

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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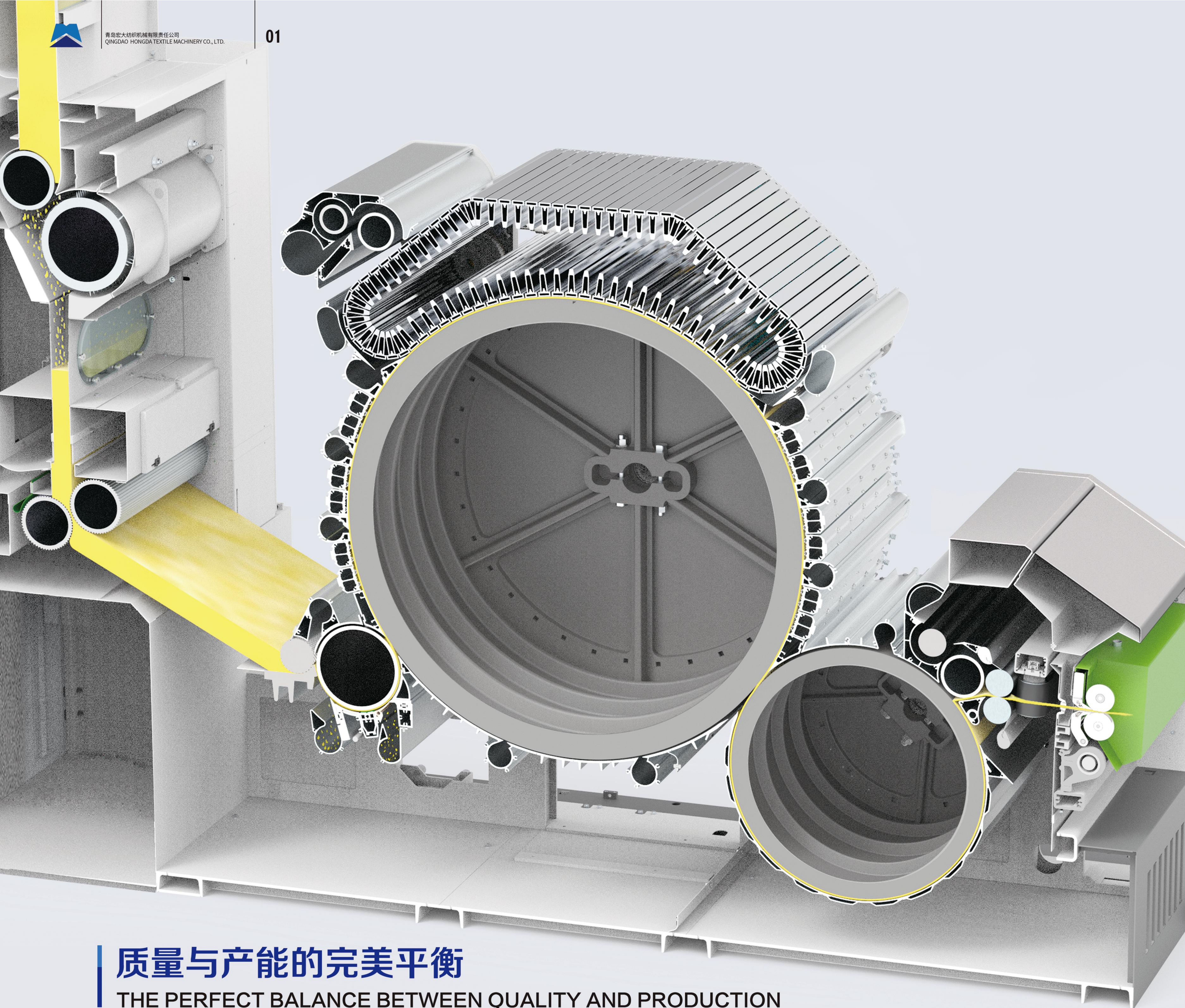


青岛宏大纺织机械有限责任公司
QINGDAO HONGDA TEXTILE MACHINERY CO., LTD.



JWF1215 梳棉机
CARDING MACHINE

创新 | 改变 | 突破 | 成长
INNOVATE | TRANSFORM | BREAKTHROUGH | GROW



质量与产能的完美平衡

THE PERFECT BALANCE BETWEEN QUALITY AND PRODUCTION

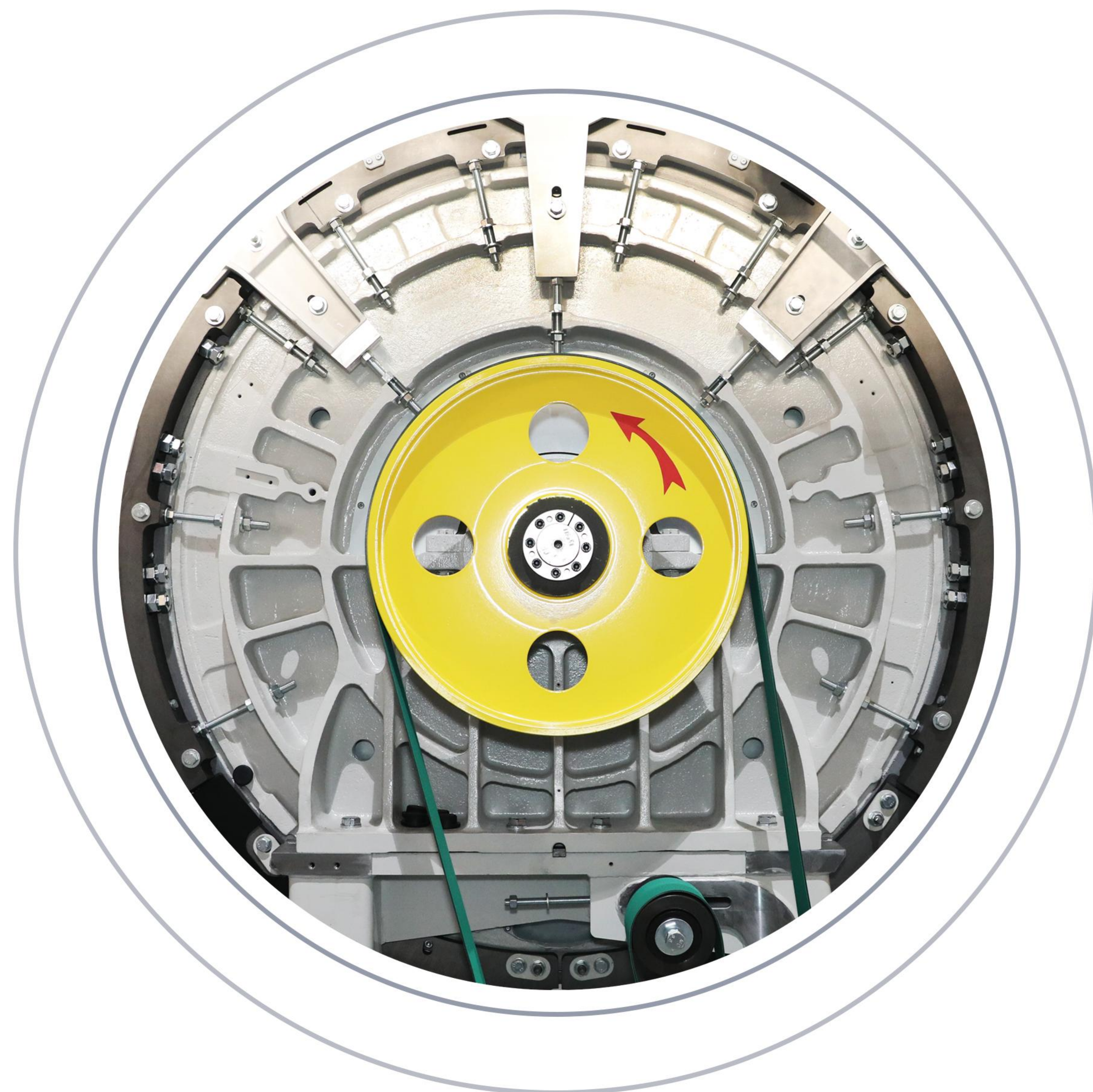


高质
HIGH QUALITY

稳定
STABILITY

高效
HIGH EFFICIENCY

智能
INTELLIGENCE



CARDING MACHINE
JWF1215梳棉机

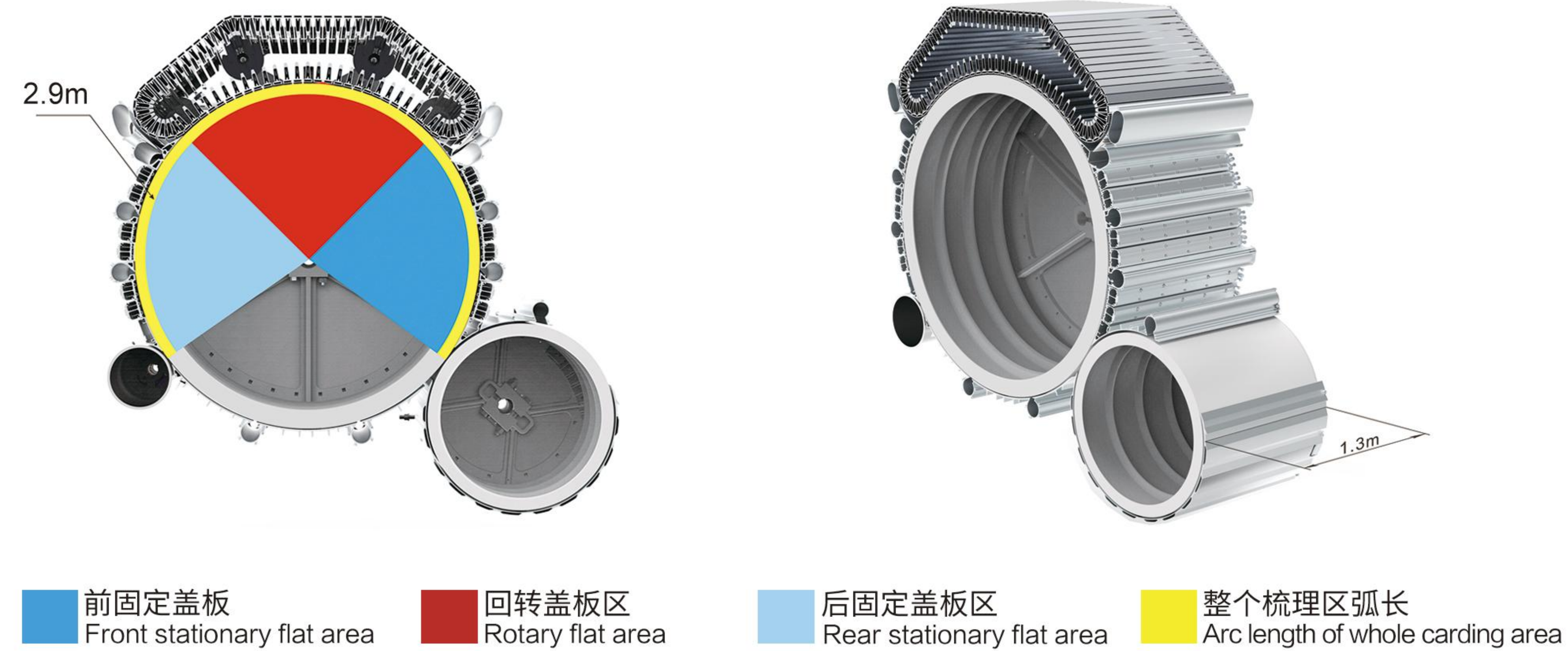
亮点 HIGHLIGHTS

- ★ **2.9米梳理弧长，工作盖板30根，固定盖板前12根、后12根，棉网清洁器前3后3，增强分梳能力。**
2.9 m carding length, 30 rotary flats, 12 front and 12 rear stationary flats, with 3 web cleaners at front and 3 at rear, enhancing the carding efficiency.
- ★ **顺逆向给棉结构可选，满足不同原料和工艺需求；全新三罗拉结构，保证高速高产。**
Optional forward or reverse feeding configuration to meet different raw material and process requirements; brand-new three-roller structure ensures high speed and high productivity.
- ★ **多伺服驱动，控制精准；核心梳理件单独传动，工艺调整灵活。**
Multi servo drive, precise control; drive of key carding elements, flexible adjustment.
- ★ **辅助生头结构，缩短生头时间，提高生产效率。**
Auxiliary piecing structure reduces piecing time and improves production efficiency.
- ★ **智能安全防护。**
Intelligent security protection.
- ★ **在线检测系统。**
On-line detecting system.

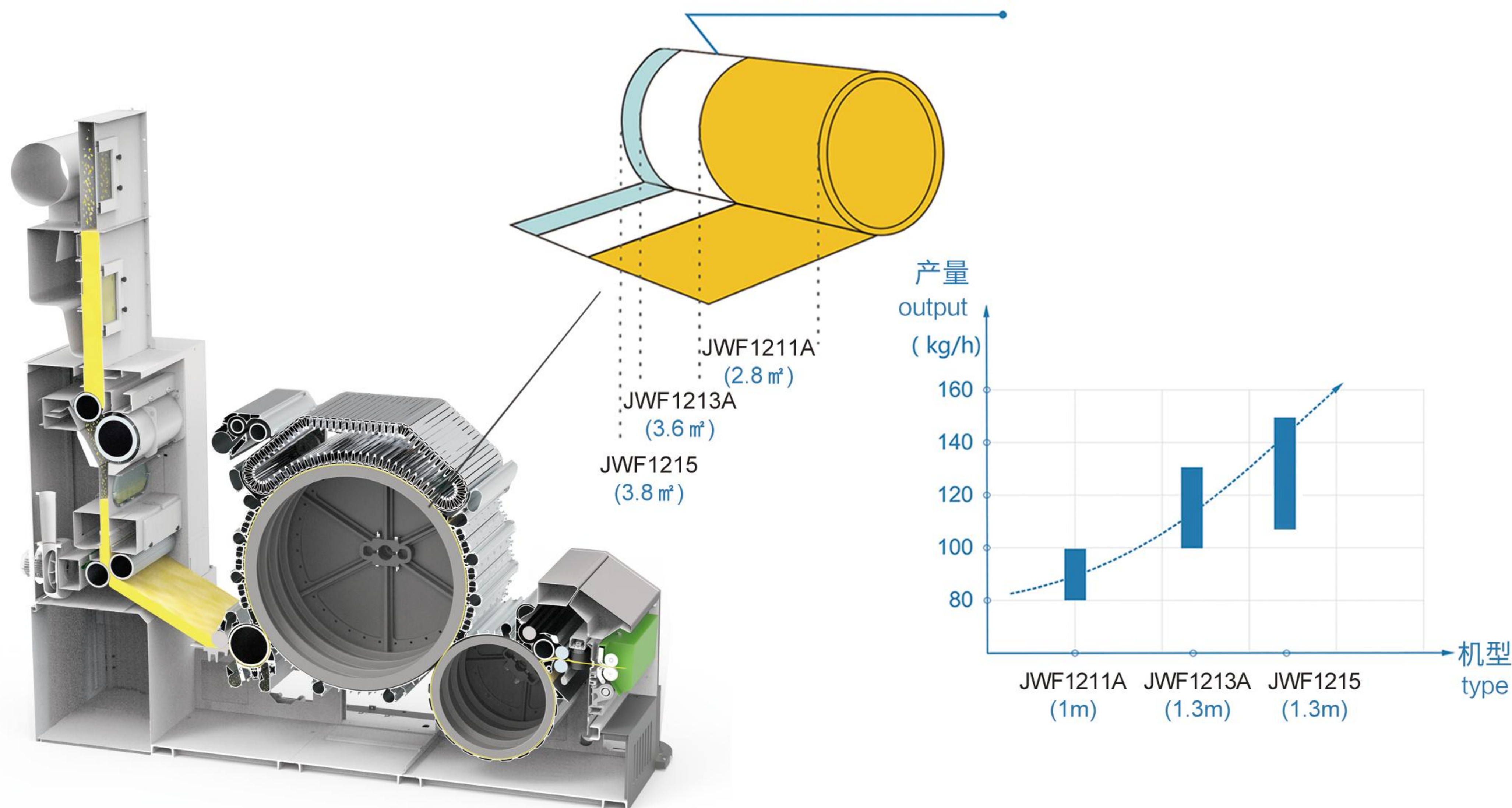
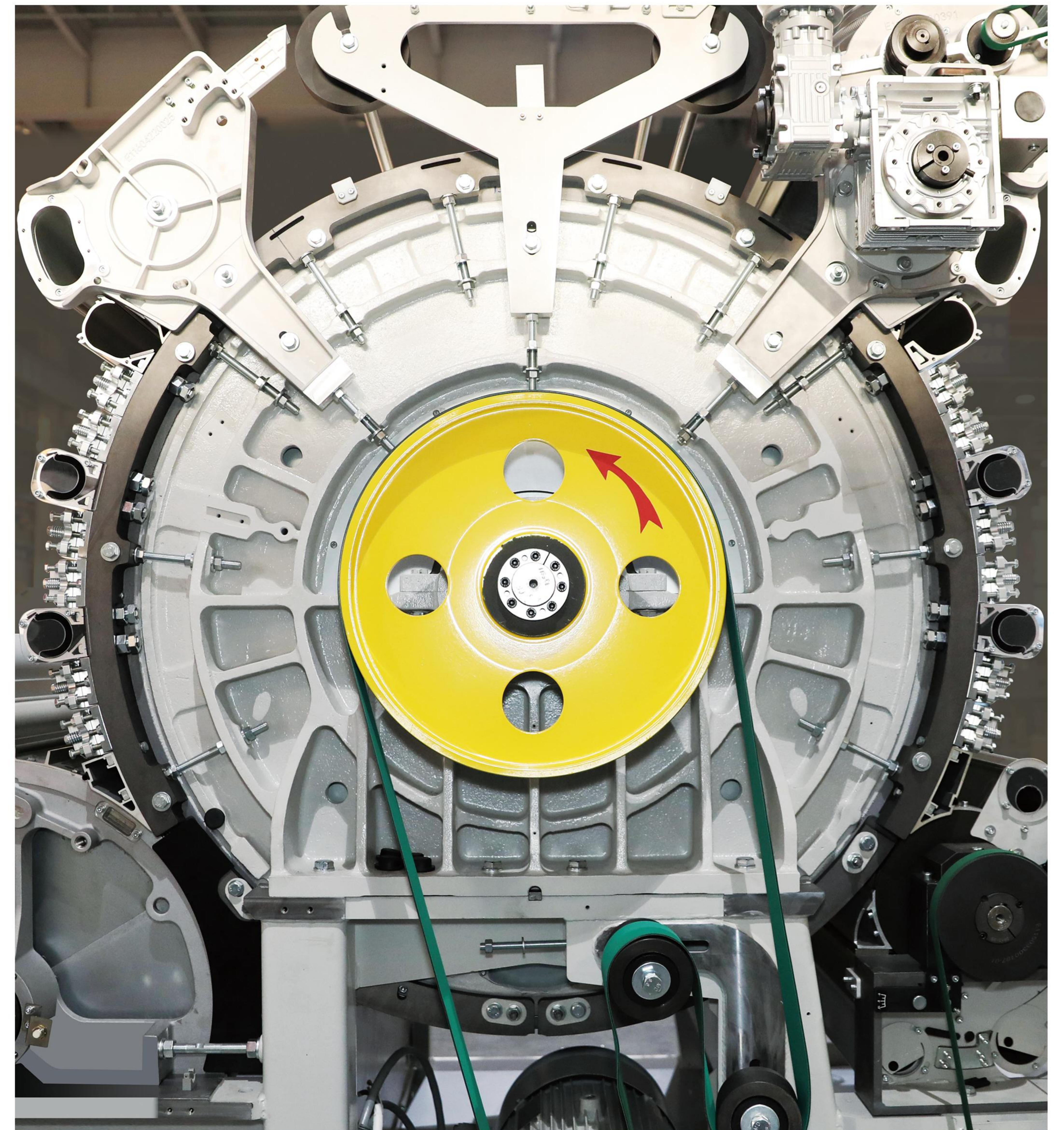


高产高效的分梳系统 >>>

CARDING SYSTEM WITH HIGH CAPACITY AND EFFICIENCY



梳理区面积增加 产量大幅提升
Increased carding area significantly enhances production capacity



► 优化的大梳理区结构设计

Optimized large carding area structure design

梳理区结构优化，使梳理弧长达到2.9m，工作幅宽1.3m，梳理面积3.8m²，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。

Optimized carding area structure extends the carding length to 2.9m. Working width: 1.3 m, Carding area: 3.8 m². 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.



可靠稳定的质量保证 >>>

STABLE AND RELIABLE QUALITY GUARANTEE



铸造锡林 Casting cylinder



铸造道夫 Casting doffer



锡林墙板 Cylinder 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、道夫及锡林墙板，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 cylinder side wall. That ensures the stability and accuracy of the carding technical gauge when running with high speed and high capacity.

> 一体式机架 Integrated frame

一体式钢板焊接整体机架，结构简单、牢固，保证了整机主要部件和隔距的稳定性、一致性。

Integral steel plate welded monolithic frame, with a simple and sturdy structure, ensuring the stability and consistency of the main components and gauge of the entire machine.



一体式机架 Integrated frame



高效的运行系统 >>>

EFFICIENT OPERATING SYSTEM

顺逆向可选的喂入系统

Optional forward/reverse feeding system

- ☆ 可根据不同原料特性，选用顺逆向喂入系统，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。
- ☆ According to different raw material characteristics, a forward or reverse feeding system can be selected to enhance fiber gripping, improve opening and carding performance in the licker-in zone, and increase feeding efficiency.



- ☆ 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。
- ☆ 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

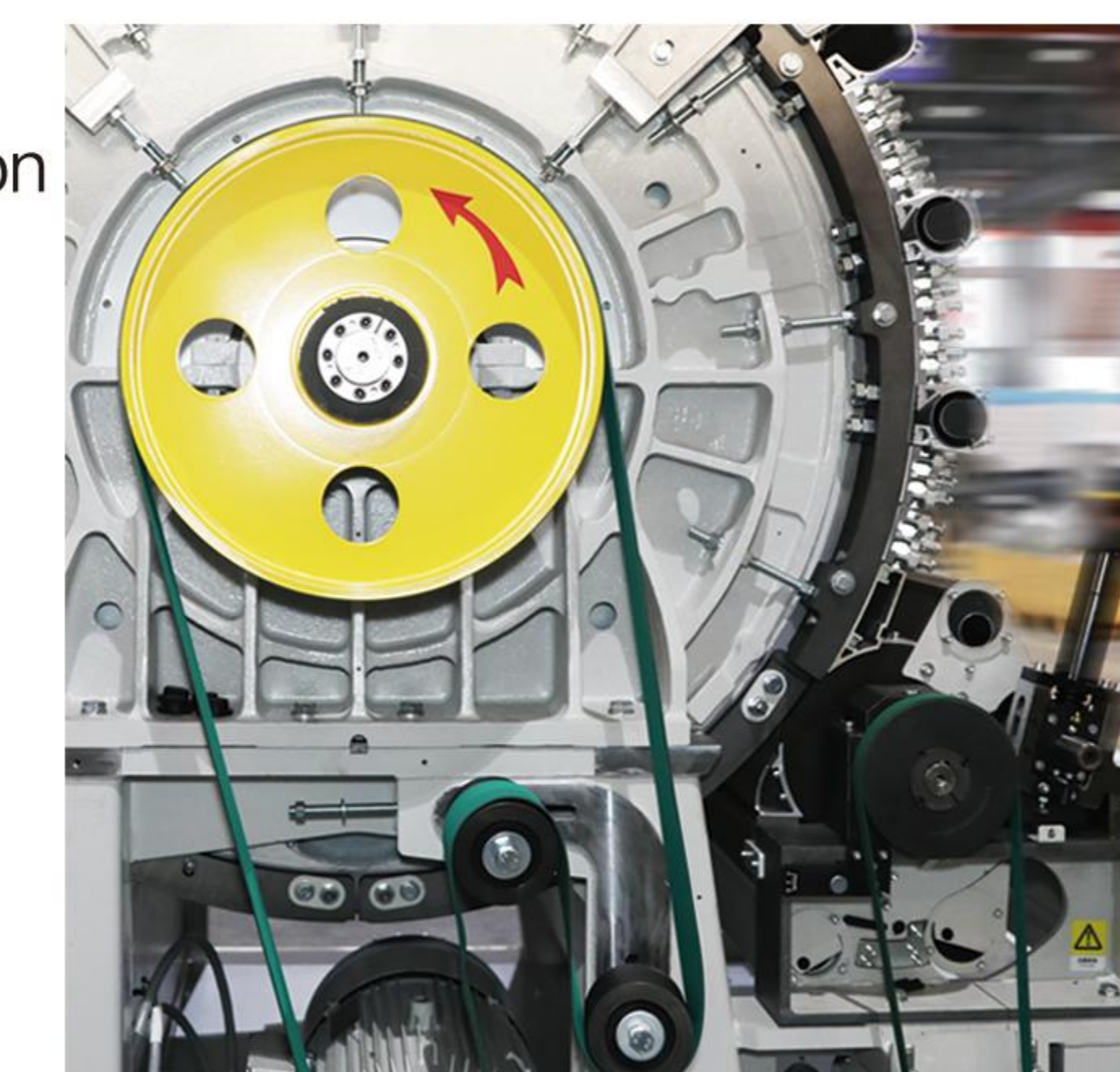
- ☆ 合理布局三罗拉结构，加强结构稳定性，工艺调整灵活，保证了棉网的高速稳定输出；
- ☆ 辅助生头装置，操作简单，节省时间，降低劳动强度和难度。
- ☆ Reasonable layout of three-roller structure, strengthening structure stability, flexible process adjustment, ensuring high-speed and stable output of web;
- ☆ Auxiliary piecing device easy to operate, saving time, reducing labor intensity and difficulty(Optional).



多点单独传动

Multipoint independent transmission

- ☆ 锡林、刺辊、回转盖板采用单独变频传动，工艺速度调整更加灵活、方便。
- ☆ Cylinder, licker-in, rotary flat are all driven by independent inverter motor for more convenient technology adjustment.

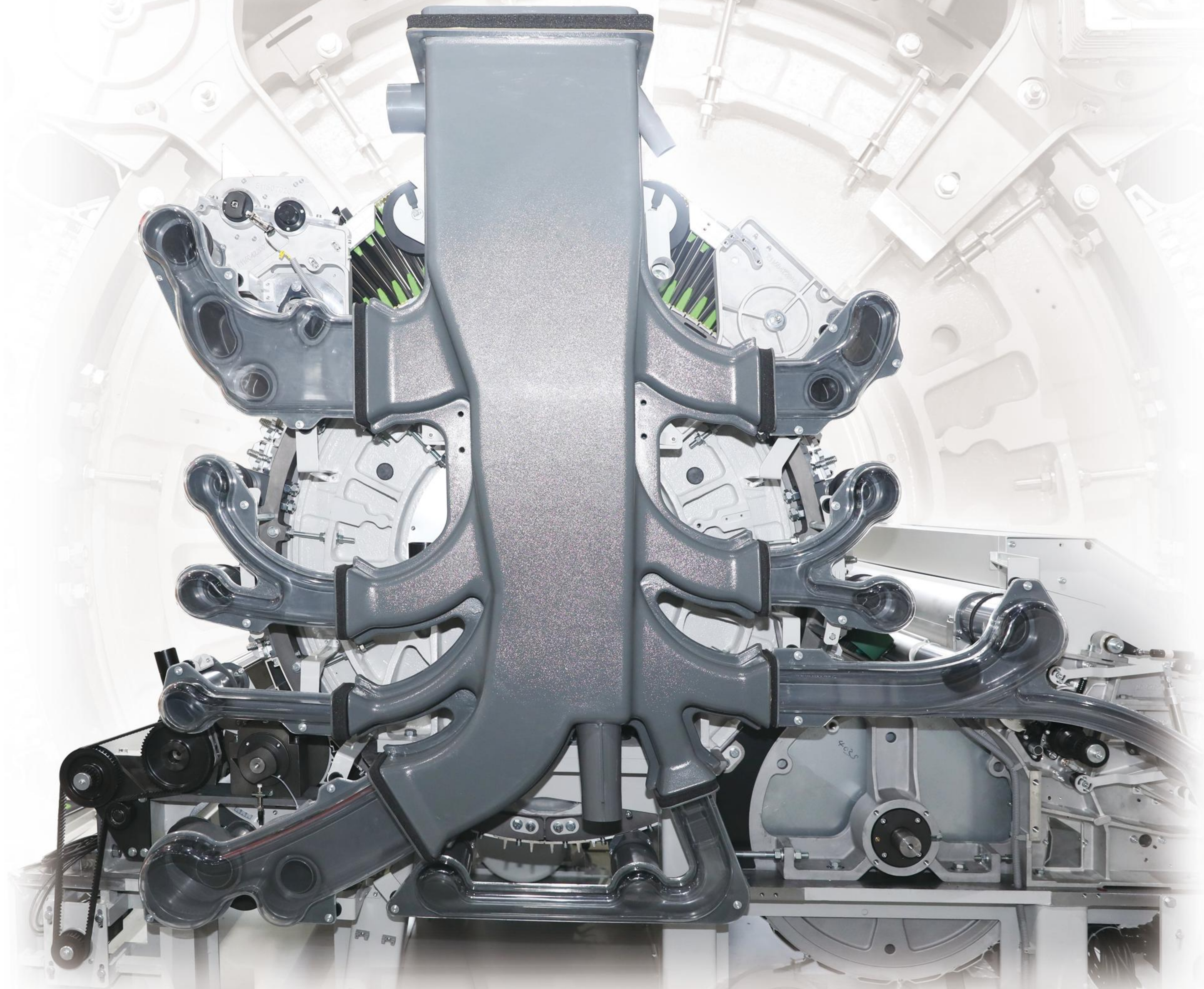


- ☆ 给棉罗拉、大压辊、圈条器、道夫及三罗拉采用单独伺服传动，控制更加精准，适应高速、高产需求。
- ☆ Feeding roller, big calender, doffer and three rollers adopt independent servo drive, more precise control, suitable for high speed and high capacity demand.



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.



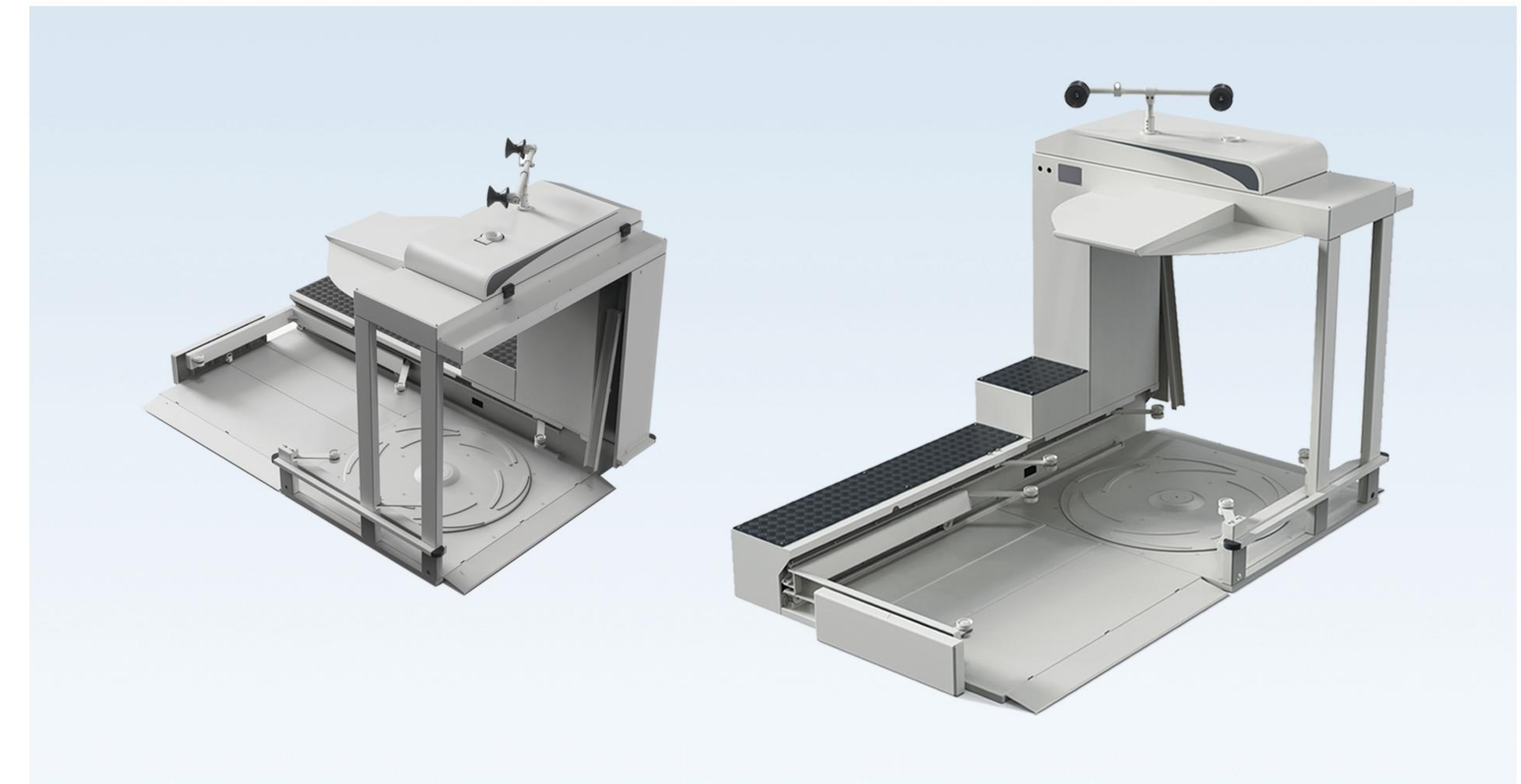
FT211系列圈条器 >>> FT211 SERIES COILER

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 $\phi 1000 \times 1100/1200/1300/1400$ 、 $\phi 1200 \times 1300/1500$ 、 $\phi 800 \times 1100/1200$ 、 $\phi 600 \times 1100/1200$ 棉条筒，直线式自动换筒，伺服电机单独传动。

Suitable for $\phi 1000 \times 1100/1200/1300/1400$ 、 $\phi 1200 \times 1300/1500$ 、 $\phi 800 \times 1100/1200$ 、 $\phi 600 \times 1100/1200$ 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灯带多彩组合显示设备状态；显示屏位置和角度可灵活调节；可灵活呈现不同参数，高效监控设备运行状态。

Adopting a new mode of human-machine interface, RFID technology achieves functions such as process classification, permission unlocking, convenient operation, etc; Multi-color LED light strip combinations are applied to indicate machine operating status; 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，标配金属检测、智能门锁系统；选配锡林接针保护、梳理区温度监控等防护功能，全方位提升梳棉机安全性能。

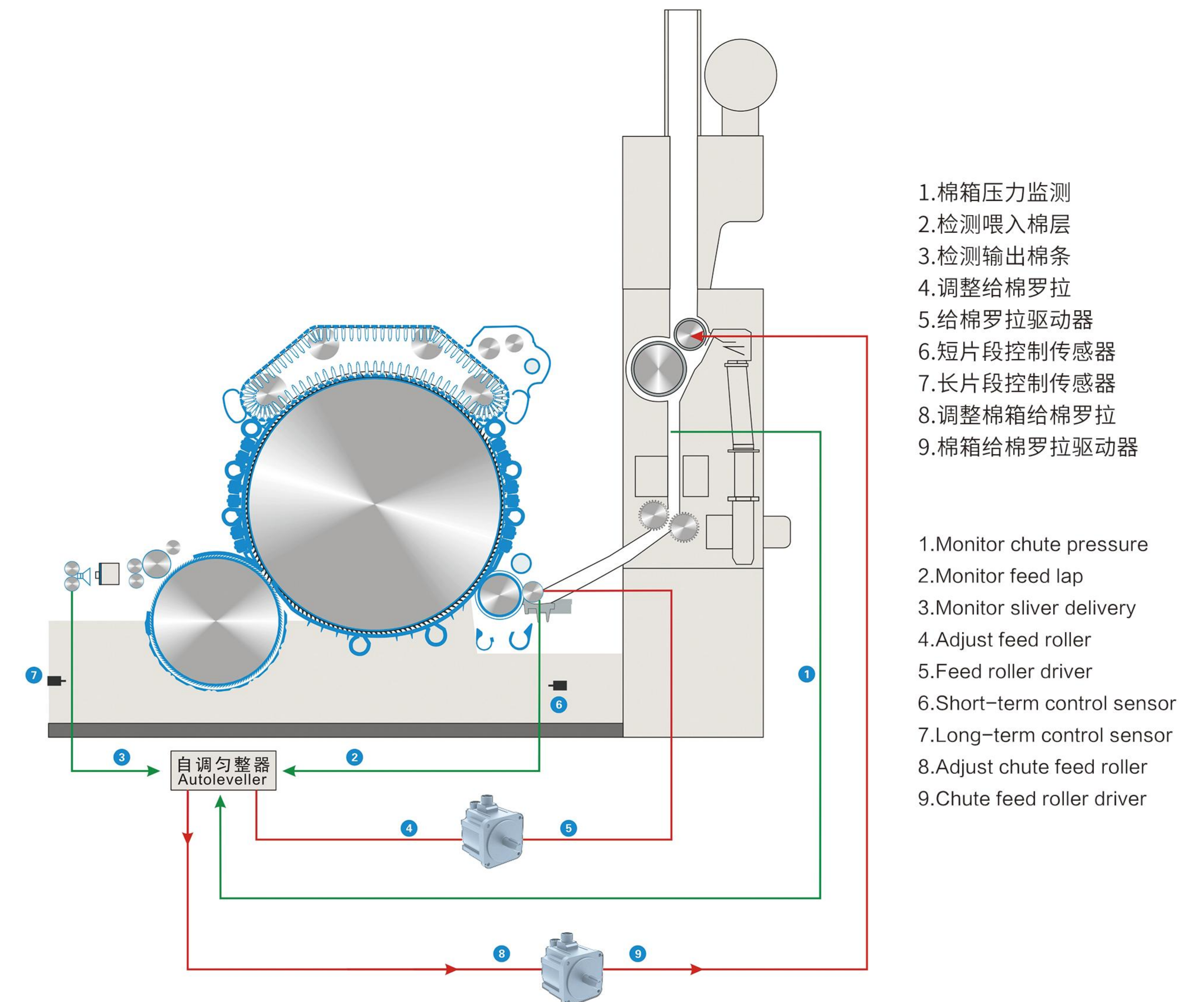
Intelligent protection functions such as cylinder wire touching protection, temperature monitoring in carding area, and metal detection to improve the safety performance of the carding machine in all aspects.

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、棉结、落棉情况，并结合在线闭环调整系统，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 flat gauge, nep level, and waste conditions in real time during machine operation, 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



- ☆ 5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。

- ☆ 5 levelling parameter curves 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 realize the remote monitoring for data and operation status.

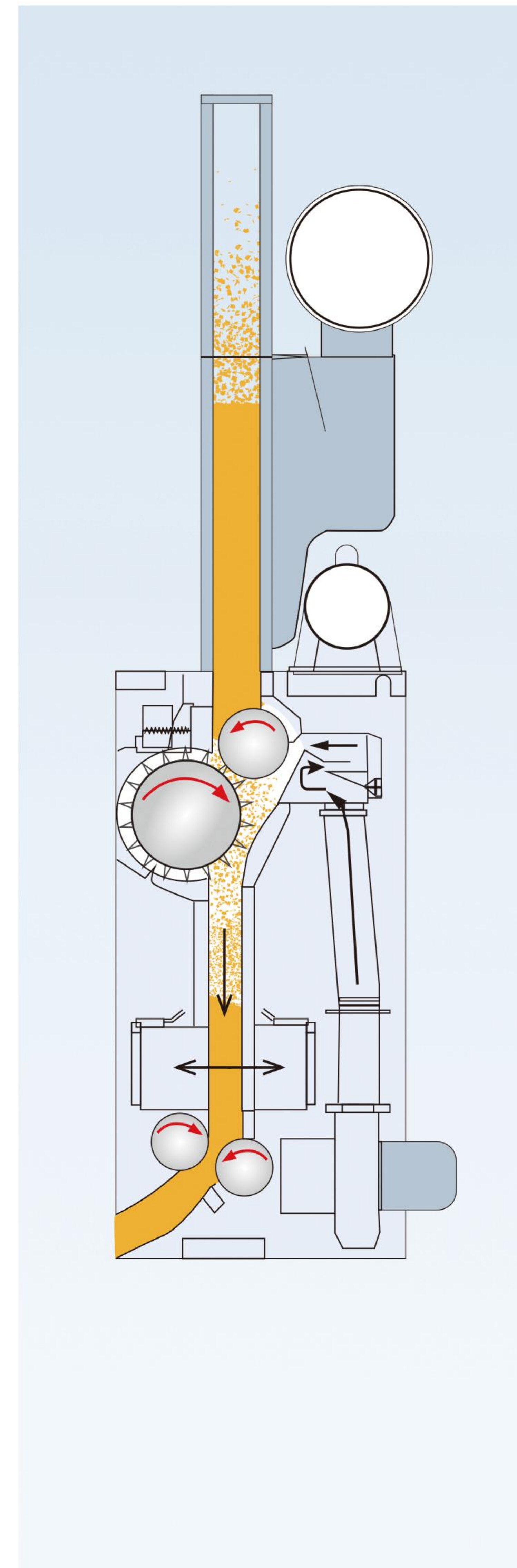


新型一体化棉箱 >>>

NEW TYPE INTEGRATED CHUTE FEEDER



- ☆ 新型棉箱储棉容量大，供棉稳定，有效改善条干均匀度及重量不匀率。配棉头采用开启式视窗，便于维护；
 - ☆ 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。
- ☆ New type of chute feeder, with big capacity, supply cotton stably and improves sliver evenness and weight regularity efficiently. The top chute feeder is equipped with the open-type view-window and easy to maintain;
- ☆ Feeding roller and opening roller covers 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)	about 810





结构示意图 >>>

STRUCTURE FIGURE

主机部分 Carding section

- 01 刺辊第一除尘刀
Licker-in 1st 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

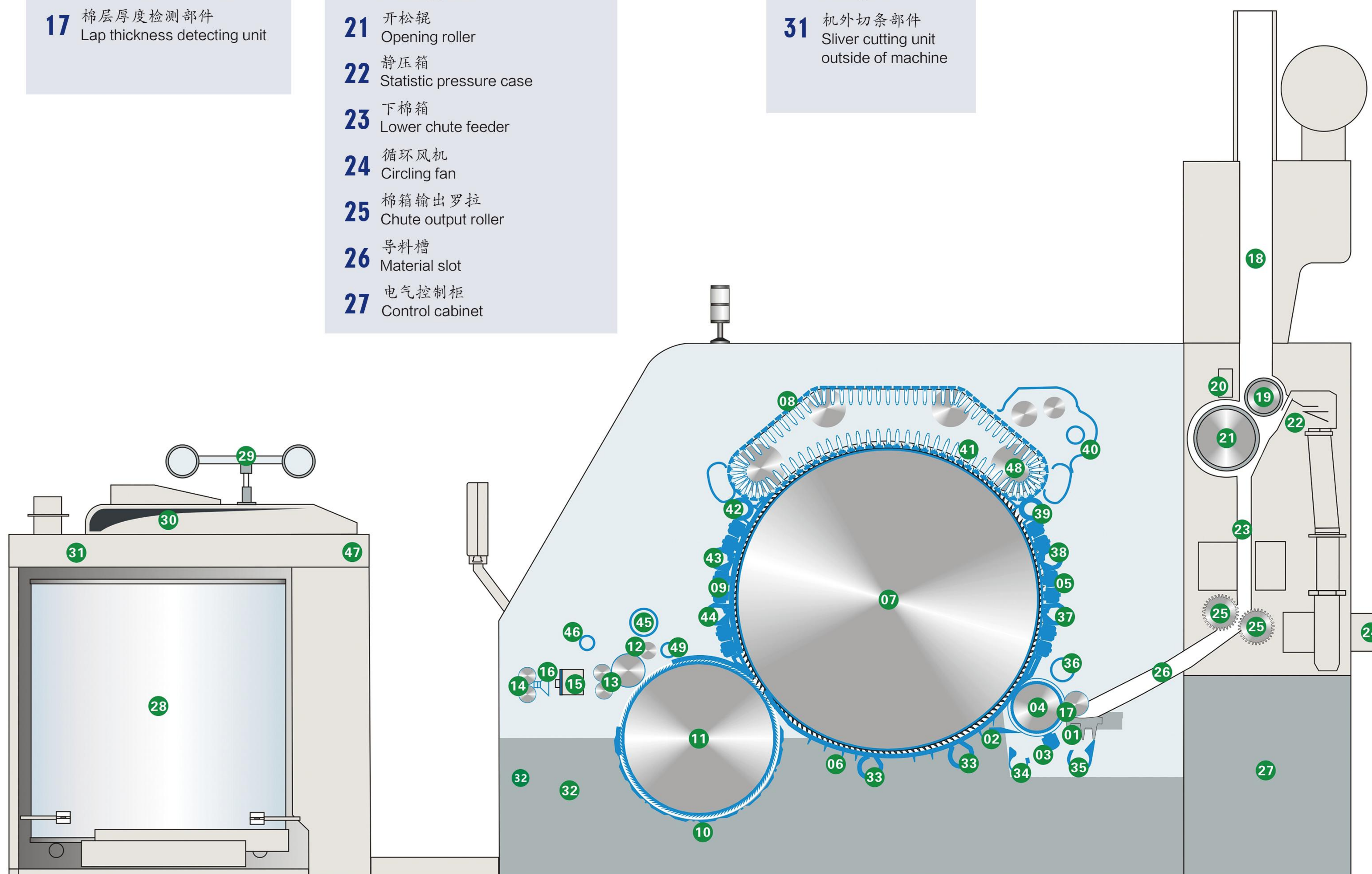
- 18 上棉箱
Upper chute feeder
- 19 给棉罗拉
Feeding roller
- 20 给棉板
Feeding plate
- 21 开松辊
Opening roller
- 22 静压箱
Statistic pressure case
- 23 下棉箱
Lower chute feeder
- 24 循环风机
Circling fan
- 25 棉箱输出罗拉
Chute output roller
- 26 导料槽
Material slot
- 27 电气控制柜
Control cabinet

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

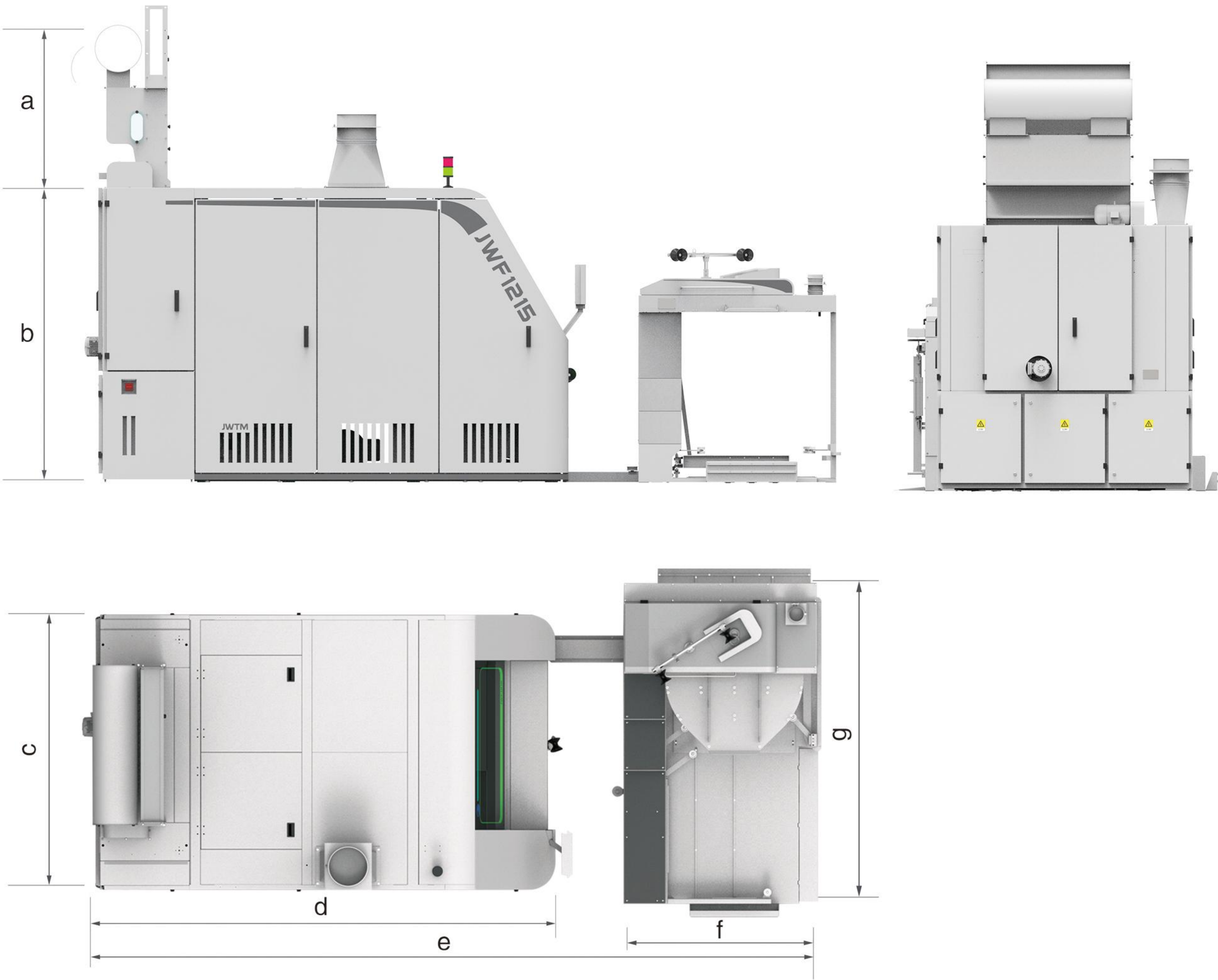
滤尘部分 Dust filtering section

- 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 1st 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
- 49 道夫吸点
Doffer suction points





主要规格 >>> SPECIFICATIONS



机型/Type	a	b	c	d
JWF1215	1395	2250	2150	3590

机型/Type	e	f	g
φ600自动	5100	1100	1610
φ800自动	5495	1310	2030
φ1000自动	5695	1510	2430
φ1200自动	5895	1710	2800



机型		Type		JWF1215
最高产量（公斤/小时）		Max. output (kg/h)		180
最高出条速度（米/分）		Max. sliver delivery speed (meter/min)		360
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)		30/84
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	12根（Pieces）
	后固定盖板		Back stationary flats	12根（Pieces）
棉网清洁剂	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 (m³/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 (m³/h)		0.5
总装机功率（千瓦）		Total power installation (kW)		15.75
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)		5606 x 2600 x 3575(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