before.

It's called dynamic shrinkage control or "Picks-Plus", another basic Strandberg contribution to textile technology.

It's easy to apply. Simply enter your target and loom-state pick counts by style number for later call up on the job. To avoid roll-to-roll differences from your loom-state pick counts, monitor and print a record of the actual average pick count in each roll of cloth. Do this at the entry of your first process after weaving. Then, enter your loom-state pick counts by the roll. Model 7765 Monitor uploads this information to a higher-level system for automatic entry.

Strandberg's new, hermetically sealed and nitrogen gas filled Laser Pick/ Course Sensor requires only grazing contact with one side of the fabric. Its count is gated by one of Strandberg's precision displacement sensors, such as the one shown below, to display picks to the nearest tenth per inch or centimeter at speeds up to 200 yards or meters per minute. Robust sensor design allows installation in the harshest processing environments.



DISPLACEMENT SENSOR
TYPE R-90-200

Moisture level at rubber belt entry is critical to achieving optimal shrinkage control. Set-point regulation of atomizers, steamers and drying cylinders guarantees constant moisture for every style.

Use the "Picks-Plus" Model 1665, with trend graphics, on stenters and shrinking machines or just about anywhere you want to monitor the pick count going in and coming out, simultaneously. Use the Strandberg Type 6267 Drive Speed Control on AC and DC drives and the Strandberg Type CM-92 Control Motor on PIV's to set-point control your pick counts by style number. Download your set points from a higher-level system running Strandberg's QC-Master Windows-95 Supervisory Software. Connect a printer to prove you did the job right.

-SPECIFICATIONS-

Power Requirements	85-265 volts, 50/60 Hz
Weights and Dimensions	Indicating Controller, Model 1665 12.0 lbs. (5.5 kg) 12.5" (318mm) high, 10.9" (277mm) wide, and 6.25" (159mm) deep
	Pick Sensor, Type 6307 8.5 lbs. (3.9kg), 4.2" (107mm) high, 8.3" (210mm) wide, and 6.3" (160mm) deep
	Displacement Sensor, Type R-90-200 3.5 lbs. (1.6kg), 11" (280mm) long, and 7.6" (193mm) wide
	Interface, Type 6928 2.9 lbs. (1.3kg), 10.2" (259mm) high, 6.9" (175mm) wide, and 4.4" (112mm) deep
	Moisture-to-Computer Interface, Type 1035 9.8 lbs. (4.5 kg), 8.3" (211mm) high, 11" (279mm) wide, 4.3" (109mm) deep
Housings	Indicating Controller, Model 1665, and Interface, Type 6928, fiber-glass NEMA-4X with hinged cover for use in wet processing areas
	Sensor, Type 6307, cast aluminum/ stainless- steel face, water tight
Principle of Operation	Impulses from laser reflectance, gated by successive lengths
Range	0.0 - 200.0 or more picks per inch or centimeter
Control	Set points and tolerances in tenth pick steps by style number, step and PID corrections, Drive Speed Control, Type 6267, for AC and DC drives and Control Motor, Type CM-92, for PIV's, includes chain, sprockets, and override push-button control station
Display	Liquid Crystal, 4.8" x 2.4" (120 x 60mm)
Outputs	0-10 volts and 4-20 mA d-c for recorders, etc., RS-232 for printers and other serial devices, and RS-485 for networking, 4-20 mA d-c proportional to skew angle
Accuracy	±0.1 pick per inch or centimeter



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