

ICS 59.120.50
CCS W 95

FZ

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

FZ/T 95004-2007

Replacing FZ/T 95004-1994

**Textile machinery and accessories. Cones for cross winding
dyeing process. Technology terms**

纺织机械与附件 交叉卷绕染色用圆锥形筒管 技术条件

(English Translation)

Issued on: May 29, 2007

Implemented on: November 1, 2007

**Issued by: National Development and Reform Commission of the
People's Republic of China**

Table of Contents

Foreword
1 Scope
2 Normative references
4 Requirements
5 Test methods

Foreword

Instead of the standard FZ/T 95004-1994 "cross winding winder stained with conical tubes" in the part, not instead of involving content and stained with a conical cross-wound bobbin main dimensions, tolerances and marking. GB/T 20035-2005 is half cone angle of $3^{\circ} 30'$, $4^{\circ} 20'$ and $5^{\circ} 57'$ with a conical cross-wound bobbin dimensions, tolerances and national standards mark. GB/T 20035.4-2005 a half cone angle $4^{\circ} 20'$ stained with conical bobbin dimensions, tolerances and the national standards. Listed below are the national standards and the corresponding structure International standards.

GB/T 20035-2005 "Textile machinery and accessories with a conical cross-wound bobbin"

- Part 1. Recommended main dimensions value (ISO 8489-1:1995, IDT);
- Part 2. half cone angle of $3^{\circ} 30'$ cone bobbin dimensions, tolerances and marking (ISO 8489-2:1995, IDT);
- Part 3. half cone angle of $4^{\circ} 20'$ cone bobbin dimensions, tolerances and marking (ISO 8489-3:1995, IDT);
- Part 4. half cone angle of $4^{\circ} 20'$ stained with conical bobbin dimensions, tolerances and marking (ISO 8489-4:1995, IDT);
- Part 5. half-cone angle of $5^{\circ} 57'$ cone bobbin dimensions, tolerances and marking (ISO 8489-5:1995, IDT).

Compared with this standard FZ/T 95004-1994, the main changes are as follows.

- a) expanding stained with conical bobbin half cone angle range, not only applies to $4^{\circ} 20'$, but also to $3^{\circ} 30'$ and $5^{\circ} 57'$;
- b) by deleting according to the pipe material, the half cone angle of the conical bobbin dyeing classification regulations and related Figure 1, Table 1;
- c) the deletion of the "method of dyeing conical tube labeled" requirement;

- d) increasing the "basic dimensions dyeing cone bobbin, limit deviations" and its measuring "gauge dimensions, tolerances and the use of" should Comply with GB/T 20035.4-2005 in chapter 5;
- e) In the inspection rules, add "There is one or more than one failure, is substandard goods," the decision rule;
- f) In the inspection rules, add "In a sample of units" description;
- g) In the inspection rules, the type of test items to increase the quality of testing, the substandard quality level of 20, classified as substandard C;
- h) by deleting the chapter on packaging box predetermined and packaging Pictorial marking tied;
- i) by deleting "Appendix A inner diameter measuring method";
- j) other necessary editorial changes.

The standard proposed by China Textile Industry Association.

This standard by the National Standardization Technical Committee Textile machinery and accessories.

This standard by the Shaanxi Institute of Textile Equipment, Zhejiang Sanyou Plastic Industry Co., Ltd. is responsible for drafting.

1 Scope

This standard specifies the cross-wound conical bobbin dyeing classification, requirements, test methods, inspection rules, packaging and identification.

Called "stained tapered pipe").

2 Normative references

The following documents contain provisions which, through reference in this standard and become the standard terms. For dated references, subsequent Amendments (not including errata content) or revisions do not apply to this standard, however, encourage the parties to the agreement are based on research Whether the latest versions of these documents. For undated reference documents, the latest versions apply to this standard.

GB/T 153 conifer sawmills GB/T 191 Packaging - Pictorial signs GB/T 2828.1 Sampling procedures for inspection - Part 1. by acceptance quality limit (AQL) retrieval batch inspection sampling plan (ISO 2859-1:1999, IDT) GB/T 2829 periodic inspection Sampling procedures and tables (suitable for process stability test) GB/T 4892 hard straight cube transport packaging size series GB/T 6543-1986 corrugated boxes GB/T 6544-1999 corrugated cardboard packaging material GB/T 20035.4-2005 Textile machinery and

accessories conical bobbin with cross winding - Part 4. half cone angle of $4^{\circ} 20'$ staining with conical bobbin dimensions, tolerances and marking Category 3 Depending on environmental requirements, divided into common type (codenamed P) and high temperature, high pressure type (code N) staining conical tube.

4 Requirements

4.1

P-type stain conical tubes under normal pressure, N type at a temperature of 120°C dispersion of the dye in the dye continuous cooking 2h, should be no distortion, no Corrosive, non-staining.

4.2

Semi basic dimensions cone angle $4^{\circ} 20'$ stained conical tube, limit deviations shall comply with GB/T 20035.4-2005 provisions; half cone angle $3^{\circ} 30'$, $5^{\circ} 57'$ and the basic size limit deviation dyeing conical tube should refer to GB/T 20035.4-2005 OK.

4.3

the same batch, the same quality of dyed conical tube sizes average quality of its deviation should be $\pm 5\%$.

4.4

staining conical tube end faces, the inner and outer surfaces and perforations should be round and smooth, there should not be worried about the fiber burrs.

4.5

plastic colorant staining conical tube should be good migration resistance, the same batch should be no color.

5 Test methods

5.1

Environmental conditions test reactor or under simulated conditions.

5.2

staining conical inner diameter should be GB/T 20035.4-2005 in Chapter 5, "gauge dimensions, tolerances, and use" measure, other