



Maintenance recommendation

Recommendation for short staple card wire maintenance

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The quality of the card clothing is key for ensuring a good carding result. To maintain the carding result over the long term, the revolving tops, cylinder and doffer wires should be re-sharpened regularly and the lick-in wires, stationary flats, cleaning fillets, stripping and feed roller wires replaced in due time.

The following tables show the recommended maintenance intervals with steel qualities Super, Duratech and Ultra when using different fibers. **Super** is a special carbon steel. **Duratech** is a micro-alloyed steel quality with a higher wear resistance compared to the Super steel quality. **Ultra** is the most valuable steel quality, mainly used for special cylinder wires, interlocked lick-in wires and stationary flats.

Maintenance schedule for Super wire

100% combed cotton			Cylinder wires	Revolving tops *	Doffer wires **	Licker-in wires ***	Stationary flats Under licker-in ***	Stationary flats Pre-carding zone ***	Stationary flats Post-carding zone	Cleaning fillets	Stripping roller wires	Feed roller wires
100% viscose Blends cotton and MMF 100% carded cotton												
100% polyester												
Tonnage												
120-150	150-180	120-150										
170-200	210-240	170-200										
210-240	260-290	210-240										
300-330	370-400	300-330										
340-370	420-450	340-370										
390-420	470-500	390-420										
470-530	570-630	470-530										
2000	2000	2000										

▲ re-sharpening ● replacing

Maintenance schedule for Duratech wire

100% combed cotton fine yarn count	100% combed cotton medium yarn count	100% viscose Blends cotton and MMF 100% carded cotton	100% polyester	Cylinder wires	Revolving tops *	Doffer wires **	Licker-in wires ***	Stationary flats Under licker-in ***	Stationary flats Pre-carding zone ***	Stationary flats Post-carding zone	Cleaning fillets	Stripping roller wires	Feed roller wires										
Tonnage																							
100-130	150-200	200-250	150-200											▲	▲								
140-170	220-270	270-320	220-270													▲	●	●	●				
180-210	280-330	330-380	280-330											▲	▲								
260-290	410-460	460-510	410-460											▲	▲					●			
290-330	470-520	520-570	470-520													▲	●	●	●				
330-360	530-580	580-630	530-580											▲	▲								
400-450	650-750	700-800	650-750											●	●	●	●	●	●	●	●		
2000	2000	2000	2000									●	●										

▲ re-sharpening ● replacing



Maintenance schedule for Ultra wire

100 % combed cotton fine yarn count	100 % combed cotton medium yarn count	100 % viscose Blends cotton and MMF 100% carded cotton	100% polyester	Cylinder wires	Revolving tops *	Doffer wires **	Licker-in wires ***	Stationary flats Under licker-in ***	Stationary flats Pre-carding zone ***	Stationary flats Post-carding zone	Cleaning fillets	Stripping roller wires	Feed roller wires
Tonnage													
150-200	150-200	200-250	150-200	▲	▲								
220-270	280-330	340-390	280-330			▲	●	●	●				
280-330	360-410	430-480	360-410	▲	▲								
410-460	570-620	660-710	570-620	▲	▲					●			
470-520	650-700	730-780	650-700			▲	●	●	●				
530-580	770-820	880-930	770-820	▲	▲								
650-750	900-1000	1000-1100	900-1000	●	●	●	●	●	●	●	●		
2000	2000	2000	2000									●	●

▲ re-sharpening ● replacing

Remarks:

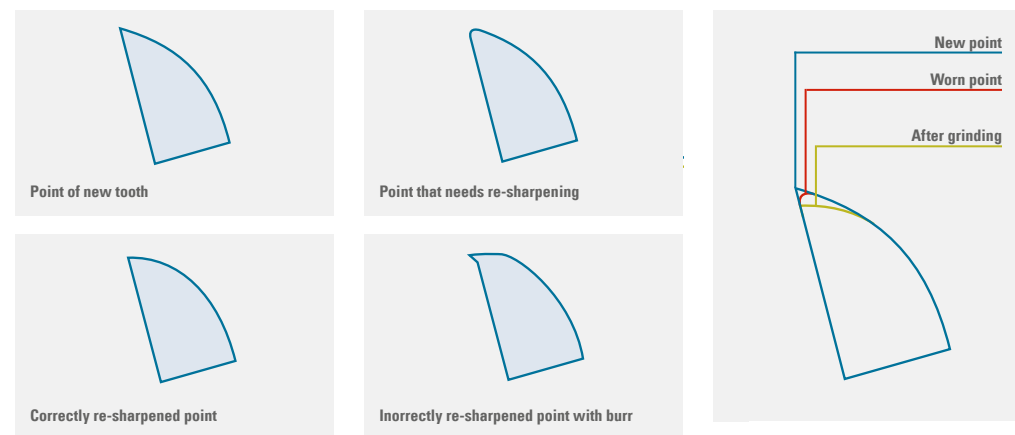
Groz-Beckert recommends that all re-sharpening be done with high precision equipment and by skilled technicians with care. The above maintenance schedules are only a general guideline while the optimum maintenance schedule and lifetime of wires in a specific application depend on fiber materials, card model, carding process, specific quality requirement on sliver or yarns, specific wire types and other factors. Upon your request, our experienced technical team can work out a customized wire maintenance program based on your specific carding conditions – for an optimum carding performance and a long wire lifetime. For further information, our experts will be pleased to help.

* To maintain an optimum carding performance, in some regions, revolving tops are changed around half the cylinder lifetime, depending on application and quality demand.

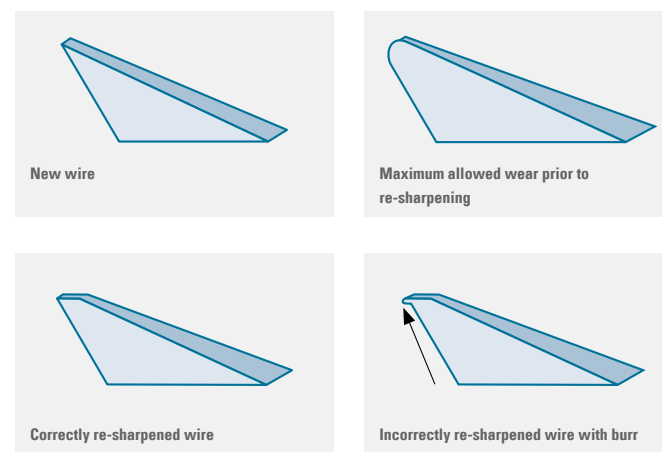
** In some regions, doffer wires are not re-sharpened, or they are re-sharpened only right before the end of their lifetime, depending on application and quality demand.

*** To maintain an optimum carding performance, in some cases it is recommended to replace licker-in wires and stationary flats under the licker-in and in the pre-carding zone more frequently, depending on application and quality demand.

Correct re-sharpening of revolving tops (1) as well as cylinder and doffer wires (2)



1



2