

Asking the right questions

On Roller no 2 there is an 8in needlefelt overlap. The overlap creates a high spot which shows up as a dark horizontal strip.

Sevenside's Gary White explains the ironer clothing choices.

Correctly chosen and fitted clothing, in good condition and run on well-maintained equipment is essential to the laundry finishing operation. Calender clothing is used to pad out a hollow roller to a specific diameter so that the whole fits evenly into the contour of the bed, ensuring uniform contact between bed and roller, essential to maximising quality, throughput and drying efficiency. The clothing should be permeable, heat resistant and resilient and must be the correct type, weight, width and length (measured in a full number of turns).

The original specification should be in the ironer's manual, but clothing suppliers can calculate a spec to individual needs, taking into account the ironer's operating steam temperature, the quality and type of work being handled, the required life of the clothing, and whether the original ironer spec has been modified.

High pressure

The ironer operating temperature determines the quality of calender clothing needed, but clothing designed to withstand higher steam pressures (up to 220psi) will also work well in the lower ranges and while more expensive, will last longer. The class of work and quality needed will affect ironer temperature and speed.

Good ironer maintenance is crucial and includes correct operation of steam traps, air-vents, vacuum fans and air pressures. Clothing should be fitted oversized and the air pressure reduced to allow the clothing to bed-in before cutting back overlaps.

Other factors affecting clothing life include moisture retention of the linen, the condition of the ironer beds, which should be waxed at least twice a day, and the performance of the springs and/or base clothing.

If the clothing does not last as long as it should, this may be a symptom of an underlying problem. It is always worth checking the following points.

- If the roller uses springs, are they in good condition?
- If the roller has base clothing, when was this last changed?
- Have the correct number of turns been used and is the clothing the right



- quality, weight, width and thickness?
- Has the steel measuring tape supplied with the ironer been used to check that the circumference of the roller (when padded) is within permitted limits?
- Is the new clothing bedded in?
- Have the overlaps been cut back four days after fitting? Failure to do so will create high spots.
- Was the calender reclothed at full steam pressure? It cannot be reclothed when cold.
- Where applicable, is the top clothing lapped into the under clothing a half turn?
- Are the clothing overhangs on either side of the roller equal?

Clothing development

Sevenside and sister company ELP have developed a hiperm polyester needlefelt to combat the effects of hydrolysis by needling coarser denier polyester fibres to a stronger filament scrim. So this hiperm has a greater tensile strength and a

higher permeability than standard polyester needlefelts. The greater tensile strength results in a more stable, longer lasting felt, even on larger diameter rollers, and the increased permeability ensures a greater airflow through the felt so it remains drier, thus reducing the effects of hydrolysis. ■

Clothing on a cutting table. Clothing must be measured and cut accurately to length and also cut on the square.

