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FZ

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

FZ/T 94047-2012

Replacing FZ/T 94047-1999

**Sectional warping machine
(English Translation)**

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Table of Contents

- Foreword
- 1 Scope
- 2 Normative references
- 3 Product type and main technical parameters

Foreword

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

Instead of the standard FZ/T 94047-1999 "section warping machine." this standard FZ/T 94047-1999 compared to the main changes are as follows.

- Original standard 3.1.1 Replace the "Host Type. drum movement, its cone taper fabric according to requirements to determine";
- Original standard 3.1.3 Replace the "creel types. rectangular frame, V-shaped frame, rectangular shaped -V double frame";
- Original standard 3.2.1 Replace the "warp speed $\leq 1000\text{m/min}$, stepless adjustable; beaming speed $\leq 200\text{m/min}$, no Level, adjustable ";
- Original standard 3.2.3 Replace the "roller diameter. 500mm, 800mm, 1000mm";
- Add "3.2.4 Adaptation weaving shaft with a flange maximum diameter. 1250mm";
- Original content to standard 4.2 "warping noise emission sound pressure level $\leq 75\text{dBA}$, noise emission sound pressure level $\leq 82\text{dBA}$ when beaming";
- Original content to a standard 4.4 "warping, beaming to maintain constant linear speed of the winding, the maximum difference of $\pm 1\%$ ";
- Original content to a standard 4.5 "warping, the difference between different cheese yarn unwinding tension. 20g or less, $\pm 2\text{g}$; 20g ~ 60g, $\pm 3\text{g}$; 60g or more, $\pm 5\text{g}$ ";
- Original content standard 4.8 changed to "roll runout before spraying $\leq 0.2\text{mm}$, after spraying $\leq 0.4\text{mm}$ ";
- Original content to the standard 4.14 "random security devices should be complete. electrical and electronic equipment and control devices conform GB 5226.1 provisions; mechanical safety in line with GB/T 17780 requirements ";
- Increase "4.20 warping station guide roller runout $\leq 0.04\text{mm}$ ";

- Increase "4.21 warping length Comptroller error $\leq 0.2\%$ ";
- Original content to the standard 5.7 "and 4.20 with a dial indicator to detect 4.8,4.11,4.12";
- Increase 5.14.1 Test conditions "a) Width. 2300mm";
- Increase "5.16 threading car parking 100m, with the meter stick measuring, testing 4.21." the standard proposed by China Textile Industry Association.

This standard by the National Standardization Technical Committee Textile machinery and accessories (SAC/TC215) centralized.

The fourth standard Jiangyin Textile Machinery Manufacturing Co., Ltd., Jiangyin Huafang New Technology Research Ltd., Shaoxing Dingfeng Textile device Material Co., Ltd. is responsible for drafting.

1 Scope

This standard specifies the type of sectional warping machines, the main technical parameters, technical requirements, test methods, inspection rules and signs, packaging, transportation Transport and storage.

This standard applies to cotton, wool, linen, silk, chemical fiber and blended yarn warping with a sectional warping machine.

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 5226.1 mechanical and electrical safety of machinery - Electrical equipment - Part 1. General requirements GB/T 7111.6 Textile machinery - Noise test code - Part 6. Weaving Machinery GB/T 8461 Textile machinery and accessories - Cone sectional warping machine Maximum effective width GB/T 9239.1-2006 mechanical vibration steady state (rigid) rotor balance quality requirements - Part 1. specification of tolerance and balance test GB/T 17780 Textile machinery - Safety requirements GB/T 20034 Textile machinery and accessories - Main dimensions warp creel FZ/T 90001 Textile machinery Packaging FZ/T 90035 Textile machinery terminology warping axis and main dimensions 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

3 Product type and main technical parameters

Type 3.1

3.1.1

Host Type. drum movement, which is determined according to taper cone fabric requirements.

3.1.2

beaming pattern. fixed and mobile.

3.1.3

creel types. rectangular frame, V-shaped frame, rectangular shaped -V duplex frame.

3.2

The main technical parameters 3.2.1 warping speed $\leq 1000\text{m/min}$, stepless adjustable; beaming speed $\leq 200\text{m/min}$, stepless adjustable.

3.2.2

Sectional warping machine maximum effective width in line with GB/T 8461.

3.2.3

Roller diameter. 500mm, 800mm, 1000mm.

3.2.4

Adaptation weaving shaft with a flange maximum diameter. 1250mm.

3.2.5

warping major axis dimensions conform FZ/T 90035.

3.2.6

creel main dimensions conform to GB/T 20034.