◆主要技术特征 Technical Features

- 1、换筒方式: 纱架内插上预备筒子后通过电动循环链传动回转集体换筒。
- 2、两翼纱架排成V字型,采用外导纱方式引纱.中间无导向元件.使纱线自由状态运行,无纱线的摩擦。
- 3、断头监控为:单锭无接触光电式检测.对低张力的细支纱也可进行准确检测。
- 4、每锭每列设有断头显示及开关. 方便处理断头. 提高生产效率。
- 5、前后筒子架上经纱张力差异依靠预张力杆改变包围角来缩小,将单纱张力差异缩小到极限。预张力杆另一个作用是在高速退绕 停车重新开车时,能将小辫子解开.以利高速退绕。
- 6、每锭设有纱线夹持装置. 当起动和停车时, 给纱施加柔和的制动, 从而防止加减速时纱线的松驰。
- 7、纱线剪切为: 电动式。
- 8、除尘装置:间隙吹风。
- 9、纱架前装有独立控制箱。
- 1. Way of bobbin changing: put the bobbin in the inside of the creel in advance, change the bobbins collectively through driving and turning of endless chain.
- 2. Both sides of the creel is in V shape, adoping turning outside yarn guide type to guide yarn, no yarn carrting plate, So the yarn founctioning freely and no yarn friction.
- 3. Breakage and monitoring: single spindle photoelectricityinspection, even the fine count yarn is also inspected accurately.
- 4. Every spindle is equipped with break and display and switch, So it is convinient to deal with break end, and can gain high production efficiency.
- 5. The tension difference in the back creel and front creel can be reduced by adjusting the angle through the tension roller, The minimum yarn difference can be gained through this nay. Another function of the tension roller is to unfasten the ties when start the machine again, which stopped when unreeling at high speed. It is good to high speed unreeling.
- 6. In order to avoide the yarn looseness when reducing the speed, every spindle has yarn clamp device, which can add soft brake to the yarn when starting and stopping.
- Yarn cutting: power driven
- 8, Dust control:electric reciprocating-walk type
- 9. Independent control casing is installed in front of creel.

◆主要技术参数 Main specifications

- 1、插筒锭杆为 φ 10 × 200。
- 1. Spindle balde ofdonning: φ 10 × 200
- 2、列距、层距、层数、列数、锭数见附表 2、Column distance, layer distance, number of layers, number of column, number of spindlesplease see attached table

| 列距(mm) Column distance | 层距(mm) layer distance | 最大筒纱直径 (mm) The maximum drum diameter | 层数 Number of layers | 锭数 Number of spindle | | | | | | | | | | | |
|------------------------------|-----------------------------|--|---------------------------|-------------------------|-----|-----|-----|-----|-----|-----|------|------|------|------|------|
| | 240 | 230 | 9 | 504 | 576 | 648 | 720 | 792 | 864 | 936 | 1008 | 1080 | 1152 | 1224 | 1296 |
| | 270 | 255 | 8 | 448 | 512 | 576 | 640 | 704 | 768 | 832 | 896 | 960 | 1024 | 1088 | 1152 |
| 240 | 305 | 265 | 7 | 392 | 448 | 504 | 560 | 616 | 672 | 728 | 784 | 840 | 896 | 952 | 1008 |
| | 350 | 278 | 6 | | 384 | 432 | 480 | 528 | 576 | 624 | 672 | 720 | 768 | 816 | 864 |
| | 435 | 305 | 5 | | 320 | 360 | 400 | 440 | 480 | 520 | 560 | 600 | 640 | 680 | 720 |
| 列数 Number of column | | | | 28 | 32 | 36 | 40 | 44 | 48 | 52 | 56 | 60 | 64 | 68 | 72 |

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ZGA129高速分批整经机/大V形循环式筒子架

ZGA129 HIGH SPEED BEAM WARPING MACHINE/ BIG V-SHAPED RECIRCULATED BOBBIN CREEL



GA129高速分批整经机



◆适用范围 Scope of Application

该机能精确控制经纱长度和经纱的排列,适 用于各种短纤维纱线的分批整经, 是各类无梭织 机的织前准备设备。

This machine can accurately control length and arrangement of warp yam. It is suitable for directly warping of various kinds of chopped yams and is the pre-spinning preparation equipment for various kinds of pirn less

◆主要技术参数 Main specifications

- 1、整经幅宽
- 2、最大经轴盘片直径 800mm
- 3、整经速度 4、制动距离
- 5、经纱长度误差
- 6、筘左右调节范围 7、主电机功率
- 8、操作显示器
- 9、主机重量 10、筒子架
- 1800mm(其它幅度根据用户要求可定制)
- 300-1000m/min ≤3m(500m/min)
- ≤0.2%
- 0-40mm
- 3500kg 大V型架(详见样本)
- 18.5 kw 10.4寸触摸屏

- 1.Fabric width of warping beam: 1800mm
- (Other fabric width could be customize according to the
 - requirement of customer)
- 2.Max. diameter of warp beam:800mm,1000mm
- 3.Speed of beam warping:300-1000m/min
- 4.Braking length:≤3m(500m/min) 5.Error in right adjustable range of reed: ≤0.2%
- 6.Left and right adjustable range of reed:0-40mm
- 7.Power of main engine:18.5KW
- 8. Operation displayer: 10.4inch touch panel
- 9. Weight of main engine: 3500kg
- 10.Bobbin creel:large V shape creel(see to sample)

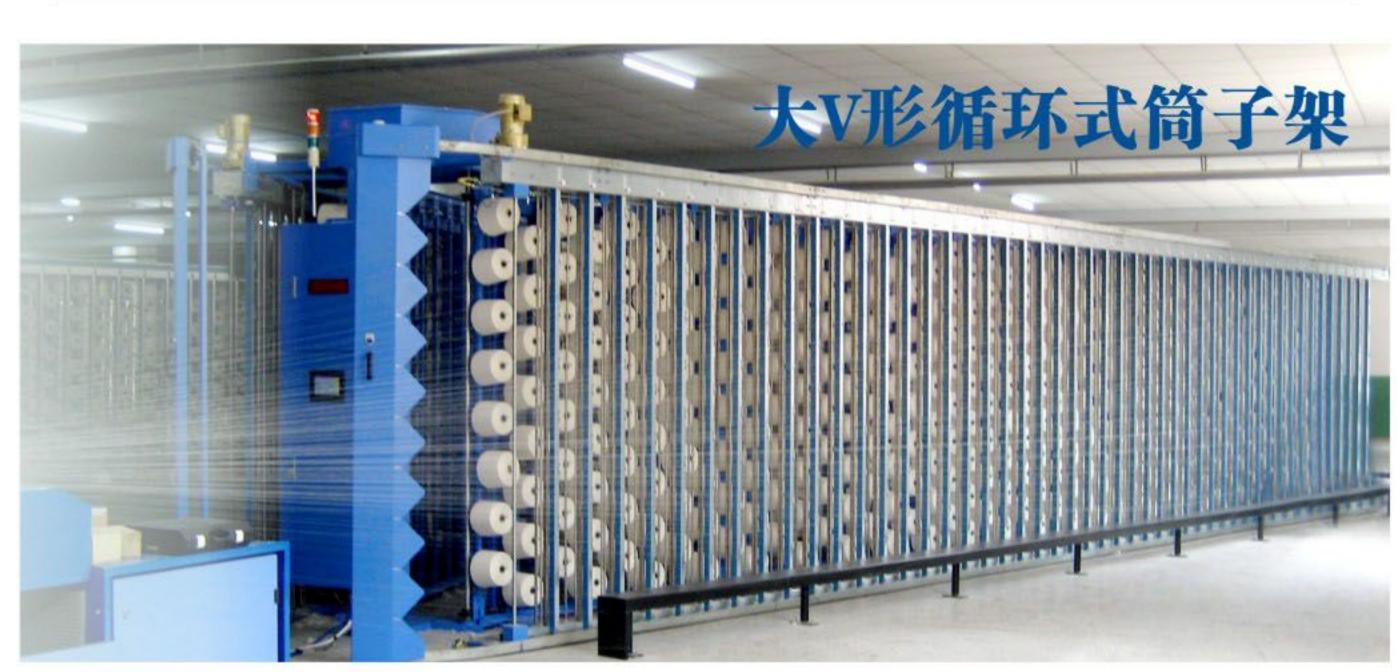
◆主要技术特征 Technical Features

- 1.经轴直接传动,变频控制电机实现整经线速度无极设定,线速 6.气动自锁,安全可靠。 度恒定。
- 2.采用压辊间接加压方式,防止了加压过程中的跳动,使经轴成 形圆整均匀。压辊为液压制动,制动时瞬间脱离避免了压辊与纱 线表面的摩擦。
- 3.采用左右经轴高效的钳式制动。导辊钳制动,制动平稳迅速。 4.气动上落轴快速,方便。
- 5.气动拍合,拍合头采用锥齿形式使对中精确,保证经轴的扭转 和制动的同步性能。
- 7.采用加压辊与经轴互联计长方式, 计长精度更高。
- 8.伸缩寇处设有间隙吹风功能,用于清洁筘齿:筘齿左右上下摆动 功能,避免筘齿的磨损,保证了纱线卷绕均匀一致。
- 9.在伸缩筘和导辊间设有防缠绕装置。在机器起动时产生作用,使 纱线重新排列均匀。
- 10.配挡风罩,操作安全方便。
- 11.操作根据实际需要采用按钮与触摸屏相结合,功能更加合理, 操作更加方便快捷。



- 1. The warping beam is directly transmitted, the variable frequency control motor has achieved stepless setting for yam warping speed. and the yam speed is constant.
- 2. Adopt indirect pressure between press rollers thus to prevent jump in the pressing procedure and the formation of spindle beam would be round and uniformed. The press roller adopts hydraulic braking; the instant separation in braking avoids the friction between press roller and the surface of yam.
- 3. Adopt clamp braking in left and right synchronize mechanical beating in yam guiding roller, the braking is stable and fast
- 4. Pneumatically control for beam loading and doffing makes fhe operation fast and convenient. 5. The beating head of pneumatically beam clamping adopts bevel gear pattern to precise the centering thus to ensure the synchronous performance of the rotation and braking of warp beam.
- Pneumatically Interlock makes sure the safety and reliability.
- 7. Adopt interconnecting length calculation of yam press roller and warping beam the accuracy of which is higher.
- 8.Blasting function is set for the space in creel reed to clean the reed gear. the function of reed gear to flap left to right and up to down avoids the abrasion of reed gear which ensures the equality and uniformity in yam winding.
- 9. Anti-winding device is equipped between creel reed and yarn guide roller which works by the startup of machine to rearrange the yarns into uniform.
- 10. Adopt totally closed guard device which would qutomatically open when the equipment stopped running; the operation is safer and convenient.
- 11. The operation combines the adoption of button and touch panel according to requirements; the function is more reasonable; the operation is more fast and convenient.





◆筒子架型式 General Verview

大V形循环式筒子架主要和整经短纤维的分批整经机配套使用。主要特点是架身短,架子与伸缩筘之间无导纱器,特别适应对摩擦敏 感的某些短纤维,实现低张力水平高速运行,有利于减少纱线的张力差异和整经时的断头率、交错的纱筒布置优化了空间利用,V形内侧 可存放预备筒子架,便于工作操作,换筒时间短,减少整经时停车时间。该筒子架特别适应高速整经。

Big V-shaped recirculated bobbin creel is assorted with direct warping machine for chopped fiber. Its advantages include shorter creel boby,no carrier between frame and creel,especially adapted for some chopped fibers which are senstive to friction, working under low tension and high speed, be favorable to reduce tension difference of yarn and end breakage when warping. The inner side of v-shaped creel could store bobbin. which is convenient for operation. The bobbin changing time is short so that can save idie period for warping machine. This kind of bobbin creel is especially fit for high speed warping.