

# APT Asia Pacific Pty Ltd

QMS 8.1  
EMS



## Yarn Product Specification

COMPANY CONFIDENTIAL

For Internal Use Only

BL - Rev 33 - 20200925

Product Code **210934**

Product Description:

Job Number **3193**

Winder Recipe Used

Jet Yarn Tension (cN)	
Setup Completed By	

Specification (Target)	Filament Extruded Linear Density (Tex)	Filament Thickness (µm)	Filament Width (µm)	Filament Number	Shrinkage (%)	Texturisation (%)	Bobbin Weight Tolerance (Kgs)		Test Settings	PE yarn	PP yarn
		200	392		6	6		5.50		Shrinkage Test	90°C for 60sec
Min	190.0	350			2		5.30		Curl Test	80°C for 5 mins.	Not used
Max	205.0	431			10		5.70		Texturization Test	85°C for 10 min.	Not used

All test must be completed & results recorded. All samples retained.

If any tests are out of specification - retest, record results & immediately notify Team Leader for corrective action. Note Line Setting Adjustments.

Pallet Number	Sample Information				QC In Process Check Results - 2 samples per pallet								
	Number	Initial	Date	Time hrs.	Extruded Linear Density (Tex)	Filament Thickness (µm)	Filament Number	Shrinkage (%)	Curling	Texturisation (Circle one)	Bobbin Weight 0.00kgs	Bobbin Length mtrs.	Pass/Fail
Startup Checks	Ext. #1									Pass / C.R./ Fail			
	Ext. #2									Pass / C.R./ Fail			
	Sample 1									Pass / C.R./ Fail			
	Sample 2									Pass / C.R./ Fail			
	Sample 1									Pass / C.R./ Fail			
	Sample 2									Pass / C.R./ Fail			
	Sample 1									Pass / C.R./ Fail			
	Sample 2									Pass / C.R./ Fail			
	Sample 1									Pass / C.R./ Fail			
	Sample 2									Pass / C.R./ Fail			
	Sample 1									Pass / C.R./ Fail			
	Sample 2									Pass / C.R./ Fail			
	Sample 1									Pass / C.R./ Fail			
	Sample 2									Pass / C.R./ Fail			
	Sample 1									Pass / C.R./ Fail			
	Sample 2									Pass / C.R./ Fail			
	Sample 1									Pass / C.R./ Fail			
	Sample 2									Pass / C.R./ Fail			
	Sample 1									Pass / C.R./ Fail			
	Sample 2									Pass / C.R./ Fail			

Comments:



# STEPS MODE

LOGGED USER  
operator

ID Tag

Alarm Text

7/7/2025  
1:22:36 AM

PRODUCTION MODE:

SILCS MODE

LINE STATUS  
[40] PRODUCTION

1 2 3 4 5 6 7 8

PRODUCER

AUTOMATIC INCREMENT

GO TO STEP: PROD.

THREADING CONFIGURATION

STEPS MODE CONFIGURATION

CASCADE/SINGLE ADJUSTMENT

	BASIC SPEED	1	2	3	4	5	6	7	8
EXTRUDER A	70 bar	70 bar	52.9 rpm	+25.4 %	70 bar	70 bar			
EXTRUDER B	70 bar	70 bar	53.1 rpm	+25.5 %	70 bar	70 bar			
EXTRUDER C	70 bar	70 bar	53.9 rpm	+26.1 %	70 bar	70 bar			
PUMP A	28.90 rpm	28.90 rpm	28.90 rpm	+32.2 %	74 bar	75 bar			
PUMP B	28.90 rpm	28.90 rpm	28.90 rpm	+30.5 %	70 bar	70 bar			
PUMP C	28.90 rpm	28.90 rpm	28.89 rpm	+28.3 %	71 bar	71 bar			

	ACTIVE SP	ACT. STEP SAVED	PV
TANK LEVEL	5.0 cm	30 °C	30 °C
DRAW STAND 1	36.4 m/l	70 °C	70 °C
DRAW STAND 2	202.3 m/l	90 °C	90 °C
DRAW STAND 3	163.8 m/l	90 °C	90 °C
DRAW STAND 4	160.0 m/l	22 °C	22 °C

SUPER HEATER 1 TEMP. 280 °C

STEAM CHANNEL 1 PRESS. 0.55 bar

STEAM CHANNEL 1 TEMP. 126 °C

OVER 2 - AIR SPEED 80%

OVER 2 - TEMP. 125 °C

OVER 3 - AIR SPEED 80%

OVER 3 - TEMP. 125 °C

STRETCHING		ANNEALING RATIO	
SP	5.56	(B-C)/B %	20.9%
PV	5.56	(C-D)/C %	2.3%
			20.9%

RECALL VALUES FROM RECIPE

EXTRUDER TEMPERATURES

FEEDING CONVEYING

EXTRUDER SPEEDS

LINE TEMPERATURES AND SPEED

STEPS MODE

RECIPES

TRENDS

MAINTENANCE

ALARMS & DIAGNOSTIC

REPORTS



# EXTRUDER TEMPERATURES

LOGGED USER  
operator

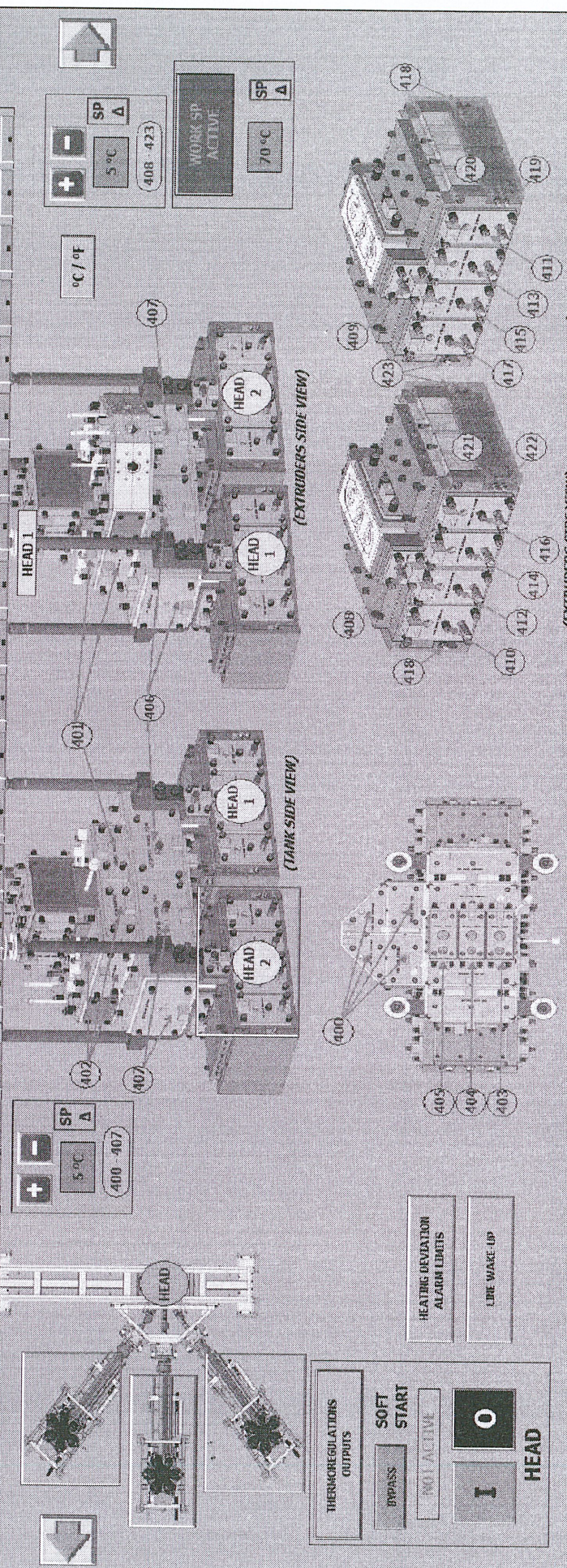
ID Tag

Alarm Text

Time

7/7/2025  
1:21:32 AM

OUT	20.2%	2.1%	1.4%	10.8%	11.8%	12.7%	20.2%	23.8%	0.0%	27.1%	25.8%	13.4%	37.9%	51.2%	42.0%	0.0%	16.8%	50.2%	34.8%	5.4%	41.9%	38.8%	7.2%	34.2%	
PV	225 °C	225 °C	225 °C	225 °C	224 °C	225 °C	225 °C	225 °C	228 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C	228 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C
SP	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C	225 °C
	400	401	402	403	404	405	406	407	408	409	410	411	412	413	414	415	416	417	418	419	420	421	422	423	423



EXTRUDER TEMPERATURES

FEEDING CONVEYING

EXTRUDER SPEEDS

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# FEEDING & CONVEYING

LOGGED USER  
operator

ID Tag

Alarm text

Time

7/7/2025  
1:22:16 AM

HOME

LOADER REFILL VALVE

**A**

MIXER WEIGHT  
1.2 kg

<b>1</b>	ON OFF	OPEN CLOSE AUTO	7.1 kg	ON OFF
<b>2</b>	ON OFF	OPEN CLOSE AUTO	2.2 kg	ON OFF
<b>3</b>	ON OFF	OPEN CLOSE AUTO	4.8 kg	ON OFF
<b>4</b>	ON OFF	OPEN CLOSE AUTO	3.6 kg	ON OFF
<b>5</b>	ON OFF	OPEN CLOSE AUTO	2.8 kg	ON OFF
<b>6</b>	ON OFF	OPEN CLOSE AUTO	3.4 kg	ON OFF

EXTRUDER - BIENDO A

**I** **O**

GLOBAL STATUS  
94 kg/h

ALARM

RESET

<b>1</b>	23%	76.0%	76.0%	5.0%	2606	RESET
<b>2</b>	0%	0.0%	0.0%	2.0%		RESET
<b>3</b>	18%	12.0%	12.0%	2.0%	KS1010B	RESET
<b>4</b>	41%	9.0%	9.0%	2.0%	OLIVE 1316	RESET
<b>5</b>	8%	2.0%	2.0%	2.0%	FUSABOND	RESET
<b>6</b>	5%	1.00%	1.00%	2.0%	TEGOMER-ANTI OXIDANT	RESET

TOTALIZER  
407.7 kg  
0.0 kg  
64.9 kg  
48.1 kg  
10.8 kg  
5.4 kg

LOADER REFILL VALVE

**B**

MIXER WEIGHT  
1.3 kg

<b>1</b>	ON OFF	OPEN CLOSE AUTO	3.5 kg	ON OFF
<b>2</b>	ON OFF	OPEN CLOSE AUTO	6.8 kg	ON OFF
<b>3</b>	ON OFF	OPEN CLOSE AUTO	5.1 kg	ON OFF
<b>4</b>	ON OFF	OPEN CLOSE AUTO	1.3 kg	ON OFF
<b>5</b>	ON OFF	OPEN CLOSE AUTO	1.4 kg	ON OFF
<b>6</b>	ON OFF	OPEN CLOSE AUTO	3.2 kg	ON OFF

EXTRUDER - BIENDO D

**I** **O**

GLOBAL STATUS  
93 kg/h

ALARM

RESET

<b>1</b>	22%	76.0%	76.0%	5.0%	2606	RESET
<b>2</b>	0%	0.0%	0.0%	2.0%		RESET
<b>3</b>	13%	12.0%	12.0%	2.0%	KS1010B	RESET
<b>4</b>	41%	9.0%	9.0%	2.0%	SPORTS 1317	RESET
<b>5</b>	8%	2.0%	2.0%	2.0%	FUSABOND	RESET
<b>6</b>	5%	1.00%	1.00%	2.0%	TEGOMER-ANTI OX	RESET

TOTALIZER  
410.3 kg  
0.0 kg  
65.4 kg  
48.8 kg  
58.8 kg  
5.5 kg

LOADER REFILL VALVE

**C**

MIXER WEIGHT  
1.3 kg

<b>1</b>	ON OFF	OPEN CLOSE AUTO	6.8 kg	ON OFF
<b>2</b>	ON OFF	OPEN CLOSE AUTO	3.4 kg	ON OFF
<b>3</b>	ON OFF	OPEN CLOSE AUTO	5.4 kg	ON OFF
<b>4</b>	ON OFF	OPEN CLOSE AUTO	2.4 kg	ON OFF
<b>5</b>	ON OFF	OPEN CLOSE AUTO	3.7 kg	ON OFF
<b>6</b>	ON OFF	OPEN CLOSE AUTO	2.2 kg	ON OFF

EXTRUDER - BIENDO C

**I** **O**

GLOBAL STATUS  
90 kg/h

ALARM

RESET

<b>1</b>	21%	77.0%	77.0%	5.0%	2606	RESET
<b>2</b>	0%	0.0%	0.0%	2.0%		RESET
<b>3</b>	17%	12.0%	12.0%	2.0%	KS1010B	RESET
<b>4</b>	37%	8.0%	8.0%	2.0%	APPLE 1315	RESET
<b>5</b>	7%	2.0%	2.0%	2.0%	FUSABOND	RESET
<b>6</b>	5%	1.00%	1.00%	2.0%	TEGOMER-ANTI OX	RESET

TOTALIZER  
414.4 kg  
0.0 kg  
65.1 kg  
43.3 kg  
10.8 kg  
5.4 kg

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