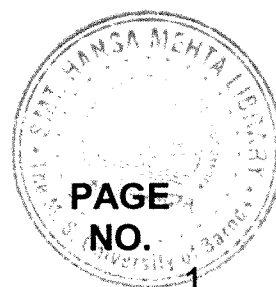


## CONTENTS



No.	CHAPTER	PAGE NO.
CHAPTER I	INTRODUCTION	1
1	Introduction	2
CHAPTER II	REVIEW OF THE LITERATURE PERTAINING TO THE PRESENT WORK	6
2.1	Introduction	7
2.2	Classification of Bulked Yarns	8
	2.2.1 Definitions	9
	2.2.2 Texturising methods	10
	2.2.2.1 Air-jet Texturising	12
	2.2.2.2 False-twist Texturising	16
	2.2.3 Production of Combined or Plied yarns	18
2.3	Mechanical Texturising: A novel concept	19
	2.3.1 Wray's Mechanical-Bulking Process	20
	2.3.2 Single-step Mechanical-Bulking process	21
	2.3.3 Mechanical Crimp Textured Yarn	22
2.4	Parameters Influencing Textured Yarn Quality	22
	2.4.1 Material Variables	23
	2.4.2 Machine Variables	28
	2.4.2.1 Type of Pre-twist Technique	29
	2.4.2.2 Type of False-twist Technique	29
	2.4.2.3 Feed systems	38
	2.4.2.4 Winding or Take-up Mechanisms	40
	2.4.3 Processing variables	42
	2.4.3.1 Pre-twist	43
	2.4.3.2 False-twist	43
	2.4.3.3 Percent Underfeed	45
	2.4.3.4 Bulking zone length	46
	2.4.3.5 Delivery speed	47
2.5	Structural Mechanics of Twisted yarns	48
	2.5.1 Twist imparted to the yarn by false-twist mechanism	48
	2.5.2 Optimum twist of Textured yarn	50
2.6	Methods of Analyzing Structure and Properties of Textured yarn	52
	2.6.1 Methods of Analyzing Textured yarn structure	52
	2.6.2 Methods of Measuring Instability of Textured yarn	53
	2.6.2.1 Weight Hanging Methods	54
	2.6.2.2 Extension Measurement under	56

	Static Conditions	
	2.6.2.3 Methods Based on Thread Tensile Force during Stretching on a Running yarn	59
	2.6.2.4 Permanent Extension as Instability in a Tensile test	59
	2.6.2.5 Methods Based on Repeated Loading (% Decay Method)	60
	2.6.3 Bulkiness of Textured Yarns	61
	2.6.4 Degree of Crimpiness of Textured yarns	64
2.7	Performance of Textured Yarn during Fabric Formation	65
<b>CHAPTER III</b>	<b>EXPERIMENTAL WORK</b>	<b>74</b>
3.0	Introduction	75
3.1	Methodology	75
	3.1.1 Development / Fabrication of the Model Machine for Innovative Texturising	77
	3.1.1.1 Pre-twisting zone	78
	3.1.1.2 Feeding zone	85
	3.1.1.3 False-twisting zone	90
	3.1.1.4 Delivery and Winding zone	95
	3.1.2 Experimental	98
	3.1.2.1 Evaluation of Structure and Properties of Innovative Textured Yarn	99
	3.1.2.2 Effect of Process variables on Structure and Properties of Mechanical Textured Yarn	101
	3.1.2.3 Effect of Raw-material Characteristics on Structure and Properties of Mechanical Textured Yarn	108
	3.1.2.4 Identifying the Performance of Knitted and Woven Fabric produced by using Newly Engineered Textured yarn	111
	3.1.2.5 Study the Cost Effectiveness of the Mechanical Textured Yarn with respect to Commercial Texturising systems	114
3.2	Testing Methods	115
	3.2.1 Denier and its Deviation	116
	3.2.2 Uniformity Measure	117
	3.2.3 Twist Measurement	117

	3.2.4 Yarn-structure and Yarn-appearance Test	119
	3.2.5 Measure of Crimp properties	121
	3.2.5.1 Crimp stability	121
	3.2.5.2 Textured yarn Bulk	122
	3.2.6 Measure of Percent Boiling water shrinkage	123
	3.2.7 Measure of Mechanical Properties	125
	3.2.8 Dyeability and Strippiness	126
3.3	Testing Methods used for Fabric	127
	3.3.1 Measure of Fabric Width Shrinkage	128
	3.3.2 Density and Count of Constituent Yarns	128
	3.3.3 Percent Crimp	130
	3.3.4 Weight per Unit Area (GSM)	131
	3.3.5 Air Permeability	131
	3.3.6 Stiffness	133
	3.3.7 Crease Recovery	134
	3.3.8 Tensile Properties	135
	3.3.9 Drape	136
	3.3.10 Abrasion Resistance	137
	3.3.11 Tearing Strength	137
	<b>CHAPTER IV RESULTS AND DISCUSSION</b>	<b>139</b>
4.1	Introduction	140
	<b>FABRICATION OF PROTOTYPE MODEL MACHINE</b>	<b>142</b>
4.2	Introduction	143
	4.2.1 Pre-twisting zone	143
	4.2.2 Feeding zone	144
	4.2.3 False-twisting zone	145
	4.2.4 Delivery and Winding zone	147
	<b>EVALUATION OF STRUCTURE AND PROPERTIES OF INNOVATIVE TEXTURED YARN</b>	
4.3	Structure of Mechanical Textured Yarn	149
4.4	Evaluation of the Quality parameters of Innovative Textured Yarn with standards	160
	4.4.1 Denier and Increase in Denier	162
	4.4.2 Mechanical Properties	162
	4.4.3 Physical Bulk	164
	4.4.4 Crimp Stability	165
	4.4.5 Twist	165
	4.4.6 Percent Boiling water shrinkage	165
	4.4.7 Tube Knitting and Dyeing (TKD) Test	166

**EFFECT OF PROCESS-VARIABLES AND MATERIAL-VARIABLES ON STRUCTURE AND PROPERTIES OF INNOVATIVE TEXTURED YARN.**

4.5	Effect of Process-Variables on Structure and Properties of Mechanical Crimp Textured Yarn	170
	4.5.1 Effect of False-twist on the Performance of Textured Yarn	171
	4.5.1.1 Increase in Linear Density and Physical Bulk	172
	4.5.1.2 Percent Boiling water shrinkage	175
	4.5.1.3 Percent Instability	175
	4.5.1.4 Twist	177
	4.5.1.5 Mechanical properties	177
	4.5.1.6 Tensile Behaviour of Innovative Textured yarn	180
	4.5.2 Effect of Pre-twist on the Performance of Textured yarn	186
	4.5.2.1 Increase in Linear density and Physical Bulk	190
	4.5.2.2 Percent Boiling water shrinkage	191
	4.5.2.3 Percent Instability	193
	4.5.2.4 Mechanical properties	194
4.6	Effect of Delivery Speed	196
	4.6.1 Increase in Linear density, Instability and Bulk	197
	4.6.2 Pre-twist	200
	4.6.3 Percent Boiling water shrinkage	200
	4.6.4 Mechanical properties	201
4.7	Effect of Bulking zone Length	202
	4.7.1 Increase in Linear density and Bulk	203
	4.7.2 Percent Instability	206
	4.7.3 Percent Boiling water shrinkage	206
	4.7.4 Mechanical Properties	208
4.8	Development of an Empirical Formula for Calculating Optimum False-twist Level	210
	4.8.1 Optimisation of False-twist at Constant Pre-twist	211
	4.8.2 Optimisation of False-twist at Variable Pre-twist	213
4.9	Mathematical Derivation of Empirical formula for Optimum False-twist K (tpm) for the Innovative Texturing process	215
4.10	Confirmation Trial: Effect of pre-twist Level at Optimum Process-variables	219
	4.10.1 Increase in Linear density and Bulk	221

	4.10.2 Instability	222
	4.10.3 Percent Boiling water shrinkage	223
	4.10.4 Pre-twist	228
	4.10.5 Mechanical properties	229
	4.10.6 Effect of Post Heat-setting	232
	4.10.6.1 Linear density and Bulk of Post Heat-set Yarn	232
	4.10.6.2 Instability and Mechanical properties of Post Heat-set Yarn	233
	4.10.6.3 Percent Boiling water shrinkage of Post Heat-set Yarn	233
4.11	Effect of Raw Material Characteristics on Structure and Properties of Mechanical Textured Yarn	234
	4.11.1 Effect of Raw Material Characteristics	234
	4.11.1.1 Increase in Linear density and Bulk	237
	4.11.1.2 Percent Instability	242
	4.11.1.3 Percent Boiling water shrinkage	244
	4.11.1.4 Pre-twist	245
	4.11.1.5 Mechanical Properties	246
	4.11.2 Effect of Yarn Fineness	249
	4.11.2.1 Increase in Linear density and Bulk	251
	4.11.2.2 Percent Instability	252
	4.11.2.3 Pre-twist and Percent Boiling water shrinkage	253
	4.11.2.4 Mechanical Properties	254
<b>PERFORMANCE EVALUATION OF NEWLY ENGINEERED TEXTURED YARN IN KNITTED AND WOVEN STRUCTURE</b>		
4.12	Introduction	257
	4.12.1 Constructional Properties	259
	4.12.1.1 Fabric sett and Fabric Width shrinkage	261
	4.12.1.2 Linear density of Constituent yarns	268
	4.12.1.3 Fabric Weight per Unit area and Fabric Thickness	269
	4.12.1.4 Physical Bulk	270
	4.12.2 Mechanical Properties	273
	4.12.2.1 Tensile Properties	273
	4.12.2.2 Tearing Strength	280
	4.12.2.3 Abrasion Resistance	283
	4.12.3 Comfort Properties	286
	4.12.3.1 Air-permeability	286

	4.12.4 Low Mechanical Stress and Aesthetical Properties	289
	4.12.4.1 Stiffness and Drape	289
	4.12.4.2 Crease-recovery	291
4.13	Knitted Fabrics	292
	<b>COST EFFECTIVENESS STUDY OF MECHANICAL TEXTURED YARN WITH RESPECT TO COMMERCIAL TEXTURISING SYSTEMS</b>	
4.14	Cost Effectiveness of Mechanical Textured Yarn with respect to Commercial texturising Systems	295
	4.14.1 Important points considered for Evaluation	295
	4.14.2 Cost Evaluation of Innovative Textured Yarn (for single head Lab apparatus)	296
	4.14.2.1 Cost per unit weight for the Newly Engineered Product	296
	4.14.2.2 Machine Power cost per Kg.	297
	4.14.2.3 Raw Material Cost per Kg.	297
	4.14.2.4 Cost per Kg.	298
CHAPTER V	<b>CONCLUSION</b>	301
5.0	Conclusion	302
	Recommendation for Future work	314
	<b>REFERECES</b>	316
APPENDIX-1	<b>CERTIFICATES</b>	323
APPENDIX-2	<b>PICTORIAL-VIEWS OF TEXTURED YARN</b>	329
APPENDIX-3	<b>MAT LAB PROGRAMME</b>	333