



RUNNING-IN PROCEDURE FOR METRO RINGS

Step	Spindle Speed	Traveler Change Duration	Traveler Number	Notes
I	80% of Final Speed	1 hour	2 no. Heavier Traveler than Normal	Clean Rings ⁽²⁾
	80% of Final Speed	1 doff		
	80% of Final Speed	2 doffs		Traveler inspection ⁽³⁾
II	90% of Final Speed	1 doff	1 no. Heavier Traveler than Normal	Clean Rings ⁽²⁾
	90% of Final Speed	2 doffs		
	90% of Final Speed	4 doffs		
	90% of Final Speed	8 doffs		Traveler Inspection ⁽³⁾
III	Final Speed	1 doff	Normal Traveler	
	Final Speed	2 doffs ⁽⁴⁾	Normal Traveler	Traveler Inspection ⁽³⁾
	Final Speed	4 doffs	Normal Traveler	
	Final Speed	8 doffs	Normal Traveler	Traveler Inspection ⁽³⁾
	Final Speed	12 doffs	Normal Traveler	
	Final Speed	16 doffs	Normal Traveler	Traveler Inspection ⁽³⁾
	Final Speed	24 doffs	Normal Traveler	
	Final Speed	32 doffs	Normal Traveler	Traveler Inspection ⁽³⁾

IMPORTANT NOTES:

- (1) The traveler change must be done with half full bobbins (not with empty bobbins).
- (2) Clean rings with a dry cotton cloth to remove dust accumulation.
- (3) If the % of burnt traveler is more than 5%, then the last traveler change duration is to be repeated until % of burnt traveler is less than 5%.
- (4) From this step and after every traveler change (during normal production) the speed should be reduced at 80% of final speed for the first 30 minutes. This procedure will increase traveler life.
- (5) From this step, if the % of burnt traveler is less than 5%, traveler replacement cycle can be extended until full change cycle is obtained.