

,

1.

長, ,

. Lenzing社

,

.

,

. Lenzing社

33%

.

用

.

. 50/50 가 ,

.

100%

,

.

. Lenzing社

,

.

2. (flock material) .

가

가 3.6

$$\begin{aligned} &= \frac{9 \times 3.6}{25.4} \\ &= 1.27d \end{aligned}$$

0.9 den = 1.0 dtex

1.2 den = 1.3 dtex

1.5 den = 1.7 dtex

2.5 den = 2.8 dtex

3.0 den = 3.3 dtex

3.75 den = 4.2 dtex

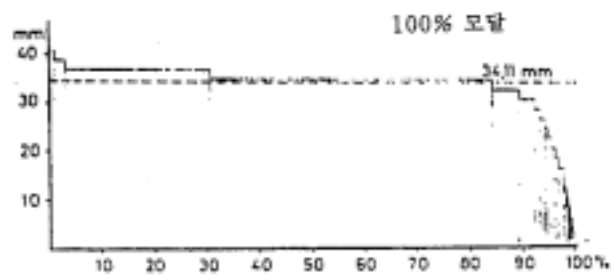
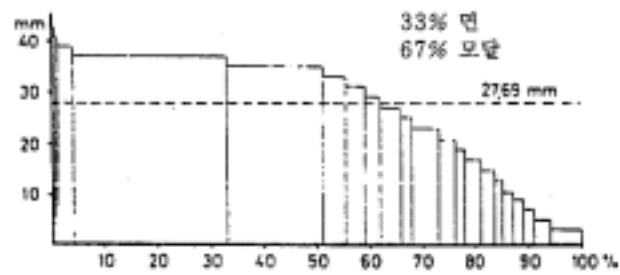
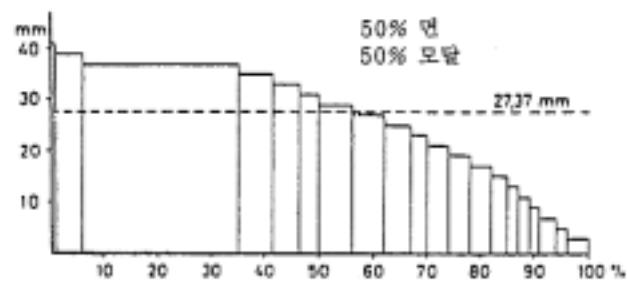
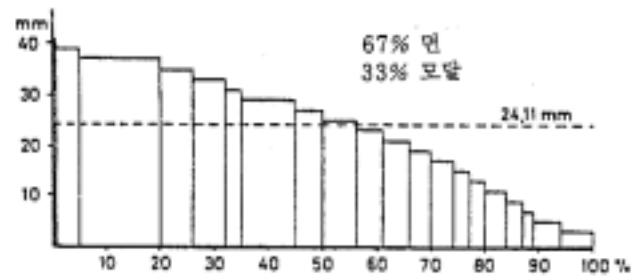
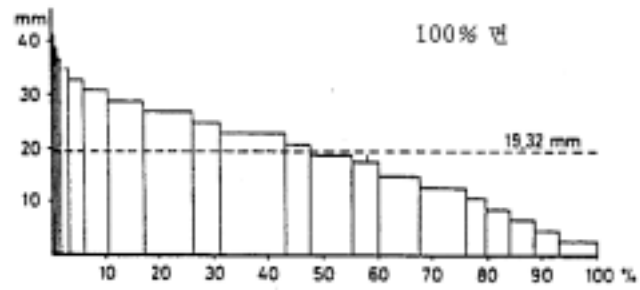


◦ : 22 ~ 26

◦ (RH) : 50 ~ 60 %

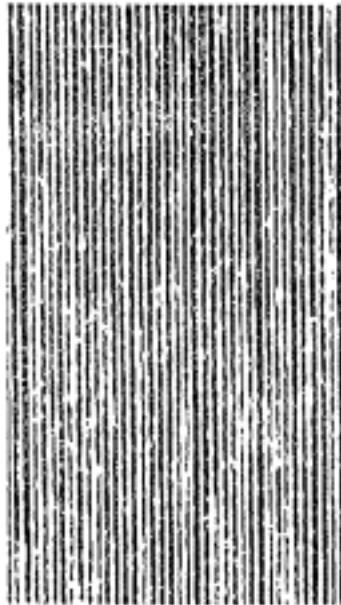
가



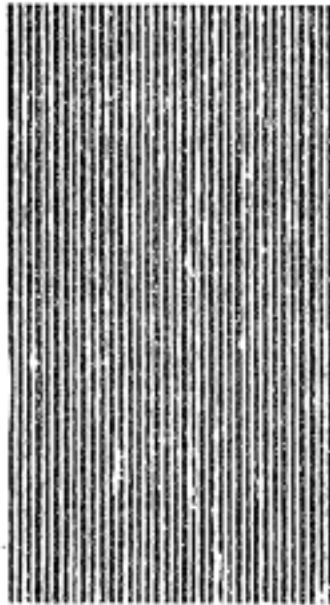


< 2> /

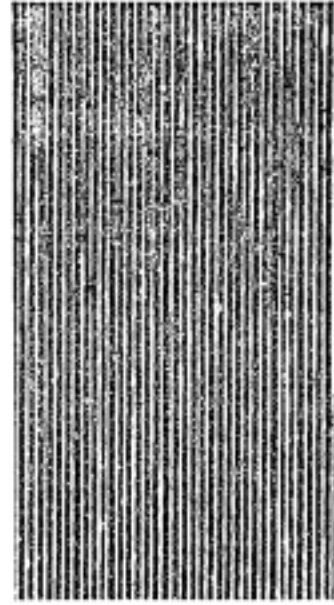
가 .



100% 소면사



50/50 모달/소면 혼방사



100% 모달사

< 2>

4.

(scutcher lap)

가 .

,

. Kirschner 가 가

◦ Kirschner 600 ~ 800rpm .

◦ 8 ~ 10mm

.

◦ 가 ,

2,500kpa .

◦ die block 200kpa .

◦ 400g/m<sup>2</sup> .

.

◦ ,

가 .

5.

.

가

.

가 5 ~ 10° 가

.

, 100%

.

< 3> 가 .

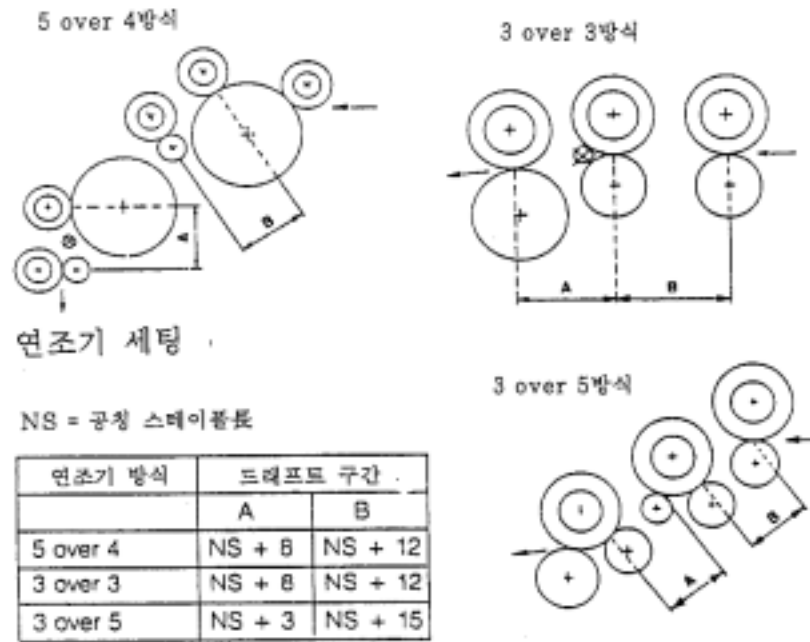
.



(lacquer)

가

< 4>



< 4>

7

3

Nm 0.20 ~ 0.30

가

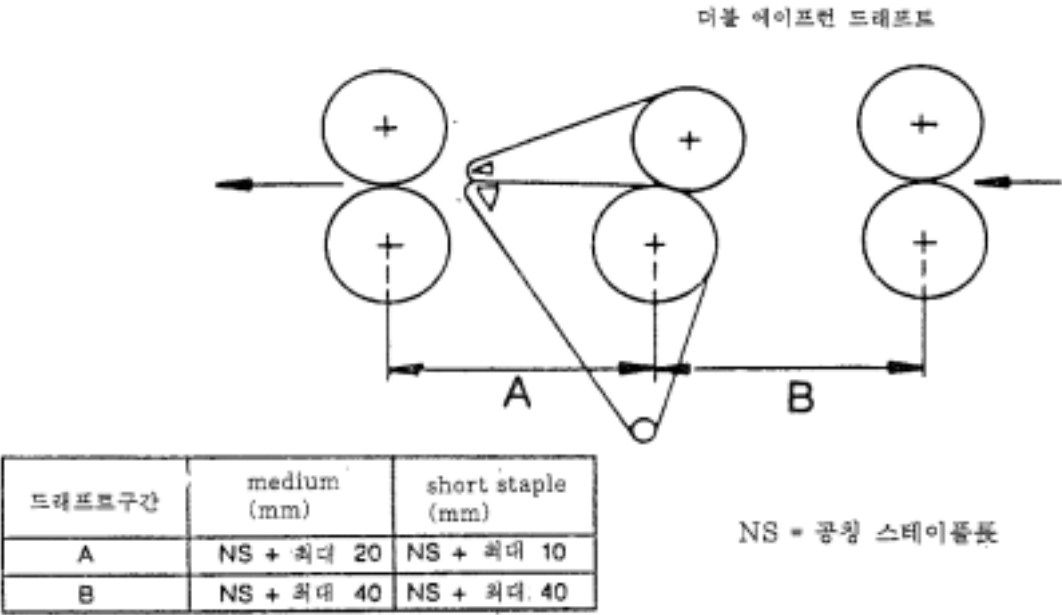
1.08 ~ 1.2가

가

가

Nm 1.0 ~ 3.0 , (α<sub>m</sub>) 27 ~ 32

가 < 5> 3



< 5>

8.

가

가 1.0, 1.3, 1.7 dtex

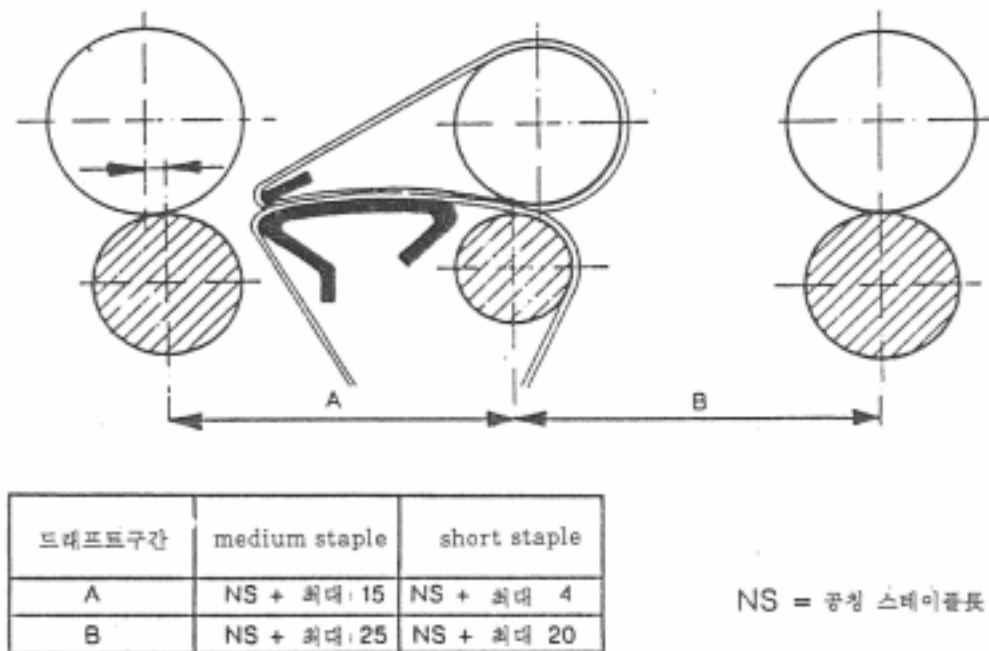
: 20 ~ 50

: 1.15 ~ 1.4

가

가

< 6> 3

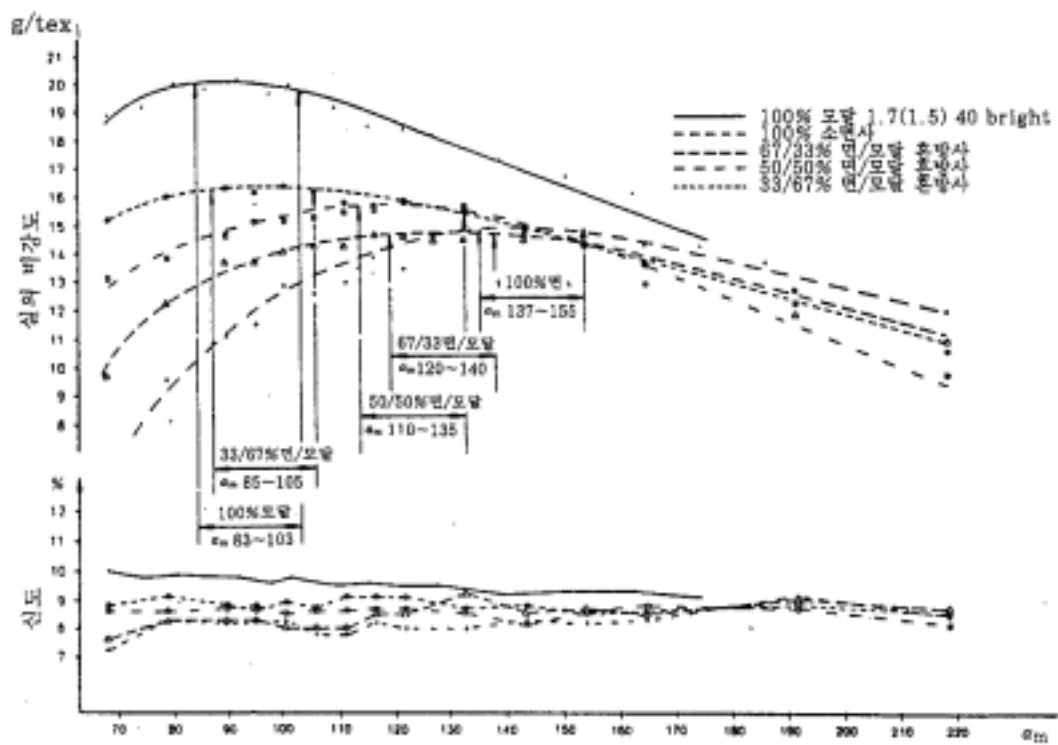


< 6>

(spinning performance)

가

< 7>



< 7 > 100% , 100%

가

34m/sec

(spinning limit)

가 70

9. OE

OE

(bright) ,  
(dull) 가  
.

9.1

. 가  
 .  $\alpha_m$   
100 ~ 130 , 20 ~ 30% .

9.2

Nm 0.17 ~ 0.30 ,  
가  
.

9.3

,  
.  
가  
,  
,  
.  
6,500 ~ 9,000 rpm .  
가 , (groove)  
 . < 1> , ,  
.

< 1>

| 섬 도     | 6.7~3.3 dte   | x1.7 dext            | 1.3 dtex       | 1.0 dtex |
|---------|---------------|----------------------|----------------|----------|
| 직경(mm)  | 5.6 또는 그 이상   | 48/46/45 40/38 36/35 | 33/32          |          |
| 최대(rpm) | 60,000        | 70,000 80,000 90,000 | 90,000~100,000 |          |
| 번 수     | Nm 18 또는 그 이하 | Nm 8~40              | Nm 28~60       | Nm 40~80 |

#### 9.4 (take off nozzle)

가 ,

가 .

, .

가 .

#### 9.5

$\alpha_m$  100 ~ 130 , 20 ~ 30%가

.

67/33% /  $\alpha_m$  95 ~ 130

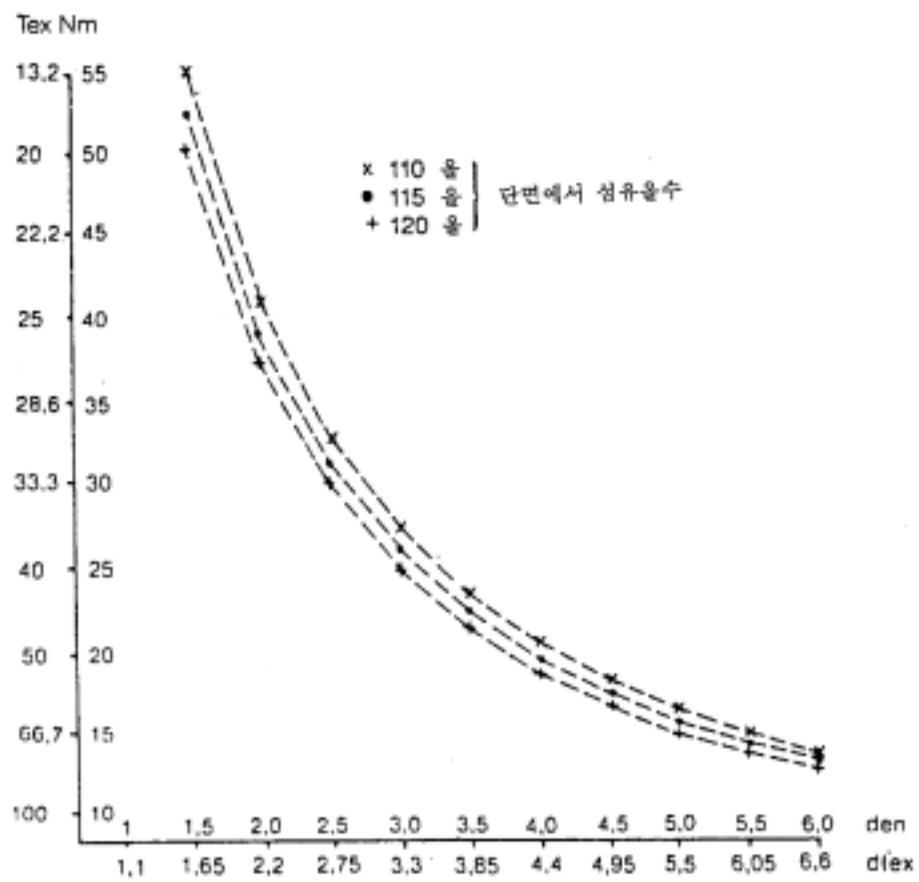
50/50% /  $\alpha_m$  90 ~ 125

33/67% /  $\alpha_m$  90 ~ 120

#### 9.6

, 가 120

. ( 8 )



< 8 >

10.

/ , /

1,200m/min 가

絲 絲

가

(knot)

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o

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o

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,

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