



RUNNING-IN PROCEDURE FOR S-2000 RINGS

Step	Spindle Speed	Traveler Change Duration	Traveler Number	Notes
I	90%	1 doff	1 or 2 Numbers Lighter than Normal	Clean Rings ⁽²⁾
	90%	12 hours	Normal Traveler	
II	95%	24 hours	Normal Traveler	Traveler Inspection ⁽³⁾
	95%	48 hours	Normal Traveler	
	95%	72 hours	Normal Traveler	
III	100%	72 hours ⁽⁴⁾	Normal Traveler	
	100%	120 hours ⁽⁵⁾	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 90% 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.