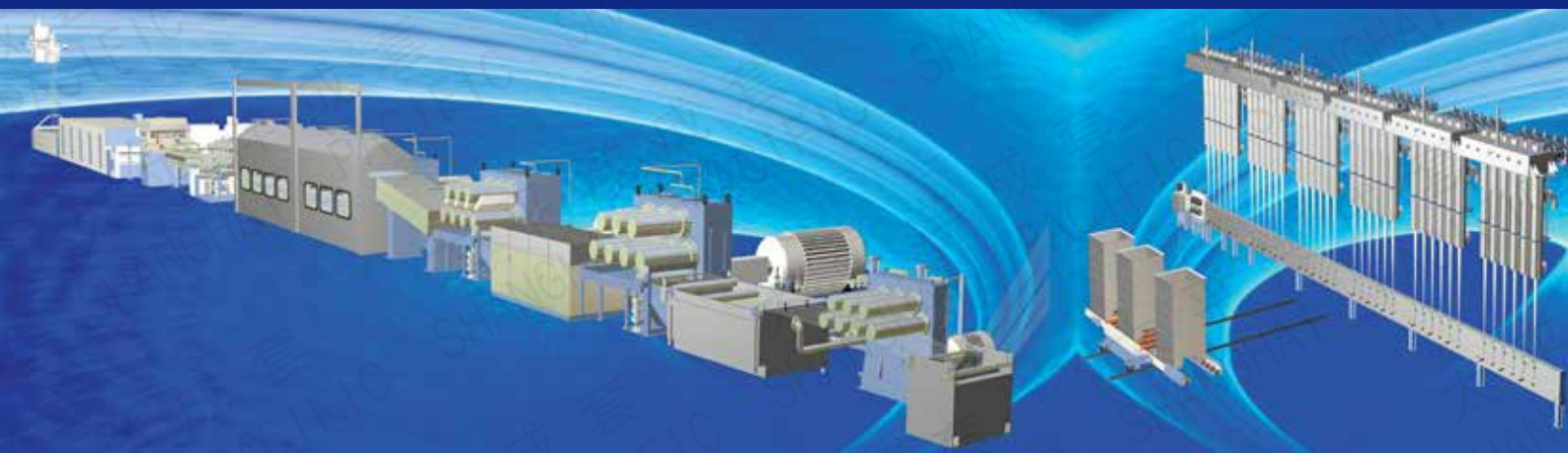




**太平洋成套**  
PACIFIC COMPLETE



# 涤纶短纤维成套设备

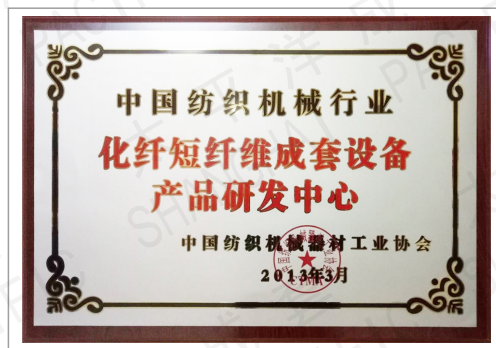
COMPLETE POLYESTER STAPLE FIBRE LINE



**上海太平洋二纺机化纤成套设备有限公司**  
SHANGHAI PACIFIC ERFANGJI SYNTHETIC FIBRE COMPLETE EQUIPMENT CO.,LTD.

# 涤纶短纤维成套设备

Complete equipment engineering

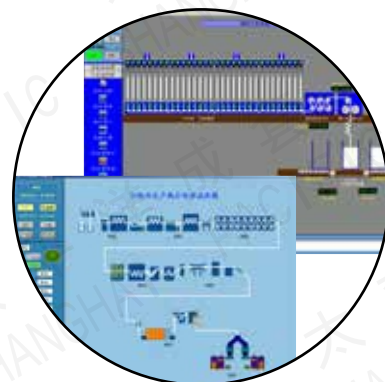


本公司专业从事以化纤设备为主的纺织机电工程项目,是中国纺织机械行业化纤短纤维成套设备产品研发中心,拥有多项国家发明专利。公司集产品开发设计、工程设计、工艺设计、制造加工、工程施工、安装调试开车为一体,实行工程总承包,实现成套设备交钥匙工程。同时,还提供各类纺织机械和配件的生产、销售。公司将不断开拓创新,为振兴上海纺机工业,服务国内外新老客户做出新的贡献。

Our company specialize in project of textile electrical and mechanical engineering mainly for chemical fiber equipment.

We are chemical staple fiber complete equipment R & D Center in China textile mechanical industry with multiple national invention patent. We handle key project from product exploration, engineering design, project design, process, manufacture, check on and install service to pro-operating with EPC contract for turnkey project . Meanwhile, we also supply all sorts of textile machinery and fittings. We will keep on innovating to make contribution to the revitalization of textile machinery industry in Shanghai and for serving new and old customers at home and abroad.

- ▶ 工艺设计 Processing design
- ▶ 设备安装、制造、投料试车 Installation, Start up
- ▶ 质量考核 Performance test



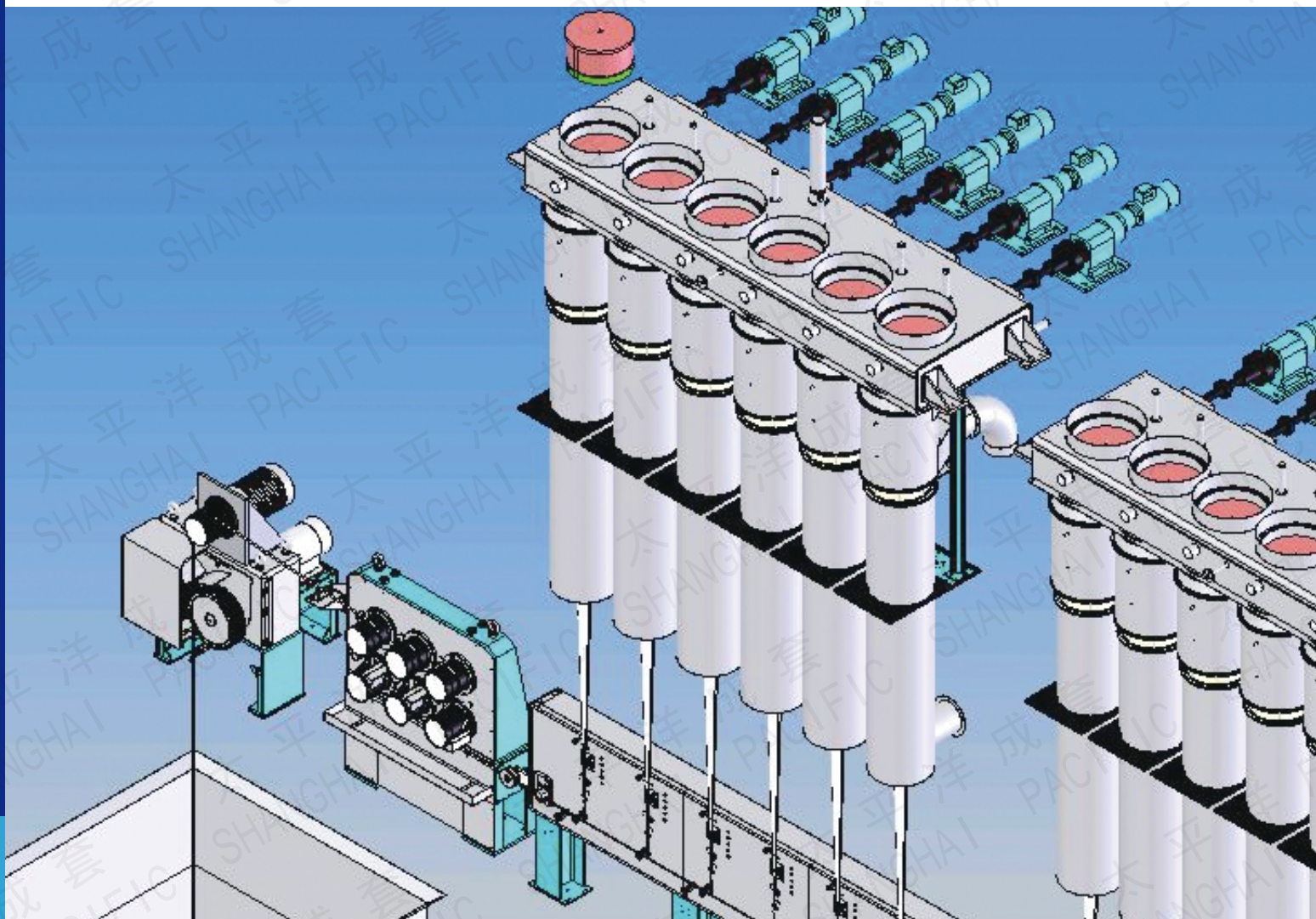
日产100吨涤纶短纤维纺丝联合机  
 100t/d Polyester staple fibre spinning line



日产100吨涤纶短纤维后处理联合机  
 100t/d Polyester staple fibre draw line

# 涤纶短纤维纺丝联合机

Spinning line for polyester staple fibre



## 纺丝联合机组成单元 Main units of spinning line

- |  |   |
|--|---|
|  纺丝机    |  Spinning machine    |
|  卷绕机    |  Take-up machine     |
|  丝桶往复装置 |  Can traverse device |

## 关键技术 Key technology

### ■ 中心吹风装置 In-to-out quenching device

低阻尼内环吹（从内向外径向吹风）开放风窗形式，低风压中心吹风装置（支风管风压2000Pa），低阻尼整流装置便于清洗。采用狭缝式环形上油技术，提高原丝上油率。

Low pressure in-to-out open quenching system, open window type, quenching-from inner to outer radial blowing, Max quenching air pressure 2000Pa, The low-damping rectifier is easy to clean. Adopts the annular spin finishing slit in quenching window.

### ■ 环吹风装置 Out-to-in quenching device

采用全封闭式外环吹风冷却形式，带自动控制系统。原丝上油采用环形内唇溢流式上油盘，整流器拆装方便，清洗便利。

It adopts the form of completely sealed Annular Quenching system(Out-to-in)with automatic adjustment on valve. Tow spin finishing adopts slit preparation ring and preparation is at the inner side of the ring. Rectifier is easy to mount and clean.

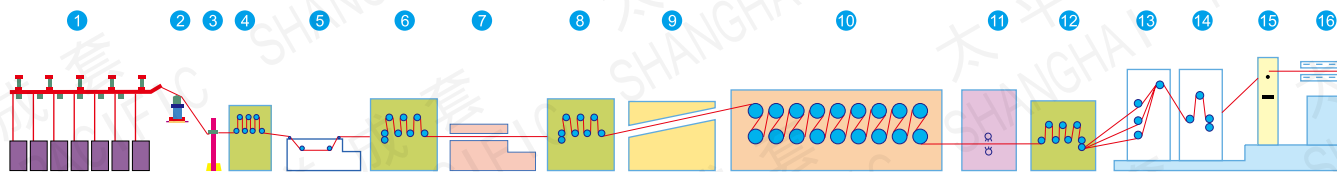
### ■ 喂入机 feeding machine

采用导入轮加喂入轮形式，辊体表面喷涂 $Al_2O_3$ 。喂入轮采用异步电机加编码器通过高精度齿轮传动。喂入轮材料改用铝合金色减轻重量同时减少运行时的不平衡离心力。Feeding machine adopts the combined form of sunflower and guiding roller. The surface of rollers is coated with  $Al_2O_3$ . The guiding rollers are driven by asynchronous motor controlled by coder through high precise gear. The material of huiding rollers adopts aluminum alloy to reduce the unbalance centrifugal power when running.



# 涤纶短纤维牵伸联合机

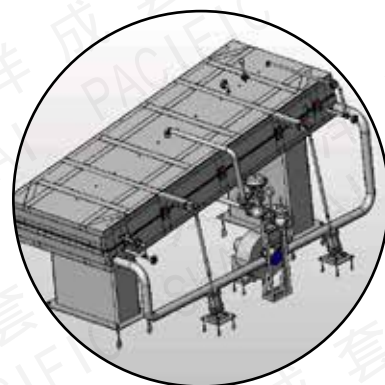
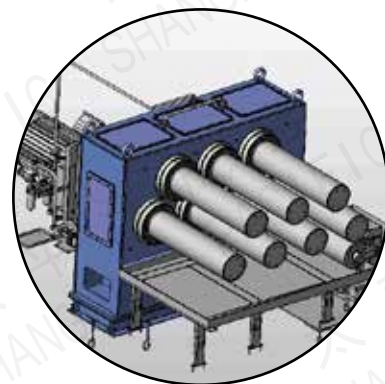
Polyester staple fiber drawing line





## 牵伸联合机主要组成单元 Main Units Of Drawing Line

- |          |                                     |
|----------|-------------------------------------|
| ① 集束架    | ① Can-type creel                    |
| ② 上导丝架   | ② Top guide creel                   |
| ③ 下导丝架   | ③ Bottom guide creel                |
| ④ 导丝机    | ④ Tow guide stand                   |
| ⑤ 浸油槽    | ⑤ Immersion bath                    |
| ⑥ 第一牵伸机  | ⑥ Draw stand 1                      |
| ⑦ 水浴牵伸槽  | ⑦ Draw chest                        |
| ⑧ 第二牵伸机  | ⑧ Draw stand 2                      |
| ⑨ 蒸汽加热箱  | ⑨ Steam chest                       |
| ⑩ 紧张热定型机 | ⑩ Tension heat-setting machine      |
| ⑪ 喷淋冷却装置 | ⑪ Spray-type cooler                 |
| ⑫ 第三牵伸机  | ⑫ Draw stand 3                      |
| ⑬ 叠丝机    | ⑬ Tow stacker                       |
| ⑭ 三辊牵引机  | ⑭ 3 rollers                         |
| ⑮ 张力架    | ⑮ Tension frame                     |
| ⑯ 卷曲预热箱  | ⑯ Steam pre-heater                  |
| ⑰ 卷曲机    | ⑰ Crimper                           |
| ⑱ 铺丝机    | ⑱ Tow spreading machine             |
| ⑲ 上油机    | ⑲ Finish applying device (optional) |
| ⑳ 烘干机    | ⑳ Drying device                     |
| ㉑ 捕结器    | ㉑ Knot detector                     |
| ㉒ 曳引张力机  | ㉒ Tow tension stand                 |
| ㉓ 切断机    | ㉓ Cutter                            |
| ㉔ 打包机    | ㉔ Baler                             |



# 涤纶短纤维牵伸联合机

Polyester staple fiber drawing line

## 关键技术 Key technology

### ■ 紧张热定型机 Annealer

四区18-22辊热定型机，齿轮、轴承润滑采用无油管、内壁油淋式循环制润滑。法兰连接夹套式定型辊结构，定型轴与传动齿轮采用过盈配合连接。带有自动停车控制的润滑检测系统。

4 groups of totally 18-22 rollers. Circulating oil bath for gears and bearings at top of inside wall. Jacket type roller connected with flange. Shaft and gears are connected by tight fits. Lubrication inspection system with auto-stop control.



### ■ 卷曲机 Crimper

采用高密度卷曲技术，整体式卷曲辊结构，旋转式铜侧板，单独电机变频传动。

High-density crimping technology, with integral crimp roller, revolving copper side panel and individual inverter.





## ■ 切断机 Cutter

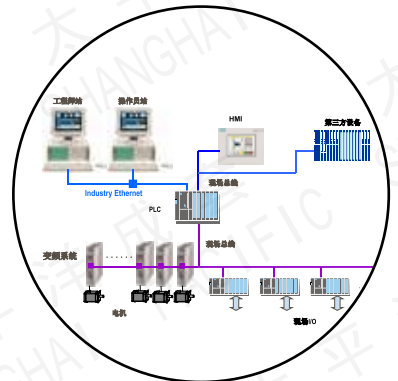
采用高旦数切断技术，整体式机架，压切式结构，大直径刀盘，在线式换刀盘机构，自动启闭密封罩机构，防倒拖功能。

High denier cutting technology, with integral frame, press cutting structure, big diameter blade disc, online switching blade disc, automatic open and close of sealing cover and the function of preventing inverse dragging.

## ■ FCS电气控制系统 Electric control system

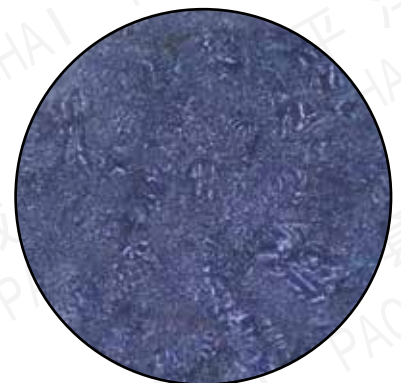
基于现场总线的FCS控制系统。开放式的总线，可以容纳第三方设备。大功率、高精度的直流母线变频传动系统，确保设备各单元机升降速的同步。全数字化、全现场化控制，实现了设备集中监控。

FCS electric control system. FCS with open end can be connect with third party equipment. Big capacity and high accuracy DC bus inverter driving system guarantees synchronous lifting of each unit machine. Completely digitalized site control realizes intergrated monitor and control.



# 产品品种和技术数据

Product and specifications



## 产品品种 Type of product fibre

- ▶ **棉型涤纶短纤维**  
Cotton type polyester staple fibre
- 高强低伸涤纶短纤维**                      0.89 dtex-2.22 dtex  
    Hi-strength less lengthening polyester staple fibre.
- 普棉型涤纶纤维**                              1.56 dtex-3.33 dtex  
    Normal cotton type polyester staple fibre.
- 毛型涤纶短纤维**                              3.33 dtex-16.67 dtex  
    Wool type polyester staple fibre.
- ▶ **中空三维卷曲涤纶短纤维**  
3D crimped hollow polyester staple fibre.
- 中空三维卷曲涤纶短纤维(有硅)**              3.33 dtex-16.67 dtex  
    3D crimped hollow polyester staple fibre with silicon.
- 中空三维卷曲涤纶短纤维(无硅)**              3.33 dtex-16.67 dtex  
    3D crimped hollow polyester staple fibre silicon free.
- ▶ **有色、异形、超长、超短、超细等短纤维产品**  
Color, abnormality, over-length, over-short, super-thin fibre.

## 技术数据 Technical data

项目 (item)		单位 (unit)	数据 (specifications)				
纺 织 联 合 机 Spinning line	适纺线密度 Spun yarn count	tex	0.89~1.56				
	成品丝日产量 Daily output of fibre	t	25	50	100	150	200
	纺丝位数 No. of spinning postions	位 position	12(16)	24	32	36	36(40)
	纺丝箱数 No. of spinning beams	pcs	2(2)	4	4	6	6(5)
	纺丝位距 Spinning postions gauge	mm	650(500)	650	500	650	650
	喷丝板直径 Diameter of spinneret	mm	328(220)	328	234	400	405
	喷丝板孔数 No. of holes on spinneret	孔 hole	2592(2210)	2592	3780	4800	5000
	纺丝速度 Spinning speed	m/min	500~1300	500~1300	500~1500	500~1500	500~1500
	纺丝泵规格 Specification of spinning pump	ml/r	70	70	100	120	120
	盛丝桶尺寸 Size of can	mm	1410×1410×1700 L×B×H	1800×1800×2000 L×B×H	2250×2250×2900 L×B×H	2600×2600×3690 L×B×H	2600×2600×3690 L×B×H
牵 伸 联 合 机 Drawing line	总牵伸旦数 Total drafting denier	10 <sup>4</sup> dtex	120	177	378	520	696
	机械速度 Design speed	m/min	200	280	300	300	300
	工艺速度 Processing speed	m/min	150	250	250	250	250
	适纺细度 Fineness	dtex	1.33~3.33	1.33~3.33	0.89~3.33	1.33~3.33	1.33~3.33
	卷曲轮宽度 Crimping roller width	mm	200	270	400	550	640
	装置容量 Installation power	kw	380	950	2300	3700	4600
	传动方式 Driving type		多单元传动 Multi-unit driving	多单元传动 Multi-unit driving	多单元传动 Multi-unit driving	多单元传动 Multi-unit driving	多单元传动 Multi-unit driving
	包重 Bale weight	kg/bale	300	300	350	350	350
	成包能力 Capacity of baler	bales/h	4.2	8.5	17.2	28.5	28.5

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上海太平洋二纺机化纤成套设备有限公司  
SHANGHAI PACIFIC ERFANGJI SYNTHETIC FIBRE COMPLETE EQUIPMENT CO.,LTD

地址：中国上海市静安区  
恒丰路600号9楼A区

电话：021-65318888

传真：021-65316186

邮编：200070

网址：[www.tpyct.com](http://www.tpyct.com)

Add: 9A, No.600, Hengfeng Road,  
Shanghai, P.R.China

Tel: 021-65318888

Fax: 021-65316186

Post: 200070

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