

# TIPS FOR KNITTING

KNITTING



**GOLDEN RULES**



## KNITTING

### Tips for Knitting: The golden rules for quality jersey knits

#### Quality check for the knitting mill & knitting machines for the production of perfect fabrics

1. Cleanliness on and around the knitting machines inside the production hall is a basic requirement for quality. Fiber fluff concentrations and traces of oil are a major enemy of quality goods.
2. Only yarns from one and the same spinning batch should be knitted together.
3. Only yarns from one and the same delivery should be processed together. It is necessary and important to separate these even when the batch number and lot number are the same as that of the last delivery.
4. The yarns must be twist-deadened and treated with paraffin wax.
5. The yarns should be adjusted to the climatic conditions in which they will be knitted up for a sufficiently long period of time. When a set of bobbins run out on a machine the set of bobbins which follow should always have the same climatic conditions for knitting.
6. The humidity of all bobbins should be the same throughout the complete set of bobbins.
7. The package hardness of all the bobbins should be the same.
8. The same cone diameter leads to a more even appearance of the knitted fabric and counters any shadow ring tendencies. The best procedure is to unpin any remaining bobbins (using these in some other way e.g. fabrics with a structure) and to continue with a new set of bobbins with the same size.
9. Standardized yarn input tension between 3.0 – 5.0 g
10. The fabric take-off should be regular and performed with a low take-off tension. The use of a Quadratex fabric spreader is recommended.
11. The untreated fabric weight and width should be checked at least once on every shift.
12. The set of needles in the knitting machine must be of the same quality and have the same service life / operating life to avoid pin-stripes.
13. An earthed knitting machine prevents bad running properties as a result of static charging.
14. Maintain a constant temperature and air humidity in the knitting mill and when acclimatizing the yarns - this leads to a more even final appearance in the fabric.

#### Plating with elastane

1. When plating with elastane it is an advantage to knit with the lowest possible input tension.
2. All elastane rolls should be of the same size (see Point 8 above).
3. Likewise all the elastane rolls must come from the same delivery. The rolls must be of the same age and storage should be performed in the same conditions.

Document Reference: K\_Golden Rules\_E\_DEG\_041201

The information published here is given in good faith and is based upon our experience to date when processing Lenzing Fibers. However these recommendations should be regarded as guidelines only, and it is the responsibility of the user to test the suitability of processes or products for a specific application.



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