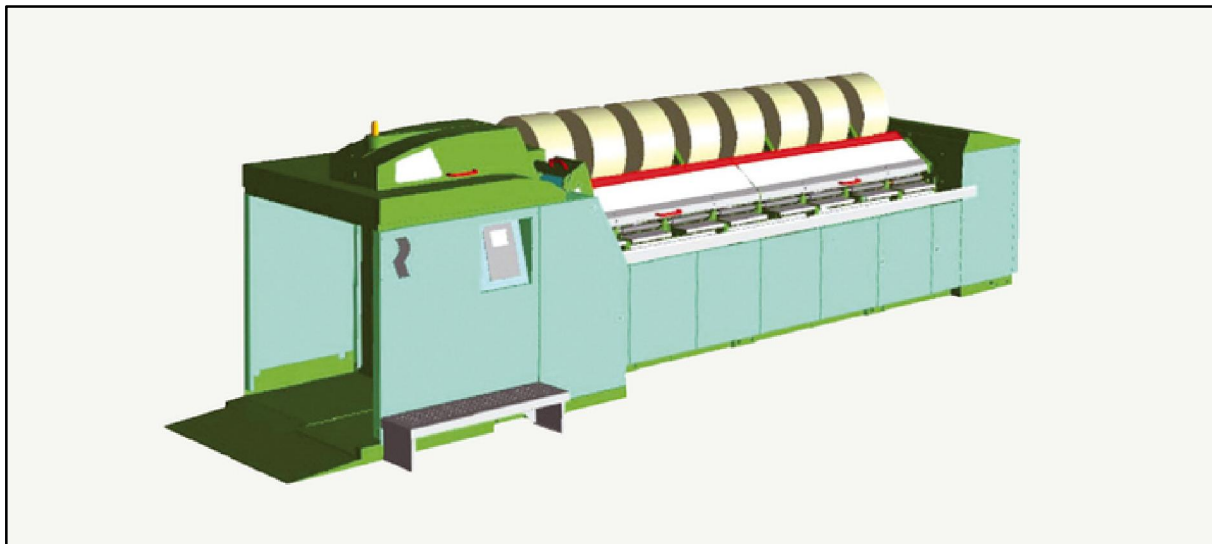
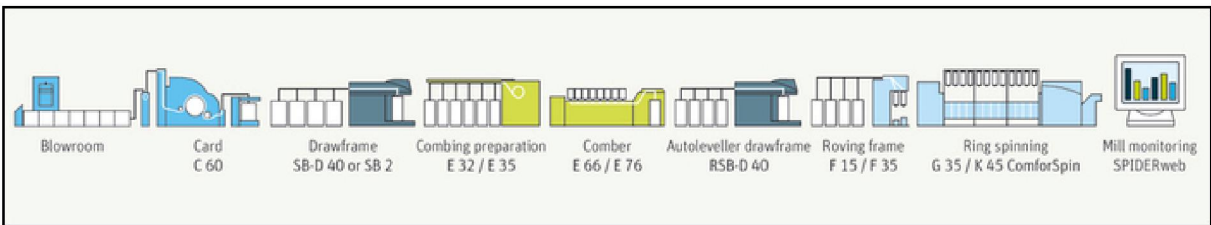
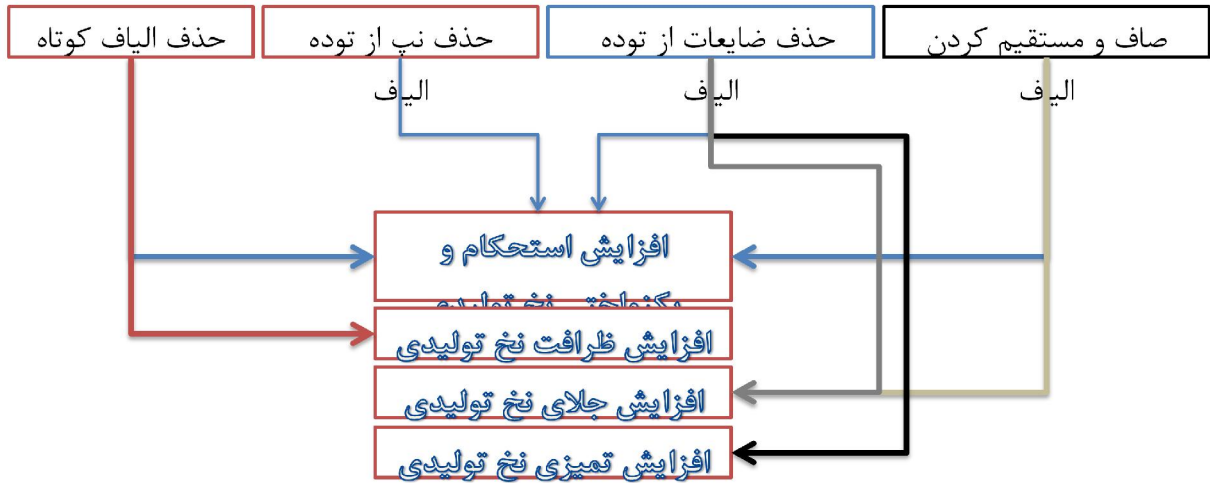
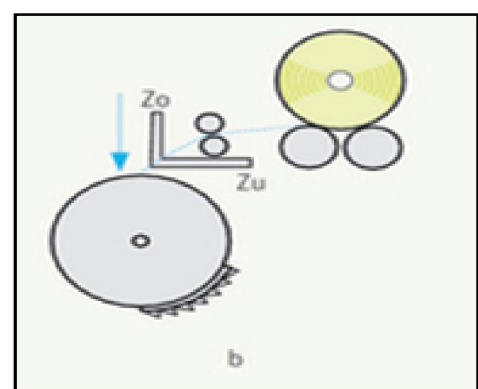
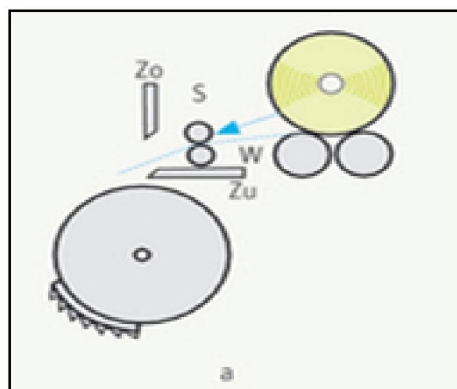
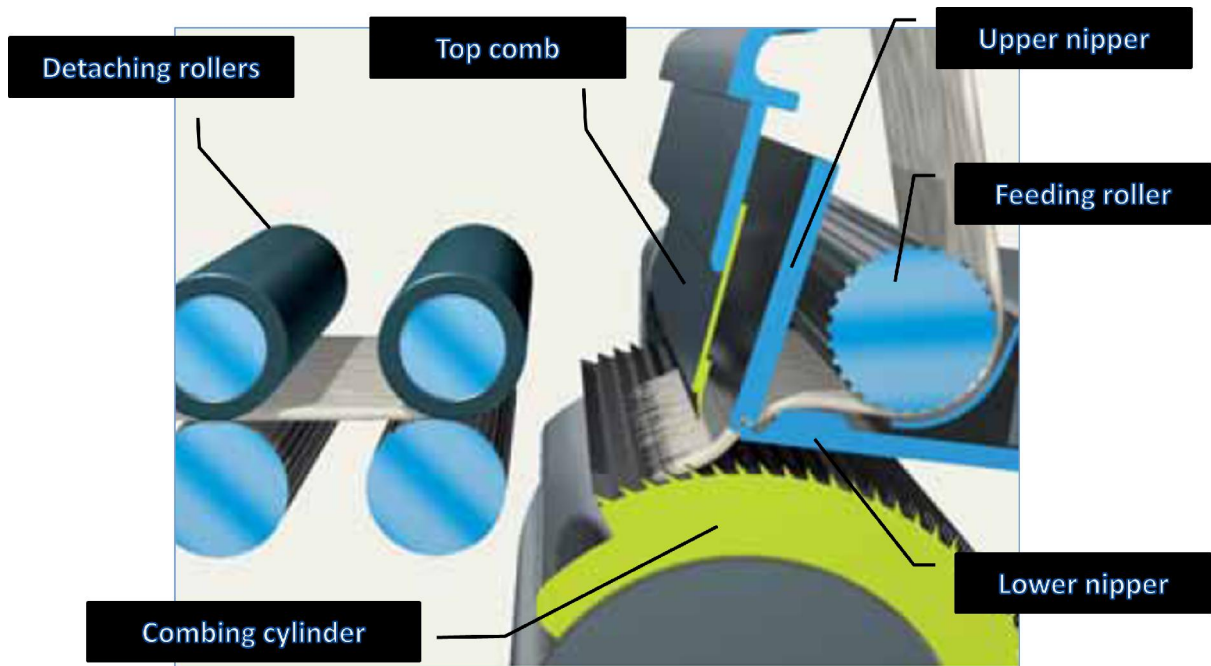
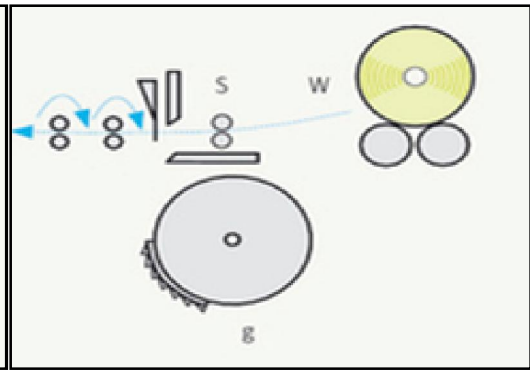
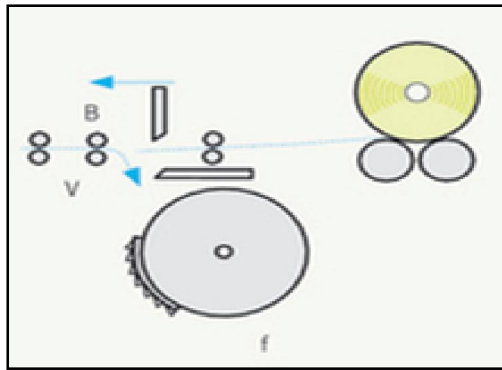
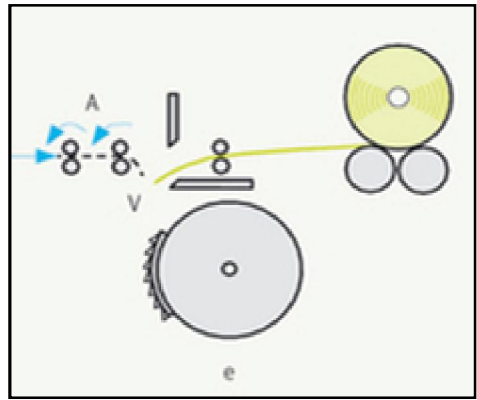
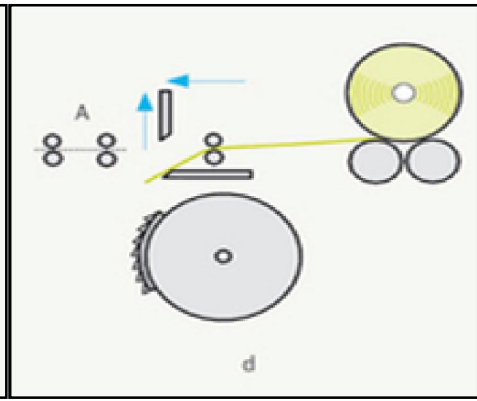
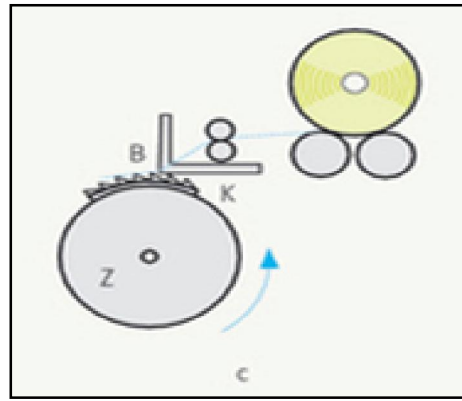
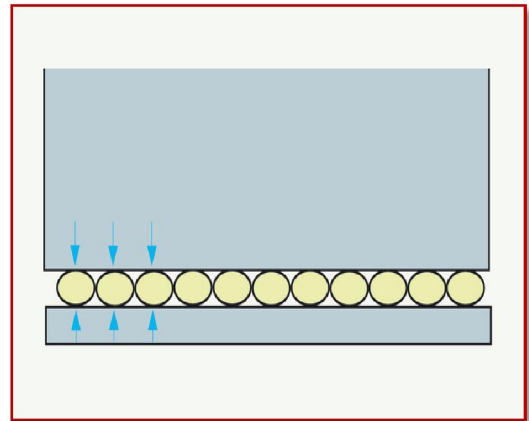
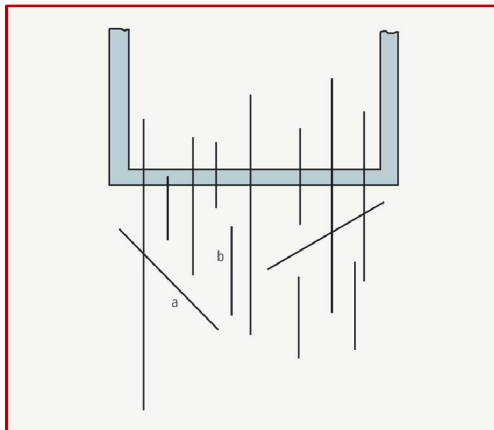
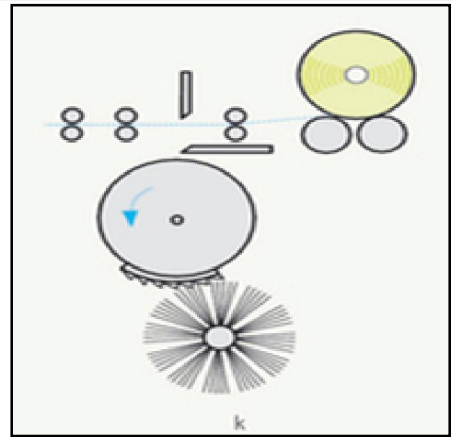
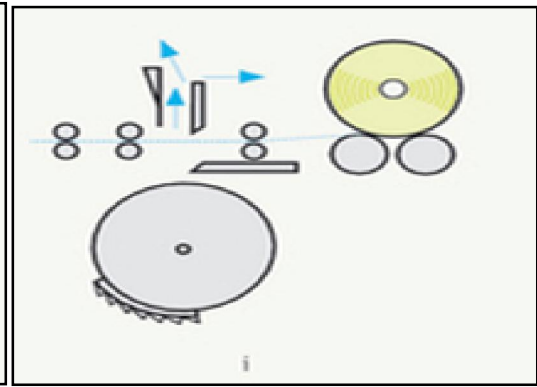
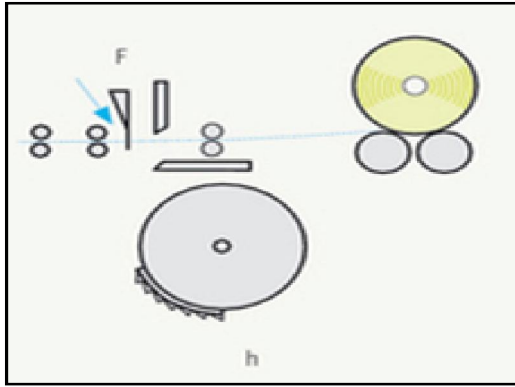


اهداف اصلی مرحله شانه زنی









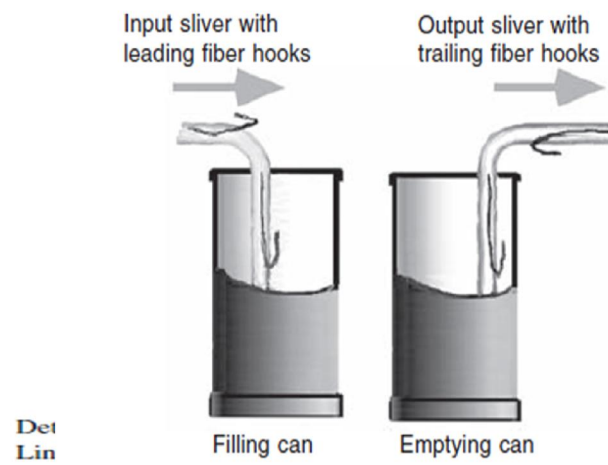
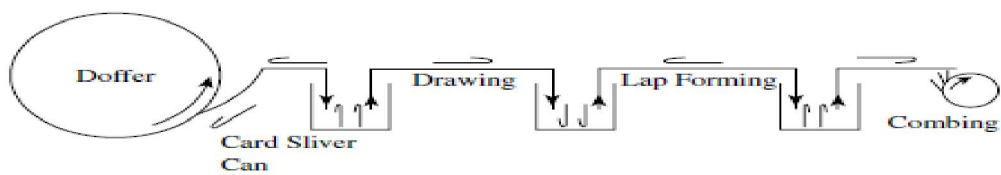
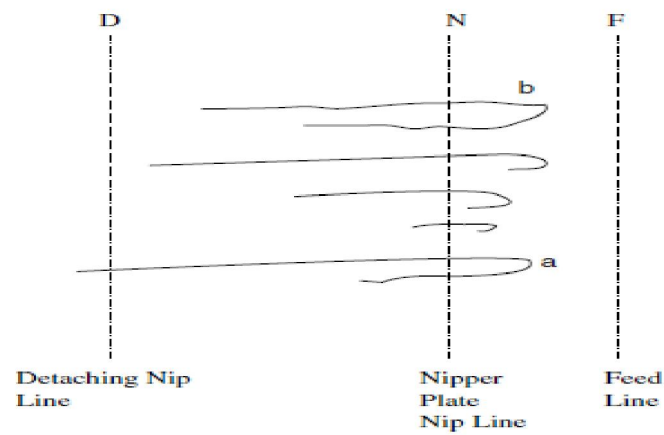
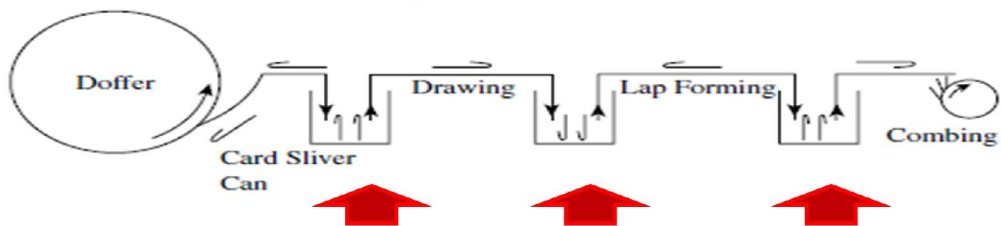
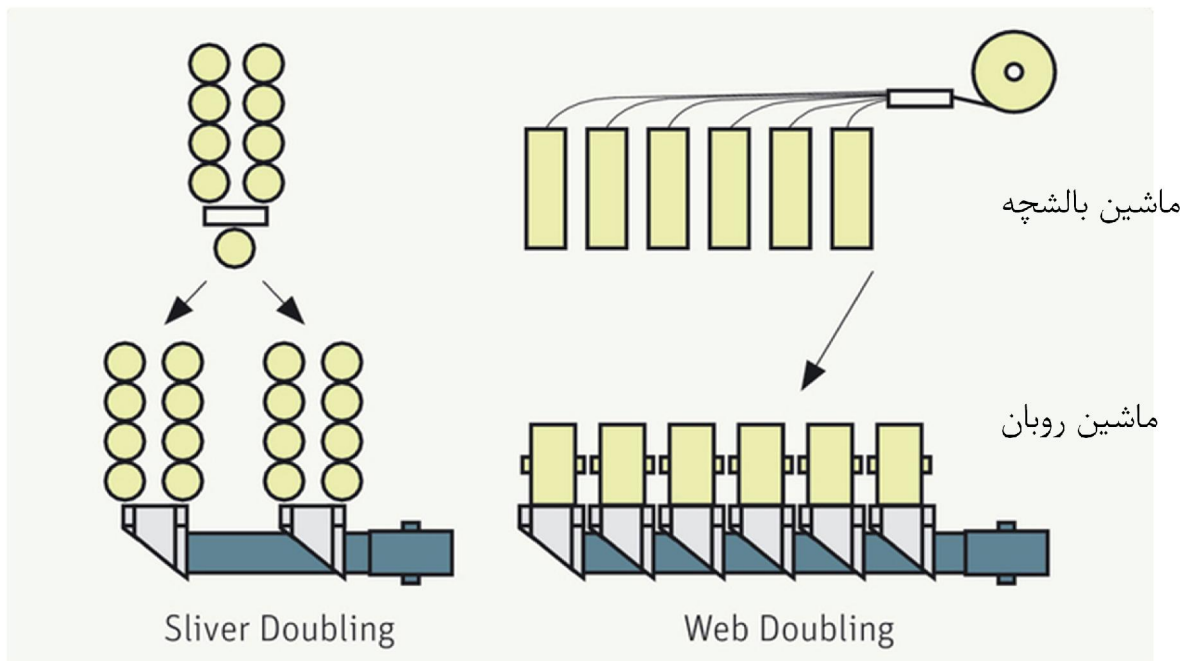
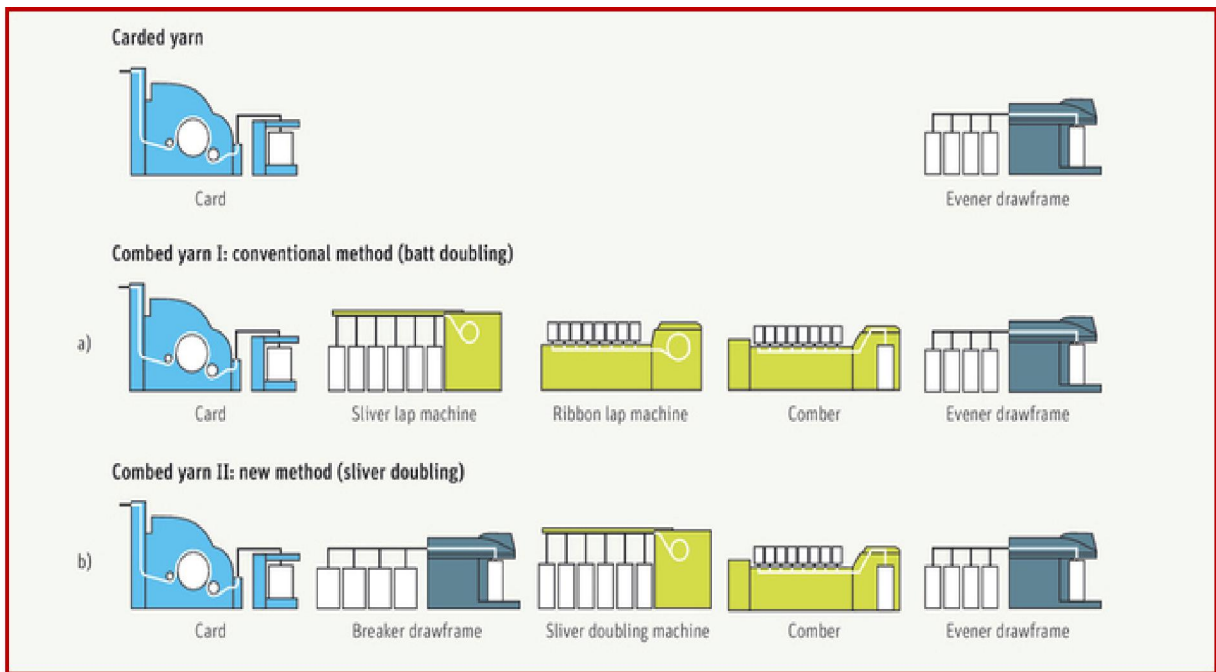


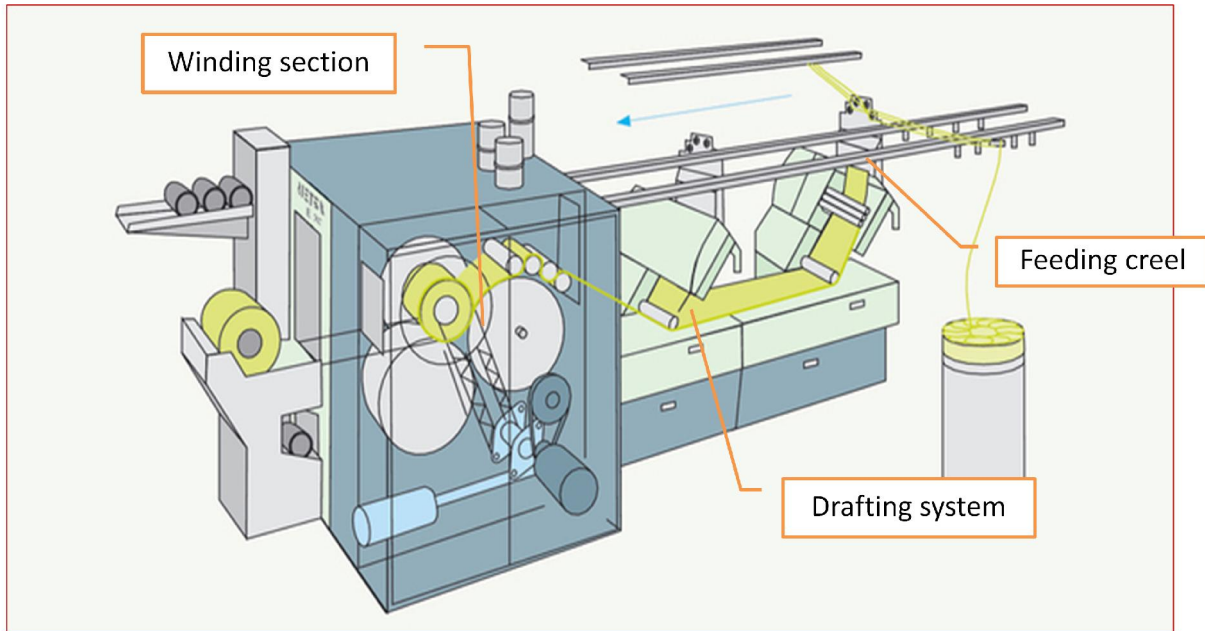
Fig. 6.3 Fiber hook reversal

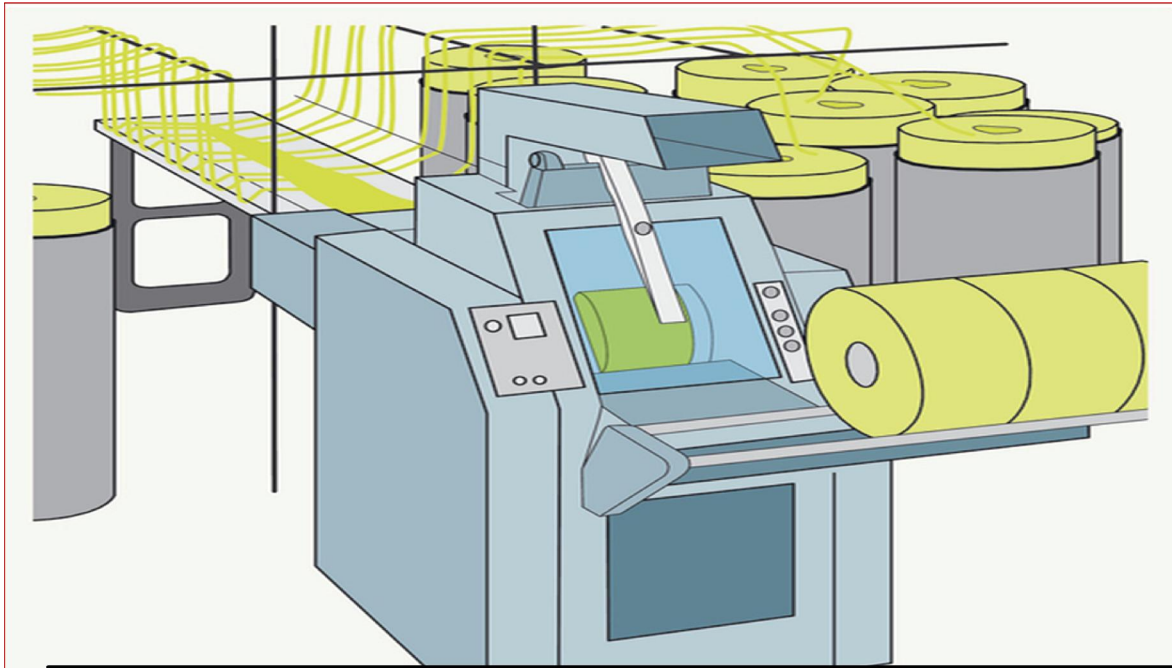




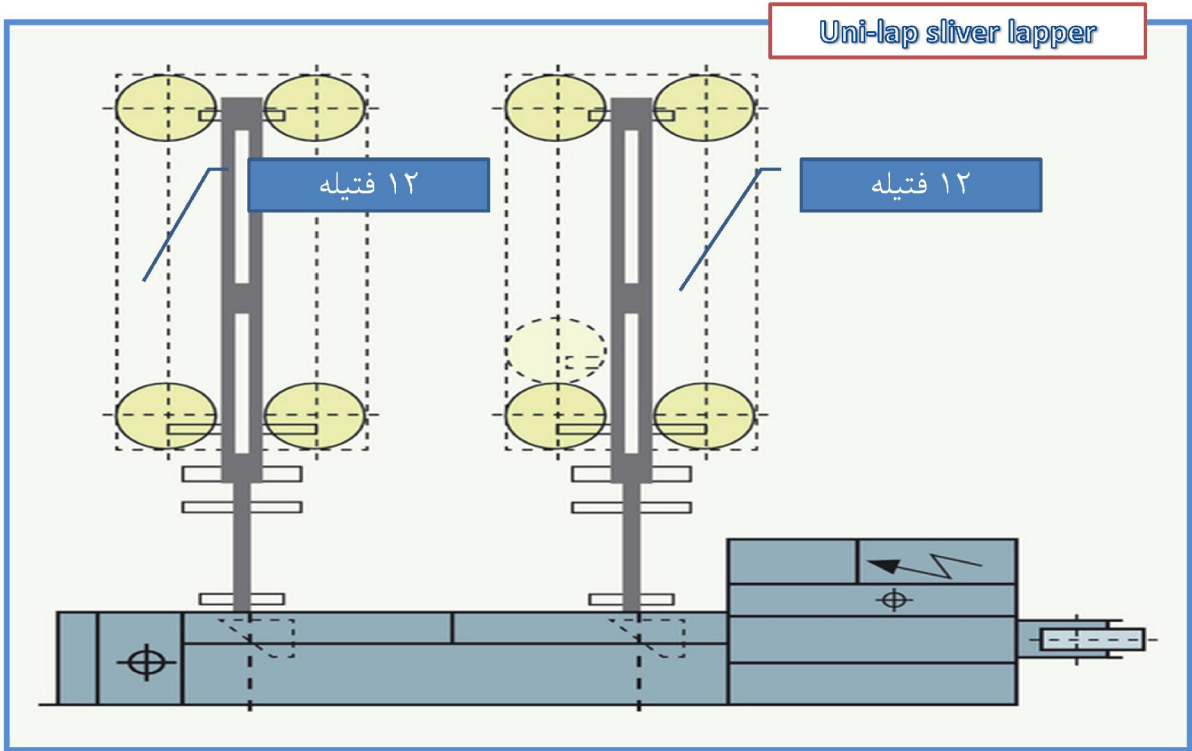
فرایند مقدمات شانه زنی مدرن

فرایند مقدمات شانه زنی قدیمی

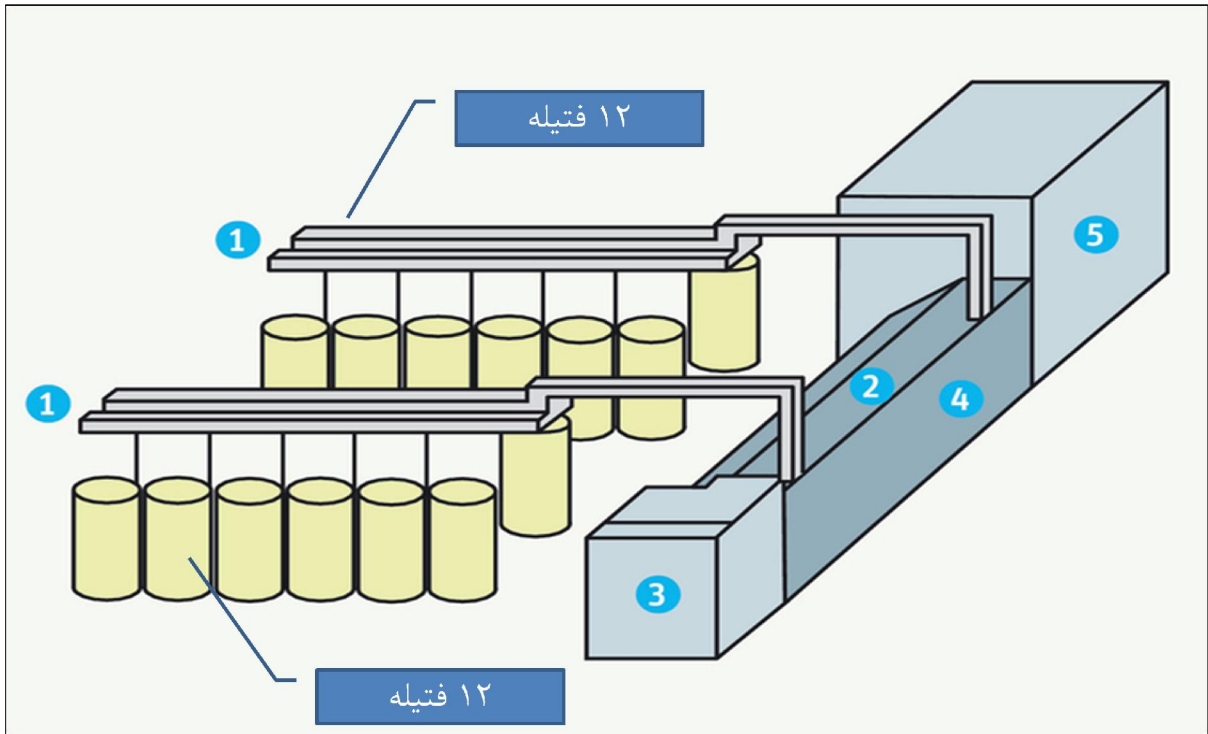


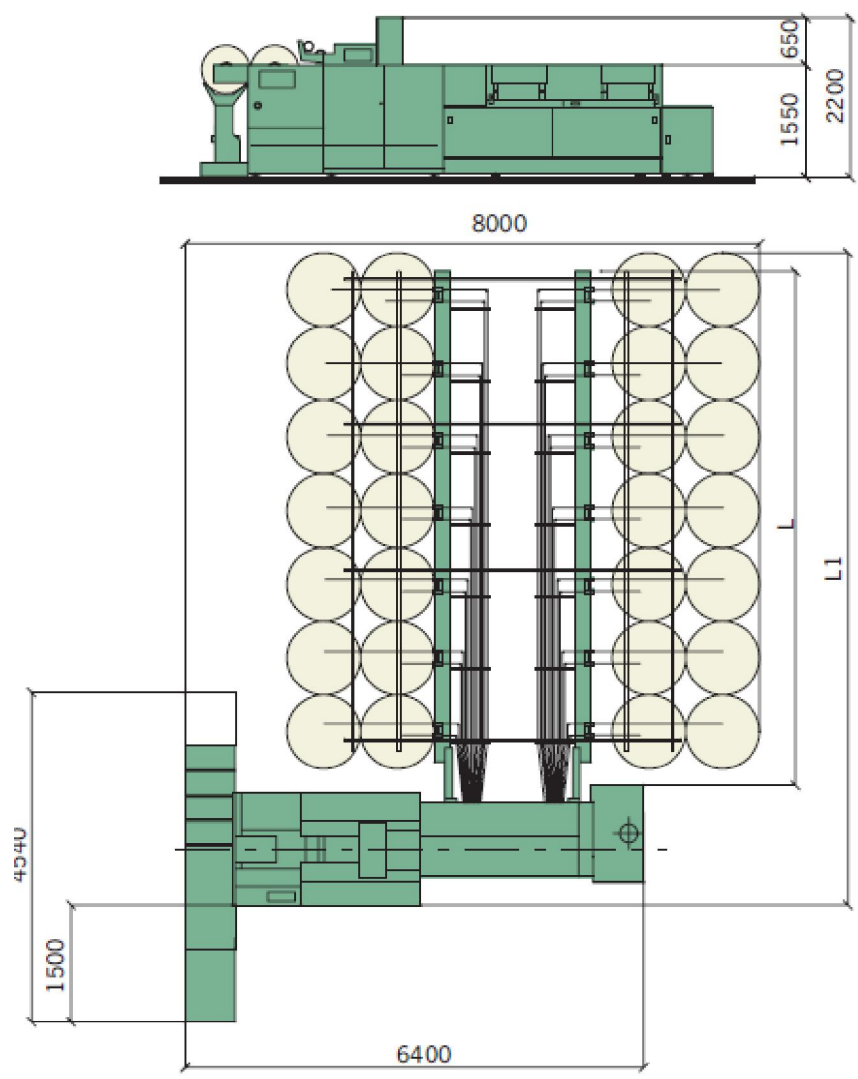


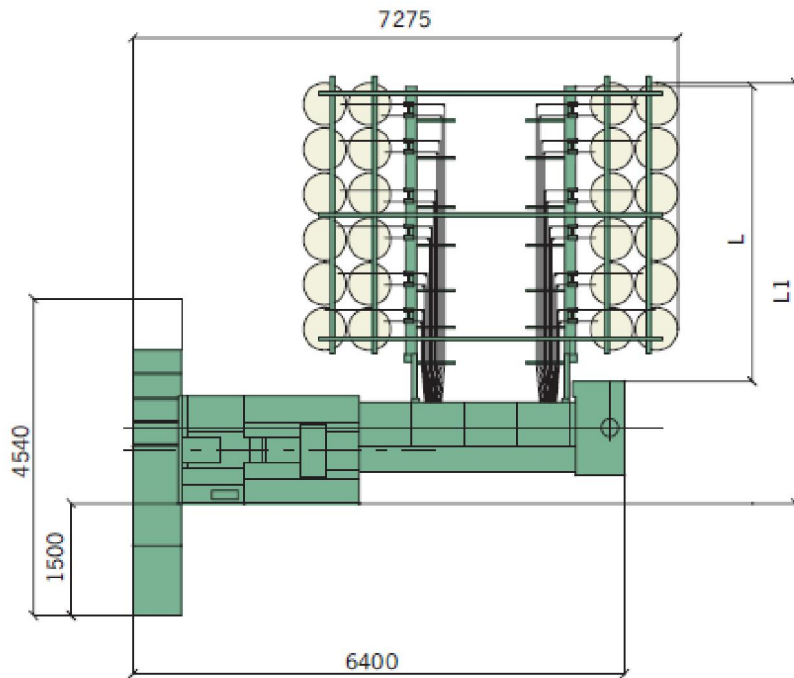
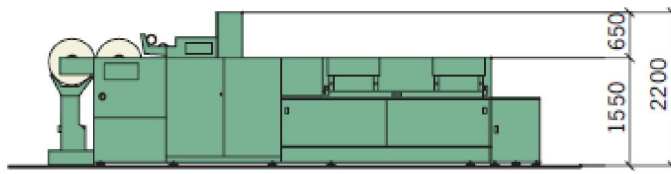
بسته به طراحی قفسه بین ۲۰ الی ۳۶ فتیله ماشین کاردینگ به ماشین بالشجه تغذیه می شود.







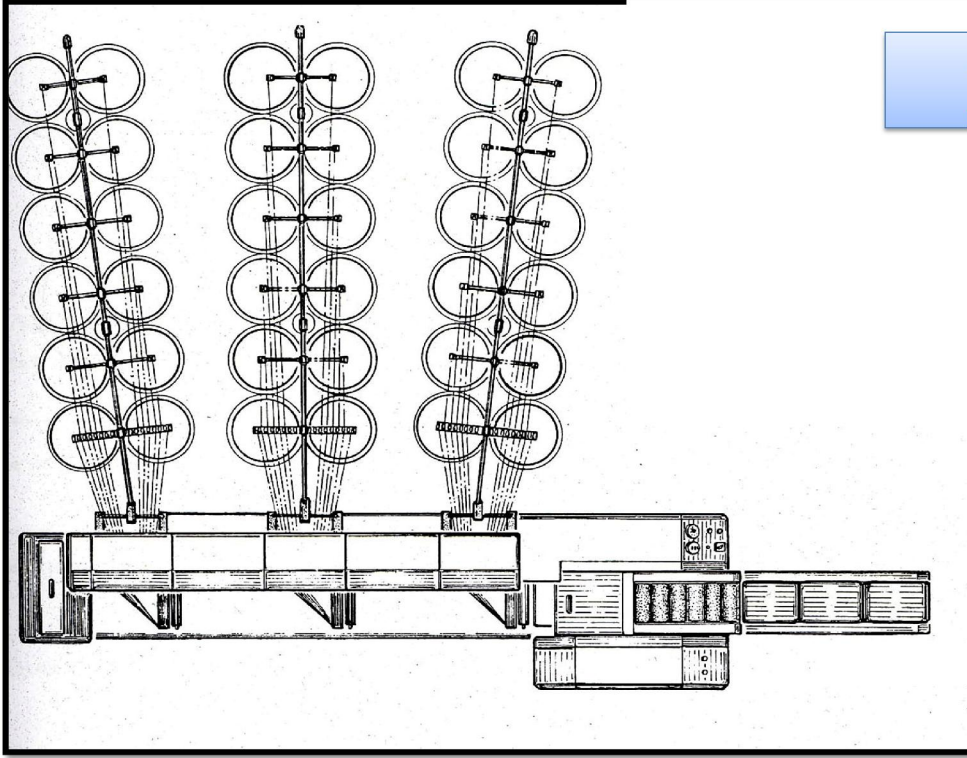




Doublings	Cans dia.
24	24"
32	
24	40"
28	

LAP WINDER LW2N

ماشين بالشچه  
مدل SR34



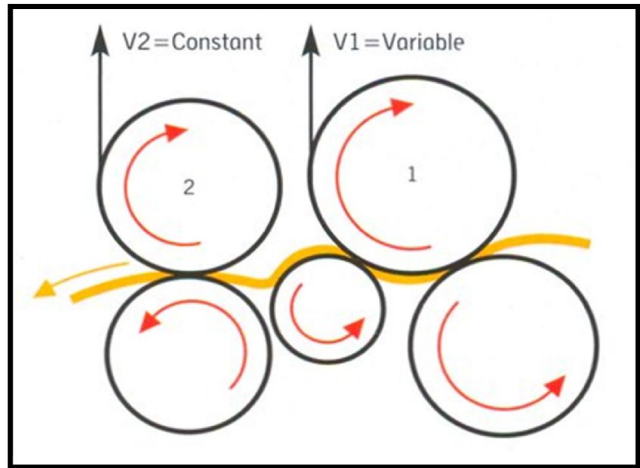


سیستم کششی ماشین یونی-لپ:  
سیستم کششی ۴ بر ۴  
مقدار کل کشش ۱/۳ تا ۳/۰۱ واحد کشش

فشار غلتکها بصورت پنوماتیک تنظیم می گردد.

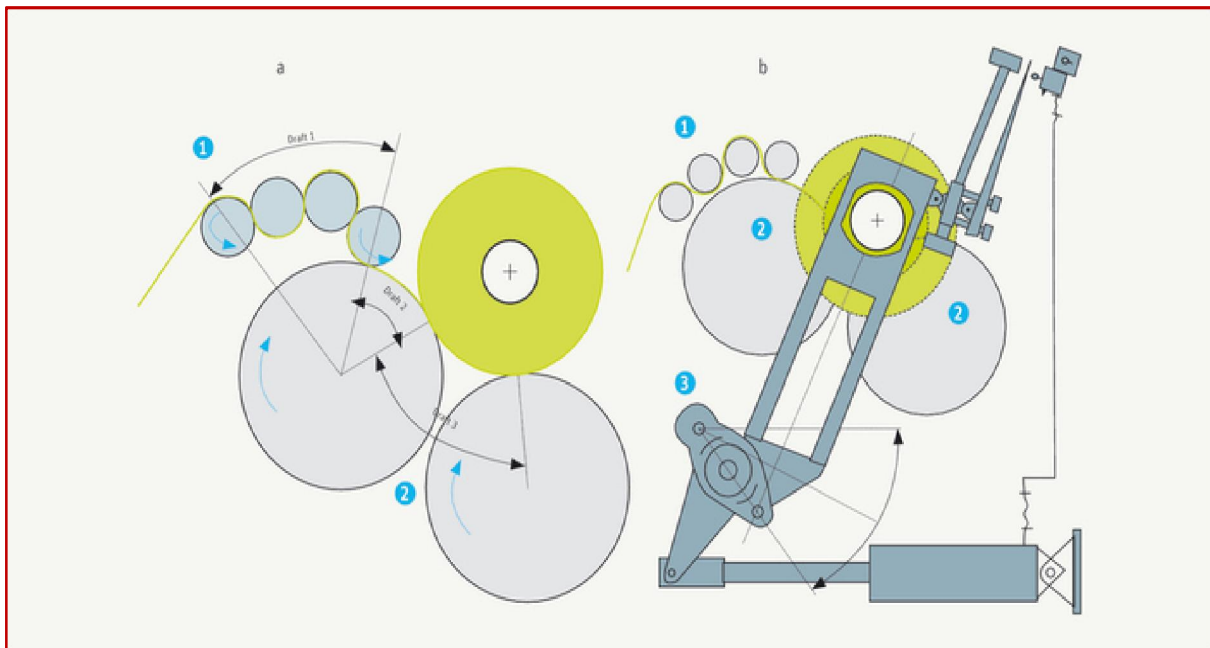
سیستم کششی ماشین بالشچه مارزولی:  
سیستم کششی ۲ بر ۳  
مقدار کل کشش ۱/۴ تا ۲/۳ واحد کشش

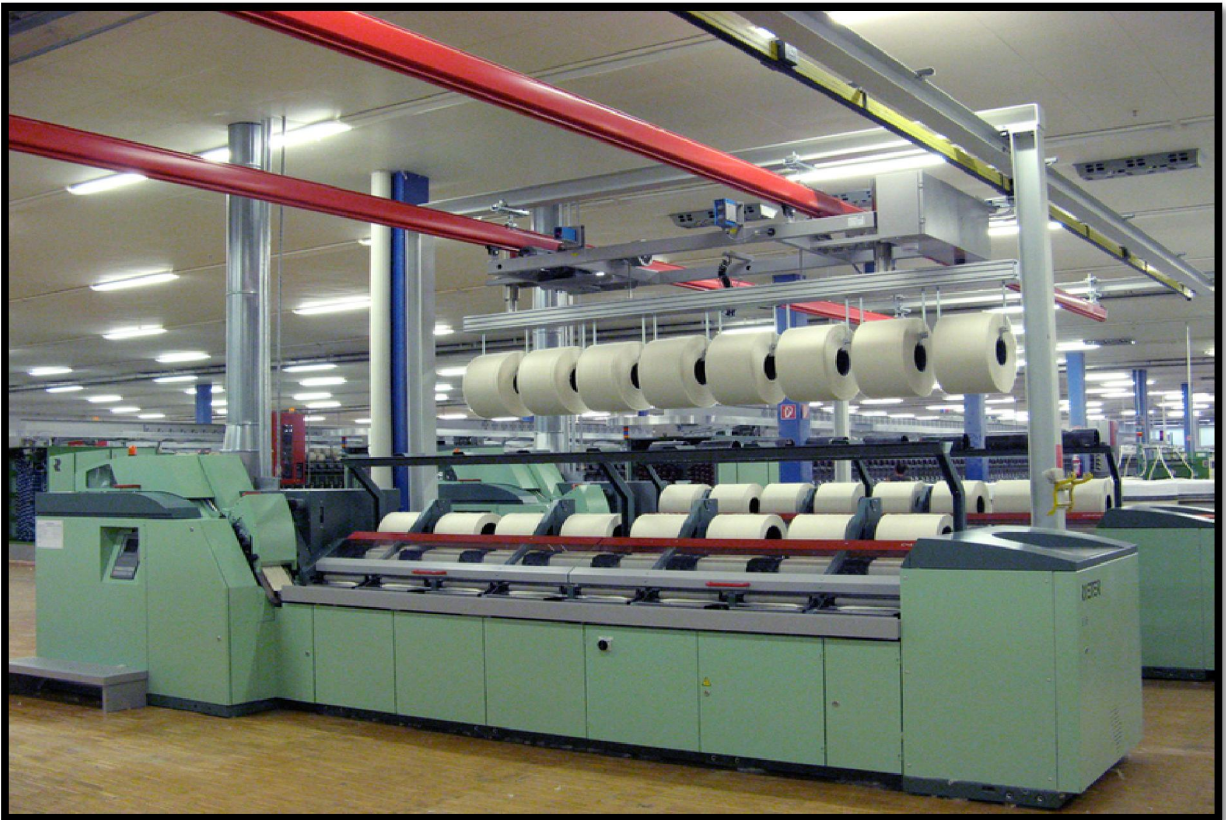
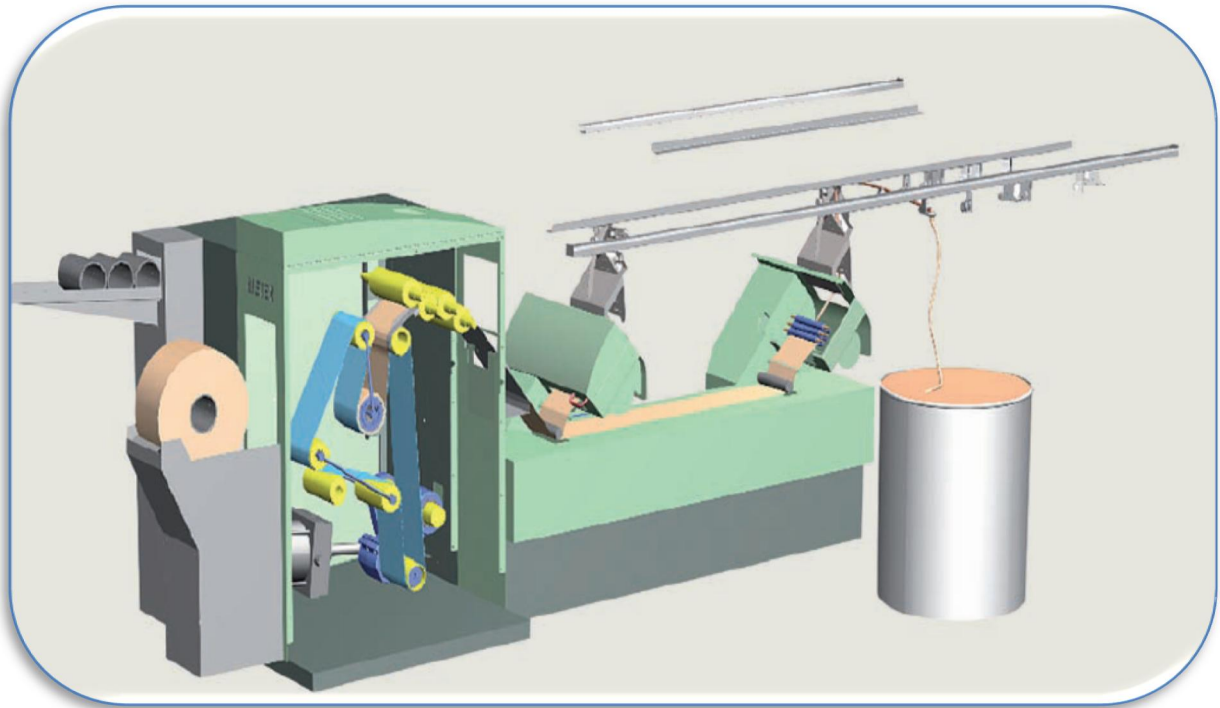
فشار غلتکها بصورت پنوماتیک تنظیم می گردد.

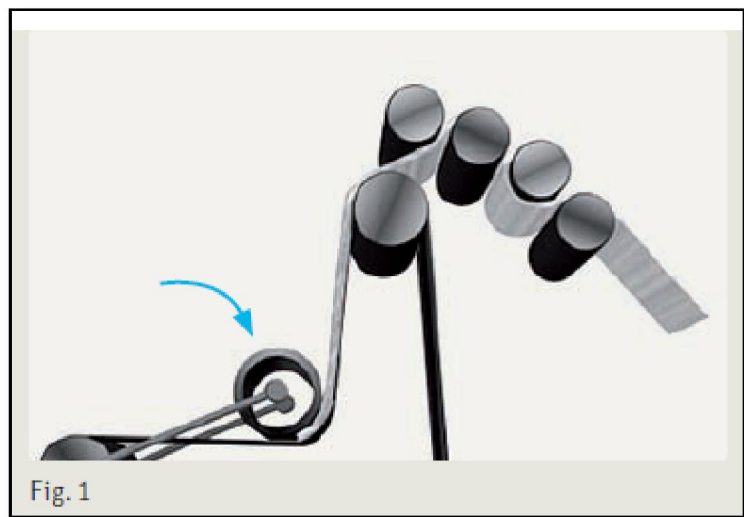
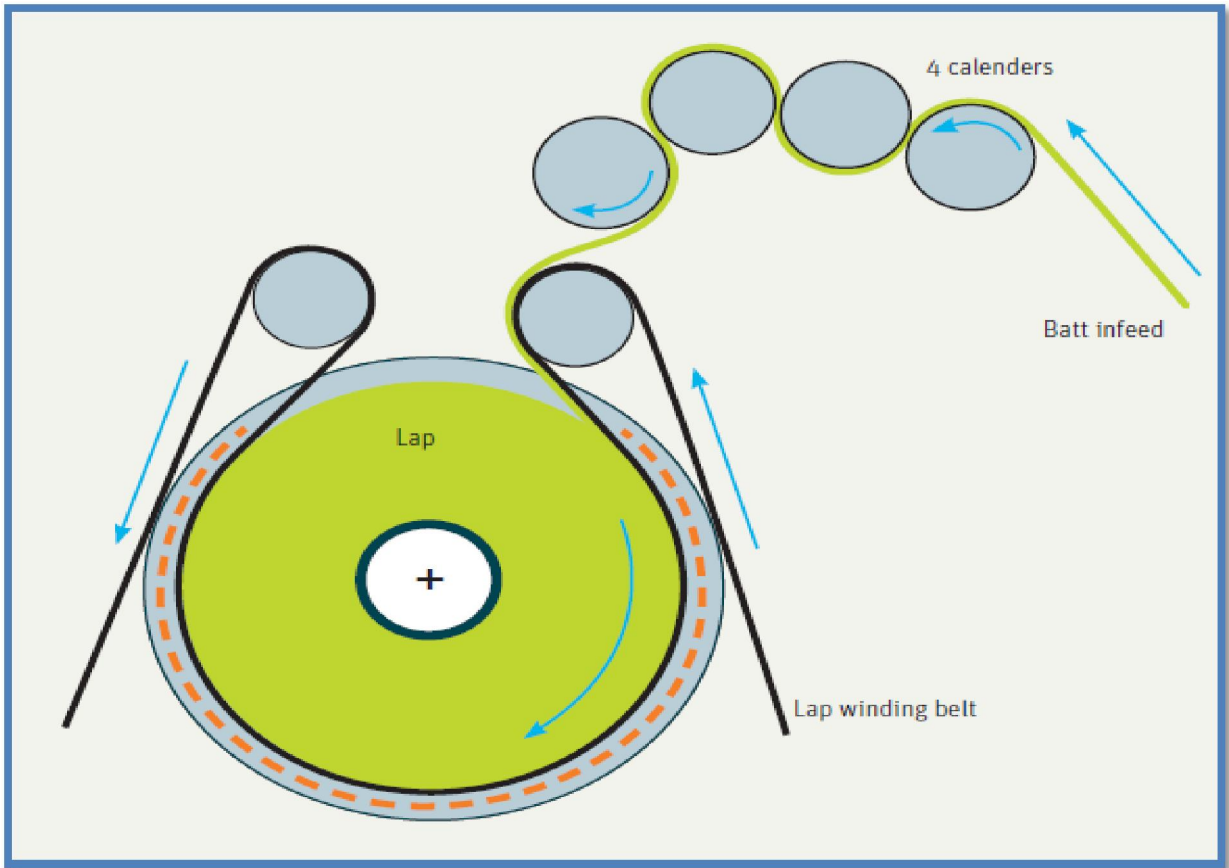


Unilap drafting system

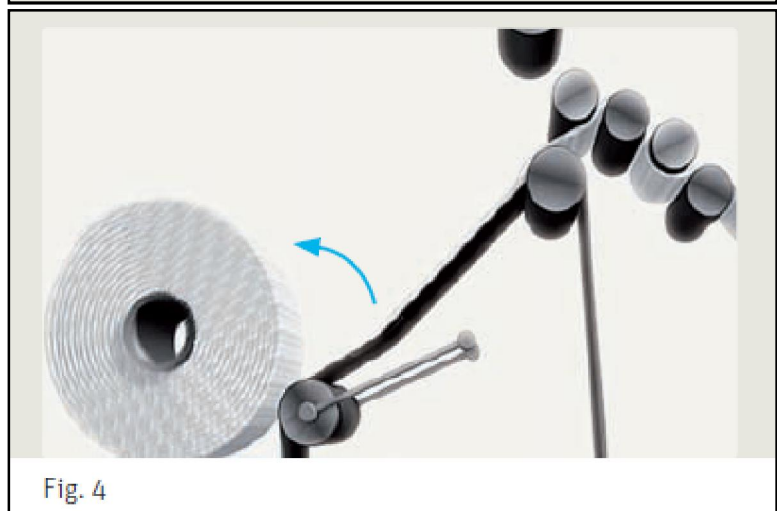
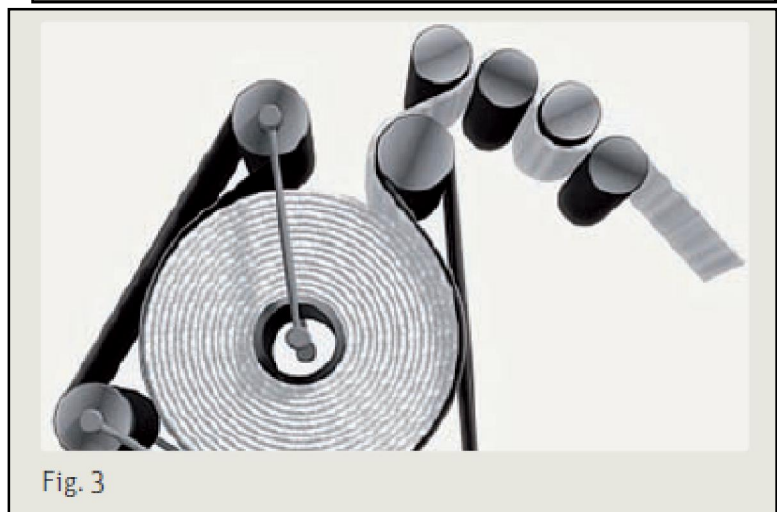
LW2N drafting system

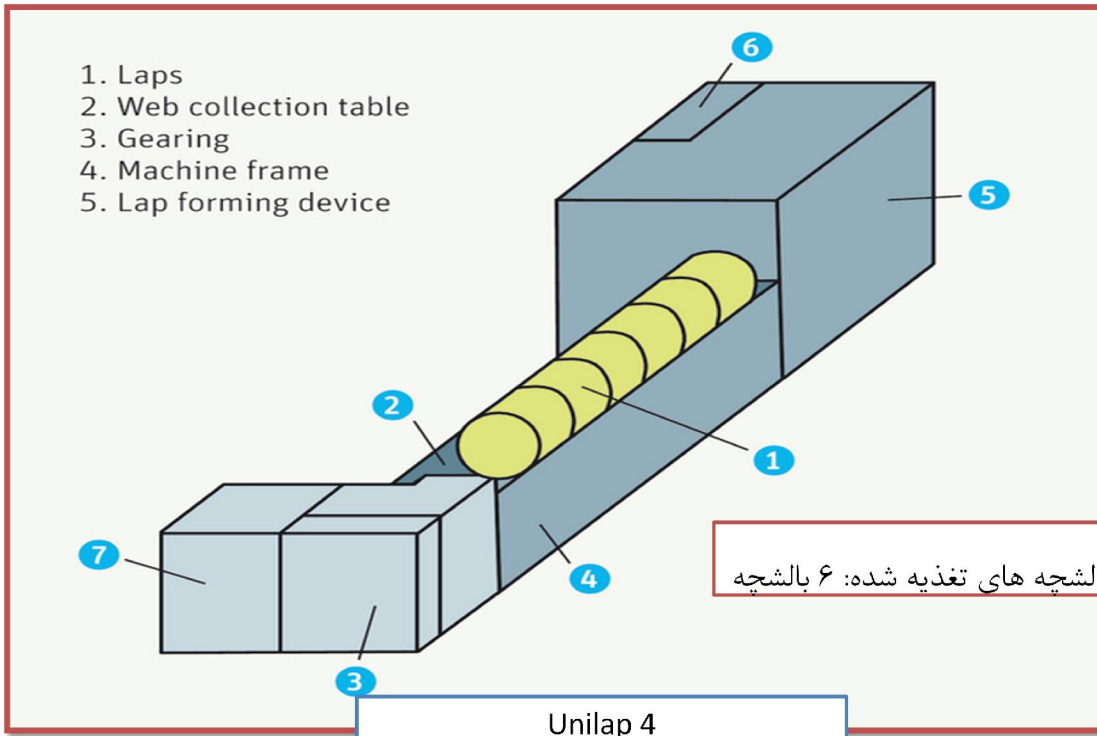


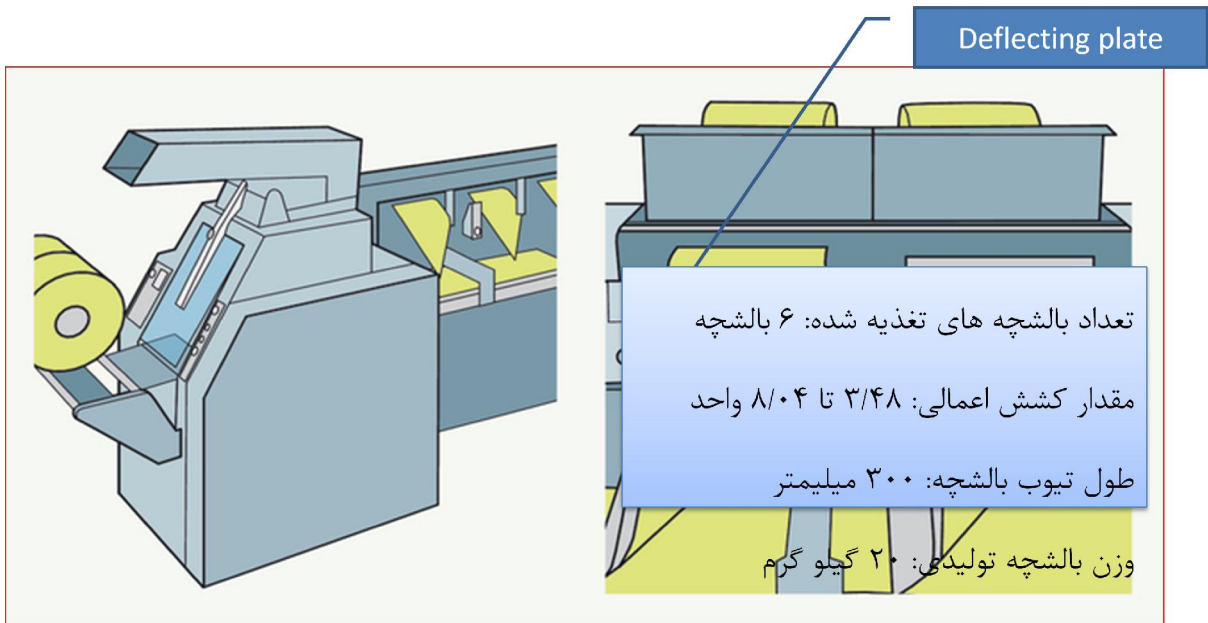
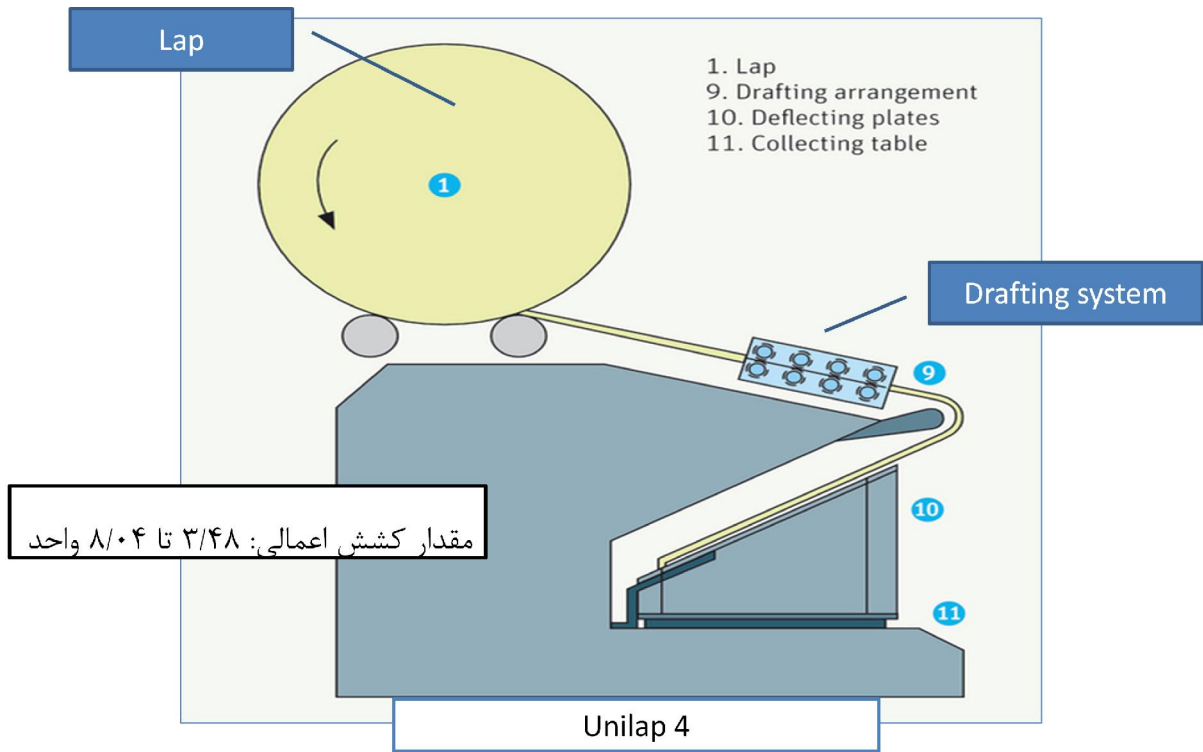




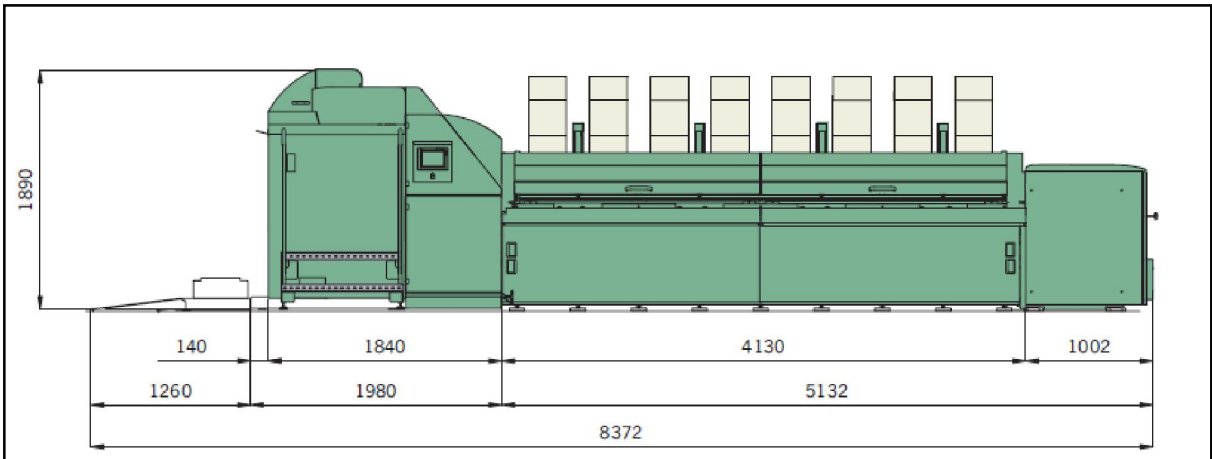
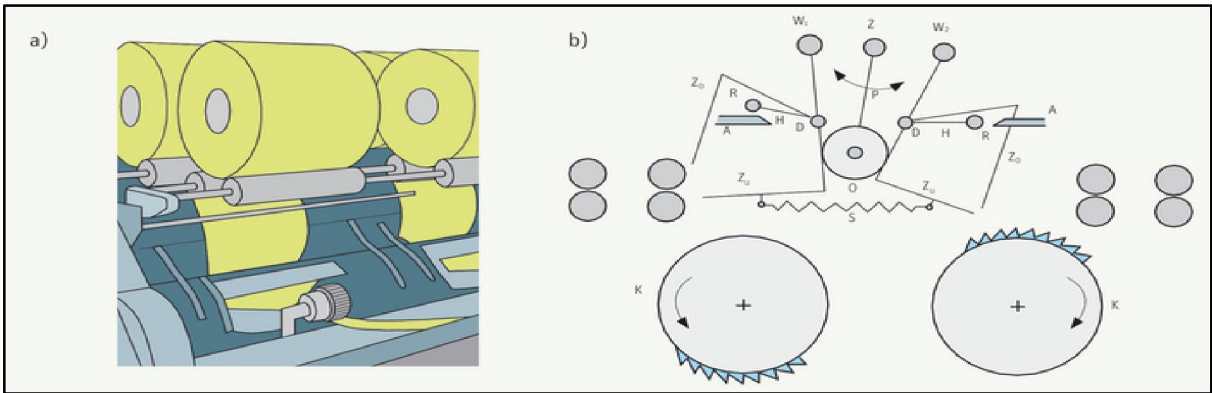
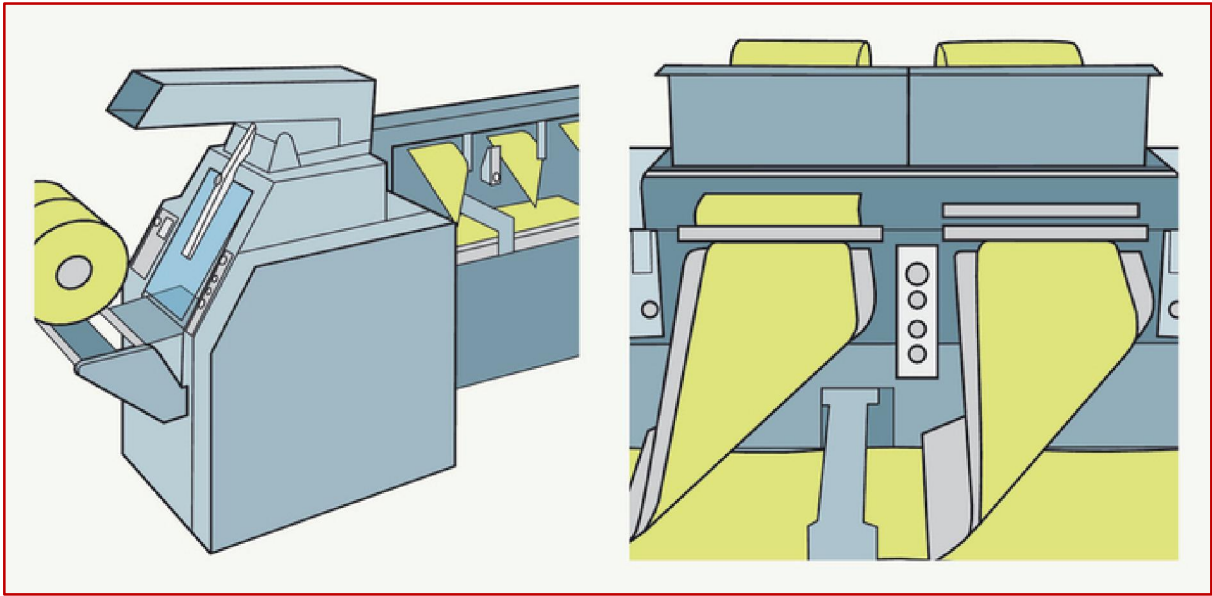


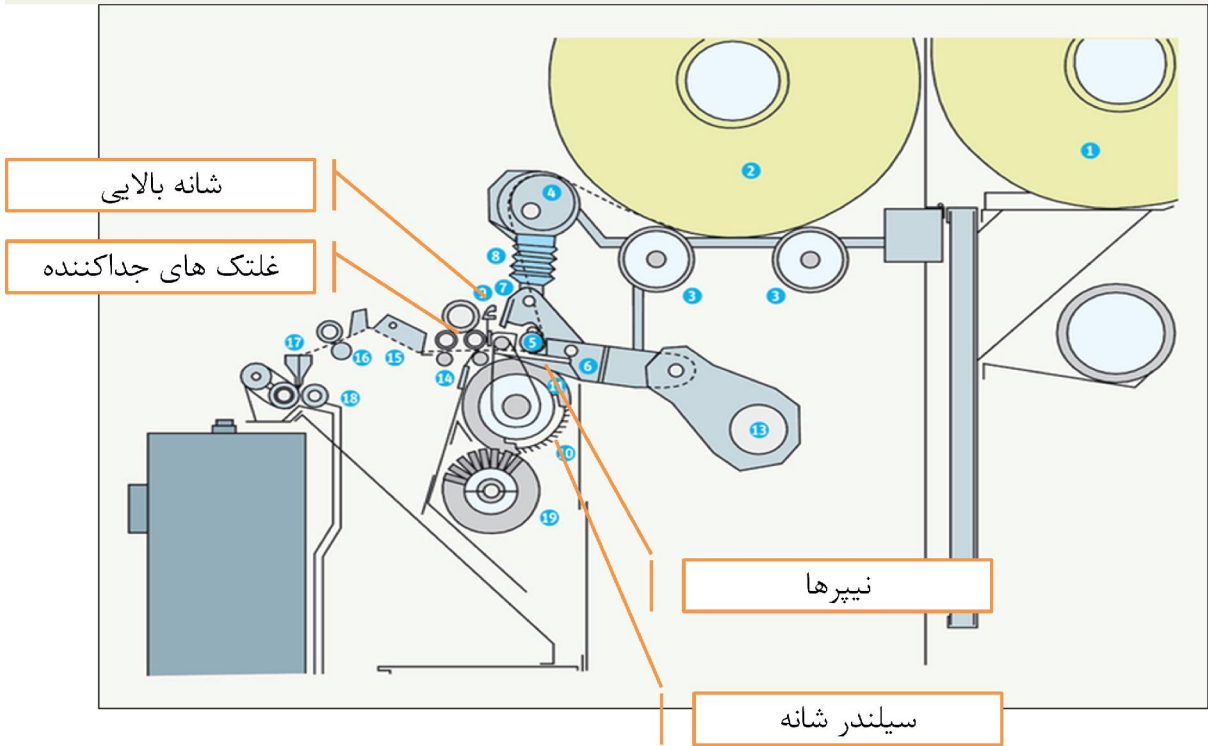
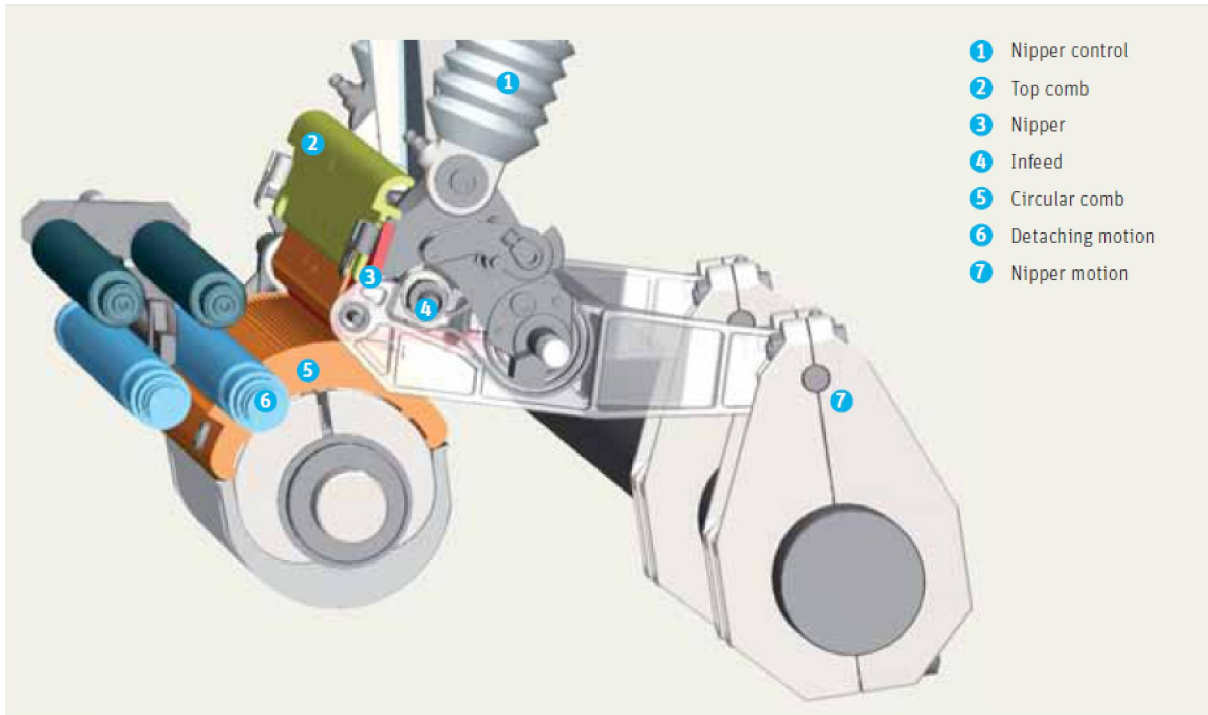


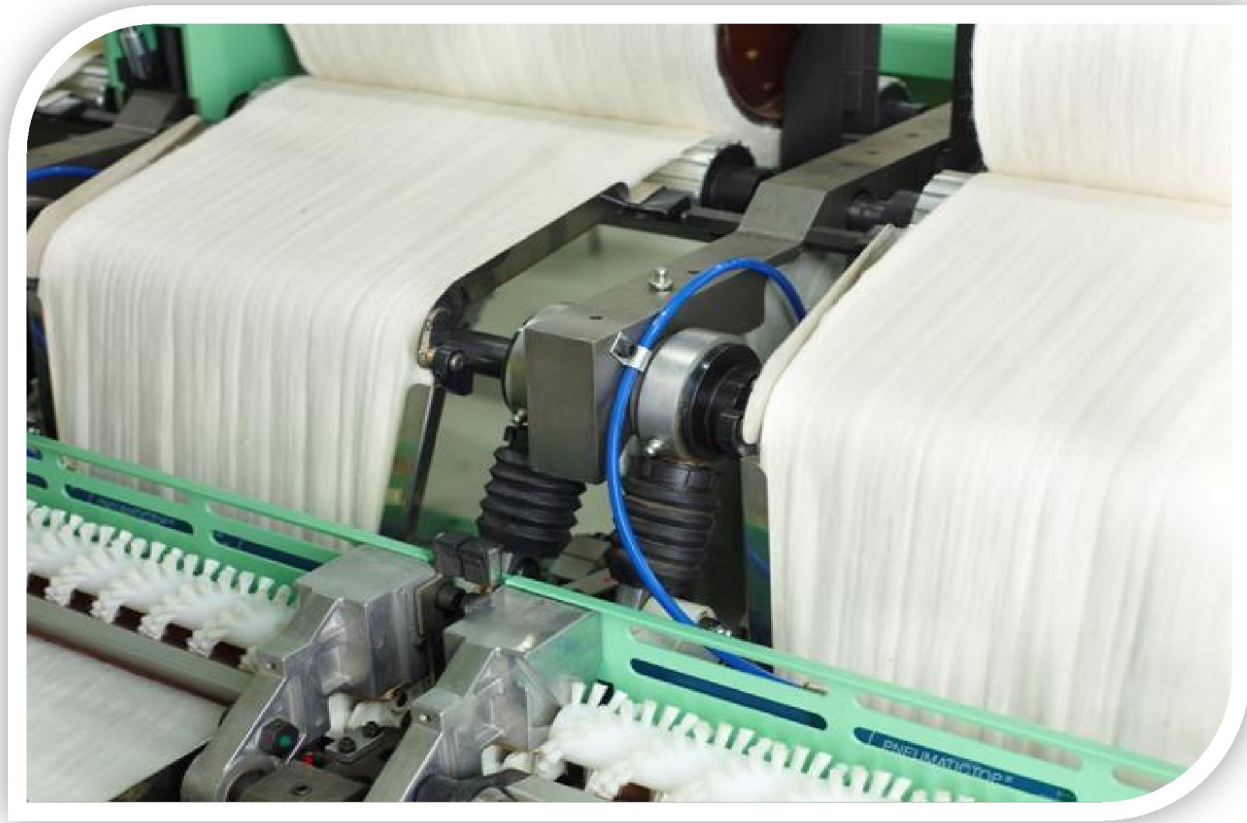
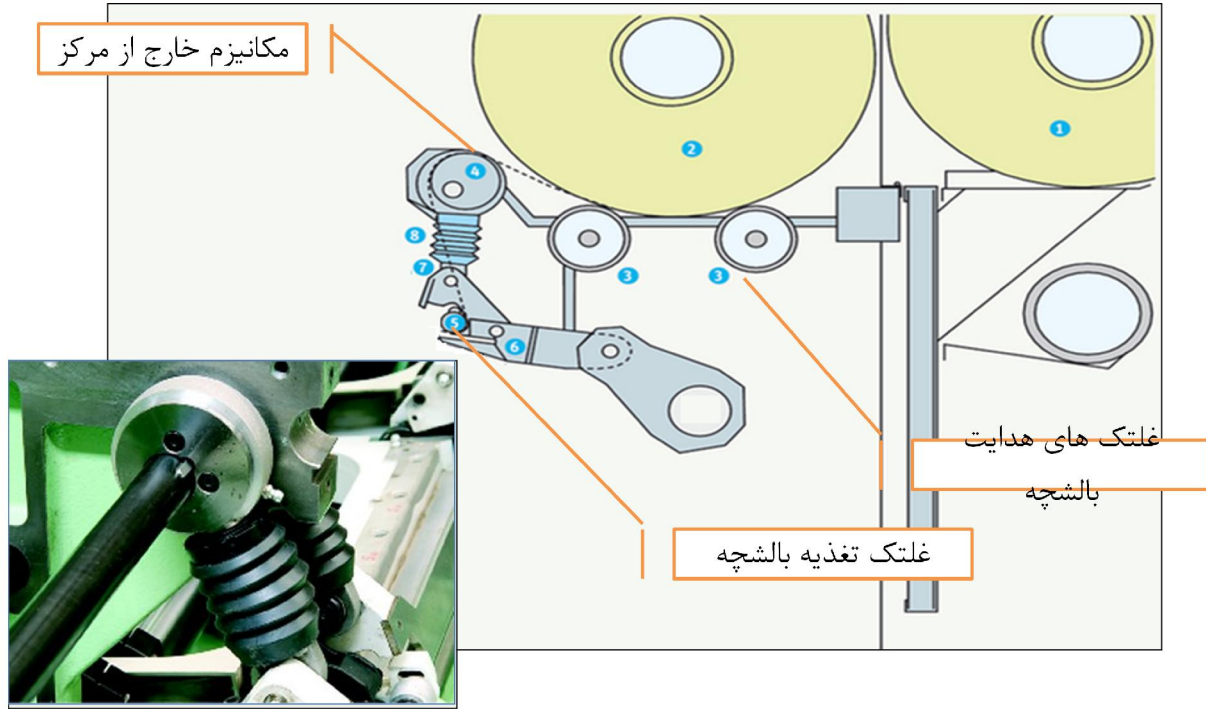


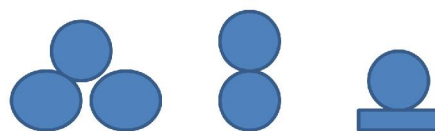
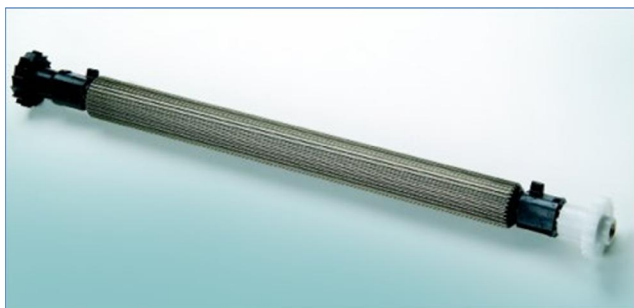


مکانیزم پیچش این ماشین کاملاً شبیه به Unilap2 است. فقط طول تیوب ۳۰۰ میلیمتر است.



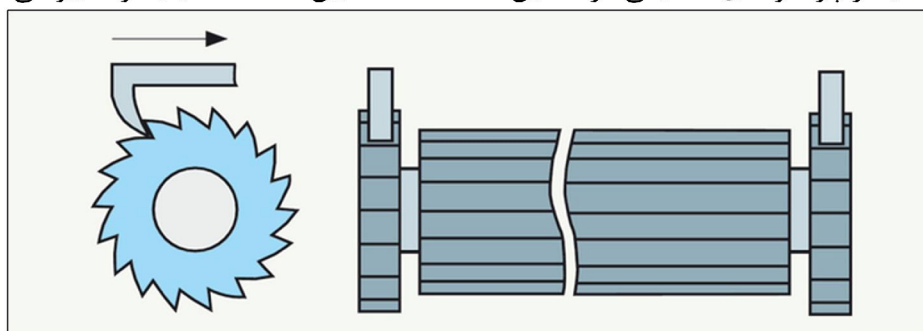






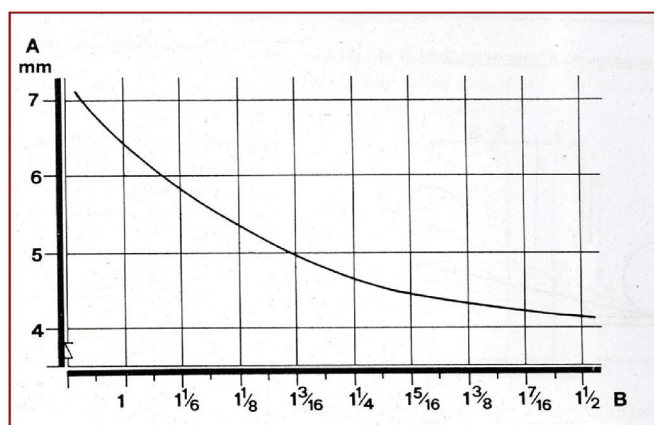
مکانیزم غلتک تغذیه

طول تغذیه از پارامترهای تنظیمی در ماشین شانه است که بین ۴ تا ۶/۷ میلیمتر تغییر می کند.

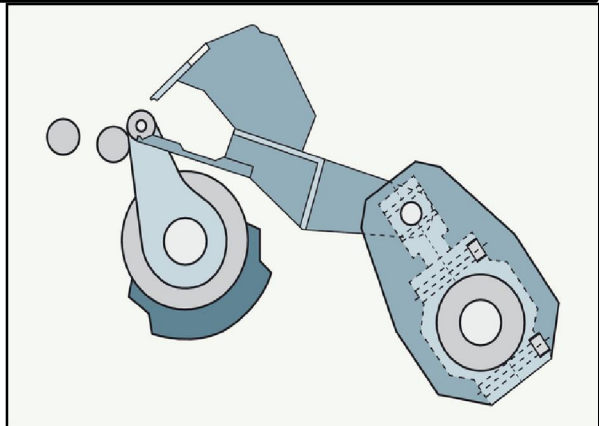
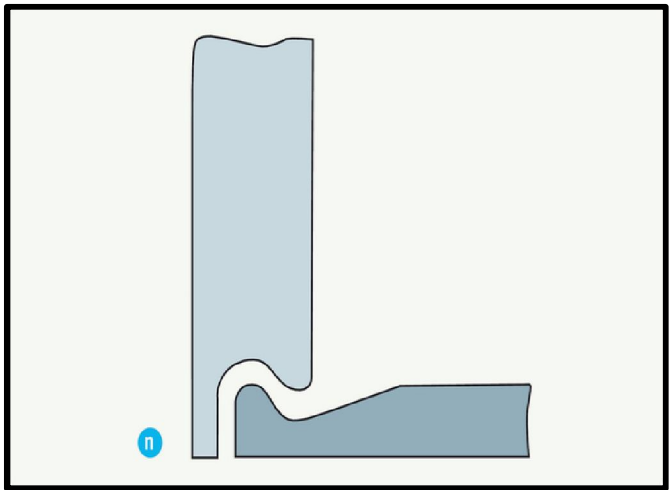
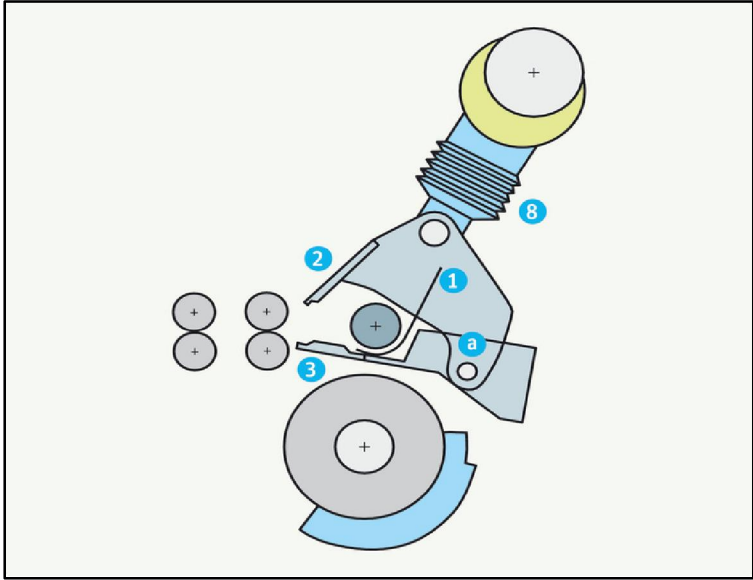


افزایش میزان تغذیه سبب افزایش تولید می شود. اما سبب کاهش کیفیت محصول نیز می شود.

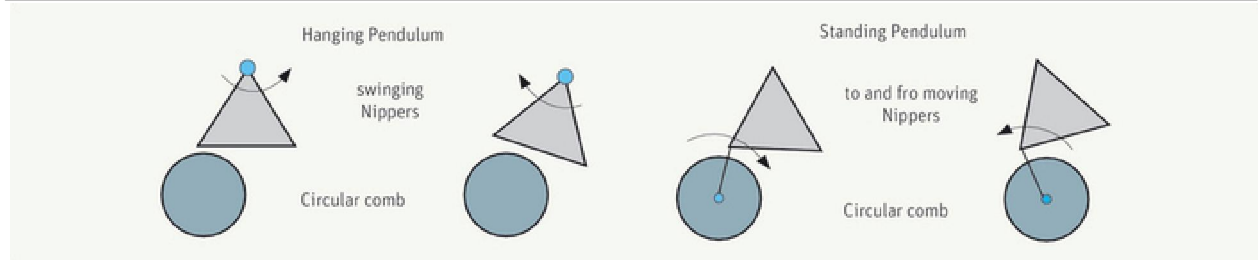
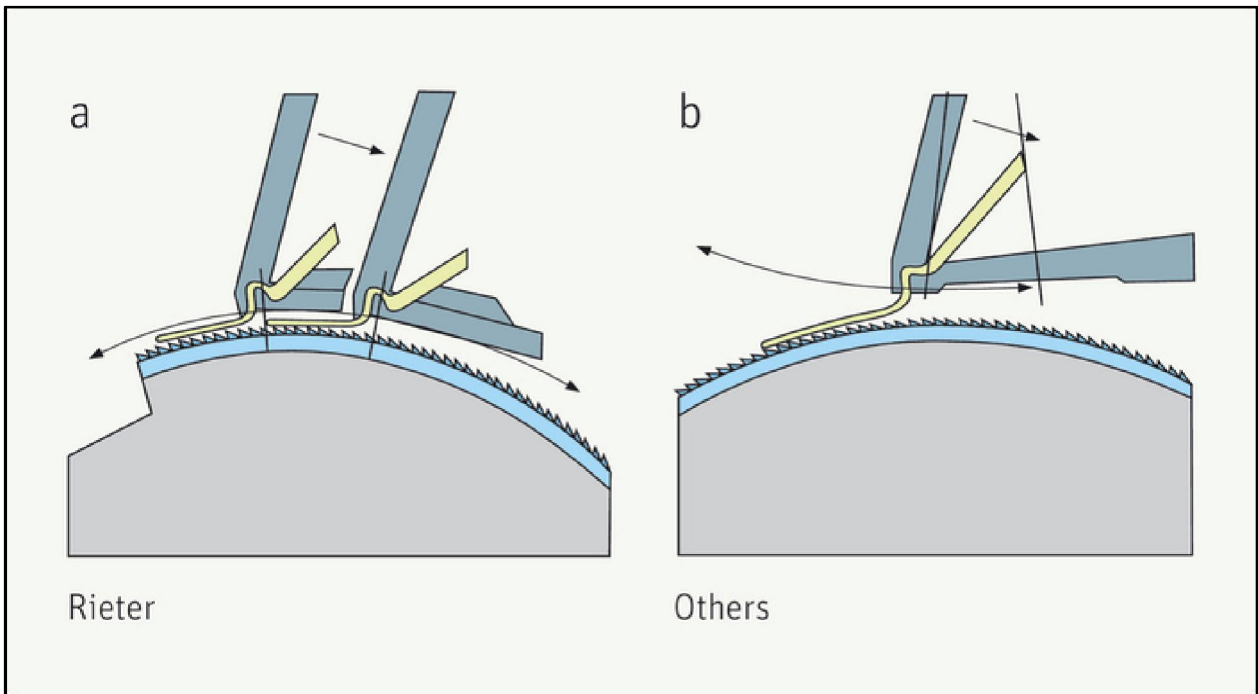
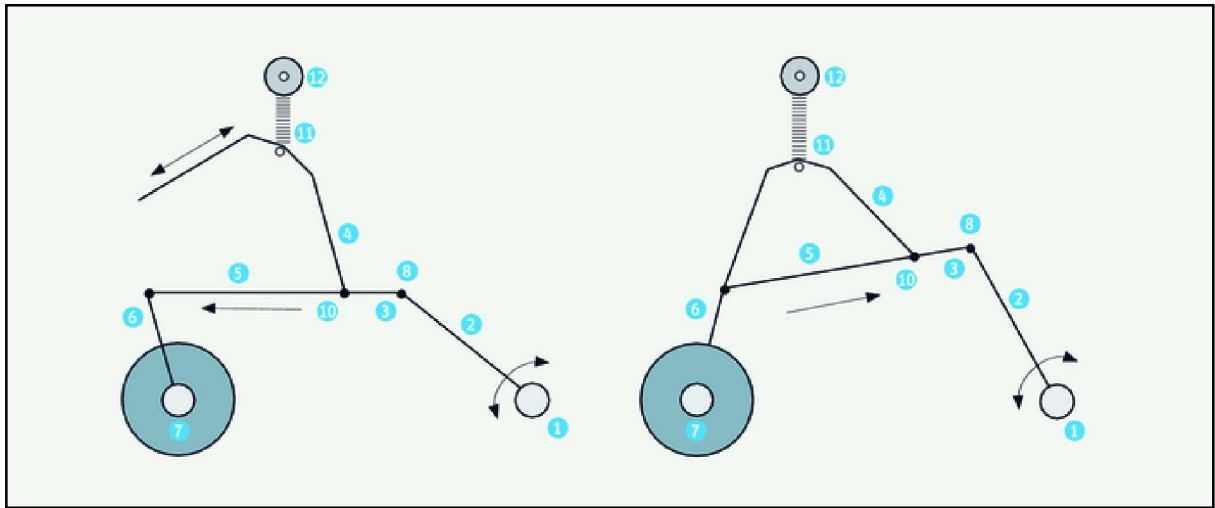
برای دسترسی به کیفیت باید میزان تغذیه در هر سیکل کاهش یابد.

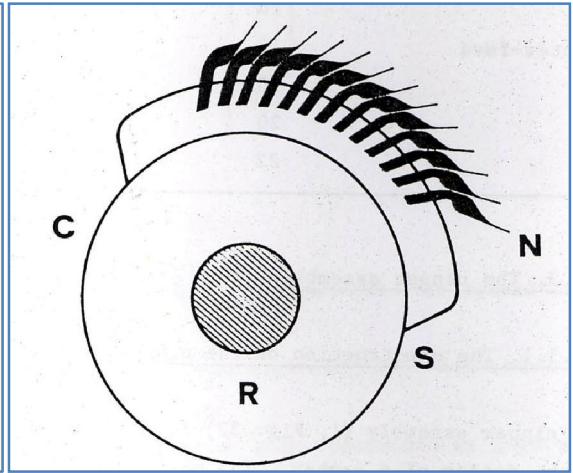
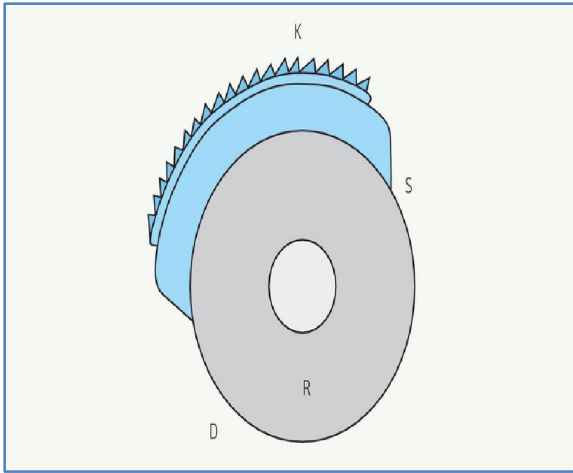


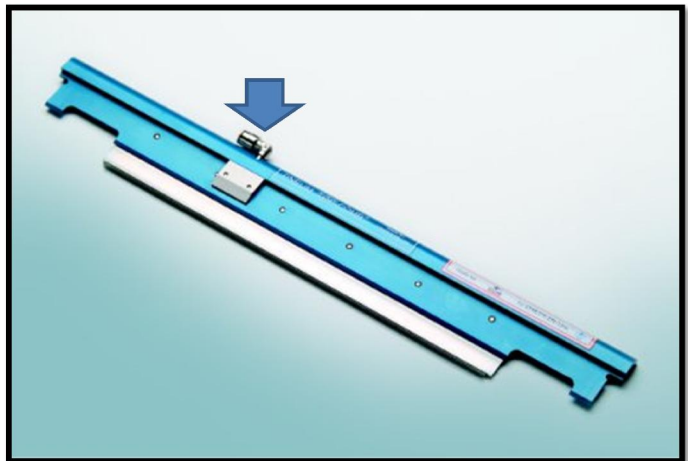
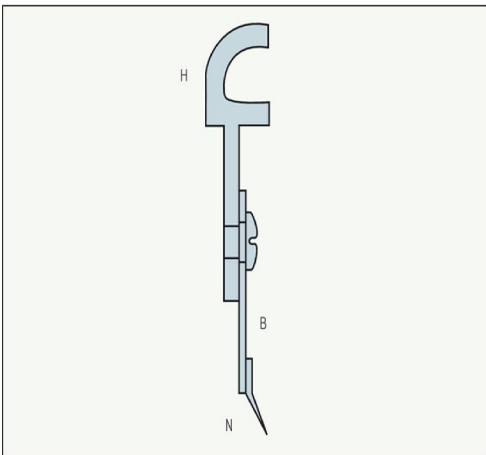
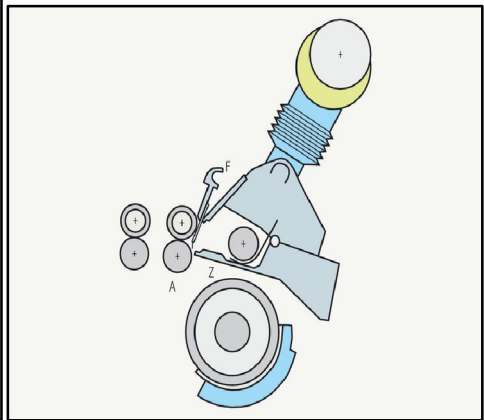
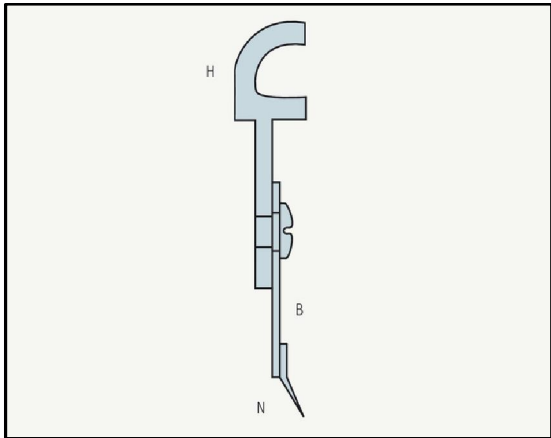
با افزایش طول الیاف میزان تغذیه کاهش می یابد.

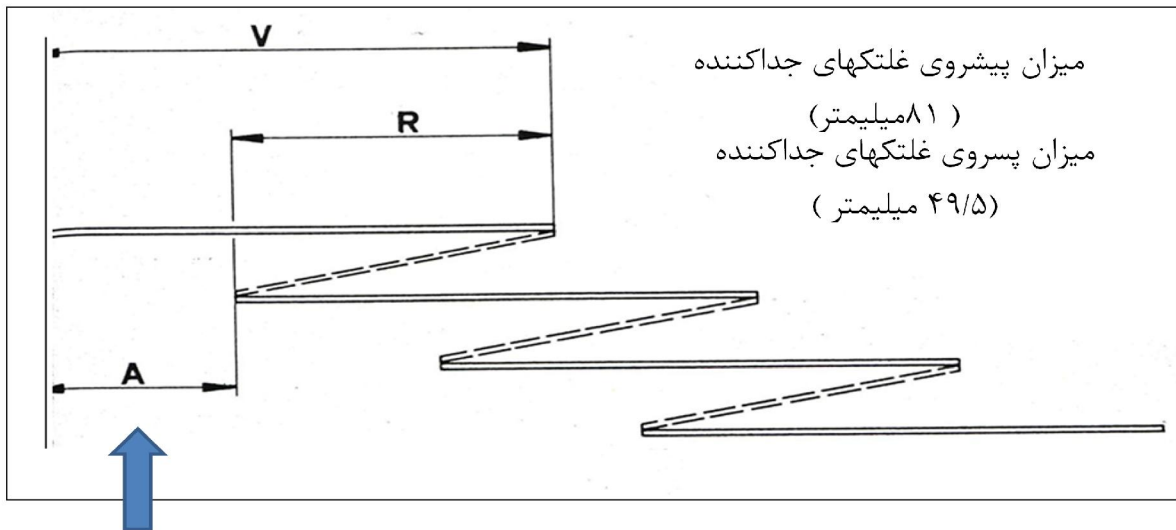
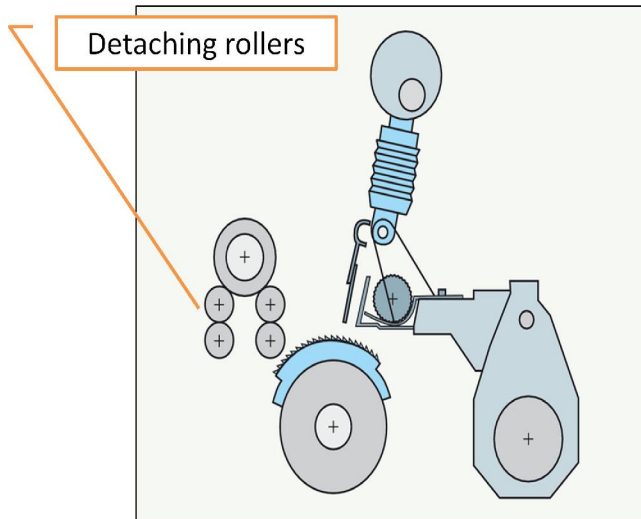






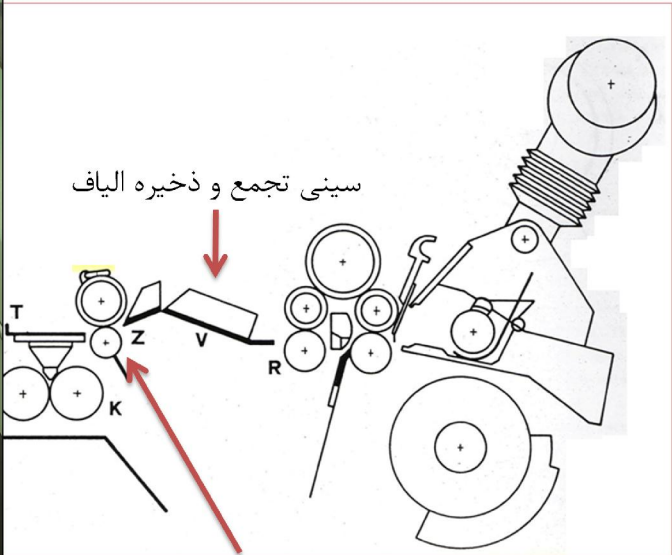




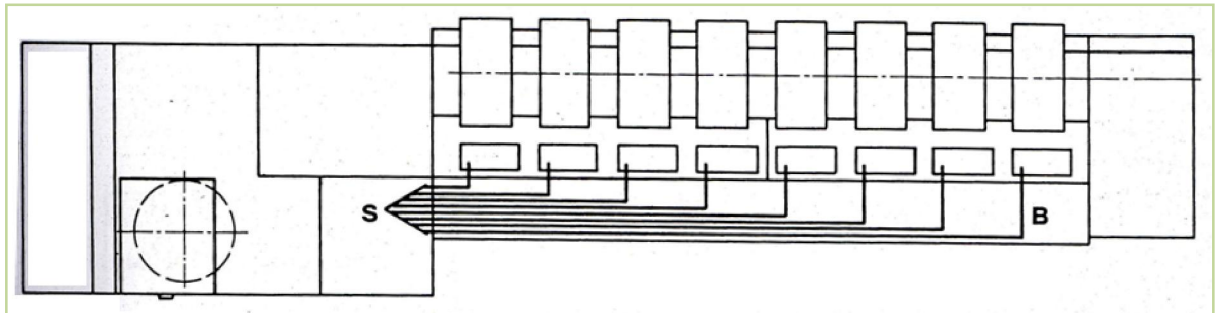


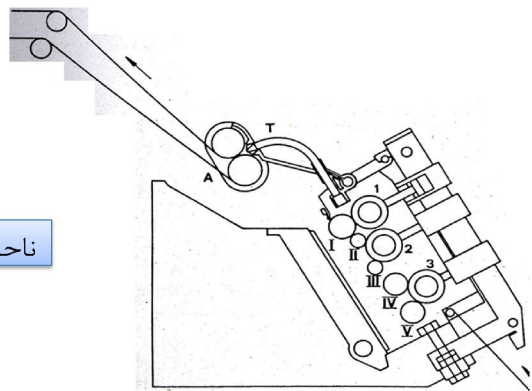
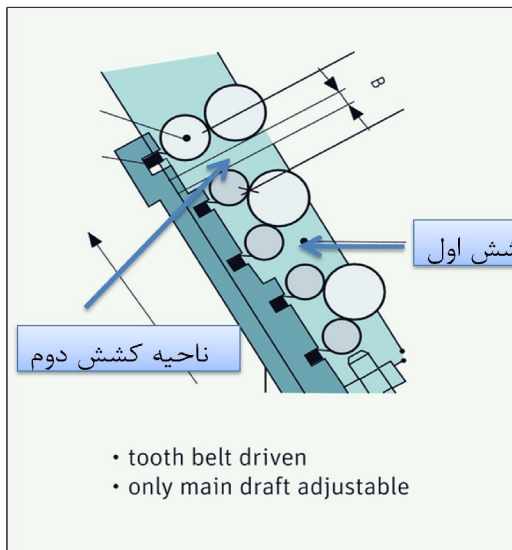
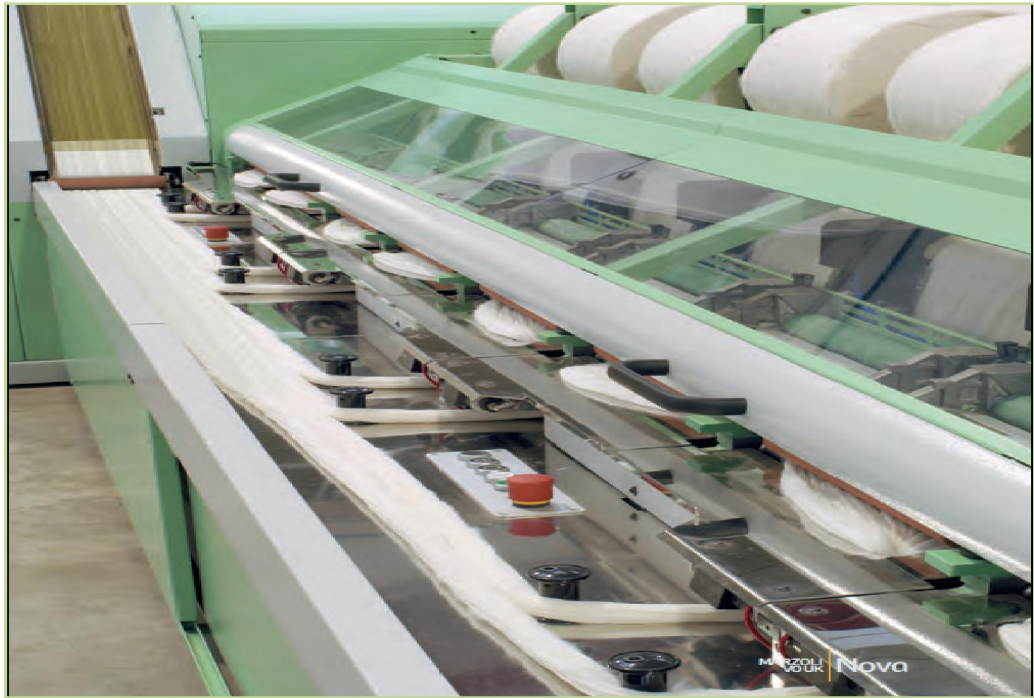
میزان پیشروی غلتکهای جداکننده  
( ۸۱ میلیمتر )  
میزان پسروی غلتکهای جداکننده  
( ۴۹/۵ میلیمتر )

طول موثر لایه برداشت شده  
( ۳۱/۵ میلیمتر )



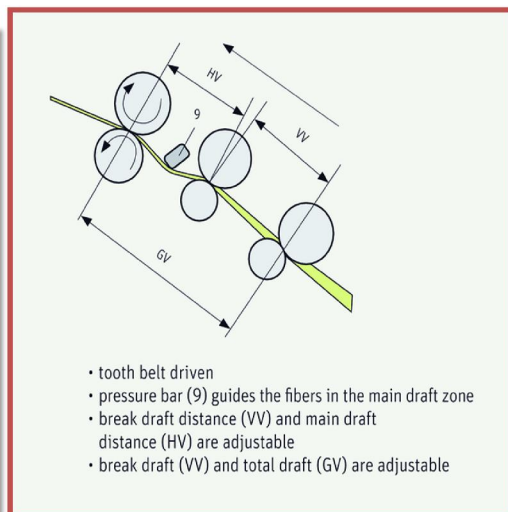
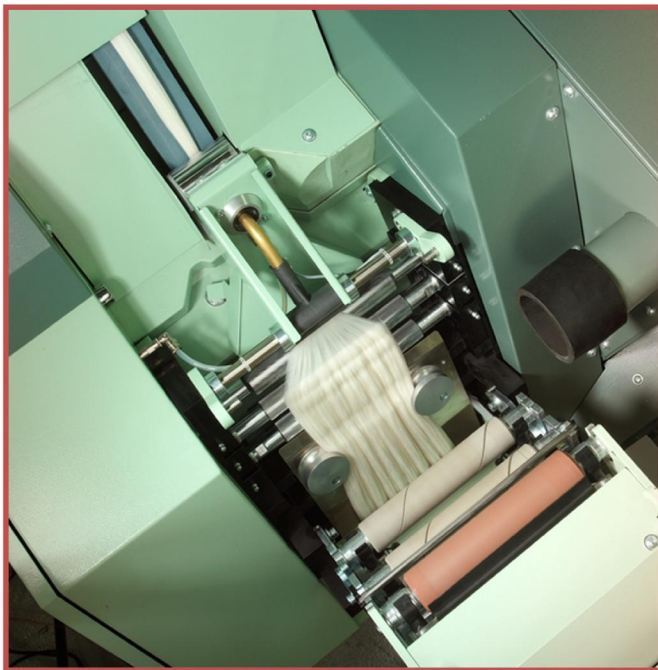
خلتک هدایت الیاف



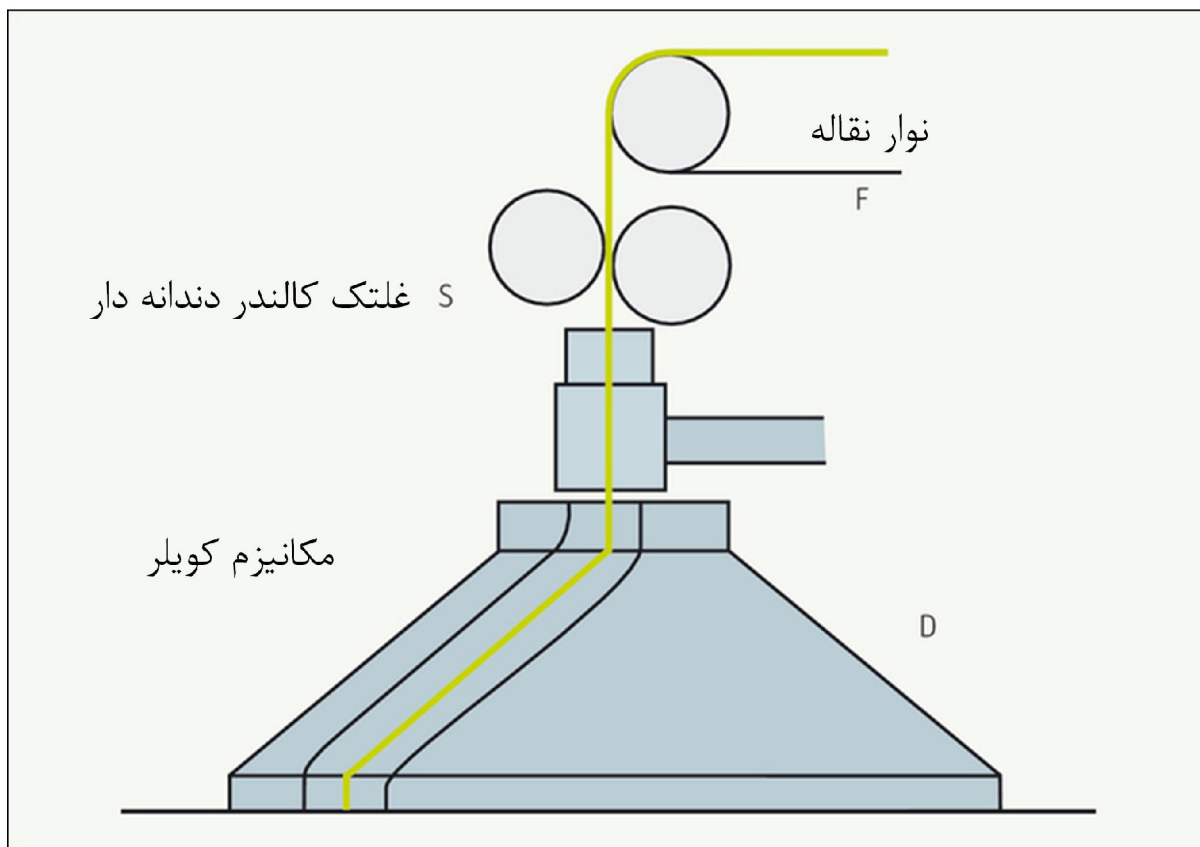


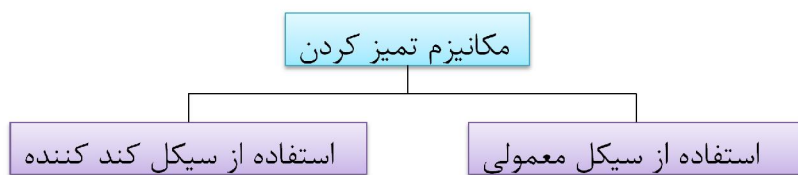
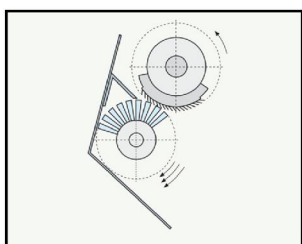
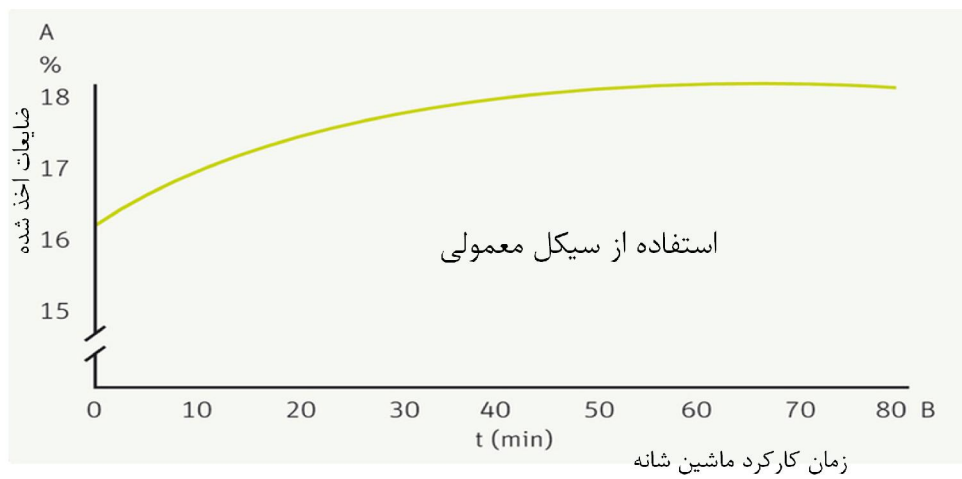
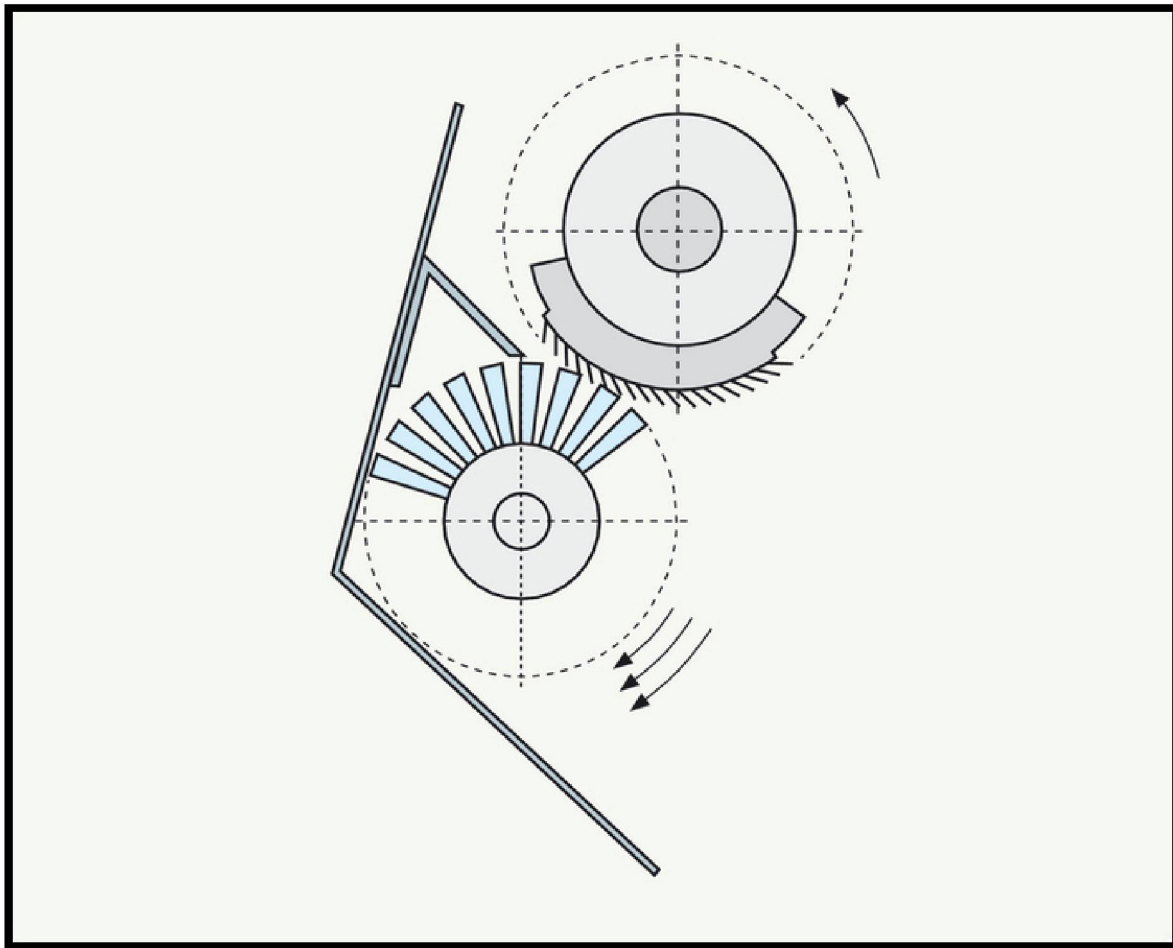
زاویه قرار گیری نسبت به خط افق : ۶۰ درجه  
فاصله غلتک ها در ناحیه کشش اول ثابت است.  
مقدار کشش کل سیستم کششی بین ۹ تا ۱۸ است.

فشار بین غلتکها بصورت پنوماتیکی است.

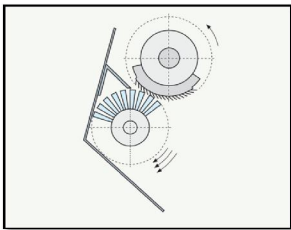
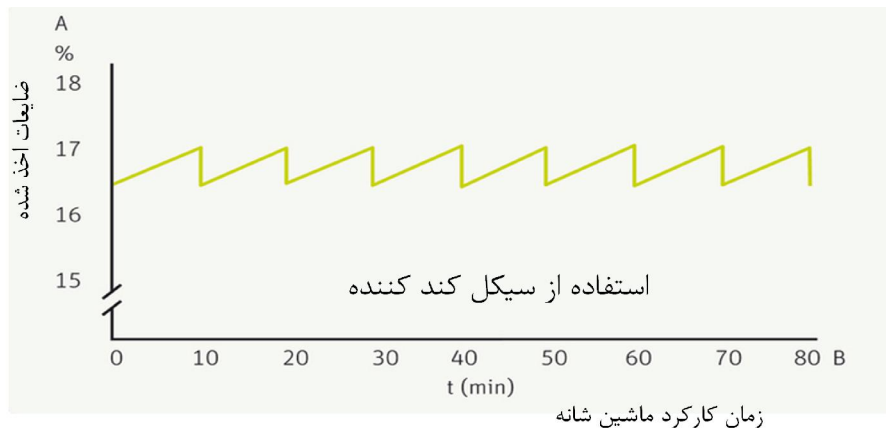


مقدار کشش کل : ۹ تا ۱۶ واحد کشش





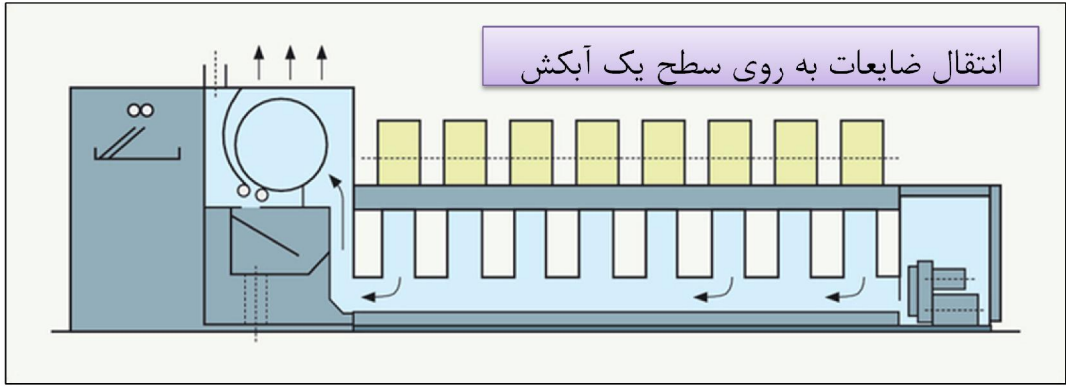




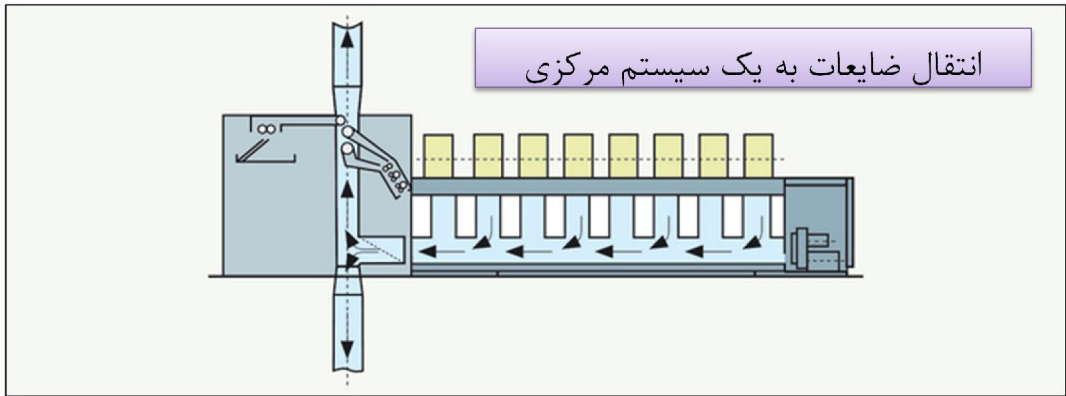
در فواصل زمانی مشخص، سرعت دورانی کلیه قسمت های دوار به یک-پنجم مقدار خود تقلیل می یابد و تنها برس دوار تمیز کننده با سرعت معمول دوران

می کند.

ماشین های قدیمی

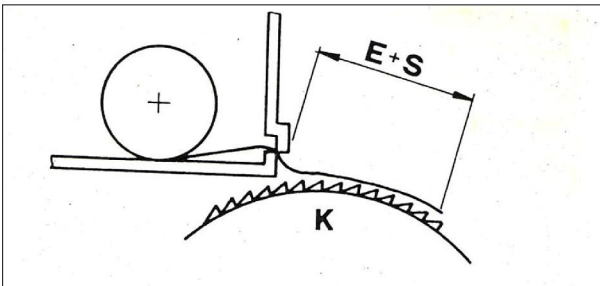
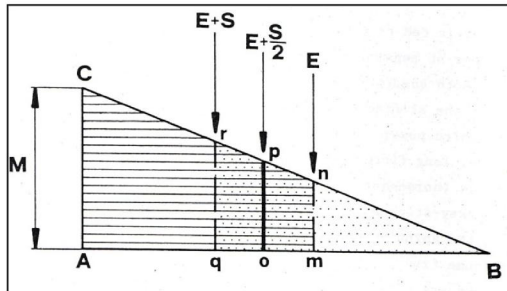
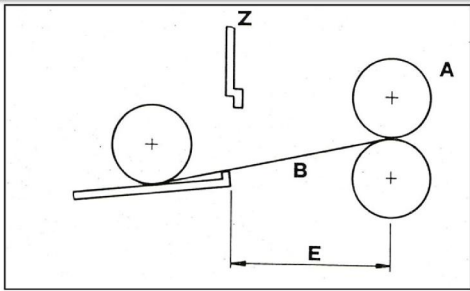


ماشین های جدید



تغذیه مخالف یا منفی

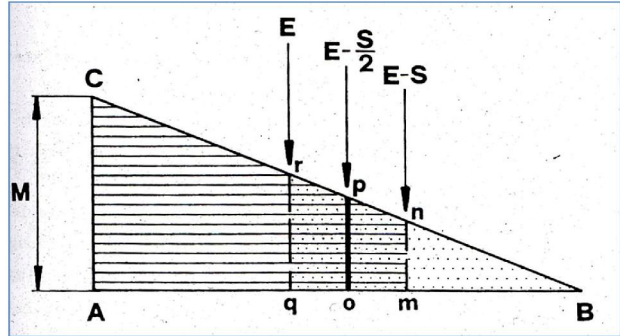
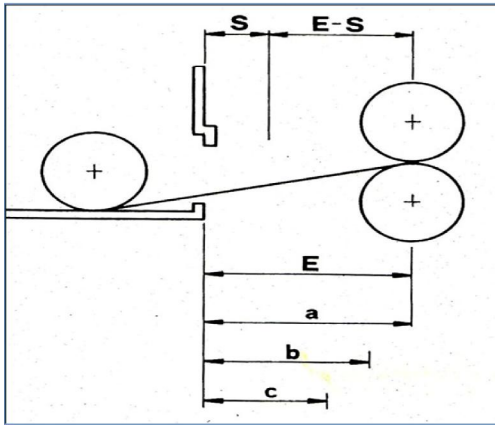
E: Detaching distance



$$p\% = \left[ \frac{(oBp)}{(ABC)} \right] \times 100 = \left[ \frac{(op)^2}{(AC)^2} \right] \times 100$$

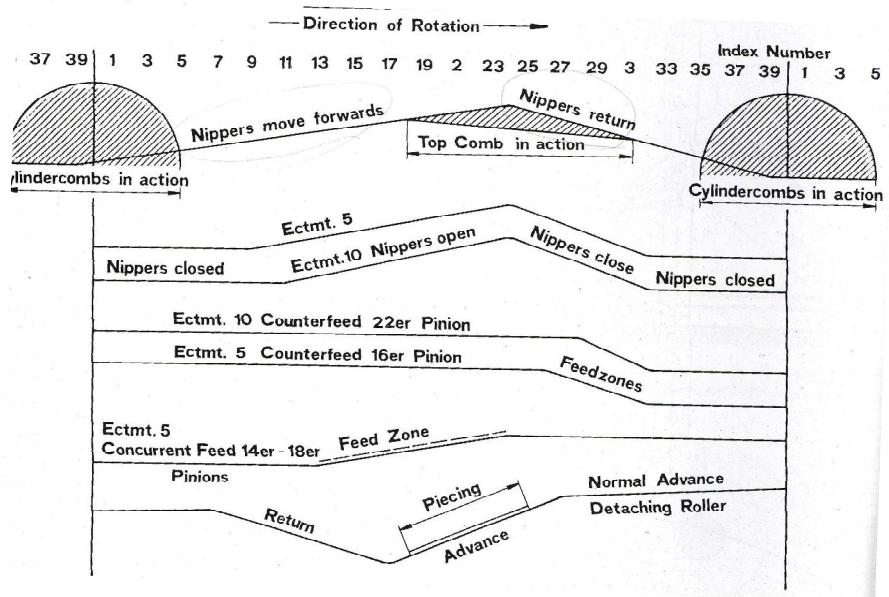
$$= \left[ \frac{[E + (S/2)]^2}{M^2} \right] \times 100$$

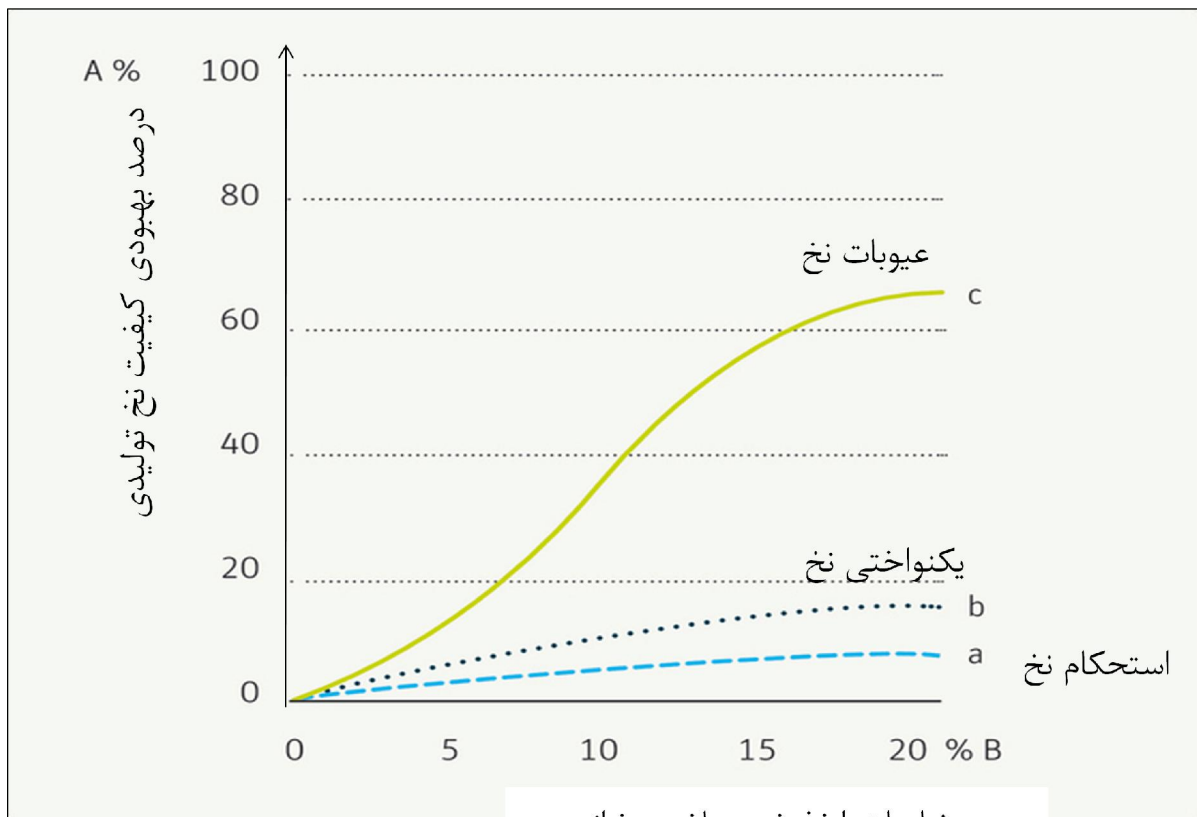
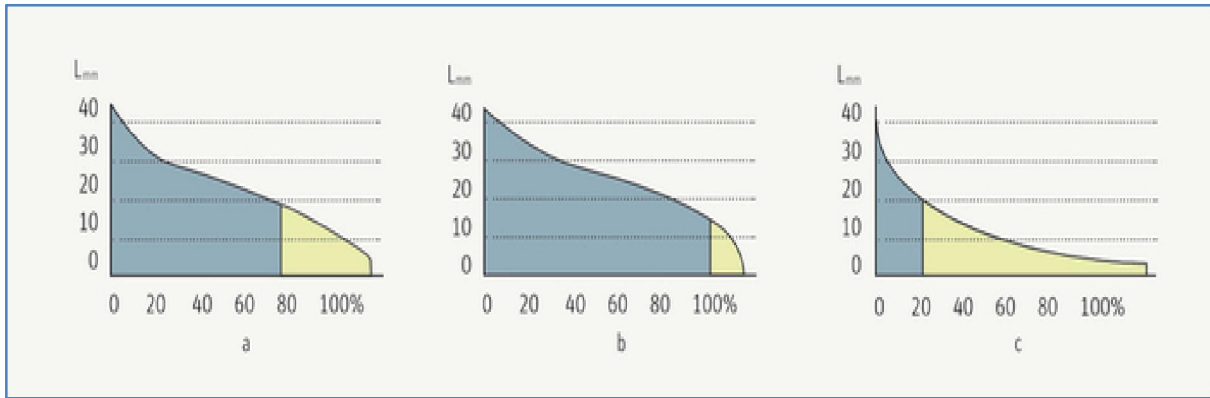
تغذیه موافق یا مثبت



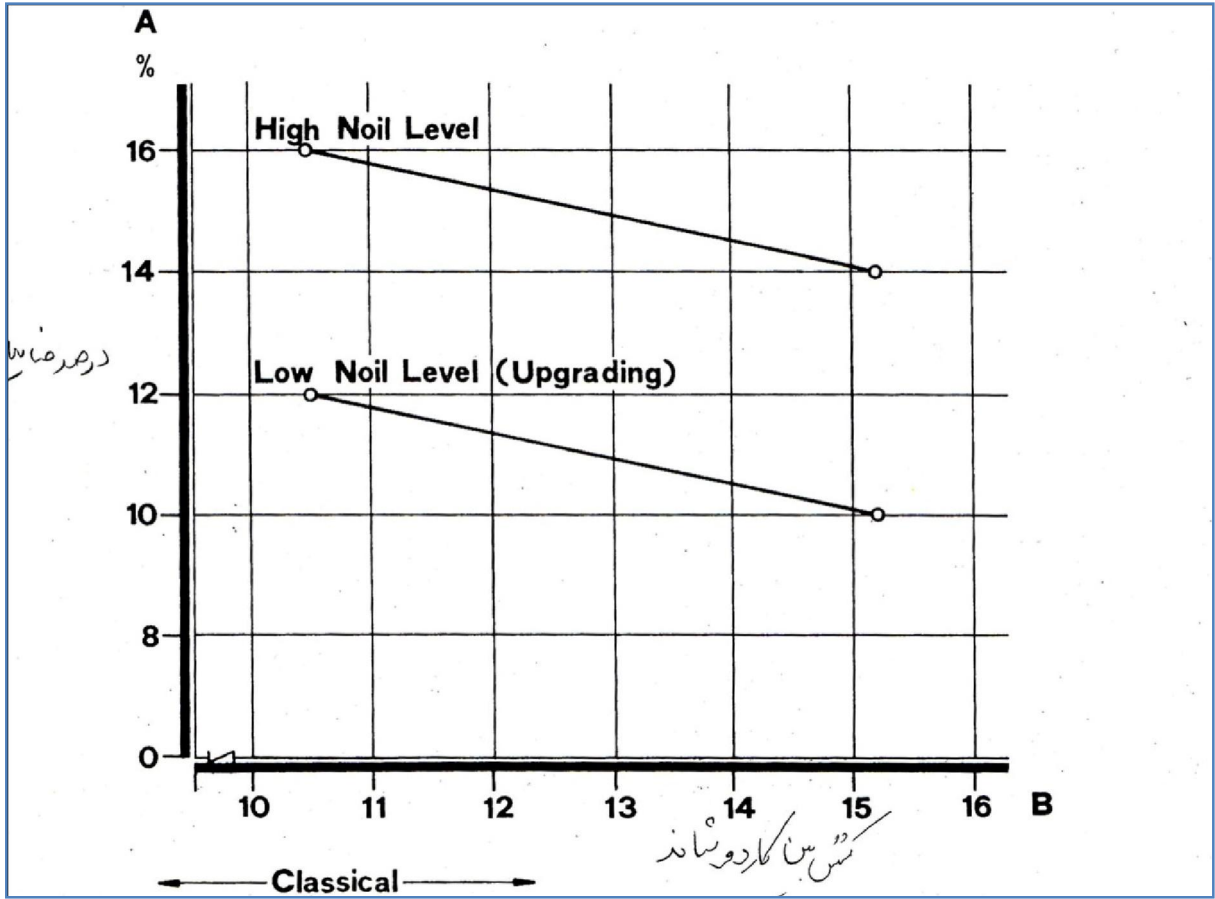
$$\% = \left[ \frac{(oBp)}{(ABC)} \right] \times 100 = \left[ \frac{(op)^2}{(AC)^2} \right] \times 100$$

$$= \left\{ \left[ E - \frac{(S/2)}{2} \right]^2 / M^2 \right\} \times 100$$

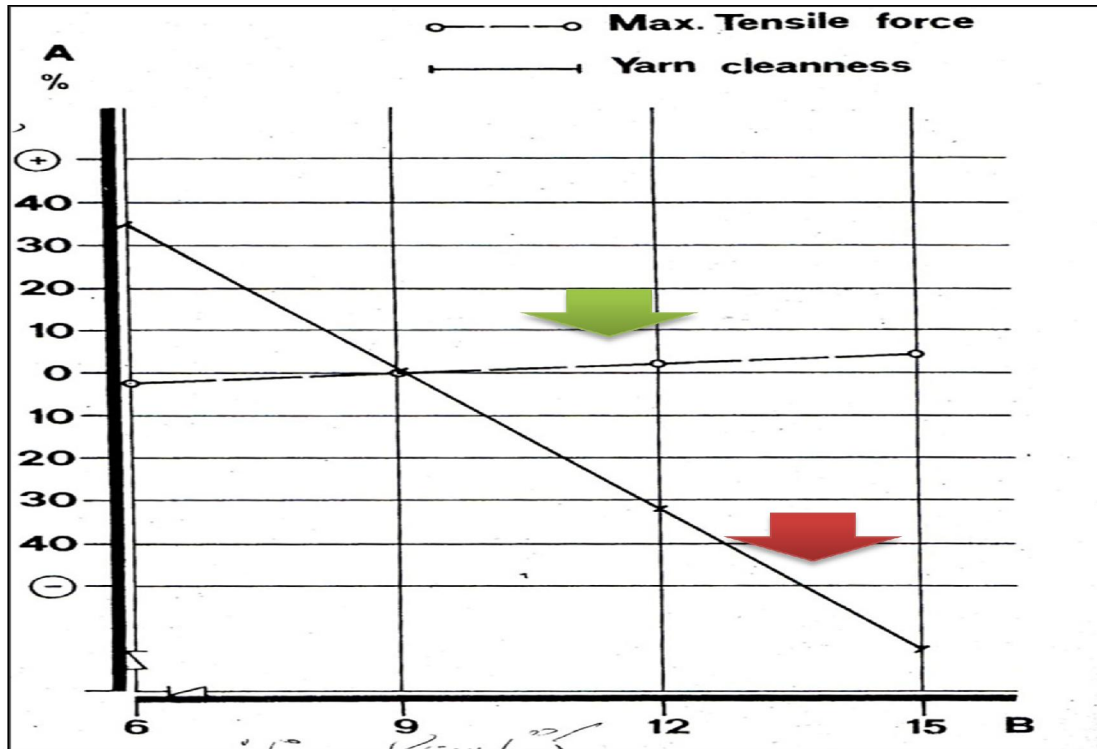




درصد ضایعات اخذ شده ماشین شانه



در صد بهبود خواص نخ



میزن کشش بین کاردینگ و شانه زنی