<table>
<thead>
<tr>
<th>Sr no</th>
<th>Contents</th>
<th>Page no.</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Basic textiles terms</td>
<td>1</td>
</tr>
<tr>
<td>2.</td>
<td>Sizing</td>
<td>1</td>
</tr>
<tr>
<td>3.</td>
<td>Sequence of operations in weaving</td>
<td>2</td>
</tr>
<tr>
<td>4.</td>
<td>Identification of sizing machine parts</td>
<td>2</td>
</tr>
<tr>
<td>5.</td>
<td>Objectives of sizing</td>
<td>2</td>
</tr>
<tr>
<td>6.</td>
<td>Operations involved in sizing</td>
<td>4</td>
</tr>
<tr>
<td>7.</td>
<td>Sizing defects</td>
<td>7</td>
</tr>
<tr>
<td>8.</td>
<td>Remedial measures for defect prevention</td>
<td>7</td>
</tr>
<tr>
<td>9.</td>
<td>Shift interchange</td>
<td>8</td>
</tr>
<tr>
<td>10.</td>
<td>Safety aspects</td>
<td>9</td>
</tr>
</tbody>
</table>
1. BASIC TEXTILES TERMS:
   - **Yarn:** A continuous strand of fibers/filament, twisted /non twisted, it is basic raw material for weaving.
   - **Type of Yarns:** single yarn, double or multi fold yarn, spun yarn & filament yarn etc.
   - **Yarn count:** the yarn count is a numerical expression which defines it’s fineness or coarseness.
   - **Yarn count:**
     - Indirect system: English count(Ne), Worsted Count etc.
     - i.e. Higher the yarn number , finer the yarn.
     - Direct System: Tex, Denier
     - i.e. Higher the yarn number , Coarser the yarn.
   - **Warp & Weft Yarn:**
     The lengthwise yarns in the woven fabric are called the warp yarn and the widthwise yarns in the woven fabric are called the weft yarn.

2. Sizing
   - Sizing is the process of applying protective adhesive coating on the yarn surface.
   - This is the most important segment of weaving preparatory process. Because sizing has direct influence on the weaving efficiency.
   - Better the quality of sizing higher the weaving efficiency & vice versa.
2.1 sequence of operation in weaving

Warping
↓
Sizing
↓
Drawing in
↓
Weaving
3 Identification of Sizing machine parts

4 Objectives of the Sizing

- To improve abrasion resistance of the yarn.
- To reduce hairiness of the yarn.
- To reduce generation of static charge for polyester blend yarn
- To improve breaking strength of cellulosic yarns.

Sizing Machine parts:

<table>
<thead>
<tr>
<th>creel</th>
<th>![Creel Image]</th>
</tr>
</thead>
</table>


<table>
<thead>
<tr>
<th>Equipment</th>
<th>Image Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Sow box</td>
<td>![Sow box Image]</td>
</tr>
<tr>
<td>Drying cylinder</td>
<td>![Drying cylinder Image]</td>
</tr>
<tr>
<td>Lease rods</td>
<td>![Lease rods Image]</td>
</tr>
<tr>
<td>Moisture roller</td>
<td>![Moisture roller Image]</td>
</tr>
</tbody>
</table>
5 Operation involved in sizing Machine

5.1 Set changing

- Clean the sizing creel & the sizing machine after the run out of the previous program.
- Bring the warped beams for the next set to the sizing from the warping
- Creel the warped beams in the sizing creel as instructed
- Knot the ends from the creeled warped beams with that of the old warp sheet from the previous set.
- Paste tape on the warp sheet, so as to enable the lease to be applied
- Check with higher authority whether single sow box or double
- Show Boxes to be used for the next set.

5.2 Running the Machine

- Pull warp sheet from the creeled warping beam according to the requirement of the sow box/ sow boxes,
- Clean the sow box/ sow boxes. before the knots reach the sow box/ sow boxes
- Switch on ‘size pump’, ‘sow box steam volve’, ‘squeeze roller press revolve, moisture control etc. once the size is filled in the sow box/ sow boxes.
- Activate impression rollers
• Ensure that the size is not boiled in excess than required and splash in the warp sheet to avoid size patches
• Check the viscosity & refract meter reading for the size in the sow box/ sow boxes.
• Check the drying cylinders temperature quite often
• Apply ‘lease’ as advised
• Mend the ‘lappers’
• Activate hydraulic rollers, when the machine is running. to ensure the required pressure.
• Ensure that no space is left near the flanges in both the sides
• Ensure that no warp thread is overlapped, particularly near the flanges in both the sides
• Ensure that the “leasing area” .comb area” etc...are free from waste.
• Ensure moisture control & temperature control are properly functioning
• Weigh each & every beam on completion and check the size pick up & Correct the migration of ends
• Note down the lapper details, migration details etc. in the performance log note book.
• Check the Stretch Control

5.3 Doffing Of Sized Beams
• Paste the gum tape on the beam just 2-3 metres before the end of each 
• Paste the another tap on the beam after the completion of the beam 
• Write the following details on the “ beam ticket” and the same has to be pasted in the flange outer of the beam after the completion of each Of the beam:-
  a) Count
  b) Set No.
  c) Beam No.
  d) Total Ends
  e) Beam metres
• Note the following set details in the "sizing production register 'after the completion of the Set, "
  a) Count
  b) Set No.
  c) Beam No.
  d) Total Ends
  e) Beam Metres
  f) Size Pick Up
  g) No. Of Lappers
  h) No of Migra

5.4 Other Work practices
• Keep the "lease rope", ready so as to apply the lease, when required
• Not touch the machine, when it is running.
• Drench the gum tape in water before the tape is wasted, so that the tape doesn’t peel off, easily.
• Check with higher authority in advance (before the set is completed) for the continuous use of the size in the sow box/sow boxes or for the collection of the same in can/cans
• Give preference to safety, should not enter the area, where he/she is not allowed. & should not do a job in which training has not being given
• Ensure that no raw material/cloth/spare/tool/any other material is thrown under/near the machines or in the other work areas.
• Run the sizing machine in the speed, as advised
• Check for the reasons for the frequent breakages, the reasons that could be Corrected by himself/herself should be corrected otherwise, the same has to be reported to the superiors
• Report immediately to supervisor for any machine faults.
6 SIZING Defects

- Ends are loose and not parallel to each other.
- Non-uniform tension from end to end.
- Non-uniform warp density of sized beam.
- Selvedge ends are on high or low tension with the warp.
- Non-uniform application of size.

7 Remedial measures for defect prevention

- Before and during the starting of the machine various zones of stretch control on sizing machines should be checked.
  1. Creel zone: start- last warper beam, end-Dry nip
  2. Wet Zone; Start- dry nip, end- first drying cylinder
  3. Drying Zone: start- first drying cylinder, end- last drying cylinder
  4. Splitting Zone: start-last drying cylinder, end- drag roll
  5. Winding Zone: start- drag roll, end- loom beam
  6. To inform the about the sticky ends and to do combing.

8 Shift interchanging charges

8.1 Taking charge

- Come at least 10 - 15 minutes earlier to the work spot
- Check for the necessary items like “chalk”, “pen” " knife" etc.
- Meet the previous shift sizer, discuss with him/her regarding the issues faced by them with respect to the quality or production or spare or safety or any other specific instruction etc.
- Check the condition of the running beams, machine, performance of the yarn running for the running program
- Check whether all the stop motions work in good condition
- Take “job cards” for the next programs, from the higher authority.
• Check availability of the warping beams & the empty sizing beams required for the next programs
• Check the quality of the warped beams for the damage, particularly near the flanges
• Check the cleanliness of the machines & other work areas
• Check whether any spare/raw material/tool /any other material is thrown under the machines or in the other work areas.
• Question the previous shift sizer for any deviation in the above and should bring the same to the knowledge of his/ her shift superior as
• Well that of the previous shift as well

8.2 Handing over change
• Hand over the shift to the incoming sizer in a proper manner & get clearance from the incoming counterpart before leaving the work spot
• Report to his/ her shift superiors as well as that of the incoming shift, in case his/ her counterpart doesn't come for work for the incoming shift. in that case, the shift has to be properly handed over to the incoming shift superior & get clearance from him/ her, before leaving the work spot
• Report to his/ her shift superior about the quality / production /
• Safety issues/ any other issue faced in his/ her shift and should leave the department only after getting concurrence for the same from his/ her superiors

9 Safety aspects
• Comply with health and safety related instructions applicable to the workplace
• Use and maintain personal protective equipment such as “ear plug”, “ nose mask “, “ head cap” etc., as per protocol
• Carry out own activities in line with approved guidelines and procedures
• Maintain a healthy lifestyle and guard against dependency on intoxicants
• Follow environment management system related procedures
• Identify and correct (if possible) malfunctions in machinery and equipment
• Report any service malfunctions that cannot be rectified
• Store materials and equipment in line with organisational requirements
• Safely handle and remove waste
• Minimize health and safety risks to self and others due to own actions
• Seek clarifications, from supervisors or other authorized personnel in case of perceived risks
• Monitor the workplace and work processes for potential risks and threat
• Carry out periodic walk-through to keep work area free from hazards and obstructions, if assigned
• Report hazards and potential risks/threats to supervisors or other authorized personnel
• Participate in mock drills/evacuation procedures organized at the workplace
• Undertake first aid, fire-fighting and emergency response training, if asked to do so
• Take action based on instructions in the event of fire, emergencies or accidents
• Follow organization procedures for shutdown and evacuation when required