Weaver Setup Sheet

Design Name :saree_body_brocade_bt_weave_02

	DATE:	TIME:
OSL NO :	D.Date :	Order :
Buyer :	Qty :	Article :

WARP YARN	SHADE_1	SHADE_2	SHADE_3	SHADE_4	T.E	WEIGH
A) 21 Denier	silk_mulberry_20_22d				2640/ 1	0.012
SELVEDGE YARN						
A) 21 Denier	silk_mulberry_20_22d				32	0.000
					2672	0.012
WEFT YARN						
A) 21 Denier	#EDE6D6 silk_mulberry_20_22d				2832/59.94	0.012
B) 300 Denier	#C59B38 half_fine_gilt_copper_on_polyes.				2832/59.94	0.178
					5664	0.190
						0.202

REED = 57/2 PICKS = 60 REEDSPACE = 47.25 FINISH WIDTH = 45 METER = 1.797

WARP	WEFT	DRAFTING	PEG PLAN
2640 Ends	1 -silk_mulberry_20_.	jacquard - no draft	selectors 0-14
	2 -half_fine_gilt_co.		regulator 15
			selvedge 16-31
			design 32-2671
			selvedge 2672-2687
			4240 picks

Selvedge Name		greige	
Sel: 8D x 2E =	16	reed	60
Sec: 2640E x 1R =	2640	pick	60
Sel: 8D x 2E =	16	r.s	45
		gsm	12 g/m2
Total Ends	2672		

LOOM AND MACHINE FILE

Loom: Surat 2688-hook saree jacquard - jacquard, 2688 hooks, rapier weft insertion, reed up to 2900 mm

Machine file: jacquard/saree_body_brocade_bt_weave_02_LOOM_MONO.bmp - 2688 x 8480 px, 1 bit; one column per hook, one row per loom pick; pick 1 is the top row of the image as viewed (stored bottom-up, standard BMP)

Pixel: BLACK = hook lifted (warp end up over the weft)

Hook map (file columns from 0, left to right; hook number = column + 1):

- cols 0-14: weft selector hooks - exactly one is marked on every loom pick: the weft thrown
  - col 0 (selector 1): weft 1 - silk_mulberry_20_22d (ground)
  - col 1 (selector 2): weft 2 - half_fine_gilt_copper_on_polyester (zari)
  - cols 2-14: not used by this design
- col 15: regulator hook - marked on every supplementary-weft pick (the take-up holds: the pick is laid in the same line as its ground pick)
- cols 16-31: left selvedge, 16 ends, plain; at rest on a supplementary pick
- cols 32-2671: design, 2640 ends
- cols 2672-2687: right selvedge, 16 ends, plain; at rest on a supplementary pick
- The selector and regulator hooks carry no warp end.

WEFTS (AS SELECTED, IN THE ORDER SELECTED)

No	Role	Yarn (as selected)	Count	Colour	Selector
1	ground	silk_mulberry_20_22d	21 Denier	#EDE6D6	1
	- the ground: on every ground pick				
2	zari	half_fine_gilt_copper_on_polyester	300 Denier	#C59B38	2
	- thrown full width only on the picks that carry it; between motifs it floats on the back - cut those floats after weaving (cut-work)				
	- a zari is not dyed — it weaves in its own colour (half-fine (tested) zari: copper lametta silver-gilded in place of silver, 300D polyester core); #C59B38 in the design marks where it is woven				

THE DESIGN ON THE LOOM

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Design: 2640 ends x 4240 picks
Drawing: 1120 x 1800 mm (width x length on the cloth), woven at its true size
Lie: as drawn - its width across the warp, its top edge woven first, its left edge on
     the first end
Placement: the whole width of the design ends
Sett: 59.94 ends/inch x 59.94 picks/inch (23.60 x 23.60 per cm); 1 end = 0.424 mm, 1
      pick = 0.424 mm
Reed: 57/2 = Stockport 56.5 (dents in 2 inches) / 2 end(s) per dent - 28.27 dents per
      inch, 111.3 dents per 10 cm; 56.55 ends per inch in the reed (the cloth's 59.94
      drawn in by the 6.0 % weft crimp)
Reed space: 47.25 in (1200 mm) for 2672 ends in 1336 dents; with a whole 57/2 reed the
            1336 dents take 46.88 in
Same sett, other denting: 1 per dent = reed 113/1 (56.5 dents per inch, 2672 dents); 3
                          per dent = reed 38/3 (18.8 dents per inch, 891 dents); 4 per
                          dent = reed 28/4 (14.1 dents per inch, 668 dents)
Cloth on the loom: 2640 design ends + 32 selvedge ends = 2672 ends, 1132 mm (44.58 in)
Cloth length: 1797 mm; take-up 7.5 % (warp crimp 7.0 %, weft crimp 6.0 %)
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FOR THE CARD MAKER (JACQUARD CAD)
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Graph (point paper): 2640 ends x 4240 picks, one square = one end x one pick; EPI 59.94
                     : PPI 59.94 (graph ratio 1 : 1.000)
Face: woven FACE DOWN - a lifted hook takes its warp end over the weft on the upper
      side, so the weft shows on the face underneath (the loom's own cards are made this
      way); set the CAD to face down, lifted = mark
Float check: at most 8 threads, warp and weft - the cards break every longer float; set
             the same float limit in the CAD
Colour -> weave, every colour of the graph as the cards were cut:
  colour 0 #EDE6D7: the ground - ground weft 1 in satin on every ground pick
  colour 1 #C59B38: on the ground pick the ground weft weaves satin under it; then weft
                    2 on its own pick, on the face in the figure weave below (its floats
                    between motifs cut)
Weave repeats as hook lifts (1 = lifted; rows from pick 1, columns from end 1; tiled
  from the design's first end and first pick):
  satin (5 ends x 5 picks; 20 of 25 cells lifted - on the face, underneath, the weft
    shows on 20 of 25: weft-faced):
    . 1 1 1 1
    1 1 . 1 1
    1 1 1 1 .
    1 . 1 1 1
    1 1 1 . 1
  figure weave - a figure weft's own pick (8 ends x 8 picks, 1 = the figure weft on the
    face = hook lifted), inside its colour only:
    . 1 1 1 1 1 1 1
    1 1 1 . 1 1 1 1
    1 1 1 1 1 1 . 1
    1 . 1 1 1 1 1 1
    1 1 1 1 . 1 1 1
    1 1 1 1 1 1 1 .
    1 1 . 1 1 1 1 1
    1 1 1 1 1 . 1 1
Denting: 2 end(s) per dent, body and selvedge (reed count above)
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WEAVES
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Ground: satin (repeat 5 ends x 5 picks)
Figure: satin (repeat 5 ends x 5 picks)
Self-tone figure: the ground weft in sateen (repeat 5 ends x 5 picks)
Note: the repeat is woven as one period of 354 ends x 425 picks (150 x 180.085 mm; drawn
      150 x 180 mm), laid edge to edge — every repeat identical
Note: the ground colour is covered everywhere by the figure: weft weft1 (the colour
      nearest the ground) weaves the cloth's ground structure
Note: the motifs drawn in the ground colour are woven self-tone: the ground weft in
      sateen on the satin ground
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WEFT ORDER
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Each design pick throws, in this order (of 4240 design picks):
  weft 1 (ground) then weft 2: 4240 picks
Loom picks: 4240 ground picks + 4240 supplementary picks = 8480
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NOTES - READ BEFORE WEAVING
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Woven: the repeat is woven as one period of 354 ends x 425 picks (150 x 180.085 mm;
       drawn 150 x 180 mm), laid edge to edge — every repeat identical
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Woven: the ground colour is covered everywhere by the figure: weft weft1 (the colour
       nearest the ground) weaves the cloth's ground structure
Woven: the motifs drawn in the ground colour are woven self-tone: the ground weft in
       sateen on the satin ground
Quantities on this sheet are net: the yarn in the cloth plus 2 % loom waste;
  costing/yarn_bom.json adds the process waste.
The costs in costing/yarn_bom.json are at reference yarn and loom rates - price the
  order at your own.
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FILES IN THIS ZIP

README.txt: this setup sheet as plain text
compliance/compliance.json: the compliance summary: the standards and limits that apply
                            (JSON)
compliance/gots.json: GOTS: whether it applies (JSON)
compliance/oekotex.json: OEKO-TEX Standard 100 limits for the product class (JSON)
compliance/reach.json: EU REACH (EC 1907/2006) requirements (JSON)
design/weave_design.json: the design specification the machine file was made from (JSON)
jacquard/saree_body_brocade_bt_weave_02_LOOM_MONO.bmp: the machine file - load it on the
  loom
pdf/weaver_sheet.pdf: this weaver setup sheet
preview/woven.glb: the woven preview, 3D
preview/woven.png: the woven preview image
preview/woven_detail.png: the woven cloth at thread scale - the weave as the file weaves
                          it
manifest.json: every file with its size and SHA-256
CHECKSUMS.txt: the SHA-256 of every file
manifest.sig: the signature of the manifest

WOVEN PREVIEW

saree_body_brocade_bt_weave_02 (880 x 1413 px)

