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FZ

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

FZ/T 93036-2017

Replacing FZ/T 93036-1995

Electro-automatic doffer

电动落纱机

(English Translation)

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Foreword

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

This standard replaces FZ/T 93036-1995 "electric doffer", compared with the FZ/T 93036-1995 main technical changes are as follows.

- Modify the scope (see Chapter 1, 1995 edition);
- Increased classification (see 3.1);
- Modify the parameters (see 3.2, 1995 edition 1);
- Modify the doffing time (see 4.1, 1995 edition Table 2);
- Pulling rate, intubation rate was edited (see 4.2, 4.3, 1995 edition Table 2);
- Removed broken rate and broken rate calculation formula (see 1995 version of the table 2,3.3);
- Increasing the head rate and head rate calculation formula (see 4.4,5.1.4);
- Modify the transmission system (see 4.5, 1995 version 2.2);
- Modify the yarn pulling mechanism (see 4.7, 1995 version 2.3);
- Modify the pipeline, intubation agencies (see 4.6, 1995 version 2.4);
- Increasing the level of the upper and lower rail surface (see 4.8);
- Increasing the upper and lower track straightness (see 4.9);
- Increased pneumatic system (see 4.10);
- Modify the electrical equipment (see 4.11, 1995 version 2.5);
- Remove the frame and appearance (see 1995 version 2.6);

- Increased safety and environmental protection (see 4.12);
- Increased painting (see 4.13);
- Added empty running test, work load test (see 5.2,5.3);
- Modify the inspection rules (see Chapter 6, 1995 edition 4).

This standard proposed by the China Textile Industry Federation.

This standard by the National Textile Machinery and Accessories Standardization Technical Committee spinning, dyeing and finishing machinery Technical Committee (SAC/TC215/SC1) centralized.

This standard was drafted unit. Tongling Songbao Intelligent Equipment Co., Ltd., the State Textile Machinery Quality Supervision and Inspection Center, Rizhao Yuhua machine Machinery Co., Ltd.

1 Scope

This standard specifies the classification of electric doffing machine and parameters, requirements, test methods, inspection rules and signs, packaging, transportation and storage.

This standard applies to cotton, hemp, wool and chemical fiber pure spinning, ring spinning machine and twisting machine supporting the use of electric doffing machine.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated version applies to this article Pieces. For undated references, the latest edition (including all amendments) applies to this document.

GB/T 191 Packaging - Pictorial signs GB 2894 safety signs and guidelines for their use Mechanical and electrical safety - Mechanical electrical equipment - Part 1. General specifications GB/T 17780.4 Textile machinery safety requirements - Part 4. Yarn and rope processing machinery FZ/T 90001 textile machinery product packaging FZ/T 90074 textile machinery product coating FZ/T 90089.1 Textile machinery nameplate type, size and technical requirements FZ/T 90089.2 textile machinery nameplate content FZ/T 92023-2008 Cotton spinning ring spindle

3.1 Classification

3.1.1

according to extubation method is divided into.

- Disc-type extubation;

--- Manipulator extubation.

3.1.2

Pull the tube position is divided into.

--- extubation at the top;

--- Central extubation;

--- Extubation at the bottom.

3.1.3

by walking divided into.

--- continuous walking;

--- Gap-type walk.

3.2 Parameters

Electric doffing machine parameters in Table 1.