

Title (en)
Warping machine and process

Title (de)
Schäranlage und Schärverfahren

Title (fr)
Dispositif et procédé d'ourdissage

Publication
EP 1209264 B1 20070516 (DE)

Application
EP 01114094 A 20010609

Priority
DE 10029492 A 20000615

Abstract (en)
[origin: DE10029492A1] The cone warping machine, with a rotating drum and a bobbin creel, has a change creel (9) with two or more bobbin points (11) for each yarn take-off. The bobbins are brought selectively into a working position. A cutter (18) severs the yarn (6) at a bobbin (12), and a knotter (18) joins the cut yarn end to the leading yarn end at a fresh bobbin. Each yarn take-off is supplied by at least six bobbin points, with at least 64 yarn take-off points at the creel. The bobbin points for a yarn take-off are at a conveyor (10), which is operated to bring a selected bobbin to the take-off. The conveyor is positioned by a drive motor, with a separate motor for each conveyor. The conveyor is a rotating table or a vertical belt conveyor. The yarn cutter/knotter is a mobile unit, to serve a number of yarn take-off points. Or each yarn take-off has a dedicated yarn cutter/knotter. The conveyor can serve at least one additional take-off point. A control (20) directs the actions of the yarn cutter(s), the positions of other bobbin points at the yarn take-off(s) and the yarn knotting in automatic operations. The control uses the data from the warping card, which show the location of bobbins of different yarn types at the bobbin points. An optical display is at the conveyors, to show the type of yarn carried by the bobbins at each bobbin point. An Independent claim is included for a warping operation, using a cone warping machine. When a given length of warps have been wound, at least a part of the yarns are cut from their supply bobbins, and the cut ends are knotted to the leading ends of other selected bobbins. Preferred Features: The yarn counts of all the wound lengths are identical, apart from wound residue, cut from the section of the conveyor which is not needed. The warps are wound into a number of wound packages with the same number of yarns of the same yarn thickness, yarns/cm and warp width, but in different colors, in succession during the warping operation.

IPC 8 full level
D02H 3/00 (2006.01); **B65H 49/12** (2006.01); **B65H 49/16** (2006.01); **B65H 69/00** (2006.01); **D02H 1/00** (2006.01)

CPC (source: EP)
B65H 49/12 (2013.01); **B65H 49/16** (2013.01); **B65H 69/00** (2013.01); **D02H 1/00** (2013.01); **D02H 3/02** (2013.01); **B65H 2701/31** (2013.01)

Cited by
CN103046190A; CN105274694A; EP1741814A3; CN103796939A

Designated contracting state (EPC)
CH DE ES IT LI

DOCDB simple family (publication)
DE 10029492 A1 20020103; **DE 10029492 C2 20030424**; DE 50112505 D1 20070628; EP 1209264 A2 20020529; EP 1209264 A3 20040107; EP 1209264 B1 20070516; ES 2282173 T3 20071016; JP 2002030537 A 20020131; JP 3492335 B2 20040203

DOCDB simple family (application)
DE 10029492 A 20000615; DE 50112505 T 20010609; EP 01114094 A 20010609; ES 01114094 T 20010609; JP 2001175429 A 20010611