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TEXTILE INDUSTRY STANDARD OF THE PEOPLE'S REPUBLIC OF CHINA

ICS 59.120.20

W 93

FZ/T 93019-2004

Replacing FZ/T 93019-1993

Flat fillet clothing for carding process

梳棉机用弹性盖板针布

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Issued on: August 15, 2004

Implemented on: January 1, 2005

**Issued by: National Development and Reform Commission of the
People's Republic of China.**

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Foreword

This Standard replaces FZ/T 93019-1993 *Flat clothing for carding process*.

Compared with FZ/T 93019-1993, the major changes of this Standard are as follows:

- MODIFY the name of this Standard.
- ADD the “Normative references” (SEE Chapter 2 of this version).
- ADD the “Terms and definitions” (SEE Chapter 3 of this version).
- MODIFY the “Classification and marks” (Section 3.1 of the 1993 version; Sections 4.1 and 4.2 of this version).
- SIMPLIFY the requirements for the limit deviations of the basic dimensions of the flat clothing. DELETE the grading rules (Section 4.1 of the 1993 version; Section 5.1 of this version).
- MODIFY the requirements for the tip flatness. DELETE the grading rules (Section 4.2 of the 1993 version; Section 5.2 of this version).
- DELETE the requirements for the distance between carding pin and side clip (Section 4.3 of the 1993 version).
- MODIFY the provisions on the tip hardness range of the carding pins. DELETE the grading rules (Section 4.4 of the 1993 version; Section 5.3 of this version).
- SIMPLIFY the test methods. DELETE the appendix (Section 5.1 of the 1993 version; Sections 6.1 to 6.5 of this version).
- MODIFY and IMPROVE the “Inspection rules” (Chapter 6 of the 1993 version; Chapter 7 of this version).
- MODIFY the “Packaging, symbols and storage” (Chapter 7 of the 1993 version; Chapter 8 of this version).

This Standard was proposed by China National Textile and Apparel Council.

This Standard shall be under the jurisdiction of the Shaanxi Textile Equipment Research Institute.

Main drafting organizations of this Standard: Shaanxi Textile Equipment Research Institute, Shanghai Far East Card Clothing Co., Ltd, Wuxi Owl

Flat fillet clothing for carding process

1 Scope

This Standard specifies the terms, definitions, classification, marks, requirements, test methods, inspection rules, symbols, packaging and storage of the flat fillet clothing for carding process (hereinafter referred to as “flat clothing”).

This Standard **is applicable to** the flat clothing using the fillet clothing as carding element.

2 Normative references

The provisions in the following documents become the provisions of this Standard through reference in this Standard. For dated references, the subsequent amendments (excluding corrections) or revisions do not apply to this Standard. However, parties who reach an agreement based on this Standard are encouraged to study if the latest versions of these documents are applicable. For undated references, the latest versions apply to this Standard.

GB/T 191 *Packaging – Pictorial marking for handling of goods*

GB/T 347 *Card wire*

GB/T 2828.1 *Sampling procedures for inspection by attributes – Part 1: Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection*

GB/T 2829 *Sampling procedures and tables for periodic inspection by attributes (Apply to inspection of process stability)*

GB/T 4340.1 *Metallic materials – Vickers hardness test – Part 1: Test method*

GB/T 4892 *Dimensions of rigid rectangular packages – Transport packages*

GB/T 6543 *Corrugated boxes*

GB/T 12339 *Inner packaging materials in preservation*

5.3 The hardness in the position which is 0.5mm under the tip of the carding pin of the flat clothing after heat treatment shall not be lower than 720HV0.2. The hardness difference of the same pair of flat clothing shall not be greater than 60HV0.2. The hardness of the tips without heat or special treatment shall be determined by the manufacturing plant.

5.4 The pin density of the flat clothing shall be 97% to 105% of the theoretical value.

5.5 The carding pins shall be neatly arranged on the base fabric. The tips and bodies of the carding pins shall be clean and without any rust. The tips shall have no barbs.

6 Test methods

6.1 MEASURE the basic dimensions according to the specified measuring tools as follows:

- a) USE a common normal micrometer to measure the total height;
- b) USE a steel tape to measure the total width;
- c) USE a vernier caliper to measure the total length and wire setting length;
- d) USE a special goniometer to measure the rake angle.

6.2 The tip flatness error shall be determined by the measurements of the total height, which is the range of the total height of the same pair of card clothing.

6.3 DETERMINE the Vickers hardness of the carding pins according to the relevant provisions of the GB/T 4340.1.

6.4 USE a vernier caliper to measure and to calculate the pin density.

6.5 USE the visual observation method for appearance quality inspection.

7 Inspection rules

7.1 General

7.1.1 The flat clothing shall be conducted with the following categories of inspection:

- Type inspection;

The basic dimensions of the packages shall conform to the provisions of the GB/T 4892 as far as possible.

8.2 Symbols

8.2.1 Product symbols

Each box of flat clothing shall have 1 to 2 product labels that are not easy to be stained, along with the following indications:

- a) manufacturing plant's name or trademark;
- b) product symbol; and
- c) manufacturing date or batch number.

8.2.2 Packaging symbols

There shall be packaging symbols (delivering symbol for transport packages, and pictorial marking for handling of goods) on the transport packages. The contents shall conform to the provisions in Sections 8.2.2.1 and 8.2.2.2.

8.2.2.1 Delivering symbol for transport packages:

- a) manufacturing plant's name and trademark;
- b) product symbol;
- c) manufacturing date or batch number;
- d) exit-factory date;
- e) number of each pair; and
- f) gross weight.

8.2.2.2 Pictorial marking for handling of goods

The symbols of "KEEP DRY" and "FRAGILE" shall conform to the provisions in the GB/T 191.

8.3 Storage

8.3.1 The manufacturing plant shall conduct adequate anti-rust treatment to the flat clothing, and shall ensure that no rusting will be caused by improper anti-rust treatment within one year from the date of exiting the factory.

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Contact: Wayne Zheng, Sales@ChineseStandard.net

Linkin: <https://www.linkedin.com/in/waynezhengwenrui/>

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