



恒天重工股份有限公司
HI-TECH HEAVY INDUSTRY CO.,LTD.

GA310/310A型浆纱机 『 技术描述 』 Technical Description
GA310/310A TYPE SIZING MACHINE

高智能：全电脑集成化控制，高速全变频9单元传动，双浆槽浆纱机。
高精度：采用Profibus通讯协议完成数据交换和检测与控制，采用国际上目前先进的控制技术。
高产量：①最高设计速度125m/min；②控制系统的可靠性设计；③1000kg/h干燥量的配置；
高配置：主要配套件（变频器、PLC、电机+减速机、气动元件、关键轴承等）均采用国际上知名品牌，当今世界上先进的技术。
低能耗：变频控制系统更节电、PID温控及回潮率控制更省汽、高压上浆更省浆料。
合理的工艺设计：①压浆辊侧向加压，纱线垂直进入烘房，各区张力控制合理。②双湿分绞装置使纱线毛羽伏贴。③工艺流畅，操作方便。④烘房中的分单元传动，保证片纱的张力均匀一致。

High intelligence: Adopting PLC on-line test and control, double-sizing box and frequency motor 9 units driving.
High Precision: Profibus communication agreement is adopted for the data exchange, detection and control, it adopts with the most advanced control technology in the world.
High production: ①125m/min of high speed.②High precision control design.③1000Kg/h of drying capacity of drying capacity.
High configuration: Inverter, PLC, computer, Low-voltage electrical components, motor+gear reducer, pneumatic components, key-bearings is adopted with international renowned.
Low energy consumption: The flexible frequency control system saves more energy, PID high precise temperature and moisture regain control saves more steam for drying. High pressure linear pressurization of squeezing roller gets more stable size pickup and saves more size agent.
Reasonable process design: ①The side pressurization of squeezing roller, Yarn's entering the drying chamber vertically makes more reasonable and evenly tension in each area.②Two wet splits device makes hairiness clinging.③Reasonable size box structural design makes your operation more convenient and rapid.④Multi-unit drive of drying chamber can guarantee the uniform tension of the yarn.

◆ 预湿上浆 Pre-wet Sizing

预湿上浆的重要特点是提高浆料在经纱上的粘着力、降低毛羽、提高织造能力、减少经纱断头，同时可以节省浆料，有利于后道处理工序，降低成本。即：

- 节省浆料的20-30%
- 提高纱线拉伸强力20%
- 降低毛羽60%
- 提高经纱耐磨性
- 提高织机效率
- 提高布匹表面等级
- 退浆更容易、降低污水处理成本

The important features of pre-wet sizing is to increase the adhesive force of the size on the warp yarn, decrease hairiness, improve weaving capacity, and reduce the warp broken in favor of the next process, and save the size agent in favor of reduce the cost. Namely:

- To save 20-30% of size agent
- To improve 20% of yarn tensile strength
- To decrease 60% of hairiness
- To improve warp wear resistance
- To improve the efficiency of Looms
- To improve the fabric surface grading
- To desize more easily and reduce water treatment costs

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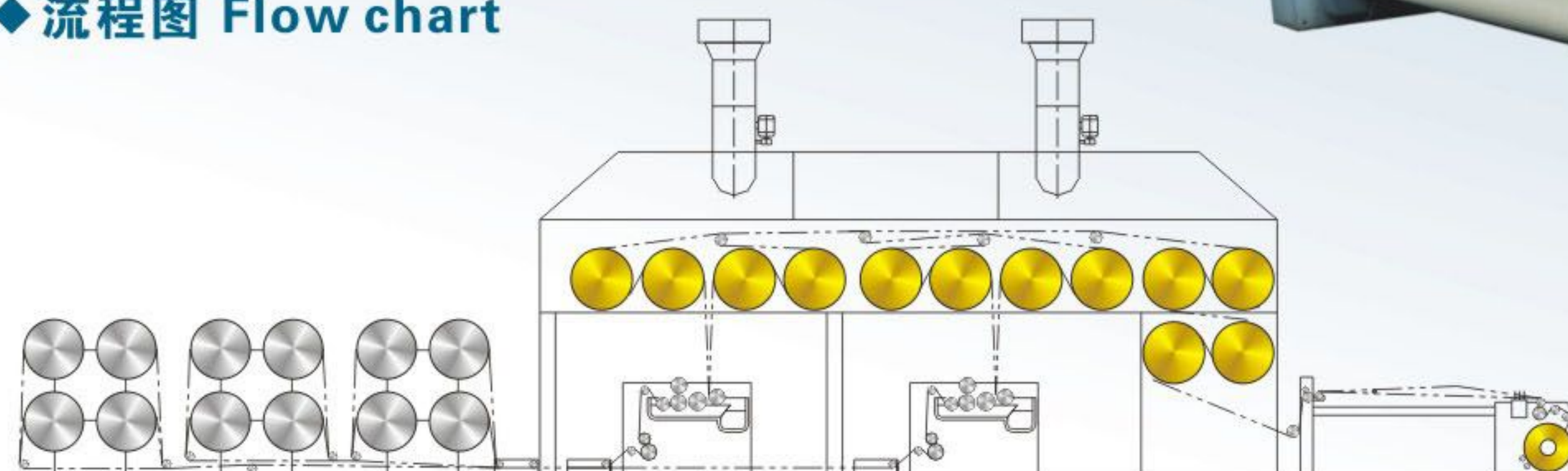
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G A310型浆纱机

GA310 Type Sizing Machine

◆流程图 Flow chart



◆主要技术参数表 Main Specifications

项目	Item	标准	Standard
适应品种范围	Suitable Varieties	GA310系列浆纱机适用于总经根数2000~20000根左右,经纱号数97tex~5tex(6°~120°)的棉、涤棉及化纤混纺短纤维织物的经纱上浆。	Ga310 series sizing machine is suitable for warp yarn sizing of pure cotton, chemical staple fiber and its blender with metric count 97tex~5tex(6°~120°) and total warp ends 2000~20000.
名义幅宽	Nominal Width	240、300、360、400	
速度 (m/min)	Speed	2~125	
蜗牛速度 (m/min)	Snail Speed	0.8	
落轴速度 (m/min)	Doffing Speed	0.5	
织轴卷绕直径 (mm)	Winding Diameter of Weaving Beam	Φ110-Φ800或 Φ1000、Φ160-Φ1250	
轴管长度 (mm)	Length Of Beam Tube	2650/3250/3930/4330	
最大卷绕张力 (N)	Maximum Winding Tension	7000	
烘筒数量	Quantities Of Drying Cylinder	12	
烘筒幅宽 (mm)	Width Of Drying Cylinder	1800或 2000	
浆槽工作幅宽 (mm)	Working Width Of Sizing Box	1800或 2000	
总功率 (KW)	Total Power	82	
长×宽×高(m)	L×W×H(m)	27×4.45×4.2 29×5.05×4.2 31×5.73×4.2	

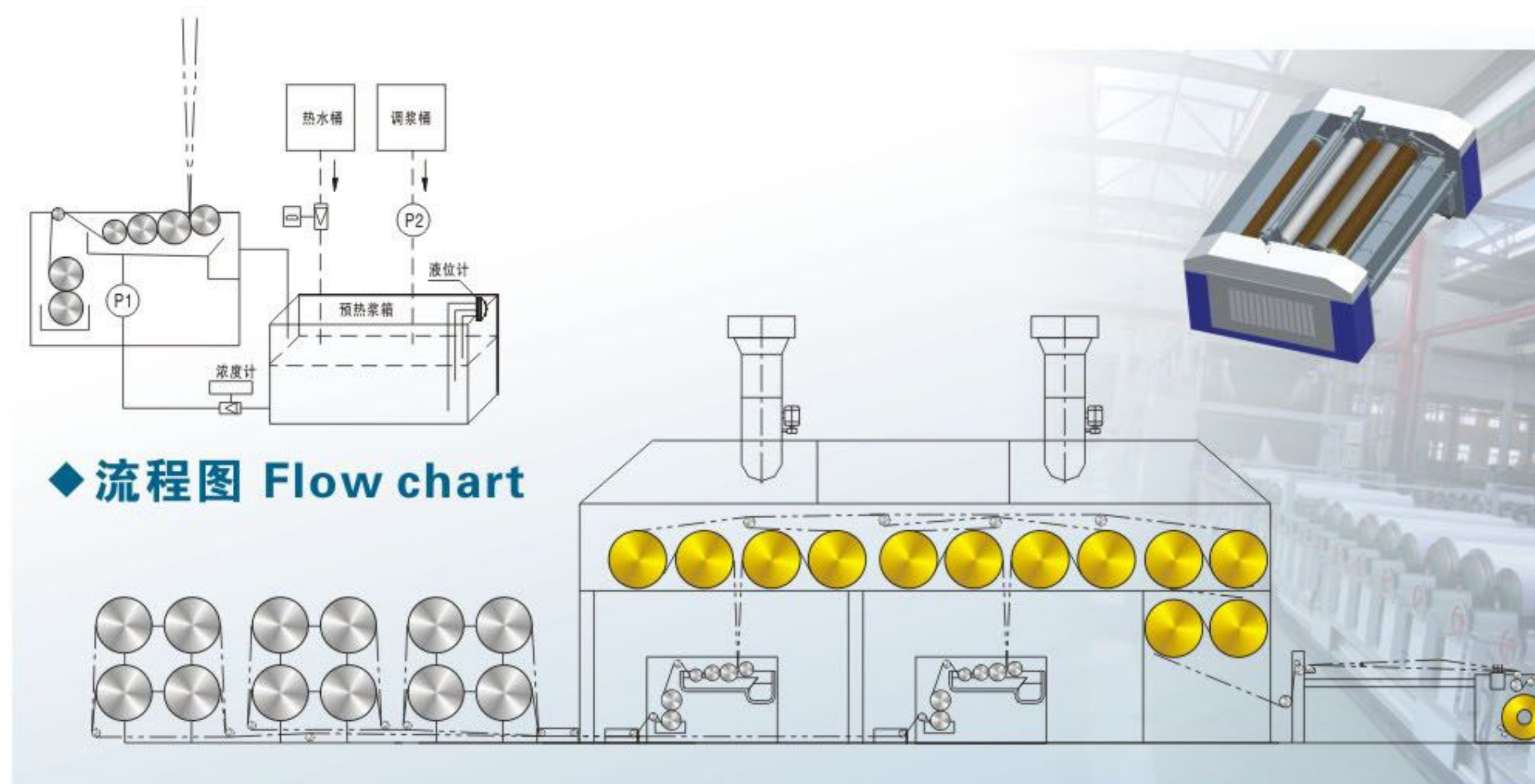


G A310A型预湿浆纱机

GA310A Type Pre-wet Sizing Machine

◆主要技术参数表 Main Specifications

项目	Item	标准	Standard
名义幅宽	Nominal Width	240 300 360	
速度 (m/min)	Speed	1~100	
落轴速度 (m/min)	Doffing Speed	0.5	
织轴卷绕直径 (mm)	Winding Diameter of Weaving Beam	Φ800/Φ1000	
轴管长度 (mm)	Length of Beam Tube	2650 3520 3930	
最大卷绕张力 (N)	Maximum Winding Tension	6000	
烘筒数量	Quantities of Drying Cylinder	12/14	
浆槽工作幅宽 (mm)	Working Width of Sizing Box	1800	
总功率 (KW)	Total Power	75	
长×宽×高(m)	L×W×H(m)	27×4.45×4.2 29×5.05×4.2 31×5.73×4.2	



◆流程图 Flow chart