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

FZ/T 94049-2018

Replacing FZ/T 94049-2006

**Batch warping machine
(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 94049-2006 "Batch Warping Machine". In addition to editorial changes, mainly compared to FZ/T 94049-2006 the technical changes are as follows.

- Removed the classification of the warping machine according to the pressure type (see 3.1.2 of the 2006 edition);
- Change the warp line speed from 1000m/min to 1200m/min, and the maximum nominal width from 2000mm to 3200mm (see 3.2.1 and 3.2.2, 2006 editions 3.2.1 and 3.2.2);
- "The diameter of the warping shaft" has increased by 1250mm and 1400mm (see 3.2.3, 3.2.3 of the 2006 edition);
- "Main technical parameters", increased the range of winding density and single yarn tension (see 3.2.7 and 3.2.8);
- Increased the parallelism between the pressure roller and the warp beam, the yarn guide roller and the warp beam (4.1.3 and 4.1.5);
- Increased requirements for the up and down axis, the warp beam, the telescopic limit (see 4.1.6, 4.1.7, 4.1.8);
- Increased the requirements of the control system (see 4.3);
- Modify and refine the safety and environmental requirements (see 4.4.1~4.4.4, 2006 edition 4.13.2~4.13.4);
- Revised the requirements for the reliability of the self-stop of the warp (see 4.6.4, 4.5 of the 2006 edition);
- Modified and refined the requirements for tension fluctuation of single yarn (see 4.6.5, 4.6 of 2006 edition);

--- Removed the requirements of the motor (see 4.13.5 in 2006);

--- Increased power requirements during commissioning (see 5.2.1a).

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

This standard is under the jurisdiction of the National Textile Machinery and Accessories Standardization Technical Committee.

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1 Scope

This standard specifies the type and main technical parameters, requirements, test methods, inspection rules, marking, packaging, transportation and Storage.

This standard is applicable to batch warping machines for cotton, chemical fiber and blended yarns of 97.2tex~5.83tex (6s~100s).

2 Normative references

The following documents are indispensable for the application of this document. 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 storage and transportation icon GB 5226.1-2008 Mechanical electrical safety machinery and electrical equipment - Part 1. General technical conditions GB/T 7111.1 Specification for noise testing of textile machinery - Part 1. General requirements GB/T 7111.5 Textile machinery - Noise test specification - Part 5. Woven and knit preparation machinery GB/T 9239.1-2006 Mechanical vibration constant (rigid) rotor balance quality requirements Part 1. Specification and balance tolerance test GB/T 17780.1 Textile machinery - Safety requirements - Part 1. General requirements GB/T 17780.5 Textile machinery - Safety requirements - Part 5. Woven and knit preparation machinery Main dimensions of GB/T.20034 textile machinery and accessories warp creel FZ/T 90001 Textile Machinery Product Packaging FZ/T 90035 Textile Machinery Warping Shaft Terms and Main Sizes 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

3.1 Type

3.1.1

Transmission type. direct drive warp beam.

3.1.2

creel type. V type, rectangular type, V-rect type.

3.2 Main technical parameters

3.2.1

Warping speed. 0~1200m/min.

3.2.2

Maximum nominal width. 3200mm.

3.2.3

The nominal diameter of warping shafts. 800mm, 1000mm, 1250mm, 1400mm.

3.2.4

Roller length. (nominal width -4) 0-0.5mm.

3.2.5

Main dimensions of warping shaft. according to FZ/T 90035.