

ICS 59.120.10
CCS W 93

FZ

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

FZ/T 93064-2017

Replacing FZ/T 93064-2006

Bottom rollers of drafting systems for cotton roving frame

棉粗纱机牵伸下罗拉

(English Translation)

Issued on: April 12, 2017

Implemented on: October 1, 2017

**Issued by: Ministry of Industry and Information Technology of the
People's Republic of China**

Table of Contents

- Foreword
- 1 Scope
- 2 Normative references
- 3 Classification, parameters and tags
- 3.1 Classification

Foreword

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

This standard replaces FZ/T 93064-2006 "cotton roving drafting lower roller." Compared with the FZ/T 93064-2006, the main changes as follows.

- Increased range of markers and parameters, expanding the scope of the standard (see Chapter I);
- Remove the "bottom roller structure", an increase of classification, marking (see Chapter 3, 2006 edition of Chapter 3);
- Added the original table 1 specifications and the spindle gauge project, an increase of the specifications in Table 2 (see 3.2 Table 1, Table 2);
- Added product mark (see 3.3);
- Under the provisions of the material used by the specific requirements of the roller (see 4.1, 2006 version 4.1);
- Increased the working surface of the bottom roller hardness requirements (see 4.2, 2006 version 4.2);
- Increased the requirements of the bottom roller coating (see 4.3);
- Increased table 3 in the lower end of the surface mount Raval surface roughness requirements (see 4.5 Table 3, 2006 edition 4.3 Table 3);
- Added lower roller bearing neck related parameters and testing (see Table 3, Table 4, Table 5, Table 6, Figure 3, Figure 4, Figure 5);
- Adjust the bottom roller length tolerance requirements (see 4.6 Table 4, 2006 edition 4.5 Table 4);
- Improve the lower roller guide column cylindrical outer diameter and the guide circle beating round, guide column, the guide hole round the end of the round beating and the

lower roller face cylindrical Requirements for radial circular beating (see Table 4.7, Table 5 of 2006 version 4.6);

--- Modify the product line pass rate determination method (see 6.3.2).

Please note that some of this document may be patentable. The issuing agencies of this document do not bear the responsibility of identifying these patents.

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. Changzhou Tonghe Textile Machinery Manufacturing Co., Ltd., National Textile Machinery Quality Supervision and Inspection Center, Shanxi Jingwei Textile Weaving Machinery Parts Co., Ltd., Dongtai Run-Textile Machinery Parts Co., Ltd., Shanghai Textile Machinery Parts Co., Ltd., Tianjin grand Textile Machinery Co., Ltd., Hebei Taihang Textile Machinery Co., Ltd., Wuxi Hongyuan Electrical Technology Co., Ltd.

1 Scope

This standard specifies the cotton roving drafting draft roller (hereinafter referred to as "bottom roller") classification, parameters and labeling, requirements, test methods, testing Rules, marking, packaging, shipping and storage.

This standard applies to cotton roving machine drafting device with groove and knurled shape of the bottom roller.

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/T 699 high-quality carbon structural steel Textile machinery - Terminology - Part 1. Textile spinning drafts FZ/T 90001 textile machinery product packaging

3.1 Classification

3.1.1

Press the roller mounting position is divided into output bottom roller, bottom roller and feed bottom roller.

NOTE The definition of output lower roller, middle lower roller and feed lower roller is given in GB/T 6002.1-2004

3.1.2

Press roller surface is divided into the shape of the bottom roller groove (see Figure 1) and knurled bottom roller (see Figure 2).

Note: Face refers to the outer surface of the groove or knurled shape.

figure 1