

OE

(rotor yarn) 가 (ring yarn) , 가
.
가 ,
(nominal twist) (actual twist)
가 .

Kasperek , (core)
.
 , 가 가

. Kasperek ()
) .

Krejci 1968 BD 200 가
가 . $T_M = 0.905T_A + 46$
($T_M =$, $T_A =$ 가)

Kleinhansl
0.1~0.2p/tex, 0.4~0.6p/tex (pre-tension) 가
.
fiber finish가
가 .

가 , 가

, Schutz Kueny

, 30.5mm, 4 .
 , 3 ,
 3,225tex . Sussen rotor box (head)
 30.4tex (106) .
 6,700rpm . 46mm 13 56mm
 2
 Box Hunter (Central rotatable design)
 . 2 .

< 1>

捻係數	標本の 크기	로우터 速度 r. p. m.	標本の 크기
2.30	2	25,860	2
2.40	4	30,000	4
2.65	14	40,000	14
2.90	4	50,000	4
3.00	2	54,140	2

1 TM , 가

.

2.3~3.0 25,860~54,140rpm

30.4tex .

.

.

a. – 가 ()

b. Kueny

c. Zweigle . 가 (Modality untwisting double twisting).

/ 가 가

.

.

i.

Zweigle

: 500mm

: 0.98cN/tex

5

.

1/4

.

: 30 /

: 1,000rpm

	Nominal twist (t/m)	Untwist- ing— twisting	Kueny- Schutz method (t/m)	Auto- matic torsi- meter (t/m)
1	710	705.20	751.62	733.77
2	710	714.87	707.90	731.24
3	826	837.87	807.63	846.61
4	826	859.13	869.17	881.14
5	768	788.40	764.82	796.86
6	768	782.33	795.68	791.77
7	687	657.87	687.95	707.23
8	849	859.07	830.23	867.12
9	768	795.47	795.08	818.08
10	768	773.60	755.90	797.72
11	768	747.77	755.38	777.82
12	768	765.80	765.97	786.75
13	768	779.73	777.55	798.69
14	710	718.20	704.98	742.22
15	710	721.13	720.15	739.70
16	826	833.27	810.14	857.51
17	826	811.47	849.62	824.95
18	768	782.20	781.40	784.80
19	768	778.85	773.65	796.76
20	687	685.50	682.62	691.67
21	849	877.27	867.35	891.70
22	768	775.60	791.77	801.31
23	768	750.00	739.52	783.87
24	768	774.07	764.45	790.46
25	768	811.40	811.58	818.56
26	768	772.13	758.43	798.26

ii. Kueny Schutz

Zweigle

: 500mm

: 0.98cN/tex

: 15 2 , 10m

(jaw) : 1,000rpm

iii. Zweigle

: 500mm

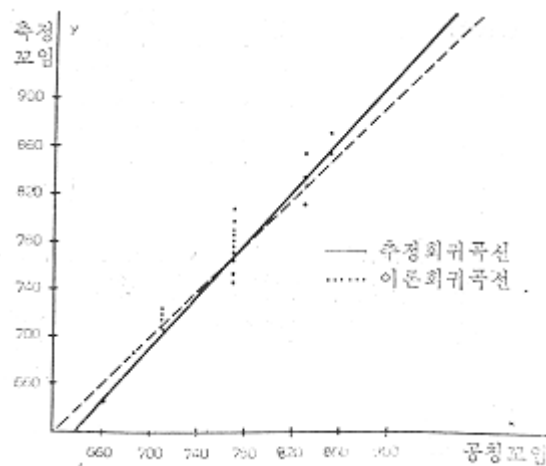
: 0.14cN/tex

: 60

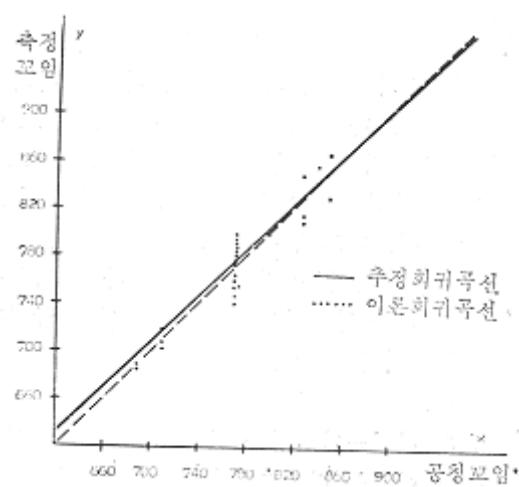
48

(65% RH $\pm$ 2%, 20°C $\pm$ 2°)

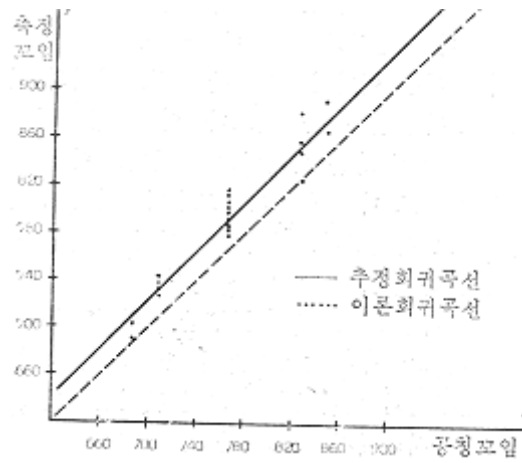
.



< 1> 가



< 2> Kueny and Schutz



< 3>

2 . 1,2,3 가

45° , 1 .
가 가

3 2 . x
가 y .

3 .

0.9661 가

. Kueny-Schutz

가 ,

가 (12t/m) 가

. 가
가 , 3가

(88t/m) 가 .

< 3>

측정 방법	상관계수	회귀적선	그림
해연가연법	0.9591	$x=0.8179 y+133.9109$ $y=1.1247 x-88.4845$	1
Kueny-Schutz	0.9148	$x=0.8441 y+114.7863$ $y=0.9914 x+12.4756$	2
자동크림 측정기	0.9661	$x=0.8857 y+64.3943$ $y=1.0539 x-14.9885$	3

가 .

20 25 .

가

가

.

$$T_M=0.9914T_A+12.4756 \text{ (Kueny-Schutz)}$$

) x y T_A T_M

Krejci T_M=0.905T_A+46

.

Kueny-Schutz

가

. 가 2

,

가 .

가 가

Kueny-Schutz 가

. 가

.

4

.

가

.

< 4>

x	y	상관계수	회귀직선
Untwisting-twisting	Automatic	0.9833	$x=0.8658y+102.6220$ $y=1.0137x-9.1876$
Untwisting—twisting	Kueny-Schutz	0.9368	$x=0.9147y+85.2998$ $y=1.0569x-64.4291$
Automatic	Kueny-Schutz	0.9354	$x=0.9411y+66.1350$ $y=0.9293x+35.5706$

.

Kueny-Schutz

-가

Zweigle

(modality untwisting-

double-twisting)

.

,

20~25t/m

.

-가

768t/m

가

가

가

.

(trend and orientation)

.

.

가

.

,

0.90

0.91~0.98

가

.