

## HY高速假捻变形机(加弹机)

HY High Speed Draw Texturing Machine



### 绍兴华裕纺机有限公司

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This booklet is only for your reference not for any basis of checking and acceptance.

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To keep up with advanced technology we reserve the right to change the specifications without notice.

# 打造国内一流高速加弹机生产基地

Creating the First-class Production Base of High-Speed Bulleting Machine in China

走技术创新为核心、高质量制造为基础的发展道路

Take the Development Path of Technology Innovation as the Core and High Quality  
Manufacturing as the Foundation





## 华裕加弹 加弹专家

*Huayu Draw Texturing, The Expert In The Field*

绍兴华裕纺机有限公司是国家重点高新技术、省专利示范企业。公司遵循技术创新为核心，高质量制造为基础的发展道路，精心制造高品质加弹机。华裕公司主要产品是倍捻机和加弹机。经过多年努力耕耘，华裕设备在市场上赢得了好的口碑，也为华裕公司发展奠定了市场基础。

一流的管理团队，不仅具有敏锐的前瞻性发展策略，更有团结协作、精细管理的丰富的实际管理条例和经验，是华裕的灵魂。专业的技术队伍，既有多年从事加弹机研发的老专家，也有年青有为的技术新兵。技术研发专业、创新活力强劲，是华裕创新的核心。

一丝不苟的质量管理体系，确保从外协采购到自制生产，都在公司严密的质量监控之中，严格的质量管理是华裕品质的保证。

Shaoxing Huayu Textile Machinery Co., Ltd. is a national key high-tech and provincial patent demonstration enterprise. Its main products are two-for-one twisting machine series and high speed draw texturing machine series. After years of hard work, the company's products has won a good reputation in the market and laid the market foundation for the company's development. Our company follows the development path of taking technology innovation as the core and high quality manufacturing as the foundation, and manufactures the high quality draw texturing machines elaborately. The first-class management team not only has the sharp forward-looking development strategy, but also has the rich practical management regulations and experience of unity, coordination and fine management, which is the soul of Huayu. Professional technical team, not only includes senior experts who have been engaged in the R & D of draw texturing machine for many years, but the young promising technical recruits. The core of Huayu's innovation lies in its professional technology R & D and the strong innovation vitality. The meticulous quality management system ensures the company's strict quality control from outsourcing procurement to self-production. Strict quality management is the guarantee of Huayu's quality.

### 【公司拥有多项加弹机技术的发明、实用新型专利】

- ◇ 丝道改良的加弹机
- ◇ 上加热箱丝道改良的加弹机
- ◇ 三轴盘式假捻器优化方法及其优化结构
- ◇ 加弹机传动轴优化的方法及其结构
- ◇ 加弹机上油轴传动优化的方法及其结构
- ◇ 组合式陶瓷假捻盘
- ◇ 微孔假捻盘

### [The company has a number of invention and utility model patents for the technology of the draw texturing machine]

- ◇ Yarn path improved draw texturing machine
- ◇ Up heater yarn path improved draw texturing machine
- ◇ Optimization method and the optimized structure of tri-axial false twister
- ◇ Optimization method and the optimized structure of drive shaft of draw texturing machine
- ◇ Optimization method and the optimized structure of oiling shaft of draw texturing machine
- ◇ Modular ceramic disc for false twister
- ◇ Microvoid disc for false twister





# HYD-1000V

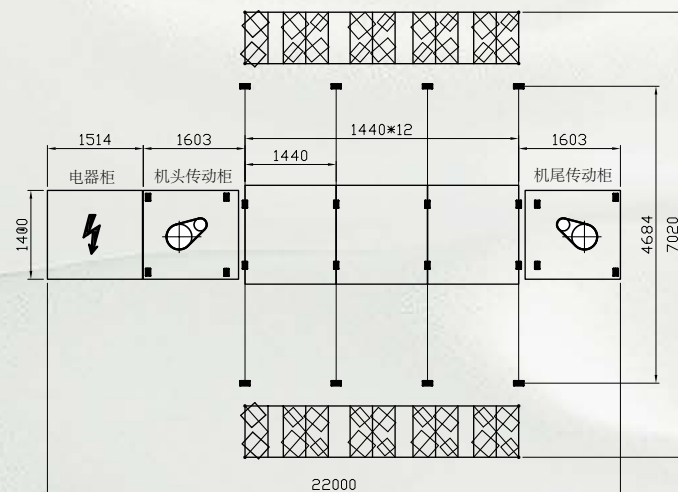
## 涤纶机Polyester DTY machine



### 【设备用途Equipment use】

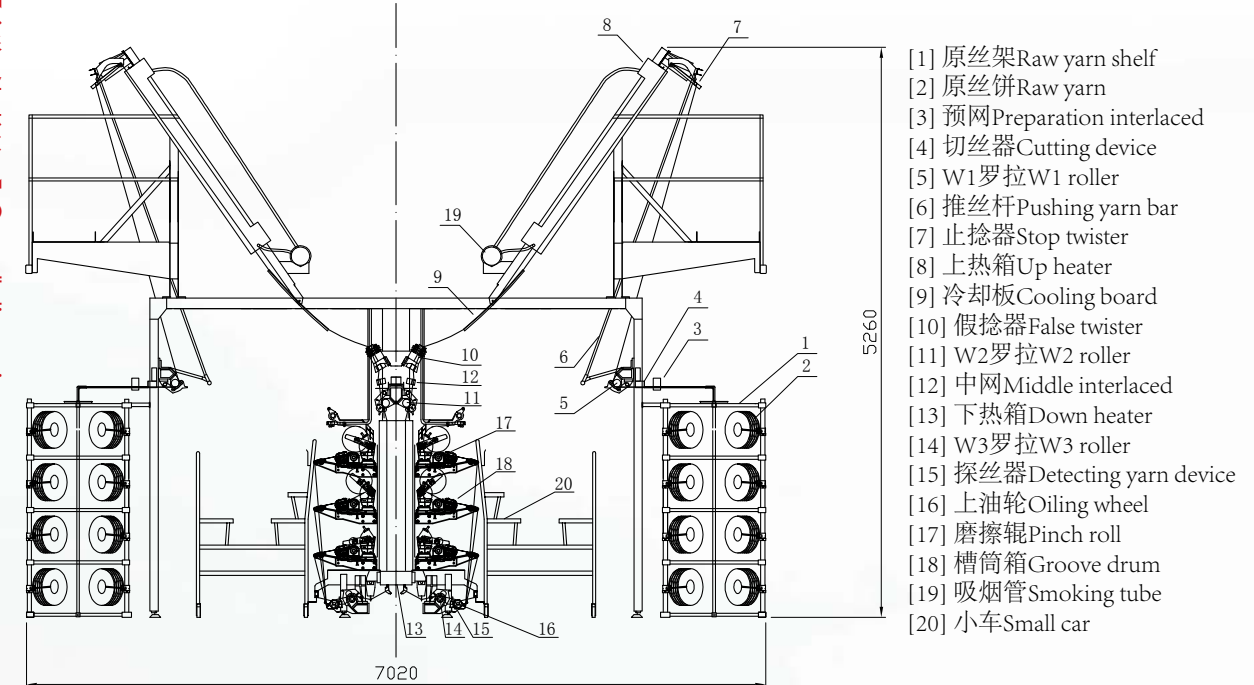
该机主要是将POY原丝(聚酯预取向丝)，通过拉伸和假捻变形加工成具有低弹性性能的假捻变形丝(DTY涤纶弹力丝)，若在设备上选择增加网络部件还可以进行网络丝的加工  
This machine mainly uses the POY yarn(Pre-Oriented Yarn) through stretching and false twisting deformation, processed into low elastic or high elastic false twisting texturing yarn(DTY), the machine can produce intermingle yarn if equipped with an optional interlaced nozzle.

### 【安装地脚图】 Foundation bolt drawing



节数	12	13	14	15
总长	22000	23440	24880	26320

### 【外形尺寸示意图】 Overall dimension



- [1] 原丝架Raw yarn shelf
- [2] 原丝饼Raw yarn
- [3] 预网Preparation interlaced
- [4] 切丝器Cutting device
- [5] W1罗拉W1 roller
- [6] 推丝杆Pushing yarn bar
- [7] 止捻器Stop twister
- [8] 上热箱Up heater
- [9] 冷却板Cooling board
- [10] 假捻器False twister
- [11] W2罗拉W2 roller
- [12] 中网Middle interlaced
- [13] 下热箱Down heater
- [14] W3罗拉W3 roller
- [15] 探丝器Detecting yarn device
- [16] 上油轮Oiling wheel
- [17] 磨擦辊Pinch roll
- [18] 槽筒箱Groove drum
- [19] 吸烟管Smoking tube
- [20] 小车Small car

### 【主要技术参数】 The Main Technical Parameters

锭数 Spindle	288锭Spindles	312锭Spindles	336锭Spindles	360锭Spindles	
节数Section	12	13	14	15	
锭距Spindle pitch	110mm				
最高机械速度Highest Mechanical Speed	1000m/min				
加工纤度范围Denier of fiber	聚酯55-222dtex(50-200Denier)/ polyester 55-222dtex(50-200Denier)				
节距Section Size	1440mm				
假捻方式False twist way	叠盘式VIII型假捻器/Type 8 disc friction unit				
假捻方向False twist direction	S,Z可调/S,Z adjustable				
第一热箱(变形The first heat box (distortion))	联苯气相加热/2000mm biphenyl gas phase heating/2000mm				
第二热箱(定型The second heat box (figuration))	联苯气相加热/1460mm biphenyl gas phase heating/1460mm				
冷却方式及长度Cooling mode and length	冷却板自然冷却/1100mm cooling rail to cool naturally/1100mm				
摩擦辊直径Friction drum diameter	Φ100mm				
罗拉直径Roller diameter	Φ75mm				
上油罗拉直径Oiling roller diameter	Φ75mm				
原丝最大尺寸Largest original yarn size	Φ435x250mm				
最大卷装尺寸Maximum take-up size	Φ250x250mm				
装机功率分类 Total power (kw)	传动 Drive	97	105	112	1112
	上热箱 Up heat box	81.6	88.4	95.2	102
	下热箱 Below heat box	28.8	31.2	33.6	36
	辅助功率 Assist power	≈6	≈6	≈6	≈6
	总功率 Total power	213.4	230.6	245.8	256



# HYD-1000VAF

## 涤纶包覆一体机

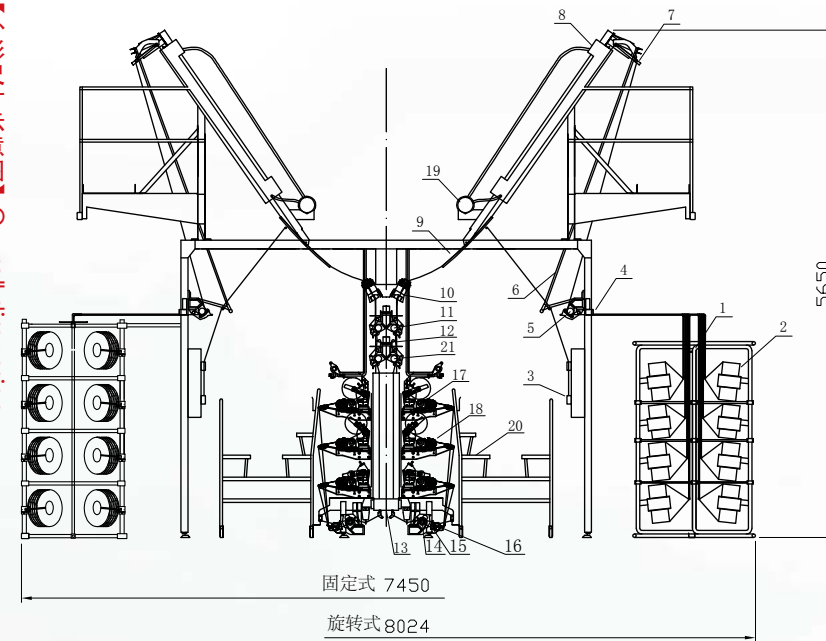
### DTY+Spandex Air Covering machine



#### 【设备用途Equipment use】

该机主要是将POY原丝(聚酯预取向丝)，通过拉伸和假捻变形加工成具有低弹性能的假捻变形丝(DTY涤纶弹力丝)，同时在机器上直接将氨纶丝与DTY丝复合，通过网络喷嘴，实现加弹与氨纶网络一步加工。  
The machine mainly processes POY raw yarn (polyester yarn) into DTY polyester stretch yarn with low elasticity through stretching and false twist deformation. At the same time, polyurethane fiber and DTY yarn are directly combined on the machine. Through the air covering nozzle, one-step processing of spandex-polyester air covering is realized.

【外形尺寸示意图】 Overall dimension

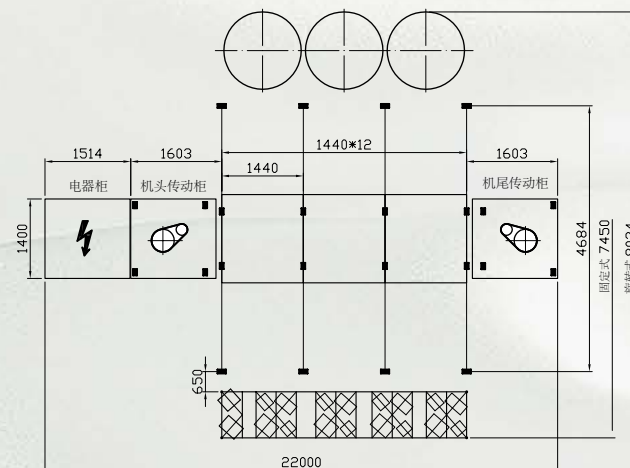


- [1] 原丝架Raw yarn shelf
- [2] 原丝饼Raw yarn
- [3] 氨纶喂入Spandex feeding device
- [4] 切丝器Cutting device
- [5] W1罗拉W1 roller
- [6] 推丝杆Pushing yarn bar
- [7] 止捻器Stop twister
- [8] 上热箱Up heater
- [9] 冷却板Cooling board
- [10] 假捻器False twister
- [11] W2罗拉W2 roller
- [12] 中网Middle interlaced
- [13] 下热箱Down heater
- [14] W3罗拉W3 roller
- [15] 探丝器Detecting yarn device
- [16] 上油轮Oiling wheel
- [17] 摩擦辊Pinch roll
- [18] 槽筒箱Groove drum
- [19] 吸烟管Smoking tube
- [20] 小车Small car
- [21] W2.2罗拉W2.2 roller

#### 【主要技术参数】 The Main Technical Parameters

锭数 Spindle	240锭Spindles	264锭Spindles	288锭Spindles	312锭Spindles	
节数Section	10	11	12	13	
锭距Spindle pitch	110mm				
最高机械速度Highest Mechanical Speed	1000m/min				
加工纤度范围Denier of fiber	聚酯55-222dtex(50-200Denier)/ polyester 55-222dtex(50-200Denier)				
节距Section Size	1440mm				
假捻方式False twist way	叠盘式VIII型假捻器 /Type 8 disc friction unit				
假捻方向False twist direction	S,Z可调/S,Z adjustable				
第一热箱(变形The first heat box (distortion)	联苯气相加热/2000mm biphenyl gas phase heating/2000mm				
第二热箱(定型The second heat box (figuration)	联苯气相加热/1460mm biphenyl gas phase heating/1460mm				
冷却方式及长度Cooling mode and length	冷却板自然冷却/1100mm cooling rail to cool naturally/1100mm				
摩擦辊直径Friction drum diameter	Φ100mm				
罗拉直径Roller diameter	Φ75mm				
上油罗拉直径Oiling roller diameter	Φ75mm				
原丝最大尺寸Largest original yarn size	Φ435x250mm				
最大卷装尺寸Maximum take-up size	Φ250x250mm				
装机功率分类 Total power (kw)	传动 Drive	117.6	118.6	119	134.8
	上热箱 Up heat box	81.6	88.4	95.2	102
	下热箱 Below heat box	28.8	31.2	33.6	36
	辅助功率 Assist power	≈6	≈6	≈6	≈6
	总功率 Total power	234	224.2	254.3	278.5

【安装地脚图】 Foundation bolt drawing



节数	10	11	12	13
总长	19120	20560	22000	23440



# HYD-1000V-D1

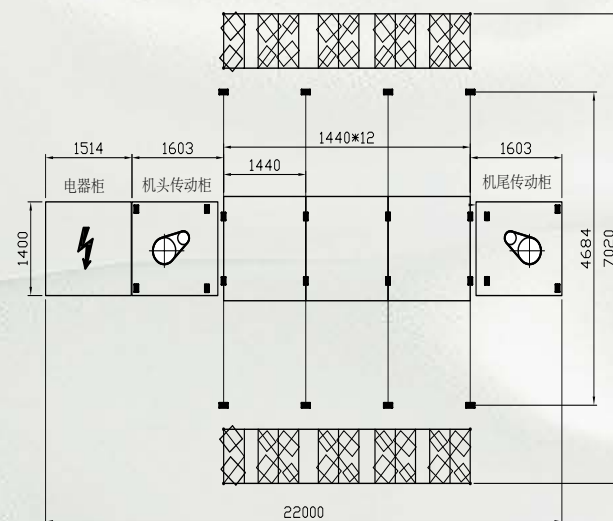
## 涤纶机 Polyester DTY machine



### 【设备用途Equipment use】

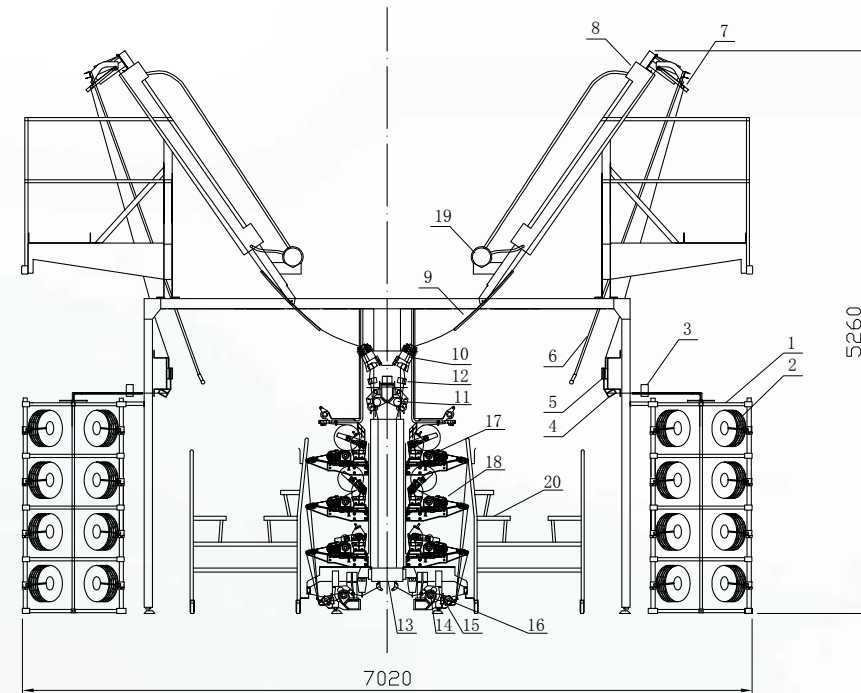
该机主要是将POY原丝(聚酯预取向丝)，通过拉伸和假捻变形加工成具有低弹性能的假捻变形丝(DTY涤纶弹力丝)，若在设备上选择增加网络部件还可以进行网络丝的加工。  
This machine mainly uses the POY yarn(Pre-Oriented Yarn) through stretching and false twisting deformation, processed into low elastic or high elastic false twisting texturing yarn(DTY), the machine can produce intermingle yarn if equipped with an optional interlaced nozzle.

### 【安装示意图】 Foundation bolt drawing



节数	12	13	14	15
总长	22000	23440	24880	26320

### 【外形尺寸示意图】 Overall dimension



- [1] 原丝架Raw yarn shelf
- [2] 原丝饼Raw yarn
- [3] 预网Preparation interlaced
- [4] 切丝器Cutting device
- [5] D1罗拉D1 roller
- [6] 推丝杆Pushing yarn bar
- [7] 止捻器Stop twister
- [8] 上热箱Up heater
- [9] 冷却板Cooling board
- [10] 假捻器False twister
- [11] W2罗拉W2 roller
- [12] 中网Middle interlaced
- [13] 下热箱Down heater
- [14] W3罗拉W3 roller
- [15] 探丝器Detecting yarn device
- [16] 上油轮Oiling wheel
- [17] 摩擦辊Pinch roll
- [18] 槽筒箱Groove drum
- [19] 吸烟管Smoking tube
- [20] 小车Small car

### 【主要技术参数】 The Main Technical Parameters

锭数 Spindle	288锭Spindles	312锭Spindles	336锭Spindles	360锭Spindles	
节数Section	12	13	14	15	
锭距Spindle pitch	110mm				
最高机械速度Highest Mechanical Speed	1000m/min				
加工纤度范围Denier of fiber	聚酯55-222dtex(50-200Denier)/ polyester 55-222dtex(50-200Denier)				
节距Section Size	1440mm				
假捻方式False twist way	叠盘式VIII型假捻器 /Type 8 disc friction unit				
假捻方向False twist direction	S,Z可调/S,Z adjustable				
第一热箱(变形The first heat box (distortion)	联苯气相加热/2000mm biphenyl gas phase heating/2000mm				
第二热箱(定型The second heat box (figuration)	联苯气相加热/1460mm biphenyl gas phase heating/1460mm				
冷却方式及长度Cooling mode and length	冷却板自然冷却/1100mm cooling rail to cool naturally/1100mm				
摩擦辊直径Friction drum diameter	Φ100mm				
罗拉直径Roller diameter	Φ75mm				
上油罗拉直径Oiling roller diameter	Φ75mm				
原丝最大尺寸Largest original yarn size	Φ435x250mm				
最大卷装尺寸Maximum take-up size	Φ250x250mm				
装机功率分类 Total power (kw)	传动 Drive	100.5	109.5	117.5	118.5
	上热箱 Up heat box	81.6	88.4	95.2	102
	下热箱 Below heat box	28.8	31.2	33.6	36
	辅助功率 Assist power	≈6	≈6	≈6	≈6
	总功率 Total power	216.9	235.1	251.3	262.5



# HYD-1000V-S

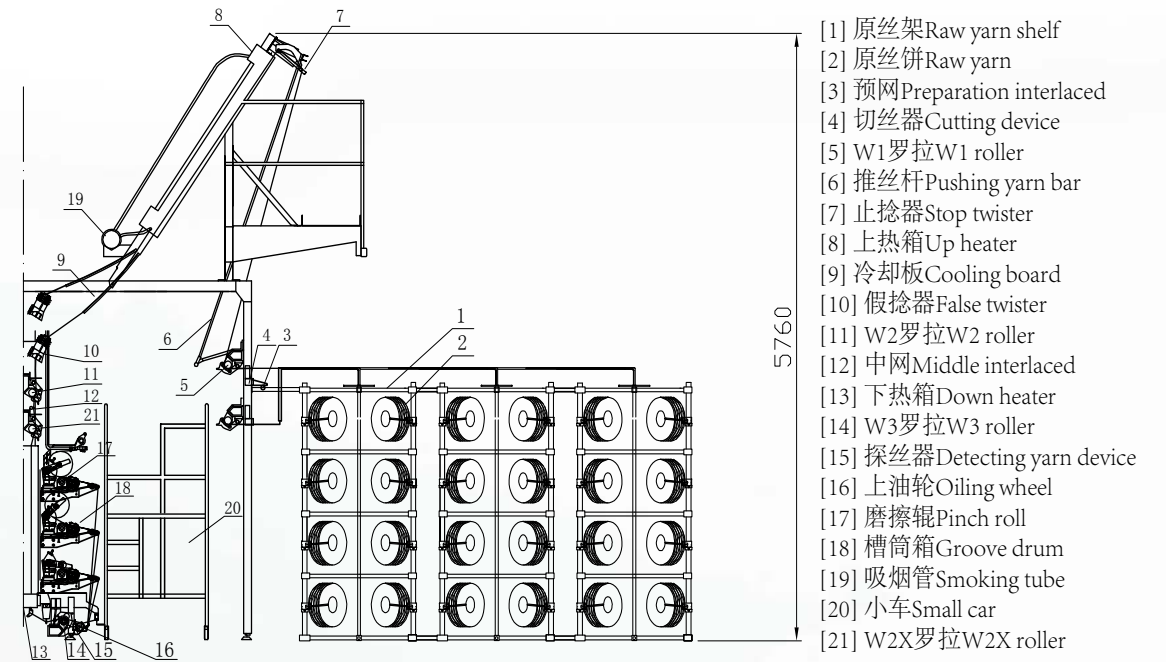
## 涤纶机 Polyester DTY machine



### 【设备用途Equipment use】

该机主要是将POY原丝(聚酯预取向丝)，通过拉伸和假捻变形加工成具有低弹性能的假捻变形丝(DTY涤纶弹力丝)，加工时在每个锭位将S捻和Z捻的双丝合股直接一步加工成无剩余扭矩丝，相对于单锭生产后合股，该机产量增加一倍。  
The machine is mainly use POY yarn, through stretching and false twisting deformation, processed into a low false twist textured yarn (DTY), every spindle can produce S twist and Z twist, the S yarn and the Z yarn can be completed directly by one spindle

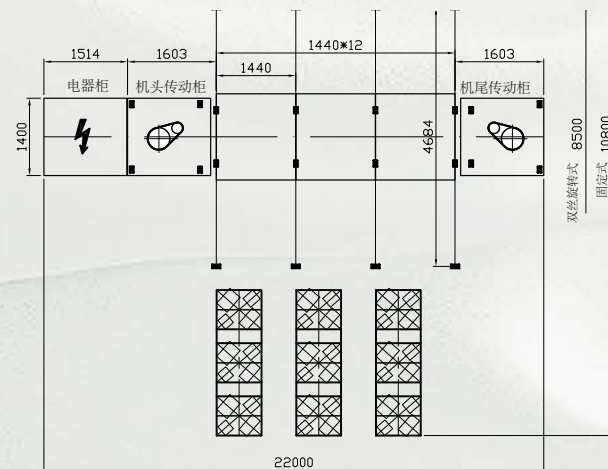
【外形尺寸示意图】 Overall dimension



### 【主要技术参数】 The Main Technical Parameters

锭数 Spindle	240锭Spindles	264锭Spindles	288锭Spindles	312锭Spindles	
节数Section	10	11	12	13	
锭距Spindle pitch	110mm				
最高机械速度Highest Mechanical Speed	1000m/min				
加工纤度范围Denier of fiber	聚酯55-222dtex(50-200Denier)/ polyester 55-222dtex(50-200Denier)				
节距Section Size	1440mm				
假捻方式False twist way	双层电锭叠盘式假捻器Double layer electric spindle stack disk false twister				
假捻方向False twist direction	S,Z可调/S,Z adjustable				
第一热箱(变形The first heat box (distortion))	联苯气相加热/2000mm biphenyl gas phase heating/2000mm				
第二热箱(定型The second heat box (figuration))	联苯气相加热/1460mm biphenyl gas phase heating/1460mm				
冷却方式及长度Cooling mode and length	冷却板自然冷却/1100mm cooling rail to cool naturally/1100mm				
摩擦辊直径Friction drum diameter	Φ100mm				
罗拉直径Roller diameter	Φ75mm				
上油罗拉直径Oiling roler diameter	Φ75mm				
原丝最大尺寸Largest original yarn size	Φ435x250mm				
最大卷装尺寸Maximum take-up size	Φ250x250mm				
装机功率分类 Total power (kw)	传动 Drive	171.4	180	200.6	209.3
	上热箱 Up heat box	68	74.8	81.6	88.4
	下热箱 Below heat box	24	26.4	28.8	31.2
	辅助功率 Assist power	≈6	≈6	≈6	≈6
	总功率 Total powe	269.4	287.2	317	334.9

【安装地脚图】 Foundation bolt drawing



节数	10	11	12	13
总长	19120	20560	22000	23440



# HYD-1000V-W0

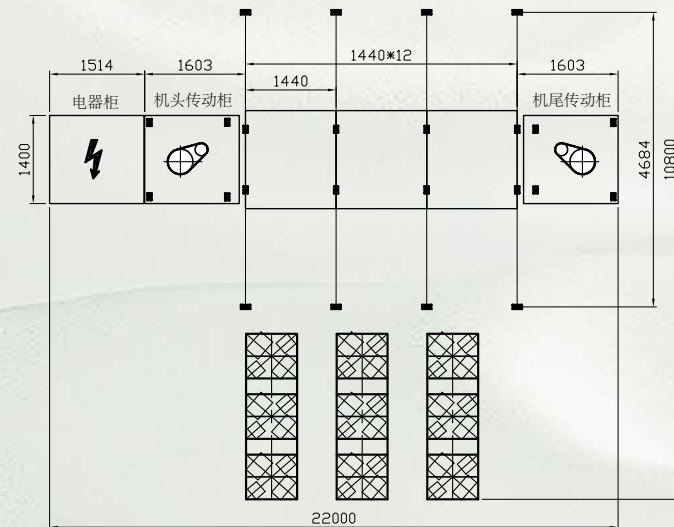
涤纶机 Polyester DTY machine  
仿棉丝 Imitation cotton silk



### 【设备用途 Equipment use】

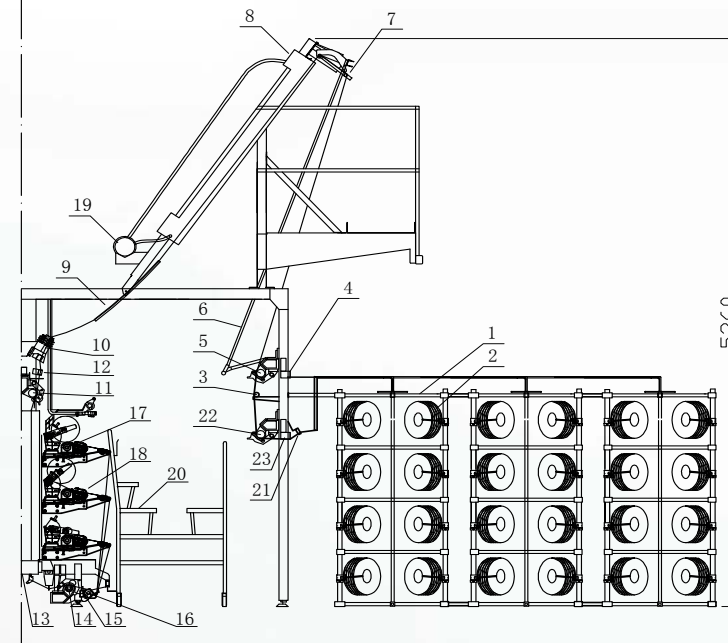
该机主要是将POY原丝(聚酯预取向丝)，通过拉伸和假捻变形加工成具有低弹性能的假捻变形丝(DTY涤纶弹力丝)，若在设备上选择增加网络部件还可以进行网络丝的加工，加入FDY丝可以合股。  
This machine mainly uses the POY yarn (Pre-Oriented Yarn) through stretching and false twisting deformation, processed into low elastic or high elastic false twisting texturing yarn (DTY), the machine can produce intermingle yarn if equipped with an optional interlaced nozzle.

### 【安装示意图】 Foundation bolt drawing



节数	12	13	14	15
总长	22000	23440	24880	26320

### 【外形尺寸示意图】 Overall dimension



- [1] 原丝架 Raw yarn shelf
- [2] 原丝饼 Raw yarn
- [3] 预网 Preparation interlaced
- [4] 切丝器 Cutting device
- [5] W1罗拉 W1 roller
- [6] 推丝杆 Pushing yarn bar
- [7] 止捻器 Stop twister
- [8] 上热箱 Up heater
- [9] 冷却板 Cooling board
- [10] 假捻器 False twister
- [11] W2罗拉 W2 roller
- [12] 中网 Middle interlaced
- [13] 下热箱 Down heater
- [14] W3罗拉 W3 roller
- [15] 探丝器 Detecting yarn device
- [16] 上油轮 Oiling wheel
- [17] 磨擦辊 Pinch roll
- [18] 槽筒箱 Groove drum
- [19] 吸烟管 Smoking tube
- [20] 小车 Small car
- [21] W0探丝器 W0 Detecting yarn device
- [22] W0罗拉 W0 roller
- [23] W0切丝器 W0 Cutting device

### 【主要技术参数】 The Main Technical Parameters

锭数 Spindle	288锭 Spindles	312锭 Spindles	336锭 Spindles	360锭 Spindles	
节数 Section	12	13	14	15	
锭距 Spindle pitch	110mm				
最高机械速度 Highest Mechanical Speed	1000m/min				
加工纤度范围 Denier of fiber	聚酯 55-222dtex(50-200Denier) / polyester 55-222dtex(50-200Denier)				
节距 Section Size	1440mm				
假捻方式 False twist way	叠盘式 VIII型假捻器 / Type 8 disc friction unit				
假捻方向 False twist direction	S,Z可调 / S,Z adjustable				
第一热箱 (变形) The first heat box (distortion)	联苯气相加热 / 2000mm biphenyl gas phase heating / 2000mm				
第二热箱 (定型) The second heat box (figuration)	联苯气相加热 / 1460mm biphenyl gas phase heating / 1460mm				
冷却方式及长度 Cooling mode and length	冷却板自然冷却 / 1100mm cooling rail to cool naturally / 1100mm				
摩擦辊直径 Friction drum diameter	Φ100mm				
罗拉直径 Roller diameter	Φ75mm				
上油罗拉直径 Oiling roller diameter	Φ75mm				
原丝最大尺寸 Largest original yarn size	Φ435x250mm				
最大卷装尺寸 Maximum take-up size	Φ250x250mm				
装机功率分类 Total power (kw)	传动 Drive	105	113	120	120
	上热箱 Up heat box	81.6	88.4	95.2	102
	下热箱 Below heat box	28.8	31.2	33.6	36
	辅助功率 Assist power	≈6	≈6	≈6	≈6
	总功率 Total power	221.4	238.6	253.8	264



# HYD-1000V-FD-W0

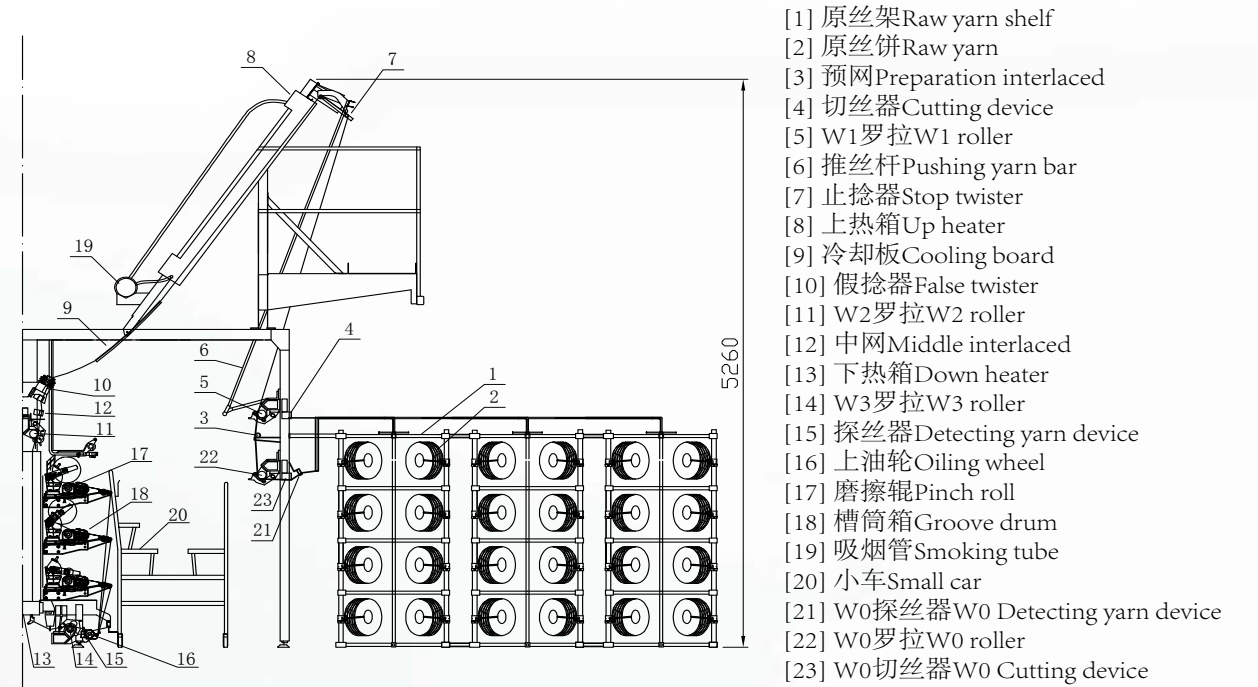
涤纶机Polyester DTY machine  
海岛丝Island silk



### 【设备用途Equipment use】

该机是在1000V基础上增加W0罗拉的高速电脑加弹机，是一种新型、高速、高效长丝合股加工设备，主要用于将涤纶预取向丝(POY)通过变形假捻成具有低弹性能的牵伸变形丝(DTY),并与通过旁丝装置的另一股旁丝合成网络复合丝。旁丝可以为海岛丝、FDY、DTY、高效收缩丝等。This machine is used to make the polyester fiber and polypropylene fiber to be low,middle and high stretch fiber through twister.If equipped with intermingle nozzle, this machine can make intermingle fiber.

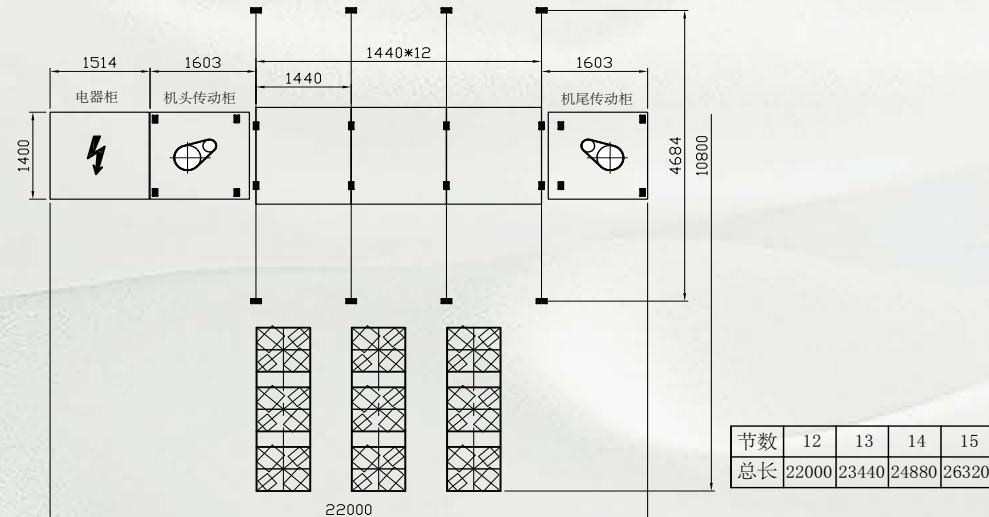
【外形尺寸示意图】 Overall dimension



### 【主要技术参数】 The Main Technical Parameters

锭数 Spindle	288锭Spindles	312锭Spindles	336锭Spindles	360锭Spindles	
节数Section	12	13	14	15	
锭距Spindle pitch	110mm				
最高机械速度Highest Mechanical Speed	1000m/min				
加工纤度范围Denier of fiber	聚酯55-222dtex(50-200Denier)/ polyester 55-222dtex(50-200Denier)				
节距Section Size	1440mm				
假捻方式False twist way	叠盘式VIII假捻器 /Type 8 disc friction unit				
假捻方向False twist direction	S,Z可调/S,Z adjustable				
第一热箱(变形The first heat box (distortion)	联苯气相加热/2000mm biphenyl gas phase heating/2000mm				
第二热箱(定型The second heat box (figuration)	联苯气相加热/1460mm biphenyl gas phase heating/1460mm				
冷却方式及长度Cooling mode and length	冷却板自然冷却/1100mm cooling rail to cool naturally/1100mm				
摩擦辊直径Friction drum diameter	Φ100mm				
罗拉直径Roller diameter	Φ75mm				
上油罗拉直径Oiling roler diameter	Φ75mm				
原丝最大尺寸Largest original yarn size	Φ435x250mm				
最大卷装尺寸Maximum take-up size	Φ250x250mm				
装机功率分类 Total power (kw)	传动 Drive	105	113	120	120
	上热箱 Up heat box	81.6	88.4	95.2	102
	下热箱 Below heat box	28.8	31.2	33.6	36
	辅助功率 Assist power	≈6	≈6	≈6	≈6
	总功率 Total powe	221.4	238.6	253.8	264

【安装示意图】 Foundation bolt drawing



# HYD-1000M

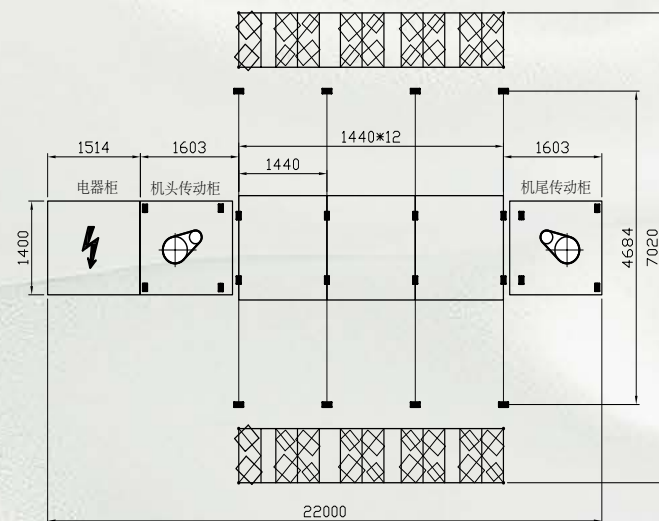
## 涤纶机 Polyester DTY machine



### 【设备用途Equipment use】

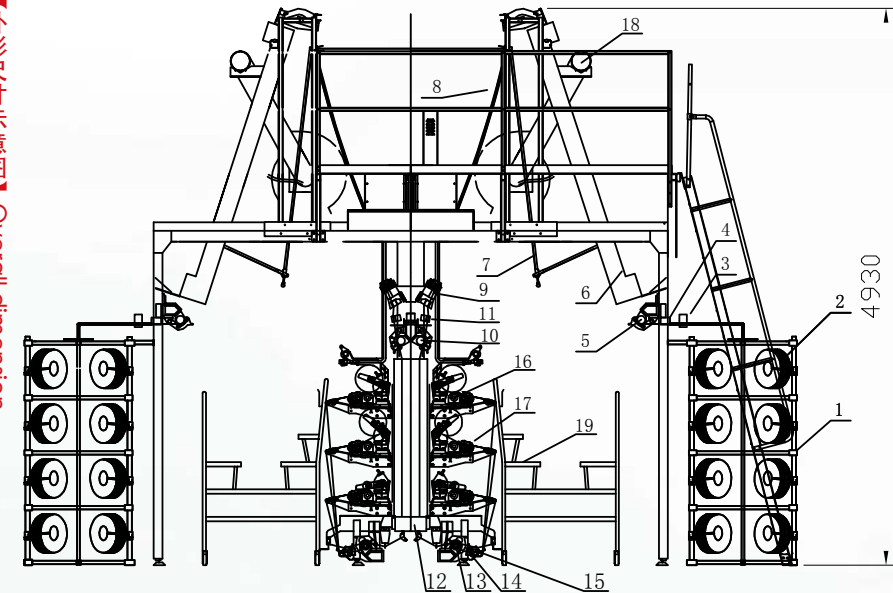
该机主要是将POY原丝(聚酯预取向丝)，通过拉伸和假捻变形加工成具有低弹性性能的假捻变形丝(DTY涤纶弹力丝)，若在设备上选择增加网络部件还可以进行网络丝的加工。  
This machine mainly uses the POY yarn(Pre-Oriented Yarn) through stretching and false twisting deformation, processed into low elastic or high elastic false twisting texturing yarn(DTY), the machine can produce intermingle yarn if equipped with an optional interlaced nozzle.

### 【安装地脚图】 Foundation bolt drawing



节数	10	11	12	13
总长	19120	20560	22000	23440

### 【外形尺寸示意图】 Overall dimension



- [1] 原丝架Raw yarn shelf
- [2] 原丝饼Raw yarn
- [3] 预网Preparation interlaced
- [4] 切丝器Cutting device
- [5] W1罗拉W1 roller
- [7] 推丝杆Pushing yarn bar
- [6] 上热箱Up heater
- [8] 冷却板Cooling board
- [9] 假捻器False twister
- [10] W2罗拉W2 roller
- [11] 中网Middle interlaced
- [12] 下热箱Down heater
- [13] W3罗拉W3 roller
- [14] 探丝器Detecting yarn device
- [15] 上油轮Oiling wheel
- [16] 磨擦辊Pinch roll
- [17] 槽筒箱Groove drum
- [18] 吸烟管Smoking tube
- [19] 小车Small car

### 【主要技术参数】 The Main Technical Parameters

锭数 Spindle	240锭Spindles	264锭Spindles	288锭Spindles	312锭Spindles	
节数Section	10	11	12	13	
锭距Spindle pitch	110mm				
最高机械速度Highest Mechanical Speed	1000m/min				
加工纤度范围Denier of fiber	聚酯167-333dtex(150-300Denier)/polyester 167-333dtex(150-300Denier)				
节距Section Size	1440mm				
假捻方式False twist way	叠盘式8型假捻器Type 8 disc friction unit				
假捻方向False twist direction	S,Z可调/S,Z adjustable				
第一热箱(变形)The first heat box (distortion)	联苯气相加热/2500mm biphenyl gas phase heating/2500mm				
第二热箱(定型)The second heat box (figuration)	联苯气相加热/1460mm biphenyl gas phase heating/1460mm				
冷却方式及长度Cooling mode and length	冷却板自然冷却/2100mm cooling rail to cool naturally/2100mm				
摩擦辊直径Friction drum diameter	Φ100mm				
罗拉直径Roller diameter	Φ75mm				
上油罗拉直径Oiling roller diameter	Φ75mm				
原丝最大尺寸Largest original yarn size	Φ435x250mm				
最大卷装尺寸Maximum take-up size	Φ250x250mm				
装机功率分类 Total power (kw)	传动 Drive	107.5	110.5	110.5	127
	上热箱 Up heat box	80	88	96	104
	下热箱 Below heat box	24	26.4	28.8	31.2
	辅助功率 Assist power	≈6	≈6	≈6	≈6
	总功率 Total power	217.5	236.9	241.3	268.2



# HYJ-1200V

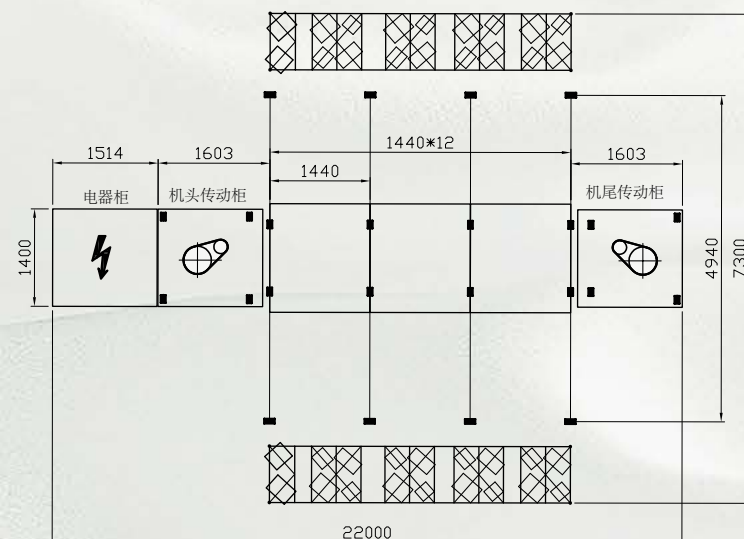
## 锦纶机Polyamide DTY machine



### 【设备用途Equipment use】

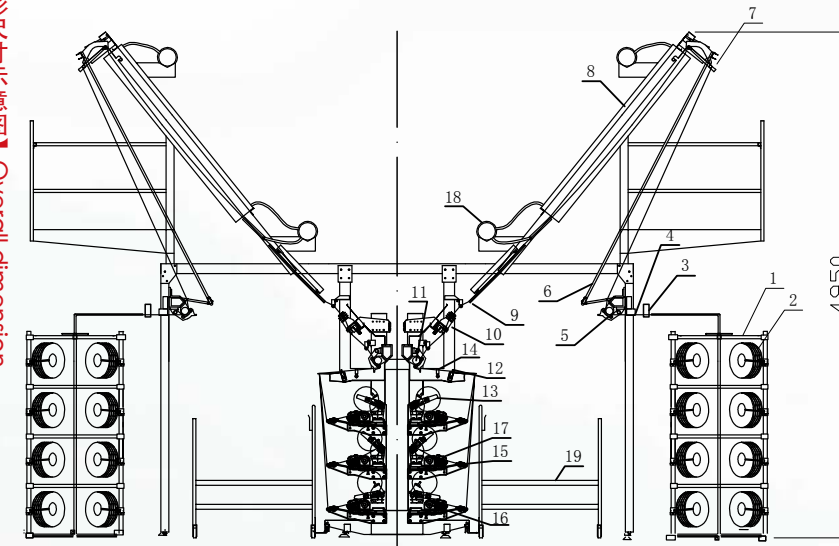
该机主要是将聚酰胺(锦纶)POY原丝，通过拉伸和假捻变形加工成具有高弹性的假捻变形丝(锦纶DTY弹力丝)。  
This machine mainly uses the polyamide (nylon) POY yarn through stretching and false twist deformation processed into false twist textured yarn with high elasticity (nylo DTY yarn).

### 【安装脚图】 Foundation bolt drawing



节数	12	13	14	15
总长	22000	23440	24880	26320

### 【外形尺寸示意图】 Overall dimension



- [1] 原丝架Raw yarn shelf
- [2] 原丝饼Raw yarn
- [3] 预网Preparation interlaced
- [4] 切丝器Cutting device
- [5] W1罗拉W1 roller
- [6] 推丝杆Pushing yarn bar
- [7] 止捻器Stop twister
- [8] 上热箱Up heater
- [9] 冷却板Cooling board
- [10] 假捻器False twister
- [11] W2罗拉W2 roller
- [12] 中网Middle interlaced
- [13] 筒子架Creel stand
- [14] 探丝器Detecting yarn device
- [15] 上油辊Oiling wheel
- [16] 磨擦辊Pinch roll
- [17] 槽筒箱Groove drum
- [18] 吸烟管Smoking tube
- [19] 小车Small car

### 【主要技术参数】 The Main Technical Parameters

锭数 Spindle	288锭Spindles	312锭Spindles	336锭Spindles	360锭Spindles	
节数Section	12	13	14	15	
锭距Spindle pitch	110mm				
最高机械速度Highest Mechanical Speed	1200m/min				
加工纤度范围Denier of fiber	聚酯33-222dtex(30-200Denier)				
节距Section Size	1440mm				
假捻方式False twist way	叠盘式假捻器摩擦假捻/ folding disc 8 type false twister				
假捻方向False twist direction	S,Z可调/S,Z adjustable				
第一热箱(变形)The first heat box (distortion)	联苯气相加热/2000mm biphenyl gas phase heating/2000mm				
冷却方式及长度Cooling mode and length	冷却板自然冷却/1100mm cooling rail to cool naturally/1100mm				
摩擦辊直径Friction drum diameter	Φ100mm				
罗拉直径Roler diameter	Φ75mm				
上油罗拉直径Oiling roler diameter	Φ30mm				
原丝最大尺寸Largest original yarn size	Φ435x250mm				
最大卷装尺寸Maximum take-up size	Φ250x250mm				
装机功率分类 Total power (kw)	传动 Drive	97	105	112	112
	上热箱 Up heat box	81.6	88.4	95.2	102
	辅助功率 Assist power	≈6	≈6	≈6	≈6
	总功率 Total powe	184.6	238.6	213.2	220



# HYJ-1200AF

## 锦纶包覆一体机

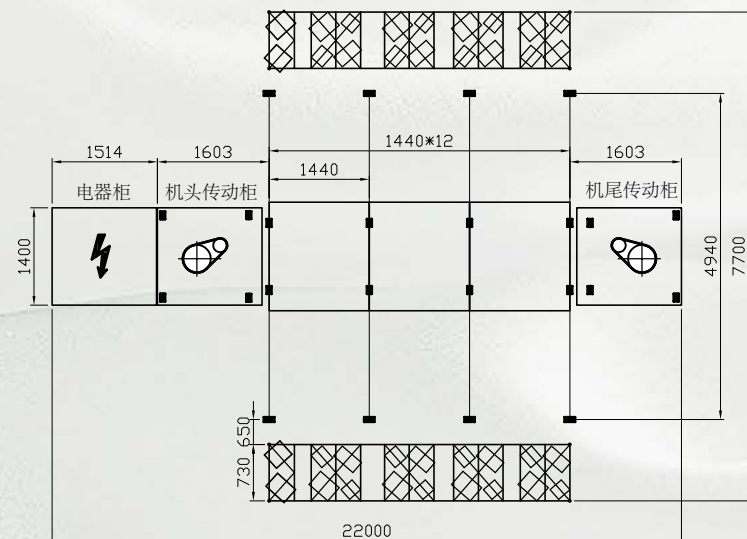
## Polyamide DTY+Spandex Air covering machine



### 【设备用途Equipment use】

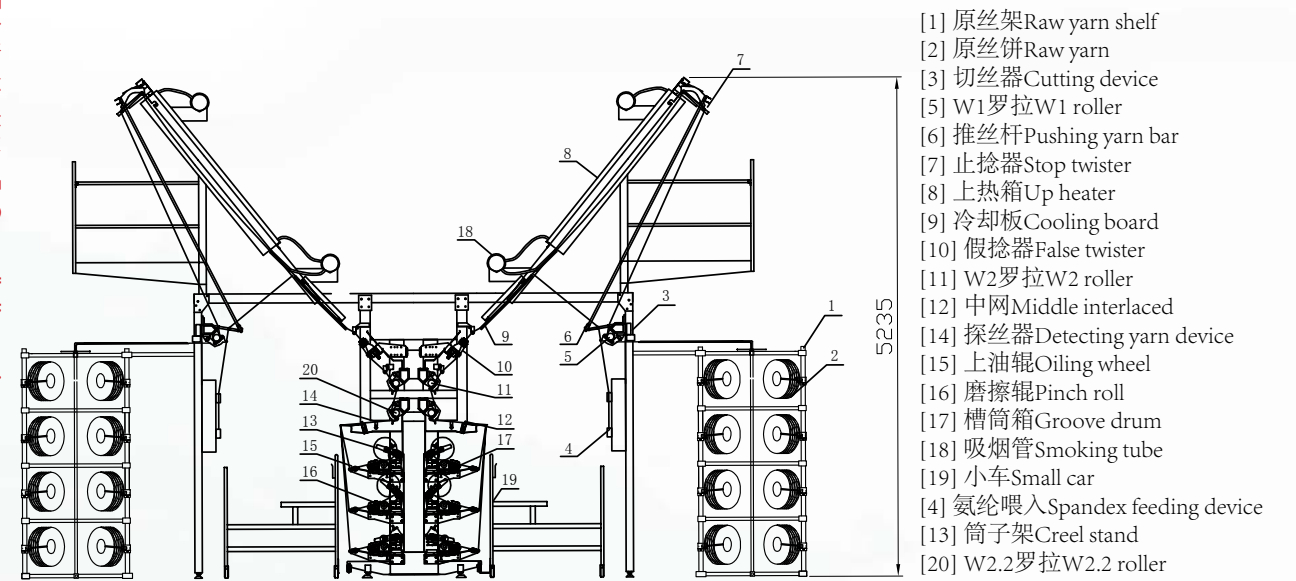
该机主要是将锦纶POY原丝(聚酯胺)，通过拉伸和假捻变形加工成具有高弹性能的假捻变形丝(DTY锦纶弹力丝)，同时在机器上直接将氨纶丝与锦纶DTY丝复合，通过网络喷嘴，实现加弹与氨纶网络一步加工，最终加工得到锦纶空包纱。This machine mainly uses the polyamide(nylon) POY yarn through stretching and false twisting deformation, processes into false Polyamide DTY+Spandex Air covering machine

### 【安装示意图】 Foundation bolt drawing



节数	10	11	12	13
总长	19120	20560	22000	23440

### 【外形尺寸示意图】 Overall dimension



### 【主要技术参数】 The Main Technical Parameters

锭数 Spindle	288锭Spindles	312锭Spindles	336锭Spindles	360锭Spindles	
节数Section	12	13	14	15	
锭距Spindle pitch	110mm				
最高机械速度Highest Mechanical Speed	1200m/min				
加工纤度范围Denier of fiber	聚酯33-222dtex(30-200Denier)				
节距Section Size	1440mm				
假捻方式False twist way	叠盘式假捻器摩擦假捻/ folding disc 8 type false twister				
假捻方向False twist direction	S,Z可调/S,Z adjustable				
第一热箱(变形)The first heat box (distortion)	联苯气相加热/2000mm biphenyl gas phase heating/2000mm				
冷却方式及长度Cooling mode and length	冷却板自然冷却/1100mm cooling rail to cool naturally/1100mm				
摩擦辊直径Friction drum diameter	Φ100mm				
罗拉直径Roler diameter	Φ75mm				
上油罗拉直径Oiling roler diameter	Φ30mm				
原丝最大尺寸Largest original yarn size	Φ435x250mm				
最大卷装尺寸Maximum take-up size	Φ250x250mm				
装机功率分类 Total power (kw)	传动 Drive	106.6	107.6	108.5	117.5
	上热箱 Up heat box	68	74.8	81.6	88.4
	辅助功率 Assist power	≈6	≈6	≈6	≈6
	总功率 Total powe	180.6	188.4	196.1	211.9



## 设备主要部件性能与特点

### Equipment performance and characteristics of main components

#### → 【D1导丝盘罗拉装置】 D1 Godet roller device

单锭驱动导丝盘取代整体罗拉传动、皮辊加压等结构，提高成纱品质。  
Individual driving godet roller device replaces nip roller to improve yarn quality.



#### ← 【电器控制系统】 Electric control and drive system

1-采用PLC控制系统，整机通过人机交流实现工艺调整，触摸屏显示及操作使得工艺设定简单化，同时可预设网络接口，根据用户的需要可以进行多机联网管理；同时根据用户需要进行手机“APP”软件管理（定制）。  
2-采用优质的电器元器件，确保设备在使用过程中运行更为稳定、可靠。  
1-PLC control system, the machine through man and machine communication, to realizes process adjustment. The touch screen and operation made the process set simply and easily, so it is easy to understand, using the network interface can customized do more machine networking management.  
2-Use the high quality of electrical components, to ensure that equipment in use process operation more reliable, more stable.



#### → 【氨纶喂入装置】 Spandex feeding system

氨纶喂入装置采用单锭独立电机传动，每个氨纶丝由独立电机带动，AB面装置可独立控制，确保氨纶送丝稳定，牵伸均匀。  
Sparate motor drive every spandex feeding device, separate controlling for side A and side B, thus spandex feeding more steady and uniformity.



#### ← 【假捻器】 False twister

采用叠盘式VIII型假捻器，可选择单龙带或双龙带传动方式，安装陶瓷导入盘和刀口导出盘，配置范围1-4-1至1-7-1可选。  
The fold type disc VIII false twist device, can choose single belt or double belt transmission mode, install guide ceramic disc and knife edge disc, optional configuration scope from 1-4-1 to 1-7-1.



#### → 【卷绕系统】 Winding system

采用全新的筒管架及卷绕系统，三层独立上油槽，整体式上油辊。  
Using new bobbin holder and winding system, single independent oil groove, monolithic oil roller.



#### ← 【卷取成形】 Take-up forming

高速卷绕成形系统，带动程修正，成形优良，易于高速退绕，定重定长，最大卷装容量可达6Kg。  
High speed winding shaping system, forming good, easy to unwinding, the biggest capacity can be processing to 6kg.



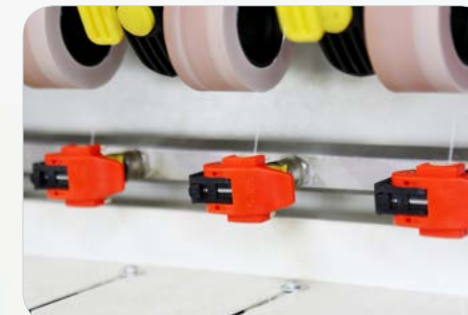
← 【共有两种原丝架可供用户选择，固定式与旋转式两种】  
There are two creels for user to choose, stationary creel and rotary creel.

#### → 【W2X结构】 W2X structute

采用双W2罗拉结构，提高网络质量，确保成纱品质。  
Adopting double W2 roller, it can increase the yarn quality and intermingle quality.



### 选择安装部件（不属标准配置，由客户选择安装） Optional system



【空气包覆系统】 Air covering system



【在线张力检测装置】 On-line yarn tension detecting device

#### 【设备安装及使用条件】

- ◇ 安装设备的地基需采用钢筋水泥结构浇注，要有足够的地面负载能力，浇注厚度不得小于20cm；
- ◇ 地坪水平度，纵向高低不得大于2cm，横向高低不得大于1cm；
- ◇ 电源：380V ± 10%，三相五线制（3x380V/N/PE），频率：50Hz ± 1Hz，具有良好的接地系统；
- ◇ 压缩空气：常压露点 ≤ -25℃，操作压力 ≥ 0.6MPa，杂质颗粒 < 0.2μm，残留油 < 0.1ppm；
- ◇ 使用环境：温度 25℃ ± 2℃，相对湿度 65% ± 5%。

#### [Equipment installation conditions]

- ◇ The foundations of the installation of the equipment shall be reinforced concrete structure pouring, and have enough load capacity, pouring theckness is not less than 20cm.
- ◇ Levelness of the floor and vertical height should not be more than 2cm, horizontal discreton should not be more than 1cm.
- ◇ Power: 380V ± 10%, three-phase-five wire(3x380V/N/P), frequency: 50Hz ± 1Hz, has the good grounding system.
- ◇ Compressed air: dew point ≤ -25℃, pressure ≥ 0.6MPa, impurities < 0.2μm, residual oil < 0.1ppm.
- ◇ The environment requirement: temperature 25℃ ± 2℃, relative humidity of 65% ± 5%.



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