

ICS 59.120.10  
CCS W 90



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

**GB/T 46536-2025**

---

**Textile machinery and accessories - Two-for-one twisters -  
Vocabulary**

纺织机械及附件 倍捻机 术语

**(English Translation)**

**Issued on: October 31, 2025**

**Implemented on: May 1, 2026**

---

**Issued by: State Administration for Market Regulation**

## Table of Contents

- Foreword
- 1 Scope
- 2 Normative references
- 3 Terms and Definitions
  - 3.1 Equipment
  - 3.2 Dimensions

### Foreword

This document complies with the provisions of GB/T 1.1-2020 "Standardization Work Guidelines Part 1: Structure and Drafting Rules of Standardization Documents".

Drafting.

This document is modified to adopt ISO 9947:2005 "Textile machinery and accessories - Twisting machines - Terminology".

Compared with ISO 9947:2005, this document has undergone many structural adjustments. A comparison table of the structural numbering changes between the two documents can be found here.

Appendix A.

The technical differences between this document and ISO 9947:2005, and the reasons therefor, are as follows.

---The diagrams for the doubling twister, the collective drive type 1, and the single spindle drive type have been revised (see Figures 1, 2, and 3) to adapt to my country's technology.

Conditions to improve operability;

---A diagram for the second type of collective transmission mechanism has been added (see Figure 4) to adapt to my country's technical conditions and improve operability;

---The terms and definitions for "yarn guide roller" and "automatic roll lifting device" have been added (see 3.3.9.2 and 3.3.9.6) to adapt to my country's technical requirements.

Improve technical conditions and enhance operability.

The following editorial changes have been made to this document.

---The notes for the "Scope" chapter have been deleted;

---The title of Figure 2 has been changed (see Figure 2);

---Added descriptions of the reference models in the notes of Figures 2 and 3 (see Figures 2 and 3).

Please note that some content in this document may involve patents. The issuing organization of this document assumes no responsibility for identifying patents.

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

This document is under the jurisdiction of the National Technical Committee on Standardization of Textile Machinery and Accessories (SAC/TC215).

## 1 Scope

This document defines the terminology for doubling machines and their main components.

This document applies to doubling machines.

**Note:** The diagrams in this document are for illustrative purposes only and do not represent the only type of twisting machine.

## 2 Normative references

This document has no normative references.

### 3.1 Equipment

#### 3.1.1

Two-for-one twister

Each spindle revolution adds two twisting machines to the yarn.

**Note 1:** Yarn unwound from a fixed feed package is guided through a rotating spindle, twisted, and then wound onto a take-up bobbin.

The air ring rotates around the fixed roll to achieve a double twist effect.

**Note 2:** Twist (number of twists per meter) is calculated according to formula (1).

Twist (twist/m) =

$2 \times \text{spindle speed (r/min)} \times \text{Yarn speed (m/min)} (1)$

### 3.2 Dimensions

#### 3.2.1

machine length

The total length of the machine, including all parts (see Figure 1).