

Spinning and weaving mill solutions

From the bale to the cloth in one system

Counts that carry their system, cloth weight worked out from the threads, warp bought by the warp's length, and the blend on the label checked against what was actually spun.

Ne · tex · denier

Every count carries its system

Warp + crimp + waste

Beams that do not run short

Even laydown

Micronaire spread kept narrow

From fibre to fabric – each stage in its own unit

Bales, mixings, yarns and cloth sit in one chain, so a stripe found in the dyehouse is traced back to the laydown that caused it – all tied to the stores and the accounts.



Counts that cannot be misread

40s Ne is finer than 20s; 40 tex is coarser than 20 tex. Every count converts through tex and carries its system, so 2/40s is costed as a 20s.



Warp bought to its own length

Crimp, loom waste and beam ends are added before the yarn is ordered, so a beam does not run out before the order is woven.



The blend you spin

Cleaning losses shift the blend. The system works out what the yarn really is – and what to charge to spin the blend on the label.



Barré traced to its cause

Each dye lot links back through the cloth's yarns to its mixing, so a stripe found weeks later is tied to the laydown that made it.

14.1%

more warp than the cloth

4.79

blend points off, example

1.04%

cost of level dyeing

~28

cover-factor ceiling

Yarn and cloth – worked out, not typed

Count systems that run in opposite directions, a cloth weight computed from its threads, and a warp order sized to the warp rather than the fabric.



Counts and cloth weight

- Ne, tex and denier on every yarn, converted through tex, with the direction stated in words – numbers alone cannot show it.
- Plied yarns resolved: **2/40s is a 20s**. Costing on the singles count would put the cloth at half its weight.
- Cloth weight in g/m² computed from ends, picks and counts rather than typed in.
- Cover factor checked: past about **28** no reed holds the ends, so the construction is refused rather than priced.



Warp to the beam's length

- The warp goes over and under, so its length includes crimp (**8%** in the example), loom waste and unweavable beam ends.
- Beam ends are fixed: **45 m** is 18% of a 200 m order and 0.9% of a 5,000 m one.
- Warping is costed per order, not per metre, because its labour does not shrink with a short run.
- Looms costed by picks, not loom-hours: the same loom makes twice as much 36-pick cloth as 72-pick.



The warp crimps as it weaves

Checked in the running system: a thousand metres of poplin needs **80.87 kg** of warp yarn, not the **70.86 kg** the cloth length suggests. Buy against the cloth and the beam is about **14% short**, every time.

Cost per usable kg

Bale price ÷ (1 – cleaning loss): a cheap, dirty cotton is not cheap.

Yarn spun off count

The mill board flags yarn spinning coarse against its count – sold by weight, delivered by length.

Beams that will run short

Each beam is checked against its order length before weaving starts, not when it runs out.

The blend on the label – against what was spun

Cotton and polyester lose different amounts in cleaning, and mixings vary in fineness. The module works out both before the yarn reaches the dyehouse.



Blend claims

- Each yarn's claimed blend is compared with what its mixing actually spins, after each fibre's cleaning loss.
- A claim more than **3 points** out shows on the mill board – the blend on a garment label is a statement of fact.
- The system works backwards to the charge that spins the label blend, then proves it by re-blending.



Even laydown

- The bale laydown is solved at least cost by VLUERP's shared blending optimiser, one fibre kind at a time.
- The optimiser hits the mean micronaire but not the spread, so a narrow micronaire window is imposed before it runs.
- In the example, the even laydown cost **1.04%** more than the cheapest mixing – less than one barré piece.

Blowroom loss and the blend it makes

Case	What happens	Figure
Cotton, carded	Trash and short fibre removed in cleaning	8-12%
Cotton, combed	Combing takes out more short fibre	20% and over
Polyester staple	Very little removed	about 1%
Charged 65/35 P/C	Spun with a combed cotton, the yarn comes out at	69.8/30.2
To spin 65/35	Worked backwards, the charge becomes	59.89/40.12

Losses are the ranges used in the module's worked example; each of your lots carries its own cleaning loss on the fibre card.

Every screen in the module – and what is on it

Read off the running application – the panels, columns and figures that are actually there.

4 screens
36 functions

01 Mill

Unsupported blend claims Mixings that will stripe Yarn spun off count Cloth woven
Yarn spun Rejected for barré Of that, foreseeable Label claims that fail
Beams that will run short

02 Fibre

Add a lot Origin Micronaire Staple Strength Trash Lost in cleaning
Price/kg Cost/usable kg

03 Mixings

Lay one down Start a mixing by hand Lots Weight Mean mic Spread Staple
Cost/kg Work out both

04 Yarns

Add a yarn Count as written System Resultant tex denier Mixing
Claimed blend Price/kg

Not a separate program – a complete business system

The trade module sits on top of a complete ERP: everything it does lands directly in the accounts, the stores and the reports – no double entry.



Accounting

Editable chart of accounts, automatic entries from every transaction, VAT and financial statements.



Financial dimensions

Cost centres, departments, business lines and sites – with statements per factory.



Inventory

Warehouses and bins, batches and serials, moving average, FIFO or standard cost.



Purchasing & sales

RFQs, purchase orders and receipts, quotations, invoices and ageing.



Maintenance & assets

Equipment register, preventive maintenance, work orders and depreciation.



Access & language

Roles and rights per module, audit trail, full Arabic and English interface.

Methods built into the module

tex base

Every count converted through tex

Warp length

Crimp, loom waste and beam ends added

Cover factor

Threads/in ÷ $\sqrt{\text{Ne}}$, refused past ~28

Blend charge

Charge worked back from the label blend

Mic window

Micronaire spread set before optimising

These are calculations the module runs itself, as working methods. They are not claims of conformity to any published standard.

See your own mill **in figures**

Book a session and we'll set up the demo with your own fibre lots, yarns and cloth constructions, and walk through it with your team.

Request a demo

Website

www.vluerp.com

Demo request

www.vluerp.com/#demo

Email

hello@vluerp.com

- 1 Mill board:** blend claims, mixings that will stripe and beams that will run short.
- 2 Yarn counts:** enter a plied yarn as written and watch it resolve to tex and its resultant count.
- 3 Laydown:** the cheapest mixing and the even one side by side, with the cost of level dyeing.
- 4 Warp order:** size a beam for a real order, with crimp, loom waste and beam ends included.

Switched on from Add-ons with a free seven-day trial, and it runs on the same general ledger.