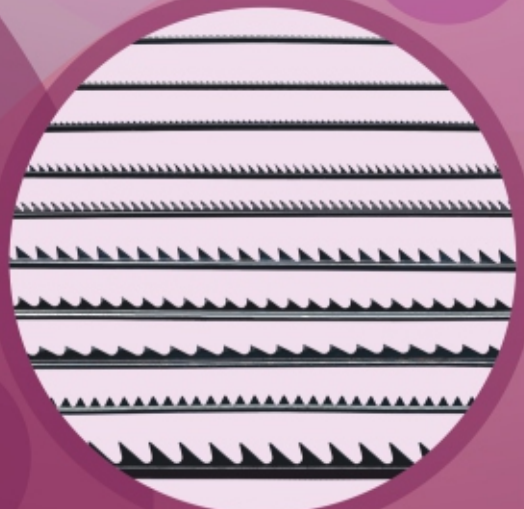


reliable  
**carding**  
solutions

**UCC**  
CARD CLOTHING

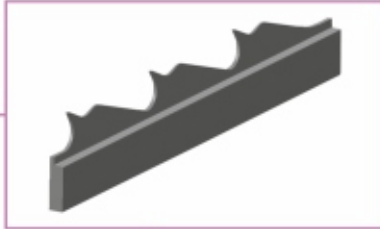


Metallic Wires | Flat Tops | Stationary Flat Tops | Fillets & Accessories  
Raising Fillet | Nonwoven Metallic Wires

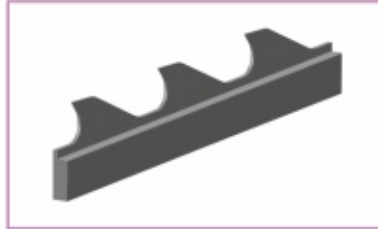
[www.unispincardclothing.com](http://www.unispincardclothing.com)

## Cotton Series Card Clothing

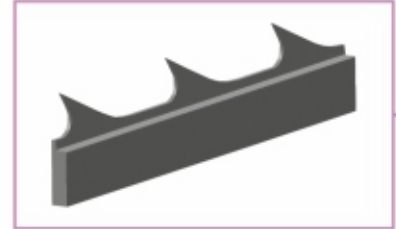
### CYLINDER WIRES



**Unimax**

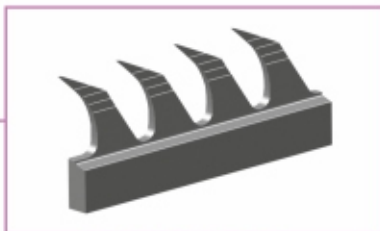


**UNISTAR PLUS**

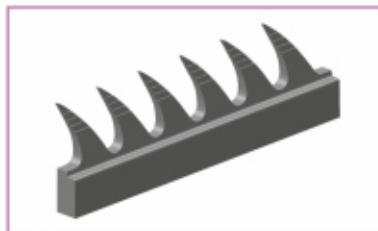


**UNISTAR**

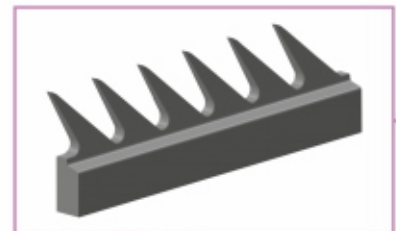
### DOFFER WIRES



**Unimax**



**UNISTAR SERRATED (R)**



**UNISTAR PLAIN (C)**

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

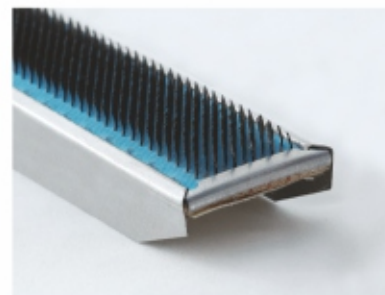
Doffer wire available in 310, 330 & 390 ppsi  
 Metallurgy : Unistar, Unichrome & Unicarb  
 Specification : DL 4030 X 0.9 310RC  
 DL 4030 X 0.85 330RC  
 DN 4030 X 0.85 390R  
 DN 4030 X 0.85 390C  
 DM 4030 X 0.8 400

### 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, 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 <sub>2</sub> 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

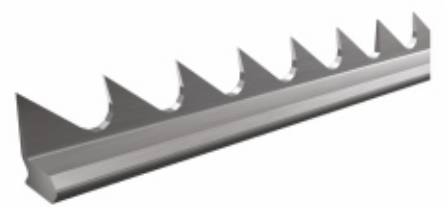
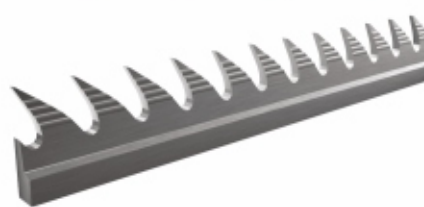
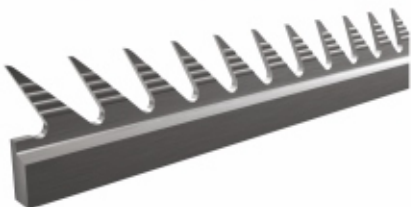
S.No	Type	Height	Rib	Angle	PPSI
1	DL 4030 x 0.85 RC - 330	4.0	0.85	30	330
2	DN 4030 x 0.85 R - 390	4.0	0.85	30	390
3	DM 4030 x 0.8 - 400	4.0	0.8	30	380
4	DL 4030 x 0.9 RC - 310	4.0	0.9	30	310
5	DK 4035 x 0.8 UC - 320	4.0	0.8	35	320
6	DL 4030 x 1.0 RC - 280	4.0	1.0	30	280
7	DM 4730 x 1.0 - 305	4.7	1.0	30	305
8	DM 5030 x 0.9 - 340	5.0	0.9	30	340

## 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
5	LV16 K-5020 - 10T	5.0	V16	20	10.0
6	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	1.1to1.6	0	3
2	GLD 5505 - 4T	5.5	1.1to1.6	5	4
3	GLE 5510 - 5T	5.5	1.1to1.6	10	5
4	GLE 5500 - 5T	5.5	1.1to1.6	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

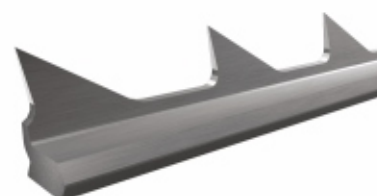
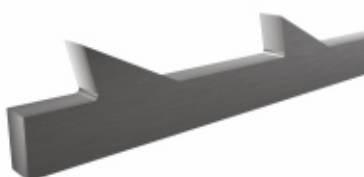
S.No	Type	Height	Rib	Angle	TPI
1	BR 10/0	10	2.5	0	2.5
2	BR 10/10	10	2.5	10	2.5
3	BR 20/0	10	2.5	0	1.5
4	BR 20/10	10	2.5	10	1.5

## 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	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	F <sub>2</sub> 3500 x 3.0	3.5	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	3.6	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

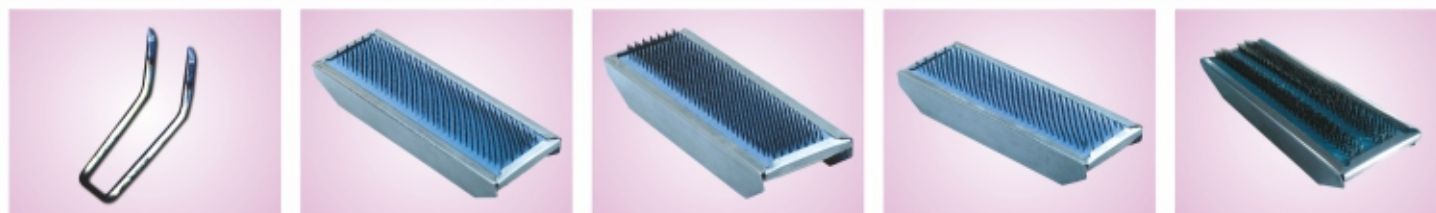
Suitable for Machine Models

SE7  
SE8  
SE9  
SE10  
SE11



# FLAT TOPS

Type	Specifications	PPSI	Suitable For	Features
<b>Stilo</b> 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 580	580		
	STILO 600	600		
	STILO 700	700		
Uno Series	UNO 310	310	Cotton & PC Blends (Polyester & Cotton)	<ol style="list-style-type: none"> <li>1. Uniform density - Flat tops wire PPSI uniform across the width of flat top.</li> <li>2. Unique setting pattern of flat tops provides better fibre trapping. Better elimination of short fibre &amp; neps at high production rates</li> </ol>
	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	<ol style="list-style-type: none"> <li>1. Synthetic tops - Tops with angle suitable for processing synthetic fibres.</li> <li>2. Reduces resistance in carding zone there by reduces static electricity and prevents card loading. Hightensile wires used to with stand load.</li> </ol>
	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	<ol style="list-style-type: none"> <li>1. Tops with open space in between.</li> <li>2. Reduced resistance to fibre flow.</li> <li>3. Lesser waste removal.</li> </ol>
	UNO - G 330	330		
Recto Series	RECTO 330	330	100% Polyester, Acrylic, Recycled waste & bleached cotton.	<ol style="list-style-type: none"> <li>1. Rectangular wire with no knee bend - Regrinding not required.</li> <li>2. Semi rigid tops - Extraction of low flat waste.</li> <li>3. Suitable for very coarse micronaire / denier fibres and sliver hanks.</li> </ol>

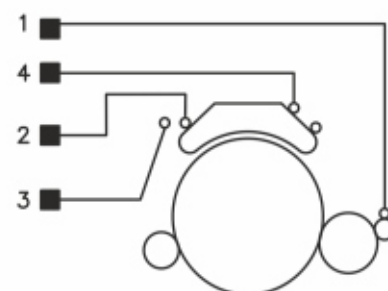


- ❖ Flat tops pins made out of **Special grade oil tempered steel with high fatigue properties.**
- ❖ Tips are extra hardened in advanced **HAQ** - method (Hydrogen fuel flaming and cryogenic quenching).
- ❖ This advanced treatment keeps the flat tops naturally clean, due to smooth surface finish.

# FILLET CHART

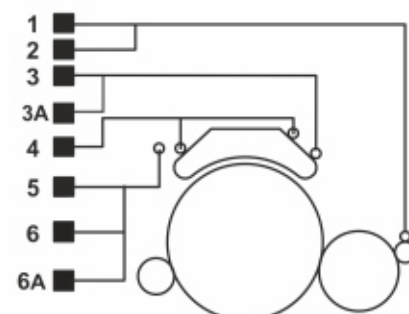
## LMW LC 636 (1.5 Meter Card)

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



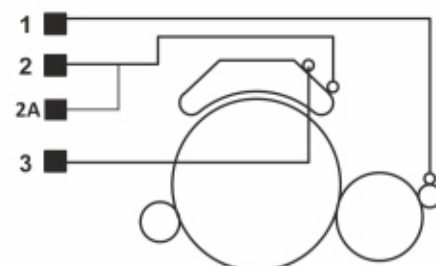
## LMW- LC100 / 300 / 300A / 300AV3 / 300AV4 / 333 / 361 / 363 CARDS

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



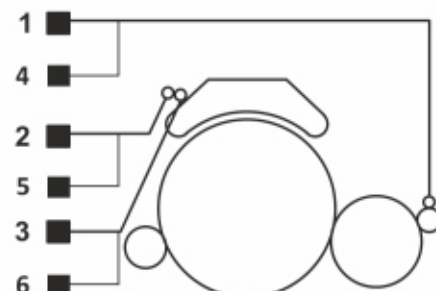
## LAKSHMI RIETER C 1/1 , C 1/2, C1/3 & TEXTTOOL-TC360,450 & SHANTHI SC2 CARDS

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 SERIES 03,05,5/1,5/3,07,08,10,11, 12, 15&19i 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
4	Cleaning fillet TR AP No.26 (TC11)	20 mtrs x 20 mm	20 mtrs
5	Cleaning fillet TR DP 18 - 1 (TC11)	14 mtrs x 28 mm	14 mtrs
6	Stripping fillet TR DS 609 (TC11)	12 mtrs x 40 mm	12 mtrs

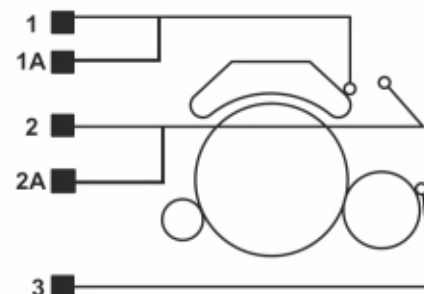


“These fillets are available in bright steel wire and stainless wire executions.”



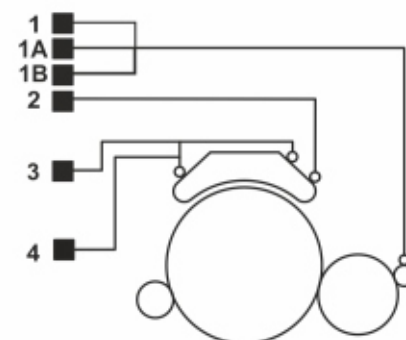
### CROSROL MK 4, MK5, MK 6 & MK 7 SERIES CARDS

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



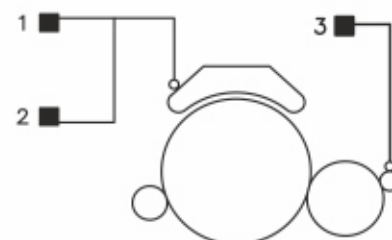
### RIETER C4,C10, C50, C51 CARDS

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

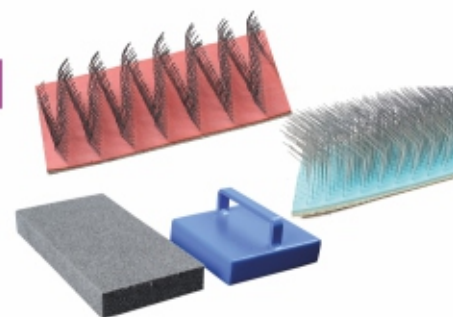


### RIETER C 70 CARD

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
3	Doffer cleaning fillet AP No.26	21 mtrs x 20 mm	21 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 cleaner 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

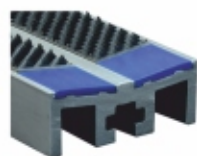
- ◆ Available for all make and model cards
- ◆ Periodical Replacement of SF Tops Enhance Cylinder and Flat Top Life.
- ◆ Stationary Flat Metallic wires are made out of imported NANO ALLOY STEELS
- ◆ Latest Tooth Geometry and angle Suitable for Super High Production Cards (up to 100kg/hrs)

Type		Card Make	Suitable For	PPSI
A		LMW Trutzschler	<ul style="list-style-type: none"> <li>◆ LC300, LC300A (above Lickerin SFL) Cards.</li> <li>◆ Under Lickerin Strip LC 333/LC 363 Cards.</li> <li>◆ DK 760 card (with Aluminium Bare Flat).</li> <li>◆ DK 780, DK803 cards.</li> </ul>	70,90,100,150, 250,350,450, 550,650
B		Trutzschler Rieter Crosrol Chinise	<ul style="list-style-type: none"> <li>◆ DK 740,760 (Cards with Cast Iron Bare Flat card) DK 800,903, TC-03,05,5/1,5/3, 07,08, 11 cards</li> <li>◆ C4, C10, C50, C51 / C60, C70 (40" / 60" Cards)</li> <li>◆ MK-4,5,6,7 cards</li> <li>◆ FA 203A, FA290C, FA225, JWF1203, JFA226E, JFA228A, FA231 Cards</li> <li>◆ ICC and ECC C' Cleaner Conversion Rieter and LMW Cards</li> <li>◆ ICC Under lickerin Segment strips</li> <li>◆ Marzoli - C 701, CX400, CX300, C40</li> <li>◆ LMW LC 361 / 363 card SFL &amp; SFD</li> </ul>	70,90,100,150, 250,350,450, 550,650
C		Trutzschler Rieter	<ul style="list-style-type: none"> <li>◆ Under lickerin Segment-DK740, 760, 780, 800 Cards.</li> <li>◆ Under lickerin Segment - C10, 50, 51 Cards (LCC &amp; UCC &amp; Lakzer - Segment)</li> <li>◆ C1/2,C1/3,LC100, LC300, LC300AV3 TC360, TC450,SC2 Cards.</li> <li>◆ CVT - FD6 Blowroom - S.F. Tops (1200mm)</li> </ul>	70, 90
D		Rieter	<ul style="list-style-type: none"> <li>◆ C60-Uniflex Carding Segment 40 PPSI (FD 4)</li> </ul>	40

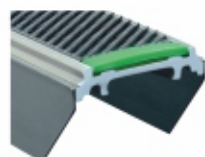
Type	Card Make	Suitable For	PPSI
E	Rieter	◆ C4 Card	70, 90



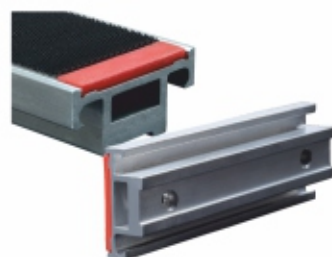
Type	Card Make	Suitable For	PPSI
F	Trutzschler	◆ TCO3, 05, 5/1, 5/3, 07, 08, 10 Cards Under lickerin Segment	70



Type	Card Make	Suitable For	PPSI
G	Crosrol Trumac Rieter Chinise	◆ MK4, MK5 Cards ◆ DK715, DK740 Cards ◆ C4 Card ◆ FA186F, FA20A, FA201B Cards	100, 150, 250 350, 450 550, 650



Type	Card Make	Suitable For	PPSI
H	LMW	◆ LC300A, 300AV3, 300AV4, 333, 361, 363 LC300, 300A( Above Doffer SFD) ◆ LCC-'C' Cleaner-C1/2,C1/3,LC100,TC360, TC450, SC2 ◆ LCC-'C' Cleaner-DK715, 740, 760, 780, C4, C10 ◆ All UCC & Lakzer - Conversion	70, 90, 100, 150, 250, 350, 450, 550, 650

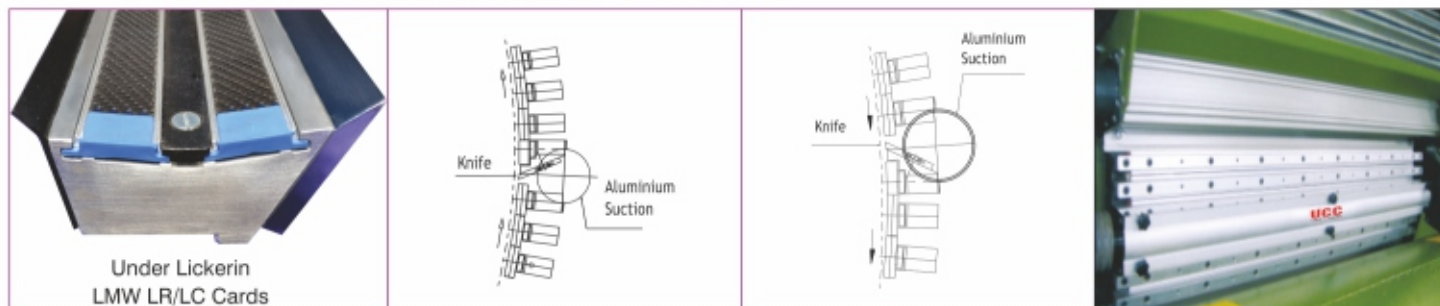


PPSI COLOR CODE	PPSI COLOR CODE	PPSI COLOR CODE
70 Blue	150 Green	450 Black
90 Dark Blue	250 Pink	550 Orange
100 Yellow	350 Blue	650 Red

**Note:** ◆ For normal cards 40" - 1.0 meter.  
 ◆ For Rieter C60, 70, LC636 - 60" - 1.5 meter.  
 ◆ For Trutzschler TC11, 15, 19i - 50" - 1.28 meter.  
 ◆ For Jingwei JFA 1204 A - 50" - 1.20 meter.

\* Price may vary as per card width

## EXTENDED STATIONARY FLAT SYSTEM

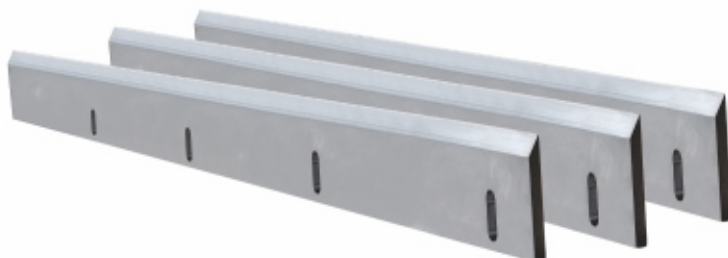


## CARD CONVERSION C-SYSTEM

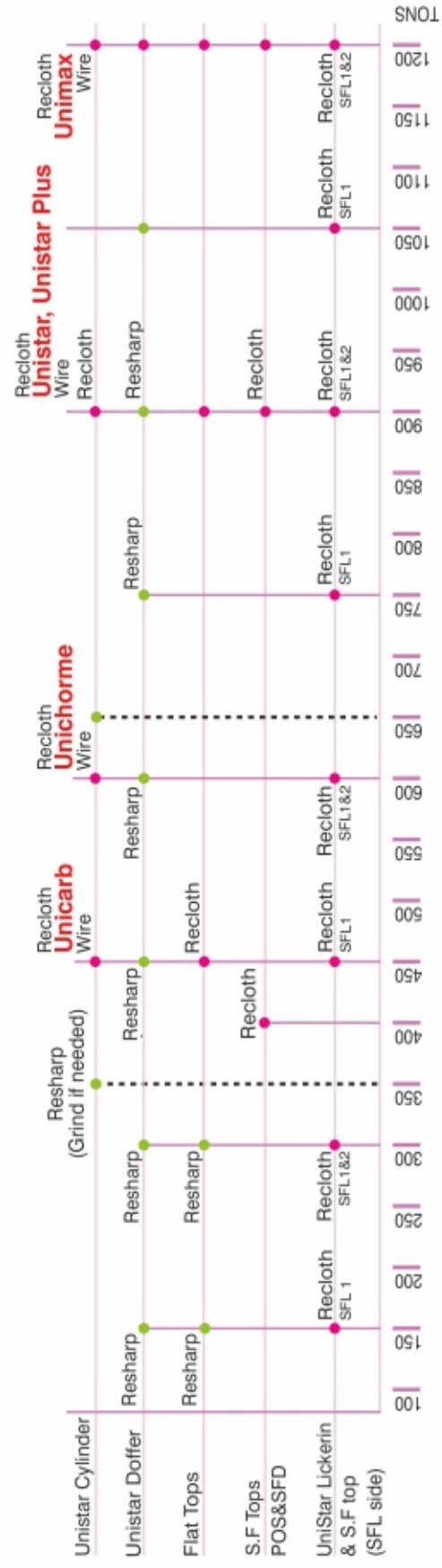
CARD MODEL	WIRE TYPE	TYPE OF CONVERSION
LR C1/1, C1/2, C1/3, TC360	Above Lickerin Above Doffer  Combing segment with Knife Combing segment without Knife	3F 3F+1K+1SD 6F+1K+1SD 2Pcs 2Pcs
DK 715, DK 740	Above Lickerin Above Doffer Combing segment	7F+1K+1SD 5F+1K+1SD 1 Pc
DK 760, 780, 800 / RIETER C4 & C10	Above Lickerin Above Doffer	8F+1K+1SD 6F+1K+1SD
DK 803	Above Lickerin Above Doffer	6F+1K+1SD 6F+1K+1SD
LC 300, 300A, 300Av3	Above Lickerin Above Doffer	Combing Bar 2 Pcs 6F+1K+1SD

## MOTE KNIFE

Under lickerin, above lickerin and above doffer C system mote knives available for different make of cards. Made of high grade steel with accuracy to endure longer."



## 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.
- ◆ For Viscose processing - 10% additional life excepted
- ◆ For 100% Polyester / dyed synthetic 15 % reduction in life expected.
- ◆ SFL 1 - 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 Spinning Medium Count		Ring Spinning Fine Count	
				20's - 40's	30's - 40's (Combed)	40's - 60's	Above 60's
	Micronaire Staple length (mm)	<5.0 20-22mm	3.5-.5.0 /≅27mm	3.5-.5.0 /≅27mm	3.5-.5.0 /≅27mm	2.5-.3.0≅30	2.5-.3.0≅30
Below 20Kgs / hr	Cylinder	CR 2030 x 0.5 CR 2520 x 0.6 CR 2030 x 0.6	CR 2520 x 0.7 CR 2520 x 0.6	CR 2030 x 0.5 CR 2035 x 0.5	CR 2030 x 0.5 CR 2040 x 0.5	CR 2030 x 0.5 CP 2035 x 0.4	CP 2035 x 0.4 CR 2030 x 0.5
	Doffer	DN 4030 x 0.85R DL 4030 X 0.9RC-310	DN 4030 x 0.85R DL 4030 X 0.9RC-310	DN 4030 x 0.85R DL 4030 X 0.9RC-310	DN 4030 x 0.85R DL 4030 X 0.9RC-310	DN 4030 x 0.85R DL 4030 X 0.9RC-310	DN 4030 x 0.85R DL 4030 X 0.9RC-310
	Flat Top	PG 330 UNO S300	UNO S300 RECTO 330	PG 430 PG 530 UNO 410 / 450	PG 530 UNO 510	PG 530 UNO 510 / 550	Stilo 580 & 600 UNO 550
	Lickerin	GLE 5510	GLD5505	GLE 5510	GLE 5510	GLE 5510	GLE 5510 GLD 5505
20-40 Kgs/ hr	Cylinder	CR 2030 x 0.5 CR 2030 x 0.6 CR 2520 x 0.6	CR 2520 x 0.7 CR 2520 x 0.6 CR 2025 x 0.6	CR 2030 x 0.5 CR 2035 x 0.5 CP 2035 x 0.4	CR 2035 x 0.5 CR 2040 x 0.5 CP 2035 x 0.4	CR 2035 x 0.5 CR 2040 x 0.5 CP 2035 x 0.4	CR 2035 x 0.4 CT <sub>2</sub> 2030 x 0.5 CP 2040 x 0.4
	Doffer	DN 4030 x 0.85R DL 4030 X 0.9RC-310	DN 4030 x 0.85R DL 4030 X 0.9RC-310	DN 4030 x 0.85R DL 4030 X 0.9RC-310	DN 4030 x 0.85R DM 4030 x 0.8	DN 4030 x 0.85R DM 4030 x 0.8	DN 4030 x 0.85R DM 4030 x 0.8
	Flat Tops	PG 430 UNO S400 (OE)	PG 330 RECTO 330	PG 530 UNO 450 / 510	PG 530 UNO 510 / 550	Stilo 580 & 600 UNO 550	Stilo 580, 600 & 700 UNO 550
	Lickerin	GLE 5510 LV8 5010	GLD 5505 LV8 5005	GLE 5510 LV8 5010	GLE 5510 LV8 5010	GLE 5510 LV8 5010	GLE 5510, GLD 5505 LV8 5010, LV8 5005
Above 40Kgs / hr	Cylinder	CR 2030 x 0.5 CR 2030 x 0.6 CR 2520 x 0.6	CR 2030 x 0.5 CR 2030 x 0.6	CR 2030 x 0.5 CR 2035 x 0.5 CR 2035 x 0.4	CR 2035 x 0.5 CP 2035 x 0.4	CP 2035 x 0.4 CP 2040 x 0.4 CT <sub>2</sub> 2030 x 0.5	CR 2035 x 0.4 CR 2040 x 0.4 CT <sub>2</sub> 2030 x 0.5
	Doffer	DN 4030 x 0.85R DL 4030 X 0.9RC-310	DN 4030 x 0.85R DL 4030 X 0.9RC-310	DN 4030 x 0.85R DL 4030 X 0.9RC-310	DN 4030 x 0.85R DM 4030 x 0.8	DN 4030 x 0.85R DM 4030 x 0.8	DN 4030 x 0.85R DM 4030 x 0.8
	Flat Tops	PG 430 UNO S400 (OE)	PG 430 PG 530	PG 530 UNO 450 / 550	Stilo 580 & 600 UNO 550, PG530	Stilo 580 & 600 UNO 550	Stilo 580, 600 & 700 UNO 550
	Lickerin	GLE 5510 LV8 5010	GLE 5510 LV8 5010	GLE 5510 LV8 5010	GLE 5510 LV8 5010	GLE 5510 LV8 5010	GLE 5510, GLD5505 LV8 5010, LV8 5005

## Card Clothing Recommendation Chart - Man Made Fibres

Production Rate	Process Count & Range	100% Polyester			100% Viscose	Polyester Viscose (Grey / Dyed)	PC Blends more Polyester Content	PC Blends more Cotton Content	Regenerated Fibres
		<1.0 dtex 38-55	1.2-3.0 dtex 38-55	<3.0 dtex					
Below 20Kgs / hr	Cylinder	CR 2525 x 0.5 CR 2530 x 0.5 CR 2520 x 0.6	CR 2520 x 0.7 CR 2520 x 0.6	CR 2820 x 0.7 CP 2815 x 0.8 CO 3210 x 0.9	CR 2530 x 0.5 CR 2530 x 0.5	CR 2520 x 0.6 CR 2520 x 0.7	CR 2520 x 0.6 CR 2525 x 0.6	CR 2530 x 0.5 CR 2530 x 0.6 CR 2030 x 0.5	CR 2520 x 0.7 H 2810 x 0.7
	Doffer	DN 4030 x 0.85R DM 4030 x 0.8	DN 4030 x 0.85R DL4030x0.9RC-310	DN 4030 x 0.85R DL4030x0.9RC-310	DN 4030 x 0.85R DM 4030 x 0.8	DN 4030 x 0.85R DL4030x0.9RC-310	DN 4030 x 0.85R DL4030x0.9RC-310	DN 4030 x 0.85R DL4030x0.9RC-310	DN 4030 x 0.85R DL4030x0.9RC-310
	Flat Tops	UNO S400 / 450	UNO S300/400 RECTO 330	UNO S300 RECTO 330	UNO S400 / 450	UNO S300 RECTO 330	UNO S400 RECTO 330	UNO S400 / 450	UNO S300 RECTO 330
	Lickerin	GLD 5505	GLD 5505	GLD 5505	GLD 5505 GLE 5510	GLD 5505	GLD 5505	GLD 5505	GLD 5505
20-40 Kgs / hr	Cylinder	CP 2525 x 0.5 CR 2530 x 0.5	CR 2520 x 0.7 CR 2520 x 0.6	CP 2815 x 0.8 CP 2820 x 0.7	CR 2030 x 0.5 CQ 2025 x 0.5	CR 2520 x 0.6 CR 2520 x 0.7	CR 2530 x 0.5 CR 2030 x 0.5 CP 2520 x 0.6	CR 2525 x 0.5 CR 2030 x 0.5	CR 2520 x 0.7 CR 2520 x 0.6
	Doffer	DN 4030 x 0.85R DM 4030 x 0.8	DN 4030 x 0.85R DL4030x0.9RC-310	DN 4030 x 0.85R DL4030x0.9RC-310	DN 4030 x 0.85R DM 4030 x 0.8	DN 4030 x 0.85R DL4030x0.9RC-310	DN 4030 x 0.85R DL4030x0.9RC-310	DN 4030 x 0.85R DL4030x0.9RC-310	DN 4030 x 0.85R DL4030x0.9RC-310
	Flat Tops	UNO S400 / 450	UNO S300 / 400 RECTO 330	UNO S300 RECTO 330	UNO S400 / 450 UNO S500 PG 530	UNO S300 UNO S400 / 450 PG 530	UNO S300 UNO S400 / 450	PG 430 UNO S400 / 450	UNO S300 RECTO 330
	Lickerin	GLD 5505 LV8 5005	GLD 5505 LV8 5005	GLD 5505 LV8 5005	GLD 5505 LV8 5005	GLD 5505 LV8 5005	GLD 5505 LV8 5005	GLD 5505 LV8 5005	GLD 5505 LV8 5005
Above 40Kgs / hr	Cylinder	CP 2025 x 0.5 CR 2530 x 0.5 CR 2030 x 0.5	CR 2520 x 0.6 CR 2520 x 0.7	CP 2815 x 0.8 CR 2820 x 0.7	CR 2030 x 0.5 CQ 2025 x 0.5	CR 2520 x 0.6 CR 2520 x 0.7	CR 2530 x 0.5 CR 2030 x 0.5 CR 2520 x 0.6	CR 2530 x 0.5 CR 2030 x 0.5	CR 2525 x 0.6 CR 2520 x 0.6
	Doffer	DN 4030 x 0.85R DM 4030 x 0.8	DN 4030 x 0.85R DL4030x0.9RC-310	DN 4030 x 0.85R DL4030x0.9RC-310	DN 4030 x 0.85R DM 4030 x 0.8	DN 4030 x 0.85R DL4030x0.9RC-310	DN 4030 x 0.85R DL4030x0.9RC-310	DN 4030 x 0.85R DL4030x0.9RC-310	DN 4030 x 0.85R DL4030x0.9RC-310
	Flat Tops	UNO S400 / 450 UNO S500 PG 530	UNO S300 / 400 RECTO 330	UNO S300 RECTO 330	UNO S400 / 450 UNO S500 PG 530	UNO S300 UNO S400 UNO S450	UNO S400 / 450 UNO 5500	UNO S400 / 450 UNO 5500	UNO S400 RECTO 330
	Lickerin	GLD 5505 LV8 5005	GLD 5505 LV8 5005	GLD 5505 LV8 5005	GLD 5505 LV8 5005	GLD 5505 LV8 5005	GLD 5505 LV8 5005	GLD 5505 LV8 5005	GLD 5505 LV8 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.



**UCC**  
CARD CLOTHING

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