

Dear Customer,

Please find herewith some guidelines on how to prepare your valuable weaving machines for the restart after a long standstill. The aim behind this is to focus on the best possible procedures to safeguard the lifetime and good functioning of your equipment.

Weaving machines (airjet/rapier)

Guidelines during a long standstill:

- Keep the power of the looms completely switched OFF during a period of long standstill.
- Clean the electrical panels in the control box and remove any dust and fluff by gently blowing towards it from a distance. Make sure the control box is closed again afterwards.
- Remove any dust from the machine body.
- The use of dry silica gel packets inside the control box to absorb moisture will be helpful when looms are stopped and powered-off.
- Use an anti-rust lubricating spray to avoid oxidation. Please note that the spray should only be used on machined and not painted surfaces, levers, etc. Furthermore, do not spray close to or on the bearings.
- Grease all items as mentioned in the Picanol Instruction Manual.
- The air conditioning should preferably remain in operation, as this will avoid condensation forming in the shed.
- Stop air compressors and any connected machinery by carefully following the guidelines of the manufacturer.
- It is preferable for the machines to be stopped without beam, as this enables better access for thorough cleaning.
- For rapier machines, it is advisable to dismount the tapes or to stop the machine with the grippers practically at transfer, in order to avoid/limit deformation of the tapes.
- Cover the machines with a sheet or other, and this should also include the rewinder and bobbin stand.
- Please read and apply the guidelines from Stäubli as mentioned below.

Machine preparation for restarting:

- If it has been stopped, restart the air conditioning at least 24 hours prior to restarting the machines.
- Remove any covering that has been placed over the machines.
- Remove any silica gel packets (if applied) from within the control box. Make sure that the control box is closed again afterwards.

- Grease the machine thoroughly before restarting (i.e. until the original grease has been removed/refreshed), as mentioned in the Picanol Instruction Manual.
- Restart the air compressors and related machinery by closely following the guidelines of the manufacturer.
- Flush the compressed air supply lines in order to remove any condensation, oil residue, as well as any foreign dust or rust particles that are possibly coming from the compressed air installation. This flushing needs to be done at the entrance of each and every single weaving machine in order to avoid contamination of the pneumatical parts of the machine (such as valves, relay nozzles, etc.).
- We highly recommend checking the entire compressed air distribution network for air leakages before starting up the weaving machines. It is known, when not being checked every now and then, that the losses in the network can go up to 10 – 15% of the compressor capacity. When weaving machines are stopped, very small leakages in joints, connections, etc. can be easily be located by the noise they are generating.
- After a long standstill all splash lubrication areas will be 'dry'. When restarting the machines, first weave approximately 10 picks in slow weaving as this will enable the oil pump to run for a while and distribute the oil prior to a high-speed start.

The below information regarding Stäubli products has been compiled by Stäubli and it has been included in this communication for completeness. Please note that Picanol cannot assume any responsibility regarding the correctness or completeness of any information issued by Stäubli.

STÄUBLI dobbie and cam box products

- Please clean the Dobby/cam box and remove any fluff from it. You should then clean the oil filters using normal air pressure.
- For cam boxes, stop the machine in a non-level position (this will avoid leveling related problems).
- For dobbies, select all down design.
- Release the warp beam tension for the cam box and dobbies.
- Completely clean the under motion with compressed air pressure (the air should be dry).
- Put some oil drops on the DRC 10 rod and connectors (do not apply an excessive amount of oil as otherwise it can be counterproductive).
- After the end of the lockdown and prior to starting up the machines, carry out the greasing of the complete under motion until the old dry grease comes out from the bearings.
- Prior to starting up the machine, check the oil level of the cam box and auto-levelling unit.
- For dobbies, you should select 'plain weave' for all units and make inching for a few picks in order to lubricate all of the jack levers prior to starting up.
- Some of the instructions for our latest series of dobbies and cam boxes are attached for your reference. Before starting up the cam box and dobbies, open the cover and put some oil on the parts as shown in the attachment.

Electronic Jacquard machines

Instructions and procedures to keep the machines stopped and to restart them after a longer period are specific for each supplier and the type of Jacquard machine. Please refer to the user manuals for all of the products or contact the supplier directly for any queries. Below, you can find some general guidelines:

- Please clean all Jacquard machine fluff and, if any, fluff from the harness.
- You should carefully stop all Jacquard with all down design and at zero degrees of Jacquard. All Jacquard covers should be installed.
- Release the warp tension of the beam.
- While re-starting the Jacquard machines, carefully carry out the greasing on all of the points, including the cardan shaft, until the old grease has come out. Then carry out and make inching on a step-by-step basis for a few picks prior to commencing with fast running. Please note that magnet heating may be required on specific types of machines.
- Check the oil level in the Jacquard and the gear box.

Do you have any feedback or questions on the restart of Picanol machines? Please feel free to contact our service colleagues, they can still be reached easily via their email address.

In case you need spare parts, Picanol Original Quality Parts are of the highest quality to ensure optimum performance of your Picanol weaving machines. For further information on our Picanol Original Quality Parts and related services, you can contact spareparts1@picanol.be.

We will be pleased to help you!

Kind regards,

Picanol nv