

가 (14)

5) relax

(生)

, , ,

.

.

→ → (heat setting)

.

heat setting

.

가

SF

.

.

open soaper

.

open soaper

guide roller

mangle

nip

.

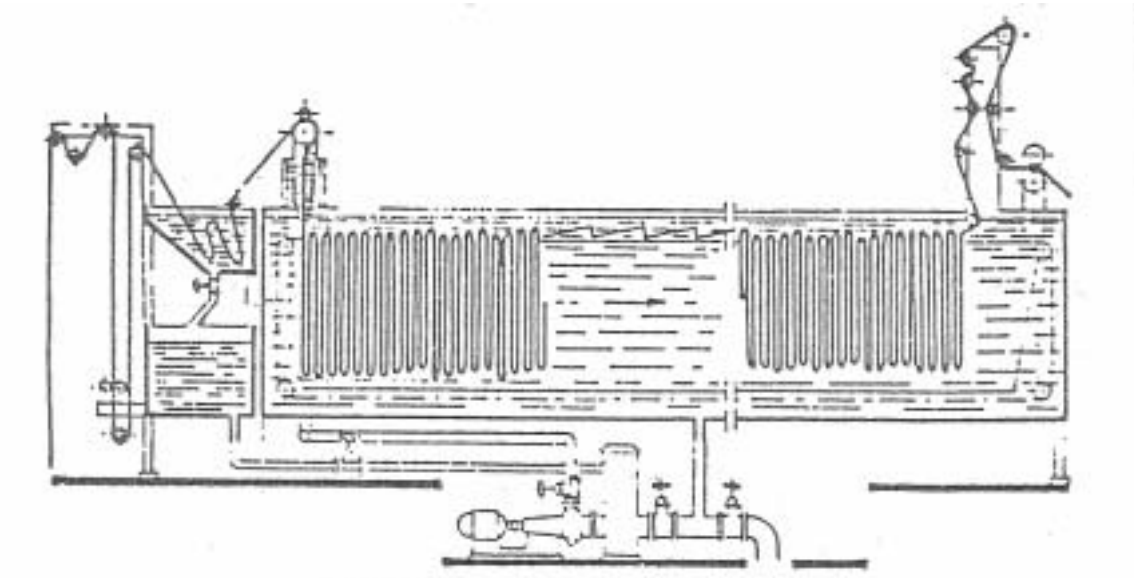
가

Scouring

Relaxation

Boil-off soaper <

1>가 .



< 1> Mazzera VB

< 1>

tank가 (含浸) Saturating tank
가 slit tank hanging bar
loop가 . Hang bar loop 가
.

NaOH 1~3 g/l
2~3g/l
Alkali builder 1~2g/l

Builder Sodium tripoly phosphate Soda ash

.

가 .

.

가

,

.

가 Relaxing

.

,

. Relaxing 가

.

.

, Relax 가

가

.

.

. 가 生

→

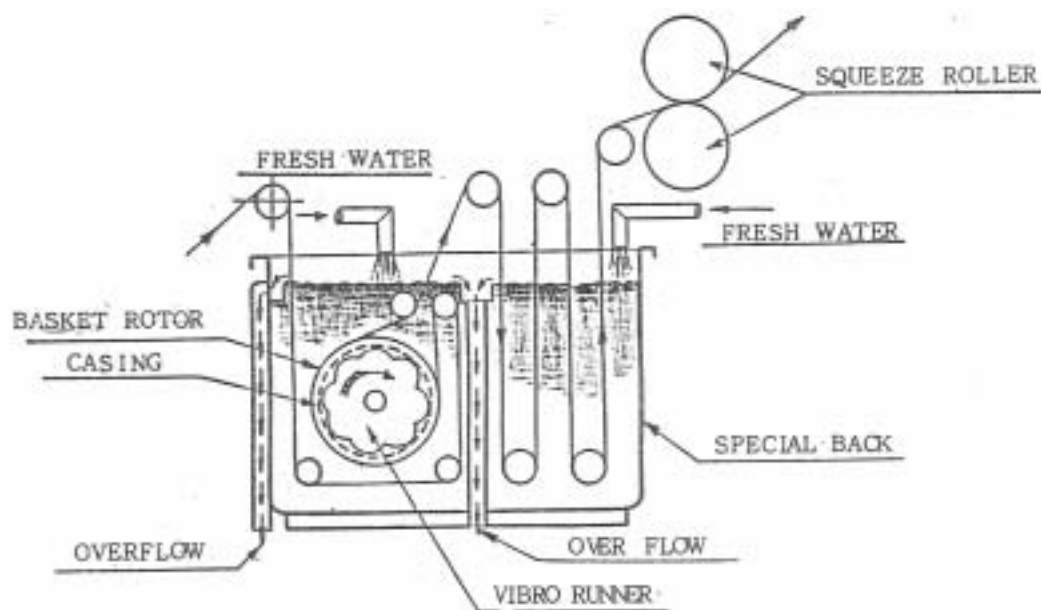
→

→

(pre-setting) → NaOH 가

가
 → () → (pre-setting) →
 NaOH 가

80 5



< 2> Viro-Washer

Relax

< 2>

Vibro Washer

가 . Vibro Washer

Vibro-runner

, Runner

Casing

가

Casing

.

3,000

.

Casing

basket rotor

, basket rotor

가

.

loop

heat-setting

over-

feeding

.

Rotary-Washer

Rotary-Washer

loop

가

.

.

가

.

가

가

.

가

Pongee

tropical

Toskine,

.

가

.

relax → rope

relax →

→

(pre-setting)

relax

relax

.

relax

, 가

.

-

- 가

-

,

-

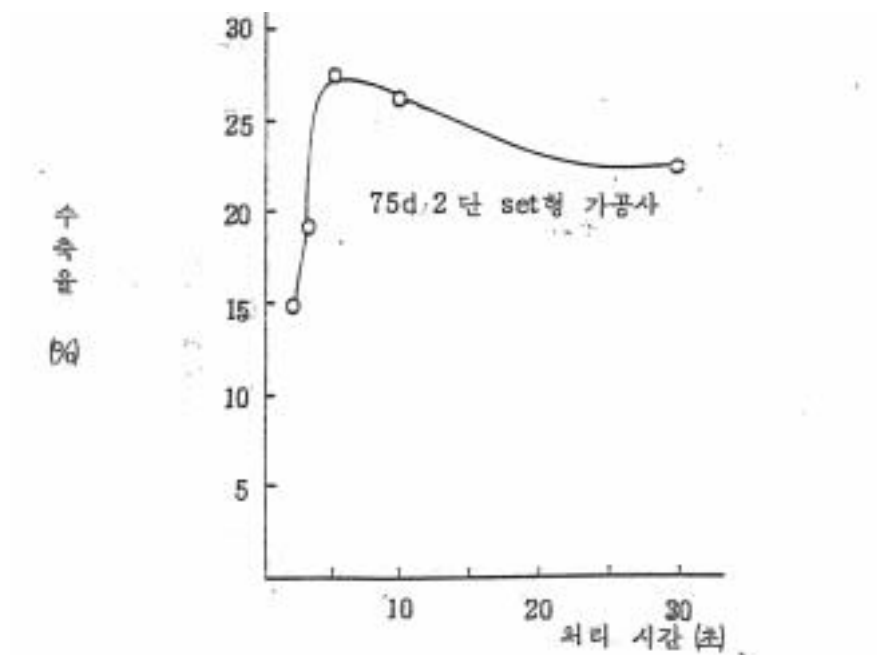
가 가

< 3>

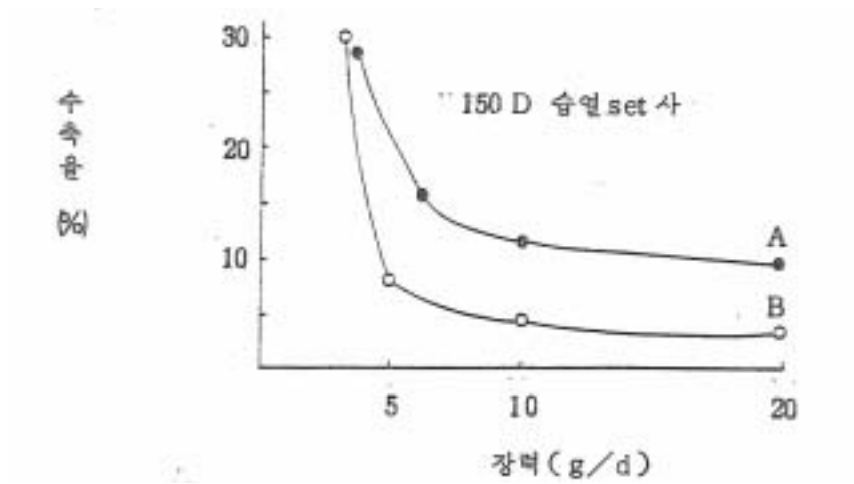
.

< 4>

.



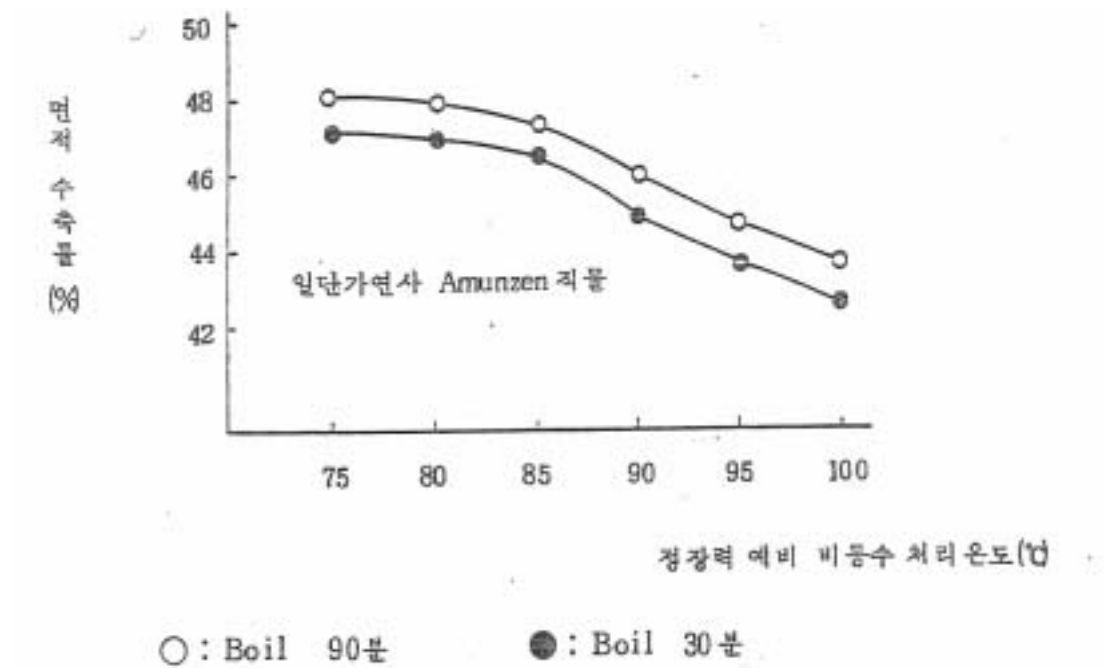
< 3>



A : , B : PET/PEI Copolymer

< 4> 가

Wet-Setting



< 5> pre-relaxation 가 relaxation

< 5>

pre-relaxation tank

가

가 .

Relaxation

.

< 1> 150denier

Cashmere

6 /3

가 60

.

< 1>

()	0.5	1	2	5	10	20
가 ()	3	6	12	30	60	10
(%)	38	37.5	38	37.5	38	39

< 2>

()		50	60	70	80	90	100
(%)		2.5	9	16	18.5	22.2	29
		4	13.5	24.5	32	37	38.5
		1.6	1.5	1.5	1.7	1.7	1.6

가

.

60 가

< 2> .

가

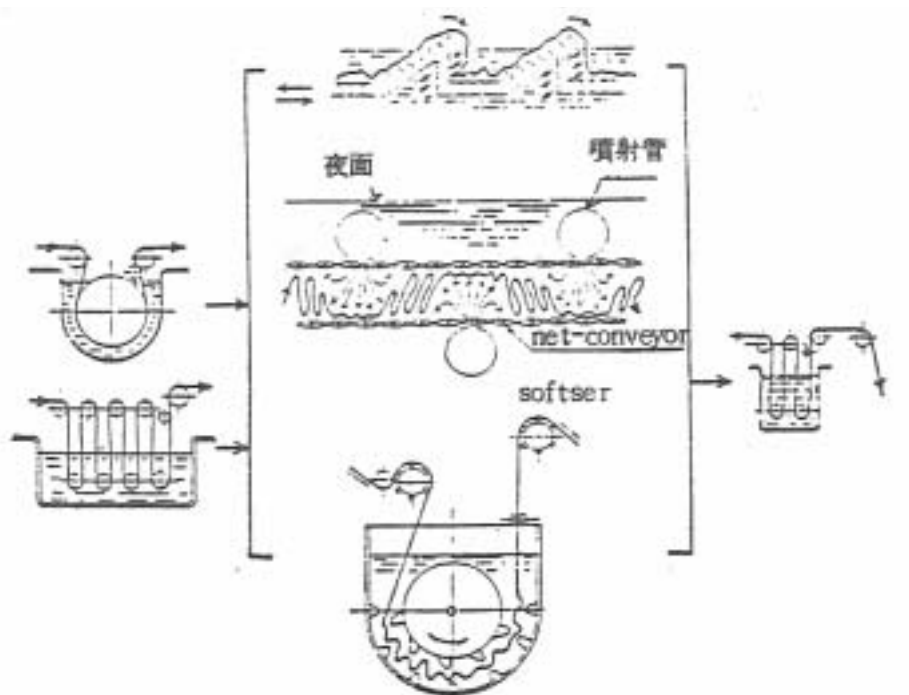
가 Relaxer 가

가

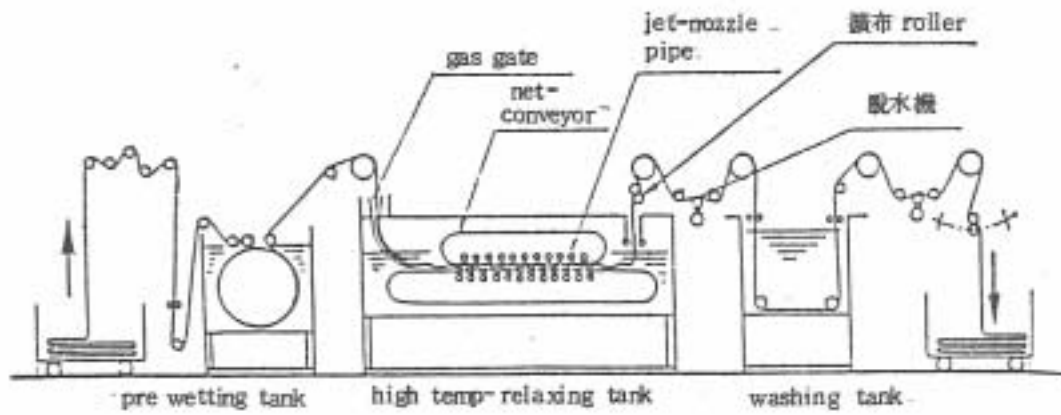
가

Relaxation machine < 6> ,

Relaxation-machine < 7> .



< 6> Relaxer



< 7> relaxation machine

pre wet tank : roller drum

. 50

:

가

20

Washing tank :

fold-mark

가 Scum

Relaxation

Handle

Relaxation

Heat-setting

Relaxation

80

Wince

가 .

NaOH(38°Bé)

3~5g/l

1~2g/l

Tri-Polysodium phosphate

1~2g/l

→

→

→

→

→

→

→

가

Embossing 가

60 ~100

가

Roller

Embossing 가

Embossing 가

Embossing

가

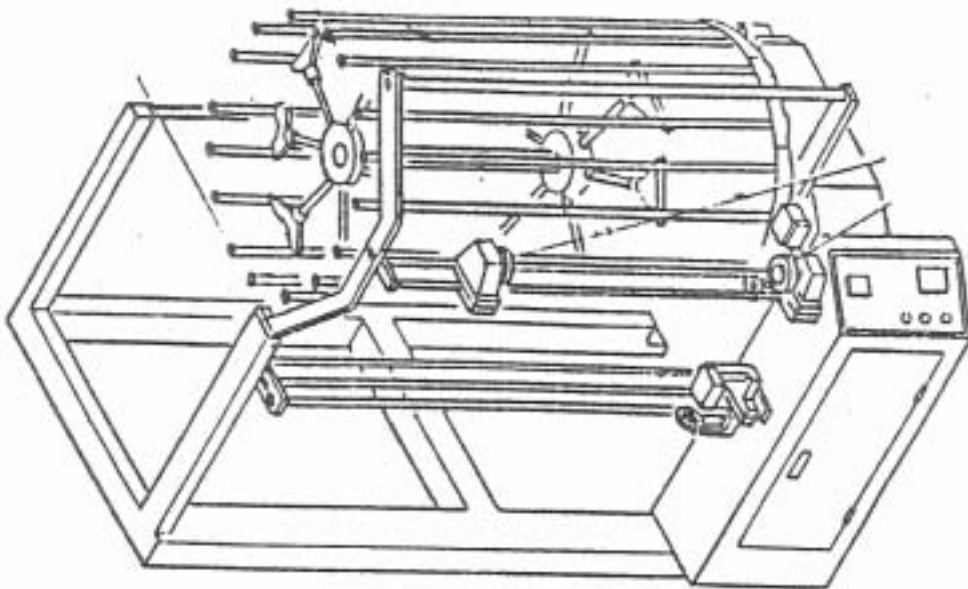
가

가

•

가 2~3m

가



< 8 >

know how

.

Rotary Washer

Rotary Washer

.

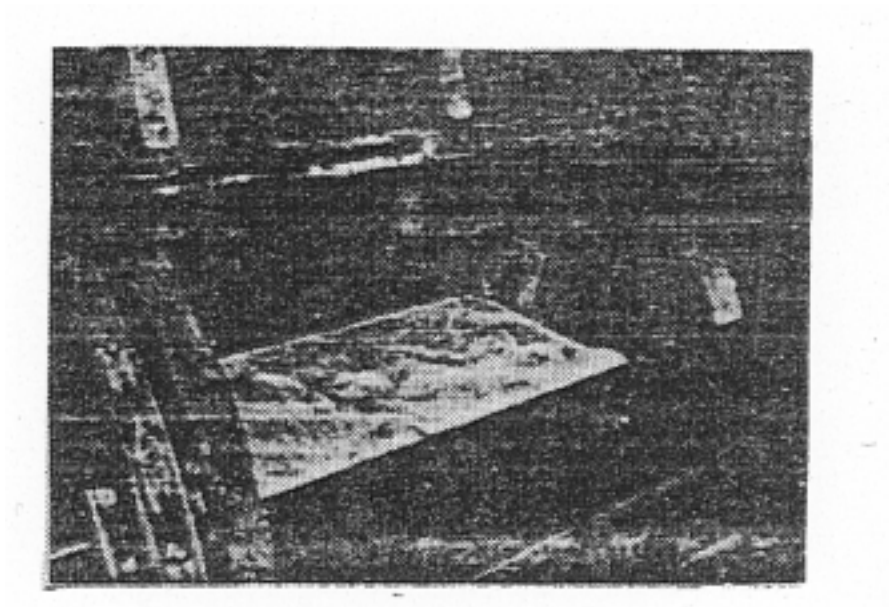
Rotary Washer

.

Rotary Washer

< 9>

.



< 9> Rotary Washer

Rotary Washer

1m , 2.5m

가

. 가

5~10

.

가

가

Rotary Washer

가

가

Rotary Washer

가

가

가

Relaxation

가

가

Rotary Washer

Wet-setting

가

Relaxing

Rotary Washer

가

Rotary Washer

-

가

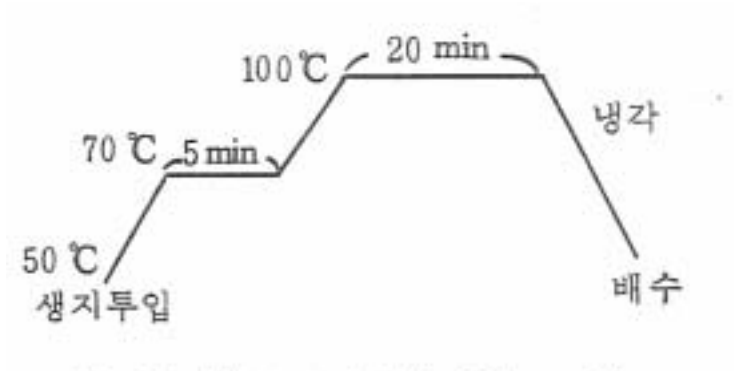
know-how

Rotary Washer

가

가 .
가 가
. Rotary Washer

< 10> .



< 10> R/W

50 - 70
5 ,

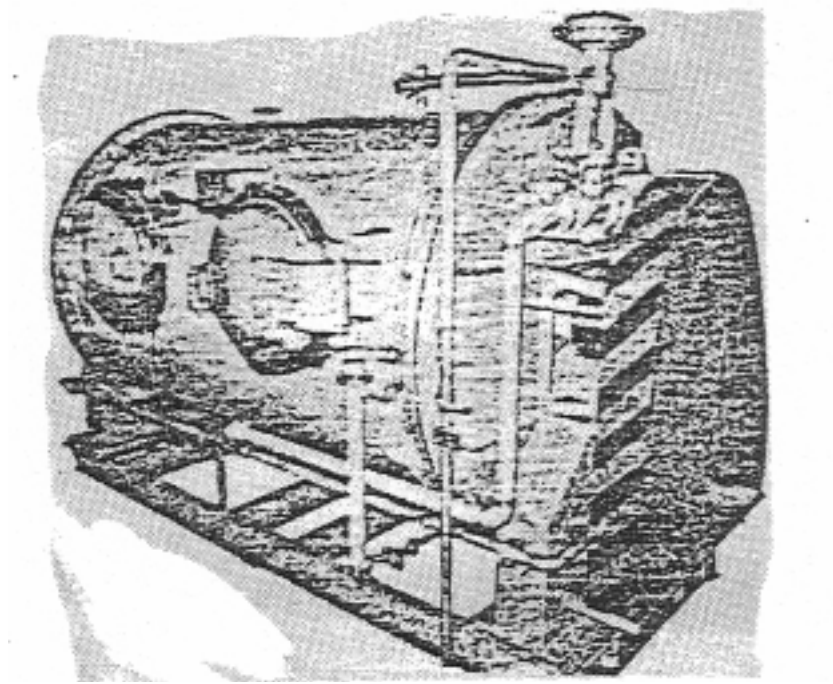
가
.
10~20 가
가 Rotary Washer
.

Washer 40~50
Rotary Washer

.

Reelless rapid

Rotary Washer



< 11> R/W

Reelless rapid

< 12>

, Rope

, 30D/30D,

50D/50D

Georgette

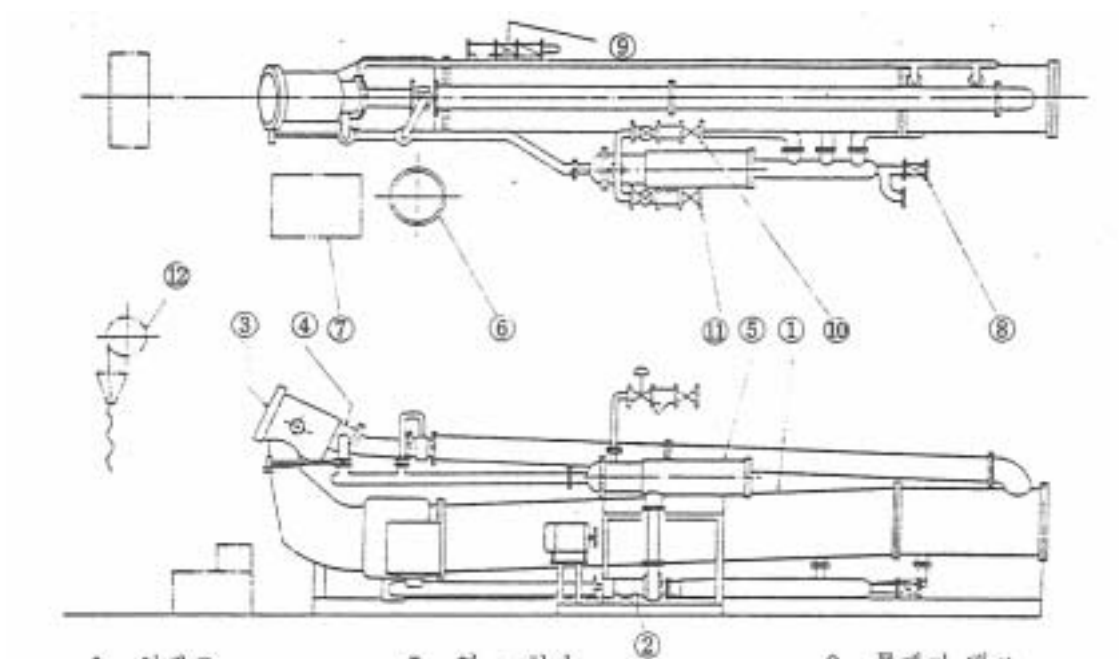
가 Torque가

(elephant crepe)

가

Torque가

Rope



, 가

Reel

< 12> Reelless Rapid