

Steelhawk Start-up Program

This document provides the recommended start-up/running-in procedure for optimum ring and traveler performance. Following the specified sequence helps ensure stable operation, reduced traveler wear and consistent spinning results.

Standard start-up program

- 100% cotton
- Cotton blends
- Ne 60 and coarser yarn counts

Phase	Spindle speed	Traveler change duration*	Traveler number
I	100%	1 doff	1 number lighter
II	100%	After 25% of the normal traveler life time	Normal traveler
III	100%	After 50% of the normal traveler life time	Normal traveler
IV	100%	After 75% of the normal traveler life time	Normal traveler
V	100%	Normal traveler life time	Normal traveler

*Note:

The traveler change must be done with full cops (not with empty tubes!).

Special start-up program

- Cotton Ne 60 and finer
- 100% synthetic fibers
- Core yarns
- Compact yarns
- Cotton and blends with high twist
- Special fibers and specialty yarns

Phase	Spindle speed	Traveler change duration*	Traveler number
I	90%	1 doff	1 number lighter
II	90%	12 hours	Normal traveler
III	95%	24 hours	Normal traveler
IV	100%	48 hours	Normal traveler
V	100%	72 hours	Normal traveler
VI	100%	120 hours, extend in steps to normal traveler life	Normal traveler

Important notes

Rings are supplied lightly oiled to facilitate start-up. Depending on spinning conditions, one or two sizes heavier travelers may be required after completion of the start-up program. Traveler changes should always be performed with full cops.