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

FZ/T 97010-2016

Replacing FZ/T 97010-1993

**General technical requirements of cams on circular weft
knitting machine**

圆型纬编机三角的通用技术条件 清晰版

(English Translation)

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Foreword

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

This standard replaces FZ/T 97010-1993 General technical conditions for knitting machinery triangular.

Compared with FZ/T 97010-1993, the main differences are as follows.

- modified the scope of application of the standard (see Chapter 1, Chapter 1 of the previous edition);
- Added normative reference documents (see Chapter 2);
- increased design content (see Chapter 3);
- modified the requirements of the material (see 4.1, the previous version of 2.2);
- modified the "hardness range" (see 4.2.1, the previous version of 2.3);
- improved "surface roughness requirements" (see 4.3, pre-version 2.4);
- improved "dimensional accuracy requirements" (see 4.5, previous version of 2.6);
- modified the "test method" (see Chapter 5, Chapter 3 of the previous edition);
- Added "inspection rules" (see Chapter 6);

Other editorial changes.

This standard is proposed by China Textile Industry Federation.

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

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1 Scope

This standard specifies the requirements, test methods and inspection rules and marking, packaging, transportation and storage of circular weft knitting machines.

This standard applies to circular weft knitting machine control knitting needle, sinker and its associated auxiliary equipment to do the knitting movement of the triangle.

2 Normative reference documents

The following documents are indispensable for the application of this document. For dated references, only the dated edition applies to this article Pieces. For undated references, the latest edition (including all modifications) applies to this document.

GB/T 191 packaging and storage icon GB/T 1184 Shapes and position tolerances Not specified Tolerance values FZ/T 90001 textile machinery product packaging 3 design to be the design of the round weft machine is shown in Appendix A.

4.1 Materials

4.1.1

Triangular material is Cr12MoV, Cr12Mo1V1.

4.1.2

Auxiliary triangular material is 45.

4.1.3

Triangular materials and auxiliary triangular materials can also be used with mechanical properties of not less than the above materials of other materials.

4.2 Hardness

4.2.1

Triangular hardness of 60HRC ~ 63HRC.

4.2.2

Where there is a special hardness requirement, the product drawings or technical documents should be specified accordingly.

4.3 Surface roughness

4.3.1

The surface roughness Ra of the contact surface of the needle should not be greater than 0.8 μ m; the direction of the texture should be consistent with the direction of the needle, and should not be clear Significant ripples and dents.

4.3.2

non-needle contact surface roughness Ra value should not be greater than 0.8 μ m.

4.3.3

The surface roughness Ra of the plane of the triangle and the knitting needle (or sinker) shall not be greater than 0.8 μ m.

4.3.4

Triangular installation plane, with the adjacent triangle at the junction of the plane and the side of the surface roughness Ra value should not be large at 1.6 μ m.

4.3.5

The surface roughness Ra of the mounting holes on the triangle shall not be greater than 3.2 μ m.

4.3.6

The surface roughness Ra of the chamfer or arc connection at each triangle shall be as specified in 4.3.1 to 4.3.5 according to its location.

4.3.7

forging into the blank of the triangle, the non-processing surface roughness Ra value should not be greater than 25 μ m; the remaining machine surface roughness Ra