

UCC
CARD CLOTHING

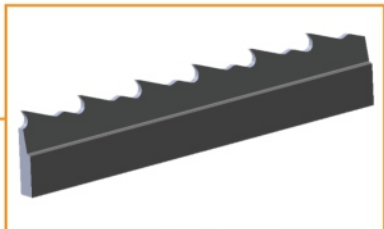
reliable
carding
solutions

Metallic Wires | Flat Tops | Stationary Flat Tops
Fillets & Accessories | Nonwoven Metallic Wires

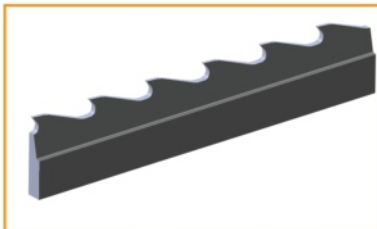
www.unispincardclothing.com

Cotton Series Card Clothing

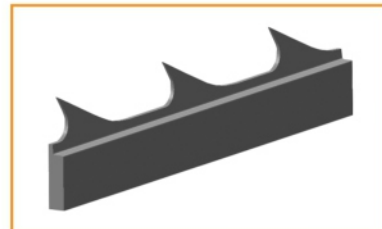
CYLINDER WIRES



Unimax

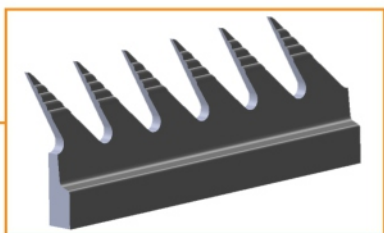


UNISTAR PLUS

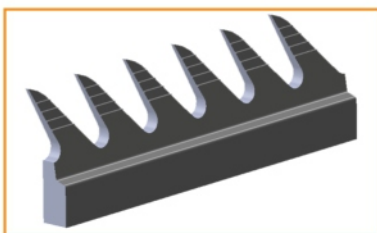


UNISTAR

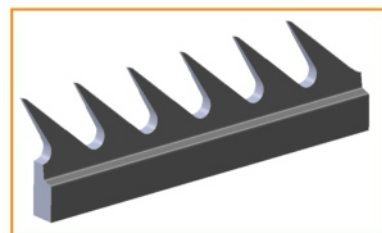
DOFFER WIRES



5 mm DOFFER



SERRATED DOFFER



PLAIN DOFFER

Cylinder wires available in 860 ppsi & 960 ppsi
 Metallurgy : Unistar, Unichrome & Unicarb
 Specification : CP 2035 X 0.4 960
 CR 2030 X 0.5 860
 CP 1735 X 0.4 960
 CR 1730 X 0.5 860

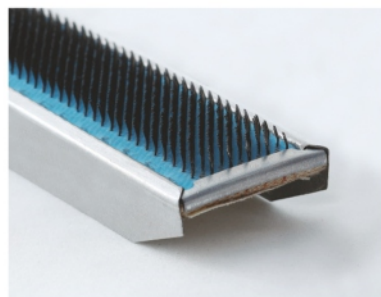
Doffer wire available in 340, 370, 390 & 400 ppsi
 Metallurgy : Unistar, Unichrome & Unicarb
 Specification : DM 4030X0.8 400
 DN 4030X0.85R 390
 DN 4730X0.9 370
 DM 5030X0.9 340

Features of Cylinder & Doffer wires:

Special tooth profile. Fibres continuously pushed toward tip for carding action between cylinder and flat tops. Strong cylinder wire tip – better life and consistency in sliver quality. Effective opening of neps in cotton fibre – Yields better NRE%. Minimum maintenance – Lesser number of re-sharpening.



Stilo SERIES
530, 550, 580,
600 & 700



UNO SERIES
550

Features of Flat Tops:

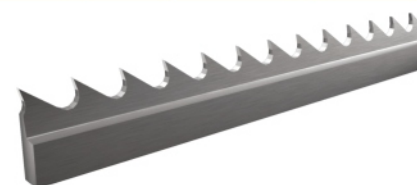
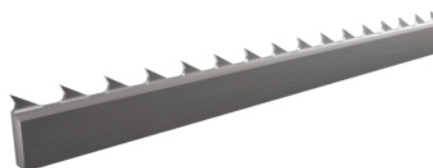
Strong – Made of special grade oil tempered steel with high fatigue properties. Long life – Extra hardened tips by hydrogen fuel and cryogenic quenching method. Smooth surface finish – Flat tops remains naturally clean for longer time. Consistent sliver quality – NRE% and imperfections. Available in progressive setting pattern STILO series and uniform setting pattern UNO series.

METALLURGY

UNISTAR : Made from NANO ALLOY STEELS for super high production cards.
UNICHROME : Made from CHROME VANADIUM STEELS for high production cards.
UNICARB : Made from Special High Tenacity CARBON STEELS for medium speed cards.

CYLINDER WIRES

S.No	Type	Height	Rib	Angle	PPSI
1	CP 1735 x 0.4 - 960	1.7	0.4	35	960
2	CR 1730 x 0.5 - 860	1.7	0.5	30	860
3	CR 2035 x 0.4 - 1080	2.0	0.4	35	1080
4	CR 2040 x 0.4 - 1080	2.0	0.4	40	1080
5	CT ₂ 2030 x 0.5 - 990	2.0	0.5	30	990
6	CP 2035 x 0.4 - 960	2.0	0.4	35	960
7	CP 2040 x 0.4 - 960	2.0	0.4	40	960
8	CR 2025 x 0.5 - 860	2.0	0.5	25	860
9	CR 2030 x 0.5 - 860	2.0	0.5	30	860
10	CR 2035 x 0.5 - 860	2.0	0.5	35	860
11	CR 2040 x 0.5 - 860	2.0	0.5	40	860
12	CQ 2025 x 0.5 - 810	2.0	0.5	25	810
13	CR 2030 x 0.6 - 720	2.0	0.6	30	720
14	CQ 2525 x 0.5 - 810	2.5	0.5	25	810
15	CR 2530 x 0.5 - 860	2.5	0.5	30	860
16	CP 2530 x 0.5 - 760	2.5	0.5	30	760
17	CR 2530 x 0.6 - 720	2.5	0.6	30	720
18	CR 2525 x 0.6 - 720	2.5	0.6	25	720
19	CR 2520 x 0.6 - 720	2.5	0.6	20	720
20	CP 2520 x 0.7 - 550	2.5	0.7	20	550
21	CR 2520 x 0.7 - 620	2.5	0.7	20	620
22	CO 2815 x 0.7 - 508	2.8	0.7	15	508
23	CR 2820 x 0.7 - 620	2.8	0.7	20	620
24	CP 2815 x 0.8 - 480	2.8	0.8	15	480
25	CO 3210 x 0.9 - 400	3.2	0.9	10	400



DOFFER WIRES

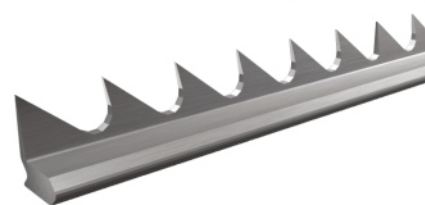
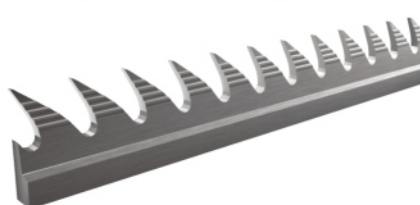
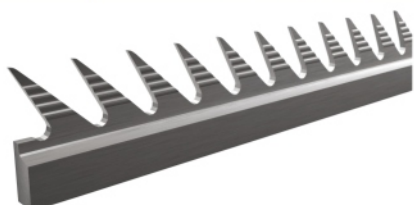
S.No	Type	Height	Rib	Angle	PPSI
1	DL 4030 x 0.85 RC - 330	4.0	0.85	30	330
2	DN 4030 x 0.85 R - 390	4.0	0.85	30	390
3	DM 4030 x 0.8 - 400	4.0	0.8	30	400
4	DL 4030 x 0.9 RC - 310	4.0	0.9	30	310
5	DK 4035 x 0.8 UC - 320	4.0	0.8	35	320
6	DL 4030 x 1.0 RC - 280	4.0	1.0	30	280
7	DO 4030 x 0.7 - 500	4.0	0.7	30	500
8	DM 4730 x 1.0 - 305	4.7	1.0	30	305
9	DM 5030 x 0.9 - 340	5.0	0.9	30	340
10	DN 4730 x 0.9 - 370	4.7	0.9	30	370

INTERLOCKING LICKER-IN WIRES

S.No	Type	Height	Rib	Angle	TPI
1	LV8 - D5005 - 4T	5.0	V8	5	4.0
2	LV8 - E5010 - 5T	5.0	V8	10	5.0
3	LV8 - E5000 - 5T	5.0	V8	0	5.0
4	LV12 J2-5010 - 9.5T	5.0	V12	10	9.5
5	LV12 E-5010 - 5T	5.0	V12	10	5.0
6	LV16 K-5020 - 10T	5.0	V16	20	10.0
7	LV16 N-5020 - 13T	5.0	V16	20	13.0

GROOVED LICKER-IN WIRES

S.No	Type	Height	Rib	Angle	TPI
1	GLC 5500 - 3T	5.5	1.1 to 1.6	0	3
2	GLC 5510 - 3T	5.5	1.1 to 1.6	10	3
3	GLD 5505 - 4T	5.5	1.1 to 1.6	5	4
4	GLE 5510 - 5T	5.5	1.1 to 1.6	10	5
5	GLE 5500 - 5T	5.5	1.1 to 1.6	0	5



BLOWROOM BEATER WIRES TRUTZSCHLER & TRUMAC

S.No	Type	Height	Rib	Angle	TPI
1	TR13 & 14	7.5	V6	10	1.5
2	LV8 D6020	6.0	V8	20	4
3	LV6 C6020	6.0	V6	20	3

BLOWROOM BEATER WIRES RIETER & LMW

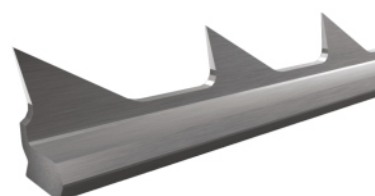
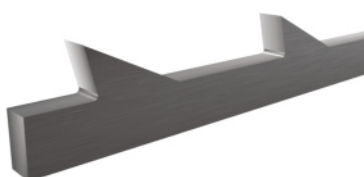
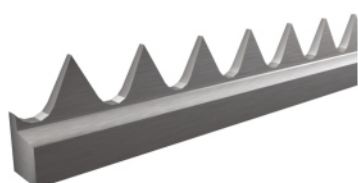
S.No	Type	Height	Rib	Angle	TPI
1	BR 10/0	10	2.5	0	2.5
2	BR 10/10	10	2.5	10	2.5
3	BR 20/0	10	2.5	0	1.5
4	BR 20/10	10	2.5	10	1.5

BORDER WIRES

S.No	Type	Height	Rib	Width
1	Steel Border wire 4.0 x 1.0	4.0	1.0	0.0
2	Anti Flock Border Wire - 1501	3.2	1.2	2.5
3	Anti Flock Border Wire - 1504	6.5	0.5	4.0

STRIPPER ROLLER & FEED ROLLER & CHUTE BEATER WIRES

S.No	Type	Height	Rib	Angle	TPI
1	Stripper wire TR12 SG2 4028x1.8	4.0	1.8	-28	7.5
2	Stripper wire H3530 x 1.0	3.5	1.0	-30	8.0
3	Feed Roller wire FV6-TR5	5.0	4.2	15	2.0
4	Chute Beater Wire-TR11	5.5	V6	0	4.5
5	J 2500 x 2.0	2.5	2.0	0	9.0
6	F2 3500 x 3.0	3.5	3.0	0	6.5
7	D2 5500 x 6G	4.0	3.0	0	7.0
8	Feed Roller wire F2 5000 x 3.0	5.0	3.0	0	6.5



OE COMBING ROLLER / OPENING ROLLER WIRES

S.No.	Wire Type	Dimensions	Height	Rib	Pitch	TPI	Angle
1	OK 37	3.60 x 0.90	3.60	0.90	4.70	5.40	-10
2	OK 36	3.60 x 0.90	3.60	0.90	4.00	6.35	0
3	OK 61	3.60 x 0.90	3.60	0.90	4.00	6.35	15
4	OS 21	3.60 x 0.90	3.60	0.90	3.25	7.80	15
5	OK 40	3.60 x 0.90	3.60	0.90	2.62	9.69	25
6	OB 20	3.60 x 0.90	3.60	0.90	2.12	11.98	25
7	OK 21A	4.10 x 0.94	4.10	0.94	3.25	7.81	15
8	OK 74A	4.10 x 0.94	4.10	0.94	6.00	4.20	25
9	OB 20A	4.10 x 0.94	4.10	0.94	2.12	11.98	25

Material	Wires			
Cotton	OK40	OB20-OK40	OB20	OB20
Polyester	OK37	OK37-OK61-OS21	OS21	OS21
Acrylic	OS21	OS21	OS21	OS21
Polyester - Cotton	OK61	OK61	OS21	OS21
Acrylic - Cotton	OK61	OK61	OS21	OS21
Polynosic - Viscose	OK61	OK61	OB20	OS21
Microfibre	OB20	OK61	OB20	OB20
Modal - Polynosic	OS21	OK61	OB20	OB20
Viscose - Rayon	OS21	OS21	OS21	OS21
Linen - Flax	OK74	OB20	OB20	OB20

Suitable for
Machine Models

SAVIO
BDA10-20
BD200ES
BD200RCE
BN200RN
BT902-905
FA601A
F1603
FA621
RN
S
SN

Suitable for
Machine Models

BD-200D
BD - D1
BD-D1K
BD-D2
BD-D2K
BD-D30
BD-D310
BD-D320
BD-D321
BD-D330
BD-D340
BD-D350
BD-SD

Suitable for
Machine Models

R1
R20
RU11
RU14

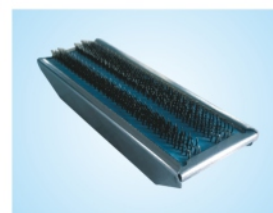
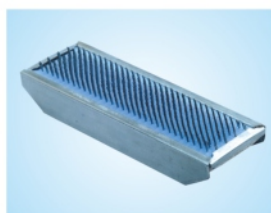
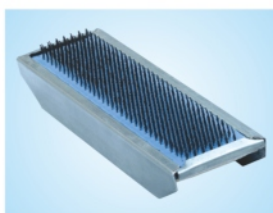
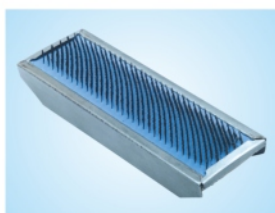
Suitable for
Machine Models

SE7
SE8
SE9
SE10
SE11



FLAT TOPS

Type	Specifications	PPSI	Suitable For	Features
Stilo Series	STILO 330	330	Cotton - medium, combed & fine counts	Tops with special setting pattern suitable for high production cards. Gives best NRE %
	STILO 430	430		
	STILO 480	480		
	STILO 530	530		
	STILO 550	550		
	STILO 580	580		
	STILO 600	600		
	STILO 700	700		
Uno Series	UNO 310	310	Cotton & PC Blends (Polyester & Cotton)	1. Uniform density - Flat tops wire PPSI uniform across the width of flat top. 2. Unique setting pattern of flat tops provides better fibre trapping. Better elimination of short fibre & neps at high production rates
	UNO 410	410		
	UNO 450	450		
	UNO 510	510		
	UNO 550	550		
Uno-S Series	UNO - S 300	300	100% polyester, Polyester & viscose blends, 100% viscose, MODAL & TENCEL fibre. For OE Process	1. Synthetic tops - Tops with angle suitable for processing synthetic fibres. 2. Reduces resistance in carding zone there by reduces static electricity and prevents card loading. Hightensile wires used to with stand load.
	UNO - S 400	400		
	UNO - S 400 OE	400		
	UNO - S 450	450		
	UNO - S 500	500		
Uno-G Series	UNO - G 280	280	Non woven material process, Surgical cotton application	1. Tops with open space in between. 2. Reduced resistance to fibre flow. 3. Lesser waste removal.
	UNO - G 330	330		
Recto Series	RECTO 330	330	100% Polyester, Acrylic, Recycled waste & bleached cotton.	1. Rectangular wire with no knee bend - Regrinding not required. 2. Semi rigid tops - Extraction of low flat waste. 3. Suitable for very coarse micronaire / denier fibres and sliver hanks.

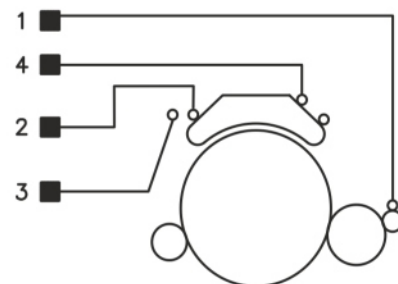


- ❖ Flat tops pins made out of **Special grade oil tempered steel with high fatigue properties.**
- ❖ Tips are extra hardened in advanced **HAQ** - method (Hydrogen fuel flaming and cryogenic quenching).
- ❖ This advanced treatment keeps the flat tops naturally clean, due to smooth surface finish.

FILLET CHART

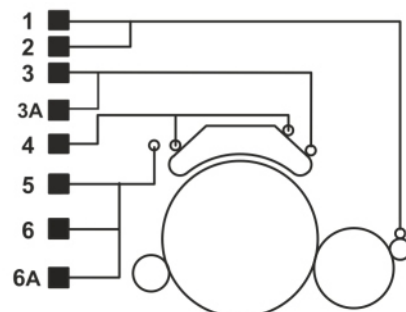
LMW LC 636 (1.5 Meter Card)

S.No	Description	Specification	Qty / Card
1	Clearer Roller Clothing CF50	23.5 mtrs x 20 mm	23.5 mtrs
2	CRC with clips	1520 mm x 58.5 mm	1 pc
3	Clearer rod clothing	1522 mm x 33 mm	2 pcs
4	Flat Clearer roller clothing	1570 mm x 33 mm	2 pcs



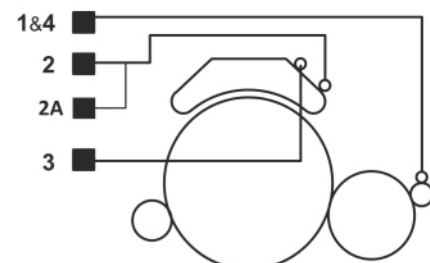
LMW- LC100 / 300 / 300A / 300AV3 / 300AV4 / 333 / 361 / 363 CARDS

S.No	Description	Specification	Qty / Card
1	Zig-Zag No.10 (LC 100)	8.6 mtrs x 38 mm	8.6 mtrs
2	CRC CF50 (LC300 to 363)	15.0 mtrs x 20 mm	15.0 mtrs
3	Flat clearer roller clothing	1050 x 33 mm	2 pcs
4	Clearer rod clothing	1010 x 33 mm	1 pc
5	Flat stripping (LC 100)	1030 x 47.5 mm	1 pc
6	CRC with clips (LC300 to LC300AV4)	1010 x 58.5 mm	1 pc
6A	CRC with clips (LC361 to LC363)	1020 x 58.5 mm	1 pc



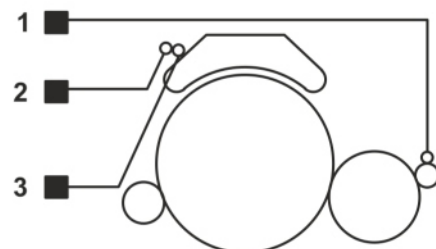
LAKSHMI RIETER C 1/1 , C 1/2, C1/3 & TEXTTOOL-TC360,450 & SHANTHI SC2 CARDS

S.No	Description	Specification	Qty / Card
1	Clearer roller clothing	11 mtrs x 28 mm	11.0 mtrs
2	Flat clearer roller clothing	1050 x 33 mm	2 pcs
2A	Flat stripping (26.5 mm ht)	11.5 mtrs x 40 mm	11.5 mtrs
3	Clearer rod clothing	1010 x 33 mm	1 pc
4	CRC Doffer cleaning fillet (straight)	15.0mtrs x 20mm	15.0 mtrs



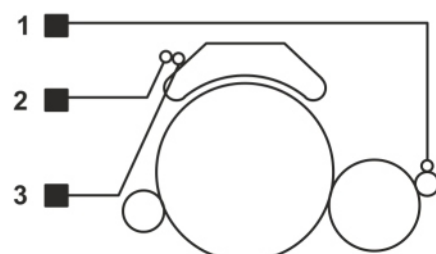
TRUTZSCHLER- DK 715, 740, 760, 780, 800, 803, 903 TC 03, 05, 5/3, 07, 08, 10, 12 CARDS

S.No	Description	Specification	Qty / Card
1	Doffer cleaning fillet TR AP No.26	15.0 mtrs x 20 mm	15.0 mtrs
2	Cleaning fillet TR DP 18 - 1	10.5 mtrs x 28 mm	10.5 mtrs
3	Stripping fillet TR DS 609	9.0 mtrs x 40 mm	9.0 mtrs



TRUTZSCHLER- TC11, TC18, TC19i, JWF 1213, JSC 3281, 326, Saurer, Auto Card SC7, SC8 CARDS

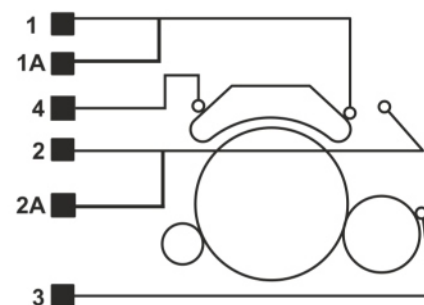
S.No	Description	Specification	Qty / Card
1	Cleaning fillet TR AP No.26 (50" Cards)	20 mtrs x 20 mm	20 mtrs
2	Cleaning fillet TR DP 18 - 1 (50" Cards)	14 mtrs x 28 mm	14 mtrs
3	Stripping fillet TR DS 609 (50" Cards)	12 mtrs x 40 mm	12 mtrs



"These fillets are available in bright steel wire and stainless wire executions."

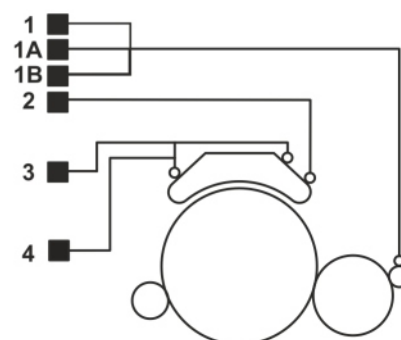
CROSROL MK 4, MK 5, MK 6, MK 7 & MK 8 SERIES CARDS

S.No	Description	Specification	Qty / Card
1	Cleaning Flat Fillet (8 rows)	1022 x 32 mm	1 pc
1A	Stripping Fillet DS - 609 (MK6)	11.0 mtrs x 40 mm	11.0 mtrs
2	Stripping Flat Fillet (10 rows)	1022 x 32 mm	1 pc
2A	Cleaning Fillet DP 18 - 1(MK6)	12.5 mtrs x 28 mm	12.5 mtrs
3	Dicky Fillet	16.0 mtrs x 20 mm	16.0 mtrs
4	Cleaning Flat Fillet 10 rows (MK8)	1270 x 32 mm	2 pcs (MK8)



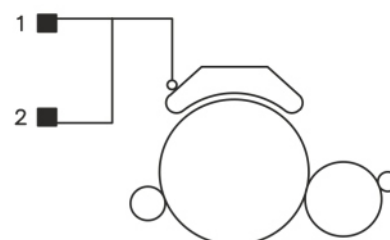
RIETER C4,C10, C50, C51 CARDS

S.No	Description	Specification	Qty / Card
1	Zig Zag No.10 (C4)	8 mtrs x 40 mm	8 mtrs
1A	Clearer Roller Clothing CF50 (C50,C51)	13 mtrs x 20 mm	13 mtrs
1B	Special CRC (C4-Advanced)	11 mtrs x 28 mm	11mtrs
2	Flat clearer roller clothing (C4, C4A, C10)	1030 mm x 33 mm	2 pcs
3	C Rod C	1010 mm x 33 mm	1 pc
4	Flat Stripping	1030 mm x 47.5 mm	1 pc



RIETER C 60 CARD

S.No	Description	Specification	Qty / Card
1	Cleaning fillet UFB60(H=26mm)	1535 x 34 mm	1pc
2	Stripping fillet UFB61(H=11mm)	1545 x 34 mm	1pc

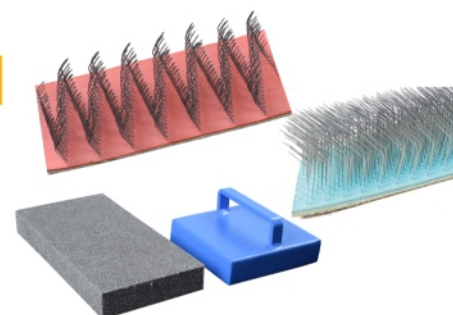


RIETER C 70, C 72, C 75, C 77, C 80, C 81 CARD

S.No	Description	Specification	Qty / Card
1	Cleaning fillet DP 18-1	15 mtrs x 28 mm	15 mtrs
2	Stripping fillet DS 609	14 mtrs x 40 mm	14 mtrs

STANDARD FILLETS

S.No	Description	Specification	Qty / Card
1	Metallic stripping fillet	14 mtrs x 40.0 mm	14 mtrs
2	Burnishing fillet	14 mtrs x 40.0 mm	14 mtrs
3	Zig zag flat cleaning fillet	11.5 mtrs x 40 mm width	11.5 mtrs
4	Burnishing pad	200 X 100 x 25 mm	1pc
5	Handle for burnishing pad	-	1pc
6	Flocked clearer roller cleaning fillet	9 mtrs x 42mm x 11mm	9 mtrs



HAND CARD STRIPPING FILLET

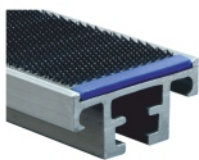
S.No	Description	Specification	Qty / Card
1	Hand card stripper with clips	260 x 64 x 14 mm	1pc
2	Handle for hand card stripper	-	1pc
3	Hand card stripper (use with wooden handle)	560 x 64 x 14 mm	1pc



STATIONARY FLAT TOPS-UCC *Stilo* SERIES

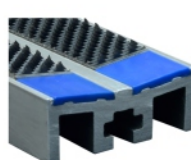
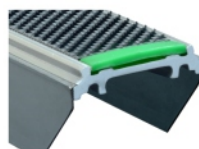
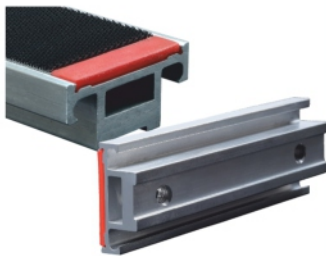
Salient Features of SF Tops

- ◆ Available for all make and model cards
- ◆ Periodical Replacement of SF Tops Enhance Cylinder and Flat Top Life.
- ◆ Stationary Flat Metallic wires are made out of imported NANO ALLOY STEELS
- ◆ Latest Tooth Geometry and angle Suitable for Super High Production Cards (up to 100kg/hrs)

Type		Card Make	Suitable For	PPSI
A		LMW Trutzschler	◆ LC 300, 300A (BACK SIDE) ◆ LC 333, 363 (UNDER LICKERIN) ◆ DK 760 card (with Aluminium Bare Flat). ◆ DK 780, DK 803 cards.	70,90,100,150, 250,350,450, 550,650

Type		Card Make	Suitable For	PPSI
B		Rieter Trutzschler LMW Saurer Jingwei Crosrol Marzoli	◆ Rieter 40" C4, C10, C50, C51 ◆ Rieter 60" C60, C70, C77, C80, C81 ◆ Trutzschler 40" DK740, DK800, 803, 903 ◆ Trutzschler 40" TC03, 05, 05/3, 06, 07, 08, 10, 12 ◆ Trutzschler 50" TC11, 15, 19i ◆ LMW 40" LC361, 363 ◆ LMW 60" LC636 ◆ Saurer 40" JSC230, JFA 212, 213, 218, 219 ◆ Saurer 50" JSC328, 326 ◆ Saurer 55" AUTOCARD SC7 ◆ Jingwei 40" A186G, JWF1203, 1204, 1206, 1207, JWF1211A ◆ Jingwei 40" FA203A, 221, 224, 225, 231, 231C ◆ Jingwei 50" JWF1217, JWF1213A ◆ Crosrol MK5, MK6, MK7, MK8(50inch) ◆ Marzoli C701, CX400, CX300, C40	70,90,100,150, 250,350,450, 550,650

Type		Card Make	Suitable For	PPSI
C		Trutzschler Rieter LMW Chinese	◆ Under Lickerin DK760, 780, 800, 803 ◆ Under Lickerin C10, C50, C51 ◆ Under Lickerin LRC1/3, LC300, 300A, 300V3, V4, 333, 361, 363 ◆ Blow room CVT-FD6 length 1200, 1599 ◆ FA221E, JWF 1213	70, 90

Type		Card Make	Suitable For	PPSI
D		Jingwei Rieter	◆ JWF1211 (length - 1186) ◆ Blow room uniflex FD4	40
Type		Card Make	Suitable For	PPSI
E		Rieter	◆ C4 Under Lickerin	70, 90
Type		Card Make	Suitable For	PPSI
F		Trutzschler	◆ Under Lickerin TC03, 05, 5/1, 5/3, 07, 08, TC12, TC19 & TC19i	70
Type		Card Make	Suitable For	PPSI
G		Trumac Crosrol Rieter Chinise	◆ Trumac 715, 740 ◆ Crosrol MK4, MK5 ◆ Rieter C4 ◆ China FA186F ,FA20A, FA201B	100, 150, 250 350, 450 550, 650
Type		Card Make	Suitable For	PPSI
H		LMW	◆ LMW LC300A, 300V3, V4 ,333, 361, 363 ◆ LCC conversions C1/3, LC100, DK740, 760, 780, C4, C10	70, 90, 100, 150, 250, 350, 450, 550, 650

PPSI COLOR CODE	PPSI COLOR CODE	PPSI COLOR CODE
70 Blue 90 Dark Blue 100 Yellow	150 Green 250 Pink 350 Blue	450 Black 550 Orange 650 Red

EXTENDED STATIONARY FLAT SYSTEM



Aluminium Combing segments for LR / LC cards

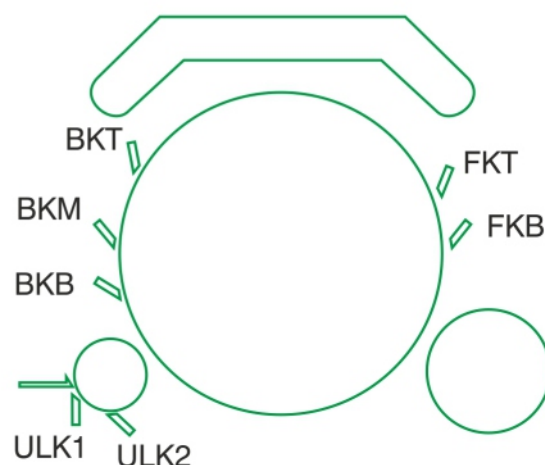
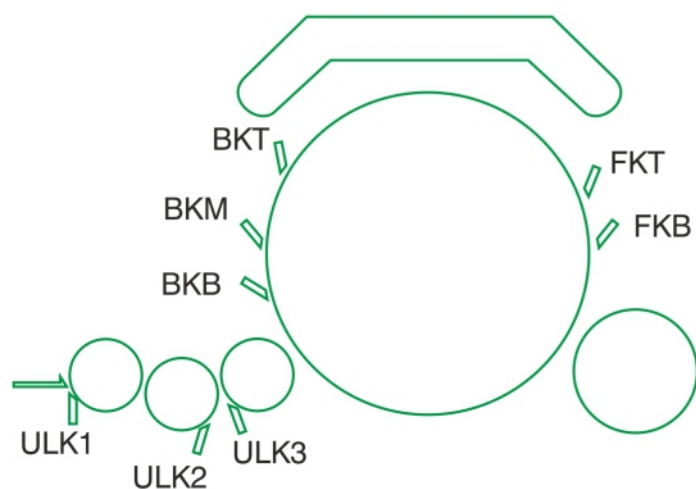
- ❖ Replaceable strip type stationary flat combing segment available for LC1/2, C1/3, LC100, LC300, LC300A & LC300A V3 cards



Card conversion C- Systems available for

- ❖ LC C1/1, C1/2, C1/3 & Textool TC 360
- ❖ LMW LC300, LC300A, LC300A V3
- ❖ Trumac DK 715, 740, 780 & 800
- ❖ Trutzschler DK 760 & DK 803
- ❖ Rieter C4 & C10

MOTE KNIFE

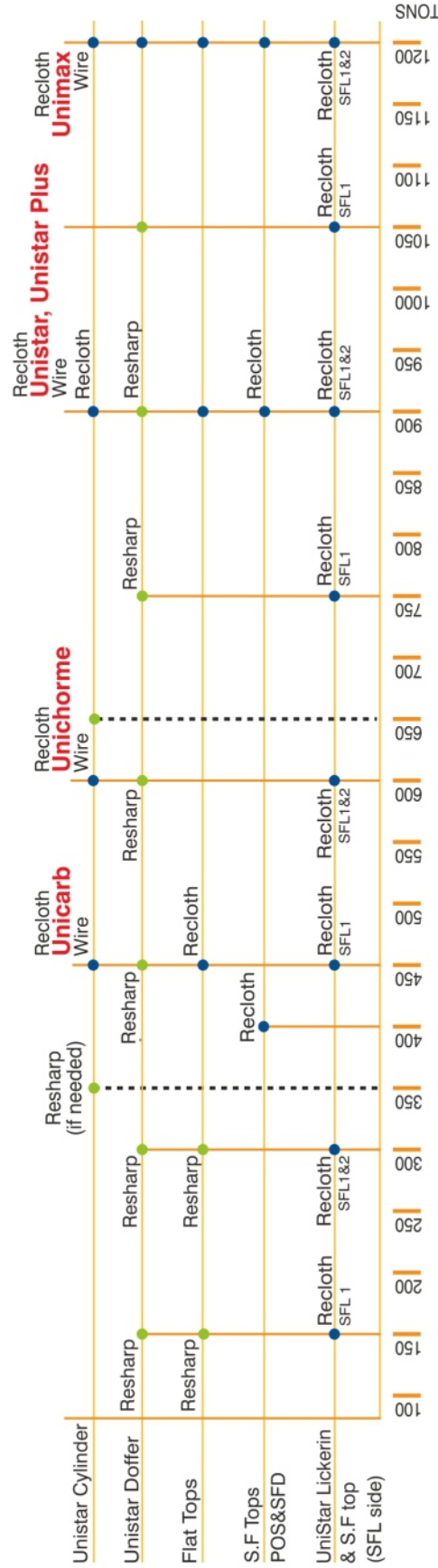


CARD MODEL	ULK1	ULK2	ULK3	BKB	BKM	BKT	FKB	FKT
LC 333, 361, 363	*	*		*	*		*	
LC 300, 300A, LC 300V3	*	*		*	*		*	
LR C1/3, LC100	*	*		*			*	
DK 740	*					*		
DK 803 & 903	*	*	*			*	*	
DK 760, 780, 800	*	*				*	*	*
TC 03, 05 & 5/3, 06, 07 08, 10, 11, 12, 15, 19 MODEL	*				*	*	*	*

NOTE: Knife for all card Models other than specified also can be supplied
Knife for Blow rooms LMW, ERM, RIETER, CVT Also available



Schedule & Maintenance for Reclothing and Resharping



Note

- ◆ Initial Grinding is Recommended for Doffer Wire.
- ◆ Above Chart is Guide Line Only.
- ◆ Intervals can be decided as per mill condition.
- ◆ Life of the stationary flats given are guidelines only.
- ◆ Life may be extended based on the actual wear and tear.
- ◆ For Viscose processing - 10% additional life excepted
- ◆ For 100% Polyester / dyed synthetic 15 % reduction in life expected.
- ◆ SFL1 - Bottom Beam, SFL 2 - Middle & Top Beam.

Card Clothing Recommendation Chart - Cotton

Production Rate	Process & Count	Open end & Ring Spinning Count	Surgical / Bleached Cotton	Ring spg & Denim 20's - 40's	Ring spinning 30s - 40s combed	Ring spinning 40s - 60s	Ring spinning Above 60s
	Micronaire Staple length (mm)	<5.0 20-22mm	3.5 - 5.0 20 - 27 mm	3.5-.5.0 ≈ 27mm	3.5 - 5.0 22 - 30 mm	2.5 - 3.5 27 - 30 mm	2.5 - 3.5 30 mm & above
Below 20Kgs / hr	Cylinder	CR 2030 x 0.6 720 CR 2030 x 0.5 860 CR 2520 x 0.6 720	CR 2520 x 0.7 620 CR 2520 x 0.6 720	CR 2030 x 0.5 860 CR 2530 x 0.5 860 CR 2035 x 0.5 860	CR 2030 x 0.5 860 CR 2035 x 0.5 860	CR 2030 x 0.5 860 CP 2035 x 0.4 960	CR 2030 x 0.5 860 CP 2035 x 0.4 960
	Doffer	DN 4030 x 0.85 R 390	DN 4030 x 0.85 R 390	DM 4030 x 0.8 400 DN 4030 x 0.85 R 390	DM 4030 x 0.8 400 DN 4030 x 0.85 R 390	DM 4030 x 0.8 400 DN 4030 x 0.85 R 390	DM 4030 x 0.8 400 DN 4030 x 0.85 R 390
	Flat Top	Stilo 330 UNO 310 UNO S 300	UNO S 300 Recto 330	Stilo 430 Stilo 530 UNO 410 / 450	Stilo 530 UNO 510	Stilo 530 UNO 510 / 550	Stilo 550, 580 & 600 UNO 550
	Lickerin	GLE 5510 LV8 E 5010 5T	GLD 5505 / E5510 LV8 E 5010 5T	GLE 5510 LV8 E 5010 5T	GLE 5510 LV8 E 5010 5T	GLE 5510 LV8 E 5010 5T	GLD 5505 / E5510 LV8 D 5005 / E5010
20-40 Kgs/ hr	Cylinder	CR 2030 x 0.6 720 CR 2030 x 0.5 860 CR 2520 x 0.6 720	CR 2520 x 0.7 620 CR 2520 x 0.6 720 CR 2025 x 0.6 720	CR 2030 x 0.5 860 CR 2035 x 0.5 860 CP 2035 x 0.4 960	CR 2030 x 0.5 860 CR 2035 x 0.5 860 CP 2035 x 0.4 960	CR 2030 x 0.5 860 CR 2035 x 0.5 860 CP 2035 x 0.4 960	CR 2030 x 0.5 860 CR 2035 x 0.5 860 CP 2035 x 0.4 960
	Doffer	DN 4030 x 0.85 R 390	DN 4030 x 0.85 R 390	DM 4030 x 0.8 400 DN 4030 x 0.85 R 390	DM 4030 x 0.8 400 DN 4030 x 0.85 R 390	DM 4030 x 0.8 400 DN 4030 x 0.85 R 390	DM 4030 x 0.8 400 DN 4030 x 0.85 R 390
	Flat Tops	Stilo 430 UNO S 400 (OE)	Stilo 330 Recto 330	Stilo 480 / 530 UNO 450 / 510	Stilo 530 / 550 UNO 510 / 550	Stilo 550, 580 & 600 UNO 550	Stilo 580, 600 & 700 UNO 550
	Lickerin	GLE 5510 LV8 E 5010 5T	GLD 5505 / E5510 LV8 E 5010 5T	GLE 5510 LV8 E 5010 5T	GLE 5510 LV8 E 5010 5T	GLE 5510 LV8 E 5010 5T	GLD 5505 / E5510 LV8 D 5005 / E5010
Above 40Kgs / hr	Cylinder	CR 2030 x 0.6 720 CR 2030 x 0.5 860 CR 2520 x 0.6 720 CR 2520 x 0.7 620	CR 2030 x 0.6 720 CR 2030 x 0.5 860	CR 2030 x 0.5 860 CR 2035 x 0.5 860 CP 2035 x 0.4 960	CR 2035 x 0.5 860 CP 2035 x 0.4 960	CP 2035 x 0.4 960 CP 2040 x 0.4 960 CT2 2030 x 0.5 990	CR 2035 x 0.4 1080 CP 2035 x 0.4 960 CT2 2030 x 0.5 990
	Doffer	DN 4030 x 0.85 R 390	DN 4030 x 0.85 R 390	DN 4030 x 0.85R DL 4030 x 0.9RC-310	DM 4030 x 0.8 400 DN 4030 x 0.85 R 390	DM 4030 x 0.8 400 DN 4030 x 0.85 R 390	DM 4030 x 0.8 400 DN 4030 x 0.85 R 390
	Flat Tops	Stilo 430 UNO S 300 UNO S 400 (OE)	Stilo 430 Stilo 480	Stilo 530/ 550 UNO 450 / 550	Stilo 550, 580 & 600 UNO 550	Stilo 550, 580 & 600 UNO 550	Stilo 580, 600 & 700 UNO 550
	Lickerin	GLE 5510 LV8 E 5010 5T	GLE 5510 LV8 E 5010 5T	GLE 5510 LV8 E 5010 5T	GLE 5510 LV8 E 5010 5T	GLE 5510 LV8 E 5010 5T	GLD 5505 / E5510 LV8 D 5005 / E5010

Card Clothing Recommendation Chart - Man Made Fibres

Production Rate	Process & Count	100% Polyester			100% Viscose	Polyster Viscose (Grey / Dyed)	PC Blends more Polyester Content	PC Blends more Cotton Content	Regenerated Fibres
	Denier & Staple length	<1.0 Denier 38-55 mm	1.2 - 3.0 Denier 38 - 55 mm	> 3.0 Denier		1.2 - 1.5 Denier 38 - 55 mm	1.2 - 1.5 Denier 38 - 55 mm	1.2 - 1.5 Denier 38 - 55 mm	
Below 20Kgs / hr	Cylinder	CR 2520 x 0.6 720 CR 2525 x 0.5 860 CR 2530 x 0.5 860	CR 2520 x 0.7 620 CR 2520 x 0.6 720	CO 3210 x 0.9 400 CP 2815 x 0.8 480 CR 2820 x 0.7 620	CR 2530 x 0.6 720 CR 2530 x 0.5 860	CR 2520 x 0.7 620 CR 2520 x 0.6 720	CR 2520 x 0.6 720 CR 2525 x 0.6 720	CR 2530 x 0.5 860 CR 2530 x 0.6 720 CR 2030 x 0.5 860	CH 2810 x 0.7 290 CR 2520 x 0.7 620
	Doffer	DN 4030 x 0.85R -390	DN 4030 x 0.85R -390	DN 4030 x 0.85R -390	DN 4030 x 0.85R -390	DN 4030 x 0.85R -390	DN 4030 x 0.85R -390	DN 4030 x 0.85R -390	DN 4030 x 0.85R -390
	Flat Tops	UNO S 400 / 450	UNO S 300 / 400 Recto 330	UNO S 300 Recto 330	UNO S 400 UNO S 450	UNO S 300 Recto 330	UNO S 400 Recto 330	UNO S 400 UNO S 450	UNO S 300 Recto 330
	Lickerin	GLD 5505 LV8 D 5005	GLD 5505 LV8 D 5005	GLD 5505 LV8 D 5005	GLD 5505 / E5510 LV8 D 5005 / E 5010	GLD 5505 LV8 D 5005	GLD 5505 LV8 D 5005	GLD 5505 LV8 D 5005	GLD 5505 LV8 D 5005
20-40 Kgs / hr	Cylinder	CP 2525 x 0.5 760 CR 2530 x 0.6 860	CR 2520 x 0.7 620 CR 2520 x 0.6 720	CR 2820 x 0.7 620 CP 2815 x 0.8 480	CQ 2025 x 0.5 810 CR 2030 x 0.5 860	CR 2520 x 0.7 620 CR 2520 x 0.6 720	CR 2530 x 0.5 860 CR 2030 x 0.5 860 CR 2520 x 0.6 720	CR 2525 x 0.5 860 CR 2030 x 0.5 860	CR 2520 x 0.7 620 CR 2520 x 0.6 720
	Doffer	DN 4030x0.85R 390 DO 4030x0.7 500	DN 4030x0.85R 390 DO 4030x0.7 500	DN 4030x0.85R 390	DN 4030x0.85R 390 DO 4030x0.7 500	DN 4030x0.85R 390	DN 4030x0.85R 390	DN 4030x0.85R 390 DM 4030x0.8 400	DN 4030x0.85R 390
	Flat Tops	UNO S 400 / 450	UNO S 300 / 400 Recto 330	UNO S 300 Recto 330	UNO S 400 / 450 / 480 / 500 Stilo 530	UNO S 300 / 400 / 450 Stilo 530	UNO S 300 / 400 / 450	Stilo 430 / 530 UNO S 400 / 450	UNO S 300 Recto 330
	Lickerin	GLD 5505 LV8 D 5005	GLD 5505 LV8 D 5005	GLD 5505 LV8 D 5005	GLD 5505 / E5510 LV8 D 5005 / E5010	GLD 5505 LV8 D 5005	GLD 5505 LV8 D 5005	GLD 5505 / E5510 LV8 D 5005 / E 5010	GLD 5505 LV8 D 5005
Above 40Kgs / hr	Cylinder	CR 2530 x 0.5 860 CR 2030 x 0.5 960 CP 2025 x 0.5 760	CR 2520 x 0.7 620 CR 2520 x 0.6 720	CP 2815 x 0.8 480 CR 2820 x 0.7 620	CR 2030 x 0.5 860 CQ2025 x 0.5 810	CR 2520 x 0.7 620 CR 2520 x 0.6 720	CR 2530 x 0.5 860 CR 2030 x 0.5 860 CR 2520 x 0.6 720	CR 2530 x 0.5 860 CR 2030 x 0.5 860	CR 2525 x 0.6 720 CR 2520 x 0.6 720
	Doffer	DN 4030x0.85R 390 DO 4030x0.7 500	DN 4030x0.85R 390 DO 4030x0.7 500	DN 4030x0.85R 390	DN 4030x0.85R 390 DO 4030x0.7 500	DN 4030x0.85R 390	DN 4030x0.85R 390	DN 4030x0.85R 390 DM 4030x0.8 400	DN 4030x0.85R 390
	Flat Tops	UNO S 400 / 450 / 500 Stilo 530	UNO S 300 / 400 Recto 330	UNO S 300 Recto 330	UNO S 400 / 450 / 480 / 500 Stilo 530	UNO S 300 / 400 / 450	UNO S 400 / 450 / 500	UNO S 400 / 450 / 500	UNO S 400 Recto 330
	Lickerin	GLD 5505 LV8 D 5005	GLD 5505 LV8 D 5005	GLD 5505 LV8 D 5005	GLD 5505 / E5510 LV8 D 5005 / E 5010	GLD 5505 LV8 D 5005	GLD 5505 LV8 D 5005	GLD 5505 / E5510 LV8 D 5005 / E 5010	GLD 5505 LV8 D 5005

PRECAUTIONS TO BE TAKEN WHILE INSTALLING NEW CARD CLOTHING



CYLINDER WIRE

- ◆ A Mounting tension of 6-8 kgs has to be applied during cylinder wire mounting.
- ◆ Tension should be sufficient enough to make the wire bend and sit straight vertically on the cylinder surface.
- ◆ No initial grinding required for cylinder wire.
- ◆ Only re-sharpening has to be done to cylinder wire in specified intervals using specified resharpening machines with 100's grit stones.
- ◆ Periodical replacement of Licker-in wire, Stationary flat tops, flat tops enhances cylinder wire life and vice versa.
- ◆ Different height and thickness cylinder wires require different mounting tension. Hence, tension varies depending on wire specification.
- ◆ Example: 2.5 mm Height x 0.6 Thickness and 2.0mm Height x 0.4 Thickness.

DOFFER WIRE

- ◆ A Mounting tension of 8 kgs has to be applied during wire doffer wire mounting.
- ◆ Being coarser wire, doffer wire may be having raised wire prints at starting and finishing.
- ◆ The raised wire points may be leveled by applying grinding machine [full width or traversing stone grinder] to the extent required.
- ◆ An initial grinding on doffer wire may be required ;
 1. To achieve uniform gauge between Cylinder & Doffer.
 2. To activate the Doffer wire points for better transfer of fiber from Cylinder to Doffer.

FLAT TOPS

- ◆ The card sliver quality, quality consistency and life of clothing depend on flat tops. Hence, due care has to be taken during clipping of flat tops.
- ◆ While clipping prescribed load of around 35 kgs, has to be applied on bare flat. Ensure the bare flat and flat tops are clipped tight with each other.
- ◆ Loose clipping will result in height variation in flat tops uneven grinding of flat wire points, bulging of flat tops during working and poor sliver quality.
- ◆ The finished set of flat tops should have a maximum variation of + 0.03 mm to + 0.05 mm only, within flat and flat to flat.
- ◆ An initial grinding after 15 days of working may be done to achieve required quality levels.
- ◆ Periodical grinding of flat tops using emery roller enhances card sliver quality.

GENERAL INSTRUCTIONS

- ◆ Cards are initially commissioned with wider settings between all organs for safe and smooth working. Based on the raw materials and production rates cards have to be worked at least few days to 2 weeks' time to complete running in. After the running in period, settings may be closed as per requirement, subsequently quality of sliver can be tested.
- ◆ The production rate of the card [meters / minute or kgs / hour], has to be reduced initially by 30-40%. After completing running in period, speed or production can be increased gradually by steps of 10%.
- ◆ Do not commission the cards during evening hours, please commission the card in day time only. Run the empty card for 1 or 2 hours, stop the card, check the gauges and then restart with material. The first day after working with the material card may be stopped by evening. Second day the card has to be cleansed, settings checked restarted and can be handed over to regular production.
- ◆ During cylinder, doffer, flat tops change, it is advisable to change licker-in wire, stationary flat tops, cleaning fillets and stripper wire. This will improve quality as well as performance of newly mounted card.
- ◆ Please refer to our brochure page no.12 for detailed card clothing maintenance schedule.



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