



YarnMaster® PRISMA快速使用指引



Valid for V6.0.72 / 20.12.2021 / P&S

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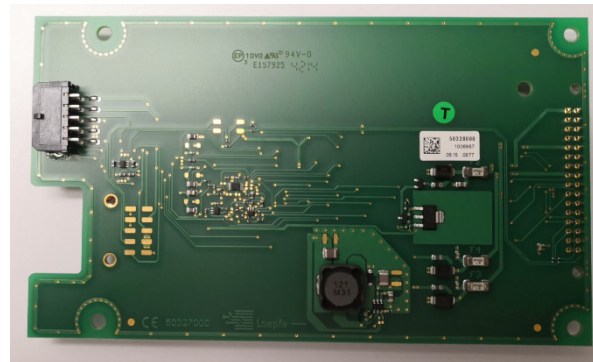
1. 清纱器的组成
2. 全新的功能
3. 三原色白光异纤检测
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YarnMaster[®] PRISMA 的组件

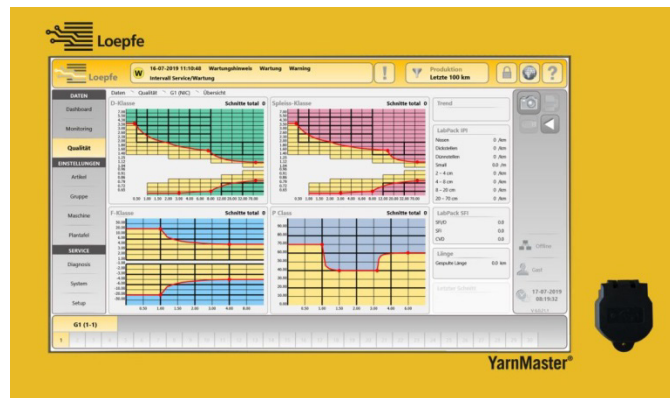
检测头



连接板



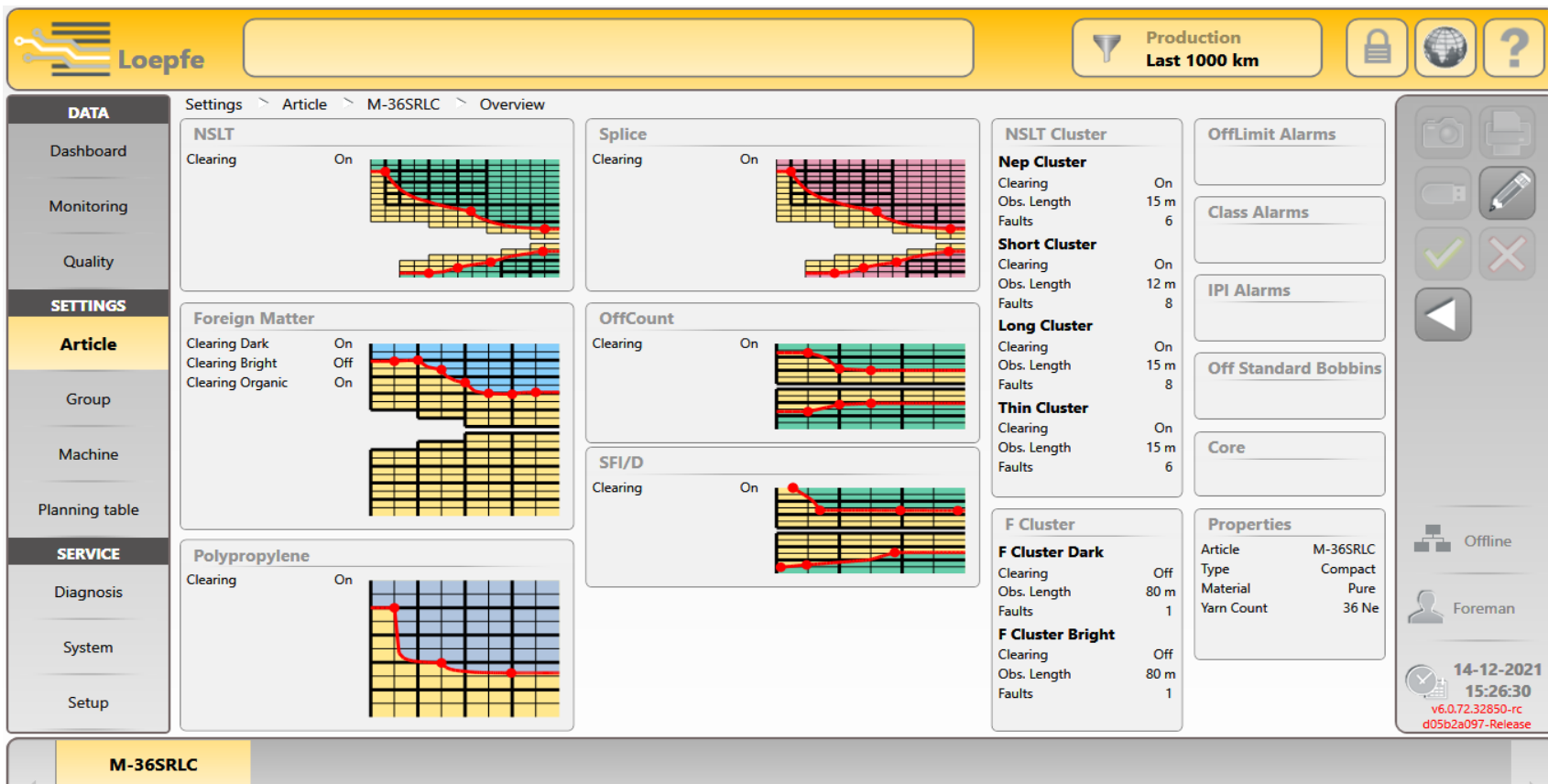
LEZ6 控制箱

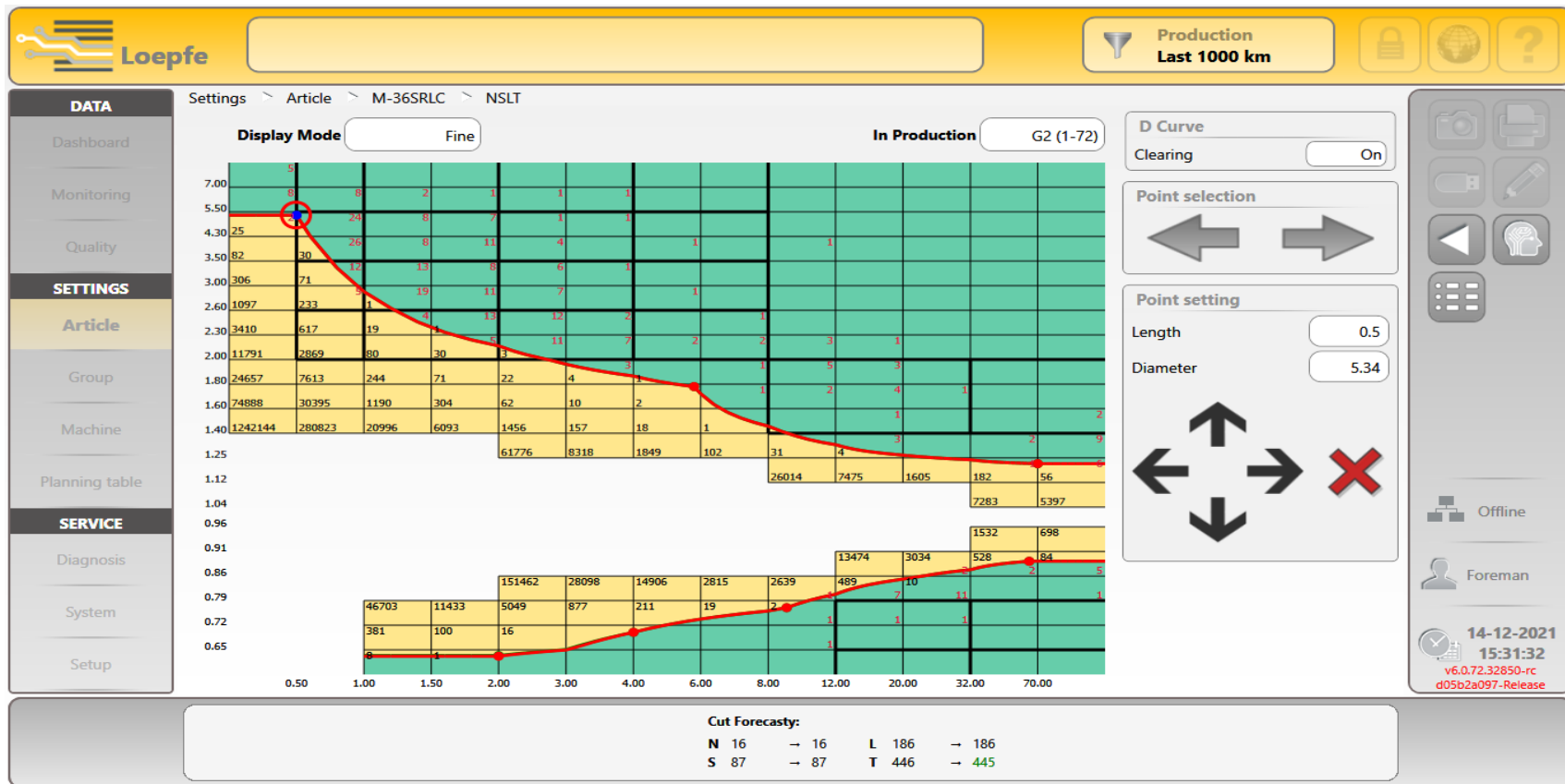


YarnMaster[®] PRISMA有哪些新功能

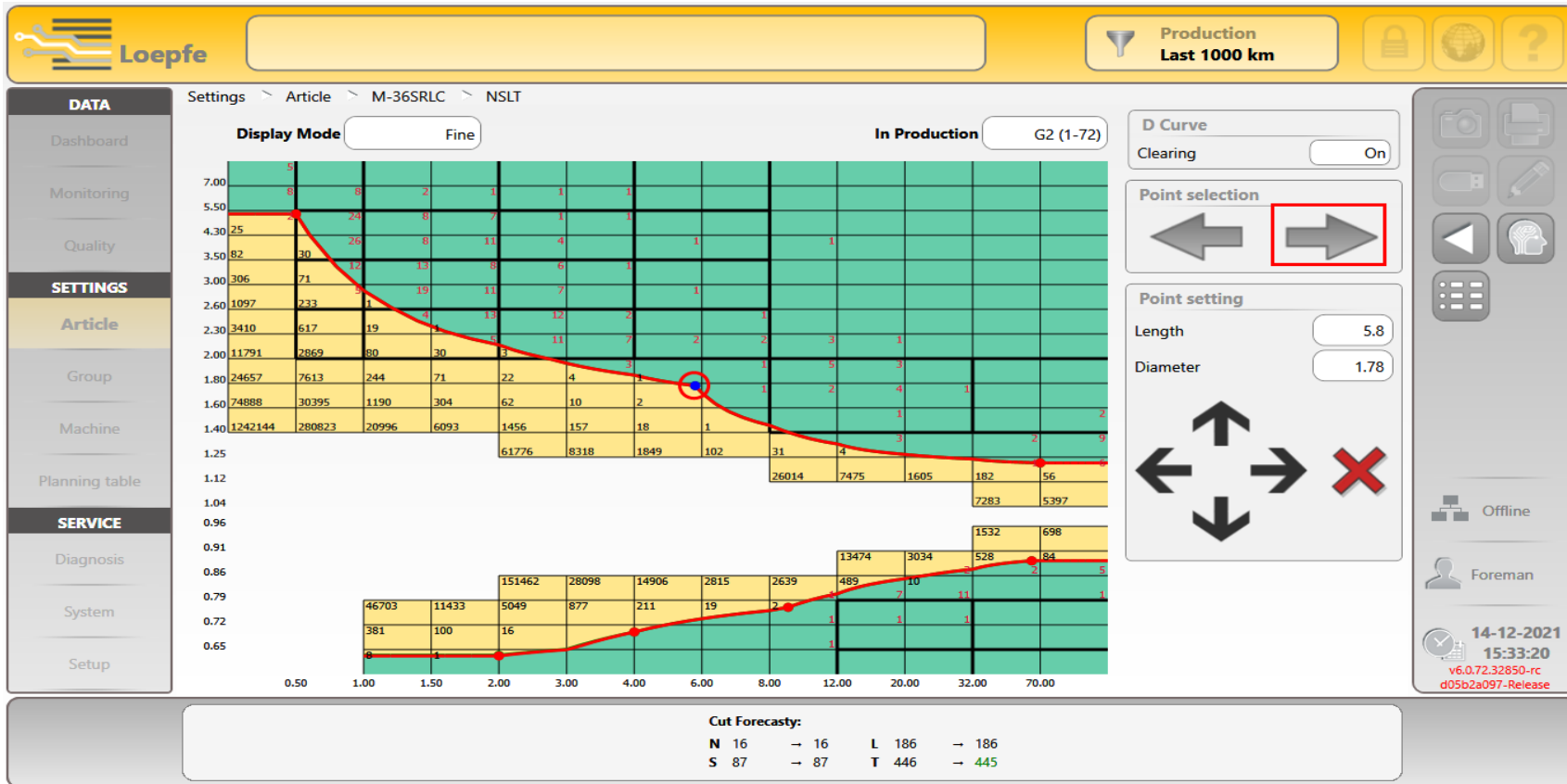
- 清纱曲线最多可设24个设定点（16个为NSL曲线的设定点，8个为细节曲线的设定点）
- 异纤清纱曲线最多可设16个设定点（8个为偏暗设定点，8个为偏亮设定点）
- 异纤有机过滤的清纱曲线最多有8个设定点。
- P功能的清纱曲线也有最多8个设定点。
- NSLT疵群的清纱曲线最多可设10个设定点（5个为NSL疵群设定点，5个为细节疵群设定点）
- 错支的清纱曲线最多可设10个设定点（5个为偏粗设定点，5个为偏细设定点）

- SFI/D毛羽的清纱曲线最多可设10个设定点 (5个为正极限设定点，5个为负极限 设定点)
- 为错支通道及SFI/D通道引入分级
- 专用的通道检测缺芯和偏芯纱
- 为优化设定而设的智能大脑模式。有助于找到基于纱线质量的最佳清纱极限。
- 最后20个切纱包含疵点敏感度和疵点长度，用以监测独立单锭
- 修改了纱种和组群的管理。现在可以对纱种和组群进行“添加”或“删除”操作。

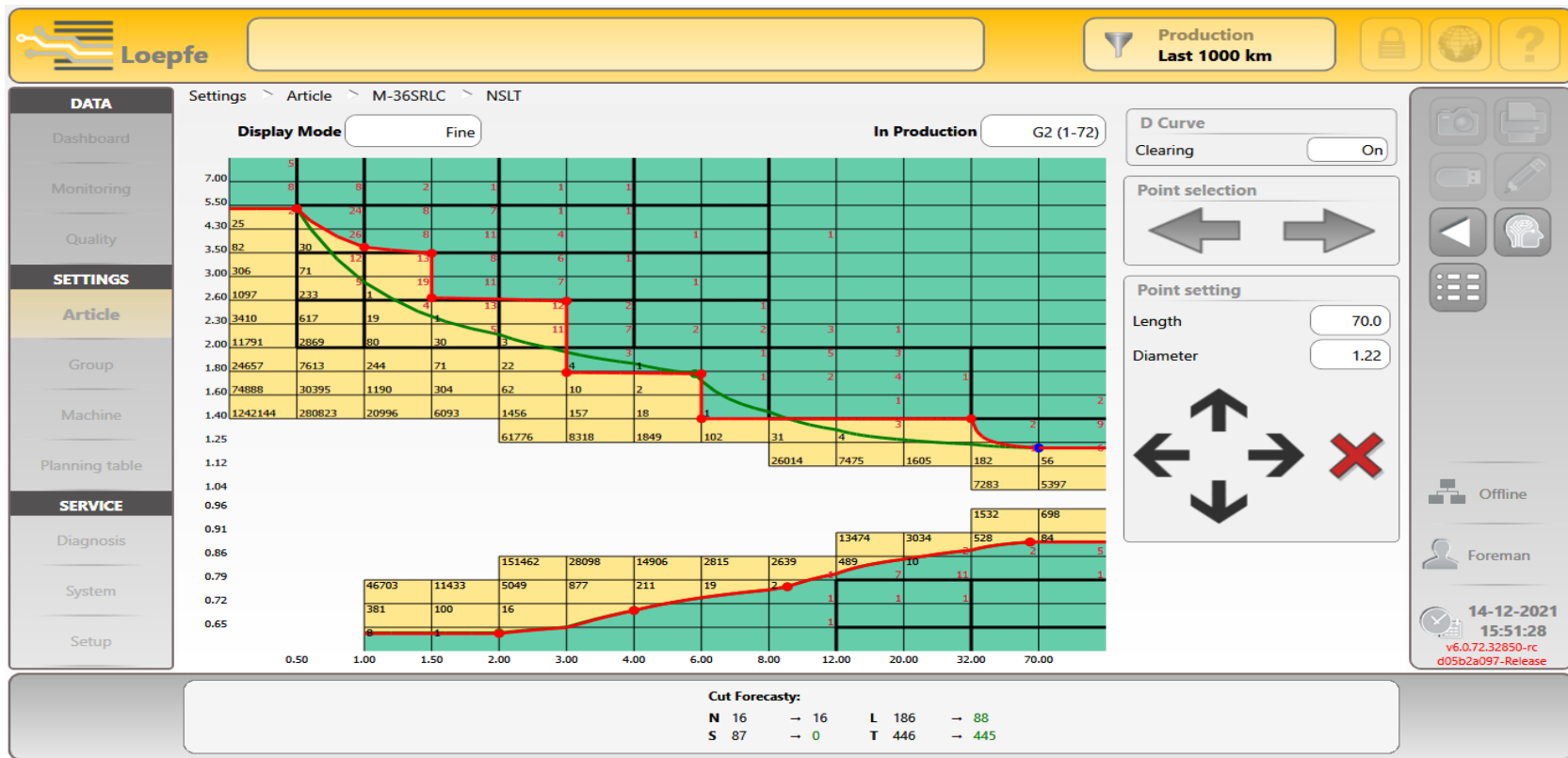




Point Selection → The Next point can be selected by pressing the highlighted arrow.
 设定点的选择 → 通过指示箭头选择下一个设定点



设定点 → 在多点触控技术的帮助下，可以通过触摸屏幕添加新的设定点到所需的清纱的区域。绿色曲线表示更改前的曲线设定，红色曲线表示新设定。在确认设定更改之前，两者都可见。



设定点 → 按下这个按钮，所有设定点的数值都可以在一个页面上看到。

Loepfe

Production Last 1000 km

Settings > Article > M-36SRLC > NSLT (Point list)

	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			

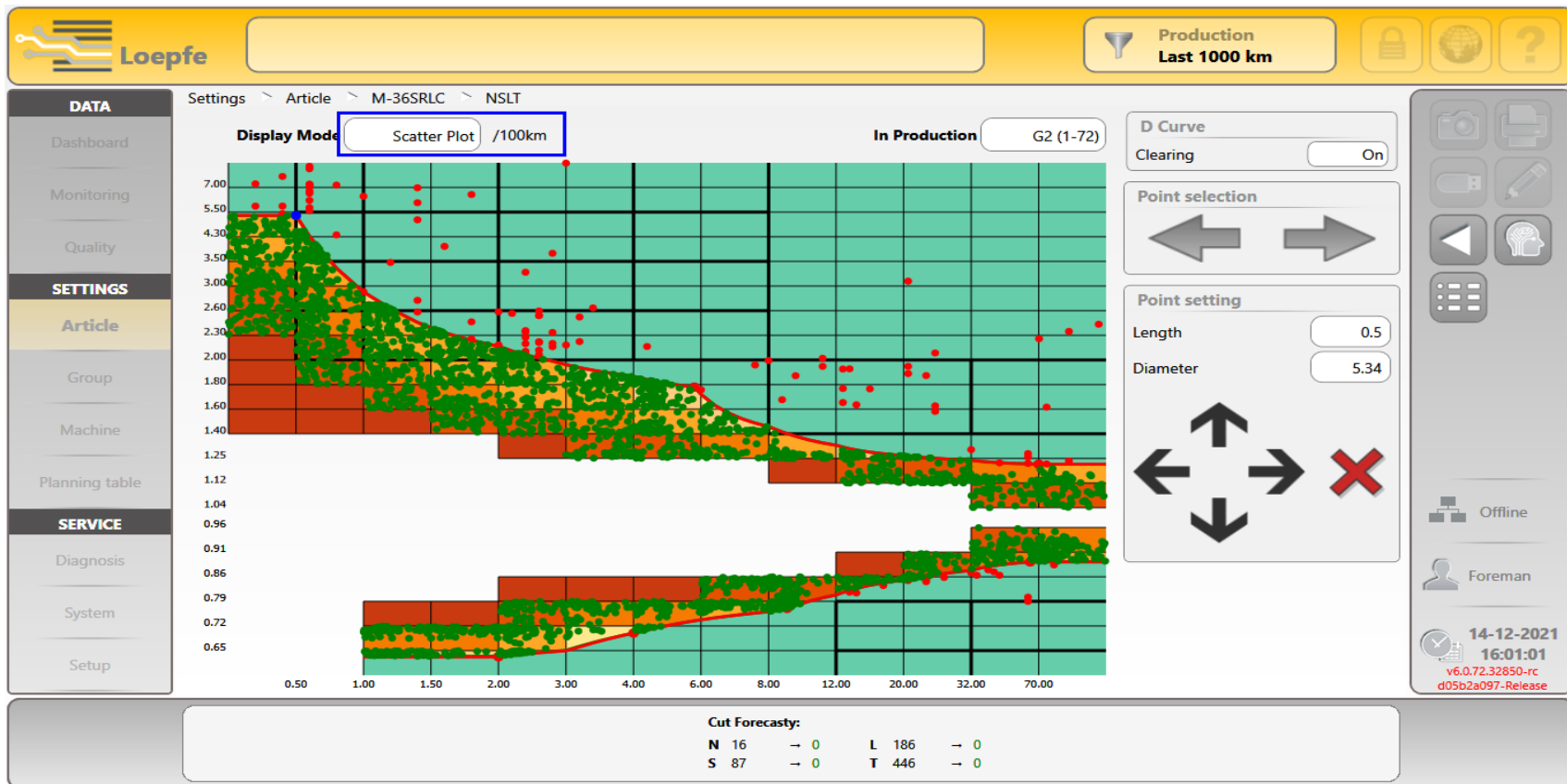
M-36SRLC

Offline

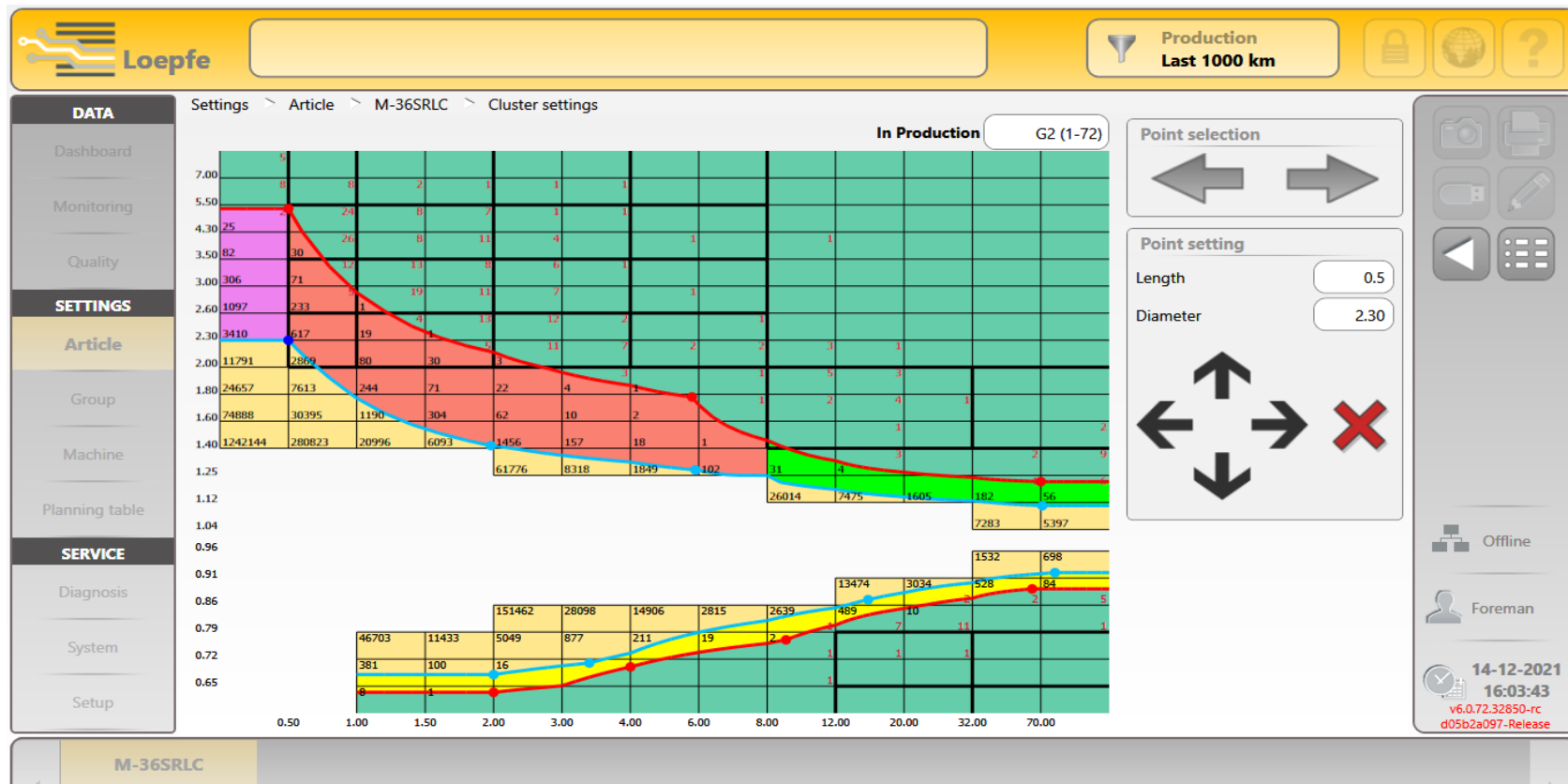
Foreman

14-12-2021 15:53:05
v6.0.72.32850-rc
d05b2a097-Release

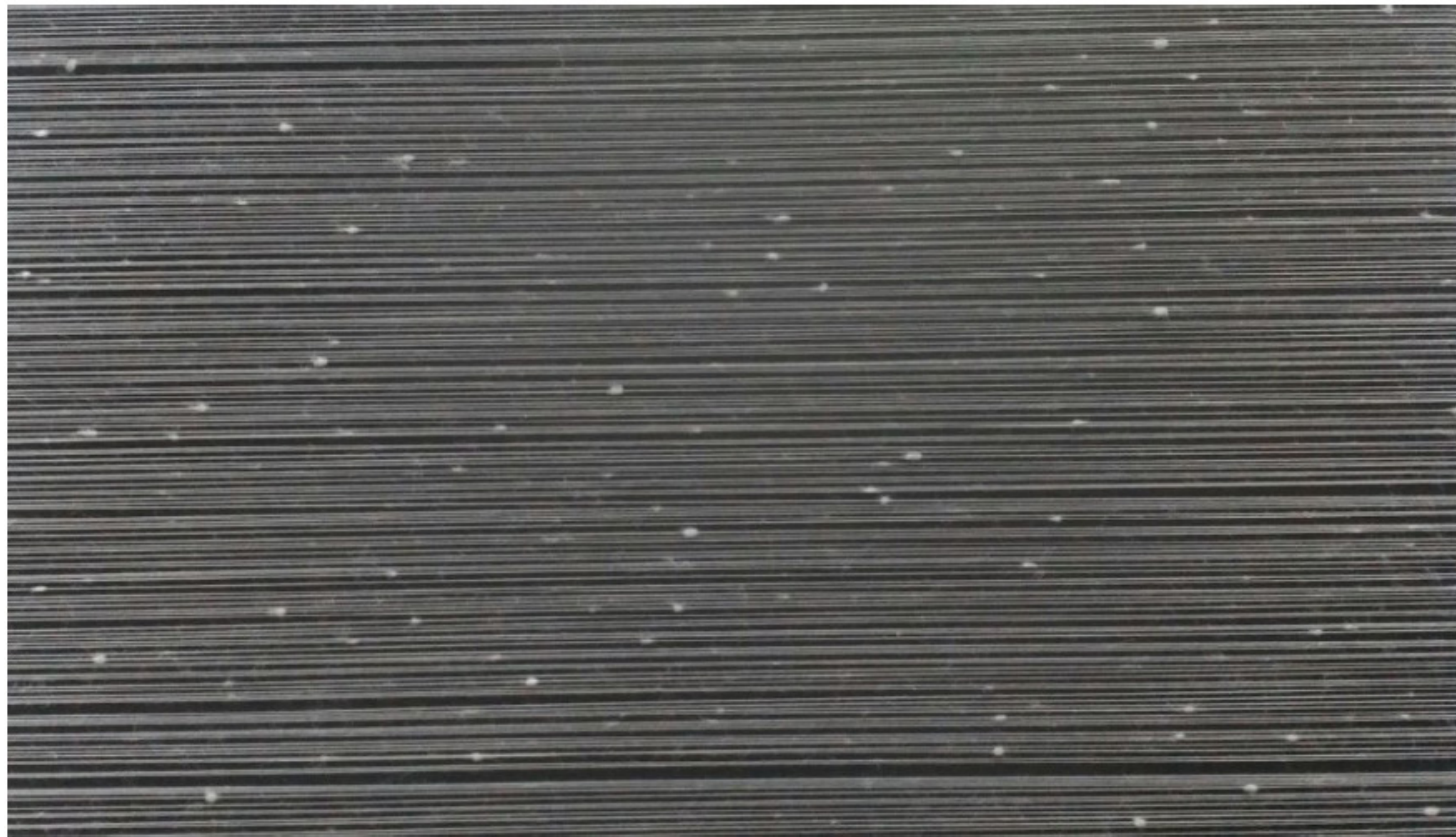
散点图 → 在散点图中可以看到纱疵的分布，便于进一步优化设定。



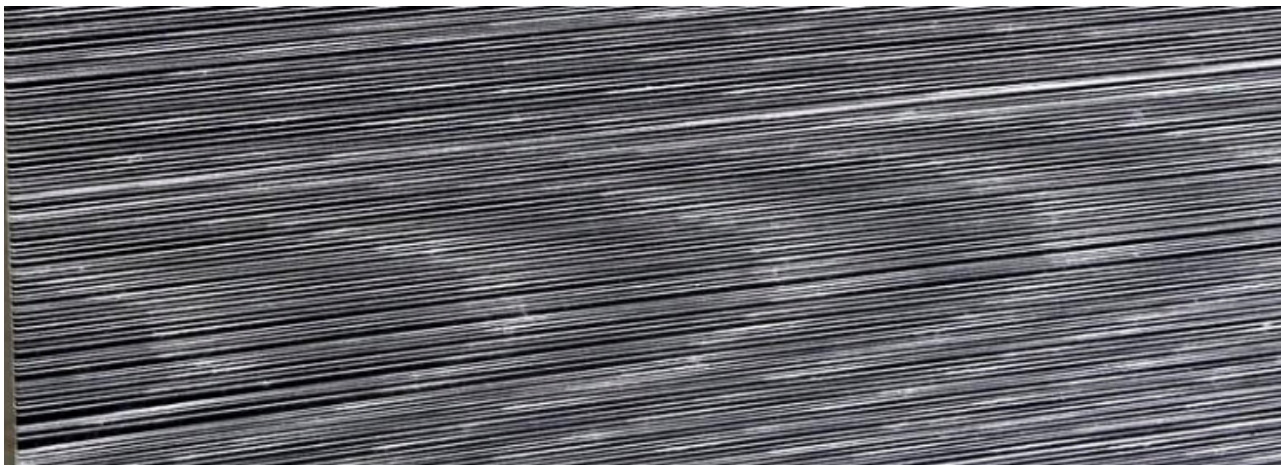
疵群 → 在疵群通道中可以检测到周期性和非周期性纱疵。用户需要定义清纱限值。紫色-棉结疵群，红色-短疵群，绿色-长疵群，黄色-偏细疵群。



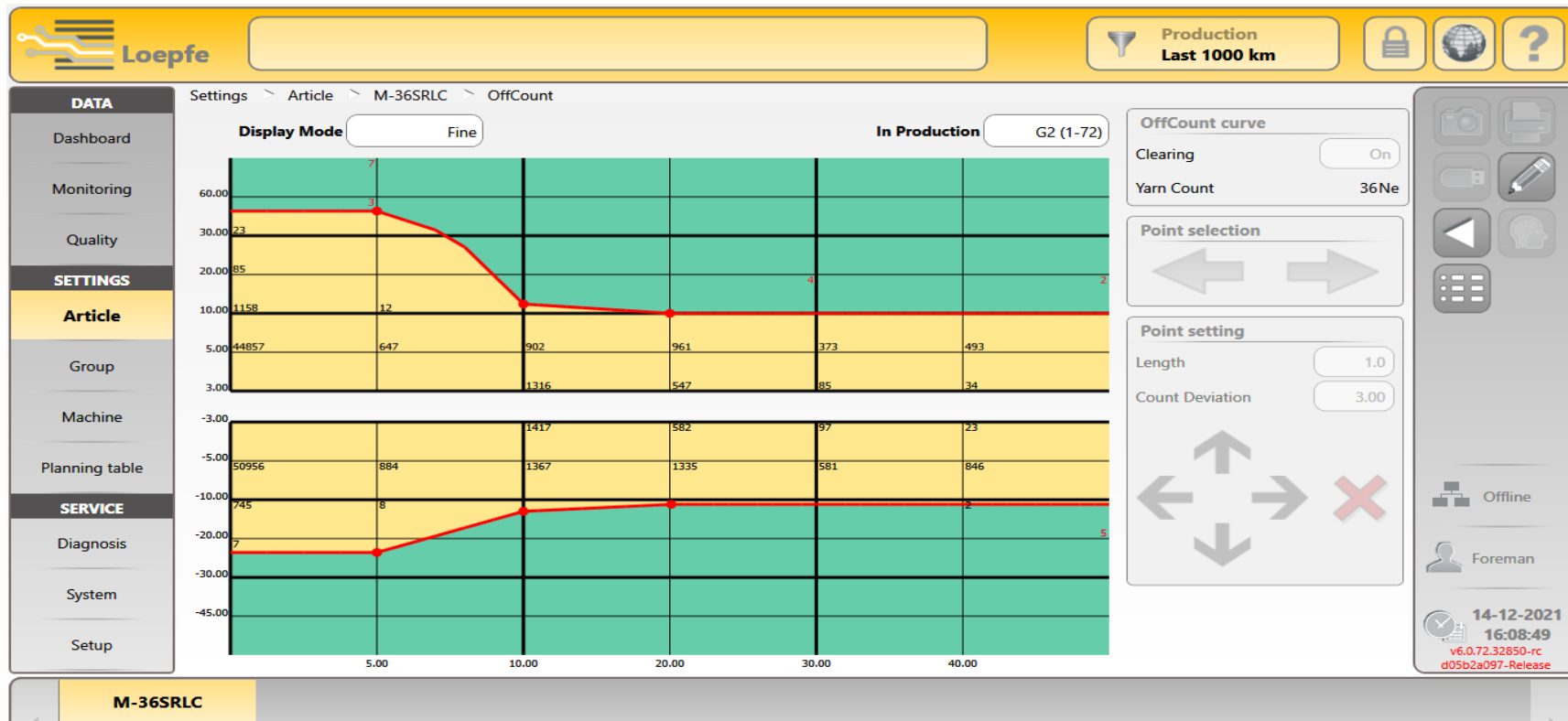
棉结疵群 → 这种周期性的棉结纱疵可以在棉结疵群中检测到。



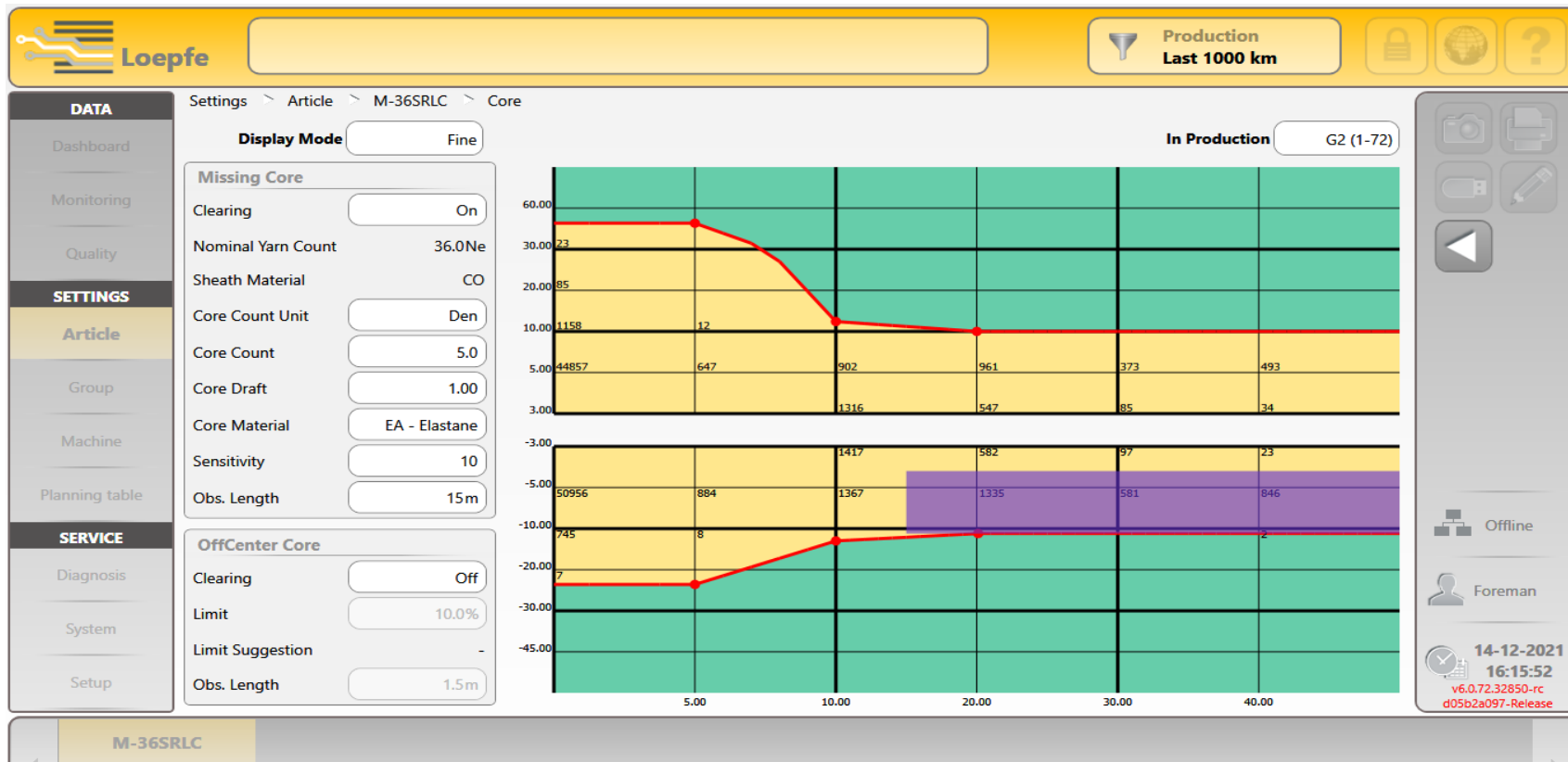
短疵群→ 这些周期性的纱疵可以在短疵群中检测到。



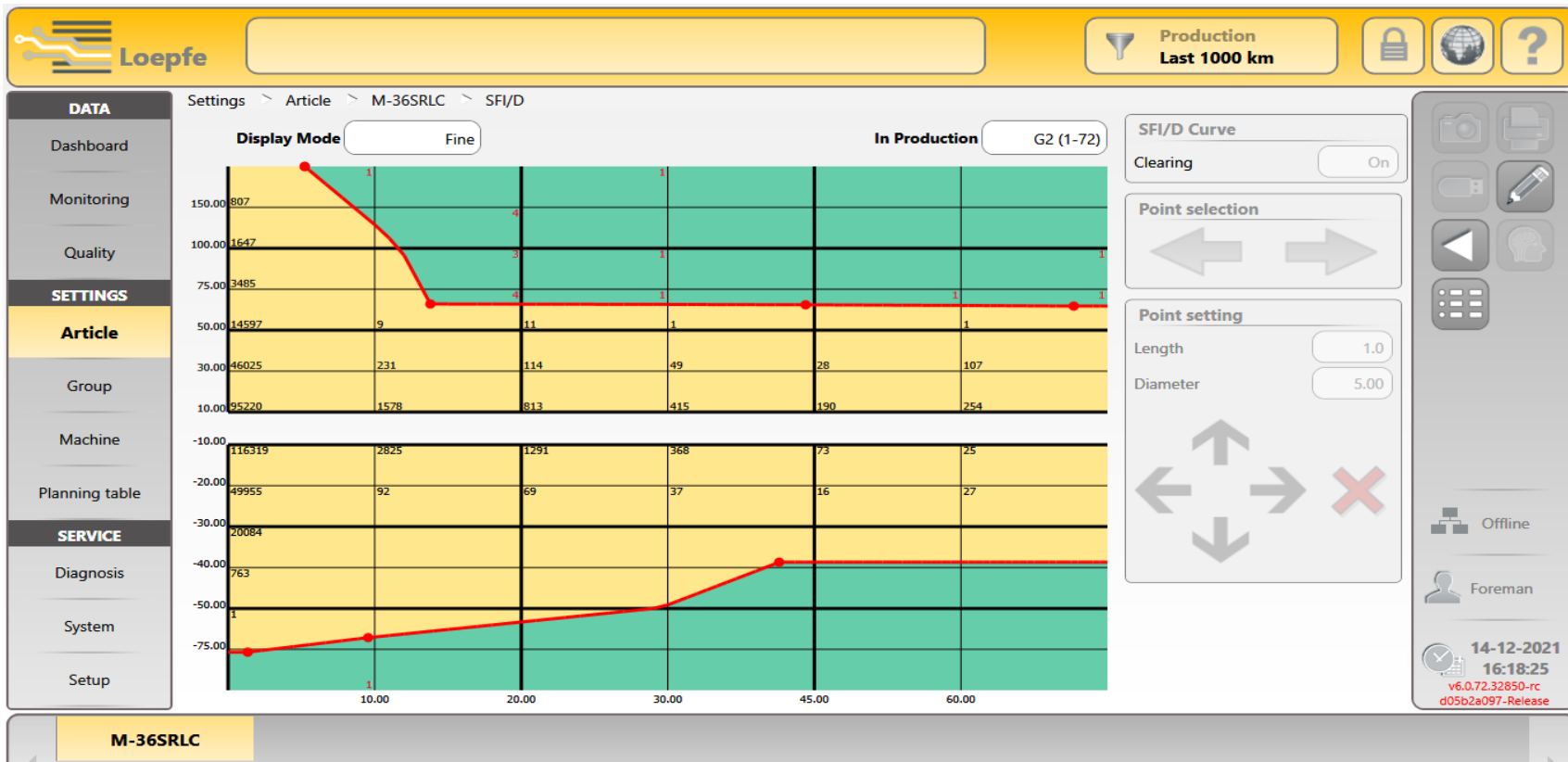
错支通道→清纱曲线可以用设定点生成。清纱总长度为50米。纱疵分级是为了方便的优化设定和检查运行中管纱的质量。如下图反映了管纱的支数变化。



包芯纱通道→可以通过错支检测通道分别对包芯纱线进行缺芯和偏芯检测。包芯纱检测为负计数偏差显示在紫色区域，芯纱的支数规格和位置根据输入的参数值，如芯纱支数、牵伸、灵敏度设定点和监测长度来检测。



SFI / D → 清纱曲线可以用设定点标出。清纱总长度为80米。纱疵分级是为了方便的优化设定和检查运行中纱线的品质。



不良管纱检测 → 不良管纱检测通道检测到换管后的纱支异常和颜色偏差，该管纱将会立即移除。不良管纱检测只有在更换管纱后检测到在定义的长度和偏差才会生效。不良管纱将分开统计。

The screenshot shows the Loepfe spinning control 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 > M-36SRLC > Off Standard Bobbins.

The main content area is divided into two columns of settings. The left column lists 'Alarm Limit / Bobbin', 'Cuts / Bobbin', 'Alarms', and 'Bad Bobbins' for various categories like NSLT, _Neps, _Short, _Long, _Thin, Max. Surface Cuts, _OffCount, _Short OffCount, _Nep Cluster, _Short Cluster, and _Long Cluster. The right column lists similar settings for categories like _Thin Cluster, _SFI/D, _Short SFI/D, F, F Organic, F Cluster, F OffColor, P, Missing Core, OffCenter Core, and Max. Cuts.

Below the settings, there is a 'Bad Bobbin Detection' section highlighted with a red box. It contains the following controls:

- Enable Count Check: On
- Enable Color Check: Off
- Count Deviation Limit: 10.0%
- Color Deviation Limit: 0.1%
- Check Length: 12m

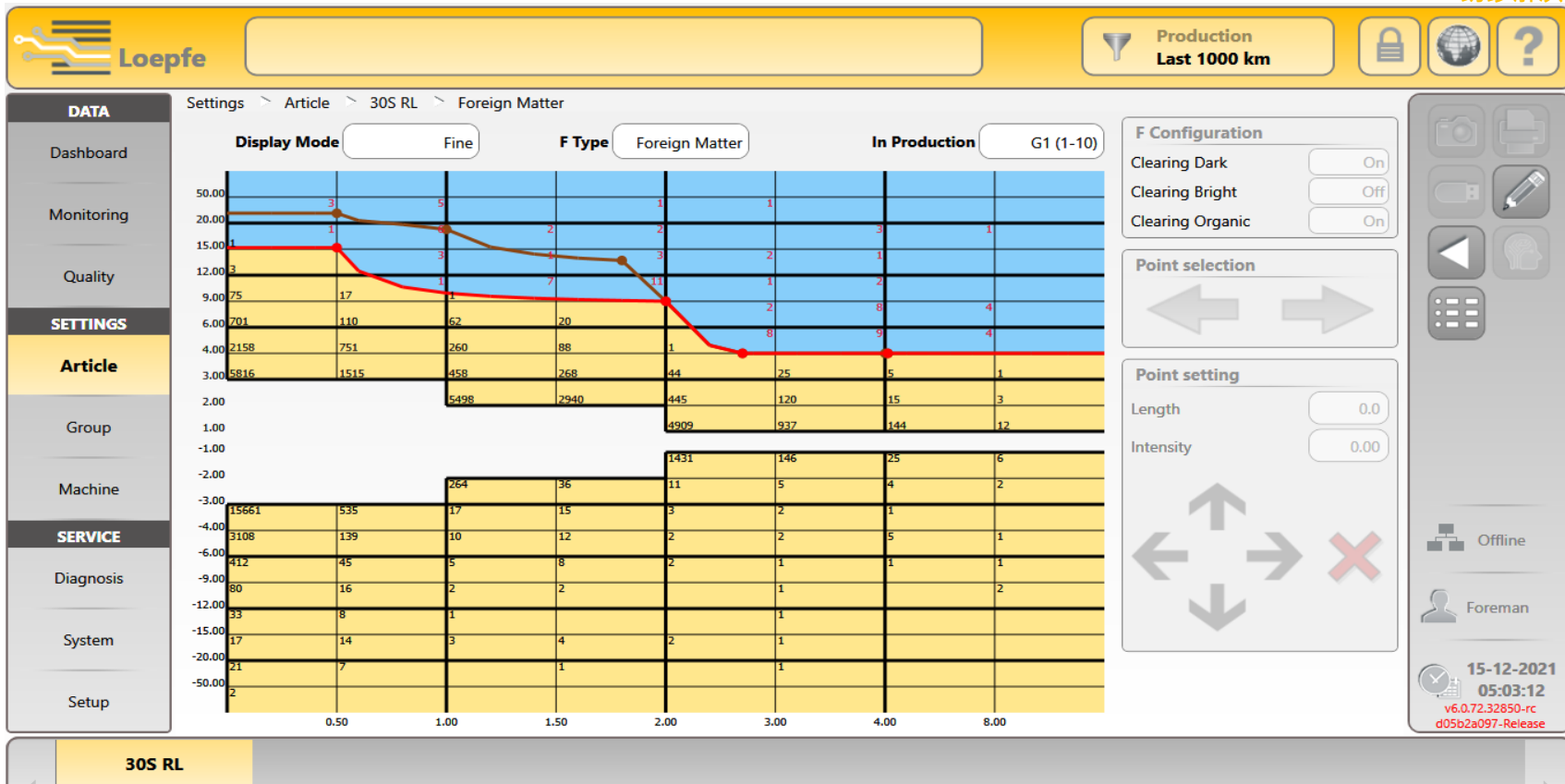
At the bottom right, there is an 'In Production' indicator showing 'G2 (1-72)' and a status bar with the date '14-12-2021', time '16:10:22', and version information 'v6.0.72.32850-rc d05b2a097-Release'.

RGB三原色白光色纤检测

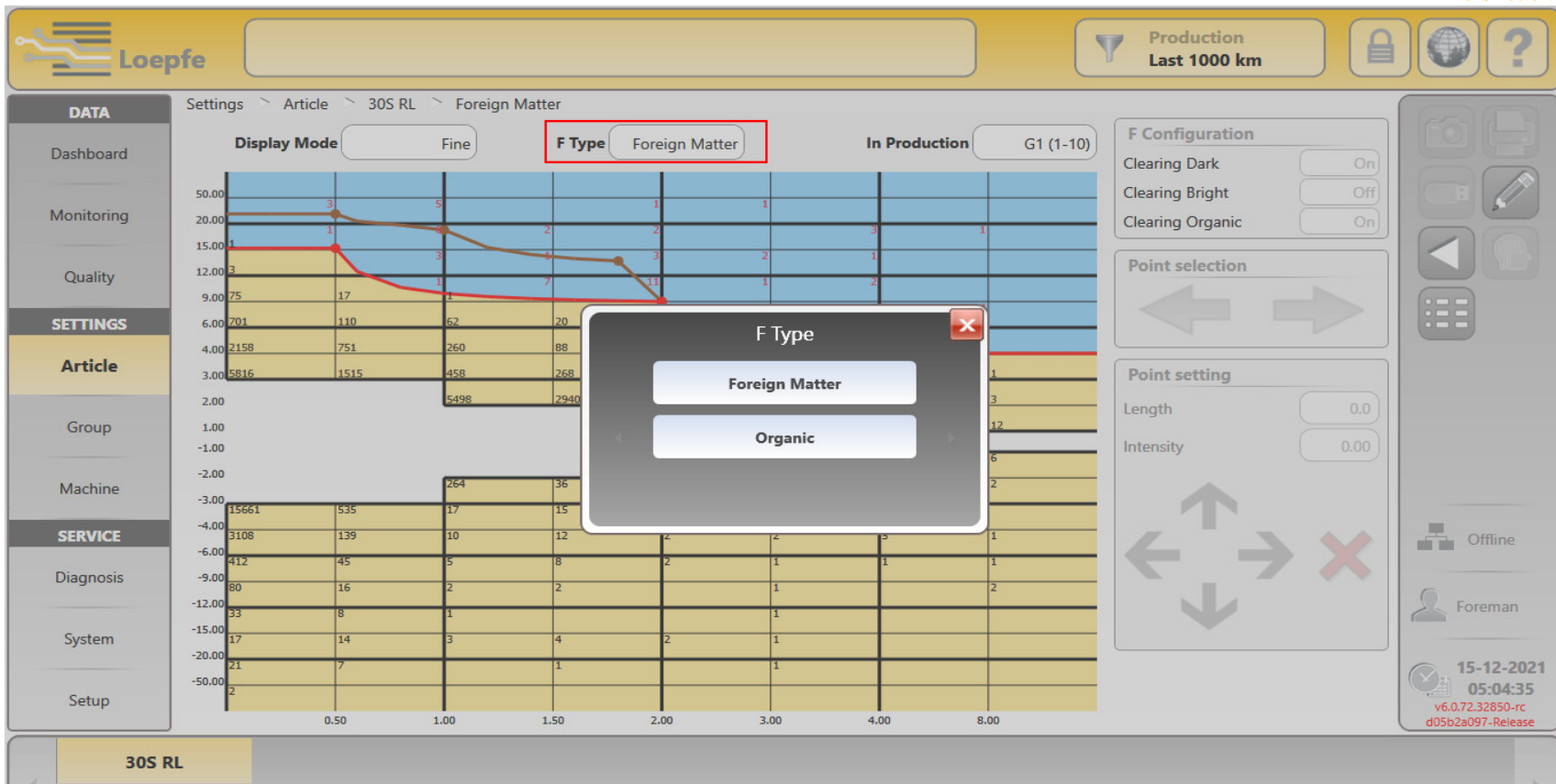
新超强功能的RGB三原色白光色纤传感器的优点

- 改进了对非常浅色异纤的检测
- 区分异纤和有机物
- 对异纤和有机过滤物进行精细分级清纱.
- 改进周期性的异纤 (异纤疵群)检测
- 增加 I, R, O 分级。它们分别为 I0 分级 R0 分级和 O0 分级区。
- 智能有机过滤通道，减少不必要的植异纤切疵, 增加效率。

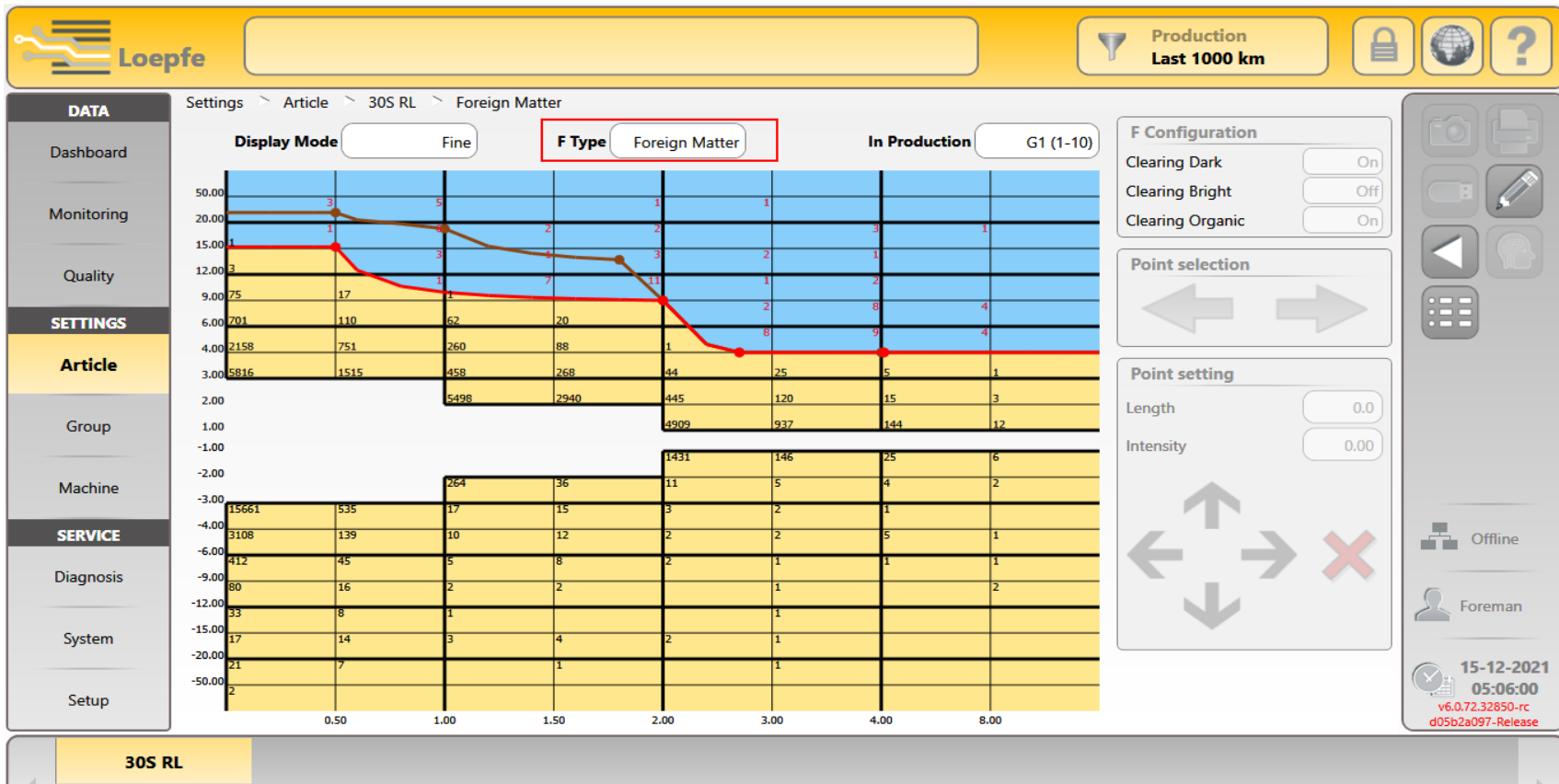
异纤架构 → 由两条清线曲线组成，红色和棕色。红色——异纤曲线，棕色——有机过滤曲线



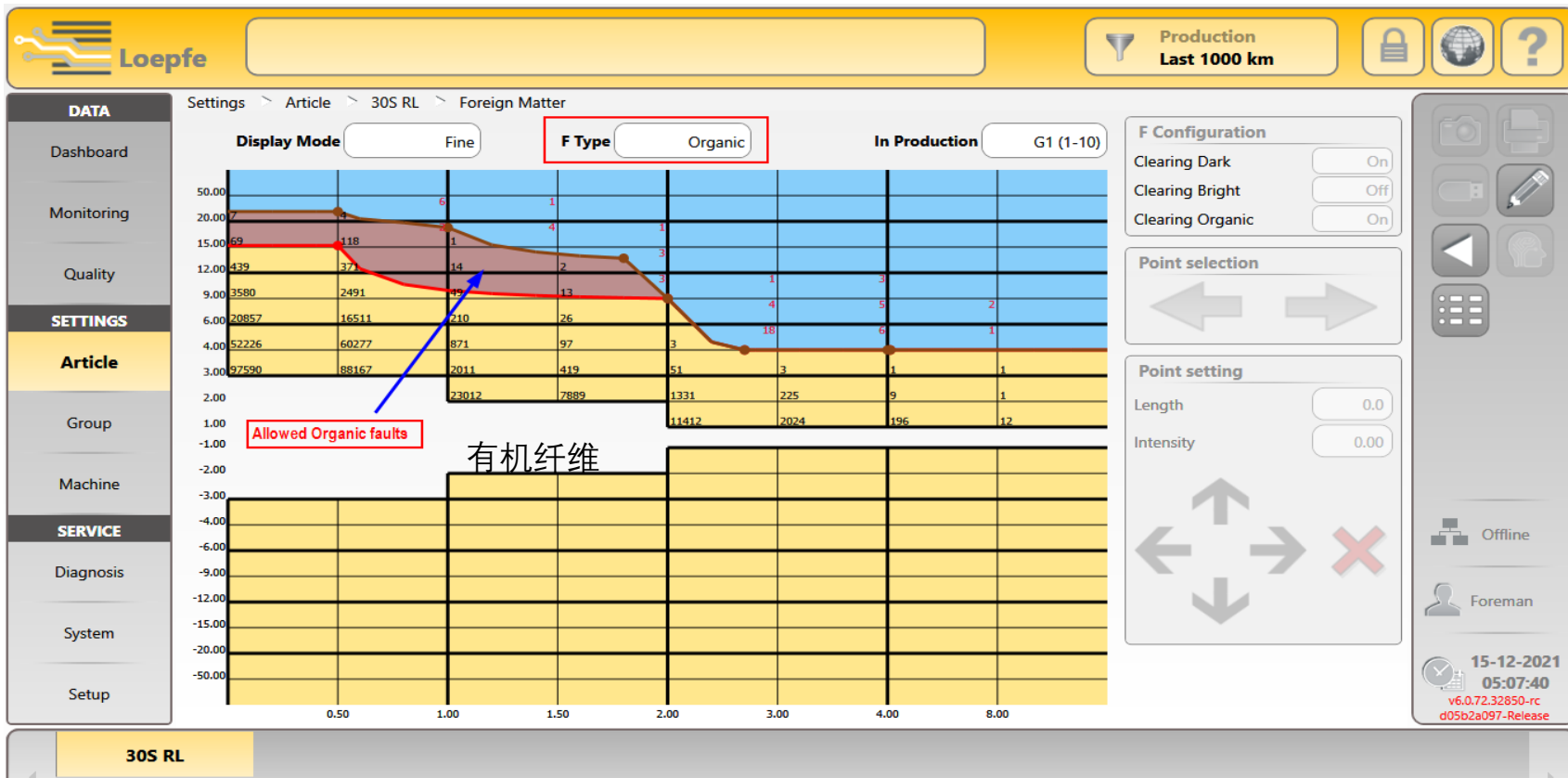
异纤类型 → 异纤选项和有机过滤选项两种，可以在这个界面切换。



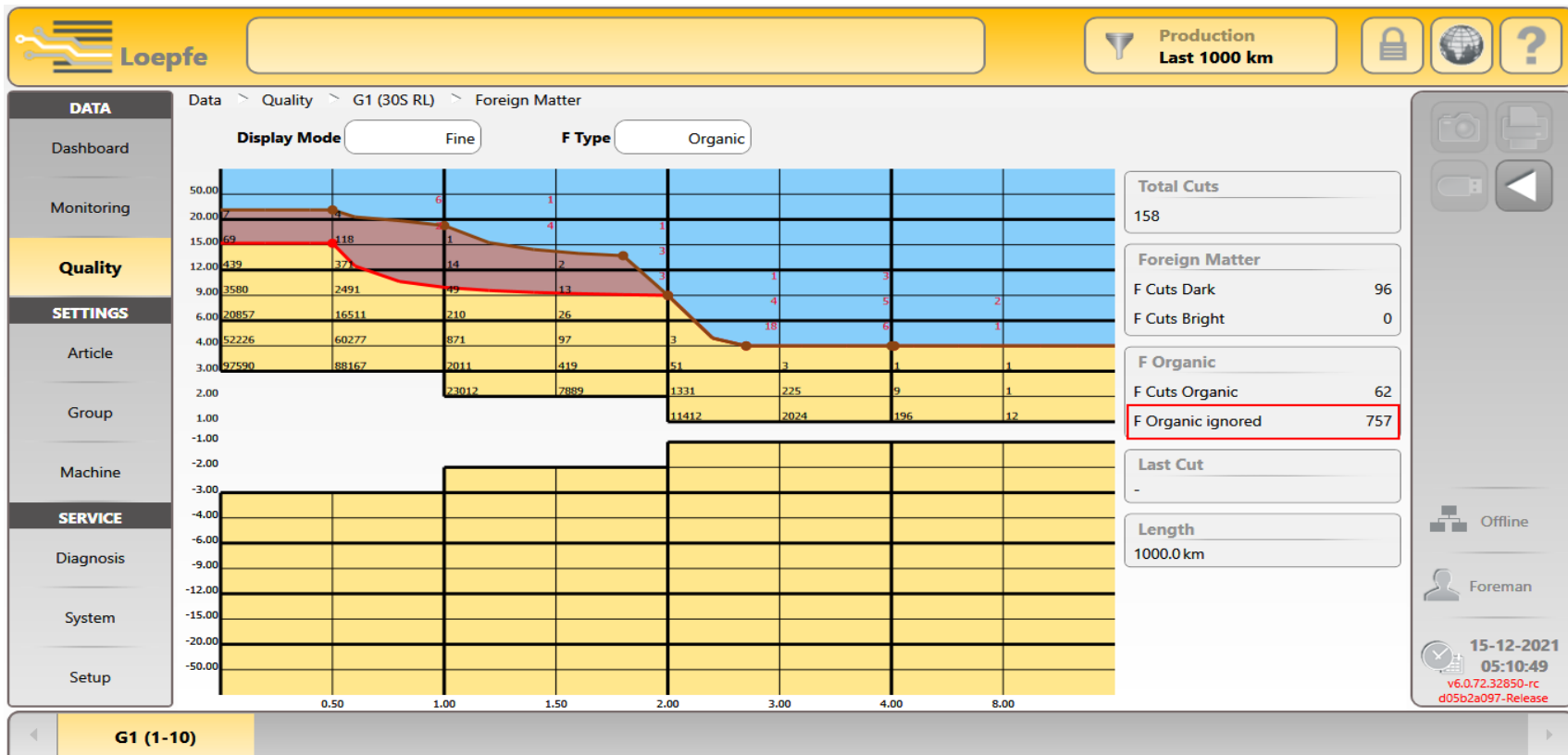
异纤检测 → 检测偏暗或偏亮的异纤



异纤有机过滤检测 → 像棉籽壳和黄麻这样的有机纤维。划分在异纤和有机过滤之间不会切除。这将减少异纤切疵的总数。



异纤有机过滤检测 → 可以通过优化有机过滤通道来减少异纤切疵总数。在异纤有机过滤的分级数据中可以看到允许通过的有机纤维总数。这样可“节省”异纤切疵数。



YarnMaster® PRISMA电子清纱器的首次启动

YarnMaster PRISMA配备了全新的硬件—LZE-6控制箱。LZE-6控制箱适用于YM PRISMA以及YM ZENIT+电子清纱器

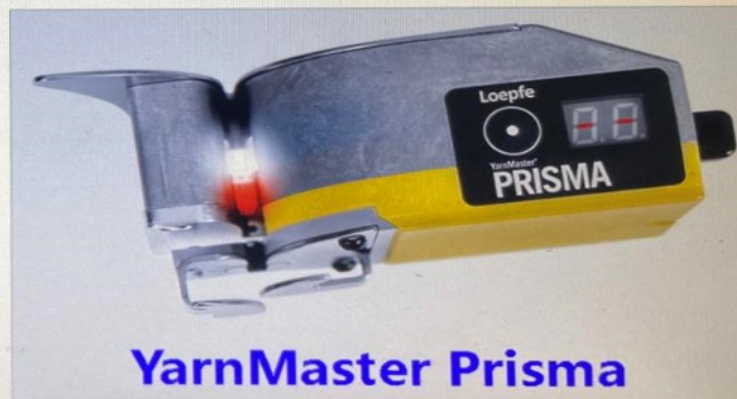
在第一次启动时需要设置适当的电子清纱器系统:

1. 打开/启动LZE-6控制箱
2. 选择合适的电子清纱器系统
3. 确认所选的电子清纱器系统(用于安装合适的电子清纱器的用户界面)
4. 系统自动更新主模块固件
5. 控制箱将跳转到启动向导程序进行电子清纱器的配置(参见操作手册第4章)



選擇清紗器型號

Please choose clearer system:



再次确认所选的电子清纱器系统：



此型PRISMA號是否正確 (Lze -6.0.51.1)?

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

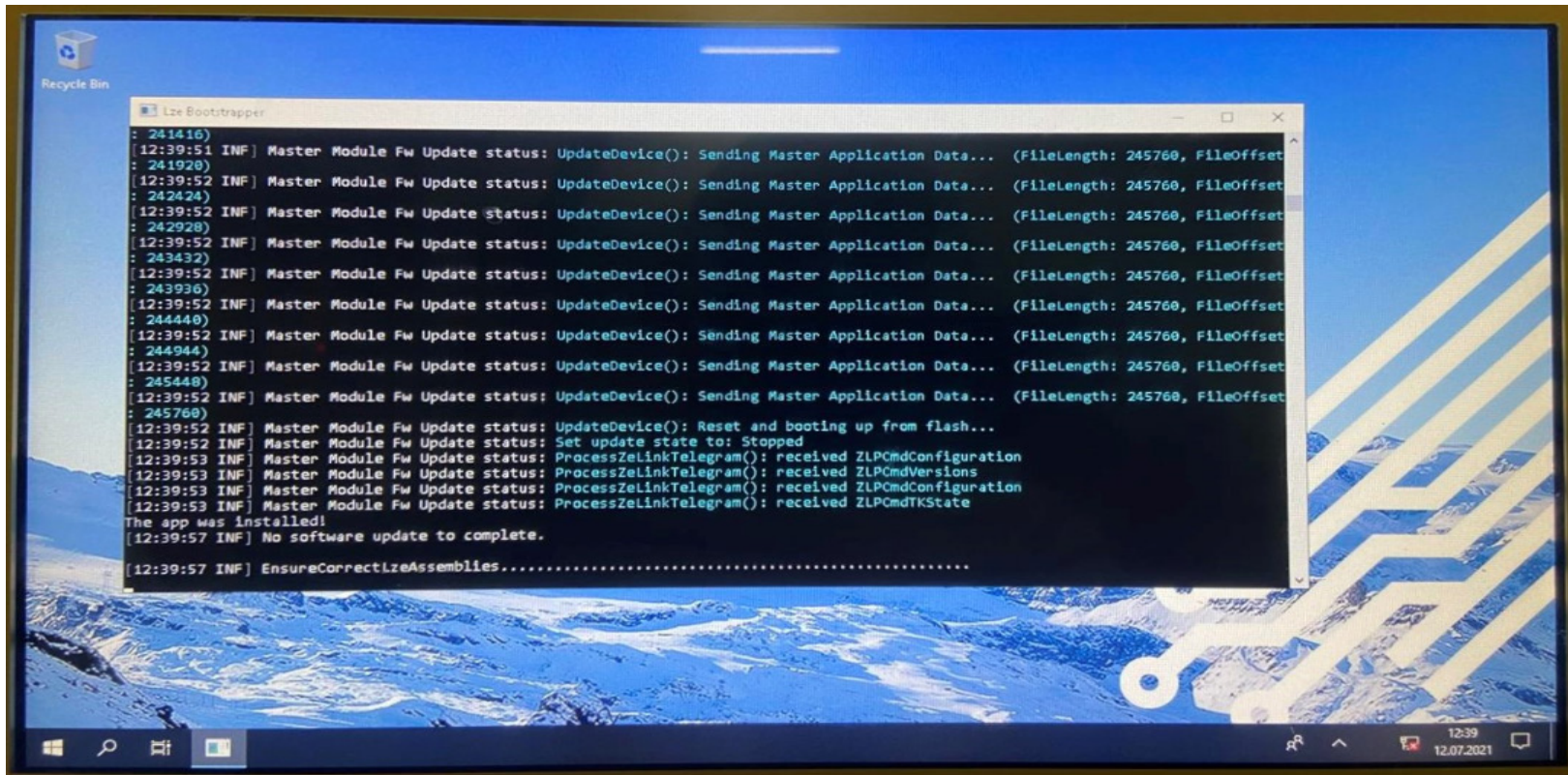


No

Yes



安装完成和启动



在控制箱成功重启后，完成安装向导并重新确认LZE-6控制箱正确安装。

进入“机器”菜单，选择基本设定。检查机器型号，总锭子数和检测头型号。

1. 检查“机器型号”中设置的机器型号是否正确
2. 检查/更正“总锭子数”中的锭位数量
3. 在“检测头型号”(DM, DMF, DMFP)中检查/确认检测头的正确类型
4. 如果机器配备了湿捻器，湿捻器(Nassspleiser)选项需要打开。
5. 保存所有的设定更改！

基本设定→增加了比重传感器·检测头的型号分为：DM, DMF, DMFP

Settings > Machine > Base Settings

Base Settings

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	25cm
Previous Shift	km
Wet Splicer	Off

14-12-2021 16:21:48
v6.0.72.32850-rc
d05b2a097-Release

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 'DATA' (Dashboard, Monitoring, Quality), 'SETTINGS' (Article, Group, Machine, Planning table), and 'SERVICE' (Diagnosis, System, Setup). The 'Machine' section is active, showing 'Base Settings' for a 'Savio Orion/Polar' machine. The settings list includes Machine Name (MC 22), MMTop Link (On), Total Spindles (72), Yarn Count Unit, Splice Check Length, Previous Shift, and Wet Splicer. A modal dialog titled 'Sensing Head Type' is open, showing the current selection as 'none' and three options: DM, DMF, and DMFP. The right sidebar contains utility icons (camera, printer, lock, globe, help), status indicators (Offline, Foreman), and system information (date: 14-12-2021, time: 16:22:39, version: v6.0.72.32850-rc, release: d05b2a097-Release).

湿捻结器功能→ 如果机台配备了湿捻结器，湿捻选项需要打开

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 'DATA', 'SETTINGS', and 'SERVICE' sections. The 'Machine' section is highlighted. The main content area shows 'Base Settings' for a 'Savio Orion/Polar' machine, with fields for 'Machine Name' (MC 22), 'MMTop Link' (On), and 'Total Spindles' (72). A 'Wet Splicer' dialog box is open, showing the current status as 'none' and two options: 'Off' and 'On'. The 'Wet Splicer' option in the main settings list is highlighted with a red box. The right sidebar contains various control icons, including a green checkmark and a red X, and status information such as 'Offline', 'Foreman', and the date/time '14-12-2021 16:23:32'.

固件升级

第一次启动机台可能需要更新电清引导装载程序或固件

1. 进入“系统”菜单
2. 选择“固件升级”
3. 检查所有单锭的固件和引导启动加载程序版本。如果版本显示为“红色”，固件或引导装载程序必须要更新。
4. 使用领导者密码“12911291”登入。
5. 按“TK引导装载程序/固件”按键下载固件
6. 更新成功后，“红色”会变成“黑色”。

Service \ System \ Firmware Update

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)	0 %	

Master Module

Version	2.0.12.0
Update State	Application

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

Production Last 1000 km

Dashboard

Monitoring

Quality

SETTINGS

Article

Group

Machine

Planning table

SERVICE

Diagnosis

System

Setup

Press this button

按这个按钮下载

Online

Foreman

14-12-2021 16:37:23
v6.0.72.32850-rc
d05b2a097-Release

在进行更新：

Loepfe Production Last 1000 km

Service > System > Firmware Update

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)	47 %	

Master Module

Version	2.0.12.0
Update State	MasterBootLoader

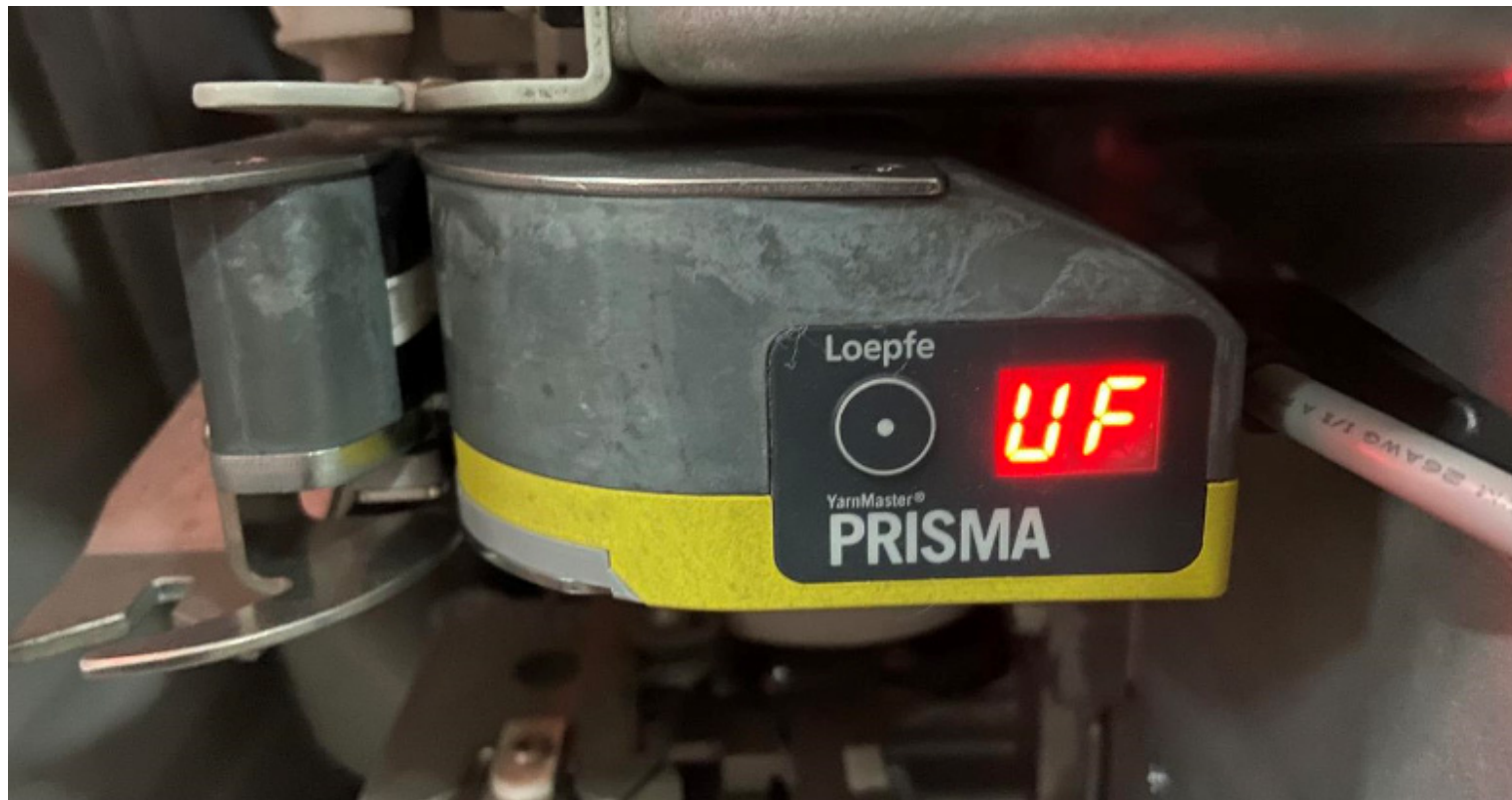
Spindles

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

Navigation: Dashboard, Monitoring, Quality, Article, Group, Machine, Planning table, Diagnosis, System, Setup

Right Sidebar: Online, Foreman, 14-12-2021 16:39:07, v6.0.72.32850-rc d05b2a097-Release

固件更新→ 更新固件时，检测头的显示器会显示“UF”



固件更新完成后，“黑色”颜色的版本的TK是完成更新。如果部分检测头的固件版本仍旧是“红色”或“空白”，则需要重复更新，直到所有检测头完全更新完毕。

The screenshot displays the Loepfe software interface for a spinning machine. The top navigation bar includes the Loepfe logo, a search field, and a filter for 'Production Last 1000 km'. The left sidebar contains menu items for DATA, SETTINGS, and SERVICE. The main content area is divided into several panels:

- Firmware Archive:** Lists the current versions for Master Module (2.0.12.0), Bootloader (6.0.25.19400-24b7cc77), and Firmware (6.0.77.32988-0e85a2c5).
- Update Progress:** Shows progress bars for Master Module and TK (bootloader/firmware), both at 100%.
- Master Module:** Shows the current version (2.0.12.0) and update state (Application).
- Spindles:** A table listing 10 spindles with their respective firmware and bootloader versions.

On the right side, there are control icons for camera, settings, and a 'Foreman' section showing the current date and time: 14-12-2021 16:40:58, along with version information: v6.0.72.32850-rc d05b2a097-Release.

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

固件更新后，检测头显示“PA”。检测头已经准备好运行并等待分配纱种参数。



错误→ 在主模块或固件更新时，错误信息“主模块离线”将出现几秒钟后消失。你可以忽略它，不会影响固件更新。

The screenshot displays the Loepfe service interface. The top navigation bar includes the Loepfe logo, a search bar, and a production status indicator showing 'Production Last 100 km'. The main content area is divided into several sections:

- Service > System > Firmware Update**: This section contains two sub-panels. The 'Firmware Archive' panel lists the following information:

Component	Version
Master Module	2.0.12.0
Bootloader	6.0.25.19400-24b7cc77
Firmware	6.0.59.30085-f72b678d

The 'Update Progress' panel shows the update status for the Master Module (78%) and TK (bootloader/firmware) (100%).
- Master Module**: This panel displays the 'Version' as 2.0.12.0 and the 'Update State' as 'MasterUpdate'. A red box highlights the text 'Master module is offline!'.
- Spindles**: This panel contains a table with the following data:

Spindle	Firmware	Bootloader
1	-	-
2	-	-
3	-	-
4	-	-
5	-	-
6	-	-
7	-	-
8	-	-
9	-	-
10	-	-

The right sidebar contains various utility icons, including a camera, a printer, a refresh button, and a close button. At the bottom right, there is a status bar showing the date and time '21-04-2021 15:00:20' and the version 'v6.0.60.30211-rc 1660ca3b5-Release'.

纱种和组群的管理

纱种的设定包含了不同的清纱通道的设定(NSLT通道,异纤通道,错支通道等)。纱种可以“添加”或“删除”，但是，不能删除已分配给正在运行的组群。

进入“纱种”菜单进行添加纱种

1. 按+（添加按钮）创建一个新的纱种
2. 新纱种有4个选项
 - a. 直接输入纱种设置
 - b. 使用纱线参数设置推荐
 - c. 复制纱种设置
 - d. 从USB导入纱种设置
3. 选择上述合适的添加选项

建立新纱种：

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 > 30S VL > List. The main content area features a table with columns: Article, Type, Count, Material, Last Change, and Active in group. A single row is visible with the following data: Article (30S VL), Type (Compact), Count (28.5 Ne), Material (Pure), Last Change (01-04-2021 12:26:03), and Active in group (1). A modal dialog box titled 'Add article' is open in the center, containing four options with checkboxes: 'Enter Article Settings' (checked), 'Use Yarn Parameter for Setting Proposal', 'Copy Settings from an Article', and 'Import Settings from USB'. A green checkmark icon is visible in the bottom right corner of the dialog. The left sidebar contains menu items under 'DATA', 'SETTINGS', and 'SERVICE'. The right sidebar includes various icons for camera, printer, and other functions, along with a status section showing 'Online', a monitor icon, a download icon, a user icon labeled 'Service', and a timestamp '14-07-2021 20:53:41' with version 'v6.0.57.29993'.

Article	Type	Count	Material	Last Change	Active in group
30S VL	Compact	28.5 Ne	Pure	01-04-2021 12:26:03	1

Add article

- Enter Article Settings
- Use Yarn Parameter for Setting Proposal
- Copy Settings from an Article
- Import Settings from USB

添加新纱种选项：

直接输入纱种设置

用户需要输入所有清纱通道的工艺设定

使用纱线参数设置推荐

用户需要自己选择纱线参数，可选择在TOP 9、TOP 12、TOP 16级对NSLT进行工艺参数设定。对于“异纤”和“丙纶丝”的设定，可以选择“正常”、“中级”和“灵敏”程度进行设定。

复制纱种设置

已经存在的纱种工艺可以直接复制到新的纱种使用。

从USB导入纱种设置

纱种的工艺设定可以从USB直接下载到LZE-6控制箱

输入纱种设置→选择所需的选项确认建立新纱种

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 > M-36SRLC > List. The main area shows a table with columns: Article, Type, Count, Material, Last Change, and Active in group. A single row is visible with the following data: M-36SRLC, Compact, 36 Ne, Pure, 02-12-2021 13:28:51, 2. An 'Add article' dialog box is open in the center, containing four options with checkboxes: 'Enter Article Settings' (checked), 'Use Yarn Parameter for Setting Proposal', 'Copy Settings from an Article', and 'Import Settings from USB'. A green checkmark icon is visible in the bottom right corner of the dialog box. The left sidebar contains sections for DATA (Dashboard, Monitoring, Quality), SETTINGS (Article, Group, Machine, Planning table), and SERVICE (Diagnosis, System, Setup). The right sidebar includes icons for camera, printer, and other functions, along with status indicators for 'Offline' and 'Foreman', and a clock showing '14-12-2021 17:03:12' and version information 'v6.0.72.32850-rc d05b2a097-Release'. At the bottom of the interface, the article name 'M-36SRLC' is displayed.

用户可以使用ZENIT+现有的NSLT工艺设定套用到PRISMA的NSLT设定。然而两种电清系统的取样长度和传感器灵敏度不相同，因此清纱结果必须检验和复核！

Loepfe

Production
Last 1000 km

Settings > Article > M-36SRLC > List

Article	Type	Count	Material	Last Change	Active in group
---------	------	-------	----------	-------------	-----------------

Create a copy of an existing article

Set properties for new article

Convert D from NSLT Convert Splice from NSLT

Properties

Article	NE 40
Yarn Count	40Ne
Fancy Yarn	Off
Type	Compact
Material	Pure
Fiber 1	CO - Cotton
Fiber 2	None
Mixed	100.0
Conductive Material	No

NSLT

Nep diameter	5.0
Short OffCount diameter	2.00
Short OffCount length	2.0cm
Long cut diameter	1.18
Long cut length	30cm
Thin diameter	11%
Thin length	30cm

D Channel

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

The curve settings will not match 100% with the new clearing. The settings should be doublechecked within the wizard!

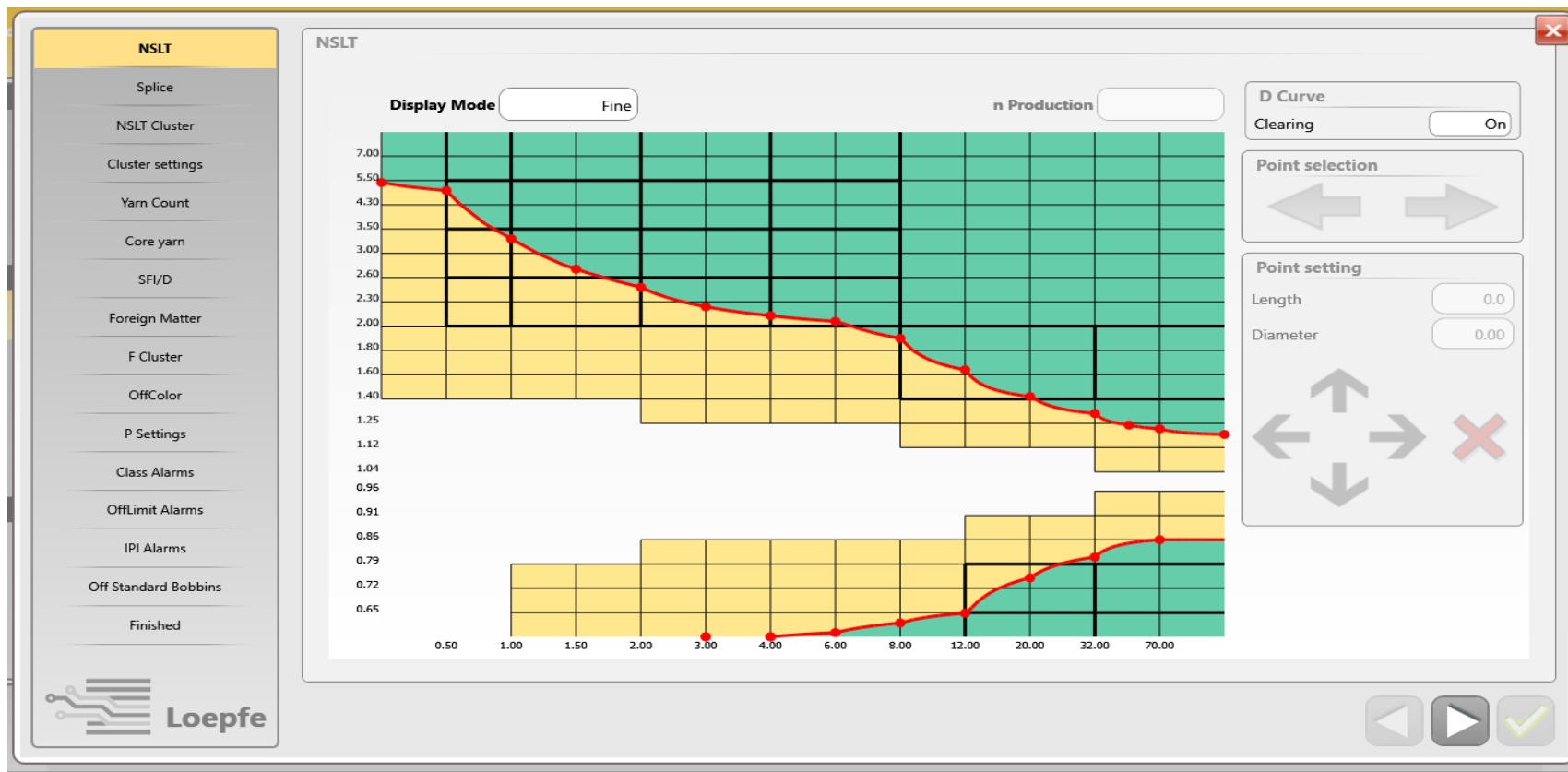
Offline

Foreman

14-12-2021
17:09:47
v6.0.72.32850-rc
d05b2a097-Release

M-36SRLC

NSLT工艺设定会跳转至下面界面。用户可以在此进行工艺设定。

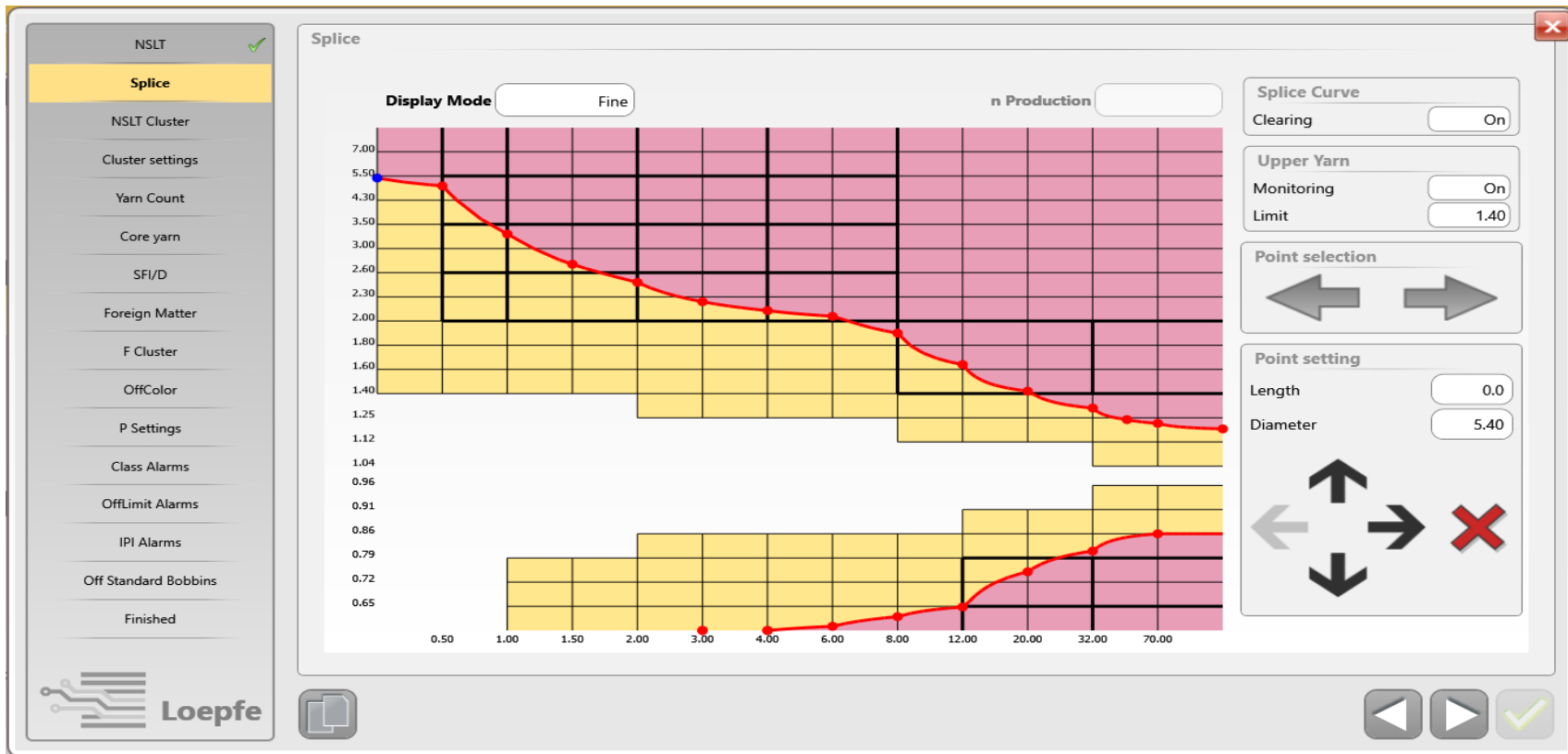


NSLT工艺设定可以通过按下图标标注的复制按钮复制工艺到捻接的工艺设定里。

The screenshot shows the 'Splice' configuration window. On the left is a sidebar menu with options: NSLT (checked), Splice (highlighted), Cluster, Cluster settings, Yarn Count, Core yarn, LabPack, Foreign Matter, F Cluster, P Settings, Class Alarm, OffLimit alarm, IPI Settings, Off Standard bobbins, and Finished. The main area features a 'Splice' plot with 'Display Mode' set to 'Fine' and 'In production' status. The plot shows a red line representing the splice profile over time (0.50 to 70.00). The y-axis ranges from 0.65 to 7.00. On the right, there are control panels: 'Splice curve' with 'Clearing' set to 'On'; 'Upper Yarn' with 'Monitoring' set to 'On' and 'Limit' set to '1.40'; 'Point selection' with left and right arrow buttons; and 'Point setting' with 'Length' set to '0.0' and 'Diameter' set to '0.00', along with directional arrow buttons and a red 'X' button. At the bottom left, a copy icon is highlighted with a red box and a red arrow points to it. At the bottom right, there are navigation buttons: a left arrow, a right arrow, and a checkmark.

确认弹出消息以将NSLT设定复制到捻接设定。

The screenshot displays the Loepfe Splice control interface. On the left is a navigation menu with options: NSLT (checked), Splice (highlighted), NSLT Cluster, Cluster settings, Yarn Count, Core yarn, SFI/D, Foreign Matter, F Cluster, OffColor, P Settings, Class Alarms, OffLimit Alarms, IPI Alarms, Off Standard Bobbins, and Finished. The main area features a 'Splice' graph with 'Display Mode' set to 'Fine' and 'n Production' set to 'Production'. The graph plots a signal over time (0.50 to 70.00) with a y-axis ranging from 0.65 to 7.00. A central dialog box titled 'Copy D channel settings' contains the text 'Copy D channel settings to splice channel' and a green checkmark icon. On the right, there are control panels for 'Splice Curve' (Clearing: On), 'Upper Yarn' (Monitoring: On, Limit: 1.40), 'Point selection' (left and right arrows), and 'Point setting' (Length: 0.0, Diameter: 0.00, and directional arrows). The bottom of the interface includes the Loepfe logo and navigation buttons (back, forward, confirm).



疵群设定—首先是设定每个疵群的监测长度和疵点个数。

The screenshot displays the 'NSLT Cluster' configuration window. On the left is a sidebar menu with options like 'NSLT', 'Splice', 'NSLT Cluster', 'Cluster settings', 'Yarn Count', 'Core yarn', 'SFI/D', 'Foreign Matter', 'F Cluster', 'OffColor', 'P Settings', 'Class Alarms', 'OffLimit Alarms', 'IPI Alarms', 'Off Standard Bobbins', and 'Finished'. The 'NSLT Cluster' option is selected and highlighted in yellow.

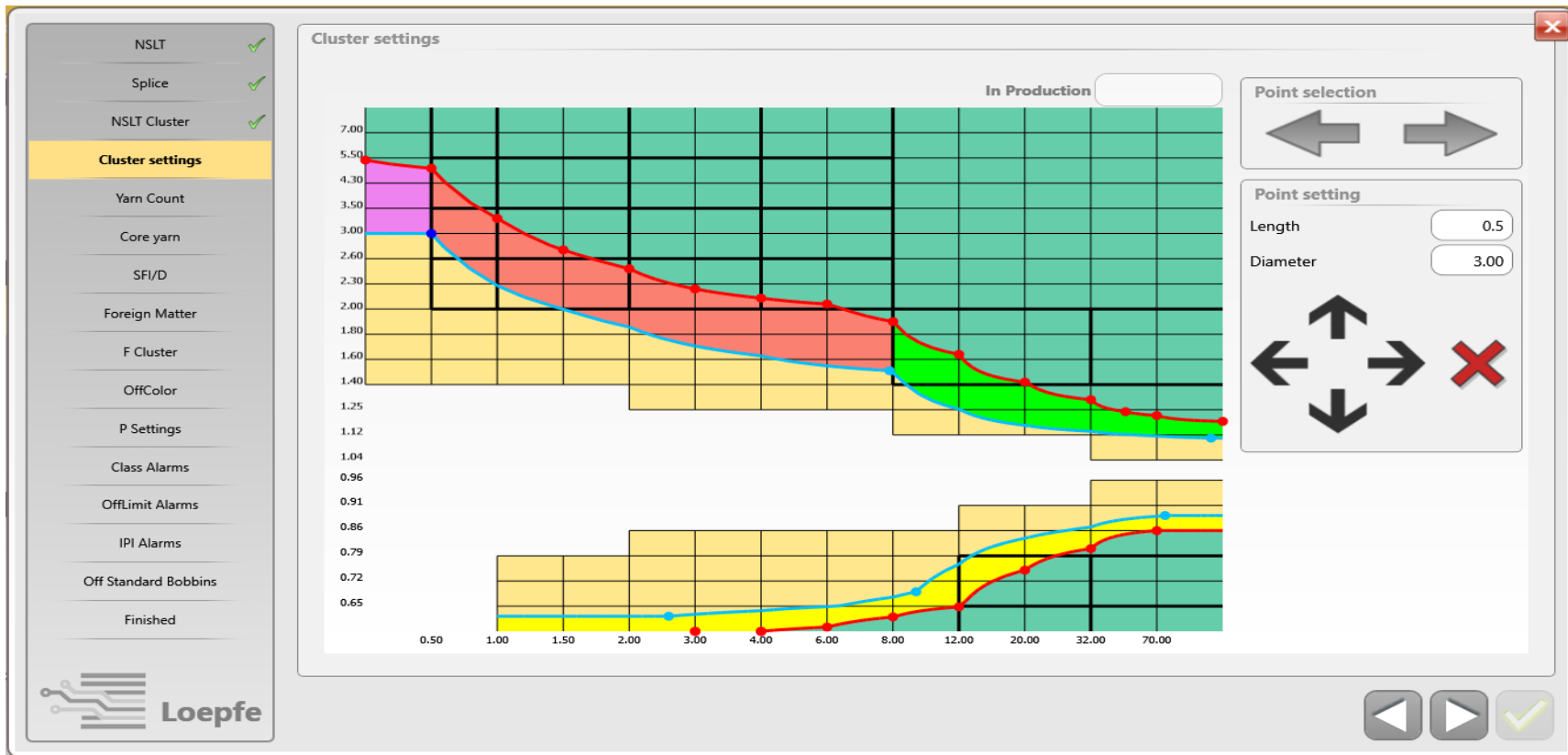
The main area is titled 'NSLT Cluster' and contains four panels for different cluster types:

- Nep Cluster:** Clearing (On), Obs. Length (12m), Faults (6), Events (0)
- Short Cluster:** Clearing (On), Obs. Length (12m), Faults (8), Events (0)
- Long Cluster:** Clearing (On), Obs. Length (12m), Faults (8), Events (0)
- Thin Cluster:** Clearing (On), Obs. Length (12m), Faults (8), Events (0)

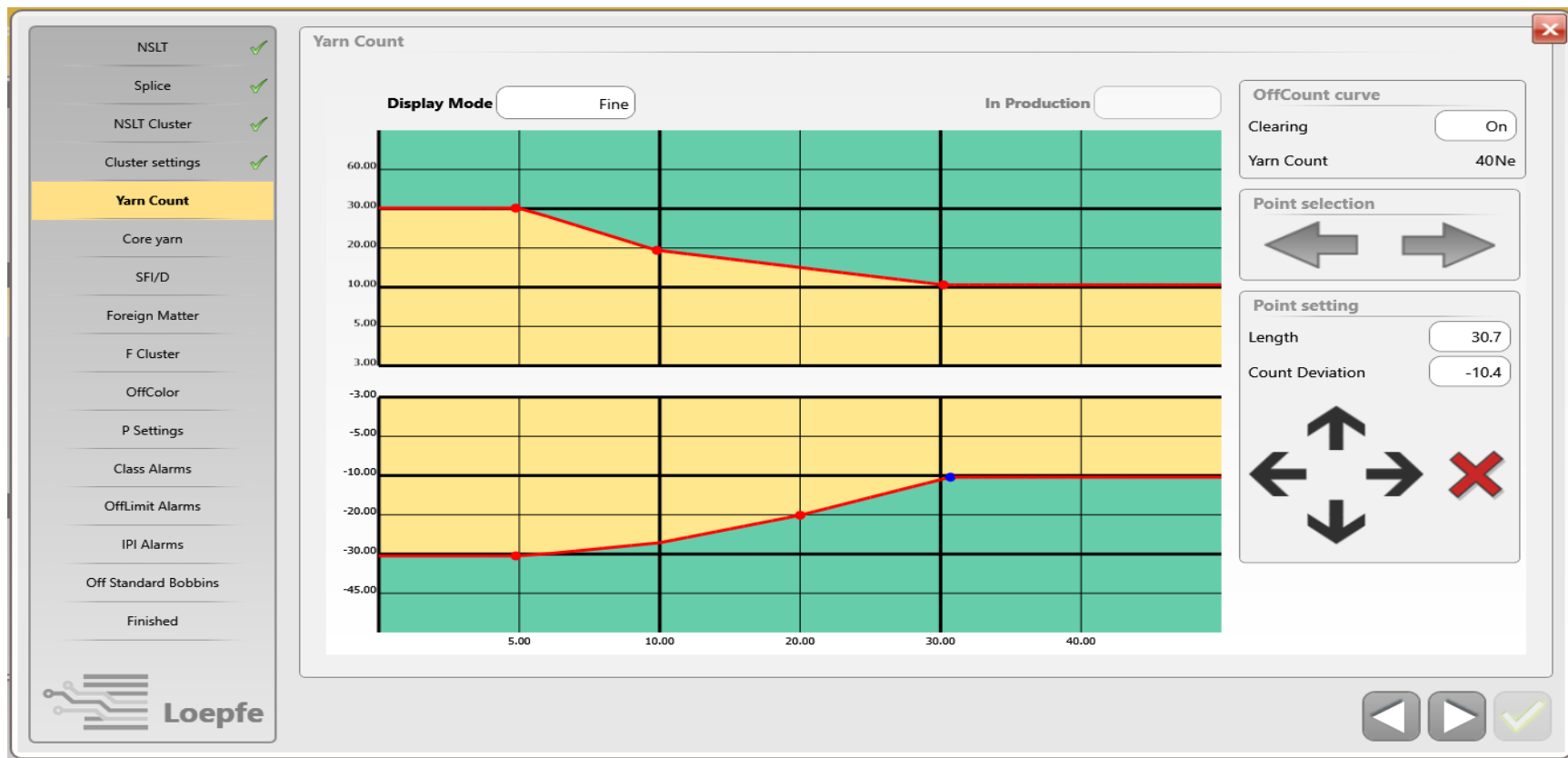
Below these panels is a 'Cluster settings' graph. The graph has a grid background with a red line showing a downward trend from left to right. The area above the red line is shaded green, and the area below is shaded yellow. The red line starts at a high point on the left and gradually descends towards the right, with some minor fluctuations.

At the bottom right of the window, there is an 'In Production' button and three navigation icons: a left arrow, a right arrow, and a checkmark.

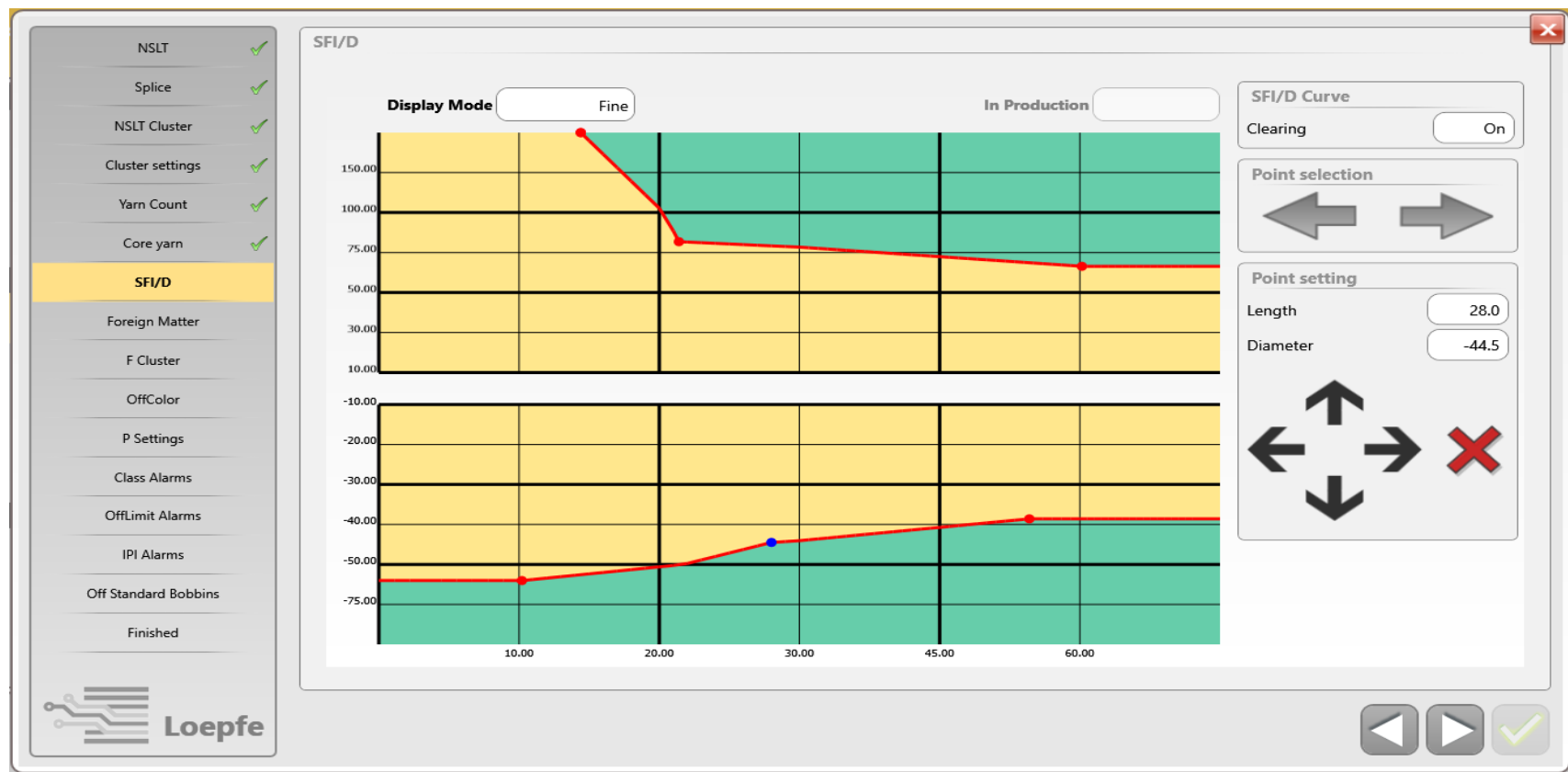
然后设置曲线区域。紫色为棉结疵群，红色短疵群，绿色为长疵群，黄色为偏细疵群。定义疵群检测范围



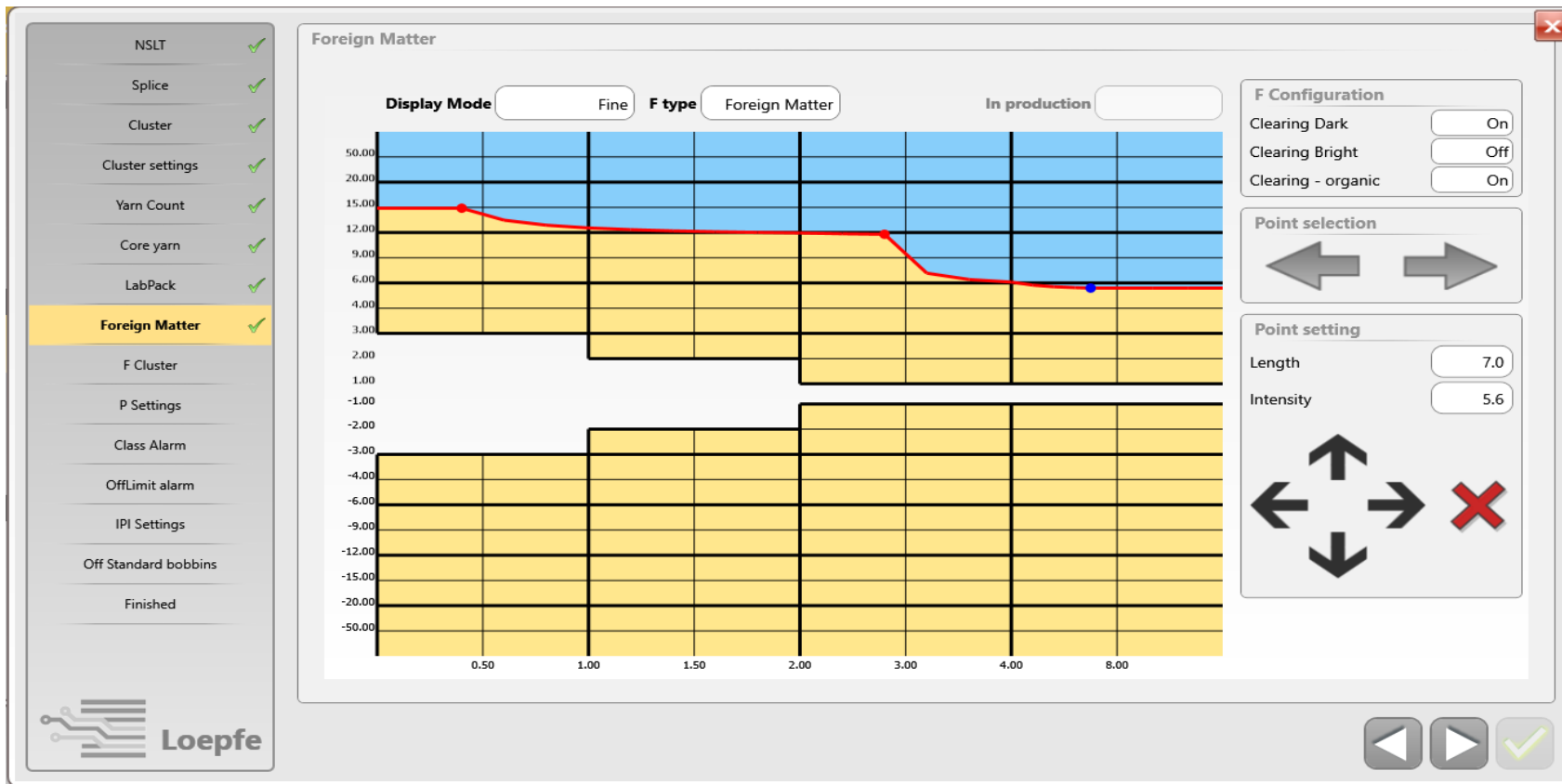
定义错支通道设定。短错支在矩阵的左半边:长度1-10米, 长错支在矩阵的右半边: 10-50米。



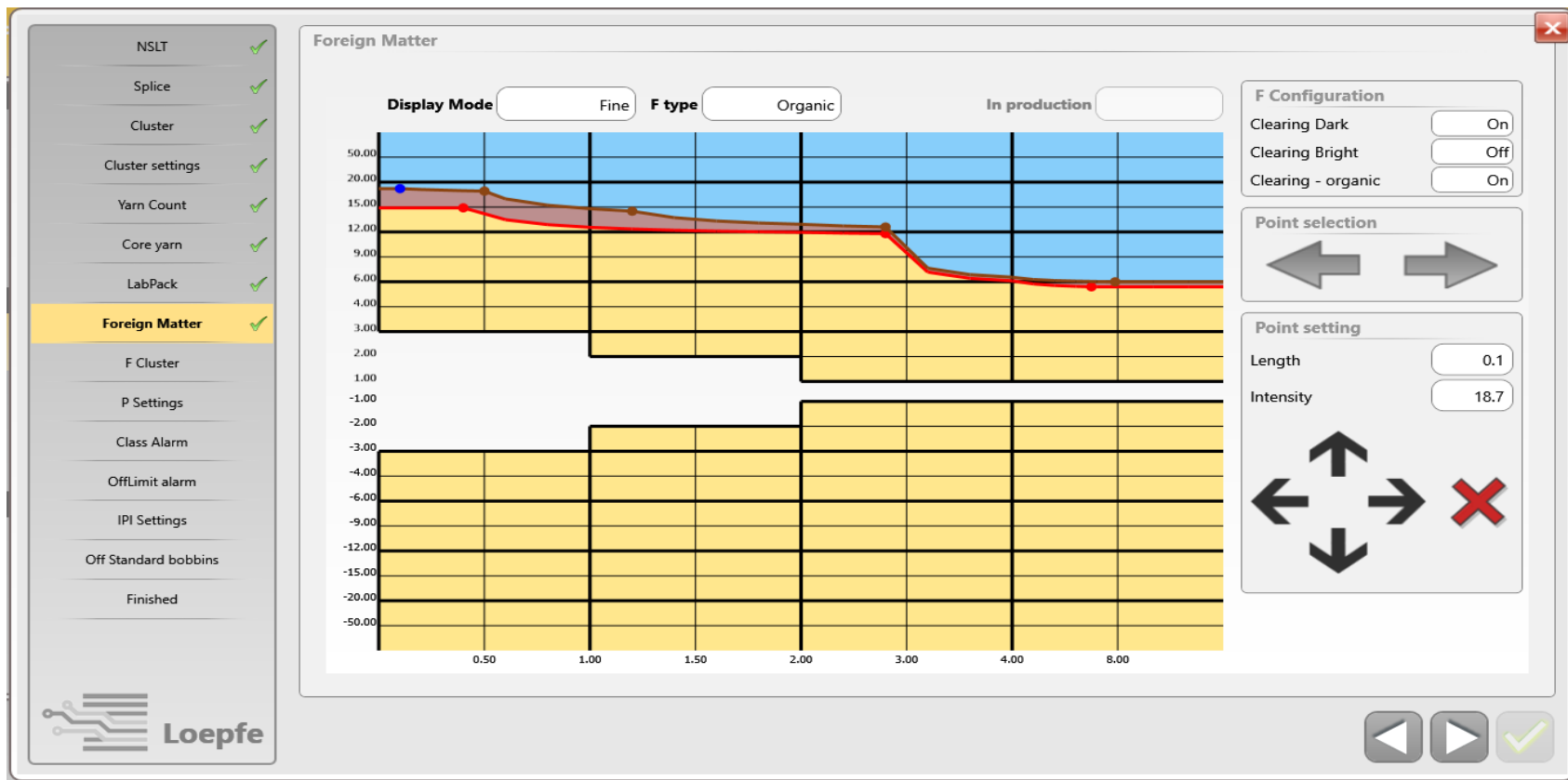
Labpack 实验室套包 → 条干和毛羽指数现在都结合在Labpack矩阵上。从5米以上的长度和直径最大(150)开始。此功能组群需卷绕纱线至少24千米后,才有足够的数据进行调整! 短毛羽(理解为条干)的长度范围是1-10米, SFI/D (不均匀条干及毛羽) 的长度范围是11-80米。



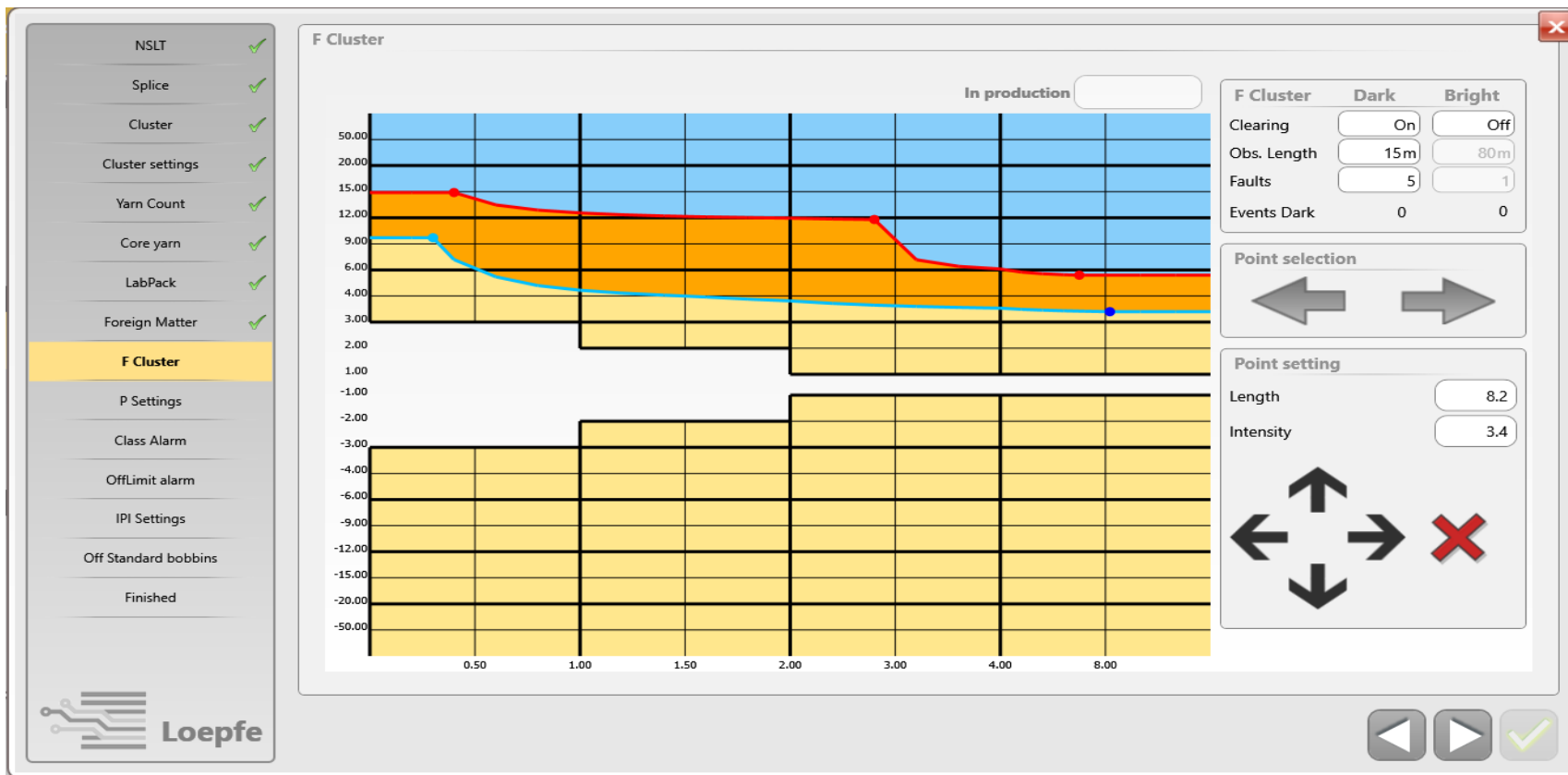
定义异纤偏暗设定。异纤清纱需要“开启”异纤架构开关



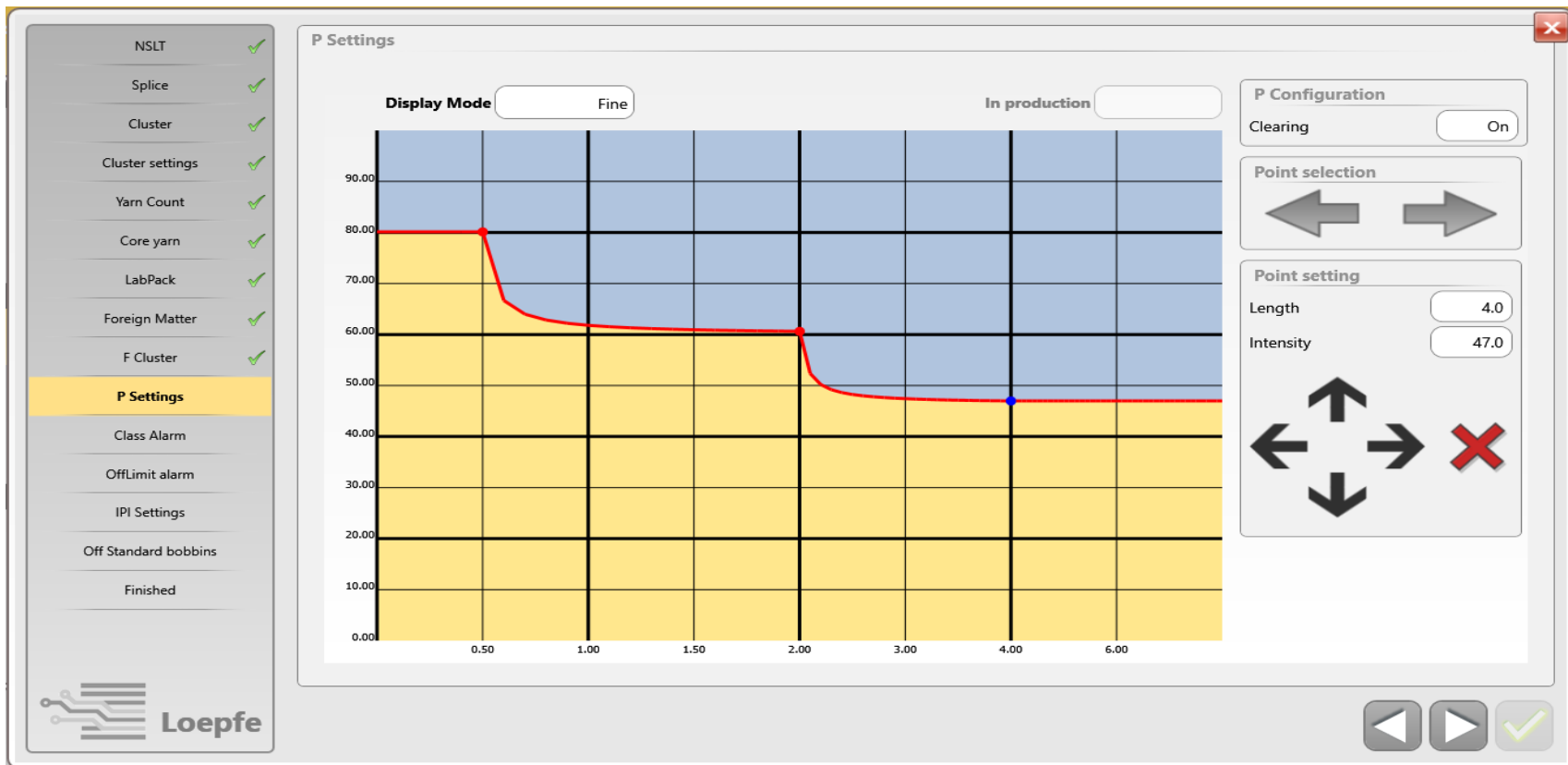
定义异纤有机过滤设定。异纤有机过滤清纱需要“开启”异纤架构开关



定义异纤疵群设定。异纤疵群清纱需要“开启”异纤偏暗疵群开关



定义PP设定。P清纱需要“开启” P架构开关



在异常管纱设置单独检测通道或组群通道的警报门限。请注意，没有带下划线“_”是组群通道警报设置，带下划线“-”开头的警报类型属于其上面组群警报的子类型。例如，为了减少异常管纱导致的停机时间，回吸长度较长的表面切疵，建议减少异常管纱检测数字(例如设定为3)。

Off Standard Bobbins

Alarm Limit / Bobbin	Cuts / Bobbin	Alarms	Bad Bobbins	Alarm Limit / Bobbin	Cuts / Bobbin	Alarms	Bad Bobbins		
NSLT	12	0.0	0.00	0.000%	_Thin Cluster	3	0.0	0.00	0.000%
_Neps	5	0.0	0.00	0.000%	_SFI/D	2	0.0	0.00	0.000%
_Short	8	0.0	0.00	0.000%	_Short SFI/D	2	0.0	0.00	0.000%
_Long	4	0.0	0.00	0.000%	F	4	0.0	0.00	0.000%
_Thin	4	0.0	0.00	0.000%	F Organic	4	0.0	0.00	0.000%
Max. Surface Cuts	3	0.0	0.00	0.000%	F Cluster	5	0.0	0.00	0.000%
_OffCount	2	0.0	0.00	0.000%	F OffColor	Off	0.0	0.00	0.000%
_Short OffCount	2	0.0	0.00	0.000%	P	5	0.0	0.00	0.000%
_Nep Cluster	3	0.0	0.00	0.000%	Missing Core	Off	0.0	0.00	0.000%
_Short Cluster	3	0.0	0.00	0.000%	OffCenter Core	Off	0.0	0.00	0.000%
_Long Cluster	3	0.0	0.00	0.000%	Max. Cuts	25	0.0	0.00	0.000%

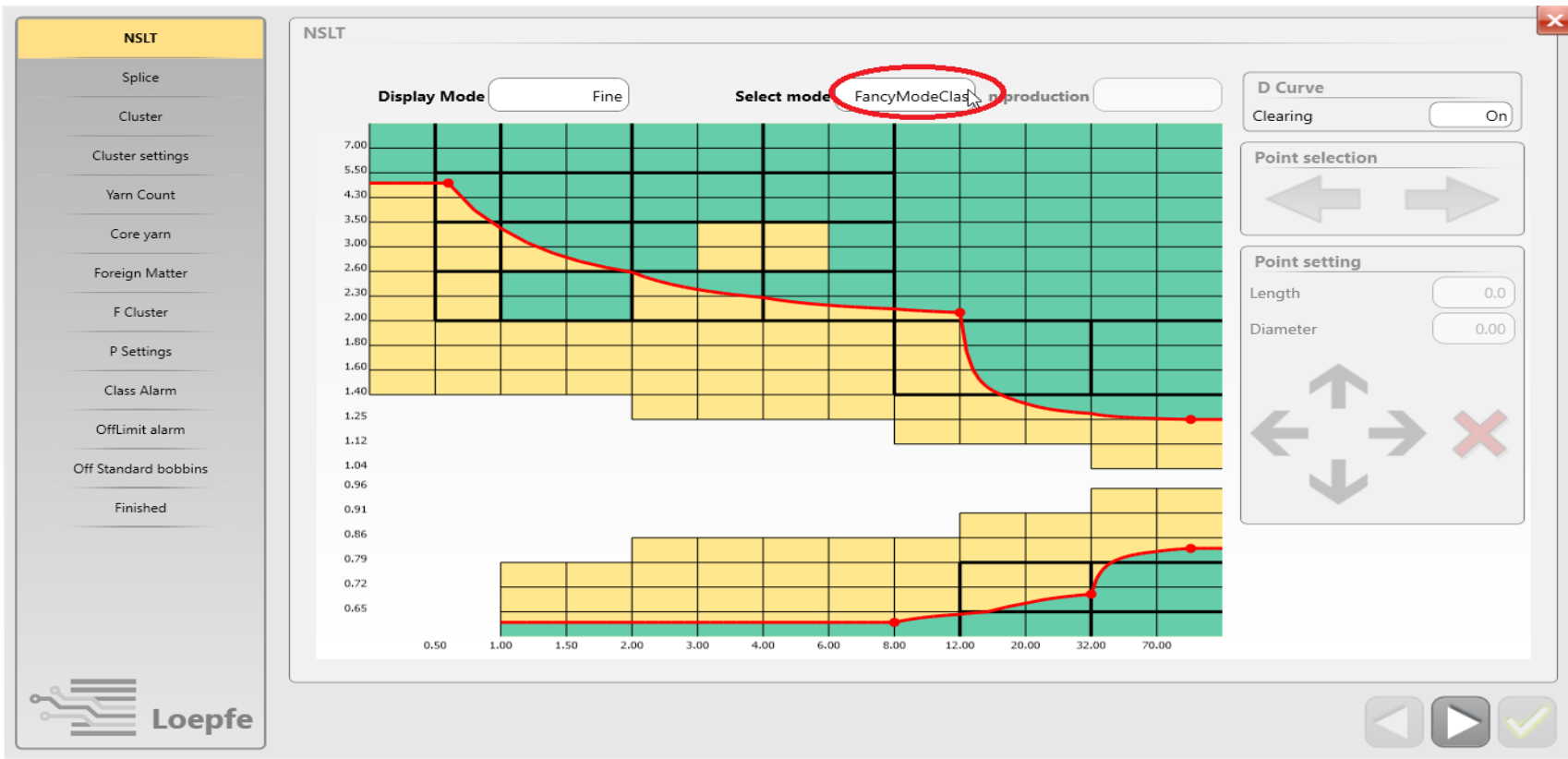
Bobbins: 0

Bad Bobbin Detection

Enable Count Check On Enable Color Check Off
 Count Deviation Limit Color Deviation Limit Check Length

In Production

在花式纱模式打开的情况下，你可以激活/禁用清纱曲线以上或者以下的单个分级设定。这个应用是对竹节纱的设定。



完成向导并保存纱种。

The screenshot shows a software wizard interface. On the left, a vertical list of settings is displayed, 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 content area 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	✓

使用建议参数设置纱线曲线→ 选择相应的选项和确认生成纱种

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 100 km' indicator. Below this is a breadcrumb trail: Settings > Article > NE 40 > List. The main content area shows a table of articles with columns: Article, Type, Count, Material, Last Change, and Active in group. Two rows are visible: one for 'M-36SRLC' (Compact, 36 Ne, Pure, 02-12-2021 13:28:51, 2) and one for 'NE 40' (Compact, 12-2021 17:04:18). An 'Add article' dialog box is open in the center, containing the following options:

- Enter Article Settings
- Use Yarn Parameter for Setting Proposal
- Copy Settings from an Article
- Import Settings from USB

A green checkmark icon is visible in the bottom right corner of the dialog box. The left sidebar contains navigation menus for 'DATA' (Dashboard, Monitoring, Quality), 'SETTINGS' (Article, Group, Machine, Planning table), and 'SERVICE' (Diagnosis, System, Setup). The bottom right corner shows system status: Offline, Foreman, and version information: 14-12-2021 17:34:40, v6.0.72.32850-rc, d05b2a097-Release.

用户可以在下图所示的框表输入支数范围，并可选择D、F和P的灵敏度。

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 100 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 shows a table with columns: Article, Type, Count, Material, Last Change, and Active in group. A modal dialog titled 'Create Article with Yarn Parameters' is open, containing the following fields:

Properties	
Article	NE 50
Type	Compact
Material	Pure
Fiber 1	CO - Cotton
Fiber 2	None
Mixed	100.0
Fancy Yarn	Off
Conductive Material	No

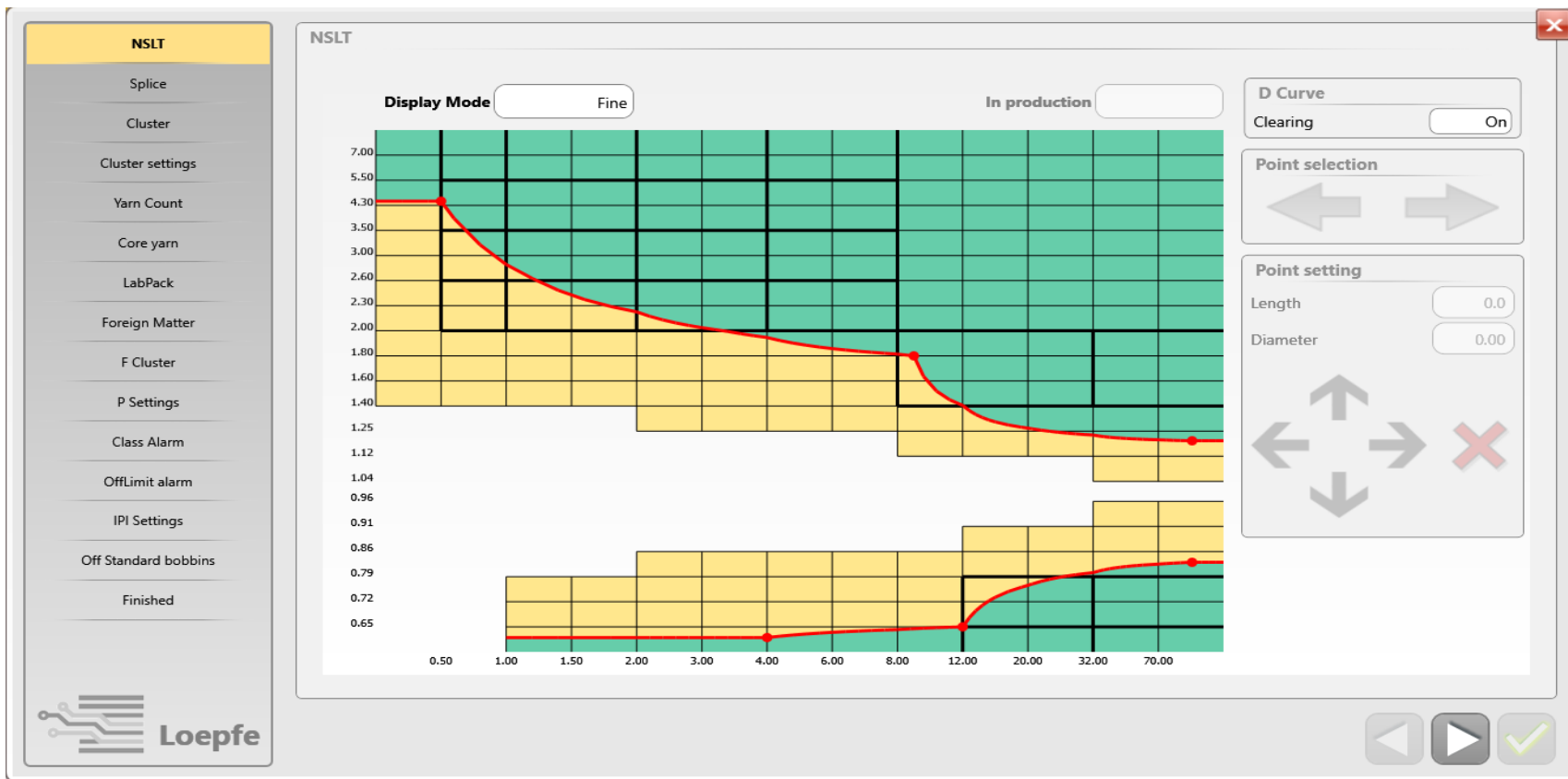
Yarn Count	
Count	50.0 Ne
Count Range	44.0 Ne - 56.0 Ne

General	
Special	None
Color	Natural

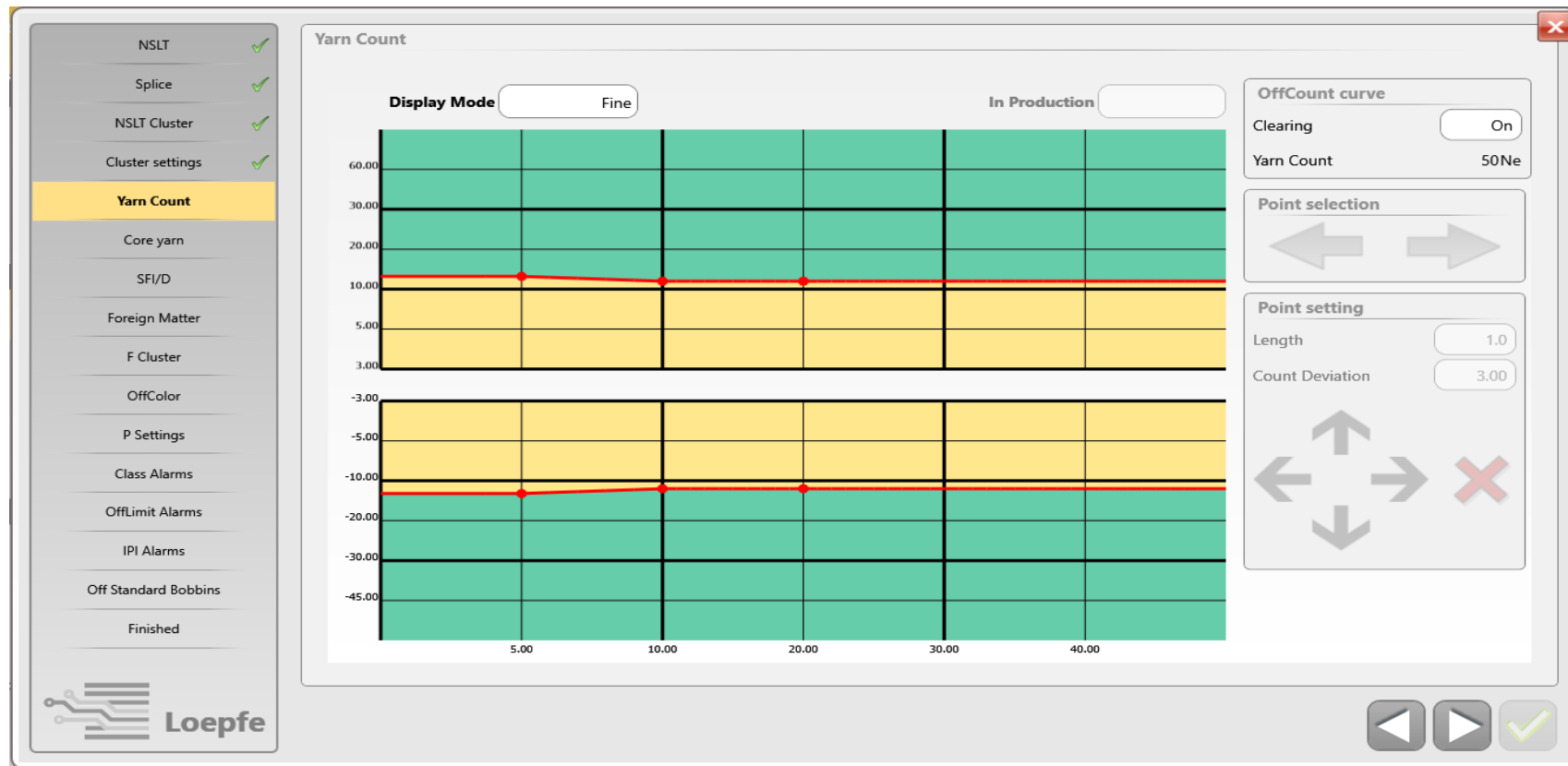
Sensitivity	
D Sensitivity	Top 12
F Sensitivity	Normal
P Sensitivity	Open

The dialog also features a close button (X) at the top right and a confirmation button (checkmark) at the bottom right.

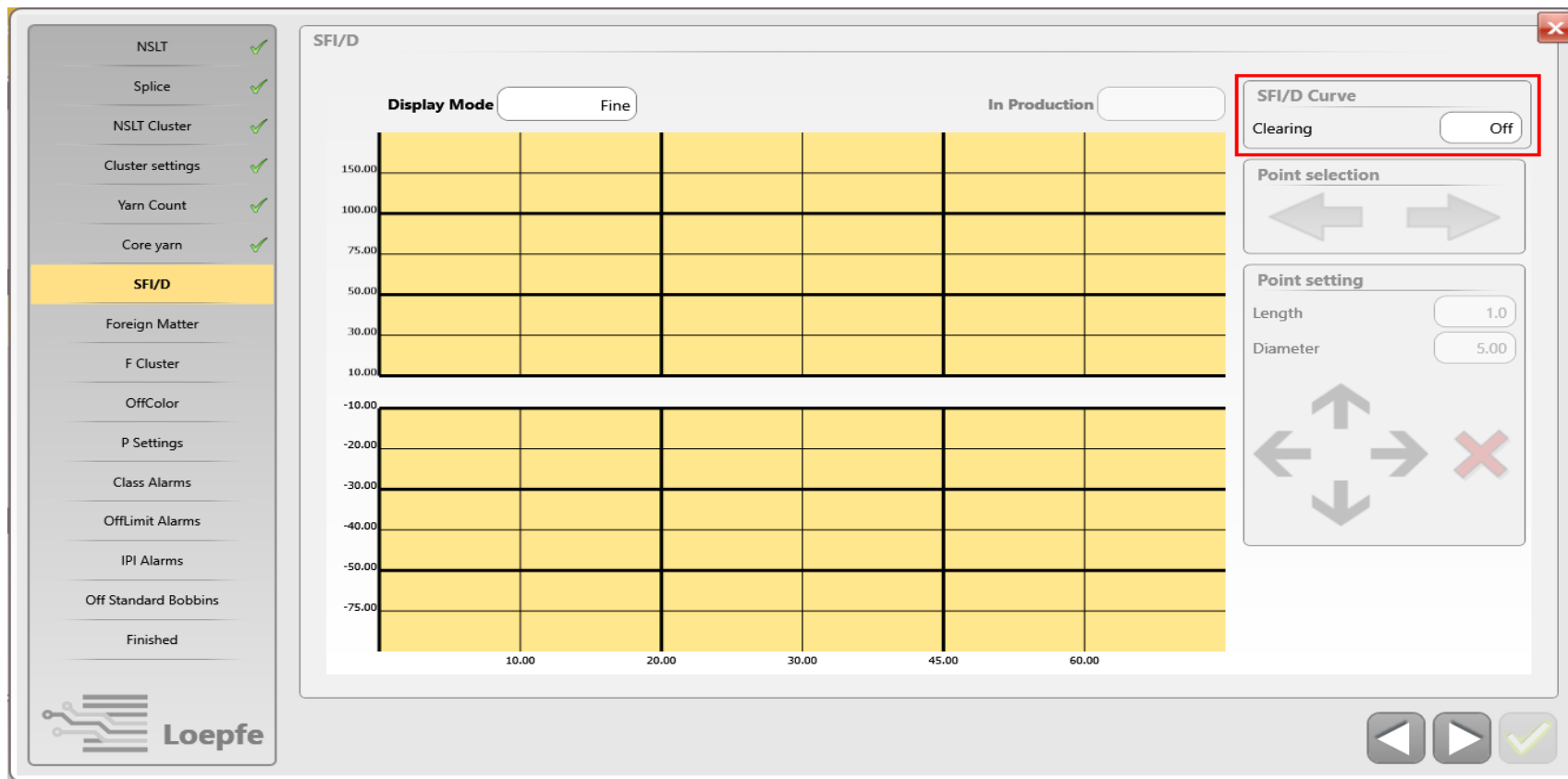
Top12级别是为清纱器的NSLT通道工艺来设定。



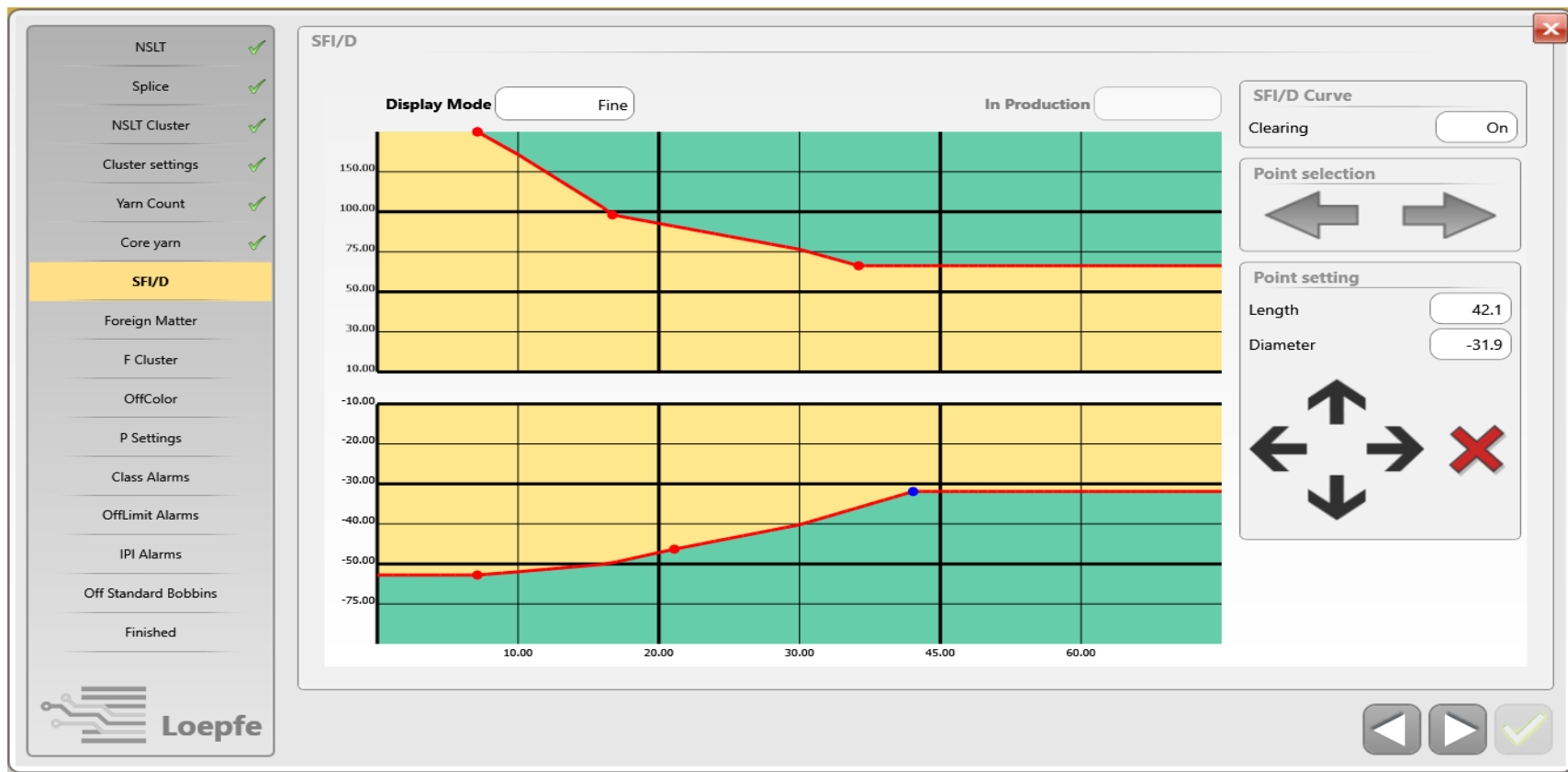
在支数通道内设定支数范围检测标准。



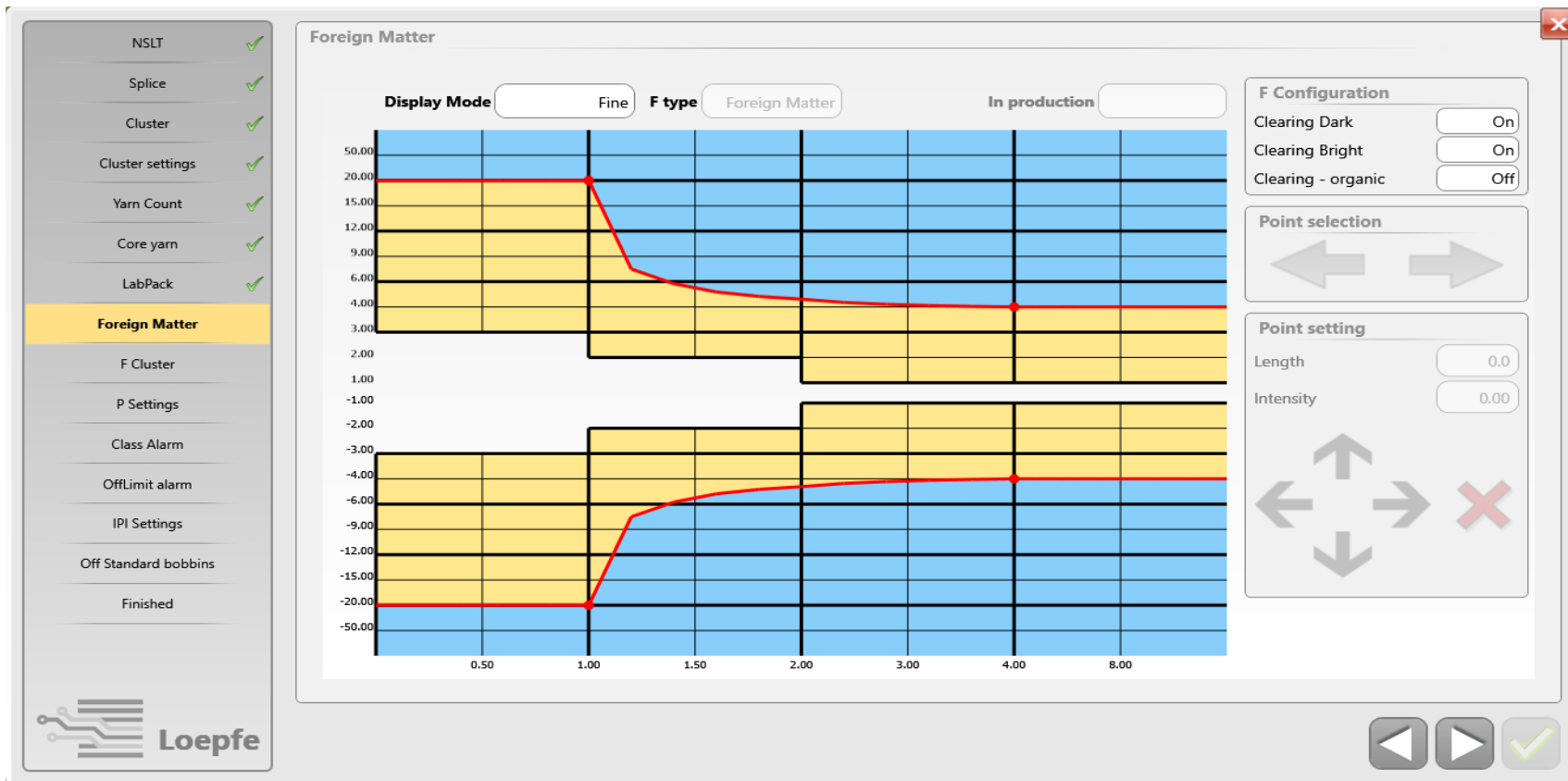
默认情况下，SFI 功能是常关的。用户可自行开启设定。



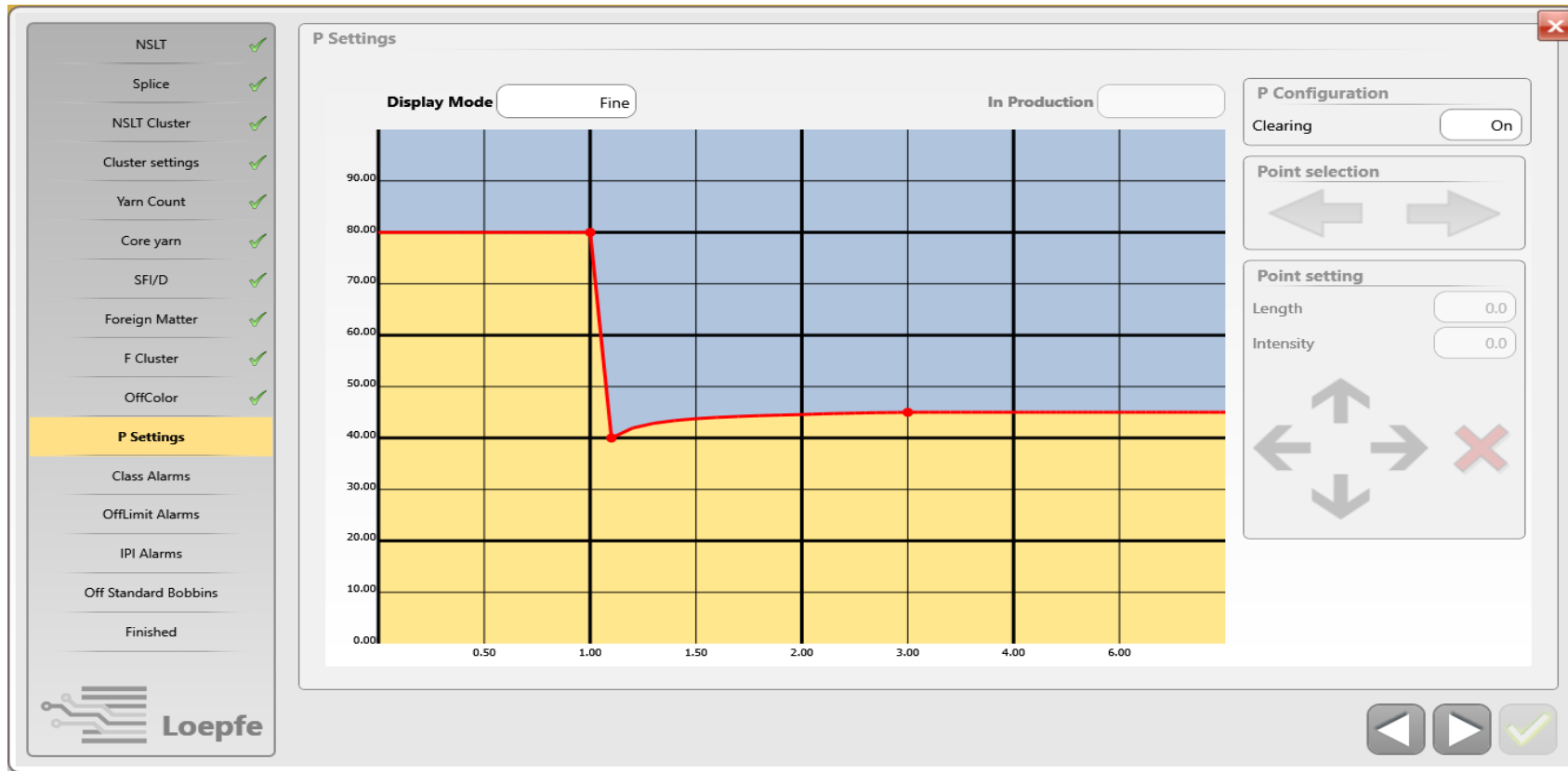
SFI 的优化设定：



异纤功能的设定通常是偏暗和偏亮。异纤有机过滤功能在默认情况下是常关的。如有需要可将其打开。




P功能的设定如下“打开”，并设定灵敏度。



大部分的报警限制是处于关闭(off) 状态的。 用户必须开启, 进行定义才能使用。

- NSLT ✔
- Splice ✔
- NSLT Cluster ✔
- Cluster settings ✔
- Yarn Count ✔
- Core yarn ✔
- SFI/D ✔
- Foreign Matter ✔
- F Cluster ✔
- OffColor ✔
- P Settings ✔
- Class Alarms ✔
- OffLimit Alarms ✔
- IPI Alarms ✔
- Off Standard Bobbins**
- Finished



Off Standard Bobbins

Alarm Limit / Bobbin	Cuts / Bobbin	Alarms	Bad Bobbins	Alarm Limit / Bobbin	Cuts / Bobbin	Alarms	Bad Bobbins
NSLT	<input type="text" value="7"/>	0.0	0.00	0.000%	_Thin Cluster	<input type="text" value="Off"/>	0.00
_Neps	<input type="text" value="Off"/>	0.0	0.00	0.000%	_SFI/D	<input type="text" value="Off"/>	0.00
_Short	<input type="text" value="Off"/>	0.0	0.00	0.000%	_Short SFI/D	<input type="text" value="Off"/>	0.00
_Long	<input type="text" value="Off"/>	0.0	0.00	0.000%	F	<input type="text" value="Off"/>	0.00
_Thin	<input type="text" value="Off"/>	0.0	0.00	0.000%	F Organic	<input type="text" value="Off"/>	0.00
Max. Surface Cuts	<input type="text" value="3"/>	0.0	0.00	0.000%	F Cluster	<input type="text" value="Off"/>	0.00
_OffCount	<input type="text" value="Off"/>	0.0	0.00	0.000%	F OffColor	<input type="text" value="Off"/>	0.00
_Short OffCount	<input type="text" value="Off"/>	0.0	0.00	0.000%	P	<input type="text" value="Off"/>	0.00
_Nep Cluster	<input type="text" value="Off"/>	0.0	0.00	0.000%	Missing Core	<input type="text" value="Off"/>	0.00
_Short Cluster	<input type="text" value="Off"/>	0.0	0.00	0.000%	OffCenter Core	<input type="text" value="Off"/>	0.00
_Long Cluster	<input type="text" value="Off"/>	0.0	0.00	0.000%	Max. Cuts	<input type="text" value="10"/>	0.00

Bobbins: 0

Bad Bobbin Detection

Enable Count Check Enable Color Check

Count Deviation Limit Color Deviation Limit Check Length

In Production

◀
▶
✔

完成向导并保存纱种。

Finished

The article will be saved when the wizard is completed.

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 ✓

Finished

Loepfe

◀ ▶ ✓

复制纱种设置→选择所需的选项确认建立新纱种

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 sidebar menu with sections for DATA, SETTINGS, and SERVICE. The main area shows a table of articles. A modal dialog titled 'Add article' is open, allowing the user to select settings for a new article. The 'Copy Settings from an Article' option is selected with a green checkmark. The background table lists articles such as M-36SRLC, NE 40, and NE 50.

Article	Type	Count	Material	Last Change	Active in group
M-36SRLC	Compact	36 Ne	Pure	02-12-2021 13:28:51	2
NE 40	Compact			2-2021 17:04:18	
NE 50	Compact			2-2021 20:50:33	

复制纱种设置→ 已经存在的纱种会显示在“纱种库”。用户可以选择复制纱种的设定,及建立新的纱种工艺设定。

Loepfe

Production
Last 1000 km

Settings \ Article \ M-36SRLC \ List

Article

Create a copy of an existing article

Source Article:

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


Offline

Foreman




14-12-2021
21:06:50
v6.0.72.32850-rc
d05b2a097-Release

M-36SRLC NE 50

复制纱种设置→给新建立的纱种命名



Production
Last 1000 km

DATA

Dashboard

Monitoring

Quality

SETTINGS

Article

Group

Machine

Planning table

SERVICE

Diagnosis

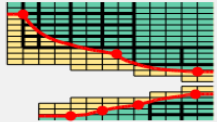
System

Setup

Settings > Article > NE 60 > Overview

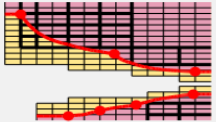
NSLT

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

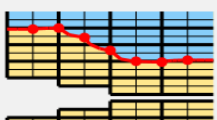
Faults 6

Foreign Matter

Clearing Dark On

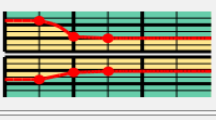
Clearing Bright Off

Clearing Organic On



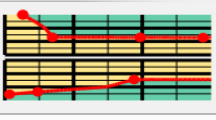
OffCount

Clearing On



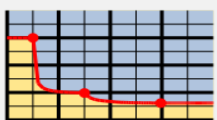
SFI/D

Clearing On



Polypropylene

Clearing On









M-36SRLC

NE 50

NE 60

NE 40

OffLimit Alarms

Class Alarms

IPI Alarms

Off Standard Bobbins

Core

Properties

Article	NE 60
Type	Compact
Material	Pure
Yarn Count	60 Ne

Offline

Foreman

14-12-2021
21:08:35
v6.0.72.32850-rc
d05b2a097-Release

从USB导入纱种设置→ 选择所需的选项确认建立新纱种

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 sidebar menu with sections for 'DATA' (Dashboard, Monitoring, Quality) and 'SETTINGS' (Article, Group, Machine, Planning table). The 'Article' section is active, showing a table of articles. A modal dialog box titled 'Add article' is open in the center, containing four options: 'Enter Article Settings', 'Use Yarn Parameter for Setting Proposal', 'Copy Settings from an Article', and 'Import Settings from USB'. The 'Import Settings from USB' option is checked with a green checkmark. The background table shows columns for Article, Type, Count, Material, Last Change, and Active in group. The bottom of the screen features a breadcrumb trail: M-36SRLC > NE 50 > NE 40.

Article	Type	Count	Material	Last Change	Active in group
M-36SRLC	Compact	36 Ne	Pure	02-12-2021 13:28:51	2
NE 40	Compact			12-2021 17:04:18	
NE 50	Compact			2-2021 20:50:33	
NE 60	Compact			2-2021 21:08:28	

从USB导入纱种设置→ 在USB里可用的纱种工艺会显示出来，选择纱种并点击下载按钮导入。

Loeefe Production Last 1000 km

DATA

- Dashboard
- Monitoring
- Quality

SETTINGS

- Article**
- Group
- Machine
- Planning table

SERVICE

- Diagnosis
- System
- Setup

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

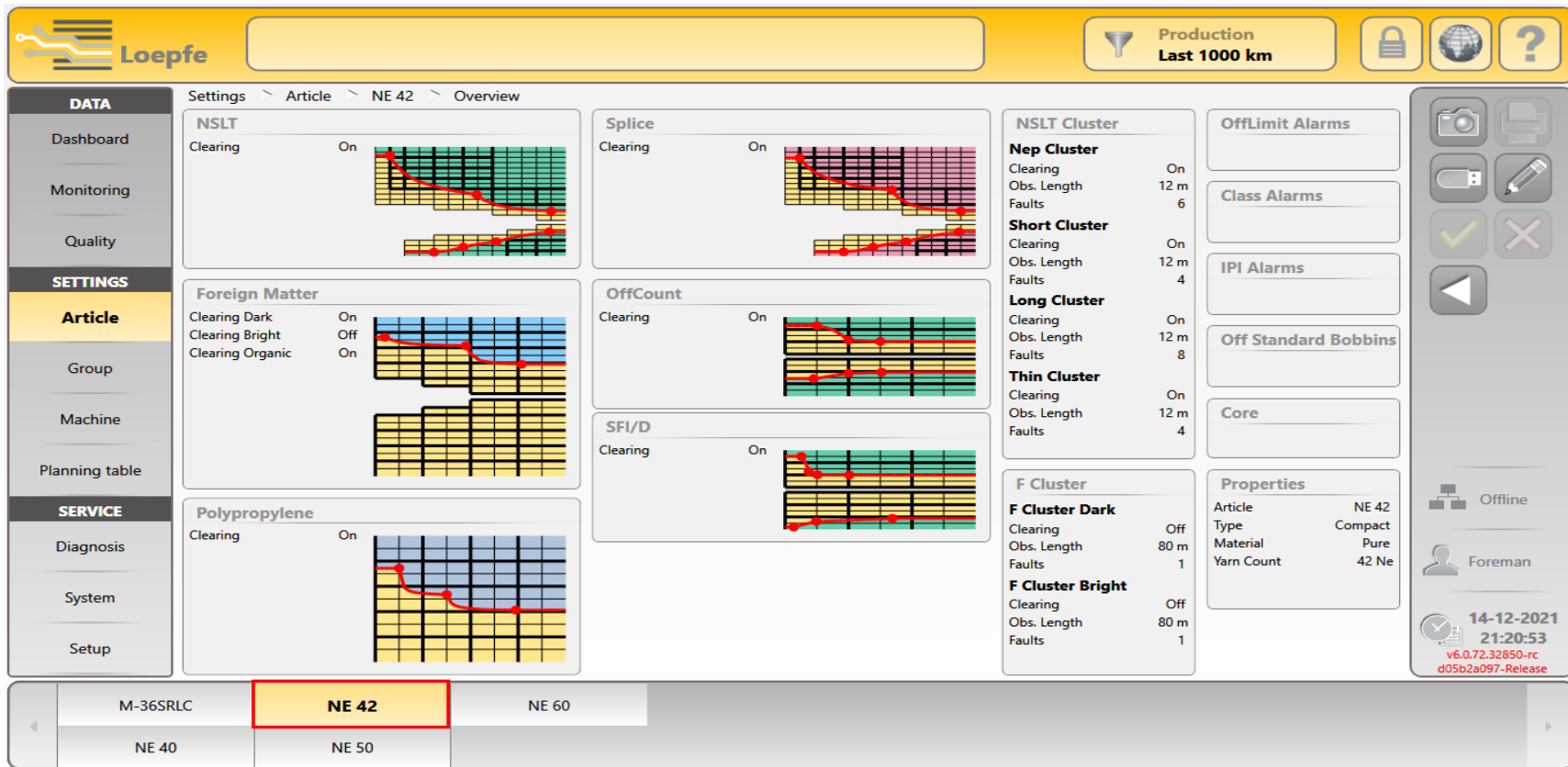
Properties

- 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



生产组群由指定的单锭分组、指定的纱种、电清型号和其他特殊设定组成。

到组群菜单建立生产组群

按 **+**（添加）生成一个新的生产组群

1. 建立生产组群有两个选项
 - a. 建立新的生产组群
 - b. 从已有的生产组群复制
2. 选择你所需的选项。

建立新的生产组群→生产组群打开默认为出厂设置，用户需要定义生产组群的参数。

Settings > Group > G2 > List

No.	First	Last	TK	Status	Lot Name	Article	Dia Diff	Last Change
G2	1	72	DMFP	Production		M-36SRLC	-1%	14-12-2021 15:23:54

Add group

Create new group

Copy from group:

Production
Last 1000 km

Offline

Foreman

14-12-2021 21:23:29
v6.0.72.32850-rc
d05b2a097-Release

G2 (1-72)

先将单锭分组，设定检测头型号，批次和纱种。

湿捻结器→ 如果使用湿捻，必须将湿捻功能打开。它防止由电容式传感器触发的不真实捻接切纱。同样也适用于捻接过程中的异纤清纱，因为水会改变纤维的色度，触发不真实的异纤切纱。

The screenshot displays the Loepte web interface for a spinning machine. The top navigation bar includes the Loepte logo, a search bar, and a 'Production Last 1000 km' indicator. The main content area is divided into several sections:

- Settings Group:** Includes fields for First Spindle (1), Last Spindle (72), Sensing Head Type (DMFP), Lot Name, and Article (M-36SRCL).
- Data Acquisition:** Includes Window Length (1000 km).
- Settings Optional:** Includes 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:** Includes Repetitive Splice Removal (On), Splice Check Length (25cm), F clearing during Splice (On), and **Wet Splicer (Off)**, which is highlighted with a red border.

The right sidebar contains various icons for navigation and status, including 'Offline' and 'Foreman'.

从已有生产组群复制 → 所选的生产组会自动复制生成新的生产组

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 funnel labeled 'Production Last 1000 km', a lock, a globe, and a question mark. Below this is a breadcrumb trail: 'Settings > Group > G2 > List'. The main area contains a table with the following columns: 'No.', 'First', 'Last', 'TK', 'Status', 'Lot', 'Article', 'D Health', and 'Last Change'. Two rows are visible: a green row for group G1 and a yellow row for group G2. A modal 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 number '1'. The dialog also has a close button (red X) and a confirmation button (green checkmark). On the right side, there is a vertical toolbar with various icons for camera, print, zoom, play, stop, add (+), and subtract (-). At the bottom right, there are status indicators for 'Online', 'Service', and a clock showing '15-07-2021 12:03:09' along with the version number 'v6.0.57.29993'. At the bottom of the screen, a navigation bar shows 'G1 (1-10)' and 'G2 (11-20)' with 'G2 (11-20)' selected.

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

启动生产组群→启动生产组群生产。PRISMA电清没有单独取样步骤。分配到组群的单锭都会自动采样。

The screenshot displays the Loepfe production control interface. The top navigation bar includes the Loepfe logo, a search bar, and a 'Production Last 1000 km' filter. The main content 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 the following data: No. G2, First 1, Last 72, TK DMFP, Status Stopped, Lot Name M-36SRC, Article M-36SRC, Dia Diff -, and Last Change 14-12-2021 21:32:02. A 'Start Group' dialog box is open in the center, asking 'Start production?' with a green checkmark button. On the right sidebar, a play button icon is highlighted with a red box and labeled 'Start Button'.

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

启动生产组群→启动生产组群后，检测头会在显示屏上显示“Ad”。这时可以使用完好新的管纱，逐一启动每个单锭。



监测和数据分级

监测数据→ 监测数据与ZENIT+电清类似。毛羽切纱分为SFI/D 和Short SFI/D两种。检测纱疵长度在10米内的计入Short SFI/D, 检测纱疵长度在10米以上的计入 SFI/D。

Loepfe Production Last 1000 km

DATA

- Dashboard
- Monitoring**
- Quality
- SETTINGS**
- Article
- Group
- Machine
- Planning table
- SERVICE**
- Diagnosis
- System
- Setup

Data \ Monitoring \ G2 (M-36SRLC) \ Overview

Cuts		Splice	
Total Cuts	585	Splices	993
D Cut	397	Splice Cuts	7
F Cuts	138	Splice Repetitions	18
P Cuts	50		

NSLT		Foreign Matter	
Nep Cuts	16	F Cuts Dark	90
Short Cuts	253	F Cuts Bright	0
Long Cuts	47	F Cuts Organic	48
Thin Cuts	33	F Cluster Cuts Dark	0
		F Cluster Cuts Bright	0
		OffColor Cuts Dark	0
		OffColor Cuts Bright	0

OffCount	
Missing Core Cuts	0
OffCenter Core Cut	0
OffCount Cuts +	5
OffCount Cuts -	5
Short OffCount Cuts +	10
Short OffCount Cuts -	0

NSLT Cluster	
Nep Cluster Cuts	0
Short Cluster Cuts	2
Long Cluster Cuts	1
Thin Cluster Cuts	6

Bad Bobbin	
Total Cuts	1

Special	
Bunch Cuts	0
Upper Yarn Cuts	0
Yarn Breaks	23
Total Bobbin Changes	395
Knife Jam	0

Alarms	
NSLT	0
Neps	0
Short	0
Long	0
Thin	0
Max. Surface Cuts	0
OffCount	2
Short OffCount	0
Nep Cluster	0
Short Cluster	0
Long Cluster	0
Thin Cluster	1
SFI/D	0
Short SFI/D	0
Foreign Matter	0
F Organic	0
F Cluster	0
OffColor	0
p	0
Missing Core	0
OffCenter Core	0
Max. Cuts	0

Bad Bobbin Alarms	
Bad Bobbin Count Thick	1
Bad Bobbin Count Thin	0
Bad Bobbin Color Dark	0
Bad Bobbin Color Bright	0

OffLimit Alarm	
Total	0

Class Alarm	
Total	0

IPI Alarms	
Total	0
Total (Spindles)	0

SFI/D	
Total Cuts	19
SFI/D Cuts +	17
SFI/D Cuts -	0
Short SFI/D Cuts +	1
Short SFI/D Cuts -	1

Length	
Wound Length	1000.0 km

Last Cut	
-	-

14-12-2021 21:39:53
v6.0.72.32850-rc
d05b2a097-Release

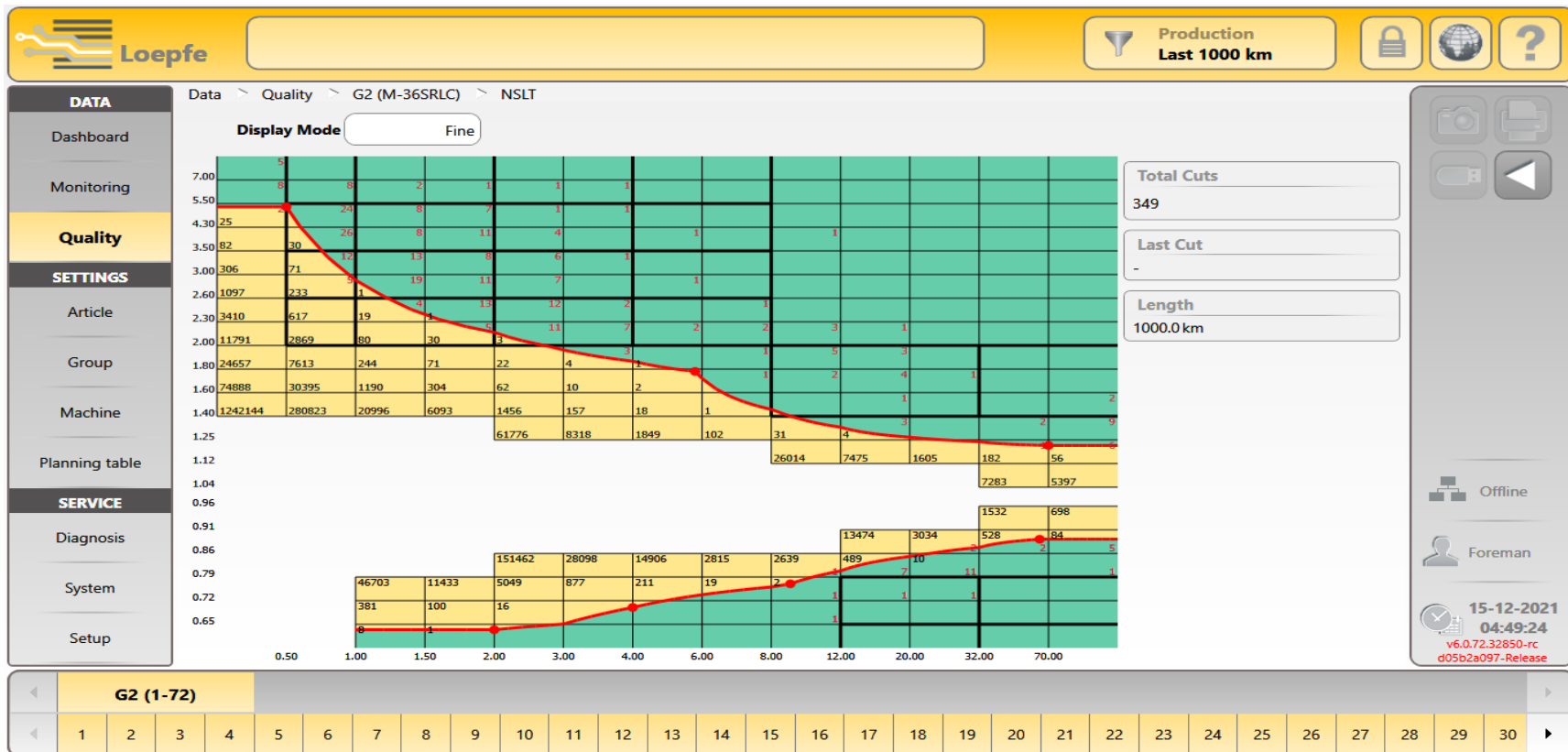
G2 (1-72)

1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30

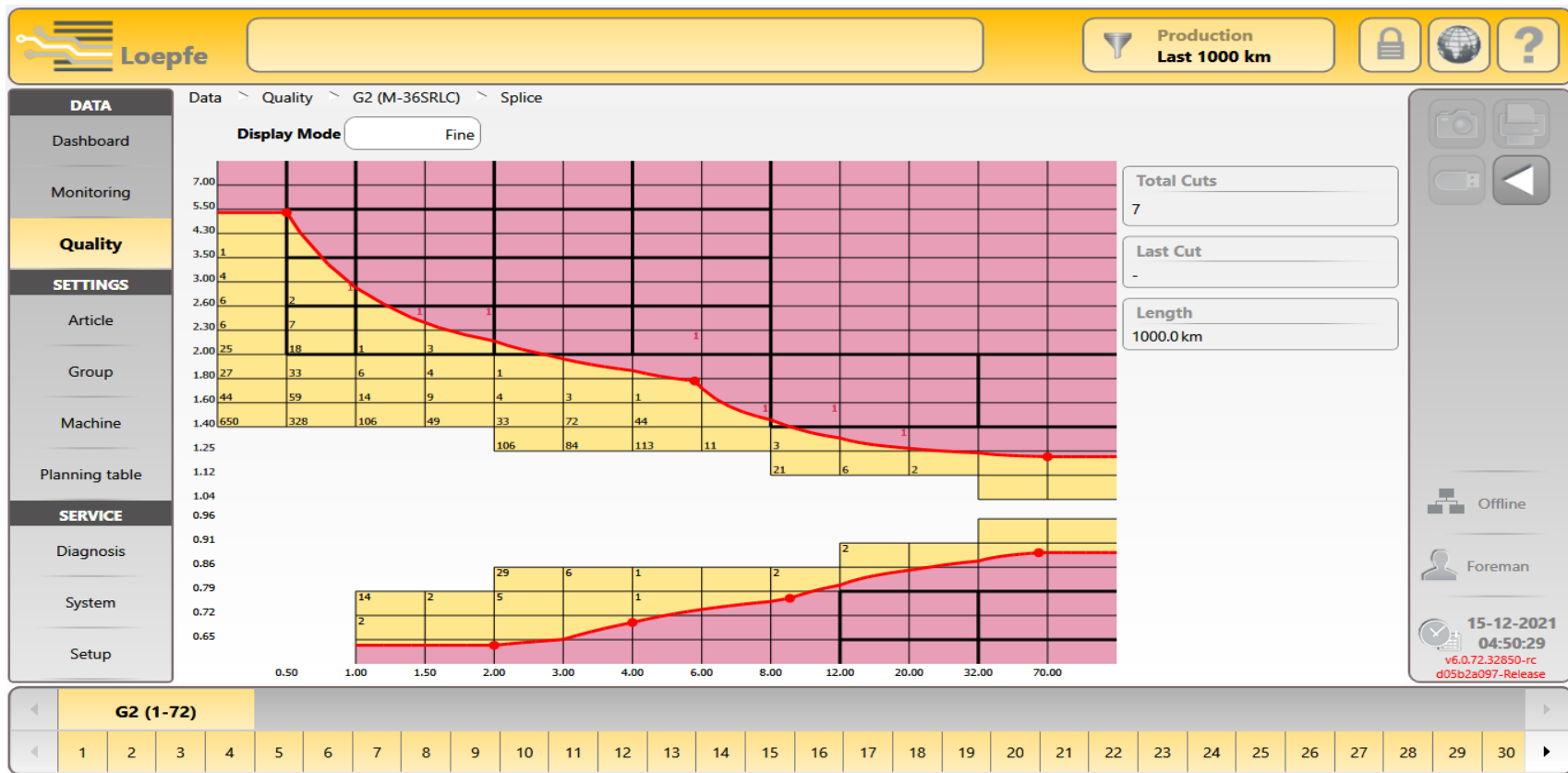
质量总览数据 → 这些数据与ZENIT+电清类似，在质量总览页面可以看到每个生产组或单锭实际生产的NSLT、捻接头、异纤和P丙纶丝的分级清纱数据。通过触摸屏幕的分级图，可以放大分级图并打开详细视图。此外，LabPack 的IPI和SFI毛羽数据在此页面也有显示。



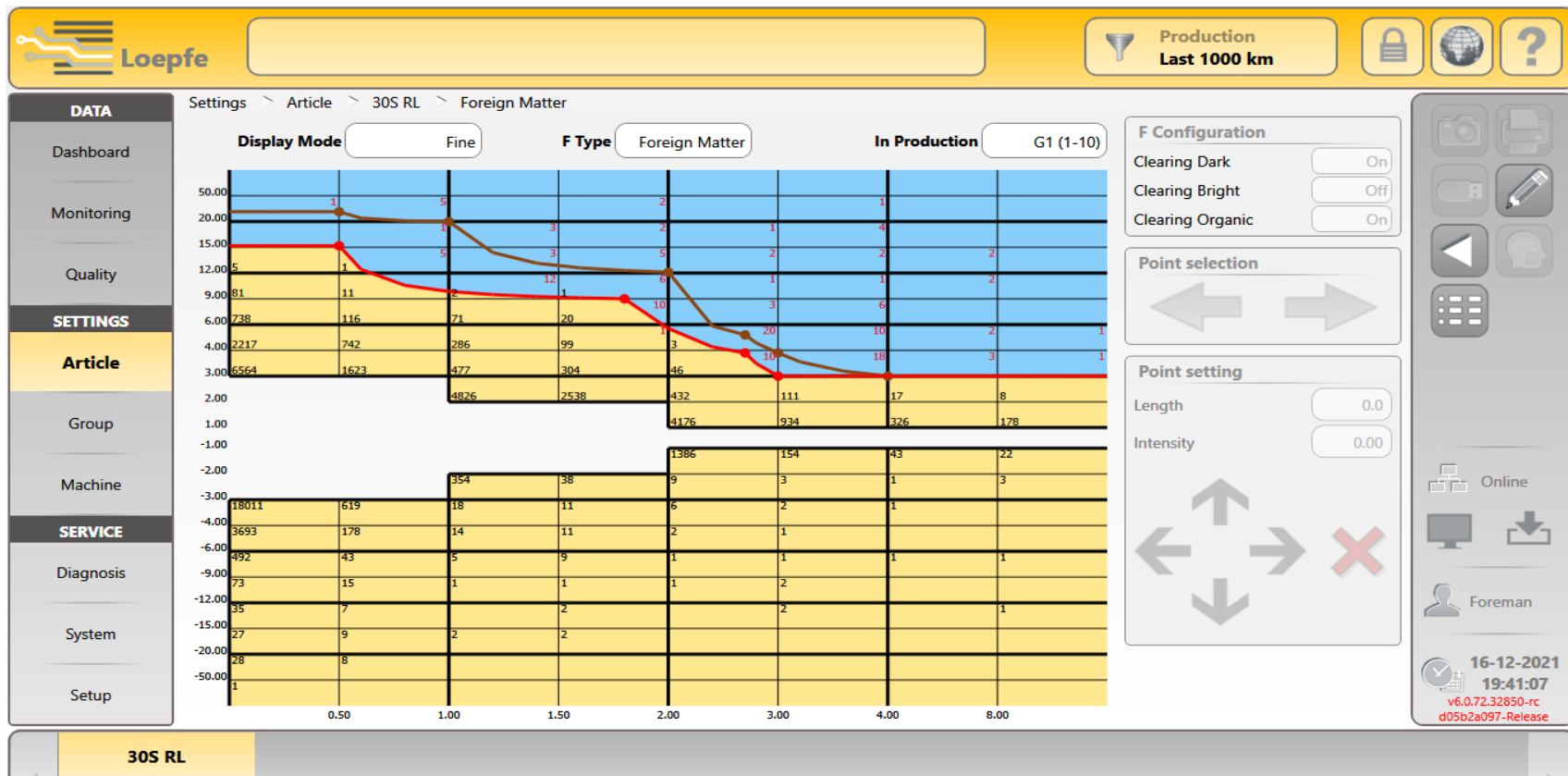
分级数据 → Prisma有 207个分级区。所有纱疵均在分级区域内精准分级。



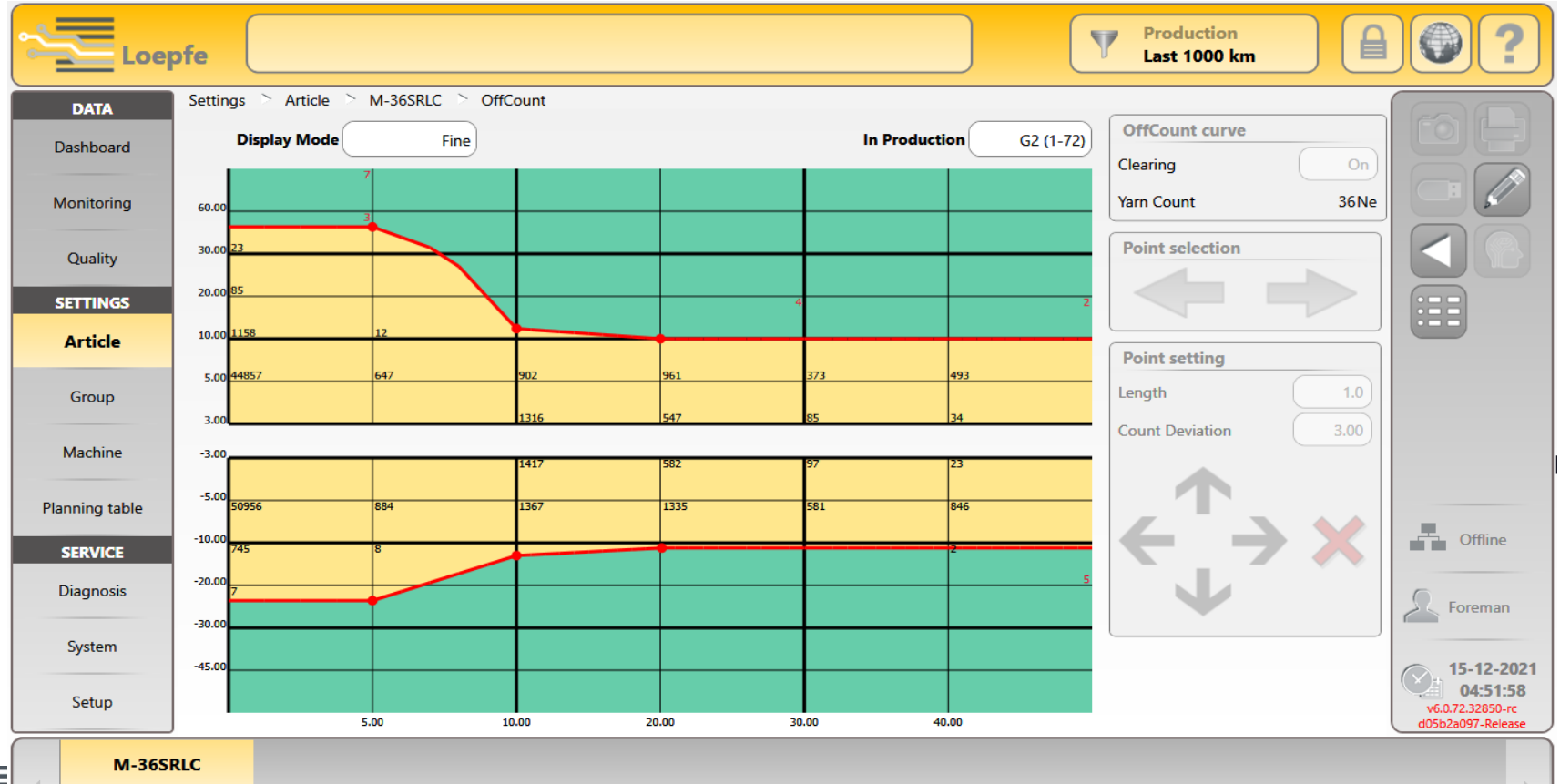
捻接分级数据 → 捻接分级表也添加了同等数量的分级区



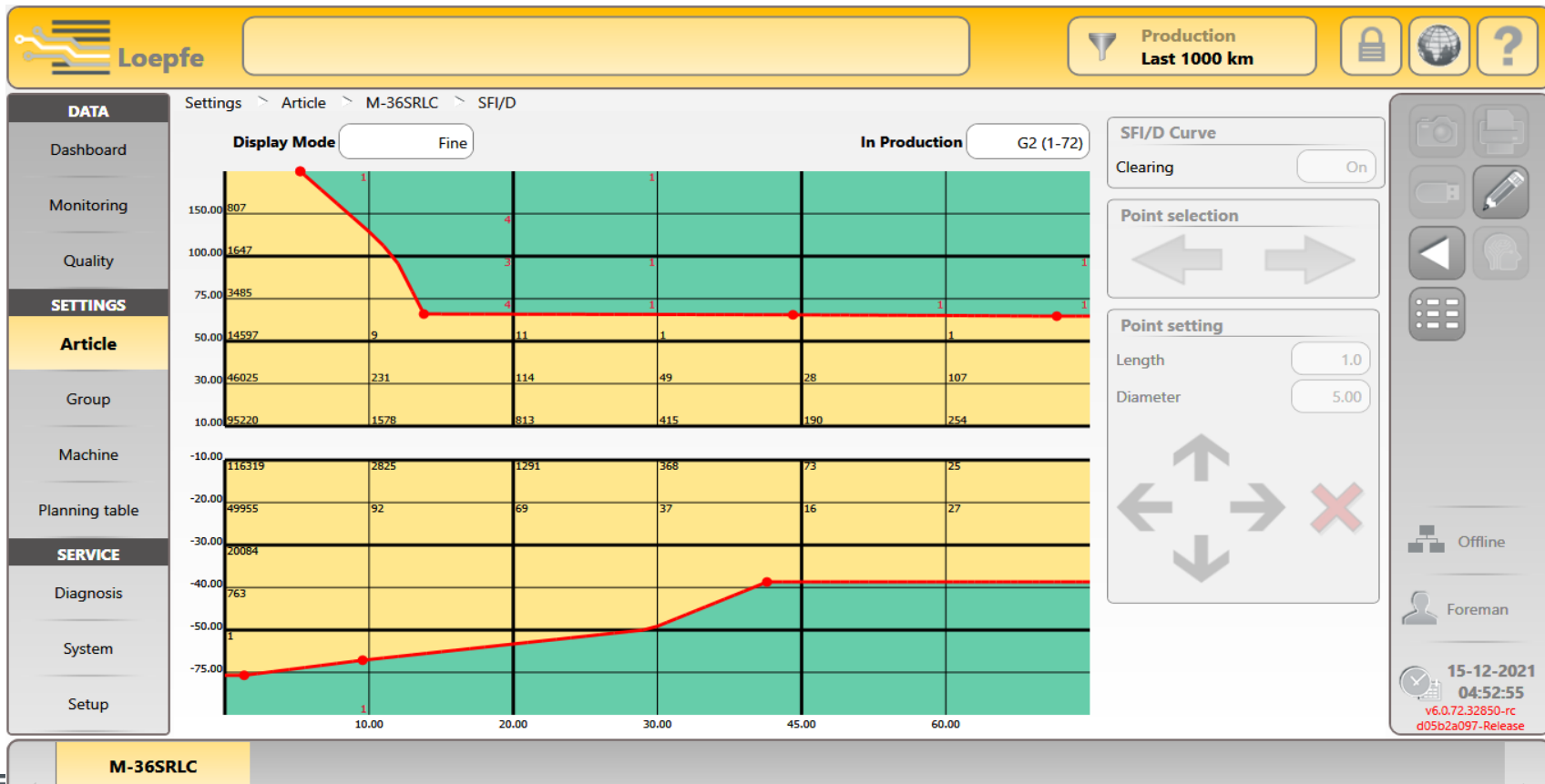
异纤分级→ PRISMA电清的异纤分偏暗和偏亮，各设74个分级区，额外增加，R和O分级，分别为I0, R0 和 O0 分级区



错支通道→错支通道分级可在纱种中设置。10米以内的纱疵称为短错支切纱，超过10米的纱疵称为错支切纱。



SFI 通道 → SFI通道分级可在纱种中进行设置。10米以内的纱疵称为Short SFI/D 切纱，超过10米的纱疵称为SFI/D切纱



最后切纱/测试模式/分级

最后切纱→可以看到每个锭子最后20个切纱的分级，长度(毫米)和强度。在异纤切纱的情况下，还能检测出纱疵的色调。

⌵
Production
Last 1000 km
🔒
🌐
?

DATA

SERVICE

Diagnosis

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

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

Offline

Foreman

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

测试模式 → 在服务/诊断/测试模式下，可以找到测试模式功能，指定检测的任何类型的切疵，让单锭停止后检查。如下面截图所示，设置检查NSL 捻接切疵，可以找到在B2.1和B2.3分级的短粗切疵，以及I2.4和R2.2分级的异纤切疵。

The screenshot displays the Loeffe software interface in 'Test Mode'. The top navigation bar includes 'Service', 'Diagnosis', 'TK2', and 'Test Mode'. The 'Test Mode' section is active, showing a 'Timeout setting (min)' of 60. Under 'Cut Types', the following options are checked:

- N Splice Cut
- S Splice Cut
- L Splice Cut

The right side of the interface features two line graphs: 'NSLT' and 'Foreign Matter'. The 'NSLT' graph shows a red line with data points, indicating a downward trend. The 'Foreign Matter' graph shows a red line with data points, indicating a downward trend. The bottom right corner displays system information: 'Offline', 'Foreman', '15-12-2021 05:15:02', and version 'v6.0.72.32850-rc d05b2a097-Release'.

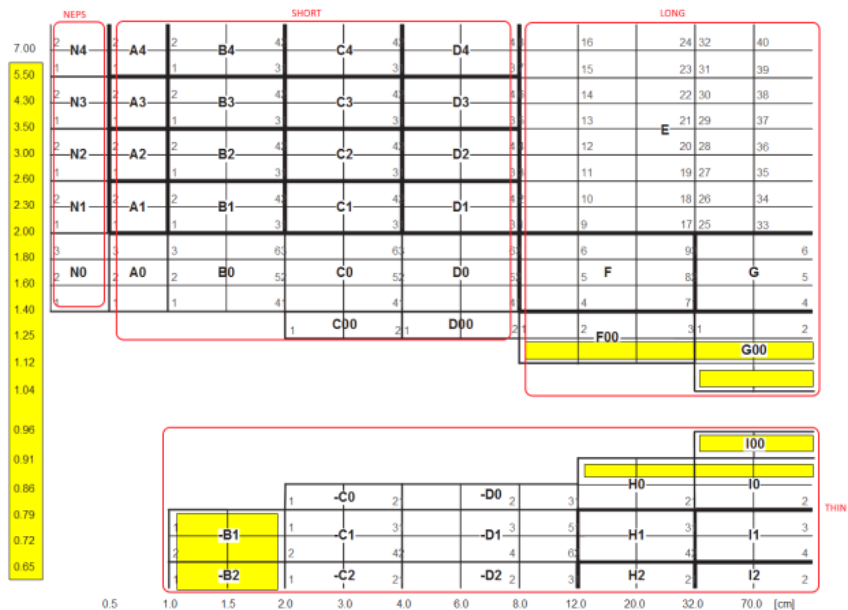
测试模式 → 选择单锭范围和时间范围。经确认后，所选单锭将在“测试”模式下运行，并允许每一种所选类型的疵点切断后停止单锭运行，同时在TK的显示器上交替闪烁所检测纱疵类别，纱疵距离纱线末端的大概长度以米为单位(通常在0.4米左右)。在锭位编号栏的下面，您可以通过下划线识别哪些锭子处于测试模式。另外，请注意，当设置超时后，测试模式被自动禁用。

The screenshot displays the Loepfe TK1 Test Mode interface. Key elements include:

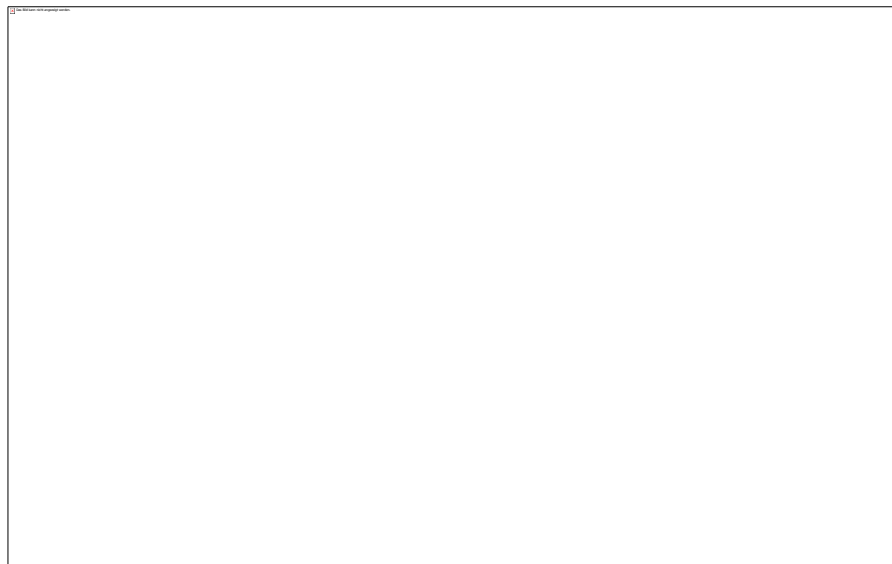
- Navigation:** Service > Diagnosis > TK1 > Test Mode.
- Timeout (min):** 60 (with a red circle around the timestamp 16-12-2021 20:50).
- Spindle Range:** A dialog box showing a range from 1 to 10.
- NSLT Chart:** A line graph showing spindle speed or tension over time.
- Foreign Matter Chart:** A line graph showing foreign matter detection over time.
- Cut Types:** A list of疵点类型 (e.g., 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, SF/D Cuts +, SF/D Cuts -, Short SF/D Cuts +, Short SF/D Cuts -, Drum Wrap Cut/Event, OffColor Cut Dark, OffColor Cut Bright, Missing Core Cut, OffCenter Core Cut).
- 锭位编号 (Spindle Numbers):** A grid at the bottom with the first row (1, 3, 5, 7, 9) underlined and circled in red.

NSLT 分级 → YM Prisma电清与早期电清相比，没有未分级的切疵，因为YM PRISMA电清提供额外的精细分级(如黄色突出显示)和调整帮助，可以让操作者全面兼顾地进行调整。

YM Prisma



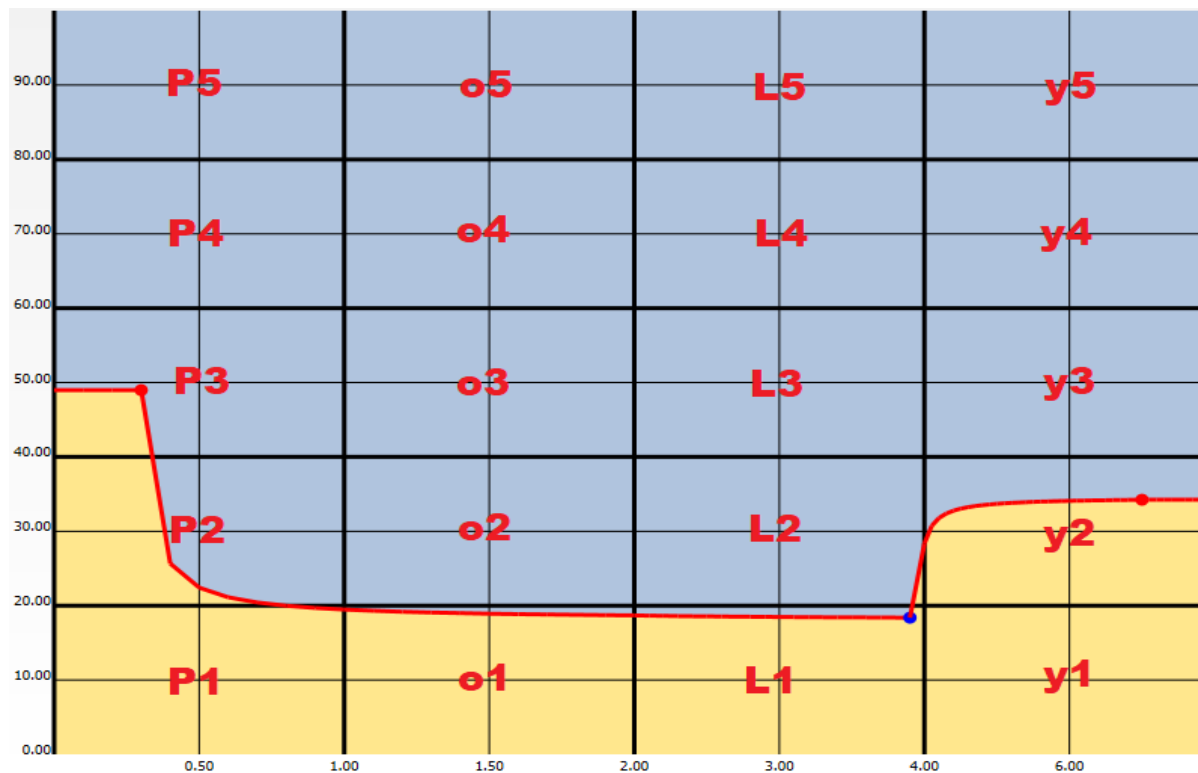
YM Zenit+



异纤分级 → 下方分级显示SIRO 0-4级别，其中S为0-10mm最短的纱疵，O为40-128mm最长的纱疵，强度范围为0-4，最低为0，最高为4。分级表上半部分为偏暗级别，下半部分为偏亮级别。

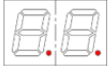
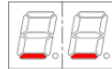
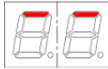
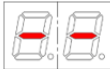
50.00	.2	D-S4	.4	.2	D-I4	.4	.2	D-R4	.4	.2	D-O4	.4		
20.00	.1		.3	.1		.3	.1		.3	.1		.3		
15.00	.2	D-S3	.4	.2	D-I3	.4	.2	D-R3	.4	.2	D-O3	.4		
12.00	.1		.3	.1		.3	.1		.3	.1		.3		
9.00	.2	D-S2	.4	.2	D-I2	.4	.2	D-R2	.4	.2	D-O2	.4		
6.00	.1		.3	.1		.3	.1		.3	.1		.3		
4.00	.2	D-S1	.4	.2	D-I1	.4	.2	D-R1	.4	.2	D-O1	.4		
3.00	.1		.3	.1		.3	.1		.3	.1		.3		
2.00			.2	D-I0	.4	.2		D-R0	.4	.2		D-O0	.4	
1.00							.1			.3	.1		.3	
-1.00								.2	B-R0	.4	.2		B-O0	.4
-2.00				.1	B-I0	.3	.1			.3	.1			.3
-3.00	.2	B-S1	.4	.2	B-I1	.4	.2	B-R1	.4	.2	B-O1	.4		
-4.00	.1		.3	.1		.3	.1		.3	.1		.3		
-6.00	.2	B-S2	.4	.2	B-I2	.4	.2	B-R2	.4	.2	B-O2	.4		
-9.00	.1		.3	.1		.3	.1		.3	.1		.3		
-12.00	.2	B-S3	.4	.2	B-I3	.4	.2	B-R3	.4	.2	B-O3	.4		
-15.00	.1		.3	.1		.3	.1		.3	.1		.3		

P丙纶丝分级显示POLY 1-5类，其中P为0-10mm最短的纱疵，Y为40-80mm最长的纱疵，摩擦电荷强度1-5级，1为最低，5为最高强度



检测头的指示灯定义

General Clearer States



Yarn runs
Diameter difference $\pm 5\%$

Out of Reset (Start Up)

Zeroing (ECR)

Wait for parameter spindle

Wait for parameter central unit (LZE)

Spindle Locked, Group not started

Adjust

Doffing

Update Firmware

Cuts

For all cuts: In case of Textile Alarm → Display is blinking (on/off) with last cut!



Bunch

Upper Yarn

Drum Wrap Cut

Drum Wrap Event

NSLT Cuts with TK Display Mode: Type (Default)



Joint short curve cut or
joint short class cut



Joint long curve cut or
joint long class cut



Joint thin curve cut
joint thin class cut



Joint nep curve cut or
joint nep class cut



Nep curve cut or
nep class cut



Short curve cut
short class cut



Long curve cut or
long class cut



Thin curve cut or
thin class cut

NSLT Cuts with TK Display Mode: Class (Detailed)



N0 – N4



A0 – A4



B0 – B4

with Dot in 1st Digit for B1 & B2: thin



C0 – C4; C00

with Dot in 1st Digit for C0 – C2: thin



D0 – D4, D00

with Dot in 1st Digit for D0 – D2: thin



E



F; F00

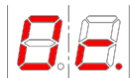
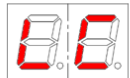
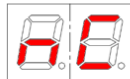


G; G00



H0 – H1

Other D Cuts



Nep – Cluster

Short – Cluster

Long – Cluster

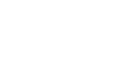
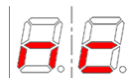
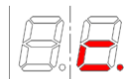
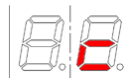
Thin – Cluster

without dot: Short Count +

with dot: Short Count -

without dot: Off Count +

with dot: Off Count -



without dot: SFID Short +

with dot: SFID Short -

SFID +

SFID -

Missing Core

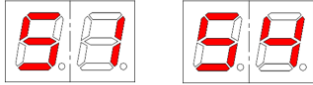
Offcentric Core

F Cuts with TK Display Mode: Type (Default)

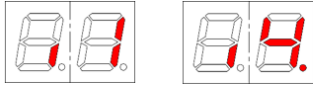


Cut by F-Sensor
without Dot: Dark
with Dot in 2nd Digit: Bright
with Dot in 1st Digit: Organic

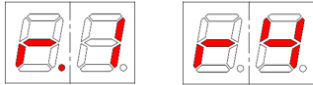
F Cuts with TK Display Mode: Class (Detailed)



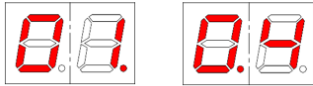
S1 – S4
without Dot: Dark
with Dot in 2nd Digit: Bright
with Dot in 1st Digit: Organic



I1 – I4
without Dot: Dark
with Dot in 2nd Digit: Bright
with Dot in 1st Digit: Organic

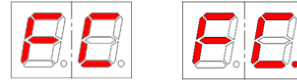


R1 – R4
without Dot: Dark
with Dot in 2nd Digit: Bright
with Dot in 1st Digit: Organic



O1 – O4
without Dot: Dark
with Dot in 2nd Digit: Bright
with Dot in 1st Digit: Organic

Other F Cuts



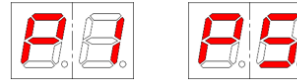
F – Cluster
without Dot: Dark
with Dot in 2nd Digit: Bright

P Cuts with TK Display Mode: Type (Default)



Cut by P-Sensor

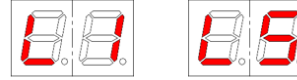
P Cuts with TK Display Mode: Class (Detailed)



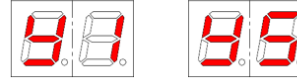
P1 – P5



o1 – o5

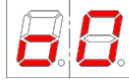


L1 – L5

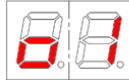


y1 – y5

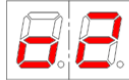
System Cuts



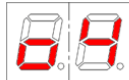
Cut request SPC



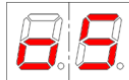
Zeroing Error



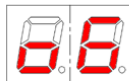
Cut User (button pushed)



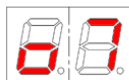
F brightness regulator limit



Adjust Cut



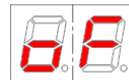
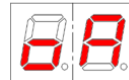
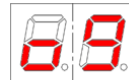
Cut failed (Cut Monitoring)



M range regulator limit



Adjust failed



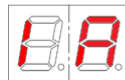
LZE triggered Cuts/Alarms



TK configuration changed by LZE



Spindle power fail



Internal Firmware Error

Class Alarm Cut

Off Limit Alarm Cut

IPI Alarm Cut