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FZ

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

FZ/T 93033-2014

Replacing FZ/T 93033-2004

**Flat carding machines
(English Translation)**

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Foreword

This standard was drafted in accordance with GB/T 1.1-2009 given rules.

Instead of the standard FZ/T 93033-2004 "carding," this standard FZ/T 93033-2004 compared to the main technical changes are as follows.

- Modify the standard English translation of the name (see the cover of the 2004 version of the cover);
- Modify the parameters (see Table 1, Table 1 of the 2004 edition);
- Increased requirements for feed device (see 4.1);
- Modified cylinder, Astoria bearing amplitude requirements (see 4.2.1, 2004 Edition 4.1.1.);
- Increasing the cylinder barrel, cylinder allowable amount of unbalance, Astoria cylinder, pre-carding board requirements (see 4.2.2, 4.2.3, 4.2.4, 4.2.9);
- Stable chassis modified rotary, top plate amplitude requirements (see 4.3, 2004 version 4.2.);
- Increasing the whole machine should be GB/T 17780.1, the provisions of GB/T 17780.2 take safety precautions and warnings to avoid products in the course of the damage to human health requirements (see 4.6.3);
- Increased electrical fast transient burst immunity performance, electrostatic discharge immunity performance requirements for connections and cabling, wire logo (see 4.7.1, 4.7.2, 4.7.3, 4.7.4);
- Modify the whole machine noise (sound power level) requirements, increasing the sound pressure level of emission requirements (see 4.8, 2004 version 4.7.);
- Modify the power consumption requirements (see 4.8, 2004 version 4.8.);
- Modify the unit of measure and weight unevenness parameters (see table 4, 2004 edition Table 3);
- Increasing the sliver weight unevenness calculation method (see 5.1.21);
- Modify the workload of the test conditions (see 5.3. 1, the 2004 version 5.2.1).

The standard proposed by China Textile Industry Association.

This standard by the National Standardization Technical Committee mechanical accessory spinning, dyeing and finishing of textile machinery and Technical Committee (SAC/TC215/SC1) Centralized.

This standard was drafted. National Textile Machinery Quality Supervision and Inspection Center, Qingdao Hongda Textile Machinery Co., Ltd., Zhengzhou Hongda New Type Textile

Machinery Co., Ltd., Cross Rolle Machinery (Shanghai) Co., Ltd., Qingdao Textile Machinery East-kai (Group) Co., Ltd., Zhuo Lang (Jintan) Textile Weaving Machinery Co., Ltd., the first textile machinery plant in Qingdao Jimo, Qingdao Textile Machinery Manufacturing Co., Fairmont.

1 Scope

This standard specifies the classification and carding parameters, requirements, test methods, inspection rules, marking, packaging, transportation and storage.

This standard applies to fiber and cotton wool, linen, chemical fiber, long fiber carding cotton.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated version suitable for use herein Member. For undated references, the latest edition (including any amendments) applies to this document.

GB/T 191 Packaging - Pictorial signs GB 2894 Safety Signs and use guidelines GB 5226.1-2008 Safety of machinery - Electrical machinery and electrical equipment - Part 1. General requirements GB/T 7111.1 Textile machinery - Noise test code - Part 1. General requirements GB/T 7111.2 Textile machinery - Noise test code - Part 2. spinning preparatory and spinning machinery GB/T 9239.1-2006 mechanical vibration steady state (rigid) rotor balance quality requirements - Part 1. specification of tolerance and balance test GB/T 17626.2-2006 Electromagnetic compatibility - Testing and measurement techniques - Electrostatic discharge immunity test GB/T 17626.4-2008 Electromagnetic compatibility - Testing and measurement techniques - Electrical fast transient burst immunity test GB/T 17780.1 Textile machinery - Safety requirements - Part 1. General requirements GB/T 17780.2 Textile machinery - Safety requirements - Part 2. Spinning preparatory and spinning machinery GB Z/T 192.1-2007 workplace dust in the air measurement - Part 1. total dust concentration FZ/T 90001 Textile machinery Packaging FZ/T 90074 textile machinery products Painting FZ/T 90089.1 textile machinery nameplate types, sizes and technical requirements FZ/T 90089.2 textile machinery nameplate content FZ/T 92029 Card cover skeleton FZ/T 93019 carding elastic flat clothing FZ/T 93038 carding machine rack FZ/T 93089 feed hopper FZ/T 93090 Pre-carding plate FZ/T 99014-1995 Textile machinery and electrical equipment and technical conditions

3.1 Classification

3.1.1

Maximum output speed is divided into. ordinary type, high speed type.

3.1.2

according to the type of cotton is divided into. lap feed, feed hopper.

3.2 Parameter

Parameters in Table 1.

Table 1

Project Parameters

Suitable for spinning fiber length/mm 22 ~ 65 Working width/mm 1000 ~ 1500 Lap
maximum working diameter x width/mm 550 x 980 Hopper Working width/mm 920 ~ 1500
Sliver/(g/m) 3 ~ 12 the maximum output/(m/min)

4.1 Feeding device

4.1.1

feeding device speed is adjustable.

4.1.2

using feed hopper, feed hopper should be consistent FZ/T 93089 requirements.

4.2 Carding system

4.2.1

cylinder, bearing amplitude Astoria. Normal is not greater than 0.07mm, high-speed type is not greater than 0.035mm.

4.2.2

cylinder radial runout tolerance of the outer cylinder axis is not more than 0.025mm.

4.2.3

cylinder allowable unbalance shall comply with GB/T 9239.1-2006 the balance quality grade G1.6 requirements.

4.2.4

Astoria outer cylinder axis radial runout tolerance is not greater than 0.020mm.

4.2.5

Cover shall comply FZ/T 92029 of.

4.2.6

There should be no cover ups and downs phenomenon obviously, the amount of deviation is not greater than 1.0mm.