打造装备旗舰 引领纺织发展

CREATING A FLAGSHIP IN MANUFACTURING
LEADING THE DEVELOPMENT OF TEXTILE INDUSTRY

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2024.07

青岛宏大纺织机械有限责任公司
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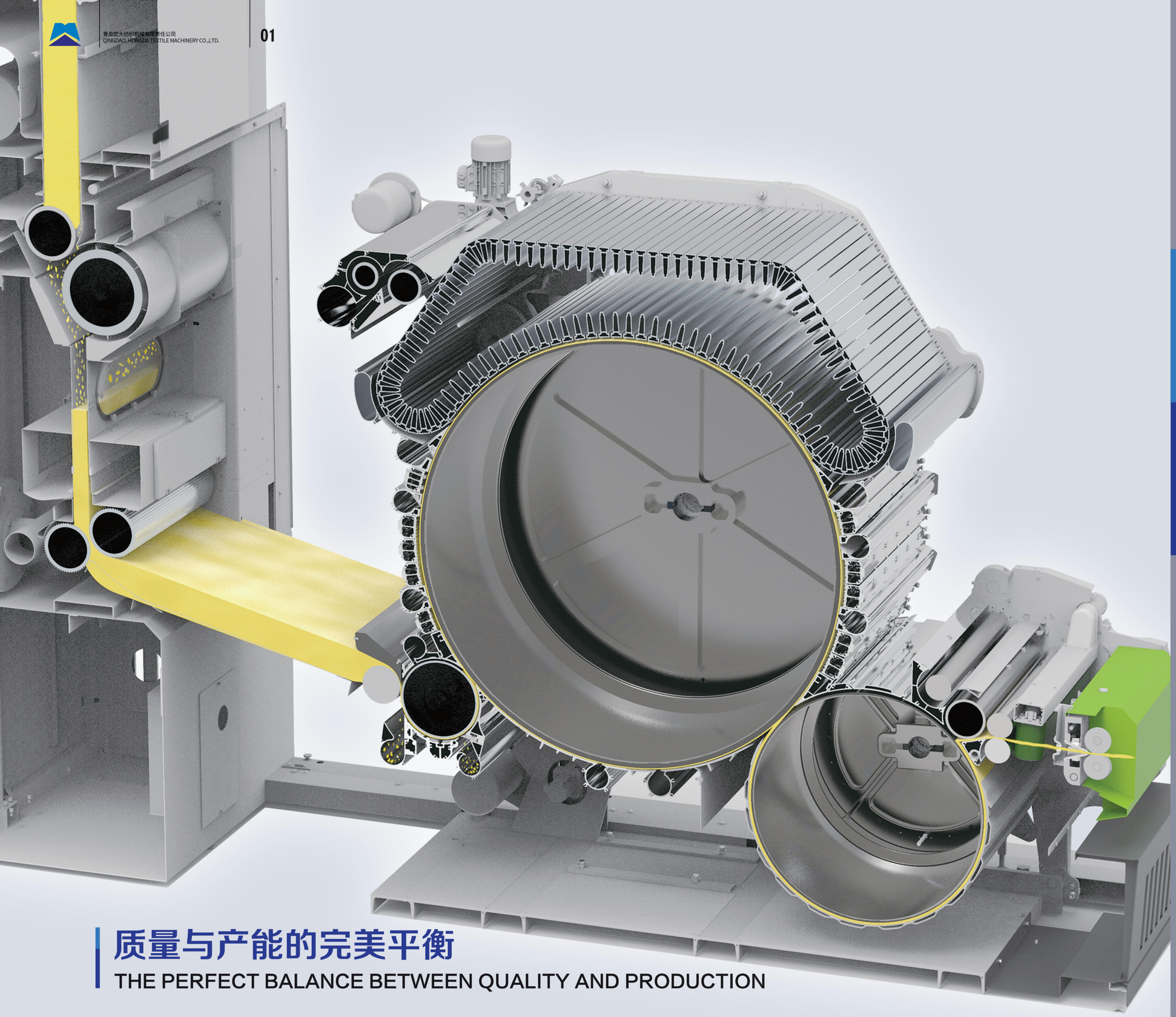
JWF1217 梳棉机
CARDING MACHINE

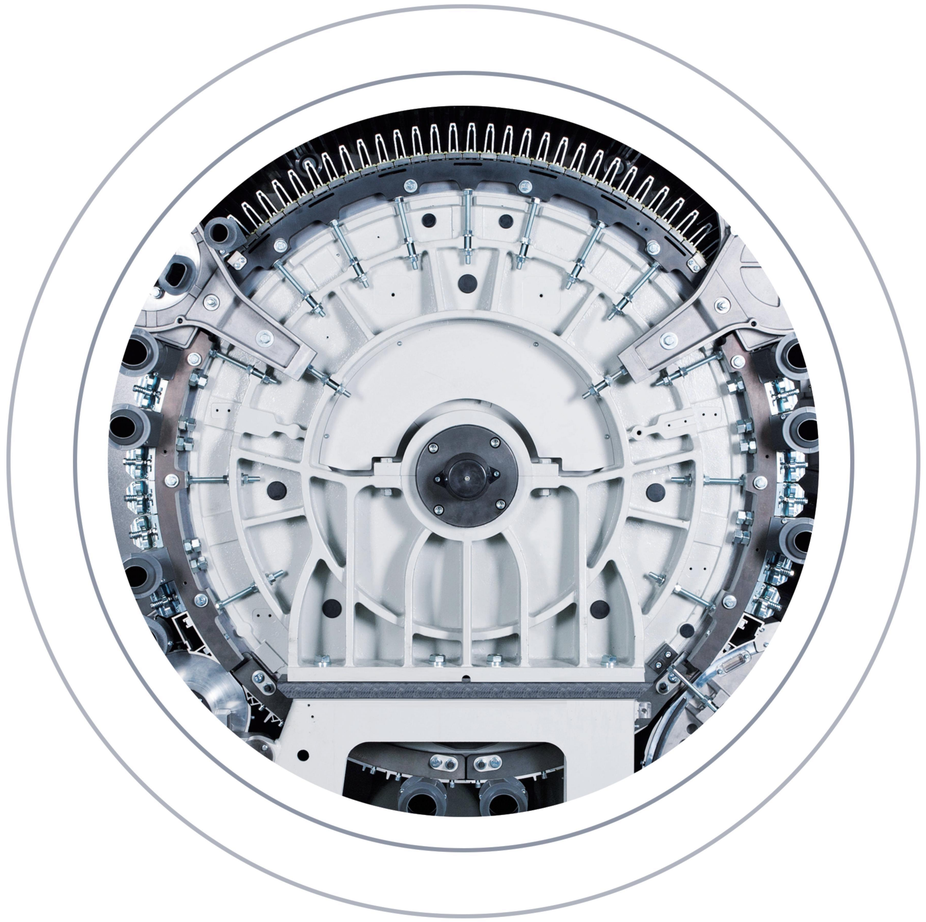
创新 | 改变 | 突破 | 成长
MAKE BREAKTHROUGHS IN THE FUTURE



质量与产能的完美平衡

THE PERFECT BALANCE BETWEEN QUALITY AND PRODUCTION

高质 HIGH QUALITY	稳定 STABILITY
高效 HIGH EFFICIENCY	智能 INTELLIGENCE



CARDING MACHINE

JWF1217梳棉机

亮点
HIGHLIGHTS

★ **3米梳理弧长，工作盖板数量增加到38根，9点隔距设定，保证隔距精准性，增强分梳能力。**

3 meter carding length, the number of rotary flats involved in carding increased to 38, 9 point gauge setting ensures the gauge accuracy and enhances the carding ability.

★ **大直径给棉喂入机构，增强握持力，提升喂入效率；全新三罗拉结构，保证高速高产。**

Large diameter feeding roller mechanism, enhance fiber grip,improve feeding efficiency;brand-new three-roller structure to ensure high speed and high yield.

★ **多伺服驱动，控制精准；单独变频传动，调整灵活。**

Multi servo drive, precise control;independent inverter drive, flexible adjustment.

★ **智能安全防护。**

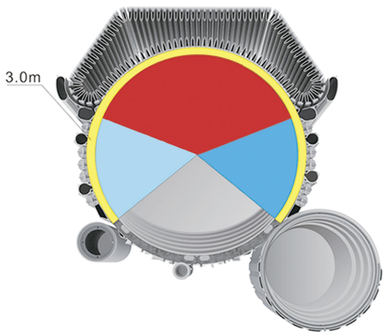
Intelligent security protection.

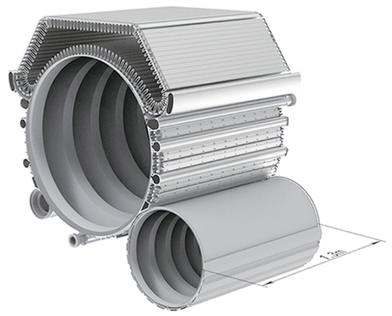
★ **在线检测系统。**

On-line detecting system.

高产高效的分梳系统 >>>

CARDING SYSTEM WITH HIGH CAPACITY AND EFFICIENCY



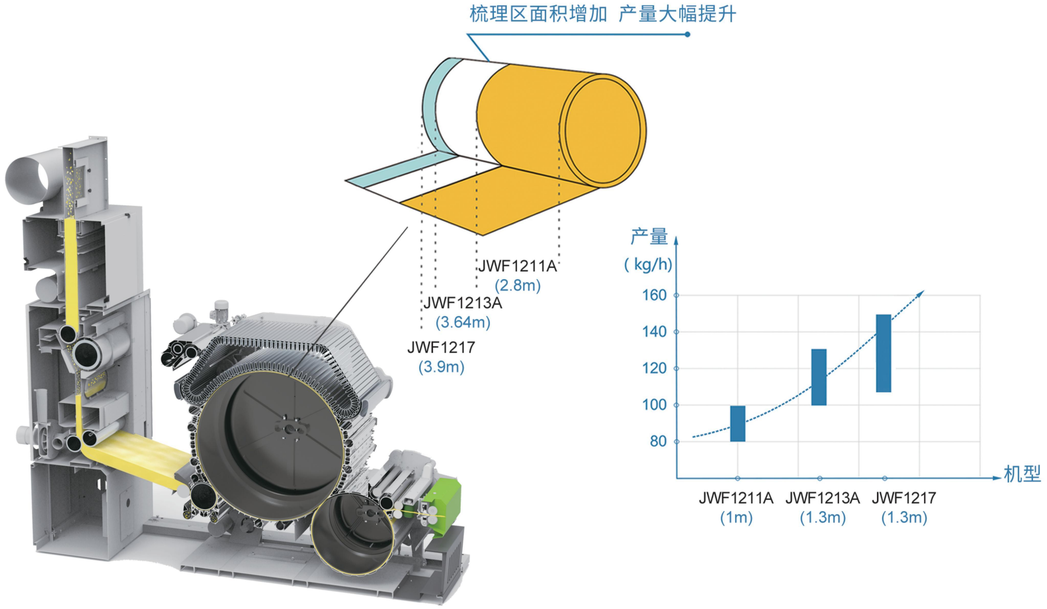


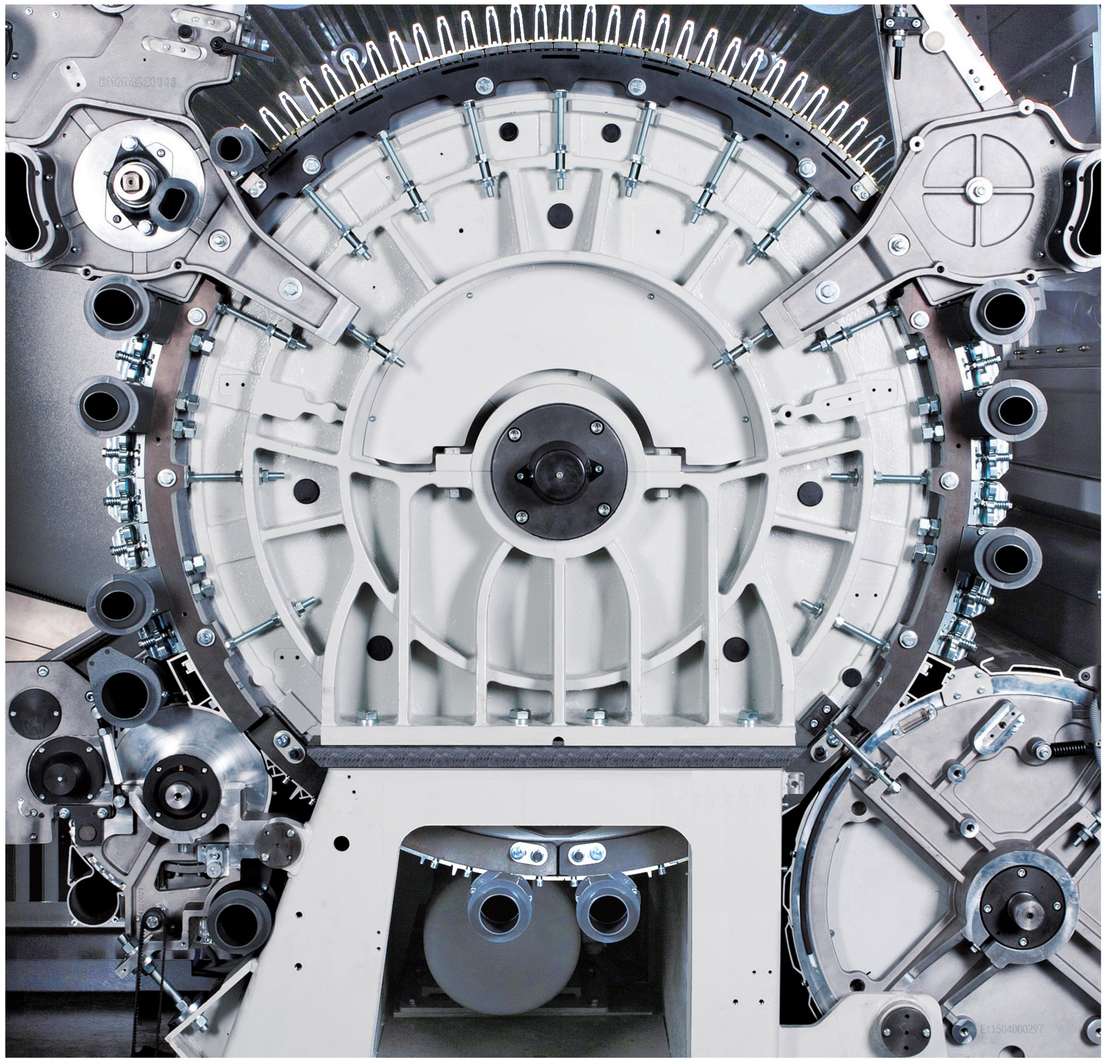
前固定盖板
Front stationary flat area

回转盖板区
Rotary flat area

后固定盖板区
Rear stationary flat area

整个梳理区弧长
Arc length of whole carding area





全新理念的大梳理区结构设计

Large carding area structure design of brand-new concept

全新理念的结构设计，使梳理弧长达到3m，工作幅宽1.3m，梳理面积3.9㎡，实现了前固定盖板区、回转盖板区和后固定盖板区的合理分布，分梳能力显著增强，在保证卓越生条质量水平的同时，拥有更高的生产力。

Including 3 meters carding length, 1.3 meters working width and 3.9㎡ carding area, realizes the reasonable distribution of the front stationary flat area, the rotary flat area and the rear stationary flat area. The carding capability has been significantly enhanced to ensure higher production while maintaining superior sliver quality.

38根工作盖板 高效分梳
38 working rotary flats / efficient carding

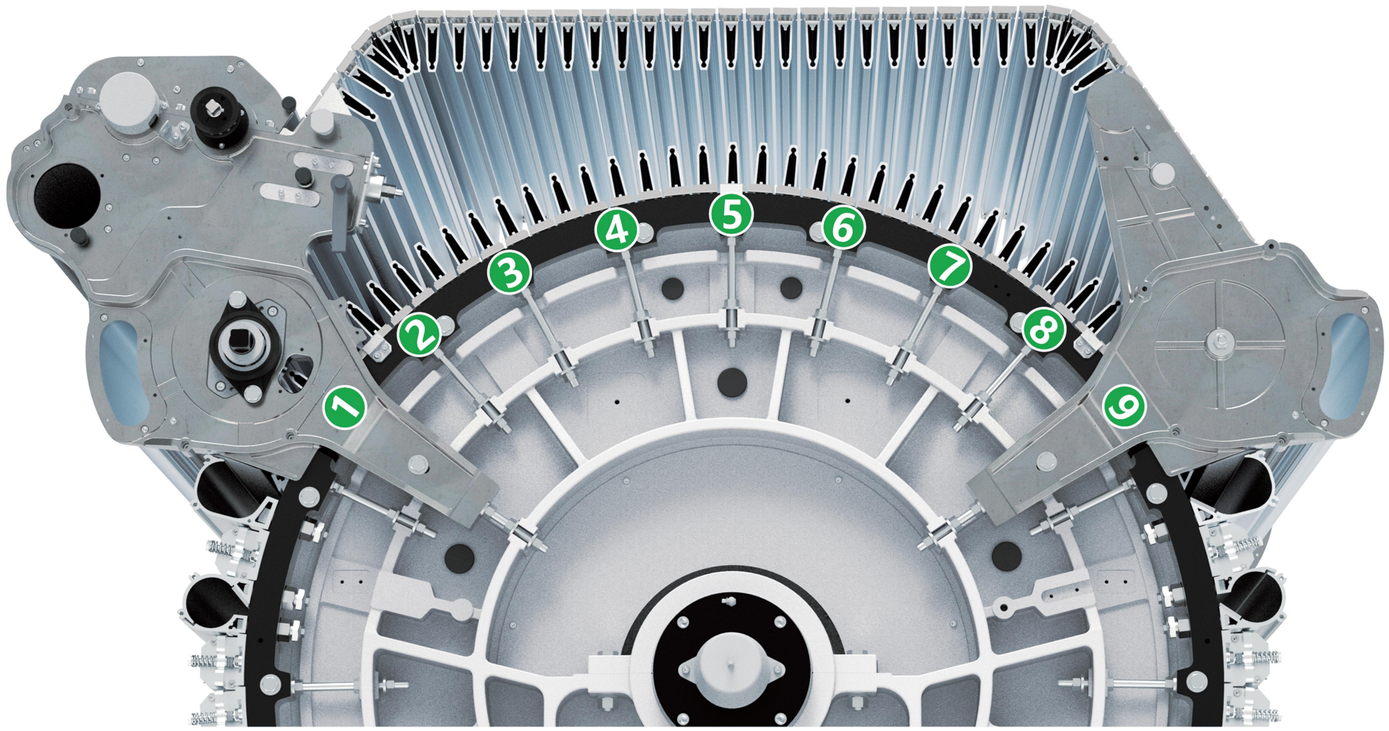
工作区域回转盖板数量是梳棉机生条质量的决定因素，JWF1217梳棉机参与分梳的回转盖板数量增加到38根，增大了有效梳理面积，分梳能力增强。

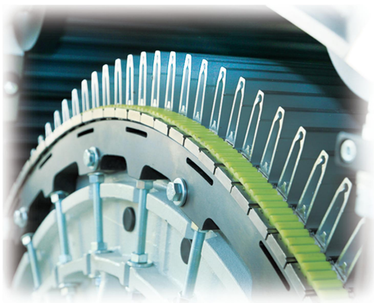
The number of working rotary flat is the key of the sliver quality. Therefore JWF1217 increased its working rotary flat number to 38 pcs, which improve the effective carding area and carding ability.

9点隔距调节
9 point gauge adjustment

回转盖板区采用9点隔距设定，确保了隔距设定的精准性和稳定性，从而达到良好的分梳效果。

The rotary flats adopt 9-point gauge setting to ensure the accuracy and stability of the gauge then achieve better carding effect.



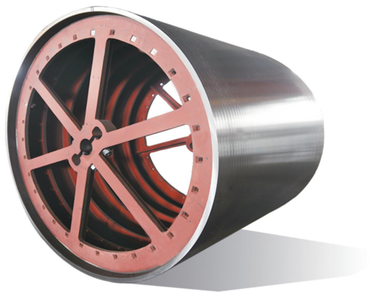


采用新型盖板传动机构，回转盖板固定牢固，运行平稳，确保良好的分梳效果。

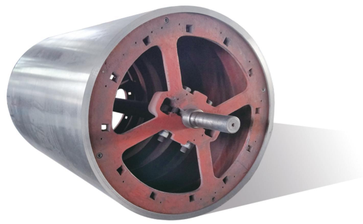
Adopt new flat transmission mechanism, the rotary flats fixed firmly and runs smoothly to ensure good carding effect.

工艺隔距的精准控制
PRECISE CONTROL OF TECHNICAL GAUGE

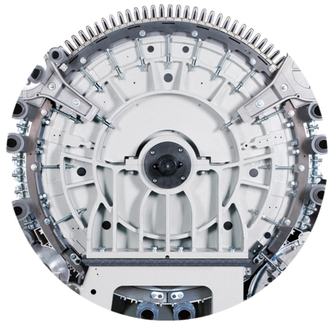
可靠稳定的质量保证 >>>
STABLE AND RELIABLE QUALITY GUARANTEE



整体铸造锡林 Mono-block casting cylinder



整体铸造道夫 Mono-block casting doffer

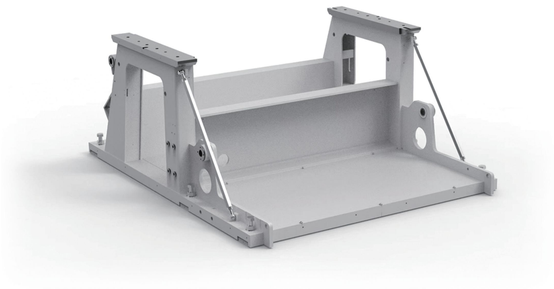


圆墙板 Side wall

整体铸造工艺
Mono-block technique

梳理隔距的精确程度决定了机器的梳理效果，我们拥有高质量的核心零部件，采用整体铸造的锡林、道夫及圆墙板，稳定性好，热膨胀系数小，确保设备在高速高产的状态下分梳工艺隔距的稳定性和精确性。

The accuracy of carding gauge determines the carding effect of the machine. We have high-quality core components and use mono-block casting iron cylinder, doffer and side wall. That ensures the stability and accuracy of the carding technical gauge when running with high speed and high capacity.



梯形机架 Trapezoidal frame

梯形机架
Trapezoidal frame

梯形钢板焊接整体机架，结构简单、牢固，采用五面加工中心一次装夹完成，保证了整机主要部件和隔距的稳定性、一致性。

The overall frame welded with trapezoidal steelplates has a reliable and firm performance and was installed by the five-sided machining center at one time, ensuring the stability and consistency of the main componentsand gauge.

高效的运行系统 >>>
EFFICIENT OPERATING SYSTEM

高效的喂入系统
Efficient feeding system

☆ 采用大直径给棉罗拉，增强对纤维的握持，提高给棉刺辊区开松分梳度，提升喂入效率。

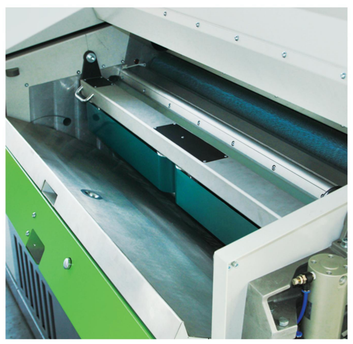
☆ The bigger-diameter feeding roller is adopted to strengthen the holding of fibers, to improve the opening, feeding and carding efficiency in the licker-in area.

☆ 配置两个落杂区和一组分梳板，保证分梳效果和除杂效率；

☆ 第一落杂区长度机外可调，第一落杂区可采用单独电机控制(选配)。

☆ Licker-in is designed with two noil areas and one set of carding segment to ensure the carding effect and impurity removal efficiency;

☆ The length of the first noil area is adjustable outside of the machine, or controlled by separate motor (Optional).



高速的输出系统
High-speed output system

☆ 合理布局三罗拉结构，加强结构稳定性，工艺调整灵活，保证了棉网的高速稳定输出；

☆ 辅助生头装置，操作简单，节省时间，降低劳动强度和难度(选配)。

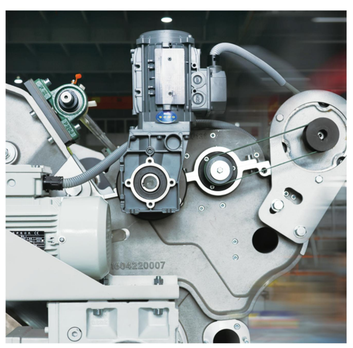
☆ Reasonable layout of three-roller structure, strengthening structure stability, flexible process adjustment, ensuring high-speed and stable output of web;

☆ Auxiliary piecing device easy to operate, saving time, reducing labor intensity and difficulty(Optional).

多点单独传动
Multipoint indepedent transmission

☆ 锡林、刺辊、回转盖板、刷辊采用单独变频传动，工艺速度调整更加灵活、方便。

☆ Cylinder, licker-in, rotary flat, brush roller are all driven by independent inverter motor for more convenient technology adjustment。



☆ 给棉罗拉、大压辊、圈条器、道夫及三罗拉采用单独伺服传动，控制更加精准，适应高速、高产需求。

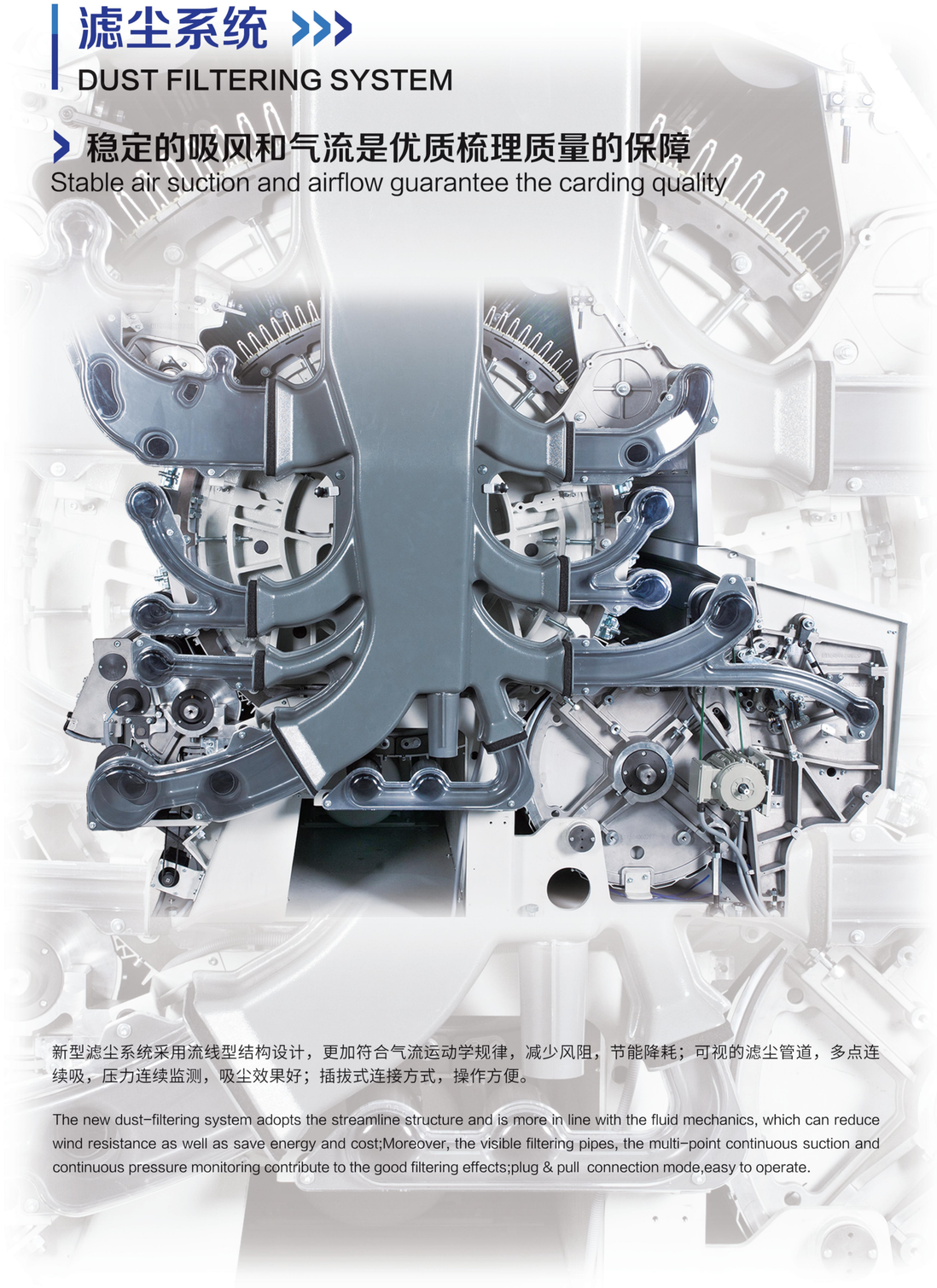
☆ Feeding roller, big calender, coiler,doffer and three rollers adopt independent servo drive, more precise control, suitable for high speed and high capacity demand.

滤尘系统 >>>

DUST FILTERING SYSTEM

稳定的吸风和气流是优质梳理质量的保障

Stable air suction and airflow guarantee the carding quality



新型滤尘系统采用流线型结构设计，更加符合气流运动学规律，减少风阻，节能降耗；可视的滤尘管道，多点连续吸，压力连续监测，吸尘效果好；插拔式连接方式，操作方便。

The new dust-filtering system adopts the streamline structure and is more in line with the fluid mechanics, which can reduce wind resistance as well as save energy and cost;Moreover, the visible filtering pipes, the multi-point continuous suction and continuous pressure monitoring contribute to the good filtering effects;plug & pull connection mode,easy to operate.

FT211系列圈条器 >>>

FT211 SERIES COILER

方便安装

Easy to install

不埋地底盘结构，地脚施工简单，方便就位。

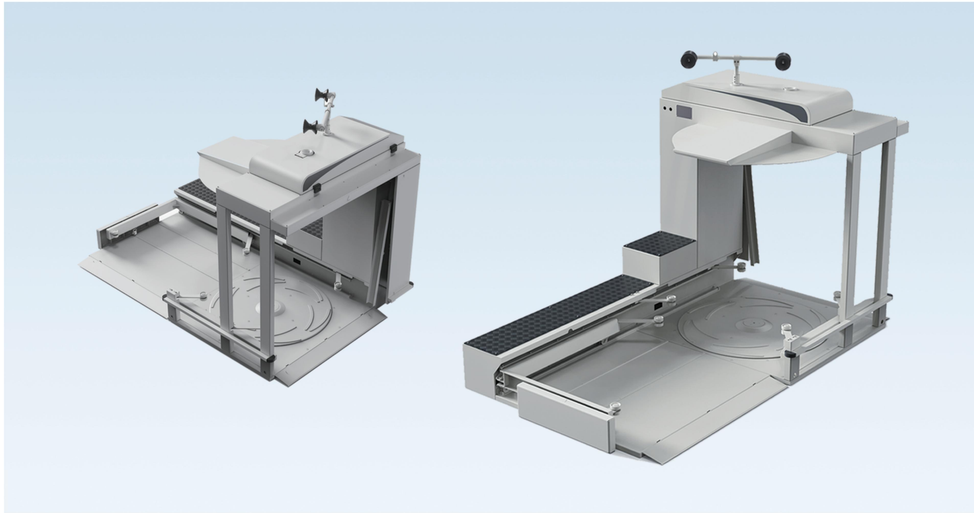
Simple foundation construction, no need burying the chassis, convenient for positioning.

结构精简

Simplified structure

新型无拖车换筒装置，结构简单。

New type trailer-free can changer with simplified structure.



高速机外切条

High-speed sliver cutting

高速机外切条，换筒时不降速，换筒过程中生条重量平稳。

Doffer speed doesn't need to decrease when cutting sliver therefore the sliver weight is stable during can-changing, avoiding materials waste.

节约占地面积

Saving occupied area

结构简洁易维护，占地面积小。

Simplified structure,easy to maintain,small floor space.

伺服电机单独传动

Independent servo motor drive

采用伺服电机单独传动，出条更稳定。

Driving by independent servo motor, to ensure sliver delivery more stable.

适用形式

Application

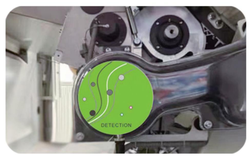
适用于φ1000x1100/1200、φ1200x1300棉条筒，直线式自动换筒，伺服电机单独传动。

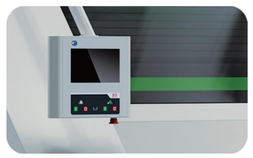
Suitable for φ1000x1100/1200、φ1200x1300 can,straight autocan changer,driven by independent servo motor.

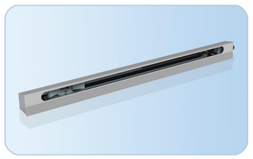
智能化提升 >>>
INTELLIGENT IMPROVEMENT

采用新模式人机界面，RFID技术实现了工艺分级、权限解锁、便捷操作等功能；应用LED灯带多彩组合的设计；显示屏位置和角度可灵活调节；可选择性展示不同参数，有效地向操作人员显示设备运行状态。

Adopting a new mode of human-machine interface, RFID technology achieves functions such as process classification, permission unlocking, convenient operation, etc;The design of colorful combination of LED light strips is applied; the position and angle of the display screen can be adjusted flexibly;different parameters can be selectively displayed, effectively showing the operating status to the operator.







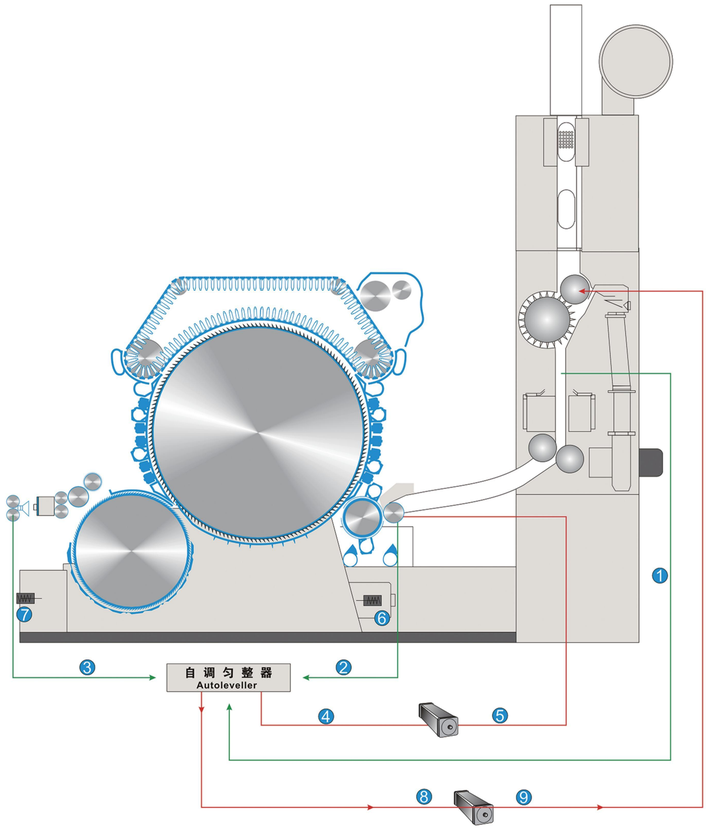
智能化安全防护系统，采用锡林接针保护、梳理区温度监控、金属检测等防护功能，全方位提升梳棉机安全性能；

Intelligent protection functions such as cylinder wire touching protection, temperature monitoring in carding area, and metal detection to improve the safety performance of the carding machine in all aspects;

可选配盖板隔距在线检测、棉结在线检测、落杂在线检测等智能化检测系统，实时监控设备运行过程中的隔距、质量指标、落棉情况，确保生条质量长期可靠稳定。

Optional flat gauge on-line detection, nep on-line detection, noil on-line detection, etc. can monitor the gauge, quality index and noil situation in real time during the operation of the equipment, to ensure long-term reliability and stability of sliver quality.

四位一体自调匀整系统 >>>
FOUR-IN-ONE AUTO-LEVELLING SYSTEM



1.棉箱压力监测
2.检测喂入棉层
3.检测输出棉条
4.调整给棉罗拉
5.给棉罗拉驱动器
6.短片段控制传感器
7.长片段控制传感器
8.调整棉箱给棉罗拉
9.棉箱给棉罗拉驱动器
10.清花供棉压力PID控制

1.Monitor chute pressure
2.Monitor feed lap
3.Monitor sliver delivery
4.Adjust feed roller
5.Feed roller driver
6.Short-term control sensor
7.Long-term control sensor
8.Adjust chute feed roller
9.Chute feed roller driver
10.PID control for blowroom supply pressure

☆ 8条匀整参数曲线，可以实时监控棉层，棉箱压力、棉条的变化趋势；
☆ 清花智能供棉、棉箱IPD控制、后环、前环四位一体式匀整系统，保证生条重量的稳定；
☆ 便捷操作，精细调控，实现参数及运行状态远程监控。

☆ 8 levelling parameter curves, which can monitor the changing trend of cotton layer, chute feeder, pressure and sliver in real time;
☆ Smart cotton supply for blowroom, PID control in chute-feeder, 4-in-1 model of the auto-levelling system in the rear loop and front loop ensure the stability of sliver count;
☆ Convenient operation and precise control, to realize the remote monitoring for data and operation status.

新型一体化棉箱 >>>

NEW TYPE INTEGRATED CHUTE FEEDER

☆ 上棉箱采用四面排风结构，储棉量大，供棉稳定；

☆ 给棉罗拉、开松辊防护罩方便打开，便于维护保养；

☆ 给棉罗拉和开松辊端面采用新型密封结构，有效防止塞花；

☆ 给棉板采用弹簧加压，弹性握持纤维，与给棉罗拉之间的隔距可根据棉层的厚度自动调节；

☆ 下棉箱采用双面梳针排风，确保输出筵绵均匀度。

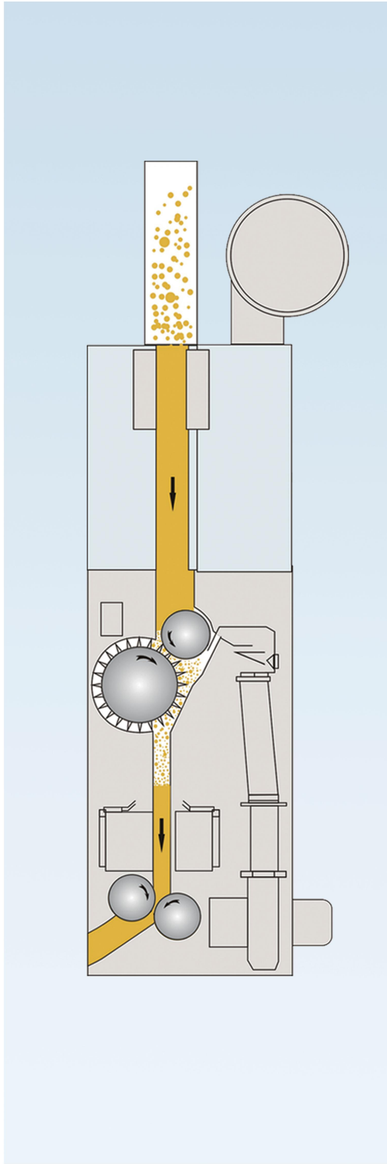
☆ The upper chute feeder adopts four-sided exhaust structure for large storage and stable supply;

☆ Feed rollers and opening rollers cover are easy to open for convenient maintenance;

☆ New sealing structure is adopted on the both ends of feeding roller and opening roller to effectively prevent cotton blocking;

☆ Feeding plate is pressurized by spring so the fiber is hold elastically. Gauge between feeding plate and feeding roller is automatically adjusted according to the layer thickness;

☆ Double-sided breathable barrier is adopted by the lower chute feeder for air discharge to ensure the output uniformity of layer.



主要规格

Specifications

喂棉箱	JWF1177B
工作宽度（毫米）	1210
给棉罗拉直径（毫米）	Φ172
开松辊直径（毫米）	Φ292
开松辊转速（转/分）	700/1150
输出罗拉直径（毫米）	Φ156
装机功率（千瓦）	2.3
外形尺寸（长X宽X高）（毫米）	2150x700x2800
机器净重（公斤）	约810

Working width (mm)	1210
Feeding roller dia. (mm)	Φ172
Opening roller dia. (mm)	Φ292
Opening roller speed (rpm)	700/1150
Output roller dia. (mm)	Φ156
Installed power (kW)	2.3
Overall dimension(LxWxH)(mm)	2150x700x2800
Net weight(kg)	about810

结构示意图 >>>
STRUCTURE FIGURE

主机部分
Carding section

01 刺辊第一除尘刀
Licker-in lst mote knife

02 刺辊第二除尘刀
Licker-in 2nd mote knife

03 刺辊分梳板
Licker-in carding segment

04 刺辊
Licker-in

05 后固定盖板
Back stationary flat

06 锡林封闭漏底
Cylinder enclosed undercase

07 锡林
Cylinder

08 铝合金回转盖板
Al-alloy rotary flat

09 前固定盖板
Front stationary flat

10 道夫封闭漏底
Doffer enclosed undercase

11 道夫
Doffer

12 三罗拉清洁辊
3-rollers' cleaning roller

13 三罗拉
3-rollers

14 大压辊
Big calender

15 皮圈导棉装置
Cross apron

16 生条重量检测部件
Sliver weight detecting unit

17 棉层厚度检测部件
Lap thickness detecting unit

棉箱部分
Chute feeder section

18 上棉箱
Upper chute feeder

19 给棉罗拉
Feeding roller

20 给棉板
Feeding plate

21 开松辊
Opening roller

22 静压箱
Statistic pressure case

23 下棉箱
Lower chute feeder

24 循环风机
Circling fan

25 棉箱输出罗拉
Chute output roller

26 导料槽
Material slot

27 电气控制柜
Control cabinet

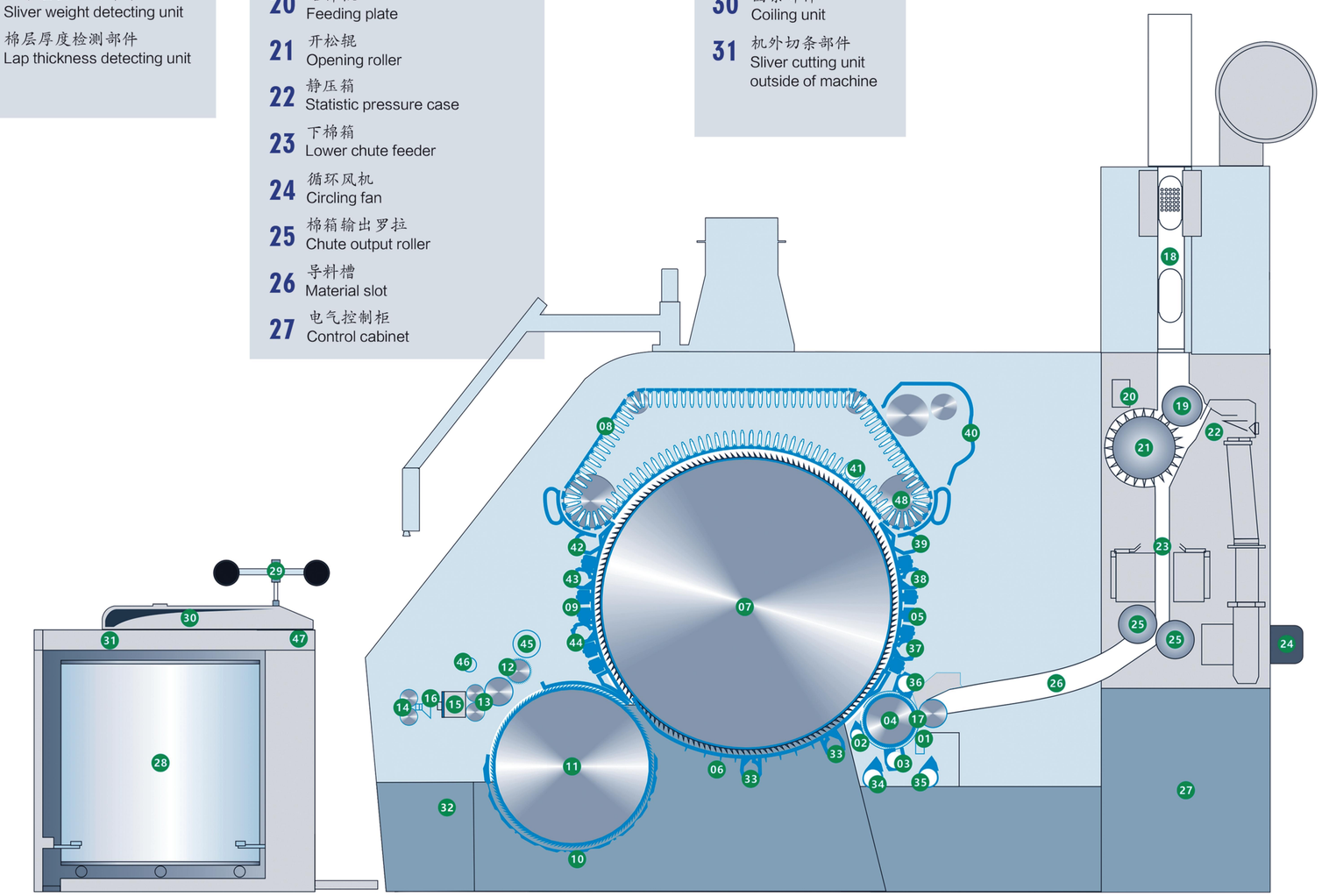
圈条器部分
Colier section

28 条筒
Can

29 导条架
Cradle

30 圈条部件
Coiling unit

31 机外切条部件
Sliver cutting unit outside of machine



滤尘部分
Dust filtering section

32 前车肚吸点
Front undercard suction point

33 锡林漏底吸点
Cylinder undercase suction point

34 刺辊第二落杂区吸点
Licker-in 2nd noil suction point

35 刺辊第一落杂区吸点
Licker-in lst noil suction point

36 刺辊放气罩吸点
Licker-in air balance point

37 后下棉网清洁器吸点
Rear /lower web cleaner suction point

38 后上棉网清洁器吸点
Rear /upper web cleaner suction point

39 后盖板杂质吸点
Rear flat trash suction point

40 盖板花吸点
Flat waste suction point

41 盖板飞花吸点
Flat fly suction point

42 前盖板杂质吸点
Front flat trash suction point

43 前上棉网清洁器吸点
Front/upper web cleaner suction point

44 前下棉网清洁器吸点
Front/lower web cleaner suction point

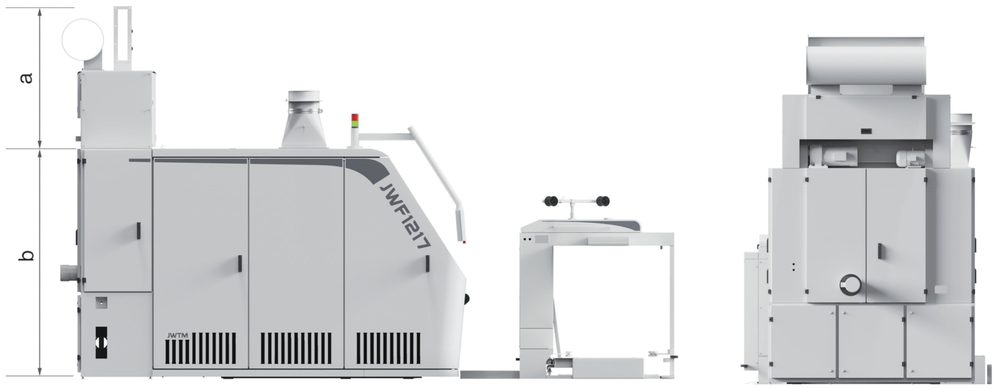
45 三罗拉清洁吸点
3-rollers suction point

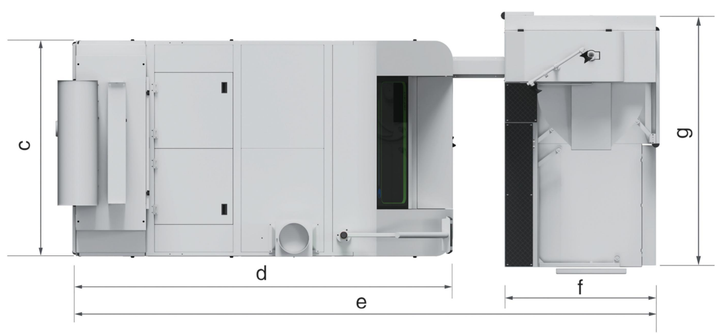
46 喇叭口吸点
Trumpet suction point

47 圈条器吸点
Coiler suction point

48 盖板传动吸点
Suction points for flat drive

主要规格 >>>
SPECIFICATIONS





机型/Type	a	b	c	d
JWF1217	1395	2250	2150	3800

机型/Type	e	f	g
ϕ600自动	5250	1130	1552
ϕ1000自动	5800	1510	2600
ϕ1200自动	5995	1710	2800

机型		Type		JWF1217
最高产量（公斤/小时）		Max. output (kg/h)		200
最高出条速度（米/分）		Max. sliver delivery speed (meter/min)		400
棉条定量（克/米）		Sliver count(g/m)		3.5 ~ 10
筵棉定量（克/米）		Feed weight(g/m)		400 ~ 1300
工作幅宽（毫米）		Working width(mm)		1280
总牵伸倍数		Total draft folds		40 ~ 370
刺辊工作直径（毫米）		Licker-in working dia.(mm)		Φ250
刺辊工作速度（转/分）		Licker-in working speed(rpm)		700 ~ 1200
道夫工作直径（毫米）		Doffer working dia.(mm)		Φ706
道夫工作速度（转/分）		Doffer working speed(rpm)		3 ~ 120
锡林工作直径（毫米）		Cylinder working dia.(mm)		Φ1288
锡林工作速度（转/分）		Cylinder working speed(rpm)		330 ~ 550
回转盖板根数（工作盖板/盖板总数）		Pieces of rotary flat(working/total)		38/108
盖板工作速度（毫米/分）		Flat working speed (mm/min)		70 ~ 400
附加梳理件	刺辊分梳板	Attached carding segments	Licker-in carding segment	2根(Pieces)
	前固定盖板		Front stationary flats	10根(Pieces)
	后固定盖板		Back stationary flats	10根(Pieces)
棉网清洁器	前3后3	Web cleaner	Front 3, Back 3	纺棉(Cotton)
	前2后2		Front 2, Back 2	纺化纤(Chemical fiber)
连续吸尘风量（立方米/小时）		Continuous air suction volume(m^3/h)		4500
出口静压（帕）		Statistic pressure at exit(Pa)		– 800
压缩空气压力（MPa）		Compressed air pressure (MPa)		0.6 ~ 0.8
空气消耗（立方米/小时）		Compressed air consumption(m^3/h)		0.5
总装机功率（千瓦）		Total power installation(kW)		15.74
安全罩形式		Safety cover type		全封闭 Totally enclosed
外形尺寸（长X宽X高）（毫米）		Overall dimension (L x W x H)(mm)		5800 x 2600 x 3645(mm)
机器净重（公斤）		Machine net weight(kg)		(About)约8000
配套棉箱型号		Matched chute model		JWF1177B
配套圈条器型号		Matched coiler model		FT211