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**TEXTILE INDUSTRY STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

FZ/T 93030-2007

Replacing FZ/T 93030-1994

**Textile machinery and accessories. Cones for cross winding.
Technology terms**

纺织机械与附件 交叉卷绕用圆锥形筒管 技术条件

(English Translation)

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Table of Contents

Foreword

1 Scope

2 Normative references

3 Requirements

Foreword

Instead of the standard FZ/T 93030-1994 "cross winding winder with conical tubes" in the part, not in place of covering cross Main dimensions fork with conical winding bobbin, tolerances and marking. GB/T 20035-2005 is half cone angle of $3^{\circ} 30'$, $4^{\circ} 20'$ and $5^{\circ} 57'$ 'cross Fork with conical winding bobbin dimensions, tolerances and the national standards. Cross winding included with main dimensions recommended values cone bobbin GB/T 20035 Part 1, its dimensions, tolerances and marking according to different half cone angle are included in Part 2 GB/T 20035 of ~ Part 5, are listed below international standards and the structure of the national standard corresponding to.

GB/T 20035-2005 "Textile machinery and accessories with a conical cross-wound bobbin"

--- Part 1. Recommended main dimensions value (ISO 8489-1:1995, IDT);

--- Part 2. half cone angle of $3^{\circ} 30'$ cone bobbin dimensions, tolerances and marking (ISO 8489-2:1995, IDT);

--- Part 3. half cone angle of $4^{\circ} 20'$ cone bobbin dimensions, tolerances and marking (ISO 8489-3:1995, IDT);

--- Part 4. half cone angle of $4^{\circ} 20'$ stained with conical bobbin dimensions, tolerances and marking (ISO 8489-4:1995, IDT);

--- Part 5. half-cone angle of $5^{\circ} 57'$ cone bobbin dimensions, tolerances and marking (ISO 8489-5:1995, IDT).

Compared with this standard FZ/T 93030-1994, the main changes are as follows.

a) by deleting the half cone angle of $9^{\circ} 15'$ cone bobbin size and gauge its provisions;

b) by deleting according to the pipe material, the small end of the structure, classification provisions of the semi-cone angle conical tube and associated Figs. 1 to 8 and Table 1 ~

Table 3;

c) the deletion of the "mark of the tapered tube method" requirement;

- d) increase "substantially conical tube size, limit deviations" and its measuring "gauge dimensions, tolerances and the use of" should be consistent GB/T 20035.2-2005, GB/T 20035.3-2005, GB/T 20035.5-2005 provisions of Chapter 5;
- e) In the inspection rules, add "There is one or more than one failure, is substandard goods," the decision rule;
- f) In the inspection rules, add "In a sample of units" description;
- g) In the inspection rules, the type of test items to increase the quality of testing, the substandard quality level of 20, classified as substandard C;
- h) by deleting the chapter on packaging box predetermined and packaging Pictorial marking tied;
- i) by deleting "Appendix A inner diameter measuring method";
- j) other necessary editorial changes.

The standard proposed by China Textile Industry Association.

This standard by the National Standardization Technical Committee Textile machinery and accessories.

This standard by the Shaanxi Institute of Textile Equipment, Zhejiang Sanyou Plastic Industry Co., Ltd. is responsible for drafting.

1 Scope

This standard specifies the conical cross-wound bobbin with the requirements, test methods, inspection rules, packaging and identification.

(Hereinafter referred to as "tapered pipe").

2 Normative references

The following documents contain provisions which, through reference in this standard and become the standard terms. For dated references, subsequent Amendments (not including errata content) or revisions do not apply to this standard, however, encourage the parties to the agreement are based on research Whether the latest versions of these documents. For undated reference documents, the latest versions apply to this standard.

GB/T 191 Packaging - Pictorial signs GB/T 1958 Geometrical Product Specifications (GPS) shape and position tolerance testing requirements GB/T 2828.1 Sampling procedures for inspection - Part 1. by acceptance quality limit (AQL) retrieval batch inspection sampling plan (ISO 2859-1:1999, IDT) GB/T 2829 periodic inspection Sampling procedures and tables (suitable for process stability test) GB/T 4892 hard straight cube transport packaging size series GB/T 6543-1986 corrugated boxes GB/T 6544-1999 corrugated cardboard

packaging material GB/T 20035.1-2005 Textile machinery and accessories with a conical cross-wound tubes - Part 1. Recommended main dimensions value (ISO 8489-1:1995, IDT) GB/T 20035.2-2005 Textile machinery and accessories with a conical cross-wound tubes - Part 2. half cone angle of $3^{\circ} 30'$ cone Shaped bobbin dimensions, tolerances and marking (ISO 8489-2:1995, IDT) GB/T 20035.3-2005 Textile machinery and accessories with a conical cross-wound tubes - Part 3. half cone angle of $4^{\circ} 20'$ cone Shaped bobbin dimensions, tolerances and marking (ISO 8489-3:1995, IDT) GB/T 20035.5-2005 Textile machinery and accessories with a conical cross-wound tubes - Part 5. half-cone angle of $5^{\circ} 57'$ cone Shaped bobbin dimensions, tolerances and marking (ISO 8489-5:1995, IDT)

3 Requirements

The basic dimensions of 3.1 conical tube, limit deviations shall comply with GB T 20035.1 ~ 20035.3-2005, GB/T 20035.5-2005 provisions /.

3.2

conical oblique tube runout should be specified in Figure 1.

NOTE: $\alpha/2$ of $3^{\circ} 30'$, $4^{\circ} 20'$, $5^{\circ} 57'$.

Figure 1 obliquely conical tube runout