

KYC

MANUALE DI ISTRUZIONE INSTRUCTION MANUAL NOTICE D'INSTRUCTION BEDIENUNGSANLEITUNG MANUAL DE INSTRUCCION EL KİTABI 使用手冊 取扱説明書

 POWER MACHINE RUN MACHINE STOP REVOLUTION PULSE INVERTER SPEED KLS STATUS FEEDER STOP SYNCHRO FEEDER BUS WI-Fi CHECK GROUNDING!
KYL





Scope of supply: Design, manufacture and after sales service of yarn and weft feeders, measuring winders, stands, creels and oil systems for textile machinery.

TRADUZIONI DELLE ISTRUZIONI ORIGINALI. TRANSLATION OF THE ORIGINAL INSTRUCTIONS. TRADUCTIONS DES INSTRUCTIONS D'ORIGINE. ÜBERSETZUNG DER ORIGINALANLEITUNGEN. TRADUCCIÓN DE LAS INSTRUCCIONES ORIGINALES. ORJİNAL TALİMATLARIN TERCÜMESİ. 原始使用说明的翻译. L.G.L. Electronics is gratified by your choice and thanks you for the preference.

INSTRUCTION MANUAL

ISSUED BY:

Service Ma'naa

APPROVED BY:

Technical Manager C Lorann

Date: 01/09/2019

Date: 01/09/2019

INDEX

1 1.1 1.2 1.3 1.4	General features Introduction KYC information LED KYC Dip Switches Steps to do to include the KYC in an infrastructure WIEL mode: Ad boc and Soft AP	6 6 7 8 9
1.5		15
2	Connection	14
2.1.1	Get connection with KYC throguh WIFI or LAN	14
2.1.2	Open KnittingGlobal software based upon JAVA	14
2.1	How to establish a connection between KYC and lap top	14
2.2	Create a shortcut to each knitting machine	15
2.3	Erase undesired feeders from visualization	16
3	Parameters	17
3.1	Feeders parameters	17
3.2	Attivo electronic brake settings: Tdes. dgr and tread dgr	20
3.3	List of parameters	22
4	KLS	23
4.1	KLS: automatic output stop motion system	23
4.2	Button for the learning procedure located on the KYC box	25
4.3	OYB SW Tmr	26
4.4	KLS FAST (Default value = 0)	27
4.5	KLSCm Delay (Default value = 86; min=20; max=100)	27
5	Alarms	28
5.1	Feeders alarms	28
6	Configuration	31
6.1	Machine configuration	31
6.2	Opening of an existing configuration	36

INDEX

7	YCM	39
7.1	YCM feature: YARN consumption	39
7.2	YCM table saving	42
7.3	Import the YARN consumption file into open office	43
7.4	Import the YARN consumption file into open office	45
7.5	YCM example	46
7.5.1	Create machine configuration	46
7.5.2	Get yarn consumption information	55
7.6	YARN consumption of belt driven feeders	62
7.6.1	Belt feeder	63
7.6.2	Belt sensor	65
8	Application close	69
8.1	Application close	69

1.1 INTRODUCTION



The KYC is an interface between feeders and lap top.

It is connected to feeders through a communication cable. It has a wireless or a LAN connection with lap top.

The Lap Top is required to have following features:

- 1. Internet Explorer, Chrome or Firefox.
- 2. Wireless or LAN connection.
- 3. JAVA (Free download from JAVA Web Site).

It takes power supply (24VAC - 35VDC) from LGL power box.

1.2 KYC INFORMATION LED

O POWER

- MACHINE RUN
- MACHINE STOP
- REVOLUTION PULSE:
- INVERTER SPEED
- KLS STATUS
- FEEDER STOP
- SYNCHRO
- O FEEDER BUS
- 🔾 WHFI
- CHECK GROUNDING

LED

The KYC device has the following information LED:

- 1. **POWER.** It is simply connected to the 5 Volts logic power supply. It indicates that the KYC is powered up.
- 2. **MACHINE RUN.** When this yellow LED is on, the machine runs. If it is off the machine is standing.
- MACHINE STOP. When this red LED turns on, it means that the KYC sends a stop signal to the machine. Normally this led blinks once when the KYC stops the machine. The led does not stay on because the KYC removes the stop signal, thus permitting the operator to turn the machine.
- 4. **REVOLUTION PULSE.** This yellow LED makes a short lighting when the revolution input sensor is detected (normally once each machine revolution).
- 5. **INVERTER SPEED.** This green LED light is proportional to the INVERTER SPEED (more light means higher inverter speed).
- 6. **KLS STATUS.** This is a bicolor LED: when it is yellow it indicates that KLS function is enabled, if it is red flashing it means that KLS function is disabled.
- 7. **FEEDER STOP**. This red LED indicates one or more feeder is in alarm condition.
- 8. **SYNCHRO**. This yellow LED flashes when the SYNCH output signal is driven (useful for LGL technical service).
- 9. **FEEDER BUS.** This orange LED flashes when there is communication flowing on the feeders bus (485 or CAN bus).
- 10. **Wi-Fi**. This is a bicolor LED : when it is yellow lighted it indicates that Wi-Fi connection is ON. The LED will became orange for a while on each data packet received.
 - when the Wi-Fi interface is in ad-hoc or soft ap mode, the LED will become soon yellow after power-up and it will stay in that state anyway.
 - When the Wi-Fi interface is in infrastructure mode, the LED will become yellow only after that KYC has joined. The Access Point with the configured SSID. If said access point will shut down, the yellow LED will turn off (with a delay of about 8-10 seconds).
- CHECK GROUNDING. This red LED will flash when KYC detects an excessive current flowing into the RS485 ground wire. This normally means that feeders are not correctly grounded.

1.3 KYC DIP SWITCHES

KYC V2 has four DIP-SWITCHES



All DIP-SWITCH settings has effect only on the next device reset or power - up.

DS1

Software Upgrade forcing: when it is in OFF state (default configuration) the application software will start. If it is in ON state, the boot loader will wait indefinitely for the software upgrade and will prevent application software from running until a valid software is loaded.

DS2

Network interface selection: when it is OFF state the Wi-Fi interface is selected and the wired Ethernet is disabled. When it is on, Ethernet interface is enabled and Wi-Fi is disabled.

DS3

Feeder bus selection: when it is in OFF state the communication is enabled on the RS485 BUS only and it is disabled on the CAN BUS. On the opposite, when it is in ON state, the CAN BUS is enabled and RS485 is disabled.

DS4

Default network configuration: when it is in OFF state (default) the network configuration is read from the SD card. When it is in ON state, the network configuration is forced to the following one :

a. KYC has a static ip address of 169.254.0.1

- b. KYC acts as a DHCP server assigning to the DHCP clients a pool from 169.254.0.5 up to 169.254.0.11
- c. For the wireless side, the Wi-Fi mode is forced to be ad hoc and without data encryption; moreover the SSID and the host name are both set to "KYC_DEFAULT"

1.4 STEPS TO DO TO INCLUDE THE KYC IN AN INFRASTRUCTURE

Note: follow this procedure only in case you want to include the KYC in a company network. After you have connected to the KYC (in soft ap mode) with the usual address : 169.254.0.1, you have to select , from the "**File**" menu, the submenu "**Options**" (like below).

Send File to KYC	N 3-1
Option	*
Exit 5	Group

The program asks for a password :



Enter **option1** password and then press **OK** button.

After a while the "Setup Connect" menu will appear like below :

約 Setup Connect	and the second				. D X
ADVANCED					
Wi-Fi Mode:					
Wi-Fi Mode:		Ad hoc			-
Network settings:					
Туре		Static IP			-
IP Address:		169 .	254 .	0	. 1
Subnet Mask:		255	255 .	0	. 0
Gateway:		169	254	0	. 2
DNS:		169	254	0	200
Advanced settings			I	-	1
Hurtanceu aettinga.				11	
Host Name:	NEWKYC000405	MIFS Power (15	
S SID:	NEWKYC000405	WIFI Rate (M		b	-
r Security settings					
• NONE					
	WEP Mode: ope	eñ .	~		
	Key 1 SCF	FF43365	64-bi	9	*
○ WEP	💿 Key z <mark>BCF</mark>	FF43365	64-bi		~
	Servey 1 SCP	FF43365	64-bi	4	*
	🔘 Key d SCF	FFF43365	64-61		*
		WPA Version: Wp3	1		Y
WPA/WPA2		PA Encryption: TKI	P.		~
		Passpringer will	passphrase		
			\sim		
	Save			EXIL	

The fields to be changed are at least the followings :

Wi-fi Mode: you have to change from "Ad Hoc" to "Infrastructure", or from «soft AP» to «infrastructure» (see also pharagraph 1.5).

Type: We recommend to select "Static IP" in order to address each KYC with a fixed address (if you select dynamic addressing you cannot know at priori the IP address).

IP Address: For each KYC you have to set a unique static IP address in order to not create IP conflicts : i.e. Machine Nr. 1 -> 192.168.0.1; Machine Nr. 2 -> 192.168.0.2, etc.

Subnet Mask: ask to the network administrator (usually 255.255.255.0 or 255.255.0.0).

Gateway: this is necessary just if you would like to reach the KYC from outside the local subnet; if you don't know you should ask to the network administrator or set it to : 0.0.0.0 or the router / access point IP address.

DNS server: actually not used (this field is provided for future uses), you can set 0.0.0.0 or the router / access point IP address.

Host Name: this file is the label that appears on the JAVA client upper bar for fast identification : this field should describe the machine where the KYC is installed (i.e. : MachineNr01).

SSID: when the infrastructure mode is selected (like in this case), this field is the SSID of the Access Point that the KYC will use to access the network.

Security Settings: this field select the encryption type and the relative keys.

A configuration example is given below (using WPA-2 Encryption) :

ADVANCED Wi-Fi Mode: Wi-Fi Mode: Wi-Fi Mode: Infrastructure Network settings: Type IP Address: 192 168 1 1 Subnet Mask: 255 255 0 0 0 Gateway: 192 168 1 254 0 Gateway: 192 168 1 254 0 Gateway: 192 168 1 254 0 Gateway: 192 168 1 254 1 Advanced settings:	Setup Connect							3
Wi-Fi Mode: Infrastructure Wi-Fi Mode: Infrastructure Network settings: Static IP IP Address: 192 168 1 1 Subnet Mask: 255 255 0 0 Gateway: 192 168 1 254 DNS: 192 168 1 254 Advanced settings: 192 168 1 254 Advanced settings: 11 15 15 SID: KYCLGLNETSSID 15 15 SSID: KYCLGUNETSSID 15 15 • NONE 0 0 0 0 • WEP Hory 8CFFF43365 64-bit 0 • WEP Hory 8CFFF43365 64-bit 0 • WPA Version: WPA Version: WPA2 WPA Version: WPA2 • WPA WPA2 WPA Encryption: CCMP Passprhase: ee19-8hk-u1uh	ADVANCED							
Wi-Fi Mode: Infrastructure Network settings: Type Type Static IP IP Address: 192 168 1 1 Subnet Mask: 255 255 0 0 Gateway: 192 168 1 254 DNS: 192 168 1 254 Advanced settings: 192 168 1 254 Advanced settings: 11 15 15 Advanced settings: 11 15 15 SID: KYCLGLNETSSID 16 1 254 Super Settings: 0 0 0 0 0 • NONE 0 0 0 0 0 0 • WEP Negritizer Science 04-bit	Wi-Fi Mode:			-				
Network settings: Static IP Type 192 168 1 1 Subnet Mask: 255 255 0 0 Gateway: 192 168 1 254 DNS: 192 168 1 254 DNS: 192 168 1 254 Advanced settings: 192 168 1 254 Advanced settings: 192 168 1 254 Host Name: MachineNr1 Mill Prover (dom) 15 5 SID: KYCLGLNETSSID Will Reine (Mitpos) b 5 SSID: KYCLGLNETSSID Will Reine (Mitpos) b 5 SVEP Key II 8CFFF43365 64-bit 64-bit WEP Key II 8CFFF43365 64-bit 64-bit WPA Version: WPA WPA WPA 64-bit WPA Version: WPA WPA 64-bit 64-bit WPA Version: WPA WPA 94-bit 64-bit WPA Version: WPA WPA </th <th>Wi-Fi Mode:</th> <th></th> <th></th> <th>Infrastructu</th> <th>re</th> <th></th> <th></th> <th>•</th>	Wi-Fi Mode:			Infrastructu	re			•
Type Static IP IP Address: 192 168 1 1 Subnet Mask: 255 255 0 0 Gateway: 192 168 1 254 DNS: 192 168 1 254 Advanced settings: 11 15 15 15 SSID: KYCLGLNETSSID 15 16 1 15 SSID: KYCLGLNETSSID 15 16 1 15 SUPP Keyrill SCFFF43365 04-bit	Network settings:							
IP Address: 192 168 1 1 Subnet Mask: 255 255 0 0 Gateway: 192 168 1 254 DNS: 192 168 1 254 Advanced settings: 192 168 1 254 Advanced settings: 11 15 5 Advanced settings: 11 15 5 SID: KYCLGLNETSSID 15 6 SSID: KYCLGLNETSSID 15 64-bit Security settings: 9CFFF43365 64-bit 64-bit VEP Key 1 8CFFF43365 64-bit 64-bit Key 1 8CFFF43365 64-bit 64-bit 64-bit Key 1 8CFFF43365 64-bit 64-bit 64-bit 64-bit Key 1 8CFFF43365 64-bit	Туре			Static IP				-
Subnet Mask: 255 255 0 0 Gateway: 192 168 1 254 DNS: 192 168 1 254 Advanced settings: 192 168 1 254 Advanced settings: 11 15 5 5 Advanced settings: 15 5 5 5 SSID: KYCLGLNETSSID WF Rate (B10ps) b 5 SSID: KYCLGLNETSSID WF Rate (B10ps) b 5 Security settings: 0 6 64-bit 5 NONE 8CFFF43365 64-bit 64-bit 5 WEP May 2 8CFFF43365 64-bit 64-bit 5 WPA Version: WPA2 WPA Version: WPA2 WPA Version: 9 WPA Version: WPA Encryption: CCMP 7 7 7 WPA NUPA2 WPA Encryption: CCMP 7 7 7 WPA Serrition: 9 9 9 9 9 9 WPA Serion:	IP Address:			192 .	168	. 1	. 1	
Gateway: 192 168 1 254 DNS: 192 168 1 254 Advanced settings: 192 168 1 254 Advanced settings: 192 168 1 254 Host Name: MachineNr1 Viii Power (00m) 15 15 SSID: KYCLGLNETSSID Viii Power (00m) 15 16 Security settings: 0 0000 0 0 0 NONE VIEF Mode: 0000 0	Subnet Mask:			255 .	255	. 0	. 0	
DNS: 192 168 1 254 Advanced settings: Advanced settings: MachineNr1 15 SSID: KYCLGLNETSSID WF Part (dom) Security settings: NONE VVEP Key 2 8CFFF43365 64-bit Key 2 8CFFF4365 64-bit Key	Gateway:			192 .	168	. 1	. 254	
Advanced settings: Host Name: MachineNr1 VII Power (dom): 15 SSID: KYCLGLNETSSID VII Power (dom): b Security settings: NONE VIEP Mode: Open V NONE VIEP Mode: Open V NONE VIEP Mode: Open V SCFFF43305 64-bit Key SCFFF43305 64-bit Key SCFFF43305 64-bit WPA Version: Wpa2 WPA Version: Wpa2 VVEP Passprhase: ee19-8hk-u1uh	DNS:			192 .	168	. 1	254	
MachineNr1 MachineNr1 MachineNr1 SSID: KYCLGLNETSSID MachineNr1 15 SSID: KYCLGLNETSSID MachineNr1 b Security settings: MachineNr1 b NONE SCFFF43365 64-bit WEP Koy 1 SCFFF43365 64-bit Koy 1 SCFFF43365 64-bit Koy 2 SCFFF43365 64-bit Koy 3 SCFFF43365 64-bit Koy 4 SCFFF43365 64-bit WPA Version: WPA2 WPA Lencryption: CCMP Passprhase: ee19-8hlx-u1uh	Advanced settings:-				1			
Host Name: MachineNr1 VII Power (dom) 15 SSID: KYCLGLNETSSID VIF Rate (Mbpe) b Security settings: NONE NONE VIEP Mode: open Key 1 SCFFF43365 Key 2 SCFFF43365 Key 2 SCFFF43365 Key 3 SCFFF43365 Key 3 SCFFF43365 Key 3 SCFFF43365 Key 4 S						11		-
SSID: KYCLGLNETSSID WE Rate (Filippe) b Security settings: NONE VICE Mode: open • Key 1 8CFFF43365 • WEP • Key 2 8CFFF43365 • Key 3 8CFFF43365 • G4-bit • Key 3 8CFFF43365 • G4-bit • Key 4 8CFFF43365 • G4-bit • WPA Version: WPA2 WPA Version: CCMP Passprhase: ee19-8hlx-u1uh	Host Name:	MachineNr1		Will Power (15		*
Security settings: NONE VIEP Key BCFFF43365 Key BCFFF436 Key BCFFF436 Key BCFFF436 Key BCFFF436 Key BCFFF436 Key BCFFF436 Key BCFFF436 Key BCFFF436 Key BCFFF436 Key BCFFF436 Key BCFFF436 Key BCFFF436 Key BCFFF436 Key BCFFF436 Key BCFFF43 Key BCFFF43 Key BCFFF43 Key BCFFF43 Key BCFFF43 Key BCFFF43 Key BCFFF43 Key BCFFF43 Key BCFFF43 Key BCFFF43	S SID:	KYCLGLNETSS	SID	WiFi Rate (M	bpis]:	b		•
NONE VICE Mode: open VICE Mode: o	Security settings:							
WEP Key 1 8CFFF43365 G4-bit Key 3 8CFFF43365 G4-bit Key 3 8CFFF43365 G4-bit Key 4 8CFFF43365 G4-bit WPA Version: wpa2 WPA Version: wpa2 WPA A Encryption: CCMP Passprhase: ee19-8hlx-u1uh	NONE							
WEP Keyr 8CFFF43365 64-bit Keyr 8CFFF43365 64-bit Keyr 8CFFF43365 64-bit Keyr 8CFFF43365 64-bit WPA Version: wpa2 WPA Version: CCMP Passprhase: ee19-8hlx-u1uh		WEP Mode:	ореп		~			
WEP		• Key 1	8CFFF43	365	64	-bit		*
Key 3 8CFFF43365 64-bit Key 4 8CFFF43365 64-bit WPA Version: wpa2 WPA Version: CCMP Passprhase: ee19-8hlx-u1uh	○ WEP	🗢 Кау 2	8CFFF43	365	64	-bit		~
Koy 4 2CFFF43365 64-bit WPA Version: wpa2 WPA WPA2 WPA Encryption: CCMP Passprhase: ee19-8hlx-u1uh		🗢 Key S	8CFFF43	365	64	-bit		-
WPA Version: wpa2 WPA WPA2 WPA Encryption: CCMP Passprhase: ee19-8hlx-u1uh		🗢 Kay 4	8CFFF43	365	64	-bit		7
WPA/WPA2 WPA Encryption: CCMP Passprhase: ee19-8hlx-u1uh			WPA	Version: wpa	2			-
Passprhase: ee19-8hlx-u1uh	WPA/WPA2		WPA En	cryption: CCM	IP			-
			Pass	sprhase: ee1	9-8hlx-u1ul	1		
Save 💥 Exit	F	Save			\$	Exit		

To save the changed configuration, press the **Save** button: the KYC will reboot itself and will try to use the new settings.

If you have any problems in the configuration (i.e. : inserted the wrong SSID) there is always the possibility to revert the KYC to the std. soft ap connection by putting the DS4 dip switch ON on the KYC device: you can then reconnect in sof ap mode and write the correct configuration (before pressing **Save** remember to put DS4 to OFF position otherwise the KYC will reboot in soft ap mode anyway...).

1.5 WIFI MODE: AD HOC AND SOFT AP

Following the procedure described at point 1.3, there is the possibility to have access to the "setup connect" menu.

In this menu the voice **WI-FI Mode** deserves a bit of attention, because the first KYC devices sold in the market were set "**Ad Hoc**" by default, while the most recent pieces are set "**Soft AP**". This change is due to the fact that "**Ad Hoc**" mode is no more supported by Windows (starting from Windows8 on).

On the contrary "**Soft AP**" mode works with Windows XP, Windows7, Windows8 and Windows10.

If you can't connect WI-FI to the KYC device, one of the reasons could be that you are using windows 8 or windows 10 and the KYC device is set "Ad Hoc". In this case we suggest to connect through LAN and change this parameter.

2.1 HOW TO ESTABLISH A CONNECTION BETWEEN KYC AND LAP TOP

2.1.1 Get connection with KYC throguh WIFI or LAN

WI-FI

If the netbook is provided by LGL, click on "LGL Connect" icon, located on the desktop. The machine and the KYC box must be switched on.

If the netbook/Laptop is not provided by LGL, follow the procedure below: Open "net connections" Click on the button "refresh network list" The lap top will search for available nets. After a little while, one of the found nets will be "LGL KYCOOXX". Press the CONNECT button. After some seconds the writing "connected" will appear.

LAN

Connect the LAN cable located in the KYC package between KYC and PC. The communication will be established after a little while.

2.1.2 Open KnittingGlobal software based upon JAVA

A. Double click on **KnittingGlobaleExe_10.0XX.jar**: the following picture appears:



- B. Press Settings Set IP address. Insert the address of the KYC (169.254.0.1 in the example of the picture).
- C. Click on OK. The software will automatically close the program and re start it. When the program restarts, you are connected to the KYC device. Top of the screen the KYC address and its name (NEWKYC00601 in teh example) appear.

2 - CONNECTION

LGL KNITTIN	IG 10.04 @169.2 evel Settings	254.0.1 NEWKYC	00601@			
₩ ₩ ₩, \$ \$\$ 22 *						
All Feeders Group YCM						
¥ 1	2	¥ 3	₩ 4	¥ 5		
RELEASE	RELEASE	RELEASE	RELEASE	R		
CMX2028	CMX2028	CMX2028	CMX2028	CA		
ALARMS ALARMS		ALARMS	ALARMS	A		

Note: The first double click on the KnittingGlobaleExe_10.XX.jar file automatically creates a LGL FILES folder on the PC under local disc.

We suggest to copy the .jar file into the LGL FILES folder and create a shortcut on the desktop. It is possible to create a shortcut for each knitting machine, as it is explained in the following pharagraph.

2.2 CREATE A SHORTCUT TO EACH KNITTING MACHINE

Available from software global knitting 10.18 onwards

- 1. Copy KnittingGlobaleExe_10.18.jar into LGL_Files folder
- 2. Create a shortcut on the desktop
- 3. Open shortcut properties



4. In the "Target" tab ("Destinazione" in Italian) add the IP address of the KYC: Here in the below example we add SPACE 192.168.1.2

Tipo:	Executable Jar File			
Percorso:	Connect_cfg			
Destinazione: hect_cfg\KnittingGlobaleExe_10.18.jar 192.168.1.2				
Da:	C:\LGL_Files\Connect_cfg			
Tasti di scelta rapida:	Nessuno			
Esegui:	Finestra normale \vee			
Commento:				
Apri perco	rso file Cambia icona Avanzate			
	Ν			

5. At the end rename the short cut on the desktop with the machine name.

2.3 ERASE UNDESIRED FEEDERS FROM VISUALIZATION

Select feeders that do not have to be shown, then press icon:



3 - PARAMETERS

3.1 FEEDERS PARAMETERS

Press GROUP ALL.

LGL 6.00 @1 File Feeder L	92.168.0.95 Deb evel Settings	ug_Luka@					
ĦĦ44°, \$\$\$ \$\$ \$\$ \$> \$> <							
All Feeders	Group All YCM						
120 COMP120	2 121 COMP121	¥ 122 COMP122	2 123 COMP123	2 124 COMPT	M 125 CO	MP125	
Select Pan meter	Select Parameter	Select Parameter	Select Parameter	Butt	on for	ameter S	
			-	nieters			
Select Paran	Select Parat COMP120: Feeder label			V 138 Select Paramet	er Select Par	ameter. S	
Select Parameter	Select Parameter	Select Parameter	Select Parameter	A	rea where alue of	e the	
V 148 Select Parameter	V 149 Select Parameter	V 150 Select Parameter		th p: w	the selected parameter will be written		
seener.	see .						

Click on one of the two **SELECT PARAMETER** buttons. A parameter list will appear:

🛓 Paramet 🛛	_		×
T des. dgr			-
T read dgr			
OYB SW Tmr			
EN OFF Stp			=
ENBrkOpAlr			
KLS Fast			-
KLSCmDelay			
RotS/Z Src			
D-4 0/7			-
Single			
⊖ Change on all fee	ders o	f the sam	e type
VIEW F	PARAM	ETER	
	EXIT		

Note: The list will be displayed only if there are selected feeders.

3 - PARAMETERS

120 COMP120	121 COMP121	
T des. dgr	T des. dgr	
Selected ter	Not selectes	

Feeder	Feeder
selected	not selected

Click on the parameter which you would like to see and click on "view parameter" (in the picture Tdes. Dgr).

Note: there is the option to select "single" or "change on all feeders of the same type". "single": the desired parameter will be shown only for one feeder.

"change on all feeders of the same type" means that the desired parameter will be shown for all connected feeders (if all connected feeders are of the same model).

In the example,	the parameter v	will be shown	as in the f	following picture:
-----------------	-----------------	---------------	-------------	--------------------

🕌 LGL KNITTI	🛓 LGL KNITTING 10.46 Java Bit: 32 @169.254.0.1 NEWKYC000260@												
File Settings 10.48 Java Bit 32													
All Feeders	All Feeders Group All YCM												
▼ 1 COMP1 ▼ 2 COMP2 ▼ 3 COMP3 ▼ 4 COMP4 ▼ 5 COMP5 ▼ 6 COMP6													
T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr								
28	24	28	18	28	24								
T read dgr	T read dgr	T read dgr	T read dgr	T read dgr	T read dgr								
28	24	27	19	28	24								
✓ 18 COMP18	✓ 19 COMP19	20 COMP20	21 COMP21	22 COMP22	23 COMP23								
T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr								
24	28	24	28	24	28								
T read dgr	T read dgr	T read dgr	T read dgr	T read dgr	T read dgr								
25	28	24	28	24	28								

The parameter "Tdes. Dgr" has been displayed and the value is 28 (which means 2,8 grams). Since there are parameters that may change in time, the system keeps reading the parameter in real time until the operator does not click on STOP.

It is possible to display two parameters together and, by clicking on RUNNING, the two parameters are read in real time. In the previous picture "Tdes dgr" and "Tread dgr" are displayed together and read in real time.

T des. dgr is a read/write parameter, and it is written in white. Read/write means that it is possible to read the parameter value but also to set a desired value. T read dgr is a read only parameter, and it is written in grey. Read only means that it is only possible to read the actual value of the parameter.

In order to set a Tdes.dgr desired value, the new value must be typed into the white tab and press **ENTER**.

The new value will be sent to all selected feeders of the same model.

If the operator wants to set a new value only for one specific feeder, he has to deselect all the other feeders of the same model.



To select all feeders, click on icon:



To deselect all feeders, click on icon:



3.2 ATTIVO ELECTRONIC BRAKE SETTINGS: TDES. DGR AND TREAD DGR



It is possible to read actual yarn tension and to program the desired tension on each feeder.

불 Paramet	_		×
T des. dgr			
T read dgr			
OYB SW Tmr			
EN OFF Stp			=
ENBrkOpAlr			
KLS Fast			_
KLSCmDelay			
RotS/Z Src			-
⊖ Single	c	- 6 Al-	
Change on all t	reeders	of the sam	е туре
	W PARAN	METER	
	EXIT		

For example in the following picture the KYC is reading Tread dgr and Tdes dgr. These parameters are written in the feeder square because they have been selected form the list (shown in the previous picture). The system is in continuous reading mode (green bar running at the bottom and green line surrounding the screen). The value of the parameters are shown in real time.

3 - PARAMETERS

😹 lgl knitti	LIGL KNITTING 10.46 Java Bit: 32 @ 169.254.0.1 NEWKYC000260@ X														-	×
File Settings	1 State 1 State 1 State	28.539 () (134											
	HILH MOUNT AND AND AND AND AND AND AND AND AND AND															
P 1 COMP1	and a second and a second a s															
28 T read dgr	24 T read dgr	28 T read dpr	18 T read dgr	28 T read dgr	24 T read dgr	28 T read ógr	24 T read dgr	28 T read dgr	24 T read dgr	28 T read dgr	24 T read dgr	28 T read dgr	24 T read dgr	28 T read dgr	18 T read dpr	28 T read ógr
28	24	27 ¥ 20 COM/P20	19 21 COM/21	28 22 COMP22	24	28	24 v 25 COMP25	29 × 26 COM/26	24	27 v 25 COM/25	24 ¥ 29 COM/P29	28 20 COMP30	24	28 ¥ 32 COMP32	18	27 ¥ 34 COMP34
T des. dgr 24	T des. dgr 28	T des. dgr 24	T des. dgr 28	T des. dgr 24	T des. dgr 28	T des. dgr 24	T des. dgr 28	T des. dgr 24	T des. dgr 28	T des. dgr 18	T des. dgr 28	T des. dgr 24	T des. dgr 28	T des. dgr 24	T des. dgr 28	T des. dgr 24
25	28	24	28	24	28	24	28	23	28	18	29	23	28	23	28	24
T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr
T read dgr 28	T read dgr 24	T read dgr 28	T read dgr 24	T read dgr 27	T read dgr 18	T read dgr 27	T read dgr 26	T read dgr 28	T read dgr 24	T read dgr 29	T read dgr 24	T read dgr 28	T read dgr 23	T read dgr 28	T read dgr 23	T read dgr 28
T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dpr	T des. dgr	T des. dgr	T des. dgr	F 42 COMP12 T des. dgr	T des. dpr	T des. dgr				
18 T read dgr 18	28 T read ógr 29	24 T read dgr 22	28 T read dgr 29	24 T read dgr 24	28 T read dgr 28	24 T read ógr 24	28 T read dgr 28	24 T read dgr 74	28 T read dgr 28	24 T read dgr 24	28 T read dgr 28	18 T read dgr 18	28 T read dgr 29	24 T read dgr 24	28 T read dpr 28	24 T read dgr 24
T das dar	To COMPTO	V 74 COMP71	V 72 COMP72	TS COMPTS	V 74 COMP74	T des der	V 76 COMP76	V 11 COMP11	The COMPTS	79 COMP73	V 80 COMP80	V 81 COMPST	V 82 COMP92	V 83 COMP83	V M COMPM	
28 T read dgr	24 T read dgr	28 T read dgr	24 T read dgr	28 T read dgr	24 T read dgr	28 T read dgr	18 T read dgr	28 T read dgr	24 T read dgr	28 T read dgr	24 T read dgr	28 T read dgr	24 T read dgr	28 T read dgr	24 T read dgr	
28	26	28	24	28	24	28	18	28	24	28	24	29	24	28	25	
										STOP	O STATUS				1011	

The continuous reading mode can be stopped any time by pressing STOP. See following picture.

😹 LGL KNITTI	NG 10.46 Jav	a Bit: 32 @169	254.0.1 NEW	<pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre></pre> <pre< th=""><th></th><th></th><th></th><th></th><th></th><th></th><th></th><th></th><th></th><th></th><th></th><th>×</th></pre<>												×
File Settings	10 46 Jane 81			10 x 10		N										
All Feeders																
T des. dgr 28	T des. dgr 24	T des. dgr 28	T des. dgr 18	T des. dgr 28	T des. dgr 24	T des. dgr 28	T des. dgr 24	T des. dgr 28	T des. dgr 24	T des. dgr 28	T des. dgr 24	T desk. dgr 28	T des. dgr 24	T des. dgr 28	T des. dgr 18	T des. dgr 28
T read dgr 28	T read dgr 23	T read dgr 28	T read dgr 18	T read dgr 28	T read dgr 24	T read dgr 28	T read dgr 25	T read dgr 28	T read dgr 24	T read dgr 28	T read dgr 24	T read dgr 28	T read dgr 24	T read dgr 28	T read dgr 18	T read dgr 28
T des, dat	T des. dar	V 20 COMP20 T des, dor	V 21 COMP21	Tides, dat	V 23 COMP23 T des. der	V 24 COMP24	T des, dat	ZE COMP2E Tides, dar	V 27 COMP27 T des, dor	V 28 COMP28	29 COMP29 Tides, dat	✓ 30 COMP30 Tides, dcr	V 31 COMP31	V 32 COMP32 T des, dar	Tides, dar	V 34 COMP34
24 T read dgr	28 T read dgr	24 T read dar	28 T read dgr	24 T read dor	28 T read dgr	24 T read dar	28 T read dgr	24 T read dgr	28 T read dar	18 T read dar	28 T read dgr	24 T read dgr	28 T read dar	24 T read dpr	28 T read dgr	24 T read dar
26	28	24	28	24	28	24	28	23	28	18	28	23	28	24	28	24
T des. dgr	T des. dgr 24	T des. dgr 28	T des. dgr	T des. dgr	T des. dgr	T des. égr 28	T des. dgr 24	T des. dgr 28	T des. dgr 24	T des. dgr	T des. dgr 24	T des. dgr 28	T des. dgr	T des. dgr	T des. dgr 24	T des. dgr
T read dgr 28	T read dgr 24	T read dgr 28	T read dgr 24	T read dgr 28	T read dgr 18	T read dgr 27	T read dgr 28	T read dgr 28	T read dgr 25	T read dgr 29	T read dgr 24	T read dgr 28	T read dgr 23	T read dgr 28	T read égr 23	T read dgr 28
V 52 COMPS2	V 53 COM/93	V 54 COMP54	V 55 COMP55	V 56 COM/55	V 57 COMP57	✓ 55 COMP58	V 50 COMPSS	V SE COMPE	V 61 COMPST	V 62 COMP62	T due day	V 64 COMP64	¥ 65 COMP65	V 65 COMPES	The dec	V 68 COMP68
18 T read dor	28 T read dor	24 T read dar	28 T read dor	24 T read dor	28 T read dar	24 T read dar	28 T read dor	24 T read dor	28 T read dar	24 T read dor	28 T read dor	18 T read dar	28 T read dar	24 T read dor	28 T read dor	24 T read dar
18	29	22	29	24	28	24	29	24	28	24	28	18	29	24	28	24
T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	T des. dgr	
T read dgr 28	T read tigr 25	T read dgr 28	T read dgr 24	T read dgr 28	T read dgr 24	T read dgr 29	T read dgr 18	T read tigr 28	T read dgr 24	T read dgr 29	T read dgr 24	T read tigr 29	T read dgr 23	T read dgr 28	T read dgr 25	
								O RUNN	NG	 STOP 	STATUS		e Pa	ge	1 of 1	8.9

In this picture the system is standing and the screen shows the last read numbers.

Tdes.dgr is written in white (read/write parameter, 2.8g for first feeder, 2.4g for second feeder and so on).

T read dgr is written in grey (read only parameter, 2.8g for first feeder, 2.3g for second feeder and so on.

3.3 LIST OF PARAMETERS

Tdes dgr (read/write):

This is the desired tension in tens of grams.

Tread dgr (read only):

It is the actual tension read from the load cell of the ATTIVO (in tens of grams).

ENBrkOPAlr (read/write):

if it is = 1, when the ATTIVO brake is completely open (open with the pertinent button on located on the ATTIVO support) the feeder send an alarm and the machine cannot start. If it is =0, when the ATTIVO brake is completely open the feeder does not send any alarm and the machine starts.

EN OFF Stp (read/write):

if it is =1, when one feeder is switched off, it sends an alarm to the machine and the machine cannot start.

If it is =0, no alarm is sent and the machine will start.

Following parameters are available on the ECOMPACT from software ECM2012, on the ECO-POWER from ECO2018:

RotS/Z Src (read/write):

RotS/Z Src = 1 the sense of rotation is set by DS1 on the feeder RotS/Z Src =0 the sense of ratation is set by paramter RotS/Z

RotS/Z (read/write):

RotS/Z=1 S rotation RotS/Z=0 Z rotation **Note:** if RotS/Z src=1, RotS/Z loses any meaning.

SensFtcSrc (read/write):

SensFtcSrc=1 sensitivity of the feeder optical sensors is set by DS2 on the feeder SensFtcSrc=0 sensitivity of the feeder optical sensors is set by parameter SensFtc

SensFtc (read/write):

SensFtc=1 standard sensitivity (yarn count > 40Den) SensFtc=0 high sensitivity for very fine yarns Note: if SensFtc src=1, SensFtc loses any meaning.

See next chapter for KLS parameters **OYB SW Tmr, KLSfast** and **KLSCmDelay.**

4.1 KLS: AUTOMATIC OUTPUT STOP MOTION SYSTEM

KLS system allows the feeder to stop the machine without using a sensor, in case of an output yarn break event. If the yarn gets broken between the feeder and the machine, the feeder will be able to detect the event and stop the machine.

Note: if the yarn gets broken before the feeder (between the bobbin and the feeder), this system is not involved. There is another sensor on the feeder itself detecting this case.

Press icon:



Setting KLS Value	<u>- 🗆 ×</u>
KLS DELAY:	Read actual value
MACHINE STATUS	Read actual value
Machine Status	KLS Status
GREEN BUTTON	Read actual value
Enabling COMMAND:(Machine must be sto	pp 🔽
Note: Press enter on yo	ur keyboard to send a new value
	💥 EXIT

1. **KLS DELAY:** èit is possible to read the present value with "read actual value" button and it is possible to write the desired value in the white space. The suggested value is 3. Write 3 and press **ENTER**.

2. **MACHINE STATUS:** (read only) by pressing READ ACTUAL VALUE button, the information about the machine status is shown. In the following picture the machine is standing and the KLS system is active.



3. GREEN BUTTON. ENABLING: there is the possibility to enable or disable the green button that is located on the KYC box (look at the previous picture). If the green button on the KYC box is disabled, the operator can press it as much as he wants, but nothing will happen. COMMAND (machine must be stopped): it is possible to disable KLS function or to send feeders in auto tuning procedure. This is the learning procedure described in paragraph 4.1.



The filter time is related to the machine acceleration phase. Select the filter time according to the duration of the machine acceleration ramp. Usually number 3 is OK (It means 3 seconds).

4.2 BUTTON FOR THE LEARNING PROCEDURE LOCATED ON THE KYC BOX



Once the installation is finished and the machine is ready to start, perform the following learning procedure:

- Press the button for the learning procedure until all feeders lights turn on (approximately 1s). Feeders will keep their lights on while the machine stands.
- 2. Start up the machine with working speed. All lights turn off.
- 3. Run the machine until the end of the pattern.
- 4. At the end of the pattern stop the machine.

When the machine stops, the feeders store the timing in their memory. Now the feeders are ready to check yarn breaks between feeder and machine.

Note 1: The machine has to run for at least 8 seconds. If for any reason the machine stops earlier than 8 seconds, re start the machine. If the machine runs for more than 8 seconds, but it stops before the end of the pattern, feeders will be ready to check output yarn breaks. In any case if you get false stops, repeat the procedure being sure that the machine completes one full pattern.

Note 2: during the procedure, feeders are not able to detect output yarn breaks.

Note 3: by pressing the button for the learning procedure, all feeders lights turn on. If at this moment the button is pressed a second time, all feeders lights turn off and the system is no more active.

4 - KLS

4.3 OYB SW TMR

LGL Connect 5.15 LastConfilcu File Feeder Level Settings 5	15			X
File Feeder Level Settings All Feeders Group All YCM V 7 Setect Parameta ? Setect Parameta? ? Setect Parameta? ?	Parameters Selection Neg_primo I des.dgr FN off Stp Nog_centro EN off Stp Nog_centro ENBrKopair OYB SW Tim Weg_utimo Single All Same Feeders VIEW PARAMETER			
	EXIT			Selection ALL NONE
		O RUNNING	🔿 STATUS 🛛 😽 Page	e 1 of 1 ≫

This parameter can be intended as a test parameter for KLS system. During running, if the operator increases machine speed, the value of this parameter should decrease. If the operator decreases the machine speed, its value should increase.

If OYB SW Tmr=0, then the output stop motion system is not active and feeders won't stop the machine if the yarn gets broken after the feeder.

In this case two LED on the KYC box will blink once per second.



Press the green button for learning procedure as it is described in paragraph 4.1.

4.4 KLS FAST (DEFAULT VALUE = 0)

Compact from SW CMX0040 CMX2014 If this parameter is set to 1, the KLS response time is 40% faster. Note: in case of false stops during production, KLS FAST must be set to 0.

4.5 KLSCM DELAY (DEFAULT VALUE = 86; MIN=20; MAX=100)

Compact from SW CMX0065 CMX2028 Ecompact from SW ECM0001 ECM2001 Ecopower from SW ECO0011 ECO2012

This parameter modifies the KLS response time. If, in case of yarn break at the output side of the feeder, the machine stops late, it is possible to decrease this value to make the machine stop earlier. If the value is set too low you may have false stops. We suggest to make some tests to find the correct value for each pattern.

Note: from softwares mentioned above KLSFAST is no more active, it has been replaced by KLSCmDelay. KLSFAST can be still present in the parameters list but setting it to 0 r to 1 does not bring to any result.

5 - ALARMS

5.1 FEEDERS ALARMS

By clicking on the **ALARMS** button located on each feeder square, it is possible to ask feeders about their status. If a feeder has its lights ON or blinking, it means the feeder is in alarm condition. At the same time the feeder is sending an information about the alarm.

LGL 6.10 216	9.254.0.1 NEW_K	YC000039@											
All Feeders	Group All YC	м											
P I RELEASE VXL0055 ALARNAS SWHTH DEF P LLASE P XL0017 ALARNAS SWHTH DEF	RELEASE VXL0055 ALARMS Settin OFF	P 3 RELEASE VLL0055 ALARMS OK	RELEASE CMX0055 ALARMS Builtion DEF	P 9 RELEASE ECO0006 ALARNS Bord Sh CKE	RELEASE CMX0055 ALARMS SAHSH CEFE	RELEASE CMX0055 ALARMS OK	RELEASE VXL0055 ALARMS Sector DFF	PI 3 RELEASE PKL0017 ALARMS Switch: OFF					
					e Stop	CTATIC	Parie	1.011					

STATUS TAB located at the bottom of the screen: alarm monitoring in continuous mode. This feature is necessary if the computer is far from the machine, in order to be able to have information on possible alarms without being at the machine. In case an alarm takes place while the machine is running and the STATUS tab is selected, the feeder will stop the machine and a big writing will come out on the display as in the following picture:

NACHINE STATUS				
Fee	der	n°:	Status:	
	1		Switch OFF	
	2		Switch OFF	
	4		Switch OFF	
	5		Switch OFF	
	6		Switch OFF	
	8		Switch OFF	

In case feeders are OK, nothing will be shown on the display. Here below a list of the possible alarms:

ALARM	MEANING	ACTIONS
AC PWRFAIL	Phase number 2 (blue) and / or phase number 3 (yellow) are missing.	Check input voltage and feeder connection on the flat cable.
YARN BREAK	Yarn broken before the feeder.	Repair the yarn.
MOTOR LOCK	Yarn entangled somewhere between the bobbin and the feeder.	Check yarn passage between bobbin and feeder.
HIGH TEMPERATURE	Too high temperature on the feeder electronic.	 Reduce input tension on the yarn. Check that the flywheel turn freely. In case disassemble spool body and remove dust and/or yarn residual.
TIME ERROR	The feeder takes too much time to wind up the yarn on the spool body at the start up.	Stop the yarn on the spool body with one finger to help yarn reserve filling procedure.
VB MOT FAIL	DC voltage on the motor too low.	Check connections on the power transformer primary voltage winding.
AC1PWRFAIL	Phase number 1 (black) is missing.	Check input voltage and feeder connection on the flat cable.
SWITCH OFF	ON OFF switch in position OFF.	Switch ON the feeder (see also EN OFF STP parameter page pagina 22).
TENSMTRERR	The feeder can't reach the preset tension value within a preset time (see also TensTMOut parameter page pagina 22).	 Check the following: 1. The yarn is passing on the load cell. 2. The TWM brake and springs are suitable to reach the desired tension. 3. OFFSET of the load cell.
OYB ERROR	Yarn broken after the feeder (or yarn consumption too low).	Repair the yarn.

5 - ALARMS

ALARM	MEANING	ACTIONS
ELBRK OPEN	Brake open (ATTIVO).	Close it by pressing the related button located on the ATTIVO blck support.
PREWINDERR	Only during winding up phase of the spool body, during the start up or after a yarn break.	It tells that during spool body filling up, the machine cannot run.
I2T ERROR	I2T protection.	 Reduce input tension on the yarn. Check that the flywheel turn freely. In case disassemble spool body and remove dust and/or yarn residual.

6 - CONFIGURATION

6.1 MACHINE CONFIGURATION

It is possible to create different feeders groups and work on each group separately.

For example if the operator has to set 2grams tension on feeder number 1, number 5, number 9 and so on, it may be easier to create one group with feeder 1, feeder5, feeder9 ...

The system allows to have on the screen only this specific group and set parameters which are valid only for this group.

Press icon NEW GROUPS CONFIGURATION





Press "**NEXT**"



This screen will appear for each group that is requested to be created. In this exaple three groups will be created, and each group needs a name.

We suggest to use the name of the yarn which is processed on the feeders belonging to the group.

6 - CONFIGURATION

🌆 Groi	p Creation																	-	×
								-	Group name: No Group	-	8	×							
🗆 1 Geoup:	EC02017	🗆 2 Groute	EC02017	🗆 3 Group:	EC02017	🗆 4 Group:	EC02017	Groups	EC02017	🗆 6 Group:	EC02017	🗆 7 Group:	EC02017	🗆 8 Group:	EC02017	Cuante D a	EC02017	🗌 10 Group:	EC02017
🗆 99 Group:	EC02017	Group:	EC02017	in 13 Group:	EC02017	Group:	EC02017	🗆 15 Groupe	EC02017	🗆 16 Group:	EC02017	Group:	EC02617	in sa Group:	EC02017	Group:	EC02017	a 20 Group:	EC02017
21 Caronape	EC02017	22 Groups	ECO2017	23 Group:	EC02017	24 Group:	ECO2017	25 Groups	EC02017	26 Group:	EC02017	27 Group:	EC02017	28 Group:	EC02017	29 Group:	EC02017	i 30 Group:	EC02017
an an Group:	ECO2017	Groups	EC02017	Group:	EC02017	Group:	EC02017	a 35 Groups	EC02017	38 Group:	EC02017	🗌 37 Group:	EC02017	Group:	EC02017	Groute	EC02017	ato Group:	EC02017
as Group:	EC02017	Group:	EC02017	🗆 43 Group:	EC02017	Group:	EC02017	as Groups	EC02017	🗌 46 Group:	EC02017	Group:	EC02017	Group:	EC02017	Groupe	EC02017	Group:	EC02017
Group:	EC02017	Groupe	EC02017	Group:	EC02017	Group:	EC02017	Croupe	EC02017	Group:	EC02017	Group:	EC02017	Group:	EC02017	Groupe	EC02017	Group:	EC02017
al 61 Group:	ECM2008	Group:	ECM2808	Grosp:	ECM2008	Group:	ECM2008	Groups	ECM2008	Croup:	ECM2008	Groep:	ECM2018	Group:	ECM2008	Groupe	ECM2008	Grosp:	ECM2018
075 Groups	ECM2808	C 72 Groups	ECM2608	i 73 Group:	ECM2008	Group:	ECM2008	Croups	ECM2003	🗌 76 Group:	ECM2008	Group:	ECM2016	aroup:	ECN2008	Group:	ECM2608	Group:	ECM2038
an Group:	ECM2008	Groups	ECM2808	Group:	ECM2008	Croup:	ECM2008	1											

실 Grou	p Creation													
								-	Group name: front	•	8 ×			
1	EC02017	2	EC02017	₽ 3	ECO2017	4	ECO2017	<u>s</u>	ECO2017	6	EC02017	1	ECO2017	3
Group:	front	Group:		Group	front	Group:		Group:		Group:		Group:		Group:
11	EC02017	12	EC02017	13	ECO2017	14	ECO2017	15	ECO2017	16	EC02017	17	ECO2017	18

On top of the screen there is the name of the group (front in this case) and the operator has the possibility to choose the feeders he wants to associate to the group. He can insert just the single repatition. In this case feeder 1 and feeder 3 have been associated to "front" goup. Then pass to the next group by means of the arrow.



By following commands the operator can move back and forth among the groups:



🏄 Grou	p Creation																	-	
								-	Group name: back2		8 X								
E 1 Grosp:	ECO2017 front	Group:	EC02017 back1	ing a	ECO2017 front	el 4 Group:	ECO2017 Deck2	5 Groupe	EC02017	Grosp:	EC02017	Trosp:	EC02017	a Sroup:	EC02017	Groups	EC02017	Groupe	EC02017
11	EC02017	12	EC02017	1 1	EC02017	54	EC02017	15	EC02017	16	EC02017	17	EC02017	10	EC02017		EC02017	20	EC02017
Group:		Group:		Group:		Groups		Group:		Groupe		Group:		Group:		Group:		Groupe	
21	EC02017	22	EC02017	23	EC02017	24	EC02017	25	EC02017	26	EC02017	27	EC02017	28	EC02017	29	EC02017		EC02017
Group:		Group:		Group:		Groups		Groupe		Group:		Group:		Group:		Greups		Groupe	
31	EC02017	32	EC02017		EC02017	П н	EC02017	35	EC02017	38	EC02017	37	EC02017		EC02017	23	EC02017	40	EC02017
Group:		Group:		Groups		Group:		Groute		Grospi		Group:		Group:		Group:		Groute	
41	EC02017	42	EC02017	43	EC02017	44	EC02017	45	EC02017	- 46	EC02017	47	EC02017	- 45	EC02017	- 43	EC02017	1 50	EC02017
Group:		Group:		Group:		Groups		Groupe		Grosp:		Group:		Group:		Groupe		Groupe	
51	EC02017	6 2	EC02017	63	EC02017	54	EC02017	55	EC02017	56	EC02017	67	EC02017	50	EC02017	59	EC02017	60	EC02017
Group:		Group:		Group:		Стомрс		Groups		Grosp:		Groep:		Group:		Group:		Groupe	
61	ECM2008	62	ECM2008	85	ECM2008	64	ECM2		ECM2108		ECM2008	67	ECM2018		ECM2018	0 69	ECM2068	11	ECM2003
Group:		Group:		Groups		Group:		Groupe		Grostc		Groep:		Group:		Groups		Groupe	
71	ECM2008	<u>n</u>	ECM2008	C 73	ECM2008	74	ECM2008	15	ECM2008	76	ECM2008		ECM2008	76	ECM2018	n	ECM2008	0	ECM2008
Group:		Group:		Group:		Groups		Groups		Group:		Group:		Group:		Group:		Groupe	
E1	ECM2008	12	ECM2008	(18)	ECM2008	84	ECM2008	1											
Group:		Group:		Groups		Groups													

The next picture shows all groups associated in one single repetition.

Now press **REPEAT** icon:



🔬 Gro	up Creation																	-	
								٠	Group name: back2	-	S 🕺								
1	EC02017	1 2 2	EC02017	23	EC02017	1	EC02017	5	EC02017	6	EC02017	1	EC02017	•	EC02017		EC02017	10	EC02017
Groep:	front	Groep:	back1	Group:	front	Group:	Dack2	Group:	front	Group:	backt	Groupe	front	Group	beck2	Groups	front	Grosp	back1
11	EC02017	10	EC02017	15	EC02017	14	EC02017	15	EC02017	16	EC02017	11	EC02017	11	EC02017	19	EC02017	120	EC02017
Group:	front	Group	back?	Group:	front	Group:	back1	Group:	front	Group	nacs?	Groupe	front	Groupe	back1	Groups	front	Group	teck2
21	EC02017	22	EC02017	23	EC02017	26	EC02017	25	EC02047	28	EC02017	27	EC02017	28	EC02017	29	EC02017	10	EC02017
Group:	front	Group:	back1	Group:	front	Group:	DACKŽ	Group:	front	Group:	back1	Group:	front	Group	oaca2	Group:	front	Group:	back1
31	EC02017	12	EC02017	33	EC02017	34	EC02017	35	EC02017	- *	EC02017	37	EC02017	38	EC02017	39	EC02017	- 40	EC02017
Grosp:	front	Group	back2	Group:	front	Group:	back1	Group:	front	Group	hack2	Group:	front	Groups	beck1	Groups	front	Groups	back2
41	EC02017	42	EC02017	45	EC02017	- ++	ECO2017	45	EC02017	45	EC02017	-47	EC02017	- 46	EC02017	-10	EC02017	50	EC02017
Group:	front	Group:	back1	Group:	front	Group:	back2	Group:	front	Group:	back1	Groups	front	Group	back2	Groups	front	Grostc	back5
51	EC02017	- 52	ECO2017	□ ω	EC02017	54	EC02017	55	EC02017		1002017	57	EC02017	58	EC02017	59	EC02017	160	EC02017
Group:	front	Groep	back2	Group:	front	Group:	back1	Group:	front	Group	back2	Group:	front	Group:	backt	Group	front	Group	beck2
61	ECW5008	- 62	ECW5000	63	ECM2008	64	FC112018	65	ECH2018	66	ECM2000	67	ECN2008	- 64	1 CM2008	69	ECW5108	20	ECM5103
Grosp:	front	Group:	back1	Group:	front	Group:	back2	Group:	front	Greep:	back1	Groupe	front	Group	back2	Groups	front	Grospi	back1
271	ECM2008	12	ECM2008	73	ECM2008	24	EC112018	275	ECM2018	100	ECM2068	$\Box n$	ECM2008	28	ECM2008	275	ECM2008	- 46	ECM2808
Group:	front	Grosp	back2	Group:	front	Group:	back1	Group:	front	Group:	back2	Group:	front	Groupe	beck1	Group:	front	Group	back2
a 1	ECM2008	52	ECM2008	0 83	ECM2008	- 54	EC412018												
Groups	front	Groep:	back1	Group:	front	Group:	back2												

The single repetition will be copied on all the other feeders, so that each feeder will be associated to the correct group.

Press icon:



6 - CONFIGURATION



Press OK.

Now groups have been created and they are loaded in teh program. By clicking **VIEW GROUPS** icon:



A drop down menu will appear and the operator will be able to load one group at a time and work with it.

<u>s</u> —	×
No Group	
No Group	
Group All	
front	
back1	
back2	

The machine configuration made by the groups and the corresponding parameters (the parameters located in the user table) can be saved in a file.

Press icon SAVE CONFIGURATION

top left of the main page:



6 - CONFIGURATION

LGL Connect 5.15 LastConfile File Feeder Level Settings	×
All Feeders Group YCM	Please choose a directory:
RELEASE	FD Save in Desktop 🕑 🗇 💬 🛄 -
	Outer Iteratiss Tersimetro Tens su cella Recent Hisses LGA/LEBOCK V.C Onderson Computer V.C Deteco Cella di acino Attivo V.C Deteco Felensentic V.C Deteco Software do tostare Software do tostare Software do tostare Software do tostare V.C File name: pippdimac X Save Save Save
	File Configuration:LastConficu ALL Groups Modify ALL NONE
	SAVE EXIT

🍰 Informat	ion		
Successfully	r Created		\$
	ок	Exit	

Please note that the name of the configuration (in this case pippo.mac) will appear top left of the screen, near the LGL connect release writing.

6.2 OPENING OF AN EXISTING CONFIGURATION

Many different machine configurations can be created depending upon different patterns. These configuration can be saved and re loaded anytime.

In order to open an existing configuration, press icon:



Choose the .mac desired file (here 4 feeders.mac) and press **OPEN**.



The follwing screen appears:


6 - CONFIGURATION

Press OK to load the configuration with its parameters. The parameters of the user table will be written in each feeder (different parameters for each different group of feeders).

Press CANCEL to load the configuration without paramtieters.

In this case the parameters will have to be set by the operator, if different from the ones already in the feeders before opening the configuration. We suggest to check them.

The configuration name 4 feeders.mac will appear top left in the screen.

LGL 6.10 off	LGL 6.10 p169.254.0.1 NEW_KYC000039p.4 feeders.mac														
N															
All Feeders	eeders Group YCM														
Y 1 RELEASE VXL0055 ALARMS VXL005 RELEASE PXL0017 ALARMS	♥ 2 RELEASE VXLOD55 ALARMS	V 3 RELASE VXL0055 ALARMS	Y A RELEASE CMX0055 ALARMS	V 5 RELEASE ECO0006 ALARMS	I♥ 6 RELEASE CMX0055 ALARMS	V 7 RELEASE CMX0055 ALARMS	V 8 RELEASE VXL0055 ALARMS	♥ 9 RELEASE PXL0017 ALARMS							
				O RLIN	• STOP	O STATUS	Page	1 of 1							

Click on VIEW GROUPS icon:



6 - CONFIGURATION

LGL 6.10 @169.254.0.1 NEW_KYC000039@-4 (cede	ers.mac													
i∎∎41°. © > :::: 8 % > .														
All Feeders Group All YCM														
T des. dgr Select Group View Select Paramete. poly poly	V 4 COMP4 T des. dgr 80 Nect Paramet	V 5 ECOPS T des. dgr 40 Select Paramet	COMP6 T des. dgr 100 Select Paramet	T des. dgr 40 Select Paramet	V 8 VECT8 T des. dgr 40 Select Paramet	Select Paramet Select Paramet								
Select Paramet Select Paramet Group All														
		RUNN	ING • STOP	STATUS	Page	1 of 1								

A drop down menu shows the groups list. Choose the group to be displayed and press **VIEW GROUP**.

All feeders of the selected group will be displayed on the screen. Feeders belonging to other groups will not be displayed on the screen. In order to display other feeders, other groups must be selected. Only one group at a time will be displayed.

7.1 YCM FEATURE: YARN CONSUMPTION

Press YCM tab. The following picture will appear:

LGL 6	.10 @169.254.0 eeder Level	.1 NEW_KYCOOO	0039@····												
i g															
	All Feeders	Group All	YCM												
100	⊻ 1 Typ: Count: cm: g: cm/100 nl:	⊻ 2 Typ: Count: cm: g: cm/100 nl:	year S Typ: Count: cm: g: cm/100 nl:	✓ 4 Typ: Count: cm: g: cm/100 nl:	year S Typ: Count: cm: g: cm/100 nl:	6 Typ: Count: cm: g: cm/100 nl:	✓ 7 Typ: Count: cm: g: cm/100 nl:	✓ 8 Typ: Count: cm: g: cm/100 nl:	y s Typ: Count: cm: g: cm/100 nl:						
ROUND	≥ 10 Typ: Count: cm: g: cm/100 nl:														
OF Repeat															
						0.000	CTATIC	Dana	1.441						
					O RUNNING	• STOP	O STATUS	Page	1 of 1 >>						

On the screen select the feeders from which the yarn consumption information is required.

If you want YCM with weight calculation click on icon:



VCM Yam Feeder Settings		Select yarn from a previously created database. Information will be reported on the drop down menù
YARN TYPE:		If you want create new yarn: - Insert the yarn name
YARN COUNT: YARN COUNT UNIT:	dTex	- Insert yarn count - Insert count unit n/100 nt: cm/100 nt: c
ADD Yam to DB Press ADD to add a yarn to database	Press Remove to cancel a yarn from database	159 Typ: vunt: n: Press to send this setting N/1 to celected feeders for
ESC	SEND TO SELECTED FEEDERS	YCM calculation

Info : 1 (g) = 0.0022046341(lb)

Press the icon:





Press "**OK**" button.

The arrow on the main screen becomes green (System enabled).



Press green arrow. If you want a continuous calculation, select "**Repeat**"



On the main screen the following information is given in real time:



When calculation is over, "OK" string will appear.

Then the yarn consumption will be displayed on the screen for each selected feeder.

Note: if the continuous calculation mode is required, the operator must check the REPEAT tab. This function allows an automatic repeat of the calculation for the next revolutions, until the check is removed or the STOP button is pressed.

At the end of the YCM calculation, it is possible to display the fabric composition by pressing icon:



It is possible to save the yarn consumption information on a file, and then convert this file in a Microsoft excel file or Open office one.

Once the yarn consumption information have been collected, click on icon:



7.2 YCM TABLE SAVING

Yarn consumption table saving.

It is possible to save the yarn consumption in one file and convert it to EXCEL. Once the reading process is over, press save button in the circle.



A .lbd file will be saved in the desired folder.



By pressing button (available from Globalknitting version 10.25), it is possible to save many yarn consumption files automatically one after the other.

For example if one pattern is 5000 revolution long and the machine knits 3 patterns, it is possible to save each 5000 revolution pattern in a separate file.

In the end the system will monitor 15000 revolution by creating three separate files, each one with the information about each single pattern. This function is useful to monitor yarn consumption on the long run in order to calculate yarn stock correctly:



	Press fo destinat	r selected tion folder	Count: cm:	المعنى والمعني والمعنى والمعنى والمعنى والمعنى والمعنى والمعنى والمعنى والمعنى والمعنى والمعنى والمعنى والمعنى والمعنى والمعنى والمعنى والمعنى والمعنى والمعنى والمعني والمعني والمعني والمعني والمعني والمعني والمعني والمعني والمعني والمعني والمعني والمعني والمعني والمعني والمعني والمعني والمعني والمعني والم والمعني والمعني وا والمعني والمعني وال والمعني والمعني r>والمعني والمعني والمعني والمعني والمع والمعني والمع		
nl: Cm p: VCM Continuou Browse directory Directory Selected: File Name:	v/100 nl: us Save C:LGI ycm	L_Files	Count: cm: g:	-		
	saving : uT i: v/100 nl:	ст: g: ст/100 nl;	Selected enabl funcion	d for e ality	Icm/100 nt:	Aprī Annulla

Each .ldb file will be saved adding date and time to the chosen file name.

7.3 IMPORT THE YARN CONSUMPTION FILE INTO OPEN OFFICE

Open "Excel", from "File" menu, choose "open" Select the file to be loaded.

Apri											?	\mathbf{X}
Cerca in:	C Temp		• •	- 🗈	0	×	Ľ	•	Strumenti -	•		
Gronologia	Test_VC											_
- 🏠 Document:												
Desktop												
Profecki												
Risorse di rete	Nome file:	Tr cri i Sla				_	_	*	Ø	} (Apri	Ŀ

In "file type" select "all files".

The Text Wizard has determined that your data is Delmited. If this is correct, choose Next, or choose the data type that best describes your data. Original data type Choose the file type that best describes your data:	ext Import Wizard	I - Step 1 of 3		8 23
If this is correct, choose Next, or choose the data type that best describes your data. Original data type Choose the file type that best describes your data: Delimited Characters such as commas or tabs separate each field. Fixed width Fields are aligned in columns with spaces between each field. Start import at row: File grigin: File grigin: 437: OEM United States Preview of file C:\Users\harrell\Desktop\YCM Reports For SQL\our_37685 (8044) 20140325 1641.ldb. Start import at row: File grigin: File grigin: Griginal data type 	he Text Wizard has	s determined that your data is De	limited.	
Original data type Choose the file type that best describes your data:	f this is correct, cho	ose Next, or choose the data ty	pe that best describes your data.	
Choose the file type that best describes your data:	Original data type			
Delimited - Characters such as commas or tabs separate each field. Fixed width - Fields are aligned in columns with spaces between each field. tart import at row: 1 File grigin: 437 : OEM United States Preview of file C: Users \harrell\Desktop\YCM Reports For SQL\our_37685 (8044) 20140325 1641.ldb. 1 2 Report Yarn Consumption 3 4 Revolution: 5 5	Choose the file typ	pe that best describes your data:	Lange and the second second	
○ Fixed width - Fields are aligned in columns with spaces between each field. tart import at row: 1	Opelimited	- Characters such as commas	or tabs separate each field.	
Start import at row: 1 💮 File grigin: 437 : OEM United States Preview of file C: Users \harrell\Desktop\YCM Reports For SQL\our_37685 (8044) 20140325 1641.kdb. 1 < FileName>37685 (8044) 20140325 1641 /FileName 2 Report Yarn Consumption 3 4 Revolution:5 5	Fixed width	 Fields are aligned in columns 	with spaces between each field.	
Start import at [ow: 1				
Preview of file C:\Users\harrell\Desktop\YCM Reports For SQL\our_37685 (8044) 20140325 1641.kdb. 1 <filename>37685 (8044) 20140325 1641</filename> 2 <pre>Report Yarn Consumtpion</pre> 3 4 4 5	start import at row:	1 🗧 File origin:	437 : OEM United States	-
s ·	Preview of file C+V	leare/barrell/Dackton/VOM Dano	the End SCI July 27685 (8044) 20140225	1641 Hb
	Preview of file C:\ 1 <filename> 2 Report Yar: 3</filename>	Users\harrell'Desktop\YCM Repor 37685 (8044) 20140325 1 3 Consumtpion	rts For SQL\our_37685 (8044) 20140325 641	1641.ldb.
4	Preview of file C:\ 1 <filename> 2 Report Yarr 4 Revolution 5</filename>	Users\harrell\Desktop\YCM Repor 87685 (8044) 20140325 1 9 Consumtpion 15	rts For SQL\our_37685 (8044) 20140325 641	1641.ldb.
	Preview of file C:\ 1 <filename>: 2 Report Yar: 4 Revolution 5 <</filename>	Users\harrell\Desktop\YCM Repor 87685 (8044) 20140325 1 9 Consumtpion 15	rts For SQL\our_37685 (8044) 20140325 641	1641.ldb.
Cancel < Back Next > Einish	Preview of file C:\ 1 <filename> 2 Report Yar: 3 Revolution 5 <</filename>	Users\harrell\Desktop\YCM Repor 87685 (8044) 20140325 1 h Consumtpion :5	rts For SQL\our_37685 (8044) 20140325 641	1641.ldb.

Press "Open" and upper picture will appear Press "NEXT".

Text Import Wizar	d - Step 2 of 3				8 3
This screen lets you below.	i set the delimiters you	ir data contains.	You can see how you	r text is affected in	the preview
Delmiters Iab Semicolon Comma Space Qther: Data preview	Treet consecu Text gualifier:	utive delimiters as	one V		
<filename>37 Report Yarn Revolution:5</filename>	685 (8044) 2014 Consumtpion	0325 1641 <td>ileName></td> <td></td> <td>î.</td>	ileName>		î.
+					•
		Cancel	< <u>B</u> ack	Next >	Einish

Put a mark on "comma" Press "**END**". You will get as a result a file like the one displayed at the end of chapter 7.5.

7.4 IMPORT THE YARN CONSUMPTION FILE INTO OPEN OFFICE

Press "calc" program. For "FILE" menu choose "**OPEN**" Select the file to be loaded Press "**OPEN**".

Picture below will appear:

porta						- 0	OF
Tigo di carattere	Europa occider	ntale (Window	vs-1252/WinL	atin 1 💌		L.	UK
Lingua (Predefinita - Ita	iliano (Italia)				l	Annulla
Dalla <u>r</u> iga	1					(2
zioni di sillabazione							
🗇 Larghezza fissa							
Separato							
Tabulazione	Virgol	a	Altri				
🔄 Punto e virgola	Spazio	,				_	
🔄 Raggruppa į separa	tori di campo		Separ. <u>d</u> i te	sto	•	•	
va oprioni						-	
III Compostro virgolatto d	amaterta						
Campo na virgoiene c	ome testo						
Individua <u>n</u> umeri spec	iali						
mpi							
Tipo colonna		Y					
				Grandard	Standa		
Standard	Standard	Standard	Standard	stanuaru			
Standard 1 Date: 0:53:14 P.1	Standard	Standard	Standard	Standard			
Standard 1 Date: 0:53:14 P.1 2 Revolution	Standard M. 3	Standard	Standard	standard			
Standard 1 Date: 0:53:14 P.M 2 Revolution 3 Needless	Standard M. 3 1111	Standard	Standard	Standard			
Standard 1 Date: 0:53:14 P.M 2 Revolution 3 Needless 4 Consumption	Standard 5 1111 0.0	Standard	Standard	Storidard			
Standard 1 Date: 0:55:14 P.M 2 Revolution 3 Needless 4 Consumption 5 Consumption	Standard M. 3 1111 0.0 0.0	Standard g cm	Standard	Storidord			
Standard 1 Date: 0:53:14 P.1 2 Revolution 3 Needless 4 Consumption 5 Consumption 6 Classe Merceolog	Standard M. 3 1111 0.0 0.0 ica	Standard g cm.	Standard	Scenderu			
Standard 1 Date: 0:53:14 P.1 2 Revolution 3 Needless 4 Consumption 5 Consumption 6 Classe Merceolog: 7 56 New	Standard 3 1111 0.0 0.0 ica Polipro	Standard g cm NaN	Standard	Stellagia			

Select "separation" and put a mark on "Comma". Press "OK".

7.5 YCM EXAMPLE

We will get yarn consumption information from a pattern made by one front yarn and two back yarns with a repetition once every four feeders.

Feeder 1 and feeder3 process the front yarn, feeder2 back yarn1 and feeder4 back yarn2. We assume front yarn is a polyester 75dTex, back yarn1 is a nylon 156dtex and back yarn2 is a cotton Ne5. The following procedure explains how to insert the information in the KYC system and how to get the desired results.

7.5.1 Create machine configuration

This operation allows to:

- a. Create groups of feeders feeding the same yarn
- b. Associate yarn type and count to each group

Click on **CREATE GROUPS CONFIGURATION** icon:



Choose the number of groups you want. 3 in this case.



See chapter 7.5 for belt feeder yarn consumption

Give a name to each group of feeders. Normally each group processes one yarn.



At the end press **NEXT**.

up Creation												
							er Gr	oup name: No Group	•		×	
ECO2017	Croup:	ECO2017	Group:	EC02017	Group:	ECO2017	Group:	ECO2017	Group:	EC02017	🗆 7 Group:	EC02017
ECO2017	12 Group:	ECO2017	13 Group:	ECO2017	14 Group:	ECO2017	Group:	ECO2017	Group:	EC02017	Group:	EC02017
EC02017	C 22 Group:	ECO2017	23 Group:	EC02017	24 Group:	ECO2017	25 Group:	ECO2017	26 Group:	EC02017	27 Group:	EC02017
ECO2017	Group:	ECO2017	Group:	EC02017	Group:	EC02017	Group:	ECO2017	Group:	EC02017	Group:	EC02017
ECO2017	Group:	ECO2017	Group:	ECO2017	Group:	ECO2017	Group:	ECO2017	Group:	ECO2017	Group:	EC02017
EC02017	Group:	ECO2017	Group:	EC02017	Group:	ECO2017	Group:	ECO2017	Group:	EC02017	Group:	ECO2017
	Ip Creation EC02017 EC02017 EC02017 EC02017 EC02017 EC02017 EC02017 EC02017	pp Creation EC02017 2 EC02017 12 EC02017 122 EC02017 122 EC02017 132 EC02017 132 EC02017 142 EC02017 132 EC02017 142 EC02017 142 EC02017 142 EC02017 142 EC02017 142 EC02017 142	ECO2017 2 ECO2017 ECO2017 12 ECO2017 Group: 12 ECO2017 ECO2017 12 ECO2017 Group: 12 ECO2017 ECO2017 22 ECO2017 Group: 12 ECO2017 ECO2017 32 ECO2017 Group: 132 ECO2017 ECO2017 142 ECO2017 Broup: ECO2017 Broup:	Image: point of the second of the s	ECO2017 2 ECO2017 3 ECO2017 ECO2017 12 ECO2017 13 ECO2017 ECO2017 14 ECO2017 14 ECO2017 ECO2017 12 ECO2017 14 ECO2017 ECO2017 12 ECO2017 14 ECO2017 ECO2017 122 ECO2017 14 ECO2017 ECO2017 122 ECO2017 13 ECO2017 ECO2017 122 ECO2017 13 ECO2017 ECO2017 122 ECO2017 13 ECO2017 ECO2017 124 ECO2017 14 ECO2017 ECO2017 144 ECO2017 144 ECO2017 ECO2017 17 144 ECO2017 144 ECO2017 ECO2017 144 ECO2017 144 ECO2017 144 ECO2017 ECO2017 145 ECO2017 145 ECO2017 144 ECO2017	Image: properties of the second sec	ECO2017 2 ECO2017 3 ECO2017 4 ECO2017 ECO2017 12 ECO2017 13 ECO2017 14 ECO2017 ECO2017 13 ECO2017 14 ECO2017 144 ECO2017 ECO2017 122 ECO2017 13 ECO2017 144 ECO2017 ECO2017 122 ECO2017 135 ECO2017 144 ECO2017 ECO2017 132 ECO2017 135 ECO2017 144 ECO2017 ECO2017 144 ECO2017 143 ECO2017 0roug: Croug: ECO2017 144 ECO2017 0roug: 0roug: Croug: ECO2017 ECO2017 144 ECO2017 0roug: 0roug: 0roug: ECO2017 ECO2017 145 ECO2017 0roug: 0roug: 0roug: 0roug:	Image: Projection Image: Projection	Image: Provide and the second secon	Image: Problem Cooperation EC02017 2 EC02017 3 EC02017 4 EC02017 6 Group: 6 EC02017 6 Group: 6 Group:	Up Creation ECO2017 2 ECO2017 3 ECO2017 4 ECO2017 5 ECO2017 6 6 ECO2017 6 6 ECO2017 6 6 ECO2017 6 6 6 6 6 6 6	Image: Problem Constrained Constrained <thconstrained< th=""> Constrained <thconstrained< th=""> <thconstrained< th=""></thconstrained<></thconstrained<></thconstrained<>

In order to select first group FRONT, move with arrow:



If needed, go back with arrow:



Select feeder number 1 and feeder number 3, as it is shown in the next picture. it is important to select the feeders belonging to the first single repetition.

🕌 Gro	up Creation											
								*	Group name: front	-	3 ¥	2
₽ 1 Group:	ECO2017 front	🗆 2 Group:	ECO2017	₽ 3 Group	ECO2017 front	Group:	ECO2017	Group:	ECO2017	Group:	ECO2017	Grou
🗌 11 Group:	ECO2017	12 Group:	ECO2017	🗋 13 Group:	ECO2017	Group:	ECO2017	Group:	ECO2017	Group:	ECO2017	Grou

Pass to the second group $\mathsf{BACK}\ 1$ and then to the third group $\mathsf{BACK2}$ and do the same thing with each one.

😹 Grou	o Creation																	-		×
								*	Group name: back2		8 🗙									
≥ 1	EC02017	2	EC02017	No.	EC02017	el i	EC02017	<u>s</u>	EC02017	0 6	EC02017	1	EC02017	.	EC02017		EC02017	10	EC0201	1
Group:	front	Group:	back1	Groupe	front	Group	back/	Group:		Group:		Group:		Groups		Group:		Group:		
11	EC02017	12	EC02017	. 13	EC02017	11	EC02017	15	EC02017	16	EC02017	17	EC02017	18	EC02017	19	EC02017	20	EC0201	,
Group:		Group:		Groups		Group:		Groupe		Group:		Group:		Groups		Group:		Group:		
. H	EC02017	22	EC02017	23	EC02017	24	EC02017	25	EC02017	26	EC02017	21	EC02017	28	EC02017	29	EC02017	30	EC0201	7
Group:		Group:		Group:		Group:		Group:		Group:		Group:		Groupe		Group:		Group:		

Press **REPEAT** icon



🔬 Gro	up Creation																	-	
								٠	Group name: back2	-	1 🖸 🗙								
21	EC02017	2 2	EC02017	F 3	EC02017	1 2 +	EC02017	□ 6	EC02017	- 6	EC02017	□ 7	EC02017	- 8	EC02017	3	EC02017	10	EC02017
Groups	front	Groute	back1	Grospi	front	Group.	Dack2	Groups	front	Groute	beck1	Grospi	front	Group	DACKS	Groups	front	Groupe	back1
. 55	EC02017	10	EC02017	13	EC02017	14	EC02017	15	EC02017	154	EC02017	17	EC02017	10	EC02017	19	EC02017	- 20	LC02017
Groups	front	Group	back2	Group:	front	Group:	back1	Groups	front	Group	teck)	Groupe	front	Group:	back1	Group:	front	Group	tock2
21	EC02017	22	EC02017	23	EC02017	24	EC02017	25	EC02017	28	EC02017	20	EC02017	18	EC02017	29	EC02017	10	EC02017
Group:	front	Group:	back1	Group:	front	üreup:	back2	Слокорс	front	Groups	back1	Group:	front	Group:	nack2	Group	front	Groupe	backt
31	EC02017	32	EC02017	32	EC02017	34	EC02017	35	EC02017	- 28	EC02017	37	EC02017	38	EC02017	22	EC02017		EC02017
Groups	front	Group	back2	Grospi	front	Group:	back1	Geoupt	front	Group	back?	Groupe	front	Group:	back1	Group:	front	Group	back2
41	EC02017	42	EC02017	43	EC02017	44	EC02017	45	EC02017	46	EC02017	47	EC02017		EC02017	49	EC02017	60	EC02017
Groups	front	Group:	back1	Group:	front	Group:	beck2	Greeapc	front	Groupe	back1	Group:	front	Group:	beck2	Groups	front	Groups	back1
61	EC02017	- 52	ECO2017	63	EC02017	54	EC02017	55	EC02017	- 55	ECO2017	1 67	EC02017	58	EC02017	59	EC02017	- 60	EC02017
Groups	front	Group	back2	Groute	front	Greup:	back1	Geoepe	front	Group	back?	Grospe	front	Group:	back1	Group:	front	Gitage	back7
61	ECM2008	0	ECM2108	0	ECM2008	64	EC112010	65	ECM2008	66	ECM2003	0	ECM2008	68	EC02008	0	ECM2008	70	ECM2603
Group:	front	Group:	back1	Group:	front	Group:	back2	Groups	front	Groupe	back1	Groupe	front	Group:	back2	Groupe	front	Groupe	back1
275	ECM2008	12	ECM2008	73	ECM2008	74	EC142058	75	EC1/2008	1.6	ECM2108	$\square n$	ECW5008	78	ECM2008	279	ECM2008	- 40	ECW5008
Group:	front	Group	back2	Group:	front	Group:	back1	Слонарс	front	Group	back2	Group:	front	Group:	back1	Сесир	front	Group	back2
0 81	ECM2008	42	ECM2008	83	ECM2008	84	ECM2008												
Groups	front	Groupe	beck1	Grospi	front	Group:	back2												



Each feeder has been associated to its group.



Press OK.

Now the groups are complete.



By clicking on icon the following drop down menu appears, with each group:



By clicking on the drop down arrow all groups are viewed

🛓 Select Group View		×
back1		-
front		
back1	50	
back2	-0	
Group All		

By choosing one group, for example FRONT, only feeders belonging to FRONT will be displayed on the screen (all the odd numbers).

Then pass to YCM tab and click on button.





Here we can insert yarn type and count for each group of feeders.

Section Settings	
SELECT YARN FROM DATABASE:	-polyester-75 dTex
YARN TYPE:	polyester
YARN COUNT:	75
YARN COUNT UNIT:	dTex
ADD Yarn to DB	REMOVE Yarn from DB
ESC	SEND TO SELECTED FEEDERS

The operator can write YARN TYPE and YARN COUNT and he can select YARN COUNT UNIT from the available units.

Then he can add the yarn to the database:



in order to have it available for future use, and at the end he has to click on:



To send the yarn to all feeders of the FRONT group.

The beolw picture shows the result, with FRONT group and its yarn loaded.

LGL I File Fe	A KNITTING 10.04 (2169.254.0.1 NEWKYC00601)													
ing P														
	All Feeders f	front YCM												
	1 Typ: polyester	3 Typ: polyester	S Typ: polyester	7 Typ: polyester	9 Typ: polyester	11 Type polyeste	✓ 13 Type polyeste	15 Typ: polyeste	17 Typ: polyeste	19 Typ: polyeste	21 Typc polyeste	23 Typ: polyeste	26 Typ: polyeste	27 Typ: polyeste
	Count: 75 d lex	count: 75 d l ex	count: 75 diex	Count: 75 diex	Count: 75 diex	Count: 75 diex cm:	count: 75 diex	count: 75 diex	Count: 75 diex	Count: 75 diex.	Count: 75 d l ex. cm:	count: 75 d l ex cm:	count: 75 diex	Count: 75 d lex
	g:	g:	g:	g:	g:	9:	g:	g:	g:	g:	9:	g:	g:	F
	2 31 (f) control (
	2 37 (projected 2 11) (
	Q:	c μ μ μ μ μ μ μ μ μ μ μ μ μ μ μ μ μ μ μ												
85	Ent/160 at Ent/160 at													
	2 37 Type content (2 11 Type project) 2 13 Type content (2 13 Type content) 2 13 Type content (2 13 Type con													
LE	- contr. 7- 0149													
Spec.	Europe Europe Europe Europe Europe Europe Europe Europe Europe Europe Europe Europe Europe Europe Europe Europe													
\$.03	chieros ne	chier room.	cha loo nic	CHIFFOO RE	Childon	CHU TOO TIL	cita roo ne	CHIEFOO IIK	CONTOORE	CHIPTOO IL	CHUING IL	cho roo ne	CITE TOO IIC	CITE TOO INC
ROUND														
OF														
Repeat														

Click on **VIEW GROUPS** icon and select another group.



Repeat the operation for BACK1 and BACK2.



🛓 LGL File Fe	KNITTING 10.0 Beder Level	04 @169.254.0.1 Settings	NEWKYC0060	L@	
ing (*	4 🐴 🗞			***	
	All Feeders	back1 YCM			
	2 Typ: Count: cm: g:	G Typ: Count: cm: g:	2 10 Typ: Count: cm: g:	i 14 Typ: Count: cm: g:	Count: cm: g:
	cm/100 nl:	cm/100 nl:	cm/100 nl:	cm/100 nl:	cm/100 n
	🛃 YCM Yarn	Feeder Settings		_	
	SELECT YARN FR	IOM DATABASE:	-nylon- 156 dTe	3X	-
80					00 n
LEL	YARN TYPE:		nylon		
1	YARN COUNT:		156		
ROUND	YARN COUNT UN	T:	dTex		-
OF		ADD Yarn to DB		MOVE Yarn from I	ов
Repeat					
		ESC	SEND	TO SELECTED FEE	DERS

& LGL File F	KNITTING 10.04 eeder Level S	0169.254.0.1 ettings	NEWKYC00601	<u>@</u>										_ 🗆 X
-9 ľ		() 🗧 🕄		:0 🎾 🖄										
	All Feeders	back1 YCM												
	2 Typ: nylon Count: 156 dTex cm: g: cm/100 nt	Count: 156 dTex Count: 156 dTex Cm: g: cm/100 nl:	Count: 156 dTex cm: g: cm/100 nt	V 14 Typ: nylon Count: 156 dTex Cm: g: cm/100 nl:	 18 Typ: nylon Count: 156 dTex cm: cm:100 nt: 	22 Typ: nylon Count: 156 dTex Cm: g: cm/100 nt:	26 Typ: nylon Count: 156 dTex cm: g: cm/100 nt:	Count: 156 dTex Count: 156 dTex Cm: g: cm:100 nt:	✓ 34 Typ: nylon Count: 156 dTex Cm: g: cm/100 nl:	38 Typ: nylon Count: 156 dTex cm: g: cm1100 nt	 ✓ 42 Typ: nyton Count: 156 dTex Cm: g: cm/100 nl: 	e Typ: nylon Count: 156 dTex cm: g: cm:100 nt	So Typ: nyto Count: 156 dTe cm: 0: cm/100 nl:	n 12 54 Typ: nyion 5x Count: 156 dTex cm: 9: cm/100 nt
	Count: 156 dTex crin: g:	Count: 156 dTex cm: g:	Count: 156 dTex cm: g:	70 Typ: nylon Count: 156 dTex cm: g:	V 74 Typ: nylon Count: 156 dTex cm: 9:	✓ 78 Typ: nylon Count: 156 dTex cm: g;	🖌 82 Typ: nylon Count: 156 dTex cm: g:							
	cm/100 nt:	cm/100 nl:	cm/100 nt	cm/100 nl:	cm/100 nt	cm/100 nl:	cm/100 nl:	I			BA	ACK1		
۲														

File Fe														
	All Feeders	back2 YCM												
	✓ 4 Typ: cotton Count: 5 Nec cm: g: cm/100 nl:	P STyp:cotton Count:5 Nec cm: g: cm/100 nt:	Y 12 Typ: cotton Count: 5 Nec cm: g: cm/100 nt:	Y 18 Typ: cotton Count: 5 Nec cm: g: cm/100 nl:	20 Typ: cotton Count: 5 Nec cm: g: cm/100 nit	24 Typ: cotton Count: 5 Nec cm: g: cm/100 nt:	28 Typ: cotton Count: 5 Nec cm: g: cm/100 nl:	2 32 Typ: cotton Count: 5 Nec cm: g: cm/100 nl:	IF 38 Typ: cotton Count: 5 Nec cm: g: cm/100 nt	40 Typ: cotton Count: 5 Nec cm: g: cm:100 nt:	44 Typ: cotton Count: 5 Nec cm: g: cm:100 nl:	V 48 Typ: cotton Count: 5 Nec cm: g: cm/100 nt:	✓ 52 Typ: cotto Count: 5 Nec cm: g: cm/100 nl;	n 🖉 50 Typ: cotton Count: 5 Nec cm: g: cm:100 nl:
	el 60 Typ: cotton Count: 5 Nec cm: 3: cm/100 nl:	el Typ: cotton Courit: 5 Nec cm: g: cmi100 nt:	(*) 68 Type cotton Count: 5 Nec cm: 0: cm/100 nt:	Y 72 Typ: cotton Count: 5 Nec cm: 2: cm/100 nl:	V 76 Typ: cotton Count: 5 Nec cm: 5: cm/100 si:	(e) 80 Type cotton Count: 5 Nec cm: 0: cm/100 nt					BA	ACK2		

When all groups have got their yarn, select **GROUP ALL**, to have the feeders all at once on the screen



In the YCM tab each feeder is displayed with its own yarn.

LGL I	. KNITTING 10.04 @169.254.0.1 NEWKYC006010													
ing P														
	All Feeders Group All YCM													
	✓ 1 Typ: polyester Count: 75 dTex cm: g: cm/100 nt:	2 Typ: nylon Count: 155 dTex cm: g; cm/100 nt:	STyp: polyester Count: 75 dTex cm: g: cm/100 nt:	A Typ: cotton Count: 5 Nec cm: g: cm/100 nt:	Y 5 Typ: polyester Count: 75 dTex cm: g: cm/100 nt:		Typ: polyester Count: 75 dTex cm: g: cm/100 nt:	eric SType cotton Count: 5 Nec cm: g: cm/100 nt:	P 9 Typ: polyester Count: 75 dTex cm: g: cm/100 nt:	≥ 10 Typ: nylon Count: 156 dTex cm: g: cm/100 n1:	In Typ: polyeste Count: 75 dTex cmc g: cm/100 nl:	2 12 Typ: cotton Count: 5 Nec cm: g: cm/100 nt:	13 Typ: polyeste Count: 75 dTex cm: g: cm/100 nl:	t4 Typ: nylon Count: 156 dTex cm: g: cm/100 nt:
	✓ 15 Typ: polyeste Count: 75 dTex cm: g: cm/100 nt:	V 16 Typ: cotton Count: 5 Nec cm: g: cm/100 nt:	✓ 17 Typ: polyeste Count: 75 dTex cm: g: cmi100 nl:	18 Typ: sylon Count: 156 dTex cm: g: cm/100 nt:	Y 19 Typ: polyeste Count: 75 dTex cm: g: cm/100 nt:	20 Typ: cotton Count: 5 Nec cm: g: cm/100 nt:	21 Typ: polyeste Count: 75 dTex cm: g: cm/100 nl:	22 Typ: nyton Count: 156 dTex cm: g: cm/100 nl:	23 Typ: polyeste Count: 75 dTex cm: g: cm/100 nt	24 Typ: cotton Count: 5 Nec cm: g: cmi100 nl:	25 Typ: polyeste Count: 75 dTex cm: g: cm/100 nl:	26 Typ: nylon Count: 156 dTex cm: g: cm/100 nt:	27 Typ: polyeste Count: 75 dTex cm: g: cm/100 nl:	28 Typ: cotton Count: 5 Nec cm: g: cm/100 nt:
	29 Typ: polyeste Count: 75 dTex cm: g: cm/100 nt:	Count: 156 dTex cm: g: cm/100 nt:		Count: 5 Nec cm: g: cm/100 nt:	Count: 75 dTex cm: g: cm/100 nl:	✓ 34 Typ: nyton Count: 156 dTex cm: g: cm/100 nl:	Count: 75 dTex cm: g: cm/100 nl:	Count: 5 Nec cm: g: cm/100 nl;	37 Typ: polyeste Count: 75 dTex cm: g: cm/100 ni:	Start Start	x) 39 Typ: polyeste Count: 75 dTex cmc g: cm/100 nl:	49 Typ: cotton Count: 5 Nec cm: g: cm/100 nt:	41 Typ: polyeste Count: 75 dTex cm: g: cm/100 nl:	42.Typ: nylon Count: 156 dTex cm: 95 cm/100 ni:
ROUND	✓ 43 Typ: polyeste Count: 75 dTex cm: g: cm/100 nt:	44 Typ: cotton Count: 5 Nec cm: g: cm/100 nt:	¥6 Typ: polyeste Count: 75 dTex cm: g: cm/100 nt:	e 46 Typ: nylon Count: 156 dTex cm: g: cm/100 nt:	✓ 47 Typ: polyeste Count: 75 dTex cm: g: cm/100 nt:	✓ 48 Typ: cotton Count: 5 Nec cm: g: cm/100 nt:	49 Typ: polyeste Count: 75 dTex cm: g: cm/160 nt:	Count: 156 dTex cm: g: cm/100 nt:	✓ 61 Typ: polyeste Count: 75 dTex cm: g: cm/100 nt	✓ 52 Typ: cotton Count: 5 Nec cm: g: cm/100 nt:		✓ 64 Typ: nylon Count: 156 dTex cm: g: cm/160 nt	✓ 55 Typ: polyeste Count: 75 dTex cm: g: cm/100 nt:	66 Typ: cotton Count: 5 Nec cm: g: cm/100 nt
Repett	▶ 57 Typ: polyeste Count: 75 dTex cm: g: cm/100 ml:	≥ sa Typ: nylon Count: 156 dTex cm: g: cm/100 nt:	r tsTyp:polyeste Count:75 dTex cm: g: cmi100 ml:	e i 69 Typ: cotton Count: 5 Nec cm: g: cm/100 nt:	Count: 75 dTex Count: 75 dTex cm: g: cm/100 nt:		Count: 75 dTex crim: g: cm/100 nt:	Count: 5 Nec cm: g: cm/100 nl:	os Typ: polyeste Count: 75 dTex cm: g: cm/100 nt:	≥ 66 Typ: nyton Count: 156 dTex cm: g: cm/100 nt:	IF or Typ: polyeste Count: 75 dTex cm: g: cm/100 ml:	♥ 68 Typ: cotion Count: 5 Nec cm: g: cm/100 ni:	 co Typ: polyeste Count: 75 dTex cm: cm:100 nl: 	V 70 Typ: nylon Count: 156 dTex cm: g: cm/100 nt:
	75 Typ: polyeste Count: 75 dTex cm: g: cm:100 nt:	72 Typ: cotton Count: 5 Nec cm: g: cm/100 nt:	73 Typ: polyeste Count: 75 dTex cm: g: cm/100 nt:	V 74 Typ: sylos Count: 156 dTex Cm: g: cm/100 st:	 75 Typ: polyeste Count: 75 dTex cm: g: cm/100 nt: 	Count: 5 Nec cm: g: cm:/100 nt:	77 Typ: polyeste Count: 75 dTex cm: g: cm/100 nt:	28 Typ: nyton Count: 156 dTex cm: g: cmi100 nt:	▼ 79 Typ: polyeste Count: 75 dTex cm: g: cm/100 nt	so Typ: cotton Count: 5 Nec cm: g: cm/100 nt:	Count: 75 dTex can: g: cm/100 nt:	S2 Typ: nyloa Count: 155 dTex cm: g: cm/160 nt:	 #3 Typ: polyeste Count: 75 dTex cm: g: cm/100 nl: 	B4 Typ: cotton Count: 5 Nec cm: g: cm/100 nt:

The machine configuration is now finished, and it can be saved in order to be used again next time the pattern is processed again.

Press on the SAVE MACHINE CONFIGURATION



Button like in the below picture.

LGL KNITTING 10.04	LGL KNITTING 10.04 @169.254.0.1 NEWKYC00601@													
File Feeder Level Se	ttings 10.04													
			's 🍤 💰											
a fa a a														
All Feeders	Group All YCM	4												
1 Typ: polyester	2 Typ: nylon	3 Typ: polyester	✓ 4 Typ: cotton	16 T)										
Count: 75 dTex	Count: 156 dTex	Count: 75 dTex	Count: 5 Nec	Count:										
cm:	cm:	cm:	cm:	cm:										
g:	g:	g:	g:	g:										
cm/100 nl:	cm/100 nl:	cm/100 nl:	cm/100 nk	cm/100										
✓ 15 Typ: polyeste	16 Typ: cotton	17 Typ: polyeste	18 Typ: nylon	191										

The saved file must be .MAC.





When the machine configuration has been saved, it is automatically loaded in the system and its name appears top left of the screen.

🍝 lgl knittin	G 10.04 @169.2	54.0.1 NEWKYC	00601@pattern1.	mac
File Feeder Le	evel Settings			45
	Q. 🖉 泽		8 50 12	
All Feeders	Group All YCM			
∠ 1	✓ 2	⊮ 3	V 4	⊮ 5
RELEASE	RELEASE	RELEASE	RELEASE	RELEASE
CMX2028	CMX2028	CMX2028	CMX2028	CMX202

Now the system is ready to be used.

7.5.2 Get yarn consumption information

Press button in the YCM tab:





The system calculates the yarn consumption in a pattern taking its length in terms of number of machine revolution.

Insert the number of machine revolution of the pattern and possibly the number of machine needles. Number of machine needles allows to get infomration about yarn consumption every 100 needles.

Select between centimeters or inches and between grams or pounds.

The System measures the centimeters(inches) of yarn consumed by each feeder, and by exploiting the yarn count it converts the centimeters(inches) in grams(pounds).



Press OK.

On the YCM tab the button gets green



Press it. The system will start counting the revolutions. Here it will count 10 revolutions.

During the count a green bar will run in the bottom of the screen. The indication of the revolution count will increase in the left bar, where the MACHINE RUN writing is showing that the machine is actually running.

If the machine stops during the count for any reason, nevermind. The system will remember the data already stored and it will start counting from the point it stopped when the machine will be started up again.

🛃 LGL	KNITTING 10.04	TTING 10.01 (0160.054.6.1 NEWKYC08601.6ppttemilanec.													
	All Seeders	Sroup All YON	1												
	Y 1 Typ: polyester Count: 75 dTex cm:	2 Typ: nyion Count: 156 dTex cm:	STyp: polyester Count: 75 dTex cm:	4 Typ: cotton Count: 5 Nec cm:	✓ 5 Typ: polyester Count: 75 dTex Critic Critic	✓ 6 Typ: nylon Count: 156 dTex cm:	7 Typ: polyester Count: 75 dTex cm:	✓ 8 Typ: cotton Count: 5 Nec cm::	P > Typ: polyester Count: 75 dTex cm:	№ 10 Typ: nylon Count: 156 dTex cm:	11 Typ: polyeste Count: 75 dTex cm: xx	12 Typ: cotton Count: 5 Nec cm:	✓ 13 Typ: polyeste Count: 75 dTex cm:	V 14 Typ: nylon Count: 156 dTex cm:	
	cm/100 nt	cm/100 nt:	cm/100 mt	on/100 nt:	cm/100 nt:	cm/100 nt	em/100 nt:	cm/100 nl:	cm/100 nt:	em/100 nt:	cm/100 nt:	o. cm/100 nt:	em/100 nt:	cm/100 m:	
	IS Typ: polyeste Count: 75 dTex cm:	 16 Typ: cotton Count: 5 Nec cm: 	V 17 Typ: polyeste Count: 76 dTex cm:	✓ 18 Typ: nylon Count: 156 dTex cm:	✓ 19 Typ: polyeste Count: 75 dTex cmc	20 Typ: cotton Count: 6 Nec cm:	✓ 21 Typ: polyeste Count: 75 dTex cm:	22 Typ: nylon Count: 156 dTex cmc	23 Typ: polyeste Count: 76 dTex cm:	24 Typ: cotton Count: 5 Nec cm:	26 Typ: polyeste Count: 76 dTex cm:	✓ 26 Typ: nylon Count: 156 dTex cm:	27 Typ: polyeste Count: 75 dTex cm:	28 Typ: cotton Count: 6 Nec cm:	
ab.	p: cm/100 nl:	a: cm/100 ni:	g: cm/100 mb	a: cm/100 nl:	q: cm/100 mi:	g: cm/100 nt	a: cm/100 al:	2: cm/100 mi:	g: cm/100 nl:	a: cm/100 nl:	g: cm/100 mit	a: cm/100 nl:	2: cm/100 nl:	g: cm/100 m/:	
LGL	29 Typ: polyeste Count: 75 dTex cm:	2 30 Typ: nyton Count: 156 dTex cm:	St Typ: polyeste Count: 75 dTex cm:	2 32 Typ: cotton Count: 5 Nec cm:	S3 Typ: polyesta Count: 75 dTex cm:	S4 Typ: nylon Count: 156 dTex cm:	26 Typ: polyeste Count: 75 dTex cm:	S8 Typ: cotton Count: 5 Nec cm:	P 37 Typ: polyeste Count: 75 dTex cm:	2 38 Typ: nyton Count: 158 dTex cm:	20 Typ: polyeste Count: 76 dTex cm:	2 40 Typ: cotton Count: 5 Nec cm:	✓ 41 Typ: polyesta Count: 75 dTex cm:	P 42 Typ: nylon Count: 156 dTex cm:	
۲	cm/100 nt:	cm/100 nl:	cm/100 nt	cm/100 nb	cm/100 nl:	cm/100 nt	cm/100 nl:	cm/100 mk	cm/100 nt:	cm/100 nl:	cm/100 nk	cm/100 nb	cm/100 nl:	cm/100 nt	
ROUND 5 OF	✓ 43 Typ: polyeste Count: 75 dTex cm:	✓ 44 Typ: cotton Count: 5 Nec cm: 	✓ 46 Typ: polyeste Count: 75 dTex cm: 	✓ 46 Typ: nyton Count: 158 dTex cm:	✓ 47 Typ: polyeste Count: 75 dTex cm: 	✓ 48 Typ: cotton Count: 5 Nec cm: cm:	✓ 49 Typ: polyeste Count: 75 dTex cm:	✓ 50 Typ: nyton Count: 158 dTex cm:	 61 Typ: polyeste Count: 75 dTex cm: 	✓ 52 Typ: cotton Count: 5 Nec cm:	✓ 53 Typ: polyeste Count: 75 dTex cm: 	S4 Typ: nyton Count: 158 dTex cm:	✓ 55 Typ: polyeste Count: 75 dTex cm:	✓ 66 Typ: cotton Count: 5 Nec cm:	
10 Repeat	0. cm/100 nt	cm/100 nl:	ph cm/100 at	cm/100 nt:	cm/100 at:	on/100 nt	cm/100 nt:	om/100 at:	0. cm/100 nt	o. cm/100 nl:	cm/100 st	o. cm/100 nt	cm/100 nl:	om/100 st	
	67 Typ: polyeste Count: 75 dTex cm:	S8 Typ: nyton Count: 156 dTex cm:	✓ 59 Typ: polyeste Count: 75 dTex cm:	e 50 Typ: cotton Count: 5 Nec cm:	✓ 61 Typ: polyeste Count: 75 dTex cm: cm:	✓ 62 Typ: nylon Count: 156 dTex cm:	✓ 63 Typ: polyeste Count: 75 dTex cm:	№ 64 Typ: cotton Count: 5 Nec cm: cm:	✓ 65 Typ: polyeste Count: 75 dTex cm: m	e6 Typ: nylon Count: 156 dTex cm:	67 Typ: polyeste Count: 75 dTex cm:	e se Typ: cotton Count: 5 Nec cm:	✓ 48 Typ: polyeste Count: 75 dTex cm:	✓ 76 Typ: nylon Count: 156 dTex cm:	
	cm/160 nt	cm/100 nl:	9" cm/100 nt	cm/100 nt:	cm/100 nl:	s+ cm/100 nt	cm/100 nt:	cm/100 nl:	cm/160 nt	cm/100 nl:	om/100 nl:	em/100 nt	cm/100 nl:	cm/100 nt	
Machine RUN	71 Typ: polyeste Count: 75 dTex cm:	272 Typ: cotton Count: 5 Nec cm:	✓ 73 Typ: polyeste Count: 75 dTex cm:	✓ 74 Typ: nylon Count: 156 dTex cm:	 76 Typ: polyeste Count: 75 dTex cm: 	Count: 5 Nec	77 Typ: polyeste Count: 75 dTex cm:	✓ 78 Typ: nylon Count: 156 dTex cmc	 79 Typ: polyeste Count: 75 dTex cm: 	em:	Count: 75 dTex	Count: 156 dTex Com:	✓ 83 Typ: polyeste Count: 75 dTex cm:	≥ 84 Typ: cotton Count: 5 Nec cm:	
	g: cm/100 nl:	g: cm/100 nl:	9: cm/100 nt	g: cm/100 nl:	g: cm/100 al:	9: cm/100 nt	g: cm/100 nl:	9: cm/100 mit	g: cm/100 nl:	9: cm/100 nl:	9: cm/100 nit	g: cm/100 ni:	9: cm/100 nl:	g: cm/100 nit	
	Counting running, 5th revolution out of 10														
									•	© STATUS	-	Page	10	f1	

- H A	Feedlers	0 🗃 👯	ANTTING 1048 2162.254.01.18.2WYC/D0602 system Lanz													
hanness of the second s																
All F	recours e	roup All YCM														
2:01 Count cm: 8 g: 0.6 cm/10	n Typ: polyester nt: 75 dTex 8165.0 .62 100 nt: 34.03	2 Typ: nylon Count: 156 dTex cm: 8981.5 g: 1.41 cm/100 nl: 37.43	STyp: polyester Count: 75 dTex cm: 7740.42 g: 0.59 cm/100 nt: 32.26	 4 Typ: cotion Count: 5 Nec cm: 8965.17 g: 10.6 cm:100 nl: 37.36 	STyp: polyester Count: 75 dTex cm: 7952.71 g: 0.8 cm/100 nl: 33.14	6 Typ: nyton Count: 156 dTex cm: 8981.5 g: 1.41 cm/100 nt: 37.43	Typ: polyester Count: 75 dTex cm: 7903.72 g:0.6 cm/100 nl: 32.94	STyp: cotton Count: 5 Nec cm: 8948.84 g: 10.59 cm/100 nl: 37.29	9 Typ: polyester Count: 75 dTex cm: 8181.34 g: 0.62 cm/100 nt: 34.09	 10 Typ: nylon Count: 156 dTex cm: 9079.48 g: 1.42 cm/100 nl: 37.84 	11 Typ: polyeste Count: 75 dTex cm: 7789.42 g: 0.59 cm/100 m: 32.46	12 Type cotton Count: 5 Nec cm: 9128,47 g: 10.8 cm/100 nt: 38.04	13 Typ: polyeste Count: 75 dTex cm: 7773.09 g: 0.59 cm/100 nl: 32.39	H4 Typ: nylon Count: 156 dTex cm: 8965.17 g: 1.4 cm/100 nt: 37.36		
2 15 Count cm: 8 g: 0.6 cm/10	ts Typ: polyeste nt: 75 dTex 8067.03 .61 100 nt: 33.62	 16 Typ: cotton Count: 5 Nec cm: 9079.48 g: 10.74 cm/100 nl: 37.84 	 17 Typ: polyeste Count: 75 dTex cm: 7903.72 g: 0.6 cm/100 nt: 32.94 	 18 Type nylon Count: 156 dTex cm: 9046.83 g: 1.42 cm/100 nl: 37.7 	Count: 75 dTex cm: 7658.78 g: 0.58 cm/100 nl: 31.92	20 Typ: cotion Count: 5 Nec cm: 8916.13 g: 10.55 cm/100 nl: 37.16	21 Typ: polyeste Count: 75 dTex cm: 8262.98 g: 0.62 cm/100 nl: 34.43	✓ 22 Typ: nyton Count: 156 dTex cm: 8883.52 g: 1.39 cm/100 nl: 37.02	23 Typ: polyeste Count: 75 dTex cm: 7773.09 g: 0.59 cm/100 nt: 32.39	24 Typ: cotton Count: 5 Nec cm: 8916.18 g: 10.55 cm/100 nl: 37.16	 25 Typ: polyeste Count: 75 dTex cm: 8067.03 g: 0.81 cm/100 nl: 33.62 	26 Type nylon Count: 156 dTex cm: 8720.22 g: 1.37 cm/100 nl: 36.34	27 Typ: polyeste Count: 75 dTex cm: 7691.44 g: 0.58 cm/100 nl: 32.05	28 Typ: cotton Count: 5 Nec cm: 8883.52 g: 10.51 cm/100 nl: 37.02		
Count Count cm: 8 g: 0.6 cm/10	29 Typ: polyeste nt: 75 dTex 8099.69 .61 100 nt: 33.75	 30 Typ: nyton Count: 156 dTex cm: 8720.22 g: 1.37 cm/100 nl: 36.34 	31 Typ: polyeste Count: 75 dTex cm: 7789.42 g: 0.59 cm/100 nt: 32,46	Count: 5 Nec. cm: 9046.83 g: 10.7 cm/100 nt: 37.7	 33 Typ: polyeste Count: 75 dTex cm: 8181.34 q: 0.62 cm/100 ml: 34.09 	2 34 Typ: nylon Count: 156 dTex cm: 8932.51 g: 1.4 cm/100 nt: 37.22	35 Typ: polyeste Count: 75 dTex cm: 7838.4 g: 0.59 cm/100 nl: 32.66	Count: 5 Nec cm: 8769.21 g: 10.37 cm/100 nt: 36.54	✓ 37 Typ: polyeste Count: 75 dTex cm: 8132.34 g: 0.61 cm/100 nt: 33.89	✓ 38 Typ: nylon Count: 156 dTex cm: 8818.21 g: 1.38 cm/100 nl: 36.75	Count: 75 dTex Count: 75 dTex cm: 7822.07 g: 0.59 cm/100 nt: 32.6	e 40 Typ: cotton Count: 5 Nec cm: 8965.17 g: 10.6 cm/100 nt: 37.36	41 Typ: polyeste Count: 75 dTex cm: 8148.67 g: 0.62 cm/100 nl: 33.95	42 Typ: nylon Count: 156 dTex cm: 8687.56 g: 1.36 cm/100 nl: 36.2		
ROUND OK OF g: 0.5 10 cm:10	a trajectoria a trajectoria a trajectoria b a trajectoria<															
Repeat Count Count cm: 7 g: 0.6 cm/10	mathem mathm mathm mathm															
Count Count Cm: 7 g: 0.5 cm/10	71 Typ: polyeste nt: 75 dTex 7593.46 .57 100 nt: 31.64	 72 Typ: cotton Count: 5 Nec cm: 8785.55 q: 10.39 cm/100 nl: 36.61 	 73 Typ: polyeste Count: 75 dTex cm: 7985.38 g: 0.5 cm/100 nl: 33.28 	 74 Typ: nylon Count: 156 dTex cm: 8997.84 g: 1.41 cm:100 nt: 37.5 	 75 Typ: polyesta Count: 75 dTex cm: 7740.42 q: 0.59 cm/100 nl: 32.26 	 78 Typ: cotton Count: 5 Nec cm: 8883.52 g: 10.51 cm!100 nt: 37.02 	 77 Typ: polyeste Count: 75 dTex cm: 8001.71 g: 0.61 cm/100 nl: 33.35 	✓ 78 Typ: nyton Count: 156 dTex cm: 9030.5 g: 1.41 cm/100 nl: 37.63	P 78 Typ: polyeste Count: 75 dTex cm: 7789.42 g: 0.59 cmi100 nt: 32.46	2 80 Typ: cotton Count: 5 Nec cm: 8834.54 g: 10.45 cm/100 nl: 36.82	♥ 81 Typ: polyeste Count: 75 dTex cm: 7985.38 g: 0.6 cm/100 nl: 33.28	 82 Typ: nylon Count: 156 dTex cm: 9193.8 g: 1.44 cmi100 nt: 38.31 	 #3 Typ: polyeste Count: 75 dTex cm: 7838.4 g: 0.59 cm/100 nl: 32.66 	84 Typ: cotton Count: 5 Nec cm: 8948.84 g: 10.59 cm/100 nt: 37.28		
12 I	Counting ended. 10 revolution have been counted and the yarn consumption result is displayed on the screen under each feeder															

By pressing icon:



The fabric composition is displayed on the screen.



By pressi	ng bottom	n of the screen the	yarn consumptio	n information can be saved.
🛃 LGL	KNITTING 10.04	@169.254.0.1		opatter
File Fe	eeder Level Se	attings		
-9				30 4
	All Feeders	Group All YCM	1	
	Count: 75 dTex Count: 75 dTex Cm: 8165.0 g: 0.62	✓ 2 Typ: nylon Count: 156 dTex cm: 8981.5 g: 1.41	✓ 3 Typ: polyester Count: 75 dTex cm: 7740.42 g: 0.59	✓ 4 Ty Count: : cm: 896 g: 10.6
	cm/100 nl: 34.03	cm/100 nl: 37.43	cm/100 nl: 32.26	cm/100
	Count: 75 dTex cm: 8067.03 g: 0.61 cm/100 nl: 33.62	Count: 5 Nec cm: 9079.48 g: 10.74 cm/100 nl: 37.84	Count: 75 dTex cm: 7903.72 g: 0.6 cm/100 nl: 32.94	Count: cm: 904 g: 1.42 cm/100
	29 Typ: polyeste Count: 75 dTex cm: 8099.69 g: 0.61 cm/100 nl: 33.75	■ 30 Typ: nylon Count: 156 dTex cm: 8720.22 g: 1.37 cm/100 nl: 36.34	 31 Typ: polyeste Count: 75 dTex cm: 7789.42 g: 0.59 cm/100 nl: 32.46 	232 T Count: : cm: 904 g: 10.7 cm/100
ROUND OK OF 10	43 Typ: polyeste Count: 75 dTex cm: 7560.8 g: 0.57 cm/100 nl: 31.51	 ✓ 44 Typ: cotton Count: 5 Nec cm: 9112.14 g: 10.78 cm/100 nl: 37.97 	✓ 45 Typ: polyeste Count: 75 dTex cm: 8067.03 g: 0.61 cm/100 nl: 33.62	46 T Count: cm: 87! g: 1.37 cm/100
Repeat	 ✓ 57 Typ: polyeste Count: 75 dTex cm: 7952.71 g: 0.6 cm/100 nl: 33.14 	 ✓ 58 Typ: nylon Count: 156 dTex cm: 9079.48 g: 1.42 cm/100 nl: 37.84 	✓ 59 Typ: polyeste Count: 75 dTex cm: 7838.4 g: 0.59 cm/100 nl: 32.66	60 T Count: : cm: 88: g: 10.47 cm/100
	71 Typ: polyeste Count: 75 dTex cm: 7593.46 g: 0.57 cm/100 nl: 31.64	Count: 5 Nec cm: 8785.55 g: 10.39 cm/100 nl: 36.61	Count: 75 dTex Count: 75 dTex cm: 7985.38 g: 0.6 cm/100 nl: 33.28	Count: cm: 89: g: 1.41 cm/100
- 0				

Note: The button to save Machine configuration (red circle on TOP) and the button to save yarn consumption information (red circle BOTTOM) are different.



The file extension must be .ldb.

For each pattern two different files can be saved and used to create a patterns database: a ".mac" file with the machine configuration information and a ".ldb" file with the yarn consumption information.

An example of how a .ldb file looks like is in the following page.

See chapter 6.1 to open stored machine configurations.

See chapter 7.2 to open .ldb file with Microsoft Excel 2016 and 7.3 to open the file with Apache OpenOffice.

YCM file saved and opened with EXCEL

<filename>pattern</filename>	1		
Revolution	10		
Feeder for belt	0		
Amount of belt feeders	0		
Needles	2400		
Consumption	276,48	g	
Consumption	707627,75	cm	

PRODUCT GROUP

75 dTex	polyester	332037,88	cm	46,93	% cm	24,91	g	9,01	% g
156 dTex	nylon	187550,06	cm	26,51	% cm	29,26	g	10,59	% g
5 Nec	cotton	188039,95	cm	26,58	% cm	222,32	g	80,42	% g

Feeder	Consumption	cm- in	Consumption	g oz	Consumption 100 nl	cm- in	% Feeder	Count	Туре
1	8165,0	cm	0,62	g	34,03	cm	1,16	75 dTex	polyester
2	8981,5	cm	1,41	g	37,43	cm	1,27	156 dTex	nylon
3	7740,42	cm	0,59	g	32,26	cm	1,1	75 dTex	polyester
4	8965, 17	cm	10,6	g	37,36	cm	1,27	5 Nec	cotton
5	7952,71	cm	0,6	g	33,14	cm	1,13	75 dTex	polyester
6	8981,5	cm	1,41	g	37,43	cm	1,27	156 dTex	nylon
7	7903,72	cm	0,6	g	32,94	cm	1,12	75 dTex	polyester
8	8948,84	cm	10,59	g	37,29	cm	1,27	5 Nec	cotton
9	8181,34	cm	0,62	g	34,09	cm	1,16	75 dTex	polyester
10	9079,48	cm	1,42	g	37,84	cm	1,29	156 dTex	nylon

7.6 YARN CONSUMPTION OF BELT DRIVEN FEEDERS

We have the possibility to calculate the yarn consumption coming from the belt driven feeders. So we can have the complete measurement of all yarns going into a pattern.

There are two possibilities:

- 1. We add an LGL feeder behind a belt driven feeder, this feeder can be a new feeder in addition to the ones already installed on the machine, or a feeder that is already installed on the machine and that is not being used in that specific pattern. All LGL feeders in the market are able to be used for this purpose, they do not require any upgrade of any sort. The system will get the yarn consumption from this one feeder and it will multiply the value for the number of belt driven feeders involved in the pattern (since there is the belt all belt feeders consume the same amount of yarn). See pharagraph 7.6.1.
- 2. We use a belt sensor connected directly to the KYC device. See pharagraph 7.6.2.

Click on icon and select the Belt feeder present check:



Number of groups: Belt feeder group is not included in this number, it comes in addition to this number.

7.6.1 Belt feeder

If **Belt consumption feeder** has been selected, the BELT name will appear among the other groups names, and the system will allow to set the address of the feeder which is installed behind one belt driven feeder.

🌆 Grou	o Creation																	_	×
								*	Group name: Bett	•	S X								
₽ 1 Group: Belt feeder	ECO2017 Dolt	Crosp:	EC02017	🗌 3 Group:	EC02017	a Group:	EC02017	Group:	EC02017	□8 Group:	EC02017	Croup:	EC02017	Group:	EC02017	Groute	EC02017	Groupe	EC02017
🗆 11 Grosp:	EC02017	🗌 12 Grosp:	EC02017	🗌 13 Groep:	EC02017	Croup:	EC02017	🗆 15 Group:	EC02017	🗆 18 Group:	EC02017	Croup:	EC02017	Group:	EC02017	Croup:	EC02017	29 Group:	EC02017
Crospc	EC02017	C 22 Group:	EC02017	C 25 Group:	EC02017	24 Group:	EC02017	as Group:	EC02017	🗆 25 Group:	EC02017	🗋 27 Group:	EC02017	🗆 25 Group:	EC02017	C 23	EC02017	Group:	EC02017
🗆 31 Group:	EC02017	Group:	EC02017	🗆 33 Group:	EC02017	Group:	EC02017	Group:	EC02017	🗆 36 Group:	EC02017	Group:	EC02017	Group:	EC02017	🗆 20 Groups	EC02017	Group:	EC02017
Group:	EC02017	az Group:	EC02017	Group:	EC02017	Group:	EC02017	Group:	EC02017	as Group:	EC02017	Group:	EC02017	Group:	EC02017	Groupe	EC02017	Group:	EC02017
51 Group:	EC02017	Croup:	EC02017	Group:	EC02017	0 64 Oroup:	EC02017	Group:	EC02017	066 Croup:	EC02017	57 Group:	EC02017	Groups	EC02017	Groupe	EC02017	Groupe	EC02017
Groupe	ECM2008	Crosp:	ECM2008	Group:	ECM2008	Group:	ECM2008	Croup:	ECH2008	Croup:	ECM2008	Group:	ECM2008	Group:	ECM2008	Cuante	ECM2008	Group:	ECM2003
Grosp:	ECM2008	Crosp:	ECM2008	Groep:	ECM2008	T4 Group:	ECM2018	Group:	ECM2008	Croup:	ECM2008	Croup:	ECM2008	Group:	ECM2008	Croup:	ECM2008	Group:	ECM2008
Grosp:	ECM2008	Group:	ECM2008	Group:	ECM2008	🗆 84 Group:	ECM2008											~	



In the belt feeder square the operator needs to set the amount of belt driven feeders used in the pattern, so that the system will report the total amount of yarn consumed by all belt driven feeders together. Here the feeder address is 1 and the amount is 15.

the belt feeder will form one specific group, and it won't enter the normal repetition, as it can be seen in the next pictures.

🛓 Group	Creation																	-	□ ×
								٠	Group name: 3	•	S X								
<u>e</u> 1	EC02017	2 2	EC02017		EC02017	2 4	EC02017	23	EC02017	.	EC02017	1	EC02017		EC02017		EC02017	19	EC02017
Group	Belt	Group:	1	Groups		Groups	1	Group:	3	Group:		Groupe		Group:		Group:		Group:	
Belt feeder	1																		
11	EC02017	12	EC02017	13	EC02017	14	EC02017	15	EC02017	16	EC02017	11	EC02017	18	EC02017	19	ECO2017	29	EC02017
Groups		Group:		Group:		Group:		Group:	ß	Group:		Group:		Group:		Group:		Groups	
21	EC02017	22	EC02017	22	EC02017	24	EC02017	25	EC02017	26	EC02017	1	EC02017	28	EC02017	28	EC02017		EC02017
Circupt		Group:		Group:		Groups		Group:		Group:		Group:		Group:		Group:		Groups	
35	EC02017	32	EC02017	23	EC02017		EC02017	35	EC02017	36	EC02017		EC02017	38	EC02017	39	EC02017	4)	EC02017
Groups		Group:		Group:		Groups		Group:		Group:		Groups		Group:		Group:		Group:	

🔬 Grou	o Creation																	-	
								-	Group name: 3	+	8 ×								
F 1	EC02017	1 2	EC02017	23	EC02017	24	EC02017	₽ 5	EC02017	6	Repeat ECO2017	11	EC02017	8	EC02017		EC02017	10	EC02017
Grospi	Bell	Groep:	1	Group:		Groups	1	Groupe	3	Grossc	1	Grosp:		Groups	1	Groups	3	Groute	1
Belt feeder	1																		
	EC02017	12	EC02017	13	EC02017	1 14	EC02017	- 15	EC02017	16	EC02017	17	EC02017	18	EC02017	- 10	EC02017	20	EC02017
Grosp		Group:	1	Group:	3	Groupe	1	Group		Grospi	1	Group:	3	Group:	1	Group:		Groupe	'
.	EC02017	22	EC02017	21	EC02617	24	EC02017	25	EC02017	26	EC02017	27	EC02017	25	EC02017	29	EC02017	30	EC02017
Group:	3	Group:	1	Group:		Groups	1	Groups	3	Group:	1	Groep		Groups	1	Groups	з	Groups	1
35	EC02017	32	EC02017	33	EC02017	ы	EC02017	38	EC02017	16	EC02017	37	EC02017	38	EC02017	19	EC02017	40	EC02017
Grosp		Group:	1	Group:	3	Groupe	1	Group		Group:	1	Group:	3	Group:	1	Сленар		Groupe	1
41	EC02017	42	EC02017	145	EC02017	41	EC02017	45	EC02017	46	EC02017	10	EC02017	43	EC02017	49	EC02017	50	EC02017
Group:	3	Group:	1	Group:		Groups	1	Groupe	3	Group:	1	Grosp:		Geoup:	1	Group:	3	Groupe	1
51	EC02017	52	EC02017	53	EC02017	54	EC02017	55	EC02017	56	EC02017	57	EC02017	55	EC02017	59	EC02017	60	EC02017
Grosp		Group:	4	Group:	3	Groups	1	Group		Grospi	1	Group:	3	Group:	1	Group		Groupe	1
61	ECM2008	a	EC112018	6	EC112058	_ 64	ECM2068	65	ECM2003		ECM2005	67	ECM2008	63	ECM2008	0	ECM2008	20	ECM2103
Groupe	3	Group:	1	Group:		Groups	1	Groups	3	Group:	1	Groep:		Group:	1	Groups	3	Groupe	1
25	ECW5008	12	£C112018	173	ECM5018	74	ECM2008	- 78	ECW5001	76	ECM2005	17	ECM2008	78	£C112008	18	ECW5000	- 80	ECW5503
Grosp		Group:	1	Group:	3	Groupe	,	Group		Grospi	1	Group:	3	Group:	'	Group		Groupe	1
B1	ECM2608	82	ECM2008	80	EC112018	34	ECM2008												
Group:	3	Broup:	1	Group:		Groups	1												

The belt driven feeder selected is number 1 only. There is the possibility to select more than one belt driven feeder. In any case none of them will enter in the REPEAT command

After teh groups creation is terminated, there is always the possibility to save the configuration. The .mac file will be saved on the PC in the desired folder and will be loaded on the JAVA, appearing top left of the screen (Pippo 1.mac in the following picture).



By clicking on the YCM tab, the feeder responsible for belt driven feeders yarn consumption will appear in a yellow square.

💰 LGL KI	/C 0.00 @169.254.0	1 NEWKYC0004056	pippo1.mac		The second second second second second second second second second second second second second second second s			
File F	eeder Level	Settings 0.00						
i g	ų 🙀 🐼		3 8 8	8 % 🎾	, A			
	All Feeders	Group All Y	СМ					
	♥ 1 Typ: Count: cm: g: cm/100 nl:	₽ 2Typ: Count: cm; g: cm/100 nl:	2 3 Typ: Count: cm: g: cm/100 nl:	✓ 4 Typ: Count: cm: g: cm/100 nl:	S Typ: Count: cm: g: cm/100 nl:	Count: Cont: cm: g: cm/100 nt:	₽ 7 Typ: Count: cm: g: cm/100 nl:	



The button will provide all information about belt driven feeder address and quantity of belt feeders involved in the pattern.

🐴 Belt Settings view 👘	
LGL Feeder number:	5
Amount of belt feeders:	10

7.6.2 Belt sensor



If **Belt consumption sensor** has been selected, the following screen will appear:



total number of belts (maximum number of belts supported by the sensor: 2)

number of feeders groups, not including belts

In the example 2 belt groups and 3 feeders groups have been choosen. Press NEXT. The following screen is reated to the belt groups:



Select the belt groups and press NEXT Belt group 1 corresponds to the top belt on the sensor

Belt group 2 corresponds to the bottom belt on the sensor.

Select the belt or the belts actually connected to belt feeders.

For each selected belt group, following information are required (here shown for belt group number 2):



By pressing NEXT, groups configuration goes on normally (see chapter 6). The operator must give names to each of the 3 feeders groups and select the related feeders.

At the end of the procedure the feeders will be shown in the YCM page together with the two belt groups. Each belt group will be shown as a feeder square with its perimeter in yellow colour.

b1x42 Typ:	▶ b2x42 Typ:
Count:	Count:
cm:	cm:
g:	g:
cm/100 nl:	cm/100 nl:

In the YCM page bottom left the button will allows to set belt feeders groups also on the machines where LGL feeders are not installed. The Belt sensor and the KYC device must be installed of course.

Open global knitting program, access the YCM page and click on the button.

The following screen appears, where it is possible to set belt groups but it is not allowed to set feeders groups:



At the end the program will report only the belt groups, like in the following picture:



Note: Can be used also to add belt sensors to an existing machine configuration from the YCM page.

8 - APPLICATION CLOSE

8.1 APPLICATION CLOSE

When you close the application, this picture appear:



By pressing **"YES"**, the last configuration file is saved and when the application starts again, the file is immediately available.

By pressing **"NO"** the configuration in use is not saved. Press **"Abort"** to go back to the main window.



L.G.L. Electronics S.p.A. reserve the right to alter in any moment one or more specifications of his machines for any technical or commercial reason without prior notice and without any obligation to supply these modifications to the machines, already installed.

www.lgl.it Italy

T +39 035 733 408 L.G.L. Electronics S.p.A.

F +39 035 733 146 Via Ugo Foscolo, 156 lgl@lgl.it 24024 Gandino (BG)