

Card
(Platt's Card)

H.P. Card

High Production

가

- 1. Nep web
- 2.

1. Nep

Nep H.P card 가 가 . 我社 card
Card

Nep가 가 .
Nep

: 40's

:

GM 1 1/16 " 20% M+1 1/16 " 20% M^{LS}1 1/16 " 20%
M+1 1/16 " 20% M1 1/16 20%

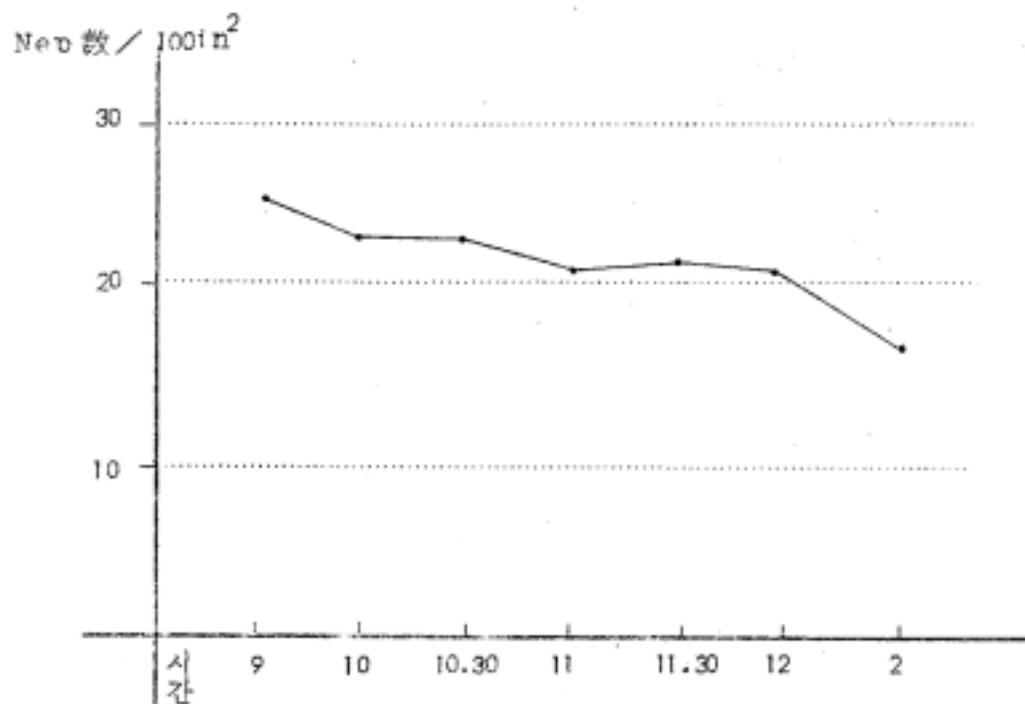
日 字	機 種	Plant(H.P)	Toyoda (N-2 Analyser)	Howa(普通)
	Cylinder r.p.m	306	300	178
条件	Takerin	918	827	460
	Doffer	8 ~ 16	13	10
	11. 1	41.06	41.82	38.78
	11. 2	37.51	39.40	38.05
	11. 3	38.96	39.59	40.47
	11. 4	38.78	39.70	37.92
	11. 5	39.46		
	平 均	39.15	40.12	38.81

(1) Nep

Nep

가

기 호	시간	9	10	10.30	11	11.30	12	14	平均	R
1		28	31	30	22	21.5	19.5	19	24.4	12
2		20.7	20.5	20	20.5	19.8	16.2	16	19.1	4.7
3		26	21	21.3	21.2	28.5	28.7	19.5	23.7	9.2
4		30	20.7	21	21.5	20.3	18	13	20.6	17
$\bar{x}$		26.1	23.3	23	21.3	22.5	20.6	16.87		9.23



Graph

Nep

17

가

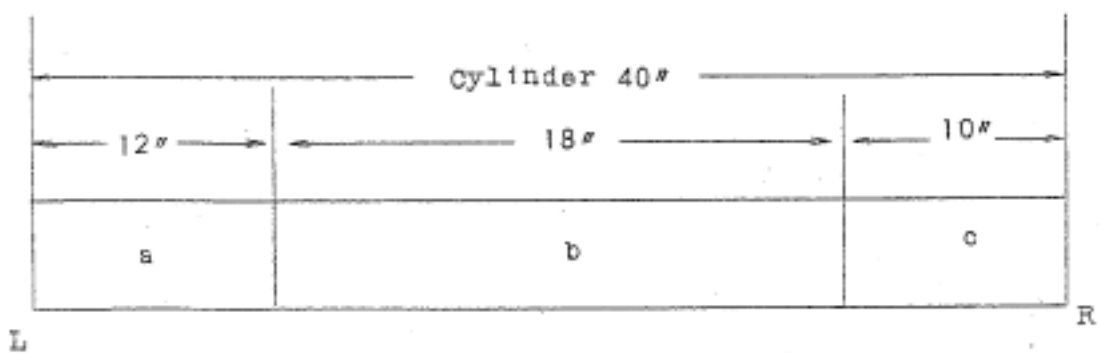
9

가

Nep

(2) Nep

cylinder part



- a 5 (3)
- b 21 (3)
- c 3 (3)

Nep b () 70%가
 . Cylinder
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Bare surface Grinder side .

MCC Mounting tension side
 .

Mounting card grinding side
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(3) Cylinder Flat gauge

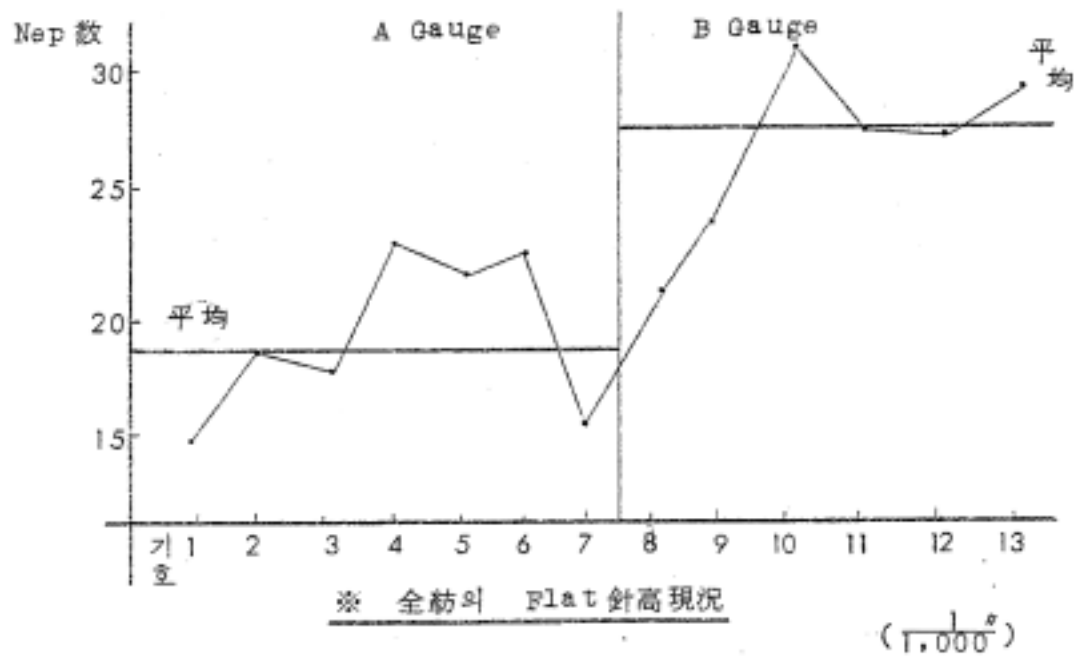
가 gauge Nep

A gauge $\frac{8''}{1.000}$

B gauge $\frac{12''}{1.000}$

graph Flat Cylinder gauge 가 Nep
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H. P card Flat
 card Flat Cylinder .



機号	R.H	L.H	機号	R.H	L.H
1	0	-2	14	0.5	0.5
2	0	1.5	15	1	1
3	1	1	16	1	1
4	0	0.5	17	1	1
5	0.5	0	18	1	1
6	1	1	19	1	1
7	1	1	20	0.5	0.5
8	0.5	0.5	21	1	1
9	0.5	0.5	22	0.5	0.5
10	0.5	1	23	1	1
11	1	1	24	1	1
12	1	1			
13	0.5	0.5	$\bar{x}$	0.70	0.87

即 平均 0.7 ~ 0.8°의 差밖에 없음.

(4) Front top sheet gauge

gauge

Nep

가

我社

Top sheet gauge

項目 \ gauge	24/1000	34/1000
Hep	48	32.5
落物 (白二)	1.17 %	2.02 %

(5) Taker in part

Taker in part gauge Nep

4가

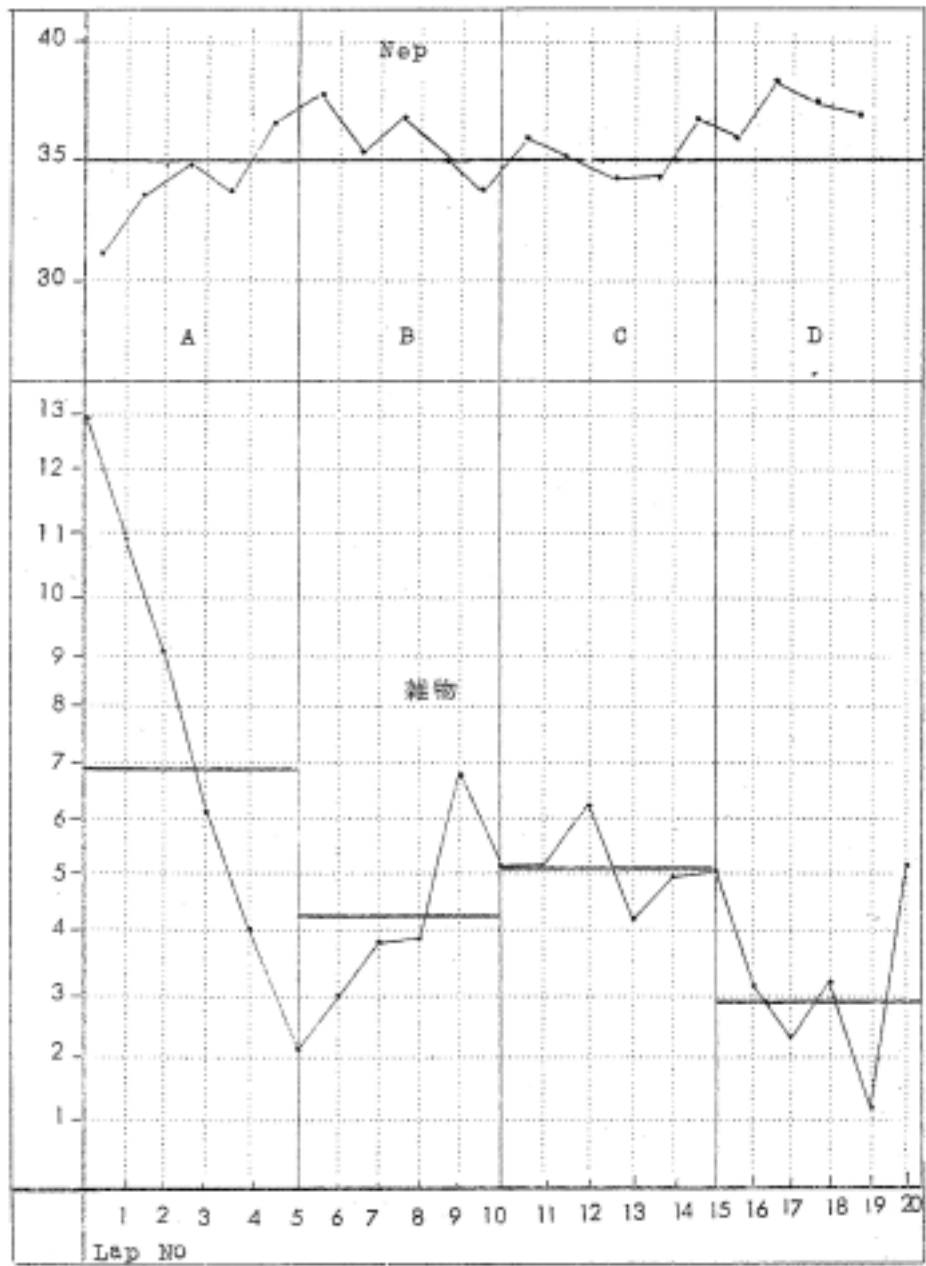
項目 \ 要件	A	B	C	D
Taker-in ~ Mote knife	0.007 ⁿ	"	0.01 ⁿ	"
" ~ taker-in under case	3/8 ⁿ	"	5/8	"
frame 上의 Mote Knife 높이	- 1/2	"	0	"
Mote knife 角度	75	"	90°	"
Taker-in rpm	900	675	675	900

Lap 20 1 lap 9 sampling

Nep

가 gauge taker-in rpm

가 가



(6) Grinding

Grinding

Grinder

가 4 "

Card

40

Grinder Cylinder Flat Emeryfillet .

Burnishing .

H. P. card .

gauge check

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(7)

가 Nep

card gauge gauge가

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gauge

gauge

gauge

가

가

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가

gauge setting

가

Check

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Flat 가 1/1000

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H. P. card

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2.

(1) cloudy web

web

cloudy web

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Cylinder side

cloudy web

Suction Dumper

web가 .

Suction

web Doffer Suction

Doffer M.C.C.

Card 가 3%

check

(40's)

区 分 项 目	H. P. Card	普通 Card
Cylinder rpm	306	176
Taker-in rpm	918	450
Doffer rpm	16	10
<u>Gauge</u>		
Cylinder~taker-in	7/1,000	7
Cylinder~Flat	7	7
Cylinder~Undercase	34,68,102	22.43.1 ⁸ / ₈
Cylinder~Doffer	4	4
Cylinder~bottom sheet	上 34 下 17	上 34 下 17
<u>梳棉度</u>		
Feed Roller~Cylinder	14.26	13.35
Flat~Cylinder	53.33	65.63
Cylinder~Doffer	0.1996	0.284

H. P. card sliver card sliver

項 目 区 分	H. P. Card sliver	普通 Card Sliver	備 考
計 算 番 手	38.89	39.47	
生 Grain(Grain)	25.56	25.26	
番手 CV %	3.11	2.90	
水分率 (%)	7.90	8.19	
Leu 強力 (Lbs)	51.37	48.87	
換算強力 (Lbs)	49.94	48.22	
番手開差率 (%)	+1.81	+0.33	
單 絲 強 力 (g)	187.32	177.24	
伸 度 (%)	5.44	5.18	
U %	15.72	15.76	

H. P. card sliver가 가