



Size-Rite™



INDICATING CONTROLLER, MODEL 1602e



AUTOMATIC SIZE ADD-ON CONTROL plus

MOISTURE, PREWET, STRETCH,
TENSION, AND TEMPERATURE

COMBO

FOR SLASHERS

The **STRANDBERG** Size-Rite Combo is a multi-item combination that includes the big four... moisture, stretch, size add-on, and prewet... plus size box and drying cylinder temperatures, creel tension, and tension in the leasing section... your option.

The **STRANDBERG** Size-Rite Combo represents 50 years of sizing experience!

As a moisture control, **it regulates drying temperatures first, then speed... just barely.** It keeps residual moisture in the loom beam where you set it.

As a stretch control, **it regulates size box speeds** to keep stretch to the front roll on your target. **It also monitors the overall stretch** from the back of the creel.

As a size add-on control, **it trims squeeze-roll pressures** to stay on the set point. Accuracy is maximized with **non-contact wet pickup sensors on the warp** and **non-invasive solids sensors on the size lines.** They are watch dogs for dilution from prewet boxes.

As a prewet moisture control, **it regulates squeeze-roll pressures** to achieve constant wet pickup at size box entry, a prerequisite for high-quality, low-solids add-on.

Set points and tolerances to the nearest hundredth percent wet pickup, moisture, stretch, and size add-on plus temperatures, tensions, and squeeze-roll pressures are called up by simply entering a style number. **The rest is automatic.**



STRANDBERG ENGINEERING LABORATORIES, INC.

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*Size-Rite*TM

PROCESS CONTROL FOR SLASHERS



-GENERAL INFORMATION-

The Size-Rite Combo, Model 1602, is a modern, world-class control. It can run a slasher by itself, or it can join in on a network of controllers to make it run even better.

Its big-figure displays, readable from across the room, its easy style-number call up, and its alarm features make it a true stand-alone.

From prewet boxes at entry, through the size boxes, to final moisture, virtual constant-speed sizing is a superb feature, a valuable result of slasher-derived controls that keep moisture in the loom beam so close to its target that the need to change speed is infrequent and almost imperceptible.

“Wet stop” automatically decreases the speed to slow when high moisture indicates a loss of steam or a lack of squeeze-roll pressure. Alarms sound off on size-box run out and overflow.

Use up to three common-connected moisture sensing rolls up front with or without a lift bar. Use a full-span roll to catch a wet end anywhere in the warp.

Watch out for big changes in stretch at slow speed. The slasher may be old, but the 1602 is not. It is fully capable of making an old machine run like new.

Use the extension cable to temporarily locate two surface-speed sensors side by side on the same roll for a 0.00% accuracy check. Intermix surface and shaft-driven speed sensors.

Connect the 1602 to Strandberg control motors, drive speed controls, and pneumatic roll pressure controls to produce the highest-quality warps possible... at the lowest possible cost.

Look for big savings in size chemicals when you prewet your yarn and take charge of the amount of size you add. It's easy enough. Just one full-span prewet sensor before each size box and one Strandberg microwave moisture sensor after each size box will do the job. Don't worry about calibration. Simply enter yarn counts and ends per inch or centimeter by style number to keep the fast-response sensors automatically calibrated for any warp density you want to run. Brand new, **non-invasive** all-microwave solids sensors at the size boxes convert wet pickup to size add-on.

-SPECIFICATIONS-

Power Requirements	115/230 volts a-c
Weights and Dimensions	12.0 lbs. (5.5 kg), 12.5" (318mm) high, 10.9" (277mm) wide, and 6.25" (159mm) deep
Housing	Fiber-glass NEMA-4X
Moisture/Wet Pickup Sensors	. Contact/Non-contact
Speed Sensors	Surface or shaft-driven, any mix up to six for stretch
Optional Sensors	Prewet full-span, tensions, temperatures, roll pressures
Solids Sensor	Optional for each size box or size recirculating line
Set Points and Tolerances	Hundredth percent (0.01%) steps for moisture, stretch, and size add-on
Control Motors	One for each size box for stretch control
Pneumatic Controllers	Analog 4-20 mA d-c to adjust- able-range pneumatic output for drying temperatures and squeeze roll pressures, including speed ramps
Display	Liquid Crystal, 4.8" x 3.5" (120 x 90mm), alternating moisture, stretch, add-on, and others, as required
Outputs	Analog 0-10 volts and 4-20 mA d-c for controls, recorders, and higher-level systems, relay closures for control motors and alarms, RS-232 printer output for alarm, beam and set reports, RS-485 for connection to STRANDBERG Microsoft Windows-based QC Master 3100 Software
Moisture Repeatability	±0.1%
Size Add-on Repeatability	±0.2%
Stretch Accuracy	±0.05%



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