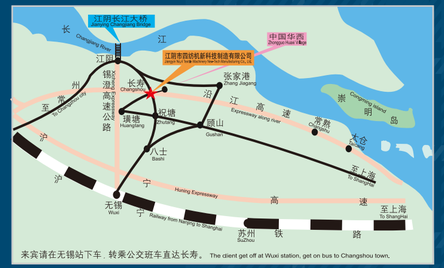

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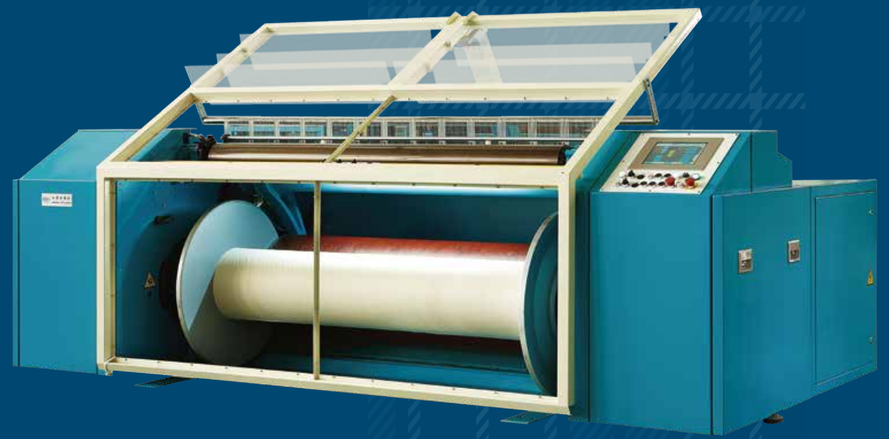
GA128C型

分 批 整 经 机

GA128C DIRECT WARPING MACHINE



江阴市四纺机新科技制造有限公司

Jiangyin No.4 Textile Machinery New-Tech Manufacturing Co., Ltd.

高品质、高速度、高效率
HIGH-QUALITY HIGH-SPEED HIGH-EFFICIENCY

四 星 ®
GA128C型分批整经机 GA128C DIRECT WARPING MACHINE

适用范围

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。

Range of application

This machine can accurately control length and arrangement of warp yarn. It is suitable for directly warping of various kinds of chopped yarns and is the pre-spinning preparation equipment for various kinds of pirnless looms.

主要技术特征

1.经轴直接传动，变频控制电机实现整经线速度无级设定，线速度恒定。

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，导辊钳式制动，制动平稳迅速。

4. 左右同步机械式拍合装置，拍合头采用锥齿形式使对中精确，保证了经轴的扭转和制动的同步性能。

5. 采用加压辊与经轴互联计长方式，计长精度更高。

6. 伸缩筘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。

7. 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。

8. 采用全封闭式挡风罩，设备停止运转时会自动打开，操作安全方便。

9. 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，操作更加方便快速。

Main technical features

1. The warping beam is directly transmitted, the variable frequency control motor has achieved stepless setting for yarn warping speed, and the yarn 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 yarn.

3. Adopt clamp braking in left and right warp beam, clamp braking in yarn guiding roller; the braking is stable and fast.

4. The beating head of left and right synchronize mechanical beating device adopts bevel gear pattern to precise the centering thus to ensure the synchronize performance of the rotation and braking of warping beam.

5. Adopt interconnecting length calculation of yarn press roller and warping beam the accuracy of which is higher.

6. Blasting function is set for the space in shinkable reed to clean the reed dents; the function of reed dents to flap left to right and up to down avoids the abrasion of reed dents which ensures the equality and uniformity in yarn winding.

7. Anti-Snarl device is equipped between reed and yarn guide roller which works by the start-up of machine to rearrange the yarns into uniform.

8. Adopt totally closed guard device which would automatically open when the equipment stopped running; the operation is safer and convenient.

9. 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.

主要技术参数 Main technical parameters

1.整经幅宽 Fabric width of warping beam	1800mm（其他幅度根据用户要求可定制） 1800mm(Other fabric width could be customize according to the requirement of customer)
2. 最大经轴盘片直径 Max. diameter of warp beam	800mm、1000mm
3. 整经速度 Speed of beam warping	300-1200m/min
4. 制动距离 Braking length	≤3m(500m/min)
5. 经纱长度误差 Deviation in the length of warped yarn	≤0.2%
6. 筘左右调节范围 Left and right adjustable range of reed	0-40mm
7. 主电机功率 Power of main engine	15KW 18KW
8. 操作显示器 Operation displayer	10.4寸触摸屏 10.4 inch touch panel
9. 主机重量 Weight of main engine	3500Kg
10. 筒子架 Bobbin creel	V型循环式筒子架 V-shaped recirculated bobbin creel

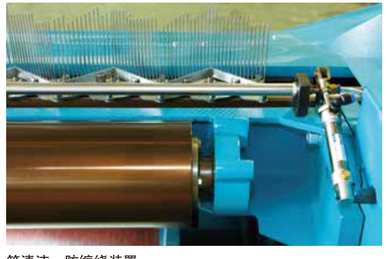
筘摆动装置
Reed swing device

压纱辊装置
Press roller equipment

锥齿形经轴夹头
Bevel gear type beam chuck header

主轴制动
Main shaft braking

四 星 ®
GA128C型分批整经机 GA128C DIRECT WARPING MACHINE



筘清洁、防缠绕装置
Reed cleaning and Anti-snarl device

压纱辊阻尼装置
Press roller damping device

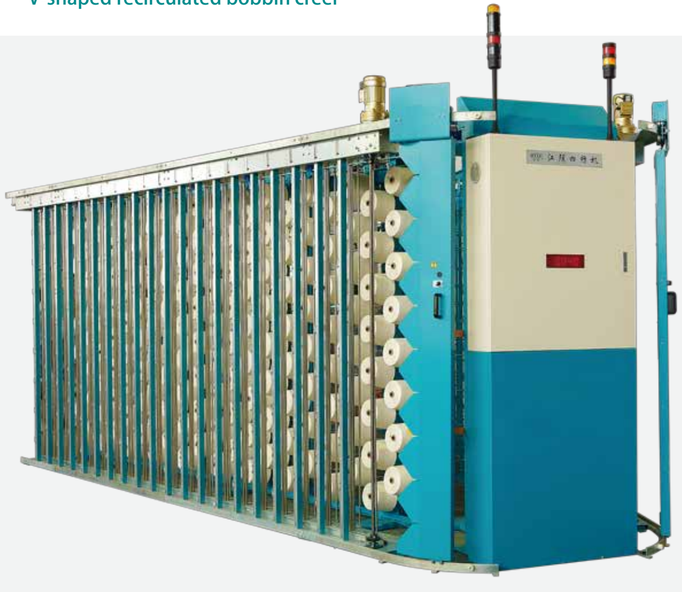
计长系统
Length measuring system

主机触摸屏工作站
Host computer touch screen workstation

液压控制系统
Hydraumatic pressure control system

电气控制系统
Electrical control system

V型循环式筒子架
V-shaped recirculated bobbin creel



颚式夹纱器
Alligator yarn clamp

电动剪纱装置
Electric yarn cutting device

电气控制系统
Electric control system

适用范围

V型循环式筒子架主要和整经短纤维的分批整经机配套使用。主要优点是架身短，架子与伸缩箝之间无导纱器，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型内侧可存放预备筒子架，便于工人操作，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。

Range of application

V-shaped recirculated bobbin creel is assorted with direct warping machine for staple fiber. Its advantages include shorter creel body, no carrier between frame and creel, especially adapted for some staple 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 inter lay-out yarn bobbins on creel optimizes the space utilization. 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 idle period for warping machine. This kind of bobbin creel is especially suitable for high speed warping.

主要技术特征

1、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，也可选择单边换筒。

2、两翼纱架呈V型排列，采用外导纱方式引纱，中间无导纱器，纱线在自由状态下退绕，可以获得更高的整经速度。

3、在经轴卷绕过程中对纱线进行柔和处理，使纱线的损伤减少到最小。

4、颚式夹纱器集成了带自诊断功能的断纱检测装置以及清洁夹纱器的喷气装置，夹纱器开放式设计使得穿纱更容易，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。

5、断纱检测装置集成带自动检测纱架当前纱线头份数功能的传感器，能自动存储纱线传感器的位置，没有纱线的传感器也能显示，提高换品种的效率。

6、传感器断纱灵敏度可根据不同的纱线自动调节，并且在断纱动作时在每锭、每列、左右都有显示，纱架前方的LED显示器上还能显示断纱具体位置，方便处理断头，提高生产效率。

7、集成的防气圈形成装置和预张力杆装置，在停车和启动时给予纱线柔性的张力补偿，前后纱线张力的差异也可以调整预张力杆的包围角来缩小。

8、高效率电动剪纱装置（选配）。

9、纱架前侧配有独立的控制箱。

Main technical features

1.Yarn bobbins can be changed altogether by electric circulation chain transmission after inserting the preparatory tube into the creel, or the tubes can be changed on one side.

2.The creel on both wings is arranged V type, the yarn will be entered by means of external rewinding, at the middle there is thread guide, the yarn is rewound in free state to get a higher warping speed.

3.Yarn will be softly dealt with in warp beam winding, in order to minimize the damage to the yarn.

4.Alligator yarn gripper integrates broken yarn detection device with self diagnosis functions and air-blow device for cleaning yarn clamp, the open design of the yarn gripper makes it easier for teh yarn to be penetrated, when the motor is turned on and turned off, the yarn can be softly braked in order to prevent the yarn from loosening in accelerating and deaccelerating.

5.The broken yarn detection device integrates the sensor which can automatically diagnose the current creel thread residue, and can automatically store the position of the yarn sensor, the sensor can display those creel without yarn, thus the efficiency for exchanging yarn types will be enhanced.

6.The broken yarn sensitivity of the sensor can be automatically adjusted according to different yarn, and can be displayed at every spindle, very column and at both sides when yarn is broken.The specific position of the broken yarn can be displayed on the LED in front of the creel, which makes it easier to deal with the broken yarn and increase the production efficiency.

7.The integrated anti-air balloon device and the pre- tension rod device can softly compensate the tension for the yarn when the motor is turned on and turned off, the difference between yarn tension can also adjust and reduce the enclosure angle of the pre tension rod.

8. High efficient electric yarn cutting device (optional).

9. Independent control panel is equipped at the front side of the creel.

主要技术参数 Main technical parameters

- 插筒锭杆为 φ10x240。
- 列距、层距、层数、列数、锭数见附表
- Spindle blade of donning: φ10 X 240
- Column distance, layer distance, number of layers, number of column, number of spindles please see attached table.

列距(mm) Column distance	层距(mm) Layer distance	层数(mm) Number of layre	列数(mm) Number colum / 锭数(mm) Number of spindle	36	40	44	48	52	56
240	240	9		648	720	792	864	936	1008
240	270	8		576	640	704	768	832	896
240	305	7		504	560	616	672	728	784