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(4) TAS (Toyoda Automated Spinning System)

Carded yarn . 2
Sliver
.
CK , Doffing,
Air-cleaning .
(Automatic cotton feeder ; ACF) Reserve
box lap . ACF 3
가
Cage .
1 30~40Lbs/hr CK 3
Sliver Ribbon Reserve box Conveyor
.
2 Calender roll Conveyor
.
Sliver Auto drawer front(ADF) 4~5 Drafting
system Drawing (Delivery speed ; 200~500m/min) 16in × 36in Can
.
Can Can Doffing 8
Sliver Doubling Auto draw back(ADB, 150~200m/min.)
.
ADB Can 가
.
8 Can Sliver 가 Cart
FXA . 14in. × 7in. Large Package

		Doffing		Flyer	Upper
Cantilever가	.				1/3
Doffing	.	Flyer	1,200r.p.m.		Drafting
25 가	. RR3		4line draft		40~80
Drafting	.				
	Auto-doffer			Doffing	가
.			Winder		
		Kamimat auto-spooler가		.	

(5) DASS (Daiwabos' Automated Spinning System)

		O-M spinning machine Mfg. Co.,		,
			TAS	가
Carded Yarn				.
	Hooked fiber			.
	Plucker	blender가		,
			Automatic doffing	
	.			
10	Plucking Part	Plucking		Duct
	Blender		가	
		Sheet former		.
8		Ribbon	Web	Conveyor
				layer
	Drafter	.	Drafter	
			.	
Sliver		Drafter		

		Sliver가		Can	
Doffing	.				
.					
DL					
Flyer가				Presser Ring	
			.		
20in. long lift,		Flyer		1,200~1,500r.p.m.	
.					
Drafting	5 line apron	High draft system			2
Sliver가	15~30	Drafting	.		
		가			
가	.	Flyer			
Bobbin holder	.				
Doffing				Blow Cleaner	
		.	Doffing	가	2
Doffing	1		Automatic doffer		
10		doffing	.	Automatic dofter	
					.
1966	12	가	Data		.

Plucker set(10bale)

300kg/hr.(660lb/hr)

Card feeder(1)

45.4kg/hr.(100lb/hr)

Card lap former(1 8)

36.2kg/hr.(80lb/hr)

Drafter(1 Card 8)

35.4kg/hr.(77.7lb/hr)

DL (1)

0.417kg/hr.(0.92lb/hr)

		Sliver	Sliver	Draft	T/in
Plucker cylinder	540rpm				
Card feeder delivery roll	1.35 "				
Lap former			Lap 150z	12.0	
Drafter front roll	166m/m	300 × 8/6yd	300/6yd	8.8	
DL Spindle	1,200rpm	300 × 1/6yd	60/12yd	9.9	1.58/in
		300 × 2/6yd		19.8	

Sliver

40's 1.5%

Auto doffer

가 40's 35 ~40

		μ %
Grain	24.77	() 14.8
	1.70%	() 5.0
	7.79%	
Lea	49.90	
Lea	48.04	
Lea %	5.05	
Lea %	6.69	

(6) KATS (Kurabo Auto Transfer Spinning System)

Spindle .

Chain

Cover . Sliver가 Can Belt

conveyor Chain conveyor

Vertical Plucker Plucking .

Non lap card feeder(NCF) .

가 OS .

8 Sliver Conveyor belt Singleprocess

drawer(SPD) . Card

. SPD 2 Drafting 1 가

220m/min .

Sliver 16in × 36in Can Can

Can Creel

Can . $F \times A$ 2 Sliver

1,200r.p.m. . Can Creel

Sliver guide 가 .

Chain Conveyor .

Conveyor .

RR Spun cop Automatic doffer가 .

cop conveyor

conveyor pipe

가 Self weight selecting mechanism

cop Cheese .

Belt conveyor

Bobbin box .

KATS Veertical plucker

.

Vertical plucker (40's)

		Vertical plucker	
	%	3.7	4.1
Web nep	/10in ²	4.6	6.7
Sliver	mm	25	24.5
Sliver	%	32	35
,	-	128	125
nep	-	130	127
μ %	%	15.5	16.2

KATS 40's data .

40's

		1		2			
Grain		262 × 2/6yd	350/6yd	500/6yd	350/6yd	320/30yd	40's

		Doffer 6rpm	220m/min	Doffer 12.6rpm	220m/min	Flyer 1,000rpm	Spindle 14,000rpm
Draft			1.83×7.5		6×8.45	10.9	55
Kg/hr	Plucker 300	5.35	53.5	10.5	52.5		
			12.5kg		12.5kg	2kg	75g

Data KATS 3 20
 1 1.0~1.2 . 1 가 25,000
 가 .

3.

7 .
 .
 .
 Plucker
 (Auto
 doffer)
 , , .
 Sliver
 , 1 2 .
 가
 .
 20's 400lb 가 8
 1.2
 , , ,

•

.

,

가

1/3 .

가 .

가 .

panel control system

가 Center

•

Sliver Roving

가

가

가

가

.

가 .

가가 15~20%

10% .

가 .

가

가 .

가 .

“Multi-fiber ” .

가 가

.

가 .

가

가 .

가

Automatic yarn

end-piecer 가 .

.
가

.

가 .

가

.

가

가 .

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