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**NATIONAL STANDARD OF THE  
PEOPLE'S REPUBLIC OF CHINA**

**GB/T 21308-2007**

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**Lint cleaners**

皮棉清理机

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Quarantine;  
Standardization Administration of the PRC**

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### Foreword

The Standard Appendix A, Appendix C is a normative appendix, Appendix B is an informative annex. The standard proposed by China Federation of Supply and Marketing Cooperatives. The standard by the China Federation of Supply and Marketing Cooperatives Standardization Technical Committee of cotton processing industry. This standard was drafted. Shandong Swan Cotton Machinery Co., Ltd. Handan Golden Lion Cotton Co., Ltd, China Federation of Supply and Marketing Cooperatives Social Zhengzhou Institute of Design Technology Fluid Systems Engineering. The main drafters of this standard. Young prop students, high Li, Li Jiuxi, Wangrui Xia, Wei Hua, Han Shuping, Hu Yushan. Lint cleaning machine

### 1 Scope

China's national standard for lint cleaners - the machines that clean cotton lint after ginning. It specifies the product classification, the technical requirements, the test methods, the inspection rules, and the marking, packaging and storage requirements, and it applies to saw-type lint cleaners handling the lint discharged by a saw gin. Lint cleaning is the last chance to remove trash from cotton, and it is a compromise made under commercial pressure. After ginning, the lint still carries fragments of leaf, bark, seed coat and motes, and every fragment left in it appears later as a nep or a speck in the yarn or the dyed fabric. Removing them raises the grade and the price. But a lint cleaner works by combing the lint over a grid with a saw cylinder, and every pass through it breaks fibres, shortens the staple and adds neps of its own - so cleaning too hard destroys more value than the trash it removes, and a gin operator who over-cleans a good crop is paid less for it, not more. The standard exists to make the machine's behaviour predictable so that the operator can make that trade knowingly. It fixes the classification and the main parameters, the requirements on the working members - the saw cylinder, the feed rollers, the grid bars and their setting, which is what determines both cleaning efficiency and fibre damage - the cleaning efficiency and the fibre damage as measured performance rather than as claims, the

throughput, the power, and the safety and reliability requirements, with the test methods by which each is demonstrated. Issued on 23 November 2007 and in force since 1 February 2008.

This standard specifies the product classifications, technical requirements, test methods, inspection rules and signs, packaging and storage requirements lint cleaning machine. This standard applies to zigzag cotton gin lint rolling out to clean the lint licker-type cleaning machine.

## 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 1103-2007 Upland Cotton

GB/T 6075.1 Measurement and Evaluation of the machine on the non-rotating member of the mechanical vibration - Part 1. General (idt ISO 10816-1. 1995)

GB/T 9239.1-2006 mechanical vibration steady state (rigid) rotor balance quality requirements - Part 1. specification of tolerance and balance test

### 3.1 Basic parameters

3.1.1 Minimum processing units is not less than 800kg.

3.1.2 licker line speed is not greater than 25m/s.

3.2 Model M Q P - - --- x xxxx Product Code. Cotton processing machinery Category Code. Cleanup machinery Category Code. lint Feature code. Cotton off mode (M is a brush type, Q is air- Main parameters. licker diameter (mm Main parameters. licker working length (mm Improved numbers. A, B, C

Note. The way to brush off the cotton type, you can omit the letter M. 4. Technical Requirements

4.1 lint Regain We need to regain the cleaned lint between 6.5% and 8.5%.

4.2 overall performance

4.2.1 Production capacity. 328 standard test lint grade level and above, when the station is not less than the production capacity of 800kg/h, per 100mm roll thorn Working cylinder capacity of not less than the length of 60kg/h.