

Back Zone

Draft Tension

1.

Back zone Draft Tension(Break Tension)

Draft Force Draft

Break Tension .

Break Tension Trouble

Break Tension , Break Draft , Back Roller Gauge

Break Tension

.

Break Draft

Draft

Roller Gauge .

Break Tension

Break Tension

.

2. Break Tension

Break Tension

Trouble

Acril 38mm × 65% 35%

45's Top Arm Back Gauge

41mm 43Lbs

. Break Tension 45~50g

Back Gauge 48mm Break Tension 20g

43Lbs . Break Tension 45~50g Back Gauge 48mm

Break Tension 20g 48Lbs

가 .(Total Draft .) 가

Break Tension Draft

() . Break Tension (10g) , Tenson .

Acril Roller Gauge 41mm 가 , Roller 가 , Oiling 가 Roller Gauge 가 . Break Tension 가 Break Tension Trouble .

3. Break Tension

120g(44mm) Roving Tester

Roller Gauge 가 . Break Tension .

Break Tension

Main Draft , Roller

Self Weight 20~25g Top arm 30g

가 R

1/2 가 .

4. Break Draft

Break Draft Draft Force 가 가 Break Tension

. Break Draft 가

High Draft Break Draft = $\frac{3\sqrt{\text{Total Draft}}}{2}$ (1.4)

Break Draft

Main Draft 가 Break Draft

, Main Draft

Break Draft .

Break Tension

Gauge .

5. Break Tension

Break Draft Roller Gauge Break Tension 1

127g

Gauge 가 .

. . . Card 40's 65gr/15yd, 127g

Draft . . . H K Top Arm , 가 Back 7kg, Cradle 2.4kg

. . . Gauge 5

. . . 23 × 60%

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< 1> Break Draft Tension

Break Draft 比	Back Middle Roller Gauge mm	Break Draft Tension g	Break Draft 比	Back Middle Roller Gauge mm	Break Draft Tension g
2.0	40	8 ~ 10	1.54	46	18 ~ 22
	38	11 ~ 13		044	20 ~ 25
	036	15 ~ 20		42	22 ~ 28
	34	20 ~ 30		40	25 ~ 30
1.85	40	10 ~ 12	1.42	38	30 ~ 35
	38	15 ~ 18		50	15 ~ 20
	036	20 ~ 25		048	20 ~ 25
1.73	40	15 ~ 20	1.31	46	25 ~ 30
	038	20 ~ 25		44	30 ~ 35
	36	25 ~ 30		56	17 ~ 21
1.63	52	8 ~ 10	1.26	54	18 ~ 22
	50	10 ~ 15		052	22 ~ 26
	48	13 ~ 16		50	25 ~ 30
	46	16 ~ 18		48	30 ~ 35
	44	18 ~ 22	1.26	46	38 ~ 43
	042	20 ~ 25		60	20 ~ 25
	40	23 ~ 28		58	27 ~ 30
1.54	38	28 ~ 30	1.26	56	28 ~ 32
	52	8 ~ 12		54	33 ~ 38
	50	10 ~ 15		52	35 ~ 40
	48	15 ~ 20			

< > 1. Break Draft() 0.1 4.7g

2. Roller Gauge() 2mm 3.37g

3. Break Tension

Back Roller Gauge Top Roller

1/3 가

Draft Gauge

6. Break Tension

Break Tension Break Draft

2 Tension

.

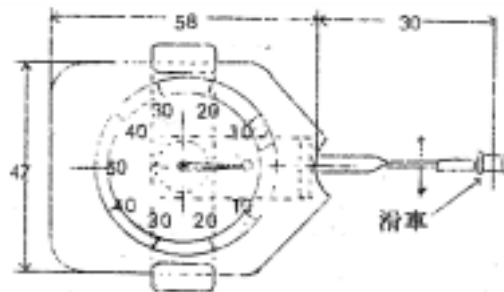
(

가) Break Tension Gauge

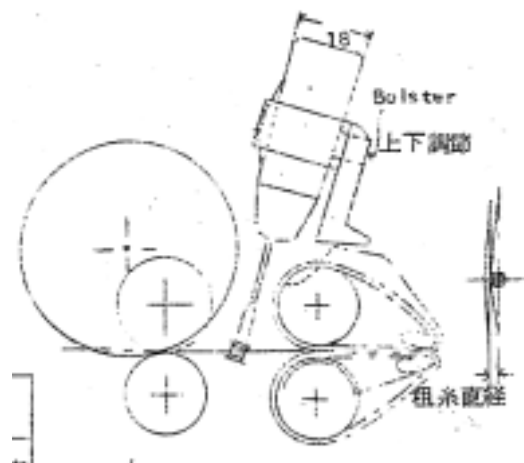
가 .

Break Draft	Roller Gauge mm	Back Roller		Break Tension	
		(in)		Tension(g)	
1.54	44	34.6	100.0	20~25	100.0
		40.9	118.2	25~30	111.1
		55.0	158.9	30~35	144.4

Tension Meter(1) 2 holder Cradle
 (Cradle Top arm Capper Bar 가) Meter
 Bar Back Zone
 가



< 1> Draft Tension Meter



< 2> Draft Tension

Tension

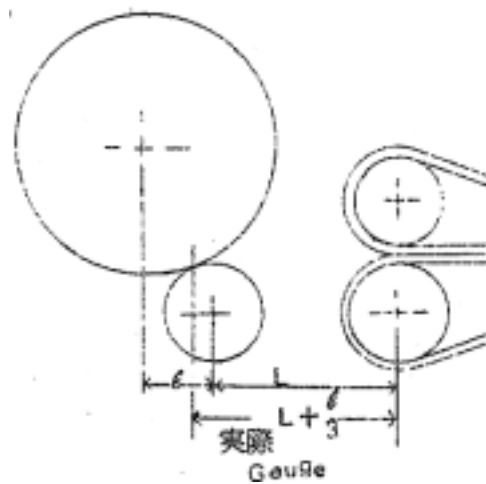
가

Tension

Tension

8. Back Roller Gauge

	Break	Tension	Trouble
Roller Gauge		Self weight	3
Back Top Roller		Bottom Roller	
.		Maker Roller Stand	
5~18mm 가		Bottom Roller	
Gauge		Gauge	1/3 가
		gauge	가 .
Top roller		Bottom Roller	
Bottom Roller			가
Top Roller	1/3 가	.	



< 3> Self weight Back Gauge

9. Trumpet , Break Tension

Trumpet	Back Roller Nip	Gauge	Back
Roller	Break Tension		

Top Arm Maker
 .
 Trumpet 가 Gauge,
 Tension 15g 가 . Gauge
 Tension 가 .

10. Draft Break Tension

Break Tension Draft Force

Draft Force Break Tension
 Draft force 70% .

11. Break Tension Draft

Draft 3 Break Tension 45~50g 83.2%,
 20~25g 88.6%, 10~12g 94% . ,
 10.8g Main Draft 가 .
 30g
 가 Break Tension 20g 가 .

< 3> Tension Draft

Break Tension(g)	Draft (%)
45~50	83.2
20~25	88.6
10~12	94.6

< > Break Draft 1.54, 1

20~25g

10 % Break Zone 가 .
Tension Break Draft Back
Roller Gauge .

12. Break Tension

Main Draft Break Draft
Roller 가
() Main Draft
가 Control
, 가
Break Draft가 가
Main Draft Main Draft
가 Draft가
Draft 가
Draft가 Trouble 가
Break Tension
Trouble .
Trouble Break Draft part Draft Force 30g
Draft Force 가
Break Tension
Roller Break Tension 20~25g가
가 30g .

13.

Break Tension

, Draft

, Back Top Roller

Trumpet

Break Tension

Break Tension 20~25g

Back Roller Gauge

가 .