

**GUJARAT TECHNOLOGICAL UNIVERSITY****BE - SEMESTER-VII(NEW) EXAMINATION – SUMMER 2019****Subject Code:2172903****Date:14/05/2019****Subject Name:Production Planning & Maintenance****Time:02:30 PM TO 05:00 PM****Total Marks: 70****Instructions:**

1. Attempt all questions.
2. Make suitable assumptions wherever necessary.
3. Figures to the right indicate full marks.

		MARKS
<b>Q.1</b>	(A) Write Production Formula For Modern Comber In Kg/Shift.	3
	(B) It Is Required To Produce 5500 Kg Of Combed Yarn Of 40'S Ne. Calculate Total Raw Cotton Required For The Same.	4
	(C) A Twill Woven Fabric Need To Prepare Of About 2500 Meter Length. Where EPI & PPI Are 40 & 26. Warp And Weft Count Is 32'S, Warp And Weft Crimp 6%. Calculate Weight Of Warp And Weft Required For This Lot If Reed Width Is Of 52 Inch.	7
<b>Q.2</b>	(A) Convert 25 Ne To Tex And Nm	3
	(B) Discuss About Different Types Of Maintenance & Its Importance.	4
	(C) Calculate Required No Of Ring Frame And Speed frame Spindle For The Production Of 2000 Kg Yarn Of 30's Carded. Where Ring Frame Spindle Speed 19500 Rpm, Time 8 Hrs, Waste 3%, T.P.I-25, Draft 22, Efficiency 90%. For Speed Frame Flyer Rpm 1400 Efficiency 85% & TPI 1.3	7
<b>OR</b>		
	(C) A Comber Machine Running At 450 Nips/Min With Feed/Nip Of 6 Mm. Calculate No Of Comber Required For A 2500 Kg/Shift. Consider Lap Hank Of 0.0125 And Noil % Of 12. Efficiency Of Machine Is 80%	7
<b>Q.3</b>	(A) Discuss Key Routine Maintenance Points For Ring Frame	3
	(B) A Carding Machine Running At 120 Doffer Rpm With 90% Efficiency. Sliver Hank 0.091. Calculate Production In Kg/Day	4
	(C) Prepare Spin Plan And Production Schedule For The 1000kg/Shift Combed Yarn Of 30'S Ne. Consider Suitable Data For A Modern Machine Combination.	7
<b>OR</b>		
<b>Q.3</b>	(A) What Will Be The Hank Deliver On A Lap Former If Sliver Hank Is Of 0.17. Draft And Doubling Are 1.3 & 18 Respectively.	3
	(B) Calculate No Of Rotor Required For The 1000 Kg/Shift Production, If Speed Is 95000 Rpm, T.M. 5.225, Count 10's And Effi. - 90%	4
	(C) Prepare Spin Plan And Production Schedule For The 5000kg/Shift OE Yarn Of 8'S Ne. Consider Suitable Data For A Modern Machine Combination.	7
<b>Q.4</b>	(A) The Length Of Warp On Warpers Beam Is 36000yards And Number Of Ends On Beam Is 420. Net Weight Of Yarn On Beam Is 500lbs, Calculate Count Of Yarn In Ne.	3
	(B) A Set Of 6 Beam Each Containing 30000 Meterof Warp Is To Be Prepared. If Speed Is 500 Mpm & Effi.-80%. Calculate A Time Required To Prepare A Set.	4

- (C) Calculate Number Of Loom And Pirm Winding Machine Required For The Production Of 40000 Yards Of Shirting Fabric/Day. Fabric Particulars:- Tape Length 108 Yards, Finished Length 100 Yards, Reed Space 50", Warp And Weft Count 50'S, PPI 48., Loom Data:- 350 Rpm, Effi-90%, Weft Waste 0.3%., Pirm Winding Data:- Speed 1100YPM, Effi-80% & No Of Spindle 36. 7
- OR**
- Q.4** (A) Discuss Key Routine Maintenance Points For Carding 3
- (B) Calculate No Of Beams Produced On A Sizing Machine In A Shift From The Following Data. Speed 50 Mpm, Effi:- 50%, No Of Ends/Beam 2200, Length Of Warp Sheet/Beam 250 Meter. 4
- (C) It Is Required To Produce 2000 Meter Suiting Fabric Per Day. Fabric Details:- Final Width 152cm, Warp & Weft Count 48'S. Reed Count 56, PPI 52. Calculate Warp & Weft Required Per Day. No of Looms And Preparatory Required Per Day. 7
- Q.5** (A) Calculate Total Number Of Ends And Picks For A Fabric Having Following Details : Reed / Pick – 70/42, Fabric Length – 42000 Meters, Fabric Width – 52 Inches 3
- (B) Prepare Warp And Weft Production Schedules If The Weights Of Warp And Weft Are 40000 Kgs And 30000 Kgs Respectively. Assume Modern Sequence Of Machines. 4
- (C) A Textile Mill Wants To Produce Fabric Of Following Particulars
- Warp/Weft : 16s/16s Ne
- EPI/PPI : 72/44 7
- R.S. : 157 Cm Length Wise Contraction : 7%
- Find Out GSM Of Fabric. Also Work Out Requirement Of Warp And Weft Yarn Per 100 M Of Fabric.(Ignore Selvage And Waste)
- OR**
- Q.5** (A) Discuss Key Routine Maintenance Points For Winding Machine 3
- (B) An Air Jet Loom Running At 850 Rpm For 20 Picks Variety. Calculate Time Required To Weave 2500 Meter Of Fabric On A Loom With 85% Efficiency. 4
- (C) Calculate GSM Of Denim Fabric. Assume Suitable Data. 7

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