APPENDICES
APPENDIX - I

TECHNICAL DATA

Number of rotors: 24-48-72-96-120-144-168

Feed: 4.0 ktex to 3.0 ktex for yarns finer than 50 tex

5.0 ktex to 4.0 ktex for yarns 100 tex to 50

6.25 ktex to 5.0 ktex for yarns 500 tex to 100

Can size 350 mm Ø x 900 mm height

Spun yarn

Cylindrical cross wound packages

Conical cross wound packages 2° inclination

Max package weight: 5.0 kg

Crossing angle: 34° (40°)

Tube dimensions:

<table>
<thead>
<tr>
<th>Diameter</th>
<th>Length</th>
<th>Wound Length</th>
<th>Cyl./Con.</th>
</tr>
</thead>
<tbody>
<tr>
<td>mm</td>
<td>mm</td>
<td>mm</td>
<td>inch</td>
</tr>
<tr>
<td>54/60 Ø</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>98/105 Ø</td>
<td>145</td>
<td>130</td>
<td>5</td>
</tr>
<tr>
<td>54/60 Ø x65/71 Ø</td>
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<tr>
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<td>170</td>
<td>150</td>
<td>6</td>
</tr>
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</tr>
</tbody>
</table>

Draft

24 to 204

Twist

T/m = 234 to 1330 (Z-twist only)
Tension : between delivery and winding rollers:
\[ V^*_A = 0.95 \text{ to } 1.07 \]

R.P.M. Max. delivery speed:
Crossing angle up to 34° \( L_{\text{max}} = 150 \text{ m/min} \)
Crossing angle 40° \( L_{\text{max}} = 130 \text{ m/min} \)
(Delivery speed depends on rotor speed and twist change wheels)

Rotors:
48 mm \( \varnothing \) \( n = \) to max. 70000 R.P.M.
56 mm \( \varnothing \) \( n = \) to max. 60000 R.P.M.
65 mm \( \varnothing \) \( n = \) to max. 45000 R.P.M.
92 mm \( \varnothing \) \( n = \) to max. 30000 R.P.M.

Opener rollers:
\( n = 5000 \text{ to } 9000 \text{ R.P.M.} \)

Fan : 35000 R.P.M.

Package conveyor belt : 5.5 m/min. at 50 Hz
\[
6.6 \text{ m/min. at 60 Hz}
\]
Trash conveyor belt : 11.0 m/min at 50 Hz
\[
13.2 \text{ m/min at 60 Hz}
\]

Dimensions:
Pitch : 195 mm
Feed roller dia. : 32 mm
Opener roller dia. : 80 mm
Delivery roller dia. : 30 mm
Winding roller dia. : 75 mm

Opener roller clothing : OB20 for cotton
\[
\text{OS21 for synthetics}
\]
**Draw-off nozzles**: smooth for cotton
with 4 notches for cotton and synthetics
with 8 notches and knurled for synthetics

**Vacuum**: 40 to 70 mbar
400 to 700 mmWS

**Air exhaust rates**: Headstock 800 m³/h, 20°C above rotor temperature
Tailstock 3800 m³/h, 25°C above rotor temperature

**Special equipment**: Opener rollers with needles or spe and accessories clothing
Ceramic nozzles smooth
with 4 notches
with 8 notches

Creel for cans with
400 mm to 600 mm dia.

Package take-off device

Counter for preadjusted yarn lengths

Scanning device for quality control

Pressing device for opener rollers.