

Z GA131分条整经机

ZGA131 Sectional Warping Machine

◆ 适用范围 Scope of Application

精毛织物、强捻化纤长丝织物、色织物、丝织物、毛巾织物及特种产业用布等品种的分条整经。可作为喷水、喷气剑杆、片梭等无梭织机的织前准备设备。能替代进口分条整经机。

This machine is suitable for sectional warping of fine wool fabric, hard twist synthetic filament fabric, colored woven fabric, silk fabric, towels and special type industrial fabric. It can be regarded as the preparation equipment for shuttleless looms such as water-jet, air-jet, rapier and projectile. It can replace imported ones.

◆ 主要技术特征 Main Technical Characteristics

整经操作台的轴向位移有高精度伺服电机控制，起点定位、条定位一次按键自动完成。
整经操作台可自动径向位移。它有独立的步进电机控制，使定幅箱与成型纱面保持等距离，其距离可任意设定。
应用交流变频调速新技术，由计算机控制达到无级调整，保持大滚筒上纱线恒线速卷绕和退绕。
专用机、电、液、气一体化的静液压装置产生油压，推动钳式制动器，完成整经刹车倒轴张力控制。
采用计算机及PLC等先进技术，并具有计总长、计匹数、计匹长、计条及断头记忆功能和满总长自停、满匹长自停、断头自停等功能。
大屏幕触摸屏的人机界面，显示清晰、信息量大、操作方便。
主机大滚筒整体在地轨上由伺服电机控制移动，分绞箱架筒子架等固定，经纱条带在整经过程中始终呈直线状态，片纱张力保持恒定。
1:6固定锥体钢质高强度大滚筒与高精度伺服电机的整经操作台配合可满足几乎所有品种的整经工艺。
可选配两种型式的倒轴机：
整体可移动式倒轴机，一台倒轴机可与多台整经机头配套，且配有上蜡（油）和织轴加压装置。
固定式倒轴机，结构简单，操作方便。
配有多种形式的筒子架能满足不同品种的工艺要求。锭距、锭数可根据用户需要特殊配置。
本机选配的张力器有三柱式可调张力器、二柱式微调张力器和单柱式张力器等多种形式。
本机还配有断经自停装置和静电消除器。

ZGA131型分条整经机		
当前经长 0 米		
当前速度 0 米/分	最近断头位置 0 条 0 米	未处理断头数 0 根
设定速度 0 米/分	整经 倒轴	现在状态 倒轴准备
产量统计 调试诊断 操作说明 郑州纺织机械股份有限公司		

整经操作显示屏(Display screen)



◆ 主要技术特征 Main Technical Characteristics

The axial displacement of operation desk is controlled by high precision servomotor. And the positioning for starting point and section is achieved automatically by pushing one button.
The radial displacement of operation desk is controlled by the independent stepping motor, so that the section space reed can keep the constant distance with the forming of yarn, and the distance can be set at will.
Controlled through computer, the new technology of AC frequency control is applied to keep the constant line speed winding yarn and unwinding.
The static oil hydraulic device, integrated with mechanic, electricity, liquid and air, produces hydraulic pressure to push the clamp brake and implement the tension control of warping brake and rebeaming.
The advanced technology of computer and PLC is adopted with the functions of total length counter, piece number counter, piece length counter, section counter and broken end memory, and the functions of auto stop while full total length, full piece length and broken end.
Large touch screen interface can display clearly with large amount of information and simple operation..
The big drum is moved as a whole on the rail and controlled by the servomotor. The cross reed frame and bobbin creel is fixed, and the warp section is always in the state of straight line, so the yarn tension can be kept constant.
1:6 the fixed cone high strength steel drum and the high precision servomotor is integrated as a whole, which can nearly meet the requirements of all varieties of warping process.
Two types of rebeaming machine is optional:
Moveable rebeaming machine: one rebeaming machine can be matched with several warping headstock and with waxing (oiling) and pressurized device for weaving beam.
Fixed rebeaming machine: with simple structure and convenient operation.
Various forms of bobbin creel are optional to meet the technological requirements of different varieties. Bobbin distance and bobbin number is optional too according to the special needs.
Several types of tensioner are optional: three-column adjustable tensioner, two-column fine adjustable tensioner and single-column tensioner.
The machine is also equipped with warp stop motion and static eliminator.

◆ 主要技术参数 Main technical data

1、有效幅宽 (Work width)	2300 (mm) (基本型) (特殊规格按用户需求可定制) (Basic) (as per user's special requirement)
2、织轴盘片直径 (Beam flange diameter)	≤ 800 (mm) (基本型) (Basic)
3、整经速度 (Warping speed)	0~600 (m/min)
4、倒轴速度 (Beaming speed)	0~100 (m/min)
5、整经、倒轴恒线速精度 (Deviation of line speed)	± 2%
6、制动距离 (Braking distance)	≤ 2 (m) (速度300m/min时) (at speed 300m/min)
7、倒轴张力 (Beaming tension)	≤ 6000 (N) (倒轴速度 ≤ 50m/min时) (Back-beaming speed ≤ 50m/min)
8、大滚筒直径 (Drum diameter)	φ 1000 (mm)
9、锥体长度 (Cone length)	950 (mm)
10、锥体角度 (Cone angle)	9°
11、导条走丝速度 (Stripe traverse speed)	0.001~9.999 (mm/r) (无级) (stepless)
12、导条随动精度 (Deviation of stripe traverse)	± 0.01 (mm)
13、定幅箱与滚筒距离 (Distance between space reed and yarn on the drum)	可调 (adjustable)
14、锥起点定位 (Positioning of cone starting point)	自动 (automatically)
15、条定位 (Stripe location)	自动 (automatically)
16、条宽设定范围 (Stripe width)	0.1~299.9 (mm)
17、筒子架锭距 (Spindle space)	250 × 250 (mm)
18、筒子架锭数 (Spindle number)	392 (毛、棉纱) (wool, cotton) 480 (化纤长丝) (chemical filament)
19、输入电压 (Input votatage)	3 × 380v (+ - 10%)
20、装机容量 (Capacity)	31.5 (kVA)
21、整经电机功率 (Warping motor power)	11 (kW)
22、倒轴电机功率 (Beaming motor power)	18.5 (kW)
23、导条移动伺服电机 (Str)	2 (kW)
24、主机重量 (Warping and beaming frame weight)	4500 (kg)
25、筒子架重量 (Creel weight)	2500 (kg)

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