Tender No. B2

Compressive Shrinking Range (Sanforising)

Machine Specification

Fabric quality: 100 to 350 GSM Cotton shirting & Cotton Bottom weight (AVG GSM=200)

Max. fabric width : 1800mm

Min. fabric width : 600mm

Roller width : 2000mm

Nominal width (mm) : 200

Width of rubber belt (mm): 2000

Speed range: 5-100 m/min.

Infeed combination

1 High cloth inlet positioned on the frame of the fabric preparation unit
- cloth guidance system and manual width adjustment

2 Fabric preparation unit
- machine frame, traction roll with device.
- fabric overtension protection (rotary compensator)
- steaming cylinder for intensive and uniform vapourization of the fabric
- rotation sprayer for application of water on one side; evenly moistening of the fabric across the web width and without touching it, a start-stop device preventing the fabric from being over moistened at machine stop. required storage tank.
- rotation sprayer for application of water on one side;

3 Spreading unit with rotary tensioner and 1 curve rubber roller
- mounted directly at entry of shrinking range

4 Rubber-belt shrinking machine
- side frames
- water spray tubes cooling system for the rubber belt, pneumatically adjustable squeezing rollers for drying the rubber belt, extensive safety devices increase the safety of the operators.
- shrinking cylinder - 616 mm diameter,
- rubber belt, 67 mm thick, Dunline
- pressure rollers for pressing.
- tensioning roller with power adjustment.
- servo compensator for shrinking cylinder.
- steam and condensate fittings.

5 Grinding Device for rubber belt
- grinding roller diameter 315mm.

6 Vulcanize shoe for rubber belt

7 Felt calender -
- smooth/threaded guide roller at inlet
- drying cylinder - 2000 mm diameter,
- 1 felt drying cylinder, 800 mm diameter
- polyester needlefelt
- felt guide rollers
- steam and condensate fittings

8 Automatic shrinkage control

9 One rectangular control box and stand
- air conditioning at PLC touchscreen back

Outlet combination
10. cooling cylinder(s)

11 Surface-driven winder
- traversing roller
- pivoted arms for fabric guidance with
- 1 curve rubber roller and 1 driven spreading roller
- drive motor for control of winding tension
- winding diameter up to 2000 mm
for A-frame roller diameter minimum 200 mm, centre from 1140 to 1250 mm,

12 Folder
- common disconnection of the traction roller and the movement of the compensator for the folding arms
- cloth tension adjustable
- lap length 1000 mm

13 High-performance ionization unit
- 2 ionization rods, 1 for folder, 1 for batcher
14 Automatic shrinkage control
- with high sensitive fabric tension measuring devices, automatic adjustment of the rubber belt pressure for compensatin of shrinkage potential varying during one fabric lot.

15 Pick density counter
2 scanner assemblies, each consisting of optoelectronic scanner, light source high resolution passage counter special cable for passage counter control and display - profibus host-computer interface for integration with Quality.

16 Required damping unit,

17) J scray feeding & delivery end with compensator limit sensor,

18) Weft Straightener Qty.- 1 Nos

TECHNICAL DATA:

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>ROLLER WIDTH</td>
<td>2000 mm</td>
</tr>
<tr>
<td>FABRIC WIDTH</td>
<td>1800 mm</td>
</tr>
<tr>
<td>NUMBER OF SKEW ROLLS</td>
<td>3</td>
</tr>
<tr>
<td>NUMBER OF BOW ROLLS</td>
<td>3</td>
</tr>
<tr>
<td>NUMBER OF READING HEADS</td>
<td>4</td>
</tr>
</tbody>
</table>

AUTOMATIC WEFT STRAIGHTENER WITH ELECTRONIC CONTROL
ROLLER WIDTH 2000 MM X 1800 MM FABRIC WIDTH

Diagonal and bow weft offset correction system composed of (3 + 3):

- Nr. 1 oscillating frame with three stainless steel idle rollers for the correction of diagonal weft, powered by independent self-braking gear motor controlled by inverter – equipped also with manual push button control as well as automatic control.

- Nr. 3 bow extension rollers, adjustable and rotating on ball bearings. Orientation powered by independent, self-braking motor controlled by inverter – equipped also with manual push–button control as well as automatic control.

- The gear boxes driving the skew and bow correcting rollers are equipped with AC motors.

- Nr. 4 S.S.Idle transmission guide rollers made of AISI 304 stainless steel are provided to move the fabric through Reading Heads..
Control panel. Electrical switchboard, suitable for automation with automatic control. The control console is also fitted with a liquid crystal display to read all correction and working data.

**FIXED READING BRIDGE WITH 4 TWIN SCAN:**

Multi processor system, computing data signal of four optical heads distributed across the entire width of fabric detecting Skew or Bow deviation of the weft and give the command to Inverter driven skew / Bow motor to correct the deviation.

Reading head can operate either transparent mode or the reflect mode depends upon the fabric surface. The position of the Reading head can be adjusted with respect to the width of fabric.

**COMPUTER – “TOUCH SCREEN” WITH UPGRADED SOFTWARE**

Data control Liquid Crystal Display is connected to the system using a serial data communication line receiving the data relating to weft offset, machine speed, length of fabric processed, programme implemented, and so on.

The weft offset data are also used for real time display of the position of the weft in the fabric being processed and show as a graphic of the diagonal and curved offsets separately for a set time until 1 hour. The scale of the graph can be set by the operator.

**LCD DISPLAY**

New kind of LCD Display Panel is installed to observe / set the weft correction with functional keys. Most of the computer touch screen functions are in-corporate.

19) Batching & platter at delivery end.