



Quick Guide YarnMaster® PRISMA



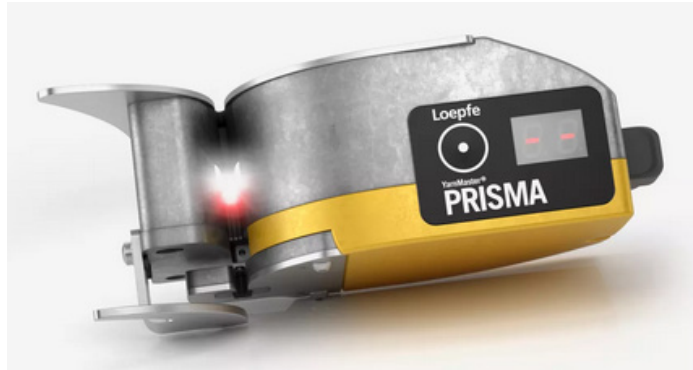
Valid for v6.23.1.xxx / 02.2023 / P&S

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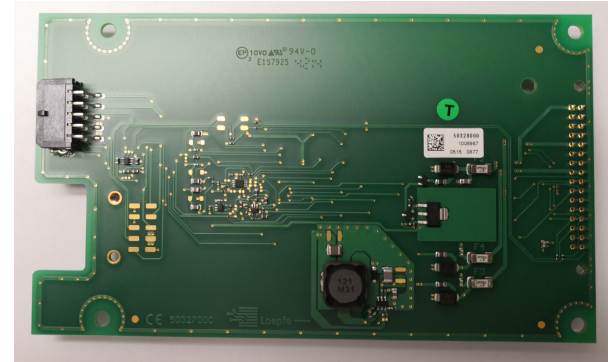
1. Components
2. What's new
3. RGB foreign matter clearing
4. First startup
5. Firmware update
6. Article and group management
7. Monitoring and classification data
8. Last cut / Test mode / Classification

Components of YarnMaster[®] PRISMA

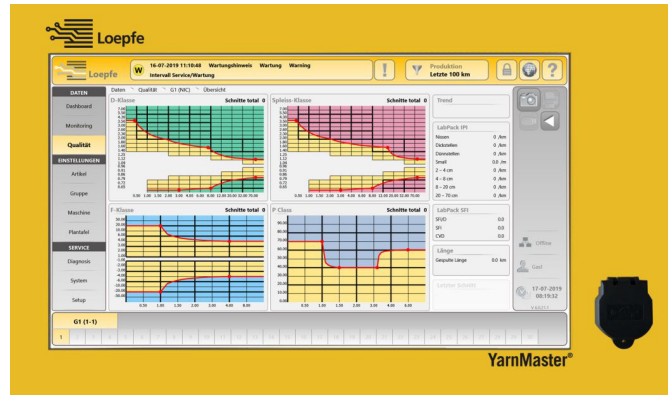
Sensing head



Spindle adapter




Control unit LZE-6






What's new in YarnMaster[®] PRISMA

- NSLT and Splice clearing curves are plotted with max. 24 setting points (16 for the NSL curve, 8 for the Thin curve)
- Splice Accumulation clearing to remove repeated splices
- F clearing is based on a clearing curve made of max.16 setting points (8 for the dark, 8 for the bright)
- F organic clearing is based on a clearing curve made of max.8 setting points
- P clearing is based on a clearing curve made of max.8 setting points
- NSLT cluster clearing curve is plotted with max.10 setting points (5 for NSL cluster, 5 for Thin cluster)
- Count channel clearing is based on a clearing curve made of max.10 setting points (5 for coarse limit, 5 for fine limit)
- SFI/D clearing (optional) is based on a clearing curve made of max.10 setting points (5 for plus limit, 5 for minus limit)
- Off-Color clearing (optional) is based on a clearing curve made of max. 10 setting points (5 for Dark limit, 5 for Bright limit)
- Dedicated channel to detect Missing Core and Off-Centre Core

- “Autostart” to adopt optimum setting for new yarn count / new lot.
- Length Limit alarm is to reject bobbins with longer fault classifications for OffCount / SFI/D / OffColor classifications
- Bobbin Startup alarm is to reject bobbins with wrong count immediately after bobbin change, also available for bobbins with wrong colour with the option OffColor clearing
- Classification introduced for OffCount, SFI/D and OffColor channel
- “Autocorrect” for setting optimization. This will help to find optimum clearing limits based on yarn quality.
- Last 20 cuts can be monitored for the individual spindle with intensity and fault length
- Revamped article and group management. One can now “add” or “remove” articles and groups

 **Loepfe**

Production
Last 1000 km




Settings > Article > 36SRLC > Overview

DATA

Dashboard

Monitoring

Quality

SETTINGS

Article

Group

Machine

Planning table

SERVICE

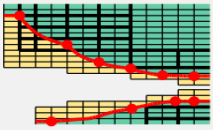
Diagnosis

System

Setup

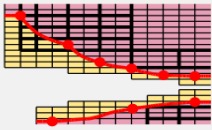
NSLT

Clearing On



Splice

Clearing On



NSLT Cluster

Nep Cluster

Clearing On

Obs. Length 12 m

Faults 4

Short Cluster

Clearing On

Obs. Length 12 m

Faults 6

Long Cluster

Clearing On

Obs. Length 12 m

Faults 8

Thin Cluster

Clearing On

Obs. Length 12 m

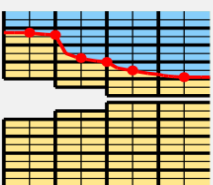
Faults 6

Foreign Matter

Clearing Dark On

Clearing Bright Off

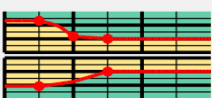
Clearing Organic On



OffCount

Clearing On

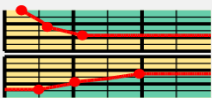
Length Limit On



SFI/D

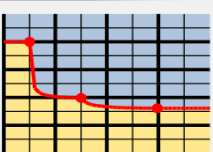
Clearing On

Length Limit On



Polypropylene

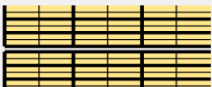
Clearing On



OffColor

Clearing Off

Length Limit Off



OffLimit Alarms

Class Alarms

IPI Alarms

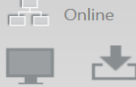
OffStandard Bobbins

Core


Properties

Article	36SRLC
Type	Compact
Material	Pure
Yarn Count	36 Ne

Online



Foreman







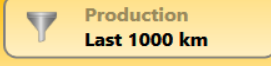
29-08-2022
11:07:24

v6.22.2.35925

30SRLC
M-42SRLC

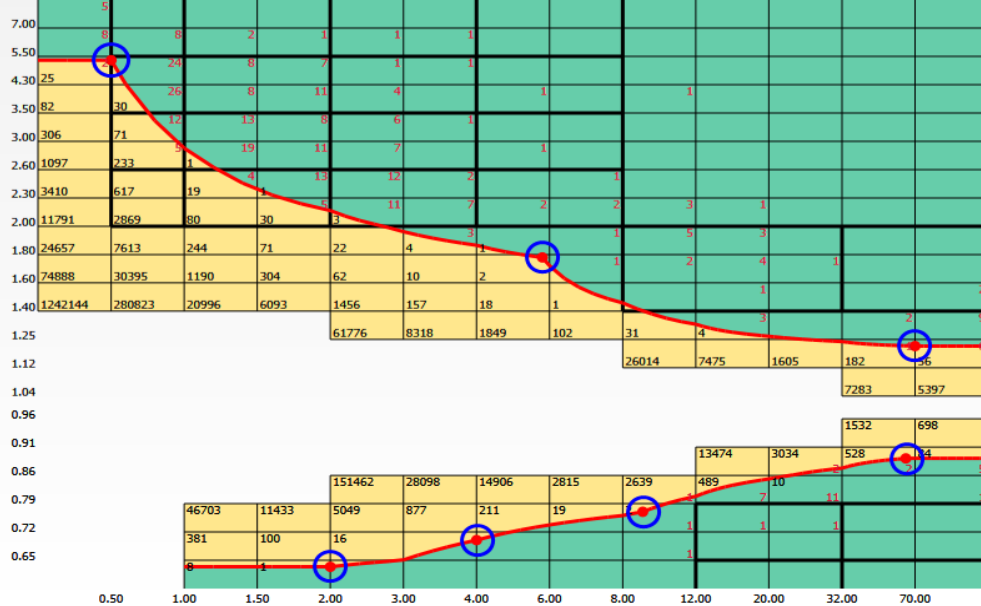
NSLT Settings → Setting points are introduced to plot the clearing curve. Maximum 16 points are available for NSL curve and 8 points for Thin curve.





Settings > Article > M-36SRLC > NSLT

Display Mode: In Production:



D Curve
Clearing On

Point selection
← →

Point setting
Length:
Diameter:

Offline
Foreman
14-12-2021 15:28:51
v6.0.72.32850-rc
d05b2a097-Release

M-36SRLC

NSLT Point selection → The selected point will be highlighted in **Blue** colour.

Production
Last 1000 km

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Setup

Settings > Article > M-36SRLC > NSLT

Display Mode In Production

D Curve

Clearing

Point selection

Point setting

Length


Diameter

Cut Forecasty:

N 16	→ 16	L 186	→ 186
S 87	→ 87	T 446	→ 445

Offline
 Foreman
 14-12-2021
15:31:32
v6.0.72.32850-rc
d05b2a097-Release

Point selection → The Next point can be selected by pressing the highlighted arrow.



Production
Last 1000 km
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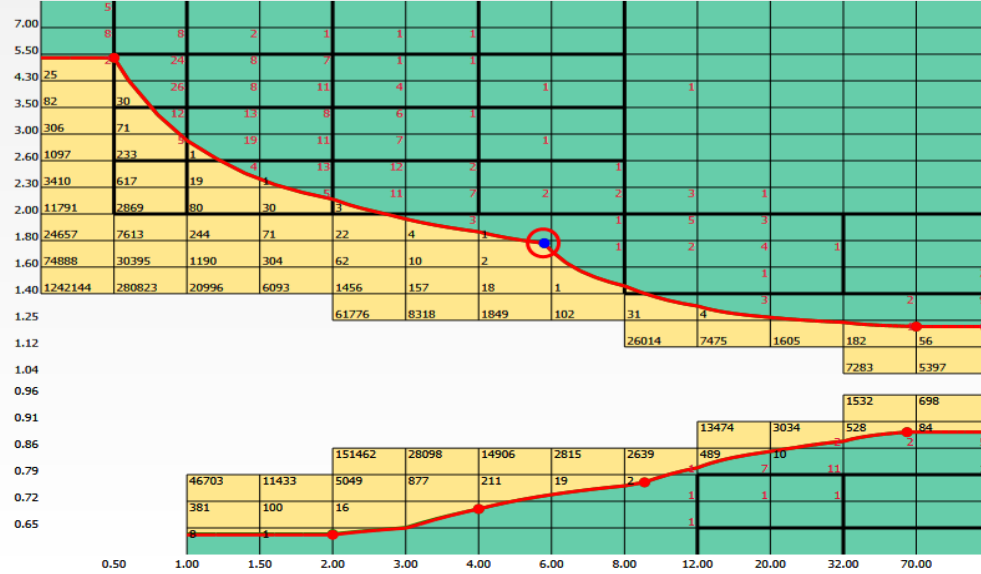
Diagnosis

System

Setup

Settings > Article > M-36SRLC > NSLT

Display Mode Fine In Production G2 (1-72)



Cut Forecasty:

N	16	→	16	L	186	→	186
S	87	→	87	T	446	→	445

D Curve

Clearing On

Point selection

←
→

Point setting

Length 5.8

Diameter 1.78

↑
↓
←
→
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🏠 Offline




👤 Foreman

🕒 14-12-2021
15:33:20
v6.0.72.32850-rc
d05b2a097-Release

Point selection → Selected points can be adjusted with the help of navigation arrows or by entering the setting values.



Production
Last 1000 km

DATA

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Setup

Settings > Article > M-36SRLC > NSLT

Display Mode Fine In Production G2 (1-72)

D Curve

Clearing On

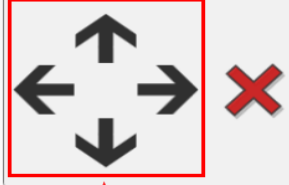
Point selection

← →

Point setting

Length 5.8

Diameter 1.96



Setting Values

Navigation Arrows

Offline

Foreman

14-12-2021
15:43:12

v6.0.72.32850-rc
d05b2a097-Release

Cut Forecasty:

N	16	L	186	→	175
S	87	→	50	T	446 → 445

Setting points → The new point can be added to desired clearing area with the help of multi-touch. Green curve displays curve setting before change, red curve is new setting. Both are visible until confirmation of setting change.

Loepfe
Production
Last 1000 km

DATA

- Dashboard
- Monitoring
- Quality

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- Machine
- Planning table

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- Diagnosis
- System
- Setup

Settings > Article > M-36SRLC > NSLT

Display Mode Fine In Production G2 (1-72)

D Curve

Clearing On

Point selection

← →

Point setting

Length 70.0

Diameter 1.22

↑
← → ↓
✖

Cut Forecasty:

N 16	→ 16	L 186	→ 88
S 87	→ 0	T 446	→ 445

Loepfe

Offline

Foreman

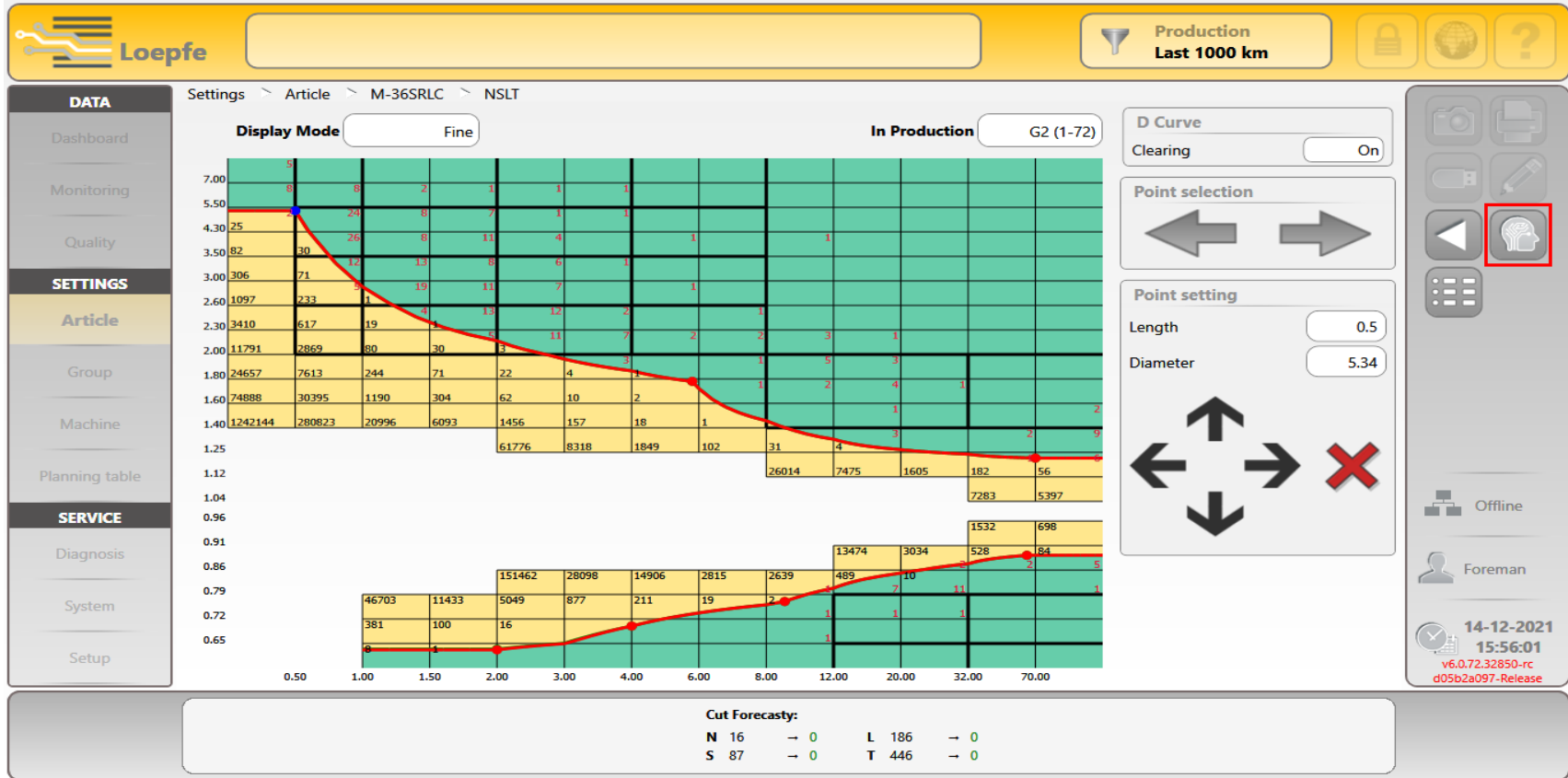
14-12-2021
15:51:28
v6.0.72.32850-rc
d05b2a097-Release

Setting points → Numerical values of all setting points can be seen on a single page by pressing this button.

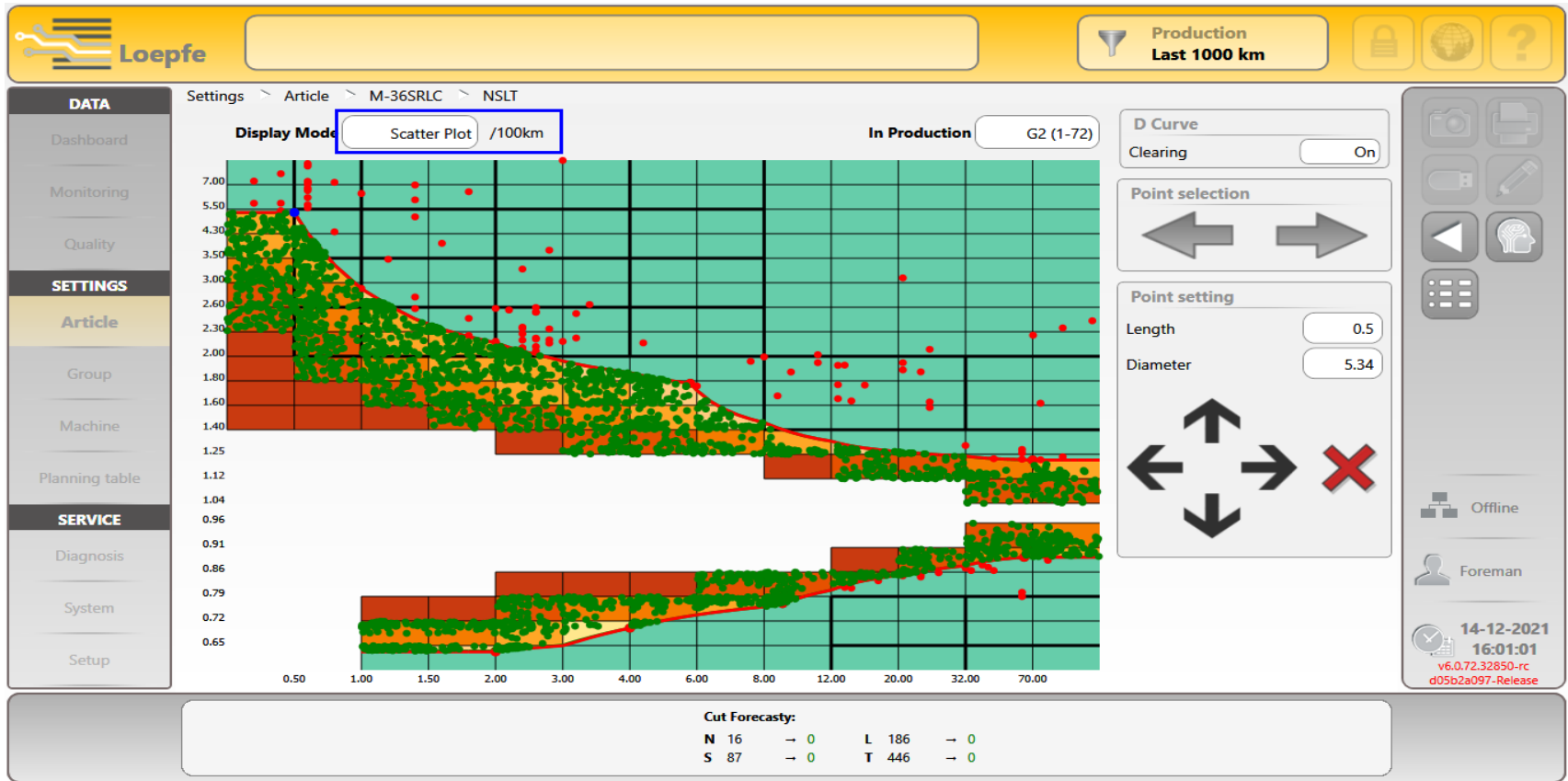
The screenshot shows the Loepfe software interface. At the top, there is a navigation bar with the Loepfe logo, a search bar, and a 'Production Last 1000 km' indicator. Below the navigation bar, the breadcrumb trail reads 'Settings > Article > M-36SRLC > NSLT (Point list)'. The main content area displays two tables of setting points. The left table lists 'Thick ID' points (0-15) with columns for 'Diameter' and 'Length'. The right table lists 'Thin ID' points (0-7) with columns for 'Diameter' and 'Length'. A yellow arrow points to a button in the top right corner of the interface, which is circled in yellow. The button is located in the right-hand sidebar area, above the 'Offline' and 'Foreman' status indicators. The bottom of the interface shows the article name 'M-36SRLC' and a footer with the Loepfe logo.

	Diameter	Length		Diameter	Length
Thick ID 0	5.34	0.5	Thin ID 0	0.56	2.0
Thick ID 1	3.69	1.0	Thin ID 1	0.70	4.0
Thick ID 2	3.49	1.5	Thin ID 2	0.77	9.1
Thick ID 3	2.64	1.5	Thin ID 3	0.89	65.2
Thick ID 4	2.59	3.0	Thin ID 4	Off	Off
Thick ID 5	1.79	3.0	Thin ID 5	Off	Off
Thick ID 6	1.78	6.0	Thin ID 6	Off	Off
Thick ID 7	1.40	6.0	Thin ID 7	Off	Off
Thick ID 8	1.40	32.0			
Thick ID 9	1.22	70.0			
Thick ID 10	Off	Off			
Thick ID 11	Off	Off			
Thick ID 12	Off	Off			
Thick ID 13	Off	Off			
Thick ID 14	Off	Off			
Thick ID 15	Off	Off			

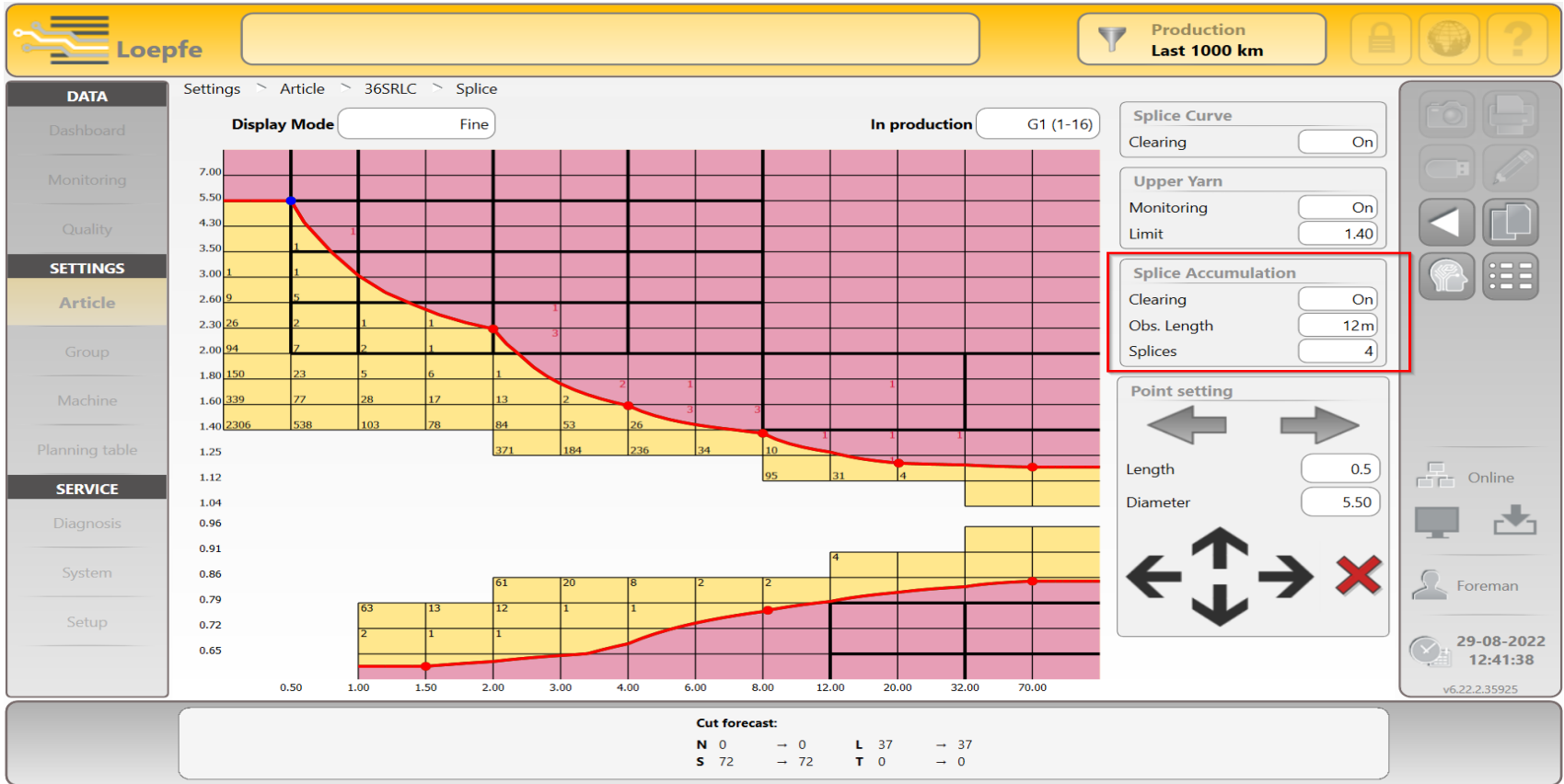
Auto Correct → On choosing “Auto Correct” mode, the system will suggest a clearing setting based on the yarn quality. This function is available **after** the first 100km of yarn wound within the group, and it is considered as an intelligent tool for **fine-tuning**.



Scatter plot → Fault distribution can be seen in the scatter plot for further optimization of settings.



Splice Accumulation clearing → Repeated splices at defined length will be removed. Obs. length 1-80m and splices 2-20.



NSLT cluster → Periodical and non-periodical faults can be detected in cluster channels. Clearing can be switched On or Off for individual cluster channels. Observation length and No. of faults can be set accordingly.

DATA

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Settings > Article > M-36SRLC > NSLT Cluster

Nep Cluster

Clearing

Obs. Length

Faults

Events

Short Cluster

Clearing

Obs. Length

Faults

Events

Long Cluster

Clearing

Obs. Length

Faults

Events

Thin Cluster

Clearing

Obs. Length

Faults

Events

Cluster settings

◀

Offline

Foreman

In Production

G2 (1-72)

14-12-2021

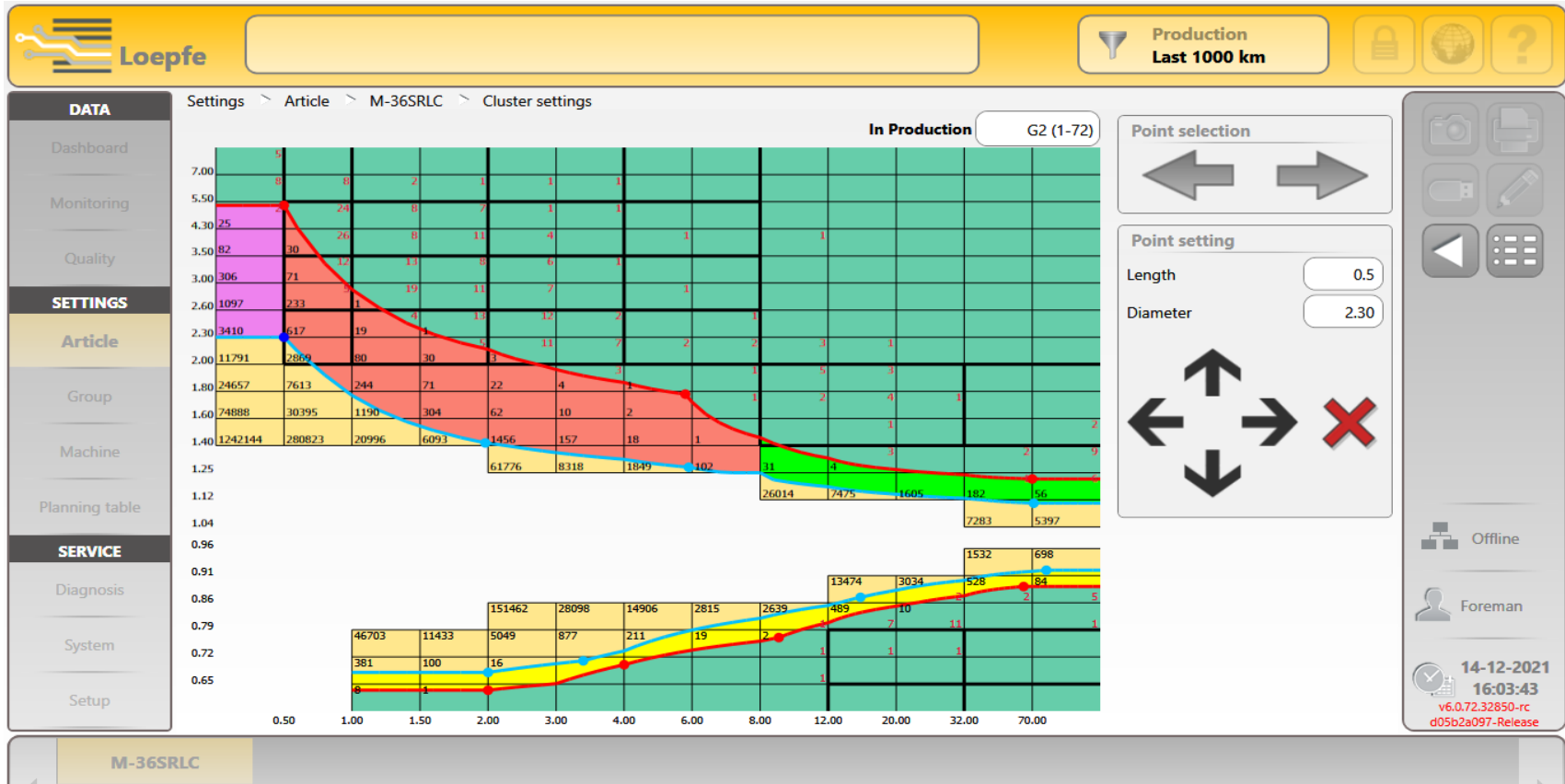
16:05:44

v6.0.72.32850-rc

d05b2a097-Release

M-36SRLC

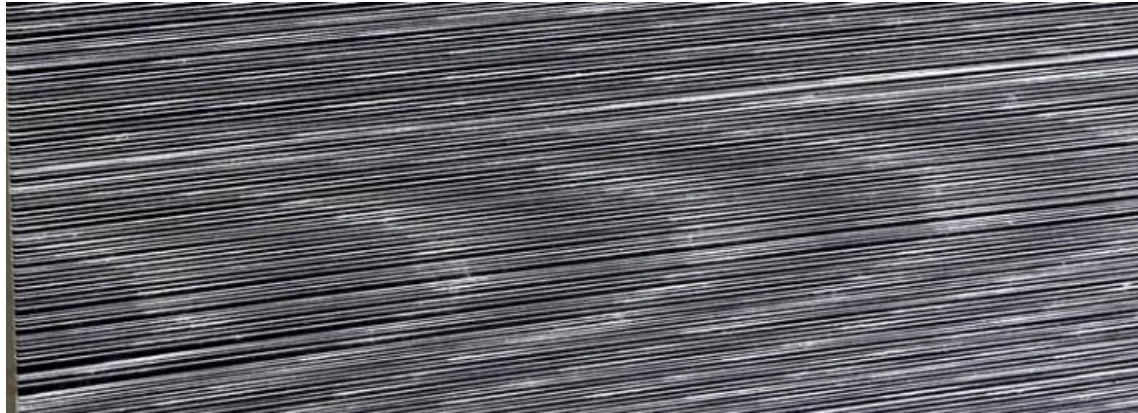
NSLT cluster settings → Tab on the matrix and define the cluster clearing curve. **Pink** – Nep cluster, **Red** – Short cluster, **Green** – Long cluster, **Yellow** – Thin cluster.



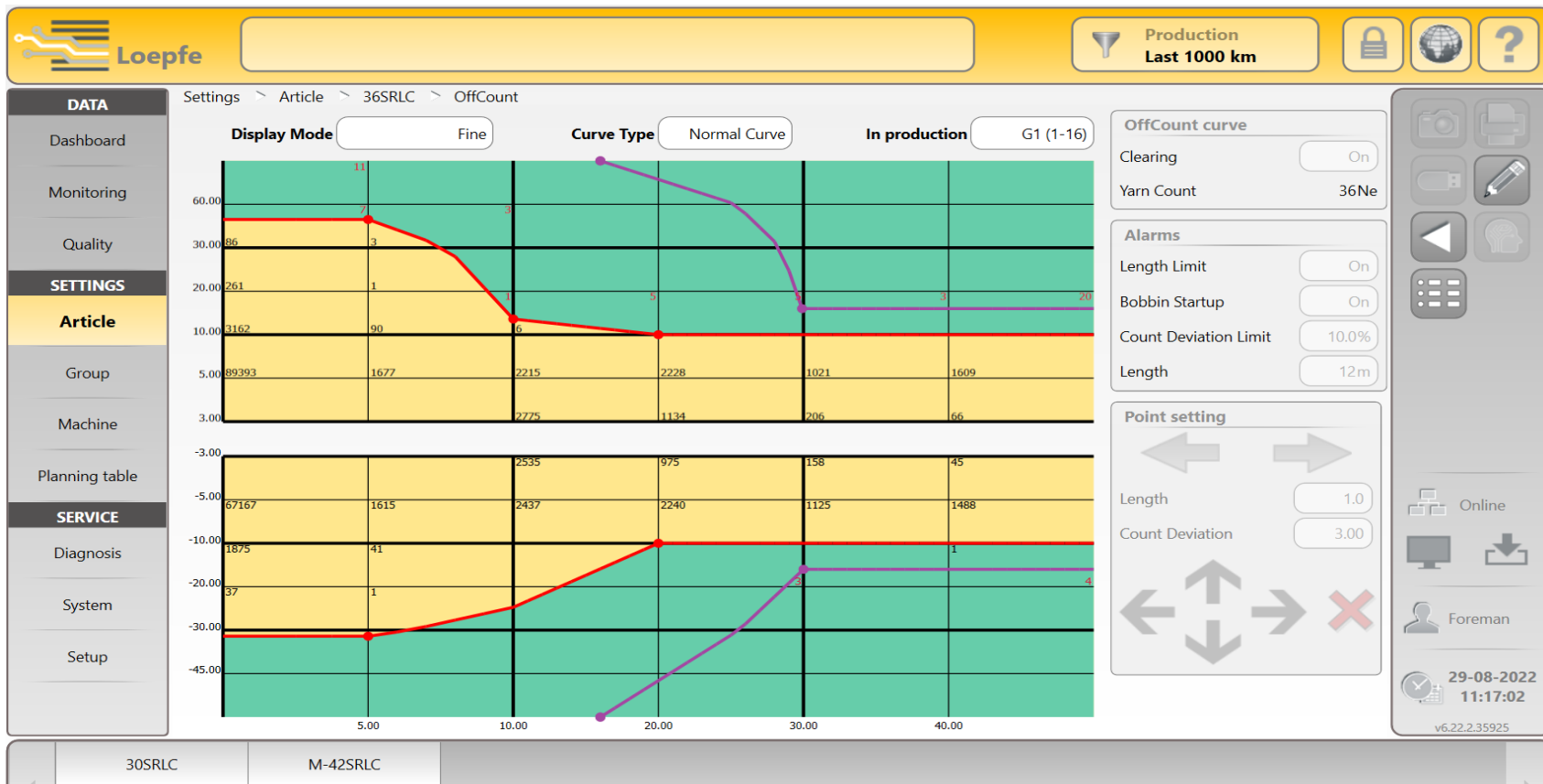
Nep Cluster → This kind of periodical nep faults can be detected in Nep cluster.



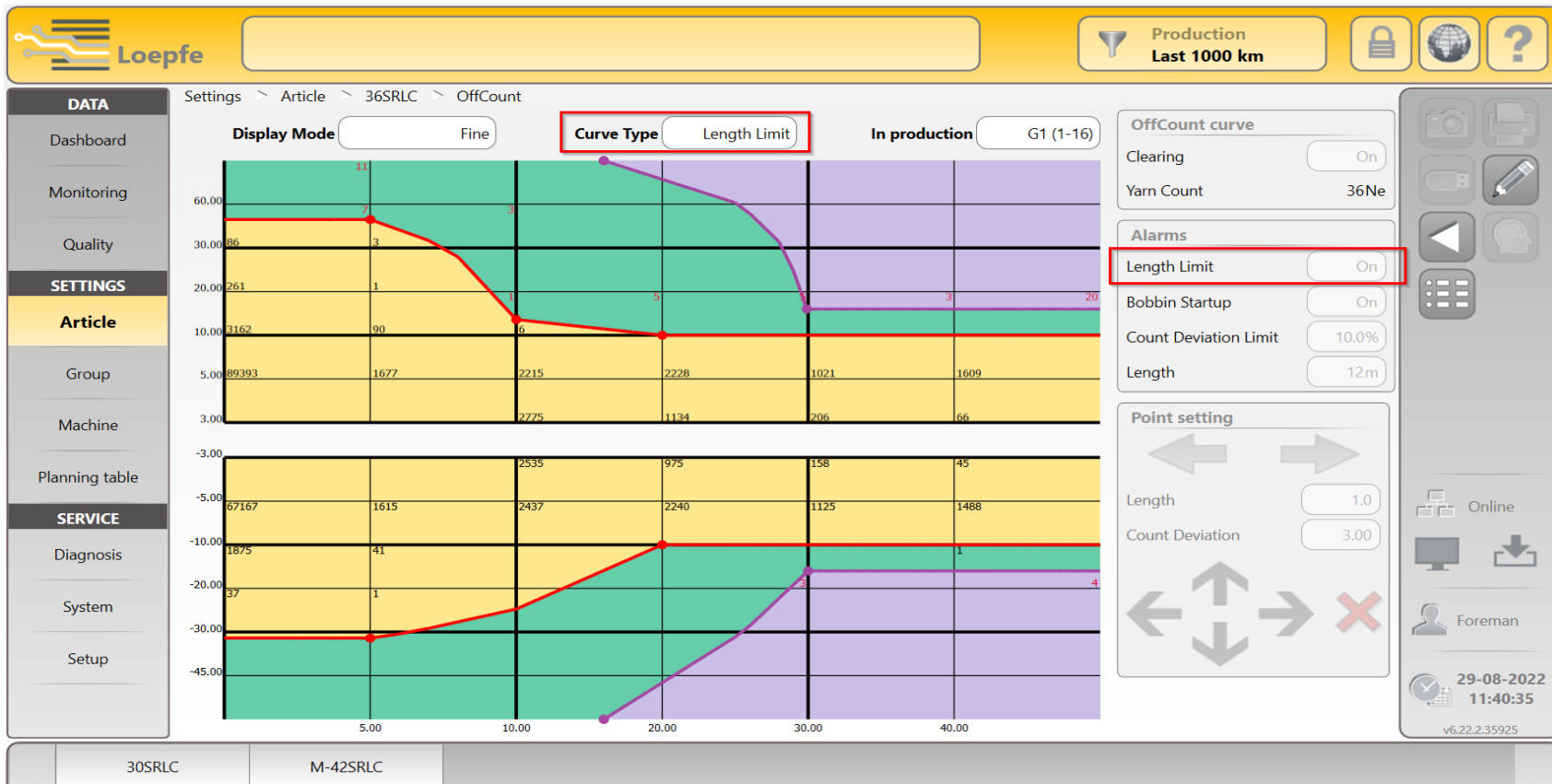
Short Cluster → Periodical and Non-periodical faults can be detected in short cluster.



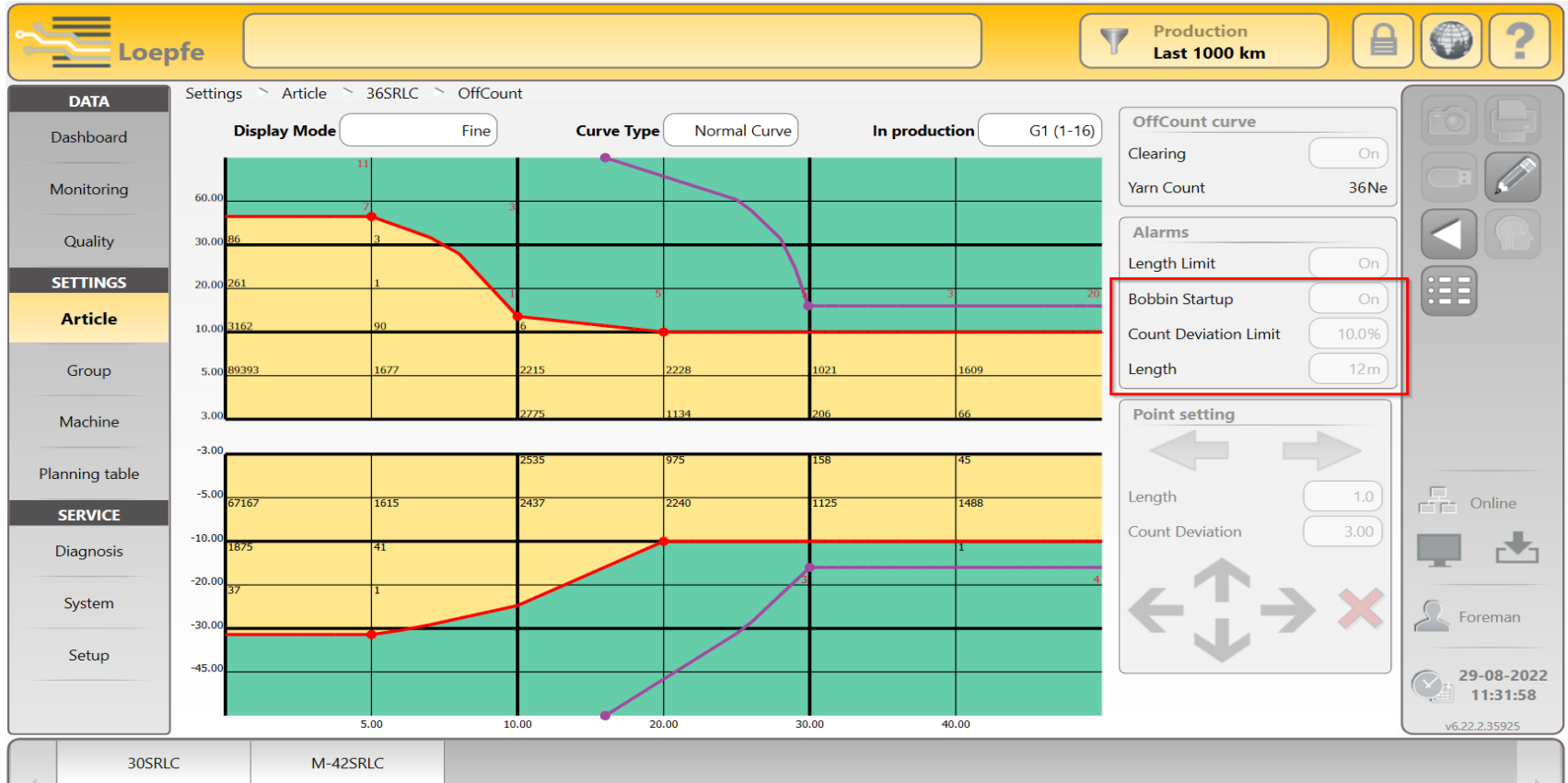
Count clearing → The red clearing curve can be plotted with setting points. The total clearing length is 50m. Classification is introduced for easy optimization of settings and to check the quality of the running material. This shows the count variation within the bobbin.




Length Limit Alarm → The purple alarm curve can be plotted with setting points. Bobbins with faults classifications which touch the alarm curve will be rejected immediately. The feature is also available for the optional SFI/D and OffColor clearing.



Bobbin Startup Alarm → The feature is active only after bobbin change for the defined length and deviation. Wrong count variations after bobbin change will be detected and rejected immediately. The feature is also available for the optional OffColor clearing.



Missing Core clearing → Detection of missing and off-center core can be done with separate channels based on OffCount measurement. The missing core is detected as a negative count deviation in the purple field, which size and position depends on core count, core draft, sensitivity setting and observation length by numerical input.



▼
Production
Last 1000 km

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Setup

Settings > Article > M-36SRLC > Core

Display Mode Fine

Missing Core

Clearing On

Nominal Yarn Count 36.0Ne

Sheath Material CO

Core Count Unit Den

Core Count 5.0

Core Draft 1.00

Core Material EA - Elastane

Sensitivity 10

Obs. Length 15m

OffCenter Core

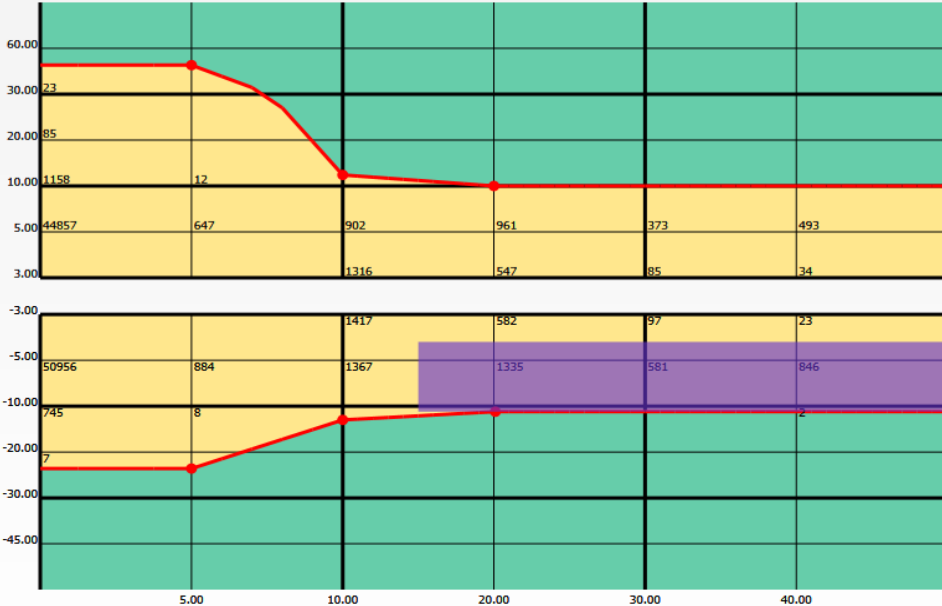
Clearing Off

Limit 10.0%

Limit Suggestion -

Obs. Length 1.5m

In Production
G2 (1-72)



60.00						
30.00	23					
20.00	85					
10.00	1158	12				
5.00	44857	647	902	961	373	493
3.00			1316	547	85	34
-3.00						
-5.00	50956	884	1367	1335	581	846
-10.00	745	8				
-20.00	7		1417	582	97	23
-30.00						
-45.00						
		5.00	10.00	20.00	30.00	40.00

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Offline

👤

Foreman

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14-12-2021

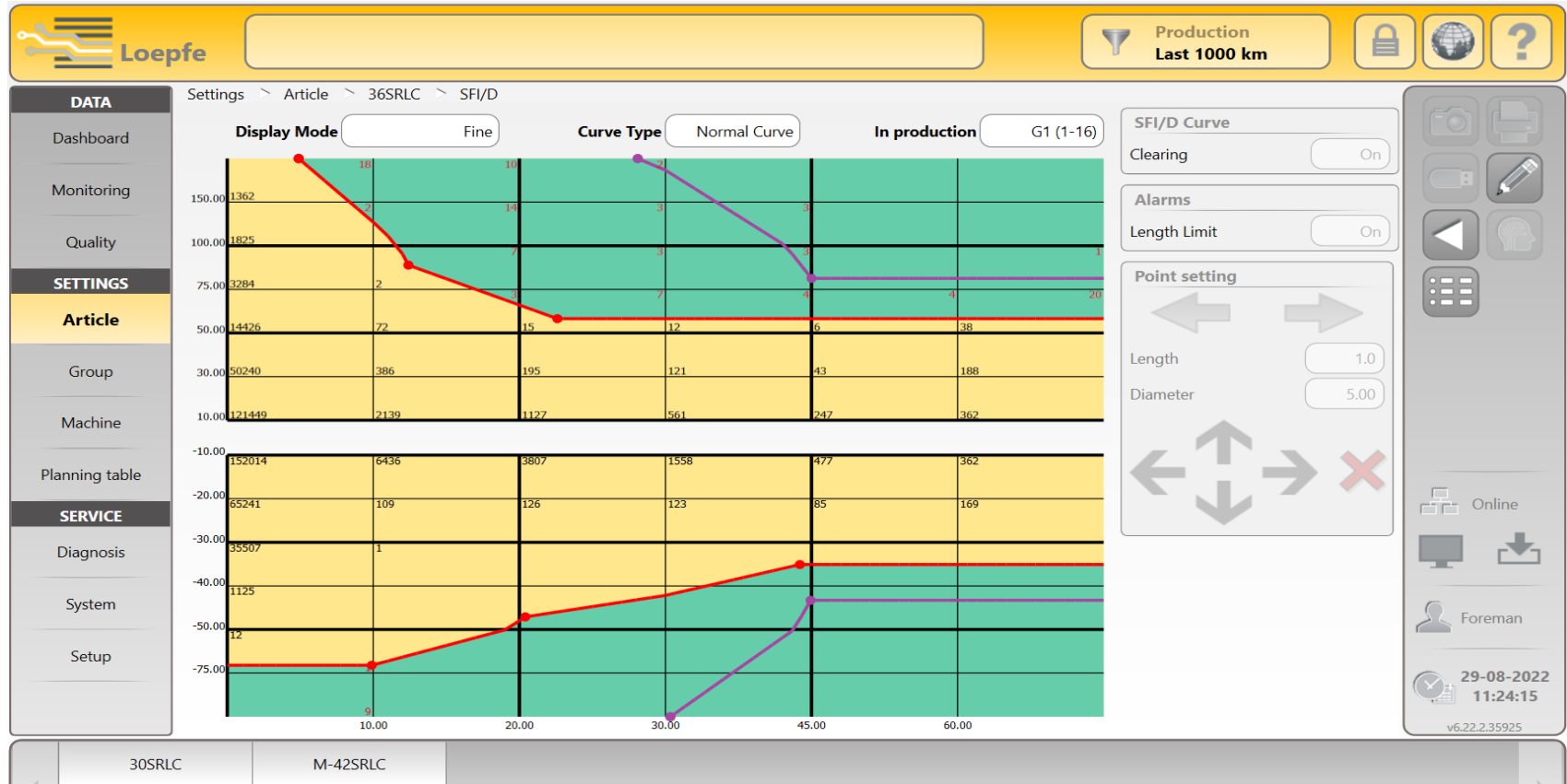
🕒

16:15:52

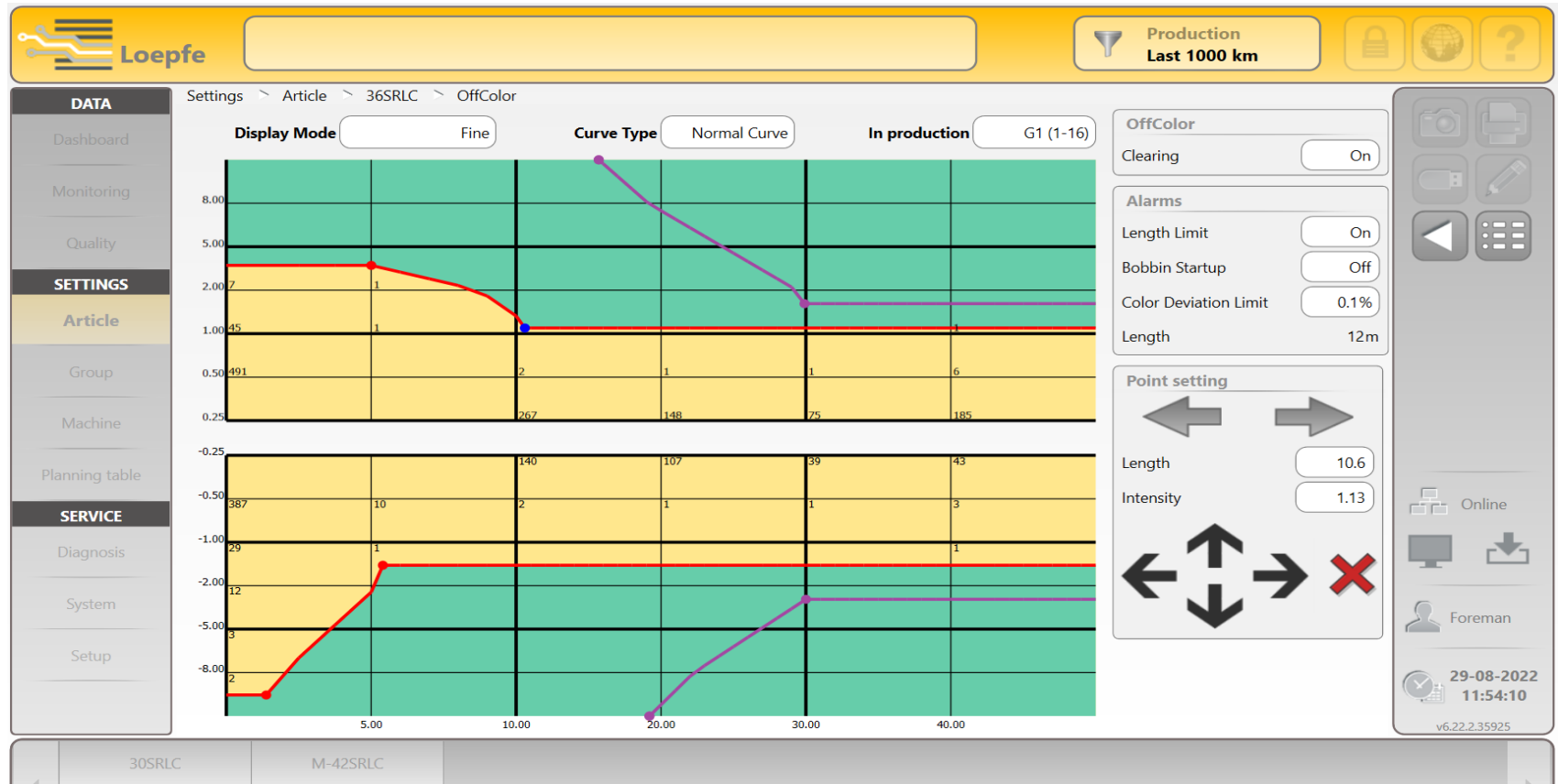
v6.0.72.32850-rc
d05b2a097-Release

M-36SRLC

SFI/D clearing (optional) – The clearing curve can be plotted with setting points. The total clearing length is 80m. Classification is introduced for easy optimization of settings and to check the quality of the running material.



OffColor clearing (optional) – The clearing curve can be plotted with setting points. The total clearing length is 50m. Classification is introduced for easy optimization of settings and to check the quality of the running material.




RGB Foreign matter clearing

Advantages of new powerful RGB foreign matter sensor

- Improved detection of very light color contamination
- Distinguish colored foreign fiber from organic matter
- Dedicated clearing and classification of foreign fiber and organic matter
- Improved detection of periodical foreign matter faults (F cluster)
- Additional classes for I, R, O classes. Those are classified as I0, R0 and O0.
- Reduced foreign matter cuts due to intelligent organic matter channel
- Fault color classification in last cut history, for raw white yarns
- Fault color mapping in FD quality screen, for raw white yarns

F Configuration → There are two curves, Red – F dark and Brown - Organic

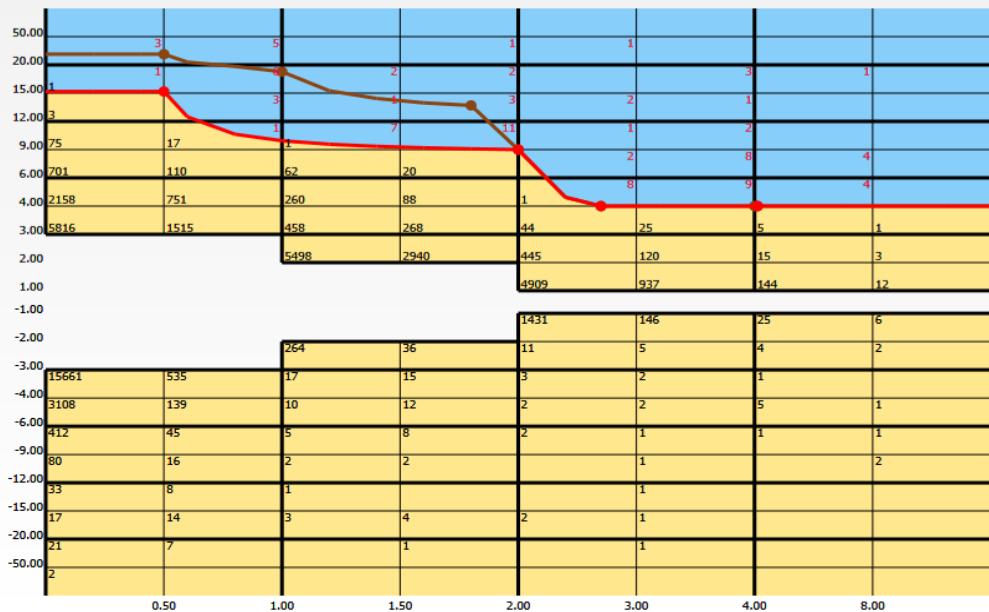


Production
Last 1000 km

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Settings > Article > 30S RL > Foreign Matter

Display Mode: Fine F Type: Foreign Matter In Production: G1 (1-10)



50.00								
20.00	3	5		1		1		
15.00	1		2	2		3		1
12.00	3	3	4	3		2		1
9.00	25	17	1	7	11	1		2
6.00	201	110	62	20		8		4
4.00	2158	751	260	88	1			4
3.00	5816	1515	458	268	44	25	5	1
2.00			5498	2940	445	120	15	3
1.00					4909	937	144	12
-1.00								
-2.00					1431	146	25	6
-3.00			264	36	11	5	4	2
-4.00	15661	535	17	15	3	2	1	
-5.00	3108	139	10	12	2	2	5	1
-6.00	412	45	5	8	2	1	1	1
-7.00	80	16	2	2		1		2
-8.00								
-9.00	33	8	1			1		
-10.00								
-11.00	17	14	3	4	2	1		
-12.00								
-13.00	21	7		1		1		
-14.00								
-15.00	2							
-16.00								
-17.00								
-18.00								
-19.00								
-20.00								
-21.00								
-22.00								
-23.00								
-24.00								
-25.00								

F Configuration

Clearing Dark On

Clearing Bright Off

Clearing Organic On

Point selection

← →

Point setting

Length

Intensity

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←

30S RL

Offline

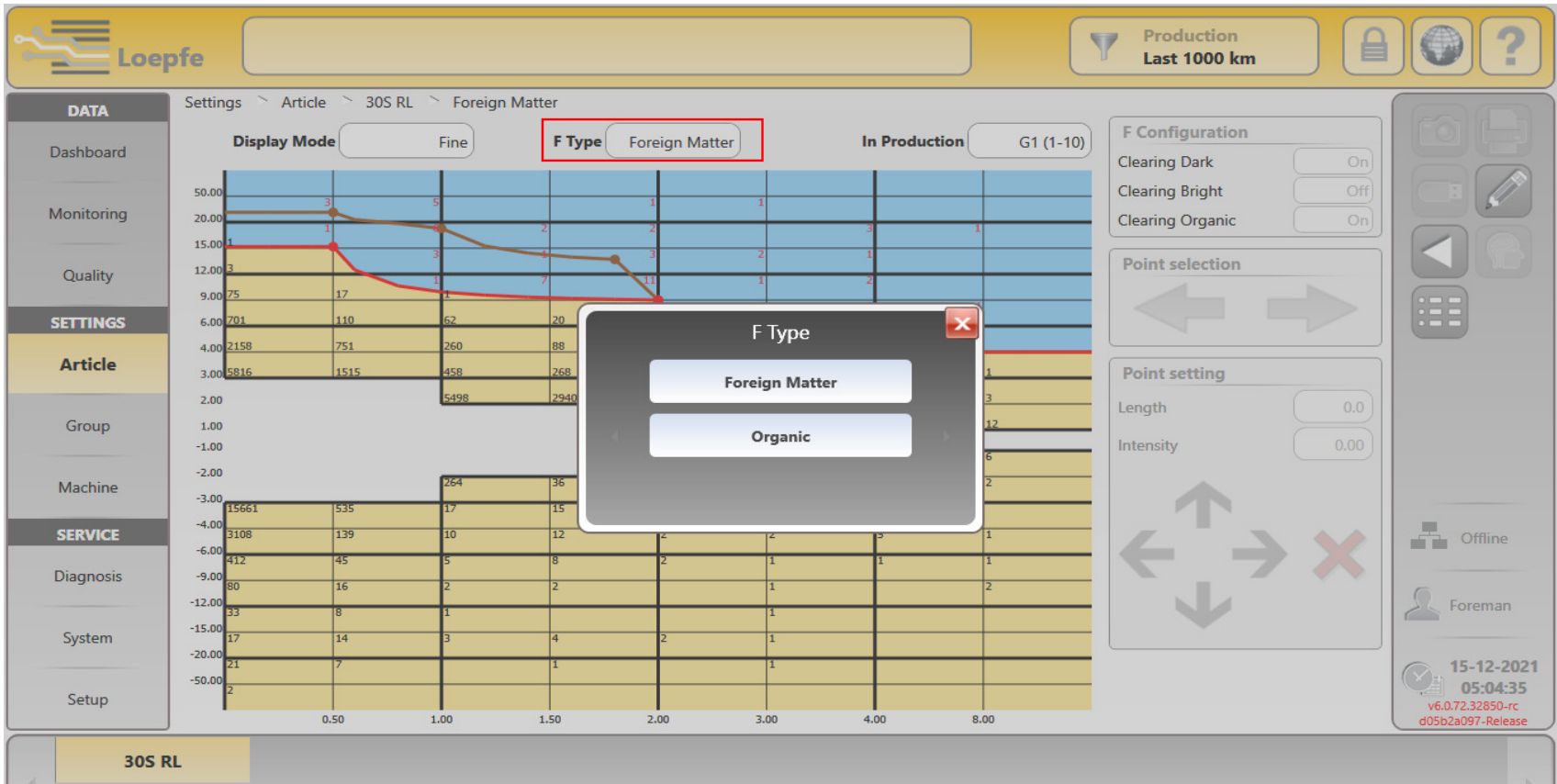
Foreman

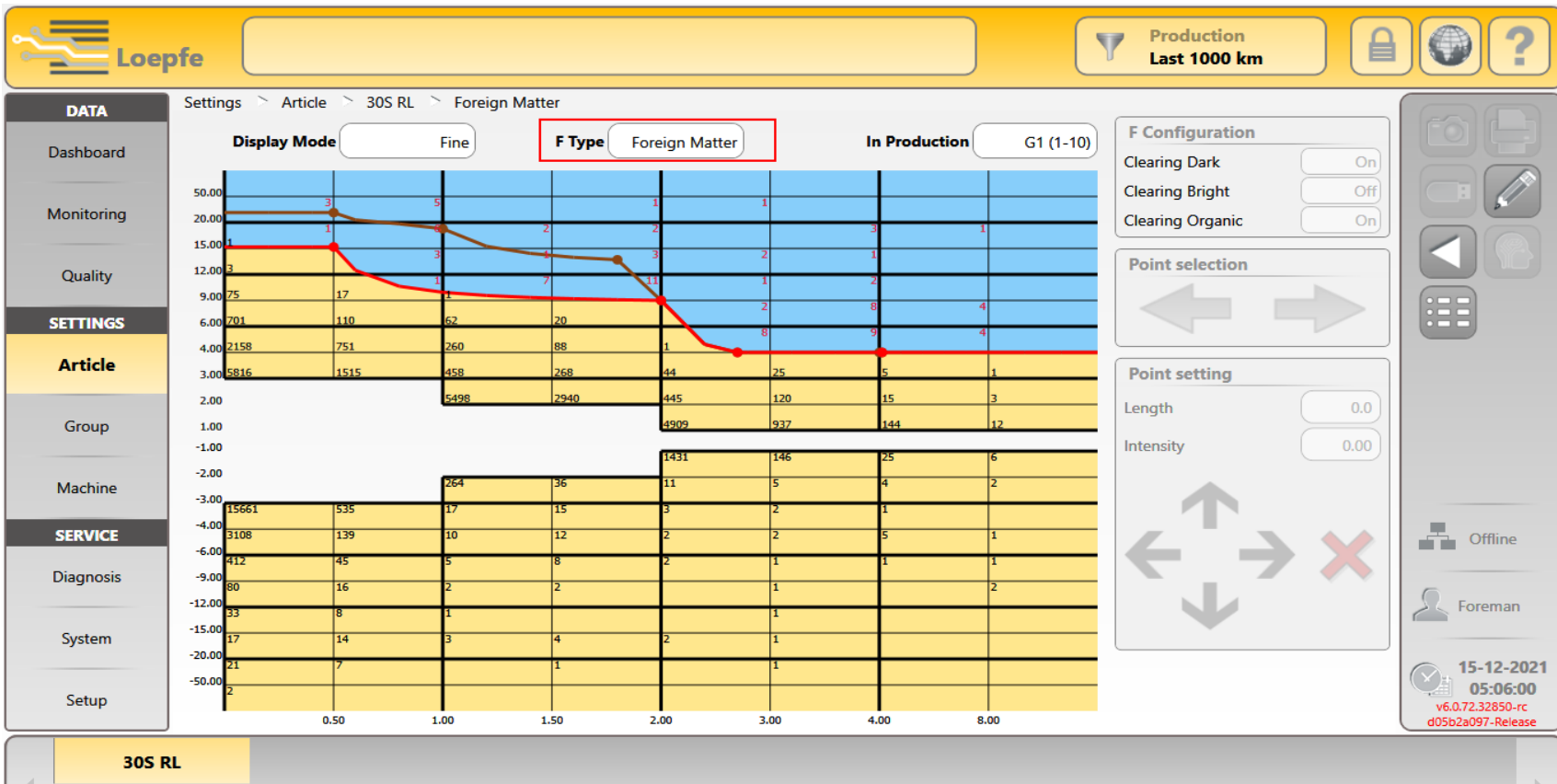
🕒 15-12-2021 05:03:12

v6.0.72.32850-rc

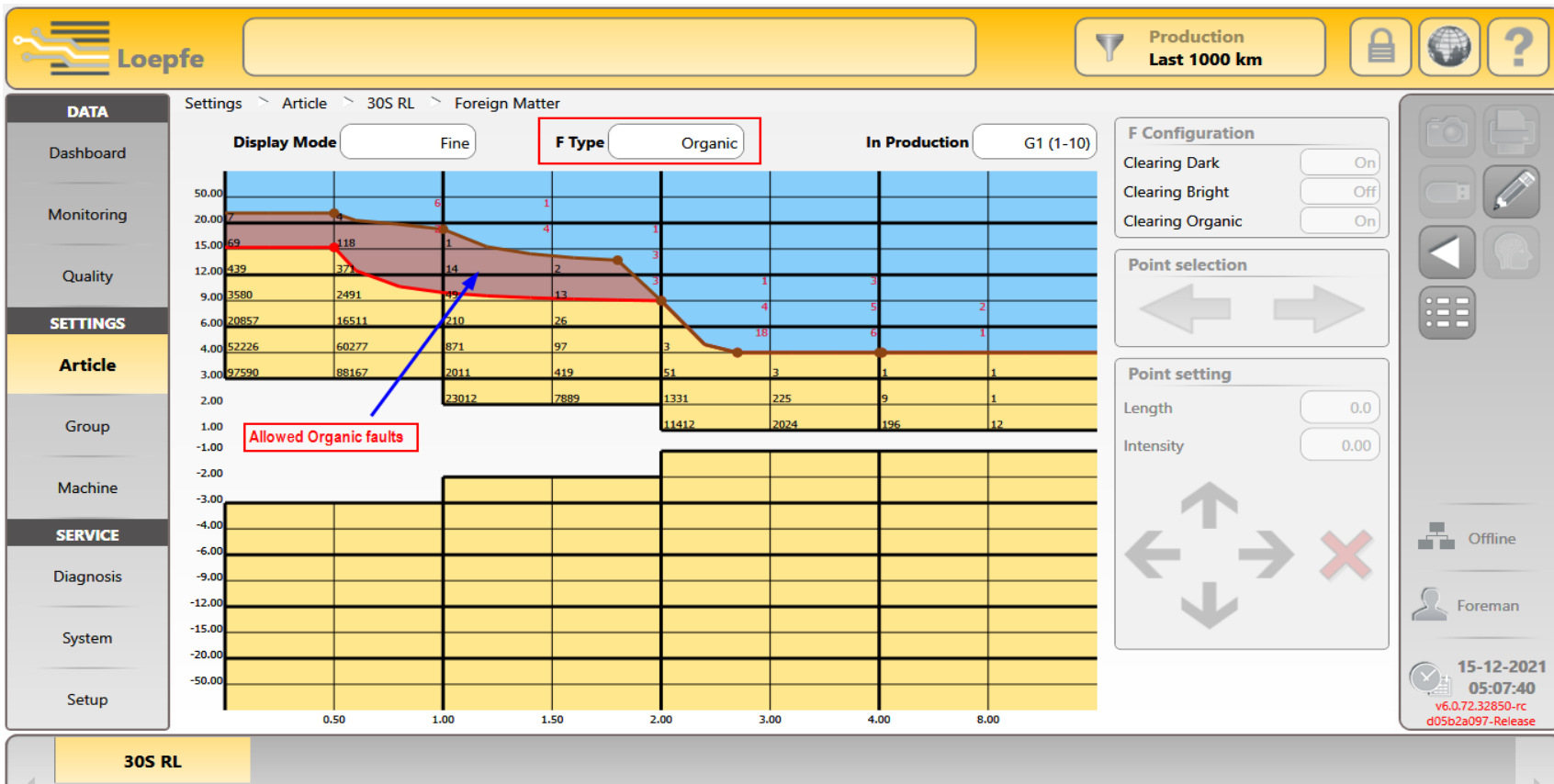
d05b2a097-Release

F Type → Foreign Matter and Organic can be switched.

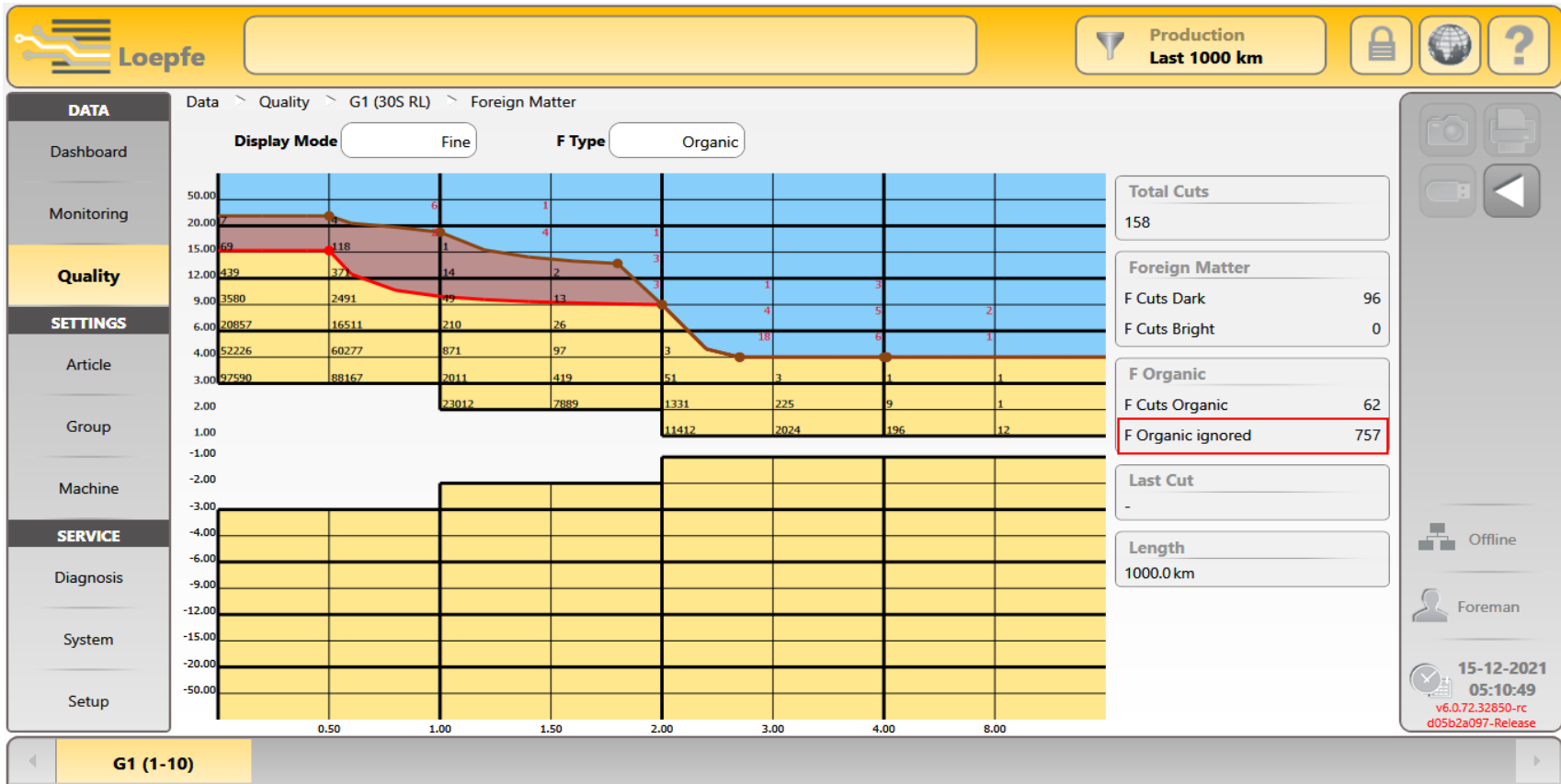




Organic → Organic faults like seed coats, branches and Jute are classified in Organic. Organic faults classified between F Dark curve and Organic are not cleared. This will reduce the total number of foreign matter cuts.



F Organic → Total F cuts can be reduced by optimizing the organic clearing. A total number of allowed organic faults can be seen in class data. Those are 'saved' F cuts.



F color classification → Every foreign matter cut is classified with its color in the last cut history.

Service > Diagnosis > TK3 > Last Cut

Time	Cut	Class		Length	Intensity
15:55:50	F Cut Organic	D-R1.2	■	2.40cm	6.00
15:55:27	F Dark	D-I2.3	■	1.60cm	8.00
15:54:05	Runout/Yarnbreak			0	0
15:53:44	F Dark	D-R1.2	■	2.40cm	4.70
15:51:45	Runout/Yarnbreak			0	0
15:50:49	L Cut	F.5		15.20cm	1.78
15:49:32	Runout/Yarnbreak			0	0
15:48:57	F Cut Organic	D-S4.1	■	0.40cm	23.90
15:47:12	Runout/Yarnbreak			0	0
15:47:03	L Cut	F.6		16.00cm	1.87
15:45:44	F Cut Organic	D-I3.2	■	1.20cm	16.60
15:44:52	S Cut	A3.2		0.80cm	4.70
15:44:40	Runout/Yarnbreak			0	0
15:44:23	F Cut Organic	D-S4.1	■	0.40cm	22.20
15:43:23	P	P3.4		0.60cm	53
15:42:55	S Cut	B4.3		1.60cm	5.58
15:42:48	L Cut	F00.4		12.80cm	1.33
15:41:56	S Cut	B2.4		1.60cm	3.28
15:41:00	S Cut	A4.2		0.60cm	9.29

1 3 5 7 9 11 13 15

Loepfe

Production Last 1000 km

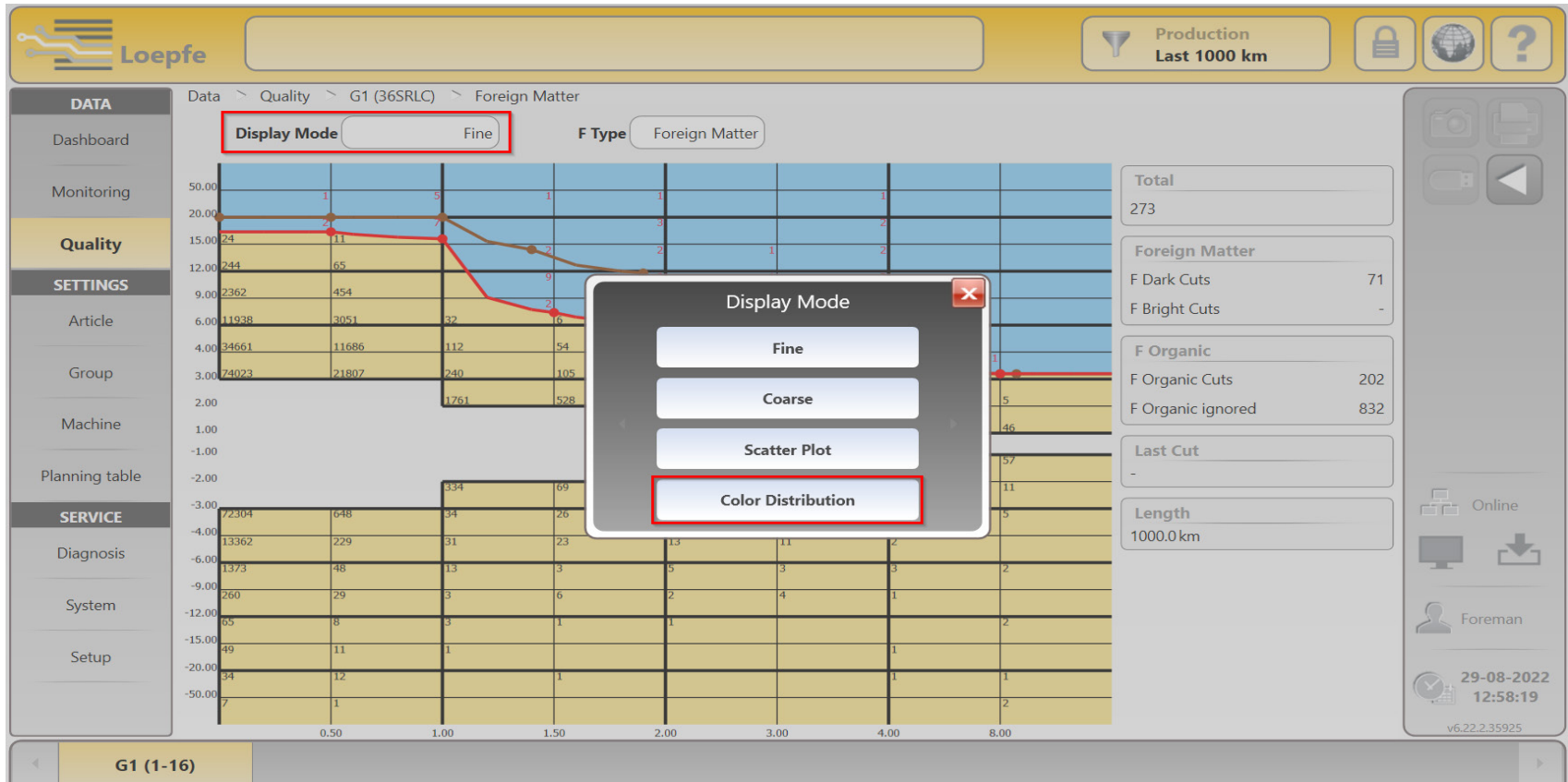
Online

Foreman

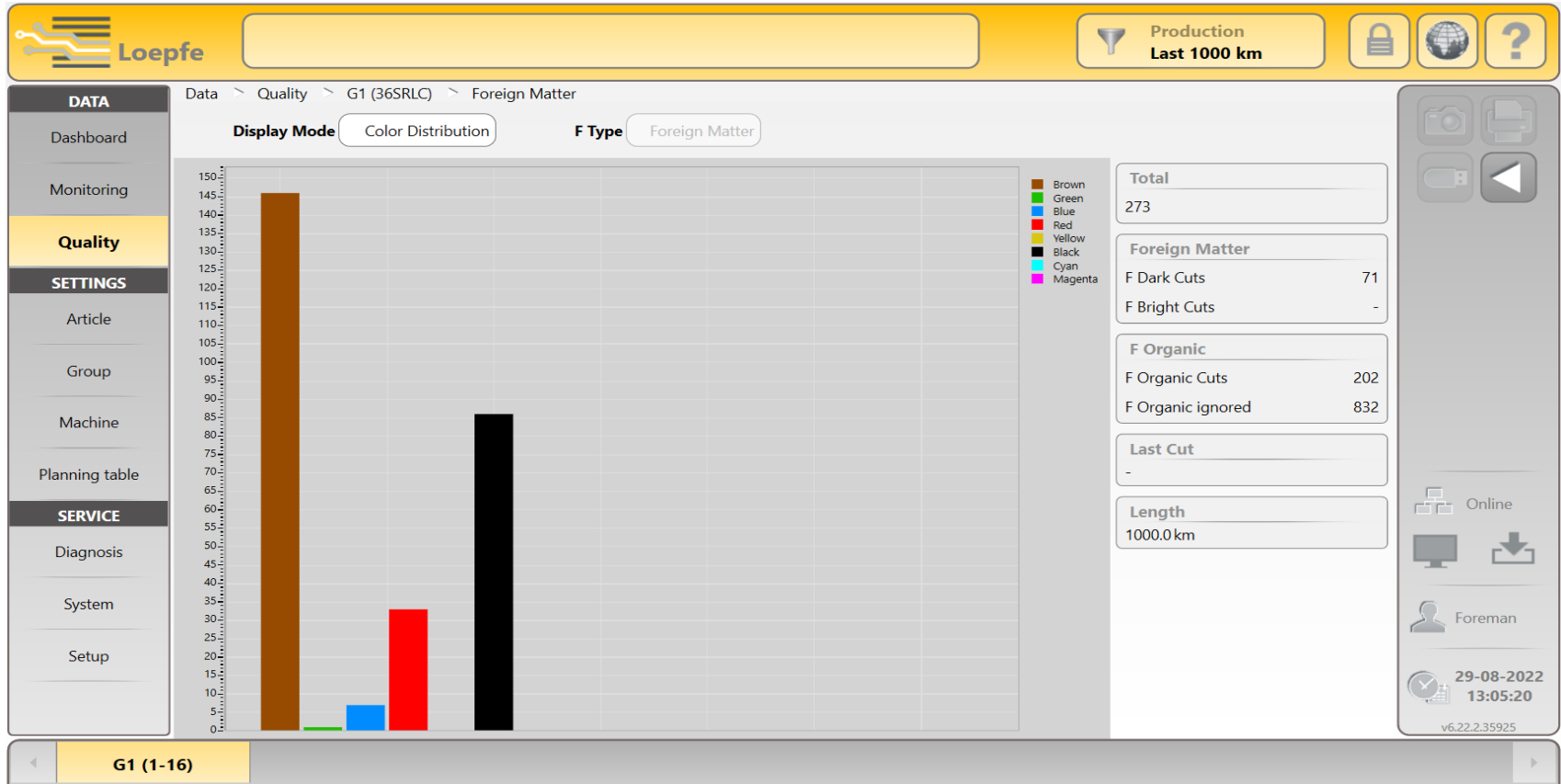
29-08-2022 12:53:09

v6.22.2.35925

F color distribution → The foreign matter color classifications get mapped in the Color Distribution.



F color distribution → The foreign matter color classifications are categorised in to 8 main color in the Color Distribution.



First startup of YarnMaster[®] PRISMA

YarnMaster® PRISMA comes with an all-new control unit hardware called LZE-6, it can be used for YM PRISMA as well as YM ZENIT+

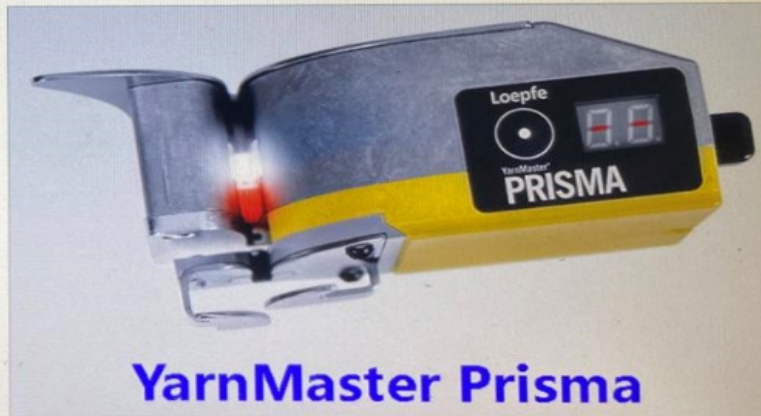
The type of applicable clearer system needs to be set during its 1st start-up:

1. Switch on/boot the LZE-6
2. Select the applicable clearer system
3. Confirm the selected clearer system (this will install the appropriate clearer GUI environment)
4. Update the Master Module firmware
5. LZE will boot into setup wizard for further clearer configuration (see chapter 4 in the operating manual)

Choose the applicable clearer system



Please choose clearer system:



Confirm the selected clearer system:

SPINNING SOLUTIONS

 Loepfe

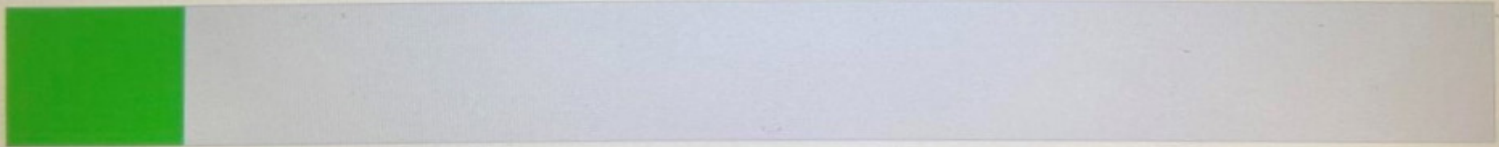
Is this correct clearer system Prisma (Lze-6.0.51.1)?



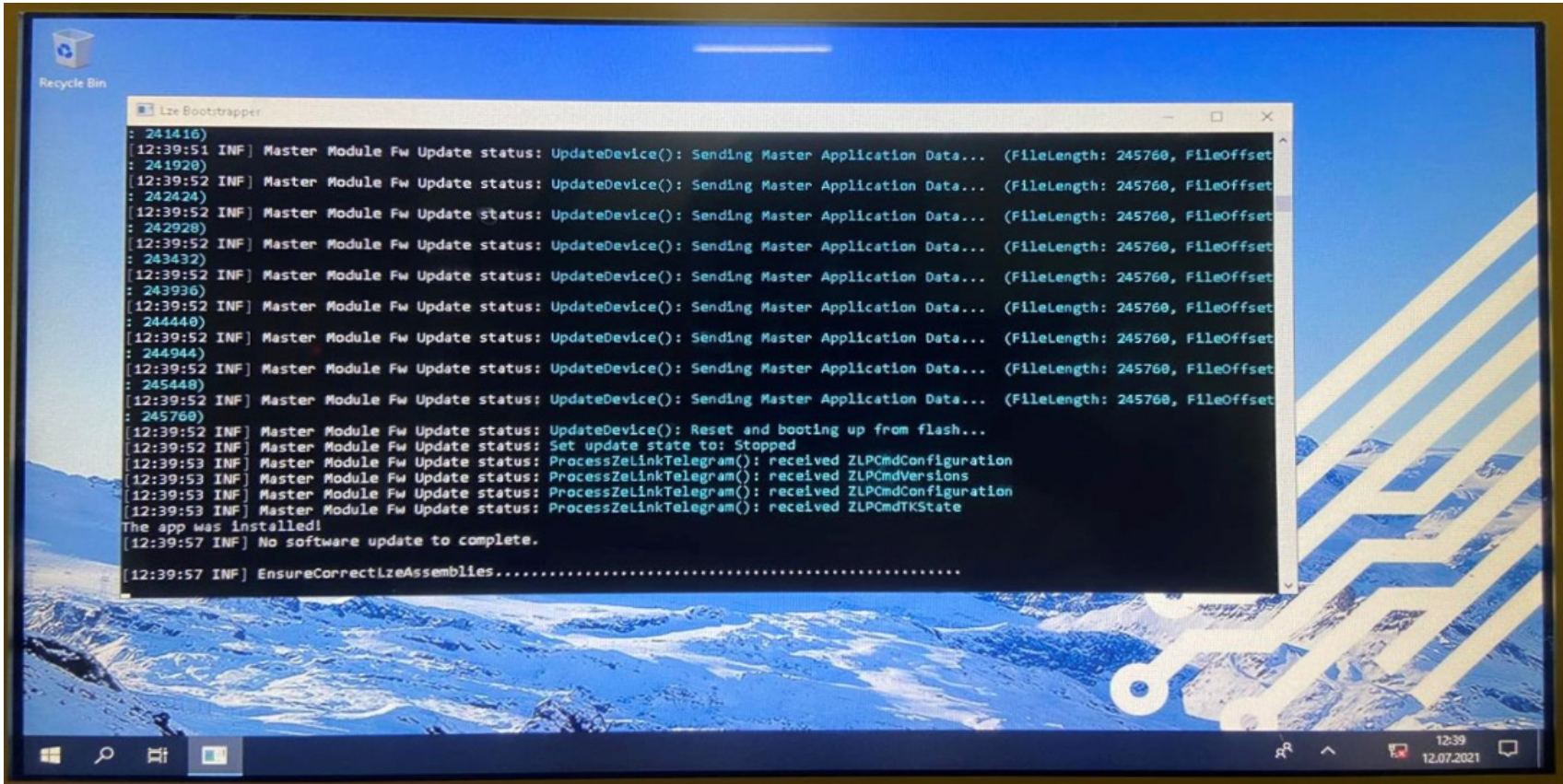
The image shows a Loepfe Prisma clearer system, a stainless steel device with a yellow base and a digital display showing '88'. The device is shown from a three-quarter perspective, highlighting its complex internal structure and the digital readout.



Updating Master Module firmware!



Installation complete and application start-up:



Complete the setup wizard and re-confirm LZE-6 correct setup after the control unit has successfully rebooted.

Go to “Machine” menu and select base setting. Check for correct machine type, total spindles and sensing head type.

1. Check machine type is correctly set in “Machine Type”
2. Check/correct total number of spindles in “Total Spindles”
3. Check/confirm correct type of sensing head in “Sensing Head Type” (DM, DMF, DMFP)
4. If the machine is equipped with a wet splicer, the wet splicer option needs to be On.
5. Save the changes!

Base setting → With the introduction of mass sensor, TK type is classified as DM, DMF, DMFP.

The screenshot displays the Loepfe machine settings interface. At the top, there is a yellow header bar with the Loepfe logo on the left, a search bar in the center, and a 'Production Last 1000 km' indicator on the right. Below the header, a navigation menu on the left lists categories: DATA (Dashboard, Monitoring, Quality), SETTINGS (Article, Group), Machine (highlighted), Planning table, and SERVICE (Diagnosis, System, Setup). The main content area shows the 'Base Settings' for a 'Savio Orion/Polar' machine. The settings are as follows:

Setting	Value
Machine Type	Savio Orion/Polar
Machine Name	MC 22
MMTop Link	On
Total Spindles	72
Yarn Count Unit	Ne
Sensing Head Type	DMFP
Splice Check Length	25 cm
Previous Shift	km
Wet Splicer	Off

On the right side of the interface, there is a vertical toolbar with icons for camera, printer, USB, pencil, checkmark, and X. Below this toolbar, there are status indicators: 'Offline' with a network icon, 'Foreman' with a user icon, and a timestamp '14-12-2021 16:21:48' with a clock icon. At the bottom right, the version information is displayed: 'v6.0.72.32850-rc d05b2a097-Release'.

Base setting → Select the type of sensing head.

The screenshot displays the Loepfe machine settings interface. At the top, the Loepfe logo is on the left, and a search bar is in the center. On the right, there is a 'Production Last 1000 km' indicator and three utility icons (lock, globe, help). The main content area is titled 'Settings > Machine > Base Settings'. A left sidebar contains navigation menus for 'DATA', 'SETTINGS', 'Machine', and 'SERVICE'. The 'Base Settings' form includes fields for 'Machine Type' (Savio Orion/Polar), 'Machine Name' (MC 22), 'MMTop Link' (On), 'Total Spindles' (72), 'Yarn Count Unit', 'Sensing Head Type', 'Splice Check Length', 'Previous Shift', and 'Wet Splicer'. A modal dialog box titled 'Sensing Head Type' is open, showing 'none' as the current selection and three options: 'DM', 'DMF', and 'DMFP'. The right sidebar contains various control icons, a status indicator (Offline), a user profile (Foreman), and system information (14-12-2021 16:22:39, v6.0.72.32850-rc, d05b2a097-Release).

Wet splicer → If the machine is equipped with a wet splicer, the option wet splicer should be On.

The screenshot displays the Loepfe machine settings interface. The top navigation bar includes the Loepfe logo, a search bar, and a 'Production Last 1000 km' indicator. The left sidebar is divided into three main sections: DATA (Dashboard, Monitoring, Quality), SETTINGS (Article, Group, Machine, Planning table), and SERVICE (Diagnosis, System, Setup). The 'Machine' section is currently selected. The main content area shows 'Base Settings' for a 'Savio Orion/Polar' machine. The settings listed are: Machine Name (MC 22), MMTop Link (On), Total Spindles (72), Yarn Count Unit, Sensing Head Type, Splice Check Length, and Previous Shift. The 'Wet Splicer' option is highlighted with a red box. A modal dialog box titled 'Wet Splicer' is open, showing the current status as 'none' and two buttons: 'Off' and 'On'. The 'On' button is highlighted. The bottom right corner of the interface shows system status: Offline, Foreman, and a timestamp of 14-12-2021 16:23:32, along with version information: v6.0.72.32850-rc d05b2a097-Release.

Firmware update

Before starting the machine for the first time it might be necessary to update the clearer's bootloader and/or firmware

1. Go to "System" menu
2. Select "Firmware Update"
3. Check firmware and bootloader version on all listed spindles. If any version is shown in "Red" color, a firmware or bootloader update is required
4. Log in with foreman password "12911291"
5. Press download button "TK (bootloader/firmware)"
6. Once the update is successful, the "Red" color will change into "Black"

Firmware update → Press download button to install the firmware.

The screenshot displays the Loepfe control interface for a firmware update. The top navigation bar includes the Loepfe logo, a search field, and a 'Production Last 1000 km' indicator. The left sidebar contains menu items for DATA, SETTINGS, and SERVICE. The main content area is divided into several sections:

- Firmware Archive:** Lists components and their versions: Master Module (2.0.12.0), Bootloader (6.0.25.19400-24b7cc77), and Firmware (6.0.77.32988-0e85a2c5).
- Master Module:** Shows Version (2.0.12.0) and Update State (Application).
- Update Progress:** Displays progress bars for Master Module (100%) and TK (bootloader/firmware) (0%). A red box highlights the download button for the TK, with a red arrow pointing to it and a text box saying "Press this button".
- Spindles:** A table listing spindles 1 through 10, each with its own Firmware and Bootloader version.

Spindle	Firmware	Bootloader
1	6.0.77.32831-8da73a54	6.0.25.19400-24b7cc77
2	6.0.77.32831-8da73a54	6.0.25.19400-24b7cc77
3	6.0.77.32831-8da73a54	6.0.25.19400-24b7cc77
4	6.0.77.32831-8da73a54	6.0.25.19400-24b7cc77
5	6.0.77.32831-8da73a54	6.0.25.19400-24b7cc77
6	6.0.77.32831-8da73a54	6.0.25.19400-24b7cc77
7	6.0.77.32831-8da73a54	6.0.25.19400-24b7cc77
8	6.0.77.32831-8da73a54	6.0.25.19400-24b7cc77
9	6.0.77.32831-8da73a54	6.0.25.19400-24b7cc77
10	6.0.77.32831-8da73a54	6.0.25.19400-24b7cc77

Additional interface elements include a right-hand sidebar with camera, settings, and status icons, and a bottom status bar showing the date and time (14-12-2021 16:37:23) and version information (v6.0.72.32850-rc d05b2a097-Release).

Production
Last 1000 km

DATA

Dashboard

Monitoring

Quality

SETTINGS

Article

Group

Machine

Planning table

SERVICE

Diagnosis

System

Setup

Service > System > Firmware Update

Firmware Archive

Master Module	2.0.12.0
Bootloader	6.0.25.19400-24b7cc77
Firmware	6.0.77.32988-0e85a2c5

Master Module

Version	2.0.12.0
Update State	MasterBootLoader

Update Progress

Master Module	100 %	
<div style="background-color: green; width: 100%;"></div>		
TK (bootloader/firmware)	47 %	
<div style="background-color: green; width: 47%;"></div>		

Spindles

Spindle	Firmware	Bootloader
1	6.0.77.32831-8da73a54	6.0.25.19400-24b7cc77
2	6.0.77.32831-8da73a54	6.0.25.19400-24b7cc77
3	6.0.77.32831-8da73a54	6.0.25.19400-24b7cc77
4	6.0.77.32831-8da73a54	6.0.25.19400-24b7cc77
5	6.0.77.32831-8da73a54	6.0.25.19400-24b7cc77
6	6.0.77.32831-8da73a54	6.0.25.19400-24b7cc77
7	6.0.77.32831-8da73a54	6.0.25.19400-24b7cc77
8	6.0.77.32831-8da73a54	6.0.25.19400-24b7cc77
9	6.0.77.32831-8da73a54	6.0.25.19400-24b7cc77
10	6.0.77.32831-8da73a54	6.0.25.19400-24b7cc77

 Online

 Foreman

14-12-2021
16:39:07
v6.0.72.32850-rc
d05b2a097-Release

Firmware update → During the update, sensing heads will show “UF” in the display.



After completion of the firmware update, TK's will read the version in "Black" color. If some sensing heads firmware version remains "Red" or "Greyed-out", it's necessary to repeat the firmware update until all sensing heads are completely updated.

Loepfe Production Last 1000 km

Service > System > Firmware Update

DATA

- Dashboard
- Monitoring
- Quality

SETTINGS

- Article
- Group
- Machine
- Planning table

SERVICE

- Diagnosis
- System**
- Setup

Firmware Archive

Master Module	2.0.12.0
Bootloader	6.0.25.19400-24b7cc77
Firmware	6.0.77.32988-0e85a2c5

Update Progress

Master Module	100 %	
TK (bootloader/firmware)	100 %	

Master Module

Version	2.0.12.0
Update State	Application

Spindles

Spindle	Firmware	Bootloader
1	6.0.77.32988-0e85a2c5	6.0.25.19400-24b7cc77
2	6.0.77.32988-0e85a2c5	6.0.25.19400-24b7cc77
3	6.0.77.32988-0e85a2c5	6.0.25.19400-24b7cc77
4	6.0.77.32988-0e85a2c5	6.0.25.19400-24b7cc77
5	6.0.77.32988-0e85a2c5	6.0.25.19400-24b7cc77
6	6.0.77.32988-0e85a2c5	6.0.25.19400-24b7cc77
7	6.0.77.32988-0e85a2c5	6.0.25.19400-24b7cc77
8	6.0.77.32988-0e85a2c5	6.0.25.19400-24b7cc77
9	6.0.77.32988-0e85a2c5	6.0.25.19400-24b7cc77
10	6.0.77.32988-0e85a2c5	6.0.25.19400-24b7cc77

Online

Foreman

14-12-2021 16:40:58
v6.0.72.32850-rc
d05b2a097-Release

After the firmware update, the sensing head will show “PA”. Now the sensing head is ready to run and waiting for article Parameters.



Error → During master module or firmware update, error message “Master module is Offline” will appear for a few seconds and disappear. It’s part of the process and won’t affect the update.

The screenshot shows the Loepfe control interface with a yellow header bar. The breadcrumb navigation is 'Service > System > Firmware Update'. The left sidebar has sections for 'DATA', 'SETTINGS', and 'SERVICE', with 'System' selected. The main content area is divided into several panels:

- Firmware Archive:** Lists components and their versions: Master Module (2.0.12.0), Bootloader (6.0.25.19400-24b7cc77), and Firmware (6.0.59.30085-f72b678d).
- Update Progress:** Shows progress bars for Master Module (78%) and TK (bootloader/firmware) (100%).
- Master Module:** Shows 'Version' as 2.0.12.0 and 'Update State' as MasterUpdate. A red error message 'Master module is offline!' is displayed in a blue-bordered box.
- Spindles:** A table with 10 rows and 3 columns: Spindle, Firmware, and Bootloader. All entries show a red dash, indicating they are offline.

The right sidebar contains various icons for camera, print, edit, and navigation, along with system status indicators like 'Online', 'Service', and a timestamp '21-04-2021 15:00:20' with version 'v6.0.60.30211-rc 1660ca3b5-Release'.

Article and Group management

An article consists of settings for different clearing channels (NSLT, Foreign matter, OffCount etc.,). Articles can be “added” or “removed”, however, an article assigned to a running group can not be removed.

For article creation go to article menu

1. Press + “add” to create a new article
2. There are 3 options to create an article
 - a) New article
 - b) Copy settings from an article
 - c) Import settings from USB
3. Select your preferred option

Article creation:

The screenshot displays the Loepfe software interface for article management. At the top, there is a navigation bar with the Loepfe logo, a search bar, and a 'Production Last 1000 km' indicator. Below this is a breadcrumb trail: Settings > Article > 30SVLC-TEST2 > List. The main area contains a table of articles with columns for Article, Process, Autostart, Count, Material, Last Change, and Active in group. A modal window titled 'Add article' is open, showing three options: 'New Article' (checked), 'Copy Settings from an Article', and 'Import Settings from USB'. The '30SVLC-TEST2' article is highlighted in the table.

Article	Process	Autostart	Count	Material	Last Change	Active in group
28SRLC	Compact		28 Ne	Pure	13-02-2023 12:38:19	1
30SVLC-TEST2	Compact		30 Ne	Pure	28-12-2022 16:22:04	
24SRLC-RWG	Compact				03-11-2022 12:27:45	
26S-TEST	Compact				10-02-2023 12:07:23	
26S-TEST2	Compact				10-02-2023 12:28:10	

Add article

- New Article
- Copy Settings from an Article
- Import Settings from USB

24SRLC-RWG 26S-TEST2 **30SVLC-TEST2**

Article creation options:

New Article

The system will generate an optimum clearer “Autostart” setting based on the yarn quality or the user needs to enter the settings for all the clearing channels.

Copy Settings from an Article

An existing article can be copied to a new Article.

Import Settings from USB

Article settings from USB can be downloaded to LZE-6.

New Article → Select the option and confirm for article creation.

The screenshot displays the Loepfe software interface. At the top, there is a navigation bar with the Loepfe logo, a search bar, and a 'Production Last 1000 km' indicator. Below this is a breadcrumb trail: Settings > Article > 30SVLC-TEST2 > List. The main area contains a table of articles with columns: Article, Process, Autostart, Count, Material, Last Change, and Active in group. The row for '30SVLC-TEST2' is highlighted in yellow. A modal dialog titled 'Add article' is open over this row, containing three options: 'New Article' (checked), 'Copy Settings from an Article', and 'Import Settings from USB'. A green checkmark icon is visible in the bottom right of the dialog. The left sidebar shows navigation options under 'DATA', 'SETTINGS', and 'SERVICE'. The right sidebar contains various icons and a 'Foreman' profile section with a clock showing '15-02-2023 12:23:29' and version 'v6.23.1.40901'.

Article	Process	Autostart	Count	Material	Last Change	Active in group
28SRLC	Compact		28 Ne	Pure	13-02-2023 12:38:19	1
30SVLC-TEST2	Compact		30 Ne	Pure	28-12-2022 16:22:04	
24SRLC-RWG	Compact				03-11-2022 12:27:45	
26S-TEST	Compact				10-02-2023 12:07:23	
26S-TEST2	Compact				10-02-2023 12:28:10	

New Article → Based on the main yarn parameters, the customer can select the clearing mode. By default Autostart is activated.

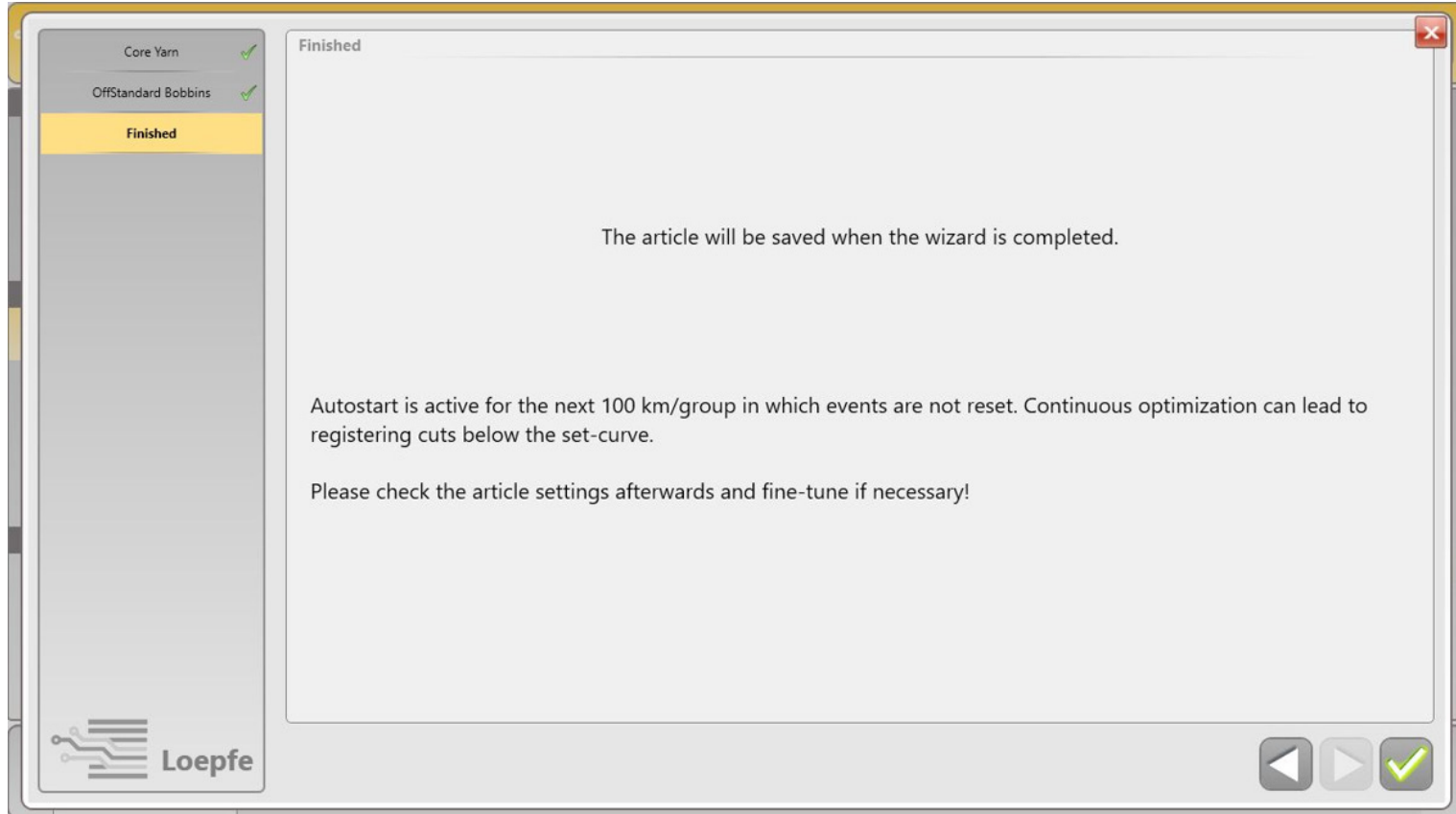
The screenshot shows the Loepfe software interface. At the top, there is a navigation bar with the Loepfe logo, a search bar, and a 'Production Last 1000 km' indicator. Below this is a sidebar with 'DATA' and 'SETTINGS' sections. The 'SETTINGS' section is expanded to 'Article', and a list of articles is shown: 28SRLC, 30SVLC-TEST2, and 24SRLC-RWG. The main area displays a table with columns: Article, Process, Autostart, Count, Material, Last Change, and Active in group. A dialog box titled 'Create Article with Yarn Parameters' is open in the center. It has a red 'X' close button in the top right and a green checkmark confirmation button in the bottom right. The dialog is divided into two sections: 'Properties' and 'Clearing'. The 'Properties' section contains various parameters with input fields or buttons: Article (26S-TEST), Process (Compact), Material (Pure), Fiber 1 (CO - Cotton), Fiber 2 (None), Blend Ratio (100.0), Fancy Yarn (Off), Conductive Material (Off), Yarn Count (26.0 Ne), Count Range (22.0 Ne - 30.0 Ne), Core Yarn (Off), and Color (Natural). The 'Clearing' section contains a list of parameters, each with an 'Autostart' button: NSLT, Splice, OffCount, SFI/D, Foreign Matter, OffColor, and Polypropylene. A red rectangular box highlights the 'Autostart' buttons for all seven parameters in the 'Clearing' section.

What is “Autostart“:

New customers always finds difficulty to choose suitable clearer settings. Until now, for a new yarn count, customer sets the clearing limits based on their previous experience. Fine-tuning of clearer setting for the given yarn quality is always a challenging task.

New feature “Autostart“ resolves this difficulty. It starts with an optimum setting for all matrix's and continuously adjusts the clearing curves for the first 100 Km wound yarn per group. Clearing curves are fixed after 100 Km. Manual fine-tuning can be done afterwards for the required yarn quality.

New Article → “Autostart“ activated article will be saved after the below information screen.



Autostart → Default setting will be applied for the selected matrix's and highlighted in blue colour to indicate that «AutoStart» is active.

The interface displays the following settings and data:

Navigation: Settings > Article > 26S-TEST > Overview

Production: Production Last 100 km

Left Sidebar (Menu):

- DATA: Dashboard, Monitoring, Quality
- SETTINGS: Article (selected), Group, Machine, Planning table
- SERVICE: Diagnosis, System, Setup

Main Content Area (Control Cards):

- NSLT:** Clearing On. Graph showing a red line on a grid.
- Splice:** Clearing On. Graph showing a red line on a grid.
- Foreign Matter:** Clearing Dark On, Clearing Bright Off, Clearing Organic Off. Graph showing a red line on a grid.
- OffCount:** Clearing On, Length Limit Off. Graph showing a red line on a grid.
- SFI/D:** Clearing On, Length Limit Off. Graph showing a red line on a grid.
- OffColor:** Clearing On, Length Limit Off. Graph showing a red line on a grid.
- Polypropylene:** Clearing On. Graph showing a red line on a grid.

Right Sidebar (Alarms and Clusters):

- NSLT Cluster:**
 - Nep Cluster:** Clearing Off, Obs. Length 80 m, Faults 2
 - Short Cluster:** Clearing Off, Obs. Length 80 m, Faults 2
 - Long Cluster:** Clearing Off, Obs. Length 80 m, Faults 2
 - Thin Cluster:** Clearing Off, Obs. Length 80 m, Faults 2
 - F Cluster:**
 - F Cluster Dark:** Clearing Off, Obs. Length 80 m, Faults 2
 - F Cluster Bright:** Clearing Off, Obs. Length 80 m, Faults 2
- OffLimit Alarms**
- Class Alarms**
- IPI Alarms**
- OffStandard Bobbins**
- Core**
- Properties:**
 - Article: 26S-TEST
 - Process: Compact
 - Material: Pure
 - Yarn Count: 26 Ne

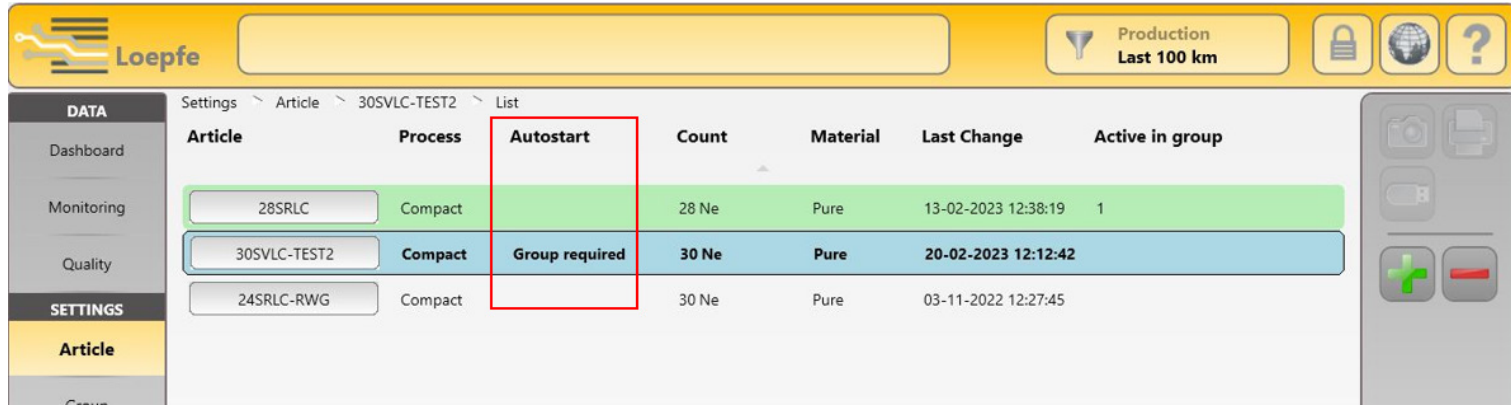
Bottom Navigation Bar:

- 24SRLC-RWG
- 26S-TEST** (highlighted)
- 26S1CK
- 30SVLC-TEST2

Right Sidebar (Tools and Info):

- Online status: Online
- Service icon
- Date and Time: 10-02-2023 11:55:58
- Version: v6.23.1.40901

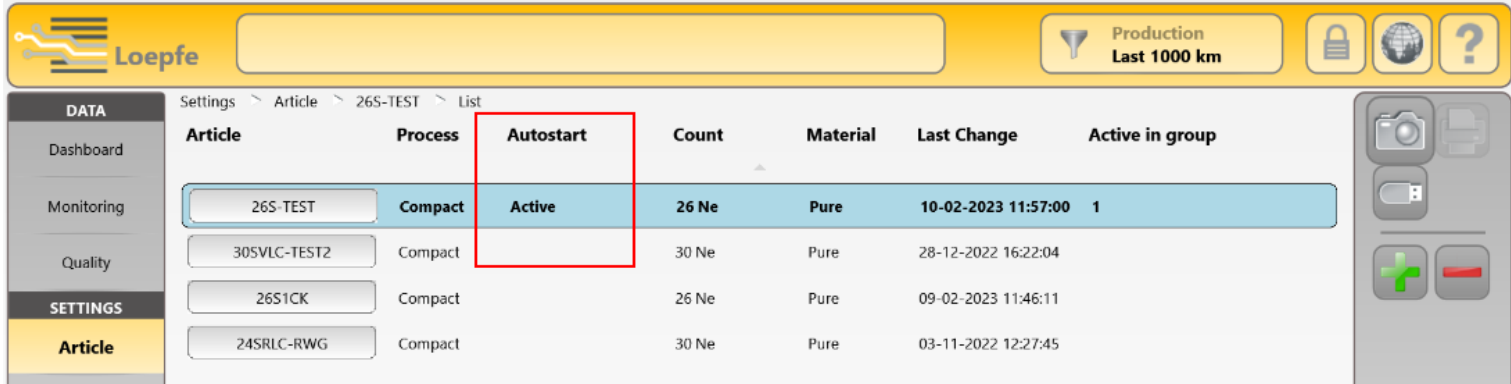
Autostart → Before assigning this article to any group, this article will be highlighted with «Group required» information.



Settings \ Article \ 30SVLC-TEST2 \ List

Article	Process	Autostart	Count	Material	Last Change	Active in group
28SRLC	Compact		28 Ne	Pure	13-02-2023 12:38:19	1
30SVLC-TEST2	Compact	Group required	30 Ne	Pure	20-02-2023 12:12:42	
24SRLC-RWG	Compact		30 Ne	Pure	03-11-2022 12:27:45	

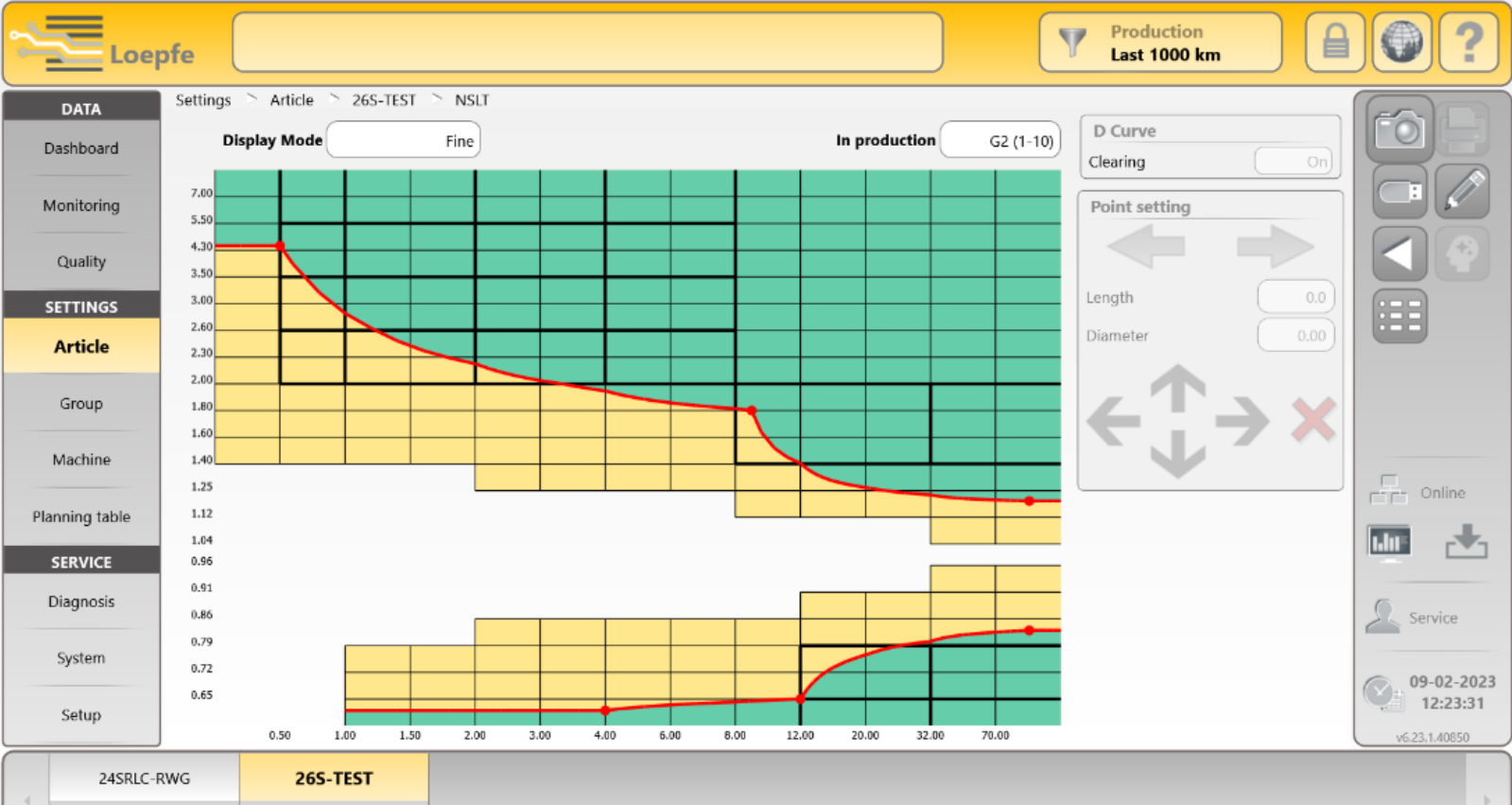
After assigning to a group, Autostart state will be highlighted as «Active» until the first 100 km completed.



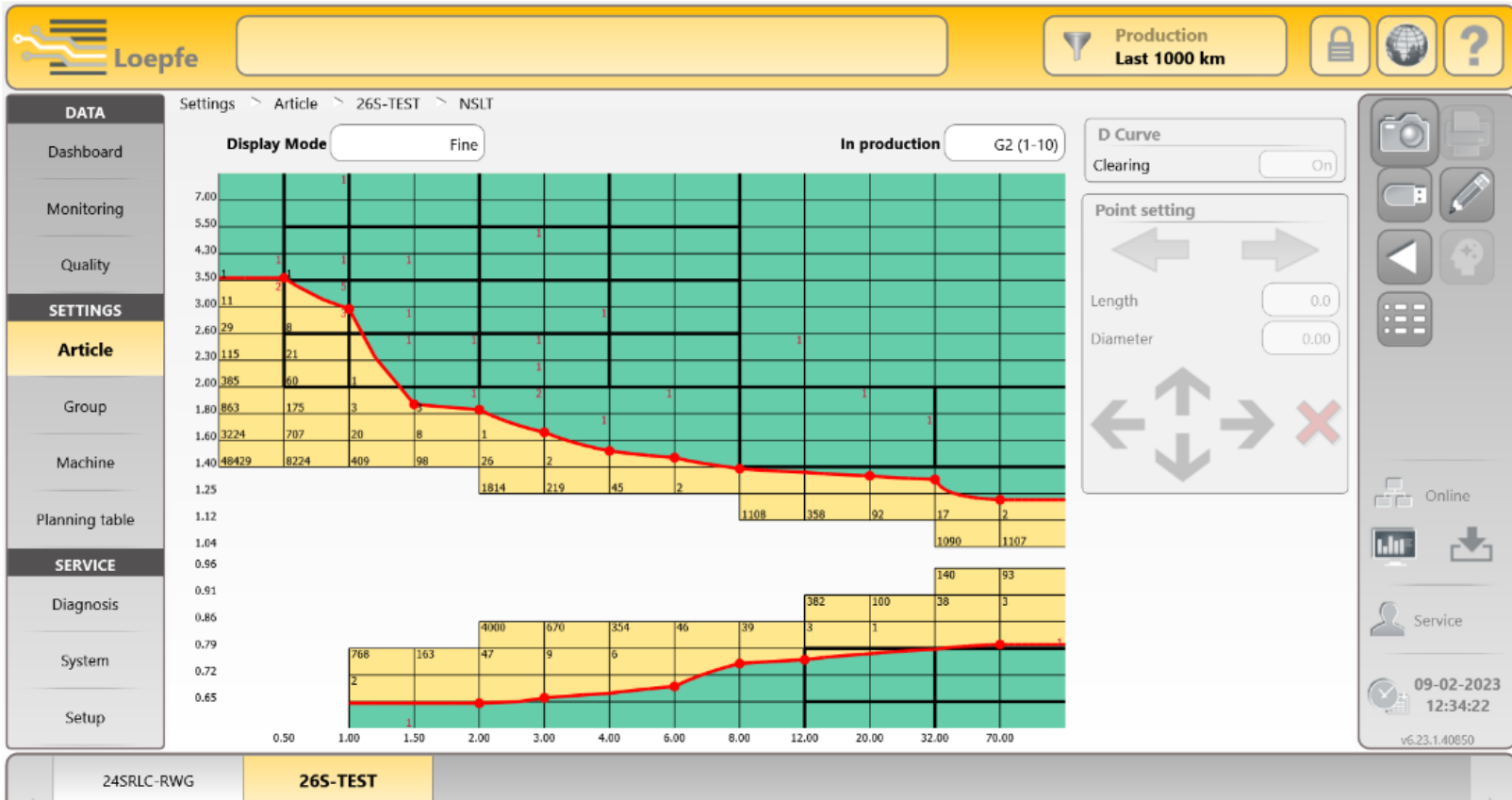
Settings \ Article \ 26S-TEST \ List

Article	Process	Autostart	Count	Material	Last Change	Active in group
26S-TEST	Compact	Active	26 Ne	Pure	10-02-2023 11:57:00	1
30SVLC-TEST2	Compact		30 Ne	Pure	28-12-2022 16:22:04	
26S1CK	Compact		26 Ne	Pure	09-02-2023 11:46:11	
24SRLC-RWG	Compact		30 Ne	Pure	03-11-2022 12:27:45	

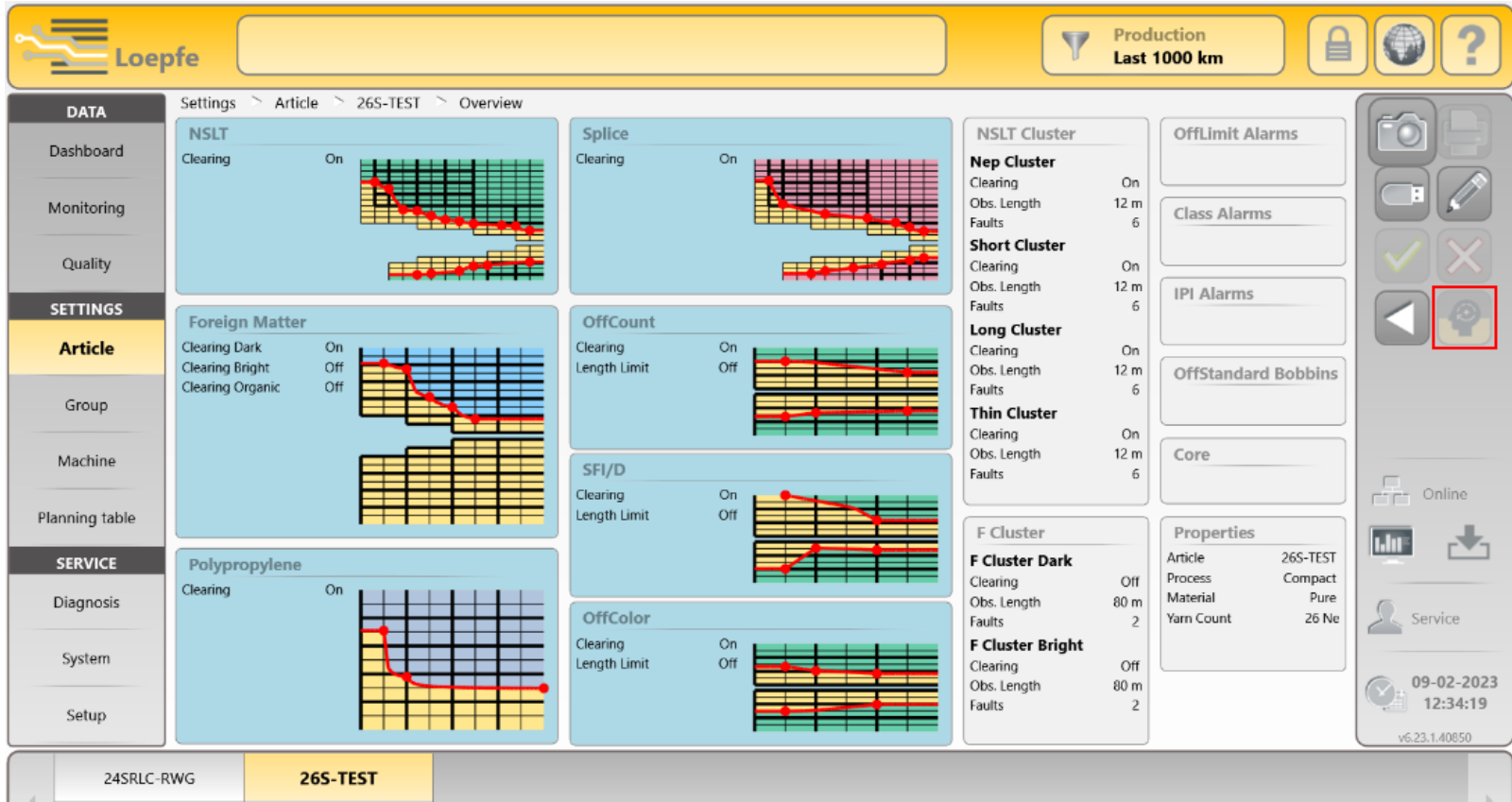
Autostart → Default NSLT setting right from the start-up.



Autostart → Up to 100 km/group, the function automatically adapts the clearing curve continuously based on real-quality data. The screenshot shows the optimised clearing curves at 50 km/group.



Autostart → Progress of “Autostart” can be seen in overview. Below screen represents, that 50 km length has been completed.



Autostart → After 100 km/group, Autostart disables automatically and saves the generated settings.

The screenshot displays the Loepfe spinning control interface. At the top, the Loepfe logo is on the left, and a search bar is in the center. On the right, there are icons for Production (Last 1000 km), a lock, a globe, and a help icon. A left sidebar contains navigation options: DATA (Dashboard, Monitoring, Quality), SETTINGS (Article, Group, Machine, Planning table), and SERVICE (Diagnosis, System, Setup). The main area is divided into several panels:

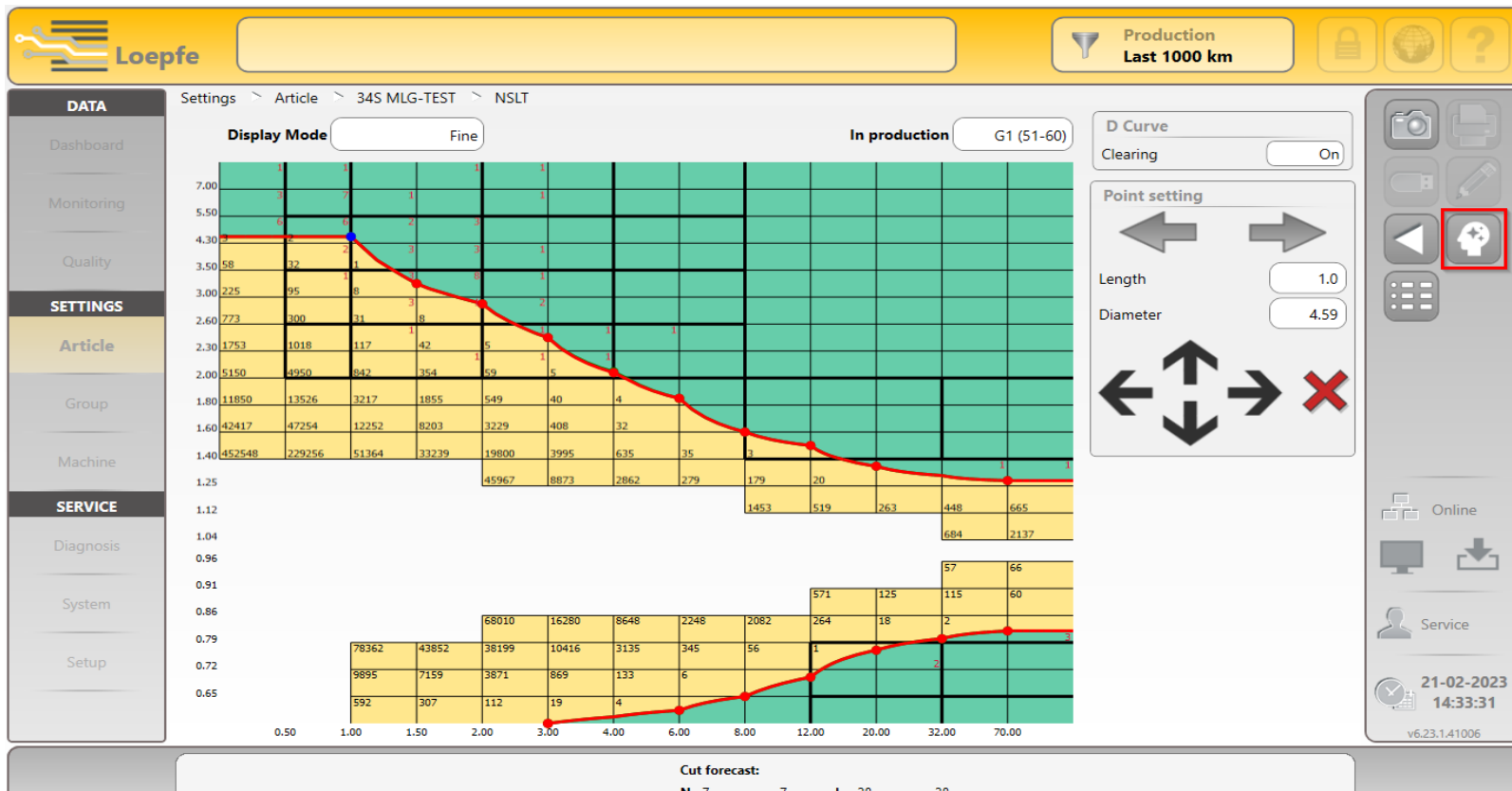
- NSLT**: Clearing On. Chart showing a red line decreasing over time.
- Splice**: Clearing On. Chart showing a red line decreasing over time.
- Foreign Matter**: Clearing Dark On, Clearing Bright Off, Clearing Organic Off. Chart showing a red line decreasing over time.
- OffCount**: Clearing On, Length Limit Off. Chart showing a red line decreasing over time.
- SFI/D**: Clearing On, Length Limit Off. Chart showing a red line decreasing over time.
- OffColor**: Clearing On, Length Limit Off. Chart showing a red line decreasing over time.
- NSLT Cluster**: Clearing On, Obs. Length 12 m, Faults 6.
- Nep Cluster**: Clearing On, Obs. Length 12 m, Faults 6.
- Short Cluster**: Clearing On, Obs. Length 12 m, Faults 6.
- Long Cluster**: Clearing On, Obs. Length 12 m, Faults 6.
- Thin Cluster**: Clearing On, Obs. Length 12 m, Faults 6.
- F Cluster**: Clearing Off, Obs. Length 80 m, Faults 2.
- F Cluster Dark**: Clearing Off, Obs. Length 80 m, Faults 2.
- F Cluster Bright**: Clearing Off, Obs. Length 80 m, Faults 2.
- OffLimit Alarms**: Empty box.
- Class Alarms**: Empty box.
- IPI Alarms**: Empty box.
- OffStandard Bobbins**: Empty box.
- Core**: Empty box.
- Properties**: Article 26S-TEST, Process Compact, Material Pure, Yarn Count 26 Ne.

At the bottom, there are buttons for 24SRLC-RWG and 26S-TEST. The bottom right corner shows the date and time: 09-02-2023 12:43:32, and the version number: v6.23.1.40850.

Define the following settings after the finalisation of “Autostart”:

- NSLT Cluster settings and curve
- F Organic clearing
- Bobbin Startup alarm
- Length limit alarm curve

Autocorrect → After the finalization of Autostart, further auto corrections of each individual curve clearing can be activated through the **Autocorrect** function.



New Article → Other than Autostart, the user can feed all the setting manually or convert ZENIT+ clearer settings to PRISMA.

The screenshot displays the Loepfe software interface. At the top, the 'Loepfe' logo is on the left, and 'Production Last 1000 km' is on the right. The main menu on the left is divided into 'DATA' (Dashboard, Monitoring, Quality) and 'SETTINGS' (Article, Group, Machine, Planning table). The 'SERVICE' section includes Diagnosis, System, and Setup. The central area shows 'Settings > Article > 30SVLC-TEST2 > List'. A 'Create Article with Yarn Parameters' dialog box is open, with the 'Clearing' tab selected. This dialog lists various parameters: Article, Process, Material, Fiber 1, Fiber 2, Blend Ratio, Fancy Yarn, Conductive Material, Yarn Count, Count Range, Core Yarn, and Color. Each parameter has an 'Autostart' button. A smaller 'NSLT' dialog box is overlaid on the 'Clearing' dialog, containing buttons for 'Autostart', 'Top 9', 'Top 12', 'Top 16', 'Convert ZENIT+', and 'Off'. The 'Convert ZENIT+' button is highlighted with a red border. The bottom status bar shows '24SRLC-RWG' and '30SVLC-TEST2'. The bottom right corner displays the date '20-02-2023', time '11:58:23', and version 'v6.23.1.40901'.

Convert ZENIT+: The user can enter existing settings from ZENIT+ to get equivalent PRISMA settings. However sensor's and its sensitivity in both clearer systems are different, so the clearing results have to be verified and double-checked!

Loepfe

Production Last 100 km

Settings > Article > NE 40 > List

Article	Process	Autostart	Count	Material	Last Change	Active in group
34S MLG-TEST	Combed		34 Ne	Blended	17-02-2023 10:39:53	1
99098 34S BDLOBA	Carded					
98117-30S	Carded					
34S MLG	Combed					
DEFAULT5	Carded					

New Article

Convert NSLT from ZENIT+

N	3.0
DS	2.10
LS	1.0cm
DL	1.20
LL	35cm
-D	10%
-L	6cm

Zenit+

D Channel

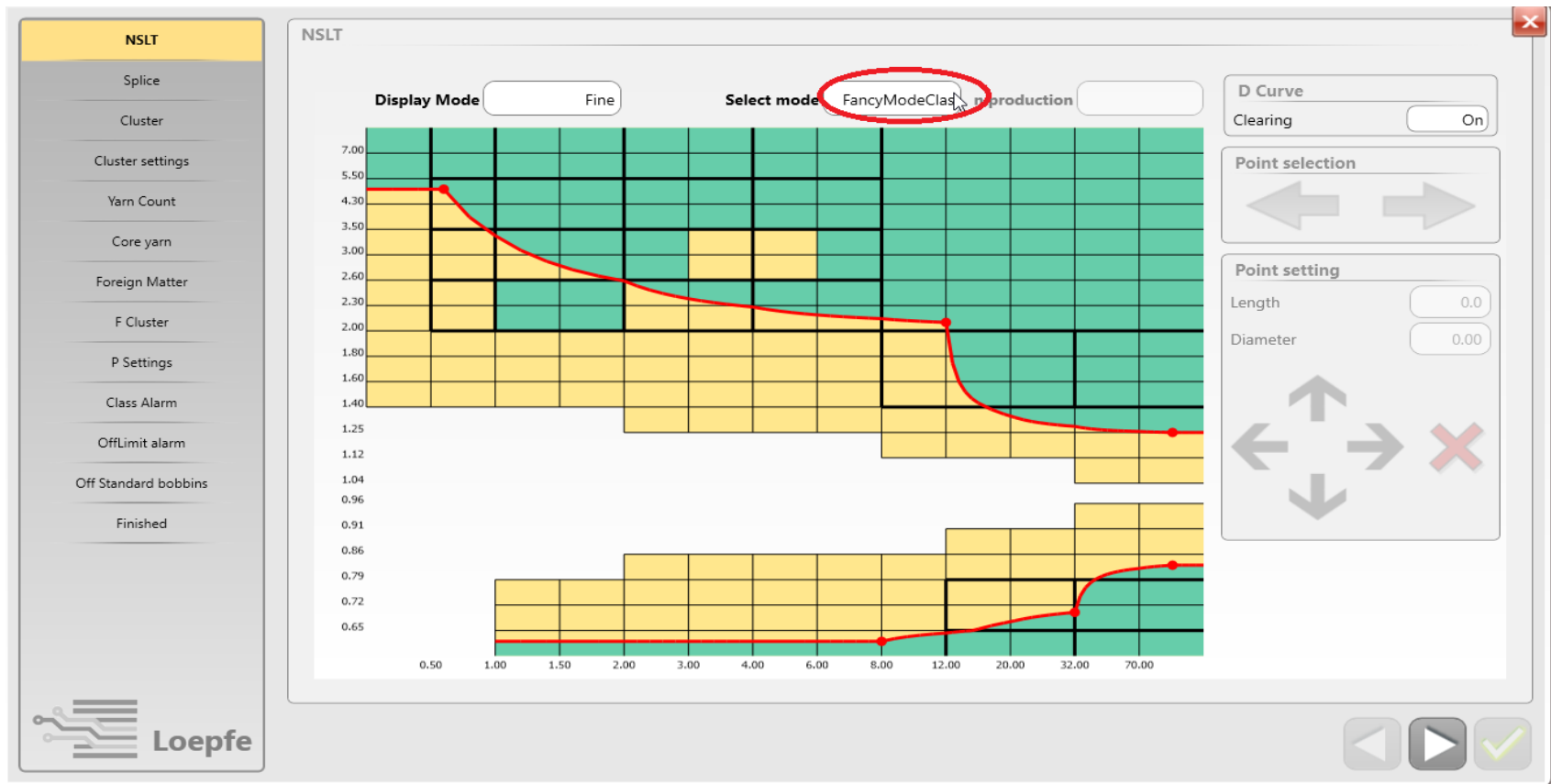
Clearing

N	5.0
DS	2.00
LS	2.0cm
DL	1.18
LL	30cm
-D	11%
-L	30cm

The settings should be doublechecked after 100km wound length per group

34S MLG 98117-30S

Fancy mode: The user can activate/deactivate single classes above or under the clearing curve. This is to process the slub yarn.



Off Standard Bobbins Alarm: The allowed number of cut repetitions per bobbin can be set for individual cut types marked with underline, or its group summary above. For cut types with long observation lengths, a lower limit is recommended

Alarm Limit / Bobbin	Cuts / Bobbin	Alarms	Bad Bobbins	Alarm Limit / Bobbin	Cuts / Bobbin	Alarms	Bad Bobbins
<u>NSLT</u>	12	0.0	0.000%	<u>_Thin Cluster</u>	3	0.0	0.000%
<u>_Neps</u>	5	0.0	0.000%	<u>_SFI/D</u>	2	0.0	0.000%
<u>_Short</u>	8	0.0	0.000%	<u>_Short SFI/D</u>	2	0.0	0.000%
<u>_Long</u>	4	0.0	0.000%	F	4	0.0	0.000%
<u>_Thin</u>	4	0.0	0.000%	F Organic	4	0.0	0.000%
<u>Max. Surface Cuts</u>	3	0.0	0.000%	F Cluster	5	0.0	0.000%
<u>_OffCount</u>	2	0.0	0.000%	F OffColor	Off	0.0	0.000%
<u>_Short OffCount</u>	2	0.0	0.000%	P	5	0.0	0.000%
<u>_Nep Cluster</u>	3	0.0	0.000%	Missing Core	Off	0.0	0.000%
<u>_Short Cluster</u>	3	0.0	0.000%	OffCenter Core	Off	0.0	0.000%
<u>_Long Cluster</u>	3	0.0	0.000%	Max. Cuts	25	0.0	0.000%

Bobbins: 0

In Production

Complete the wizard and save the article.

The screenshot shows a software wizard interface. On the left, a vertical list of 15 settings is shown, each with a green checkmark indicating it is completed. The settings are: NSLT, Splice, Cluster, Cluster settings, Yarn Count, Core yarn, LabPack, Foreign Matter, F Cluster, P Settings, Class Alarm, OffLimit alarm, IPI Settings, and Off Standard bobbins. Below this list is a yellow bar with the word "Finished". At the bottom left of the sidebar is the Loepfe logo. The main area of the wizard is titled "Finished" and contains the text "The article will be saved when the wizard is completed." At the bottom right of the main area are three buttons: a left arrow, a right arrow, and a green checkmark button.

Setting	Status
NSLT	✓
Splice	✓
Cluster	✓
Cluster settings	✓
Yarn Count	✓
Core yarn	✓
LabPack	✓
Foreign Matter	✓
F Cluster	✓
P Settings	✓
Class Alarm	✓
OffLimit alarm	✓
IPI Settings	✓
Off Standard bobbins	✓

Copy Settings from an Article → Select the option and confirm for article creation.

The screenshot displays the Loepfe software interface. At the top, there is a navigation bar with the Loepfe logo, a search field, and a 'Production Last 1000 km' indicator. Below this is a breadcrumb trail: Settings > Article > 28SRLC > List. The main area contains a table with columns: Article, Process, Autostart, Count, Material, Last Change, and Active in group. Two rows are visible: one for '28SRLC' (Compact, 28 Ne, Pure, 13-02-2023 12:38:19, 1) and one for '24SRLC-RWG' (Compact, 30 Ne, Pure, 03-11-2022 12:27:45). A dialog box titled 'Add article' is open in the center, featuring three options: 'New Article' (unchecked), 'Copy Settings from an Article' (checked with a green checkmark), and 'Import Settings from USB' (unchecked). A green checkmark icon is also present at the bottom right of the dialog box. The left sidebar shows a menu with 'DATA' (Dashboard, Monitoring, Quality) and 'SETTINGS' (Article, Group, Machine, Planning table) sections. The bottom right corner shows system information: 'Foreman', date '20-02-2023 21:59:27', and version 'v6.23.1.40901'.

Article	Process	Autostart	Count	Material	Last Change	Active in group
28SRLC	Compact		28 Ne	Pure	13-02-2023 12:38:19	1
24SRLC-RWG	Compact		30 Ne	Pure	03-11-2022 12:27:45	

Copy Settings from an Article → Existing articles will be displayed under “Source Article”. Users can choose the article to copy, and can define the new article properties.

The screenshot shows the Loepfe software interface. At the top, there is a navigation bar with the Loepfe logo, a search bar, and a 'Production Last 1000 km' indicator. Below this is a sidebar menu with categories: DATA (Dashboard, Monitoring, Quality), SETTINGS (Article, Group, Machine, Planning table), and SERVICE (Diagnosis, System, Setup). The main area displays the 'Article' settings for 'M-36SRLC'. A dialog box titled 'Create a copy of an existing article' is open, featuring a 'Source Article' section with a table and a 'Properties' section with various settings.

Article	Last Change
NE 40	12/14/2021 5:04:18 PM
M-36SRLC	12/2/2021 1:28:51 PM
NE 50	12/14/2021 8:50:33 PM

Properties

- Article: NE 60
- Yarn Count: 60Ne
- Fancy Yarn: Off
- Type: Compact
- Material: Pure
- Fiber 1: CO - Cotton
- Fiber 2: None
- Mixed: 100.0
- Conductive Material: No

Copy Settings from an Article → New article will be created with the given name.

Loepfe
Production
Last 1000 km

DATA

Dashboard

Monitoring

Quality

SETTINGS

Article

Group

Machine

Planning table

SERVICE

Diagnosis

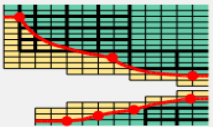
System

Setup

Settings > Article > NE 60 > Overview

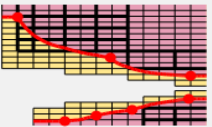
NSLT

Clearing On



Splice

Clearing On



NSLT Cluster

Nep Cluster

Clearing On

Obs. Length 15 m

Faults 6

Short Cluster

Clearing On

Obs. Length 12 m

Faults 8

Long Cluster

Clearing On

Obs. Length 15 m

Faults 8

Thin Cluster

Clearing On

Obs. Length 15 m

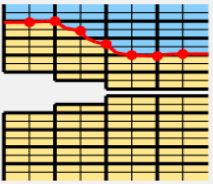
Faults 6

Foreign Matter

Clearing Dark On

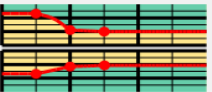
Clearing Bright Off

Clearing Organic On



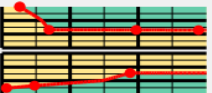
OffCount

Clearing On



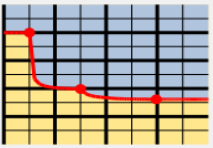
SFI/D

Clearing On



Polypropylene

Clearing On



Offline

Foreman

14-12-2021
21:08:35

v6.0.72.32850-rc
d05b2a097-Release

M-36SRLC
NE 50

NE 40
NE 60

Import Settings from USB → Select the option and confirm for article creation.

The screenshot displays the Loepfe software interface. At the top, there is a navigation bar with the Loepfe logo, a search field, and a 'Production Last 1000 km' indicator. Below this is a breadcrumb trail: Settings > Article > 28SRLC > List. The main area contains a table with columns: Article, Process, Autostart, Count, Material, Last Change, and Active in group. Two rows are visible: one for article 28SRLC (Compact process, 28 Ne count, Pure material, last change 13-02-2023 12:38:19, active in group 1) and another for 24SRLC-RWG (Compact process, 30 Ne count, Pure material, last change 03-11-2022 12:27:45). A modal dialog box titled 'Add article' is open in the center, featuring three options: 'New Article' (unchecked), 'Copy Settings from an Article' (unchecked), and 'Import Settings from USB' (checked). A green checkmark icon is visible in the bottom right corner of the dialog. The left sidebar shows navigation options under 'DATA', 'SETTINGS', and 'SERVICE'. The right sidebar includes icons for camera, print, and other functions, along with system status like 'Online', a bar chart, and user information for 'Foreman' with a timestamp of 20-02-2023 21:59:27 and version v6.23.1.40901.

Article	Process	Autostart	Count	Material	Last Change	Active in group
28SRLC	Compact		28 Ne	Pure	13-02-2023 12:38:19	1
24SRLC-RWG	Compact		30 Ne	Pure	03-11-2022 12:27:45	

Import Settings from USB → Articles available on USB will be displayed, select the article and hit the download button to import it.

Loepfe Production Last 1000 km

Import Settings Article

Settings Article

Article	Machine Name	Export Date
M-36SRLC	MC 27	11/26/2021 11:46:15 AM
M-36SRLC-RWG	MC 1	11/29/2021 11:53:21 AM
M-42SRLC (1)	MC 1	11/29/2021 11:53:23 AM
72S POLY	MC 6	11/30/2021 10:47:56 AM
50S POLY	MC 6	11/30/2021 10:47:57 AM
65S POLY	MC 6	11/30/2021 10:47:57 AM
54S POLY	MC 6	11/30/2021 10:47:57 AM
M-36SRLC	MC 22	12/2/2021 11:07:19 AM
30SVLC	MC 22	12/2/2021 11:07:22 AM

Properties

Article: NE 42
Yarn Count: 71.1Nm
Fancy Yarn: Off
Type: Compact
Material: Pure
Fiber 1: CO - Cotton
Fiber 2: None
Mixed: 100.0
Conductive Material: No

Offline
Foreman
14-12-2021 21:19:32
v6.0.72.32850-rc
d05b2a097-Release

M-36SRLC NE 50
NE 40 NE 60

Import settings from USB → Selected articles will be downloaded to article management.

Loepfe
Production
Last 1000 km

DATA

- Dashboard
- Monitoring
- Quality

SETTINGS

- Article
- Group
- Machine
- Planning table

SERVICE

- Diagnosis
- System
- Setup

Settings > Article > NE 42 > Overview

NSLT

Clearing On

Splice

Clearing On

Foreign Matter

Clearing Dark On
 Clearing Bright Off
 Clearing Organic On

OffCount

Clearing On

SFI/D

Clearing On

Polypropylene

Clearing On

M-36SRLC	NE 42	NE 60
NE 40	NE 50	

NSLT Cluster	
Clearing	On
Obs. Length	12 m
Faults	6
Short Cluster	
Clearing	On
Obs. Length	12 m
Faults	4
Long Cluster	
Clearing	On
Obs. Length	12 m
Faults	8
Thin Cluster	
Clearing	On
Obs. Length	12 m
Faults	4
F Cluster	
F Cluster Dark	
Clearing	Off
Obs. Length	80 m
Faults	1
F Cluster Bright	
Clearing	Off
Obs. Length	80 m
Faults	1

OffLimit Alarms	
Class Alarms	
IPI Alarms	
Off Standard Bobbins	
Core	
Properties	
Article	NE 42
Type	Compact
Material	Pure
Yarn Count	42 Ne

Offline
Foreman

14-12-2021
21:20:53
v6.0.72.32850-rc
d05b2a097-Release

A group consists of spindle range, assigned article, type of TK and other special settings.

For group creation go to Group menu

1. Press + “add” to create a new group

2. There are 2 options to create a new group
 - a) Create new group
 - b) Copy from group.

3. Select your preferred option

Create new group → Group will be created with default factory settings and user needs to define the group parameters.

The screenshot displays the Loepfe software interface. At the top, there is a navigation bar with the Loepfe logo, a search bar, and a filter for 'Production Last 1000 km'. Below this is a breadcrumb trail: Settings > Group > G2 > List. The main area shows a table with columns: No., First, Last, TK, Status, Lot Name, Article, Dia Diff, and Last Change. A single row is visible with values: G2, 1, 72, DMFP, Production, M-36SRLC, -1%, 14-12-2021 15:23:54. A dialog box titled 'Add group' is open in the center, containing two options: 'Create new group' (checked) and 'Copy from group:' (with a dropdown menu showing '2'). A green checkmark button is at the bottom right of the dialog. The left sidebar contains menu items: DATA (Dashboard, Monitoring, Quality), SETTINGS (Article, Group, Machine, Planning table), and SERVICE (Diagnosis, System, Setup). The right sidebar has various icons and a status section showing 'Offline', 'Foreman', and a timestamp '14-12-2021 21:23:29' with version information 'v6.0.72.32850-rc d05b2a097-Release'. At the bottom, a status bar shows 'G2 (1-72)'.

Set the "Settings Group" group spindle range, sensing head type, lot and article.

Wet Splicer → If wet splicer used, this function must be On. Same applies for F-clearing during splice, water could change shade of fibers and trigger false F cut.

The screenshot shows the Loepfe web interface for configuring a 'Settings Group'. The breadcrumb navigation is 'Settings > Group > G2 > Overview'. The interface is divided into several sections:

- Settings Group:** Contains input fields for 'First Spindle' (1), 'Last Spindle' (72), 'Sensing Head Type' (DMFP), 'Lot Name', and 'Article' (M-36SRLC).
- Settings Optional:** Contains various parameters such as 'Drum Pulse Length' (12.3mm), 'Reduction Fine Adjust' (0%), 'Reduction Cone Change' (0%), 'Bunch Monitoring' (On), 'Threshold Static Yarn Signal' (40%), 'Threshold Dynamic Yarn Signal' (25%), 'Fine Adjust Mode' (Continuous), 'Suction after Adjust' (On), 'TK Display Mode' (Class), 'Drift Limit Fine Adjust Continuous' (Off), 'Drum Wrap Detection Mode' (Off), and 'Cuts before bobbin change' (Off).
- Reset Data:** A section with a refresh icon and the text 'Resets the production data of this group!'.
- Splice Settings:** Contains 'Repetitive Splice Removal' (On), 'Splice Check Length' (25cm), 'F clearing during Splice' (On), and 'Wet Splicer' (Off). The 'Wet Splicer' setting is highlighted with a red border.
- Data Acquisition:** Contains 'Window Length' (1000 km).

The right sidebar includes navigation icons, a status indicator 'Offline', a user profile 'Foreman', and system information: '14-12-2021 21:26:50', 'v6.0.72.32850-rc', and 'd05b2a097-Release'. The bottom status bar shows 'G2 (1-72)'.

Copy from group → Group setting of selected group will be copied to the new group.

The screenshot displays the Loepfe software interface. At the top, there is a navigation bar with the Loepfe logo, a search bar, and several utility icons including a warning sign, a filter icon labeled 'Production Last 1000 km', a lock, a globe, and a help icon. A left sidebar contains a menu with categories: DATA (Dashboard, Monitoring, Quality), SETTINGS (Article, Group, Machine), and SERVICE (Diagnosis, System, Setup). The 'Group' setting is currently selected. The main area shows a breadcrumb trail 'Settings > Group > G2 > List' and a table of group configurations. A dialog box titled 'Add group' is open in the center, featuring two options: 'Create new group' (unchecked) and 'Copy from group:' (checked) with a text input field containing the value '1'. A green checkmark icon is visible in the bottom right corner of the dialog. The table below the dialog shows two groups: G1 (Production) and G2 (Defined). At the bottom, a group selection bar shows 'G1 (1-10)' and 'G2 (11-20)', with 'G2 (11-20)' being the active selection. A right-hand toolbar contains various icons for camera, print, zoom, play, stop, add, and remove, along with status indicators for 'Online', 'Service', and a timestamp '15-07-2021 12:03:09'.

No.	First	Last	TK	Status	Lot	Article	D Health	Last Change
G1	1	10	DMFP	Production		30S VL	-1%	01-04-2021 12:26:03
G2	11	20	DMFP	Defined		NE 40	-	15-07-2021 12:02:46

Group Start → Start the group, all spindles assigned to the group will do an adjust, (no pilot spindles in PRISMA).

The screenshot displays the Loepfe software interface. At the top, there is a navigation bar with the Loepfe logo, a search bar, and a 'Production Last 1000 km' indicator. Below this is a breadcrumb trail: Settings > Group > G2 > List. The main area features a table with the following columns: No., First, Last, TK, Status, Lot Name, Article, Dia Diff, and Last Change. A single row is visible with the following data: No. G2, First 1, Last 72, TK DMFP, Status Stopped, Lot Name M-36SRLC, Article -, Dia Diff -, and Last Change 14-12-2021 21:32:02. A central dialog box titled 'Start Group' is open, asking 'Start production?' with a green checkmark button. On the right-hand side, a vertical toolbar contains several icons, with a play button icon highlighted by a red box and labeled 'Start Button' with a red arrow. The bottom of the interface shows a status bar with 'G2 (1-72)' and a footer with the Loepfe logo, version information (v6.0.72.32850-rc d05b2a097-Release), and a timestamp (14-12-2021 21:35:15).

No.	First	Last	TK	Status	Lot Name	Article	Dia Diff	Last Change
G2	1	72	DMFP	Stopped	M-36SRLC	-	-	14-12-2021 21:32:02

Group Start → After starting the Group, sensing head will show “Ad” on the display.
Now you can run the spindles one by one with new “fresh” and good bobbin.



Monitoring and classification data

Monitoring data → Cuts are listed on the left half and alarms are on the right half. Cut types or alarms which are switched Off in the article settings, do not show any Number but a “-”.

▼ **Production**
Last 1000 km

Data \ Monitoring \ G1 (36SRLC) \ Overview

Cuts		
Total	997	
DM Cuts	711	
F Cuts	273	
P Cuts	13	
Splice		
Splices	2717	
Splice Cuts	18	
Splice Repetitions	272	
Splice Accumulation	11	
Foreign Matter		
F Dark Cuts	71	
F Bright Cuts	-	
F Organic Cuts	202	
F Cluster Cuts Dark	-	
F Cluster Bright Cuts	-	
OffColor Dark Cuts	-	
OffColor Bright Cuts	-	
OffStandard Alarms		
NSLT	0	
Neps	0	
Short	0	
Long	3	
Thin	0	
Max. Surface Cuts	0	
OffCount	7	
Short OffCount	0	
Nep Cluster	0	
Short Cluster	11	
Long Cluster	0	
Thin Cluster	0	
SFI/D	13	
Short SFI/D	1	
Foreign Matter	0	
F Organic	1	
F Cluster	-	
OffColor	-	
P	0	
Missing Core	-	
OffCenter Core	-	
Max. Cuts	0	
Bobbin Startup Alarms		
OffCount +	18	
OffCount -	6	
OffColor Dark	-	
OffColor Bright	0	
OffLimit Alarms		
Total	-	
Class Alarms		
Total	-	
IPI Alarms		
Total	-	
Total (Spindles)	-	
Length Limit Alarms		
OffCount +	0	
OffCount -	1	
SFI/D +	6	
SFI/D -	0	
OffColor Dark	-	
OffColor Bright	-	
Length		
Wound Length	1000.0 km	
Last Cut		
-		

G1 (1-16)

▶

◀

1

2

3

4

5

6

7

8

9

10

11

12

13

14

15

16

▶

DATA

Monitoring

SERVICE

Dashboard

Quality

SETTINGS

Article

Group

Machine

Planning table

System

Setup

NSLT

Nep Cuts 11

Short Cuts 306

Long Cuts 148

Thin Cuts 8

Nep Cluster Cuts 0

Short Cluster Cuts 62

Long Cluster Cuts 0

Thin Cluster Cuts 0

OffCount

Missing Core Cuts -

OffCenter Core Cuts -

OffCount + Cuts 33

OffCount - Cuts 7

Short OffCount + Cuts 22

Short OffCount - Cuts 0

SFI/D

Total Cuts 114

SFI/D + Cuts 83

SFI/D - Cuts 0

Short SFI/D + Cuts 20

Short SFI/D - Cuts 10

Splice

Splices 2717

Splice Cuts 18

Splice Repetitions 272

Splice Accumulation 11

Foreign Matter

F Dark Cuts 71

F Bright Cuts -

F Organic Cuts 202

F Cluster Cuts Dark -

F Cluster Bright Cuts -

OffColor Dark Cuts -

OffColor Bright Cuts -

Special

Bunch Cuts 6

Upper Yarn Cuts 1

Yarn Breaks 98

Total Bobbin Changes 475

Knife Jam 0

OffStandard Alarms

NSLT 0

Neps 0

Short 0

Long 3

Thin 0

Max. Surface Cuts 0

OffCount 7

Short OffCount 0

Nep Cluster 0

Short Cluster 11

Long Cluster 0

Thin Cluster 0

SFI/D 13

Short SFI/D 1

Foreign Matter 0

F Organic 1

F Cluster -

OffColor -

P 0

Missing Core -

OffCenter Core -

Max. Cuts 0

Bobbin Startup Alarms

OffCount + 18

OffCount - 6

OffColor Dark -

OffColor Bright 0

OffLimit Alarms

Total -

Class Alarms

Total -

IPI Alarms

Total -

Total (Spindles) -

Length Limit Alarms

OffCount + 0

OffCount - 1

SFI/D + 6

SFI/D - 0

OffColor Dark -

OffColor Bright -

Length

Wound Length 1000.0 km

Last Cut

-

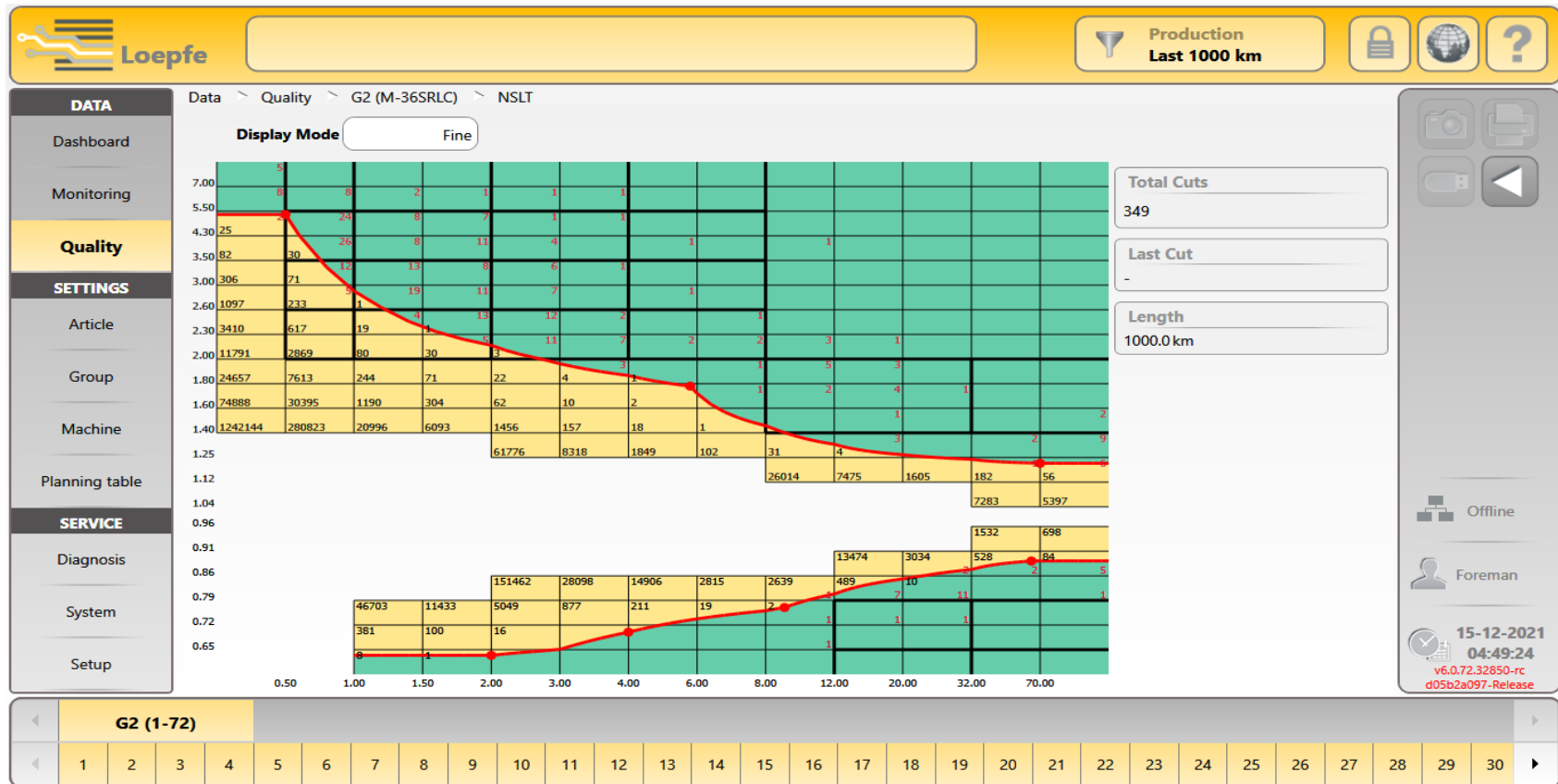
Online

Foreman

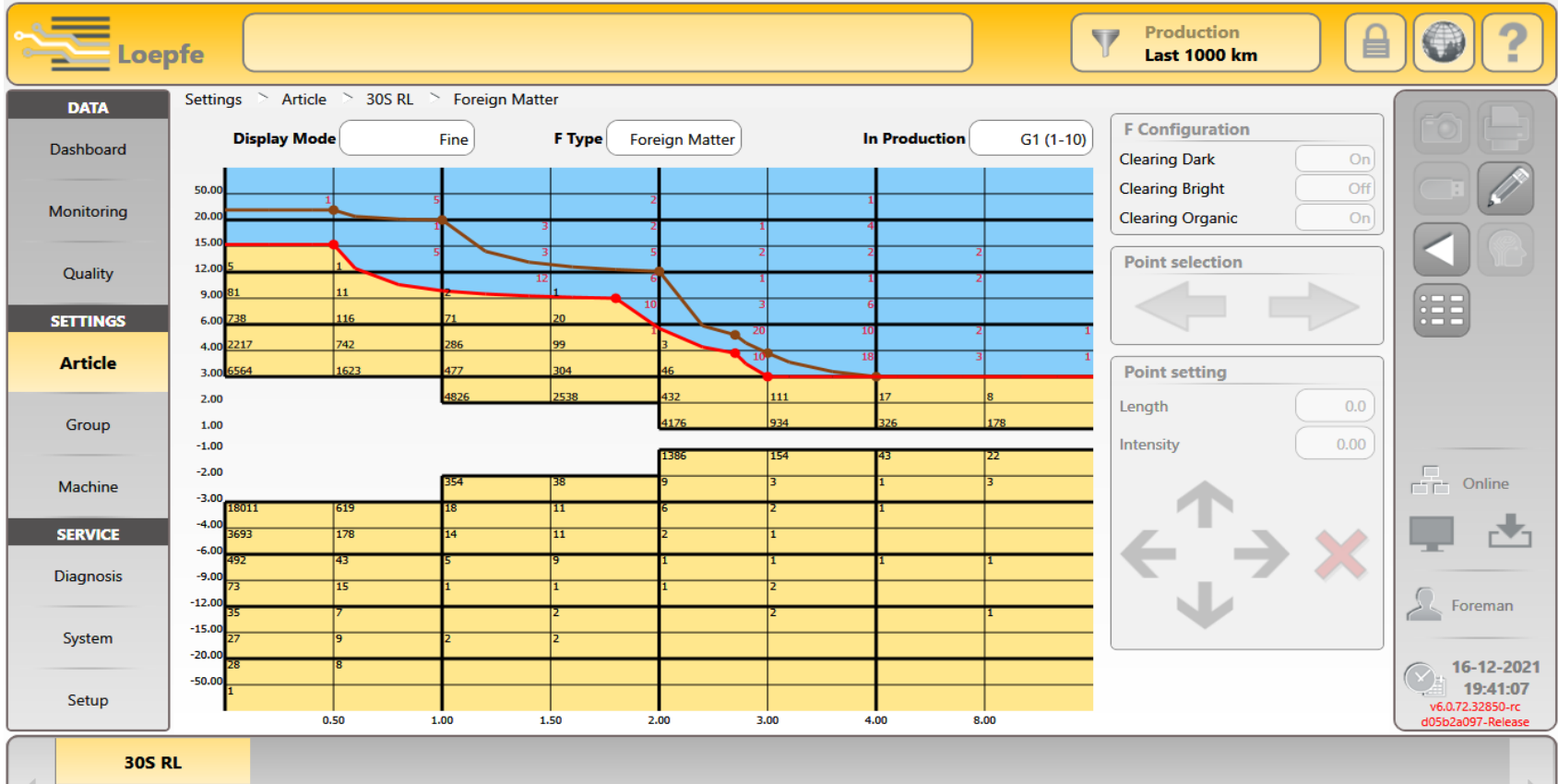
🕒 **29-08-2022**
🕒 **15:27:15**

v6.22.2.35925

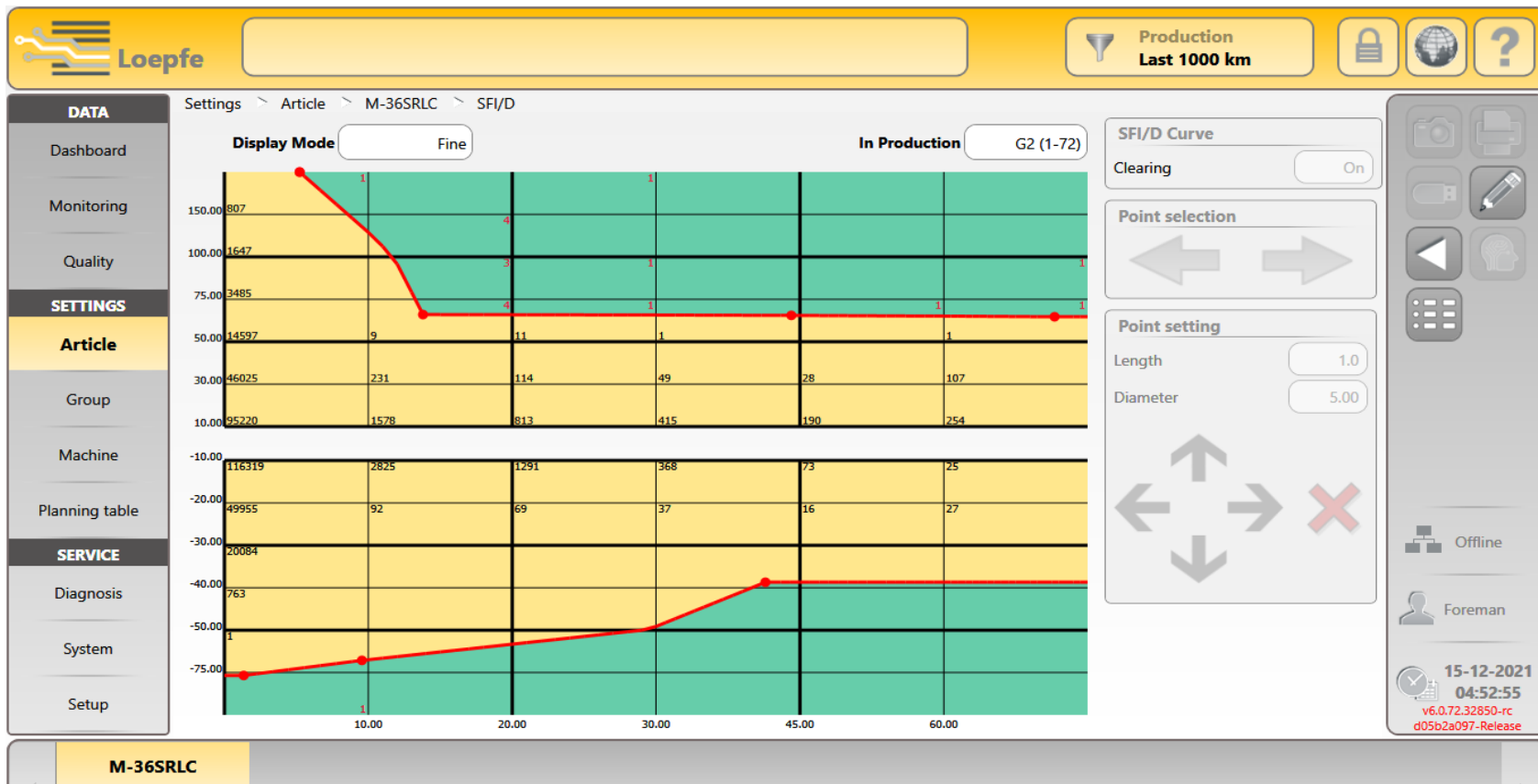
NSLT class data → PRISMA comes with 207 fine classes. All the faults are well classified within the classification area. No faults are classified out of classification.



F class data → PRISMA comes with 74 No. of F fine classes for each Dark and Bright clearing. Additional fine classes are added for I, R and O classes. Those classes are classified as IO, RO and OO.




SFI/D clearing → SFI/D classification is available in the article settings. Faults classified within 1-10m are categorized in Short SFI/D and faults with classifications 11-80m are categorized as SFI/D.






Last cut / Test mode / Classification

Last Cut → Last 20 cuts can be seen for individual spindles with class, length (mm) and Intensity. In case of F cuts, also detected color tone of yarn fault is shown.



Production
Last 1000 km

DATA

Dashboard

Monitoring

Quality

SETTINGS

Article

Group

Machine

Planning table

SERVICE

Diagnosis





System


Setup

Service ▾ Diagnosis ▾ TK10 ▾ Last Cut


Last Cut

Time	Cut	Class	Length	Intensity
15:11:41	Spindle	NoClass	-1	-1
15:11:39	Runout/Yarnbreak	NoClass	0	0
15:10:58	S Cut	A4.2	0.60cm	7.05
15:10:02	S Cut	A3.2	0.80cm	5.24
15:09:42	Spindle	NoClass	-1	-1
15:09:40	Runout/Yarnbreak	NoClass	0	0
15:09:05	P	o1.4	1.60cm	20
15:08:19	F Cut Organic	D-13.1	1.20cm	14.40
15:07:43	S Cut	C3.1	2.20cm	3.84
15:07:09	Spindle	NoClass	-1	-1
15:07:07	Runout/Yarnbreak	NoClass	0	0
15:05:57	S Cut	C2.2	2.60cm	3.19
15:04:58	Spindle	NoClass	-1	-1
15:04:56	Runout/Yarnbreak	NoClass	0	0
15:04:47	L Cut	E.1	12.00cm	2.02
15:04:29	F Dark	D-R1.4	4.00cm	4.10
15:03:51	F Dark	D-12.4	2.00cm	11.10









Offline



Foreman



15-12-2021
04:54:46
v6.0.72.32850-rc
d05b2a097-Release

1	3	5	7	9	11	13	15	17	19	21	23	25	27	29	31	33	35	37	39	41	43	45	47	49	51	53	55	57	59
2	4	6	8	10	12	14	16	18	20	22	24	26	28	30	32	34	36	38	40	42	44	46	48	50	52	54	56	58	60

Test Mode → Under Service/ Diagnosis/ Test mode, you can find a function to stop spindles in case of any kind of cut type which you specify for visual inspection. On screenshot below is for example set inspection of NSL Splice cuts, and Short cut of class B1.1 and B1.3, as well as Foreign matter class I1.4 and R1.2.

Loeffe

Production Last 1000 km

Service \ Diagnosis \ TK2 \ Test Mode

Test Mode

Timeout setting (min) 60

Cut Types

- N Cut
- S Cut
- L Cut
- T Cut
- N Splice Cut
- S Splice Cut
- L Splice Cut
- T Splice Cut
- OffCount +
- OffCount -
- Short OffCount +
- Short OffCount -
- Nep Cluster
- Short Cluster
- Long Cluster
- Thin Cluster
- F Dark
- F Bright
- F Cut Organic
- F Cluster Dark
- F Cluster Bright
- P
- Bunch
- Upper Yarn
- System
- SFI/D Cuts +
- SFI/D Cuts -
- Short SFI/D Cuts +
- Short SFI/D Cuts -
- Drum Wrap Cut/Event
- OffColor Cut Dark
- OffColor Cut Bright
- Missing Core Cut
- OffCenter Core Cut

NSLT

Foreign Matter

Offline

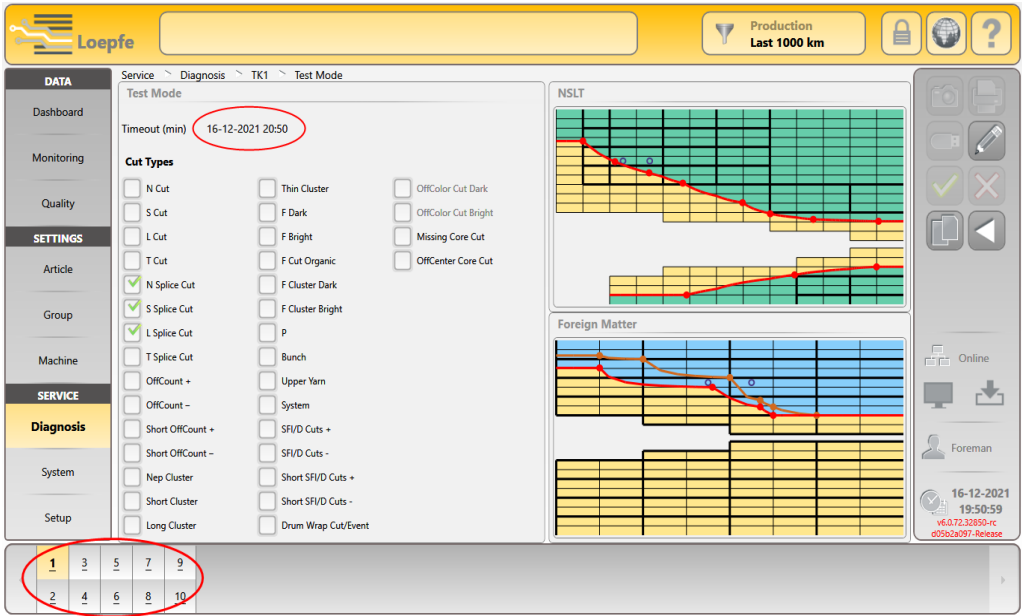
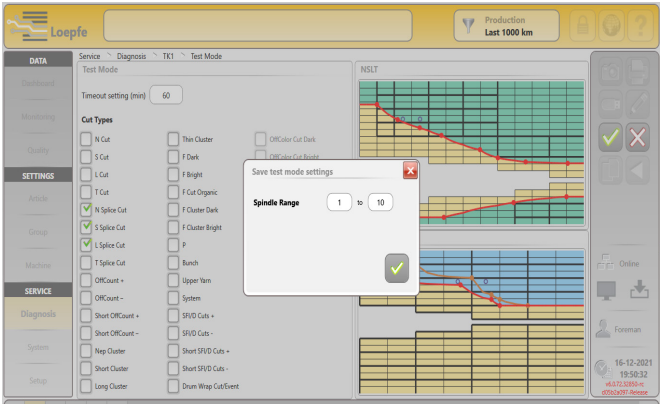
Foreman

15-12-2021
05:15:02
v6.0.72.32850-rc
d05b2a097-Release

1 3 5 7 9
2 4 6 8 10

Test mode → Then just select timeout and spindle range. After confirmation, selected spindles will be running in test mode, and will be blocked for inspection after every selected cut type, while on TK Display will be blinking alternately yarn fault classification, and approximate length of fault from the end of yarn in meters (usually around 0.4m).

Bellow on spindle Number bar, you can recognize which spindles are in test mode by underline. The set timeout is shown in the test mode, the test mode gets automatically deactivated when its over.



NSLT classification → PRISMA offers additional fine classes (highlighted in yellow) and setting options without compromise. PRISMA classifies all NSLT yarn faults, there are no unclassified cuts.

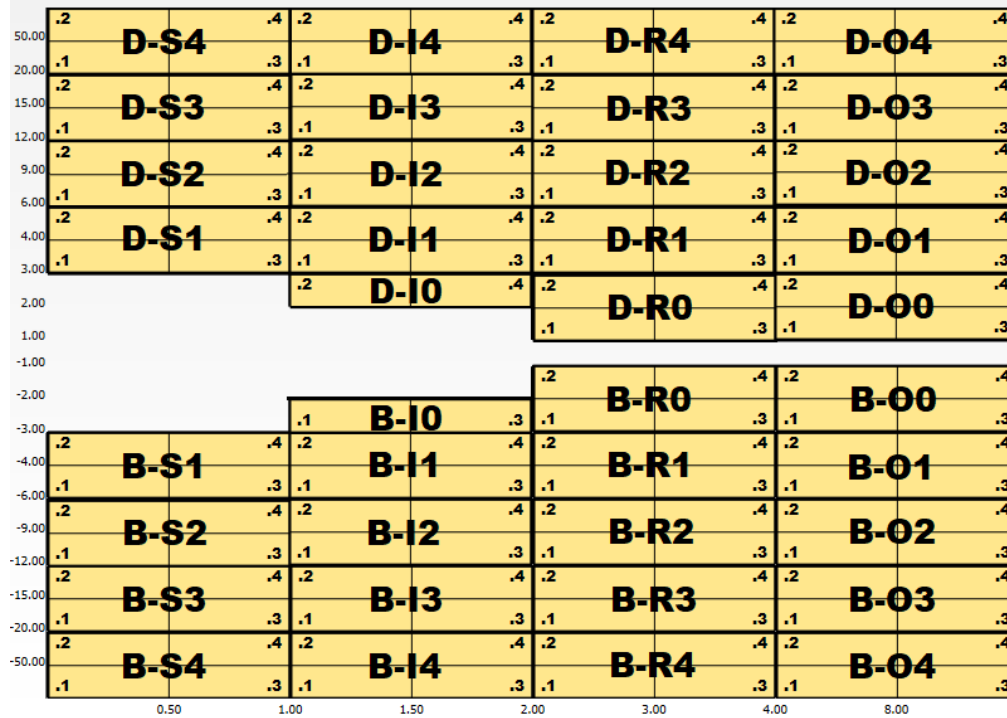
YM PRISMA



YM ZENIT+



Foreign matter classification → displays classes **SIRO** 0-4, Where S are the shortest faults 0-10mm and O are longest faults 40-128mm with 0-4 in intensity scale, where lowest is 0 and highest is 4. Upper half of matrix is for D-dark faults, the lower half is for B-bright faults.



Polypropylene classification → displays classes **POLY** 1-5, where P are shortest faults 0-10mm and Y are longest faults 40-80mm, and triboelectric charge intensity in class 1-5 where 1 is the lowest and 5 is the highest intensity disturbance.

