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

FZ/T 94037-2019

Technical provisions of temple cylinders for looms

织机用边撑刺轴技术条件 清晰版

(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 94037-1995 "Barbed Ring Braces for Looms". Compared with FZ/T 94037-1995, except for editorial changes in addition, the main technical changes are as follows.

- The standard name "Barbed Ring Braces for Looms" was changed to "Technical Conditions for Barbed Shafts for Looms";
- Deleted the rules for classifying the side brace shafts according to the requirements of use (see 1995 version 3.2);
- Removed the terms and basic dimensions of the side brace shaft (see 1995 version 3.3);
- Revised the regulations on the marking method of the side support barbed shaft (see Chapter 3, 1995 version 3.4);
- Revised the limit deviation regulations for the basic dimensions of the temple bar (see 4.1, 1995 version 3.3);
- Removed the regulations for the materials of the side brace shaft (see the 1995 edition of 4.1);
- Added the rule that the straightness of the thorn tip of the side support thorn shaft should not be greater than 0.5mm (see 4.2);
- Modify "The axial gap between the thorn ring and the ring seat on the use surface should not be greater than 0.2mm" to "The axial gap between the thorn ring and the ring seat should not be large at 0.12mm "(see 4.3, 4.6 of 1995 edition);
- Modify "the maximum allowable value of the surface roughness Ra of the thorn ring is 3.2μm" to "the surface roughness Ra value of the thorn ring should not be greater than

1.6μm "; the maximum allowable value of the needle/pricking surface roughness Ra is 1.6μm "is modified to" needle/pricking surface roughness Ra value is not should be greater than 0.8μm "(see 4.4, version 4.3 of 1995);

--- Increased the requirements of needle/puncture hardness and its test method (see 4.5, 5.3);

--- Chapter 5 added "5.5 Flexibility of the pricking ring, combined application of needle/pricking and pricking ring feel, visual inspection.";

--- Chapter 6 adds the relevant provisions of type inspection (see 6.2.1);

--- Revised the relevant provisions of the factory inspection in Chapter 6 (see 6.2.2, Chapter 6 of the 1995 edition);

--- Modify the title "Packaging, Marking" in Chapter 7 to "Packaging, Marking and Transportation" and related regulations.

This standard was proposed by the China National Textile and Apparel Council.

This standard is adopted by the National Textile Machinery and Accessories Standardization Technical Committee Textile Equipment Sub-Technical Committee (SAC/TC215/SC2) be in charge.

Introduction

Amend the national standard formulated by the international standard ISO 8118-1.:2006 "Textile machinery loom side brace part 1. side brace shaft" GB/T 30167.1-2013 "Textile machinery loom side brace part 1. side brace shaft", specifies the terms and Definitions, names, specifications and marks play an active role in eliminating technical barriers in international trade. However, the lack of its normative technical elements not only is it difficult to meet the requirements of product users under the conditions of China's market economic system, but also the operability in use is poor. although the revised version of the industry standard FZ/T 94037-1995 "Barbed Ring Braces for Looms" is a non-equivalent international standard ISO 8118-1986 "Machine Manufacturing-Barbed Shaft Braces", its product classification chapter covers the components of the barbed shaft, classification, main terms, basic size and its limit deviation Differences and marks, other chapters are technical requirements, test methods, inspection rules, and normative technical elements of packaging and marking, but they have been unable to meet Requirements for product users of the development of contemporary weaving technology. At the same time, to support the national standard GB/T 30167.1-2013, therefore, repair FZ/T 94037-1995 is based on the national standard GB/T 30167.1-2013, which will effectively improve the applicability of this standard.

Technical conditions for side support barbed shaft for loom

1 Scope

This standard stipulates the marking, requirements, test methods, inspection rules, packaging, marking and transportation of the side support barbed shaft for loom.

This standard is applicable to the side support thorn shaft (hereinafter referred to as the "side support thorn") used to control the width of the fabric during the weaving process of a shuttle loom or a shuttleless loom axis").

2 Normative references

The following documents are essential for the application of this document. For dated references, only the dated version applies to this article. For the cited documents without date, the latest version (including all amendments) applies to this document.

GB/T 191 Graphic mark for packaging, storage and transportation GB/T 2828.1 Counting sampling inspection procedures Part 1. Sampling plan for batch-by-batch inspection retrieved by acceptance quality limit (AQL) GB/T 2829 periodic inspection count sampling procedures and tables (applicable to the inspection of process stability) GB/T 4340.1 Metallic materials Vickers hardness test Part 1. Test method GB/T 30164-2013 Textile machinery and accessories Spinning preparation and steel needles for spinning machinery GB/T 30167.1-2013 Textile machinery loom side brace part 1. side brace shaft

3 Mark

The marking method of the side support barbed shaft shall comply with the provisions of Chapter 5 of GB/T 30167.1-2013.

4 Requirements

4.1

The basic dimensions and limit deviation of the side support barbed shaft.

- a) The basic dimensions should comply with the provisions of Chapter 4 of GB/T 30167.1-2013;
- b) The limit deviation of the basic dimensions shall meet the requirements of Table 1.

Table 1 The limit deviation unit of basic size is mm

Basic size	Needle/puncture height t	Ring outer diameter d2	Ring aperture d3	Ring thickness b	Roller length l	Limit deviation
	± 0.05	0.050	0.08	0.04	± 0.02	± 0.5

4.2

The straightness of the thorn tip of the side brace shaft should not be greater than 0.5mm.

4.3

The barbed ring and the bushing should be firmly connected, and the combined body should operate flexibly. The axial gap between the barbed ring and the ring seat should not be greater than 0.12mm.

4.4

The surface roughness Ra value of the barbed ring should not be greater than 1.6 μ m; the needle/barb surface roughness Ra value should not be greater than 0.8 μ m.

4.5

Needle/puncture Vickers hardness shall comply with the provisions in 3.2 of GB/T 30164-2013.

4.6

Needle/puncture should be smooth, should not be bent, broken tip, barb and rust.

4.7

The needle/puncture and puncture ring should be firmly combined, and should not be loosened or detached.