






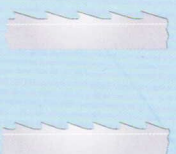
## CYLINDER WIRES

**Grandtexco Card Clothing** completely considered the customers' need and do the following designs: 2.00mm height card wire is fit for the conventional and high production carding machine and the tooth shape are helpful to prevent trash sticky such as seed, Neps.

2.50mm height card wire is fit for the conventional and high production carding machine as well as all all synthetic.

**Grandtexco Cylinder wires** have high quality and long life alloy steel type.

### 1.80-2.0mm CYLINDERS

Wire type	 Height	 Angle	 Pitch	 Rib	 PPSI	Tooth shape
C2035 x 1540	2.00	35	1.50	0.40	1075	
C1840 x 1740	1.80	40	1.70	0.40	950	
C2040 x 1740	2.00	40	1.70	0.40	950	
C2035 x 1740	2.00	35	1.70	0.40	950	
C2030 x 1740	2.00	30	1.70	0.40	950	
C2030 x 1545	2.00	30	1.50	0.45	945	
C2035 x 1350	2.00	35	1.30	0.50	993	
C2040 x 1550	2.00	40	1.50	0.50	860	
C2035 x 1550	2.00	35	1.50	0.50	860	
C2030 x 1550	2.00	30	1.50	0.50	860	
C2030 x 1365	2.00	30	1.30	0.65	760	
C2030 x 1560	2.00	30	1.50	0.60	720	
C2030 x 1565	2.00	30	1.50	0.65	660	

### 2.50mm CYLINDERS

Wire type	 Height	 Angle	 Pitch	 Rib	 PPSI	Tooth shape
C2530 x 1550	2.50	30	1.50	0.50	860	
C2525 x 1550	2.50	25	1.50	0.50	860	
C2525 x 1650	2.50	25	1.60	0.50	800	
C2530 x 1560	2.50	30	1.50	0.60	720	
C2525 x 1560	2.50	25	1.50	0.60	720	
C2520 x 1560	2.50	20	1.50	0.60	720	
C2520 x 1760	2.50	20	1.70	0.60	630	
C2515 x 1690	2.50	15	1.80	0.80	450	
C2515 x 1890	2.50	15	1.80	0.90	400	
C2510 x 3090	2.50	10	3.00	0.90	250	

## DOFFER WIRES









The **Doffer Wires** have straight and curved teeth and the teeth can be with or without striations.

The **Grandtexco Doffers** are of excellent punching quality with half-round tooth tip, as well as precise manufacturing tolerance and are widely used and maintenance free.

### PLAIN DOFFERS

Wire type	 Height	 Angle	 Pitch	 Rib	 PPSI	Tooth shape
D4030 x 2090B	4.00	30	2.00	0.90	365	
D4030 x 2090	4.00	30	2.00	0.90	365	
D4030 x 1890	4.00	30	1.80	0.90	398	
D4030 x 2080	4.00	30	2.00	0.80	403	
D5030 x 2390	5.00	30	2.30	0.90	341	



### STRIATED DOFFERS

Wire type	 Height	 Angle	 Pitch	 Rib	 PPSI	Tooth shape
D4030 x 2090BR	4.00	30	2.00	0.90	365	  
D4030 x 2090R	4.00	30	2.00	0.90	365	
D4030 x 1890R	4.00	30	1.80	0.90	398	
D4030 x 2080R	4.00	30	2.00	0.80	403	
D4030 x 2110R	4.00	30	2.10	1.00	300	
D5030 x 2390R	5.00	30	2.30	0.90	341	

## LICKERIN WIRES

**Grandtexco Licker-in wires** can be classified into plain tooth grooved type and interlocking type.

### GROOVED LICKERINS

Wire type	 Height	 Angle	 Pitch	 Rib	 PPSI	Tooth shape
L5515 x 4.5TPI	5.50	15	5.60	Var	36	 
L5510 x 4.5TPI	5.50	10	5.60	Var	36	
L5510 x 5.0TPI	5.50	10	5.10	Var	40	
L5505 x 5.0TPI	5.50	5	5.10	Var	40	
L5505 x 3.5TPI	5.50	5	7.10	Var	29	
L5500 x 5.0TPI	5.50	0	4.80	Var	42	
L5500 x 3.3TPI	5.50	0	7.60	Var	26	

### INTERLOCKING LICKERINS






Wire type	 Height	 Angle	 Pitch	 Rib	 PPSI	Tooth shape
L5000 x 6330V	5.00	0	6.30	3.00	25	  
L5000 x 5030V	5.00	0	5.00	3.00	43	
L5005 x 6030V	5.00	5	6.00	3.00	35	
L5010 x 5030V	5.00	10	5.00	3.00	43	
L5015 x 5030V	5.00	15	5.00	3.00	43	
L5015 x 5621V	5.00	15	5.60	2.10	55	
L5005 x 5321V	5.00	5	5.30	2.10	60	
L5005 x 2621V	5.00	5	2.60	2.10	120	
L5010 x 2621V	5.00	10	2.60	2.10	120	
L5020 x 2621V	5.00	20	2.60	2.10	120	
L5020 x 2515V	5.00	20	2.50	1.50	172	
L5010 x 2015V	5.00	10	2.00	1.50	215	
L5020 x 2015V	5.00	20	2.00	1.50	215	

## FLAT TOPS

Grandtexco flat top is fit for all kinds of carding machine and fiber.

- The tooth tip is specially hardened to better maintain the wire shape and prolong the service life of the flat top.
- The cloth foundation is made from 7 ply fabric and synthetic rubber, which will keep the stability of the flat top under the increased carding force.

## SETTING PATTERNS

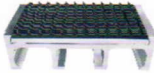
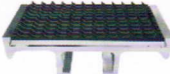


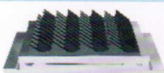
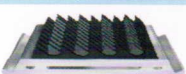



<p>MCZ18</p>  <p>180</p>	<p>MCZ24</p>  <p>240</p>	<p>MCZ28</p>  <p>280</p>	<p>MCZ32</p>  <p>320</p>	<p>MCC29</p>  <p>290</p>	<p>MCC36</p>  <p>360</p>	<p>MCC44</p>  <p>440</p>
<p>MCB30</p>  <p>300</p>	<p>MCB33</p>  <p>330</p>	<p>MCB38</p>  <p>380</p>	<p>MCB45</p>  <p>450</p>	<p>MCB52</p>  <p>520</p>	<p>MCB55</p>  <p>550</p>	
<p>WPT33</p>  <p>330</p>	<p>WPT42</p>  <p>420</p>	<p>WPT45</p>  <p>450</p>	<p>WPT48</p>  <p>480</p>	<p>WPT52</p>  <p>520</p>	<p>WPT55</p>  <p>550</p>	

## STATIONARY FLATS

Grandtexco stationary flats are fit for all models.

- Grandtexco stationary flat top uses high quality and long life alloy steel.
- The micro alloy steel wire stationary flat top is of longer service life, stable quality and will decrease the maintenance fee.
- The geometrics design of the card clothing will protect the fiber and keep the cleanness of flat top under running.
- Production technology will make sure that the flat top is of high precision and it is easy to set the space between licker-in roller and cylinder.

Grandtexco stationary flats are fit for all kinds of carding machine and improved equipment.

EXTRUSIONS	PRODUCT TYPES
	WL WSVT Fit for Crosrol, Trutzschler, Rieter and other kinds of aluminum bars carding machine.
	WLM WLMVT Fit for Chinese model with aluminum bars.
	WL-2 WL-2VT Fit for Trutzschler carding machine and improved type with aluminum bars and assorted with DK760mm
	WLC WLCVT It is easy to fix the whole clip with alminum bars and iron bars.
	WLT Fit for Rieter and Trutzschler blowrooms and segments under licker-in roller.
	WLH Designed for Rieter C4 segments under licker-in roller.
	WLE Fit for Jintan and other segments under licker-in roller.
	WLR underlickerin segment Designed for Trutzschler cast iron segments under licker-in roller.
	WLO underlickerin segment Designed for Trutzschler segments of the triple licker-in roller carding machine and assorted with DK903, TC03.

### Stationary Flats and PPSI







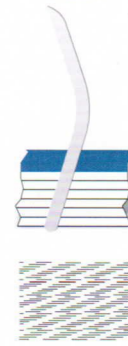











Wire type	PPSI	PPSI	PPSI	PPSI	PPSI	PPSI	PPSI	PPSI	PPSI
WL		60	90	140	240	320	420	550	640
WLVT								550	
WLM			90	140	240	320	420	550	640
WLMVT								550	
WL-2			90	140	240	320	420	550	640
WL-2VT								550	
WLC		60	90	140	240	320	420	550	640
WLCVT								550	
WLT	40	60	90						
WLH		60	90						
WLE		60	90						
WLR		60	90						
WLO			90						

## FLAT TOPS

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- The cloth foundation is made from 7 ply fabric and synthetic rubber, which will keep the stability of the flat top under the increased carding force.









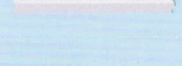
## SETTING PATTERNS

<p>MCZ18</p>  <p>180</p>	<p>MCZ24</p>  <p>240</p>	<p>MCZ28</p>  <p>280</p>	<p>MCZ32</p>  <p>320</p>	<p>MCC29</p>  <p>290</p>	<p>MCC36</p>  <p>360</p>	<p>MCC44</p>  <p>440</p>
<p>MCB30</p>  <p>300</p>	<p>MCB33</p>  <p>330</p>	<p>MCB38</p>  <p>380</p>	<p>MCB45</p>  <p>450</p>	<p>MCB52</p>  <p>520</p>	<p>MCB55</p>  <p>550</p>	
<p>WPT33</p>  <p>330</p>	<p>WPT42</p>  <p>420</p>	<p>WPT45</p>  <p>450</p>	<p>WPT48</p>  <p>480</p>	<p>WPT52</p>  <p>520</p>	<p>WPT55</p>  <p>550</p>	

## BLOWROOM WIRES

**Blowroom Wires Grandtexco** blowroom wires can be classified into the cone wire type and normal processed wire type.





**Grandtexco Blowroom Wires** It will do harm to the fiber under blowing process. And the harm will be more serious when opening, especially if higher production efficiency request. To use the brushed blowroom wires can reduce the fiber damage.

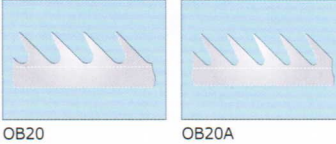
Wire type	 Height	 Angle	 Pitch	 Rib	 PPSI	Tooth shape
1000 x 1825 ERM 20/0		0	18.20	2.50	14	
1010 x 1825 ERM 20/10	10.00	10	18.20	2.50	14	
1000 x 1025 ERM 10/0	10.00	0	10.00	2.50	26	
1010 x 1025 ERM 10/10	10.00	10	10.00	2.50	26	
10-10 x 1222 A356	10.00	-10	12.25	2.20	24	
5925 x 2610 B662	5.90	25	26.00	1.05	24	
4035 x 1014 B455	4.00	35	10.20	1.40	45	
V5 8515 x 9951	8.50	15	9.90	5.08	13	
V5 8520 x 9951	8.50	20	9.90	5.08	13	
V6 55-06 x 8142 F100	5.50	-6	8.10	4.23	19	
V6 5510 x 8542 TR10	5.50	10	8.50	4.23	18	
V6 5510 x 8542 TR15	5.50	10	8.50	4.23	18	
V6 55-10 x 5442 TR11	5.50	-10	5.40	4.23	28	
V6 5515 x 5042 TR35	5.50	15	5.00	4.23	31	
V6 5520 x 8542	5.50	20	8.50	4.23	18	
V6 5520 x 5042 TR2	5.50	20	5.00	4.23	31	
V6 5520 x 5042 TR3	5.50	20	5.00	4.23	31	
V6 5520 x 5042 TR50	5.50	20	5.00	4.23	31	
V6 5530 x 6542	5.50	30	6.50	4.23	23	
V6 5530 x 6542 TR8	5.50	30	6.50	4.23	23	
V6 55-36 x 5542 TR6	5.50	-36	5.50	4.23	28	
V6 6010 x 1542 NT1A	6.00	10	15.00	4.23	10	
V6 6020 x 7842 NT2A	6.00	20	7.80	4.23	19	
V6 7510 x 1542 TR13	7.50	10	15.00	4.23	10	
V6 7510 x 1542 TR14	7.50	10	15.00	4.23	10	
V6 7510 x 7542 CR1	7.50	10	7.50	4.23	20	
V6 7520 x 1042 TR4	7.50	20	10.00	4.23	15	
V8 5020 x 1432 TR7	5.00	20	14.50	3.17	14	
V8 5520 x 6532	5.50	20	6.50	3.17	31	
V8 6020 x 6332 NT3A	6.00	20	6.30	3.17	32	
V10 4740 x 5325	4.70	40	5.30	2.54	48	
V10 4200 x 1625	4.20	0	16.60	2.54	20	

## OE WIRES


Grandtexco OE Wires is made from high quality and long life Micro alloy steel.

Grandtexco Card Clothing can be polishing processed as customer's special request.

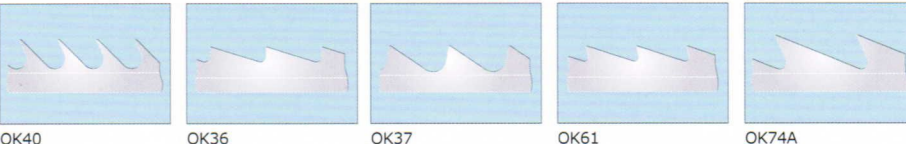
Wire type	 Height	 Angle	 Pitch	 Rib
OS21	3.60	15	3.25	0.90
OS21A	4.10	15	3.25	0.94
OK61	3.60	15	4.00	0.90
OK40	3.60	25	2.62	0.90
OK37	3.60	-10	4.70	0.90
OK36	3.60	0	4.00	0.90
OB20	3.60	25	2.12	0.90
OB20A	4.10	25	2.12	0.94
OK74A	4.10	25	6.00	0.94

OB20      OB20A

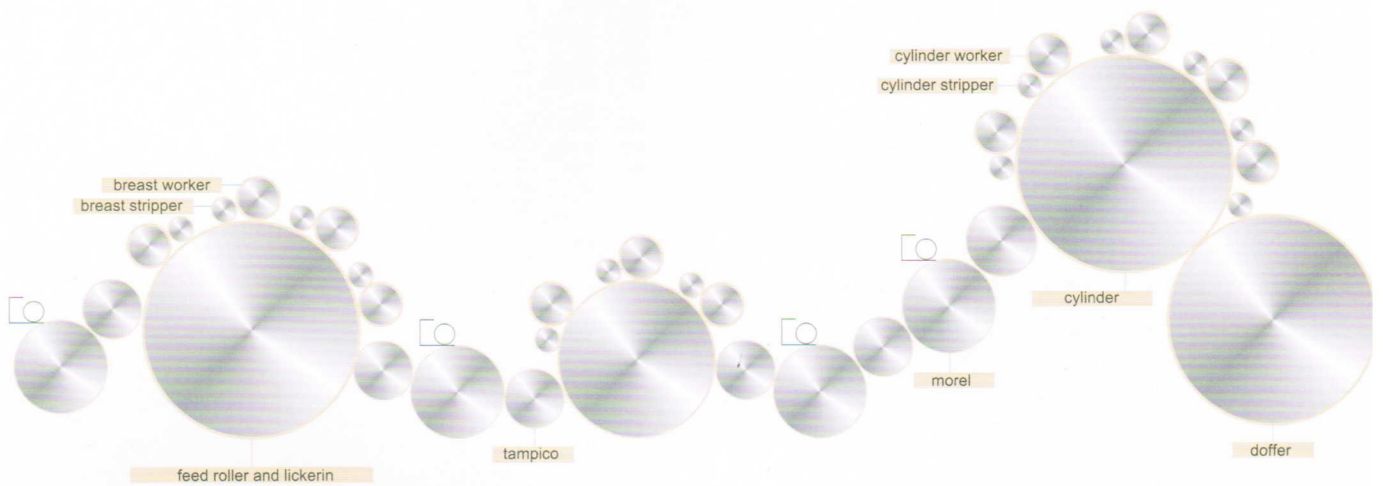
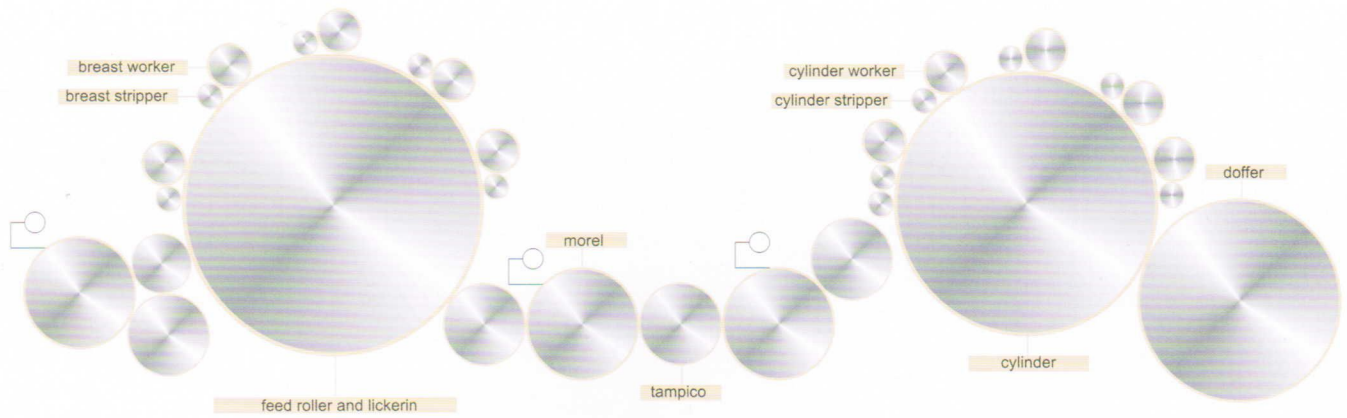
  


OS21      OS21A

OK40      OK36      OK37      OK61      OK74A

Material	Machine type			
	BD200, RCE, RN, S, SN BDA 10, 20, 30 BT10,20,30 BT902-905, BT 928	BD-D2, D2K, BD-SD BD 320, BD321 BD330, BD380 BD280	RK10, PL10 RU 11/14 R1/20 R 40	ACO, ACO 240, ACO 288 SE7/8, SE8/9, SE 10/11 ACO 312, ACO 360 SE11, SE12
Cotton	OK40	OB20-OK40	OB20	OB20
Polyester	OK37	OK37-OK61-OS21	OS21	OS21
Acrylic	OS21	OS21	OS21	OS21
Cotton Polyester	OK61	OK61	OS21	OS21-OB20
Cotton Acrylic	OK61	OK61	OS21	OS21
Viscose	OK61	OK61	OB20	OB20
Microfibre	OB20	OK61	OB20	OB20
Modal	OS21	OK61	OS21	OS21-OB20
Viscose Rayon	OS21	OS21	OS21	OS21
Linen Flax	OK74A	OB20	OB20	OB20



## NUMBERING SYSTEM

Card clothing for wool is generally classified into plain type and interlocking type.

### Plain card clothing

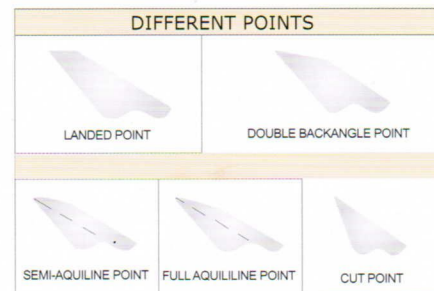
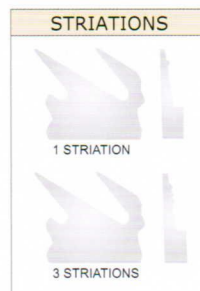
Cylinder		32	20	x	32	90	
Doffer		50	40	x	31	12	L10/125
Stripping		41	-27	x	32	18	
	Plain profile	Height	Angle	x	Pitch	Rib	Design

### Interlocking card clothing

Cylinder	V24	50	30	x	30	10	L9S
	Interlock profile	Height	Angle	x	Pitch	Rib	Design

### Specially processed card clothing.

CODE	TREATMENT
AT	arched tooth
MB	mechanically brushed
EM	eagle mouth
FT	flat tip
HH	high heat
MP	mechanically Polish
SP	pinned finish
SR	striations
RP	reinforced point
SB	sand blasted





## INTERLOCKING CARD CLOTHING

The interlocking card clothing is widely used on the pre-opening part of the carding machine such as the feed roller, chest cylinder and so on. You can choose the thick base type when having long manufacturing procedure or carding coarse fibre.

## FEED ROLLERS, FEED ROLLER CLEANING, PRE-OPENING ROLLER AND LICKERIN WIRES

Feed roller, feed roller cleaning, pre-opening roller and lickerin wire usually use the plain wire. But we advise you to use the interlocking type, and you can choose V6 LR43, V10 LR33 and V10 L6/250 and so on, which can be with different pitch designs.







Height	5.0-3.0mm
Working Angle	50
Density	19-80 ppsi
Specials	Brushed Perfecto

Wire type	 Height	 Angle	 Pitch	 Rib	 PPSI	Tooth shape
3040 x 08640 L43/860	3.00	40	8.60	4.00	19	
3040 x 06040 L43/600	3.00	40	6.00	4.00	27	
3040 x VAR40 LR43	3.00	40	VAR	4.00	23	
3040 x 08630 L33/860	3.00	40	8.60	3.00	25	
3040 x 06030 L33/600	3.00	40	6.00	3.00	36	
3040 x VAR30 LR33	3.00	40	VAR	3.00	31	
5040 x 08625 L2	5.00	40	8.60	2.50	30	
3040 x VAR25 LR2	3.00	40	VAR	2.50	37	
4240 x 05316 L4/155	4.25	40	5.30	1.55	78	

## CYLINDERS

Highend cylinder uses imported alloy steel which will be processed with special technology, greatly improving the carding performance when having high output.







Height	3.2mm
Working Angle	10-20
Density	225-400 ppsi
Specials	Imported Alloy Steel Brushed Perfecto

Wire type	 Height	 Angle	 Pitch	 Rib	 PPSI	Tooth shape
3210 x 03290	3.20	10	3.20	0.90	224	
3220 x 03290	3.20	20	3.20	0.90	224	
3215 x 02785	3.20	15	2.70	0.85	282	
3210 x 01890	3.20	10	1.80	0.90	398	
3220 x 01890	3.20	20	1.80	0.90	398	

## DOFFERS

The tooth shape design, processing technology and wale surface can greatly improve the doffer wire performance, such as the transferring performance, output and the web evenness.

Height	4.0-5.0mm
Working Angle	50-55
Density	150-330 ppsi
Specials	Brushed
	Perfecto
	Striations
	Eagle-mouth
	Arched tooth

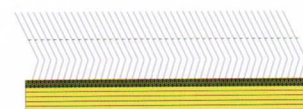
Wire type	 Height	 Angle	 Pitch	 Rib	 PPSI	Tooth shape
5040 x 03112 L10/125	5.00	40	3.10	1.25	166	
5040 x 03110 L10/100	5.00	40	3.10	1.00	208	
4035 x 02595 PPS/95	4.00	35	2.50	0.95	272	
4035 x 02580 PPS/80	4.00	35	2.50	0.80	323	







## STRIPPER ROLLER

The design of the stripper and anti-turbulence rollers can maximumly improve the stripper performance. You can choose the special processing technology wire or the wale surface wire.

According to the different fibres, the range of the steel wire is between 14 and 22, and the ply of the foundation is between 5 and 7.

Height	5.0-3.2mm
Working Angle	15-40
Density	50-110 ppsi
Specials	Brushed
	Perfecto
	Striations



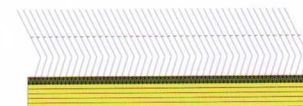
Wire type	 Height	 Angle	 Pitch	 Rib	 PPSI	Tooth shape
5040 x 04125	5.00	40	4.15	2.50	62	
3215 x 04125	3.20	15	4.25	1.50	101	
3214 x 04115	3.20	15	4.10	1.50	105	
3040 x 04030	3.00	40	4.00	3.00	54	







## WORKER ROLLER

The design of worker roller aims to maximumly improve the carding performance. You can choose the special processing technology wire or the wale surface wire.

According to the different fibres, the range of the steel wire is between 16 and 28, and the ply of the foundation is between 5 and 7.

Height	5.0mm
Working Angle	30-40
Density	60-220 ppsi
Specials	Brushed
	Perfecto
	Striations












Wire type	 Height	 Angle	 Pitch	 Rib	 PPSI	Tooth shape
5040 x 04225 L6/250	5.00	40	4.15	2.50	62	
5030 x 03010 L9S/100	5.00	30	3.00	1.00	215	

## MOREL

The special tooth design such as big flat points and different pitch can maximumly improve the crushing performance. You can choose the special processing technology wire or the wale surface wire. And the pitch is changeable.

Height	5.0-3.2mm
Working Angle	15-40
Density	50-110 ppsi
Specials	Brushed
	Perfecto
	Striations

Wire type	 Height	 Angle	 Pitch	 Rib	 PPSI	Tooth shape
3640 x 05516 M1655	3.60	40	5.50	1.60	73	
3640 x 03816 M1638	3.60	40	3.80	1.60	106	
3640 x VAR16 MR160	3.60	40	VAR	1.60	90	
3640 x 05512 M1255	3.60	40	5.50	1.20	98	
3640 x 03812 M1238	3.60	40	3.80	1.20	141	
3640 x VAR12 MR120	3.60	40	VAR	1.20	120	
3640 x 05510 M1055	3.60	40	5.50	1.00	117	
3640 x 03810 M1038	3.60	40	3.80	1.00	170	
3640 x VAR10 MR100	3.60	40	VAR	1.00	144	
3640 x 05580 M855	3.60	40	5.50	0.80	147	
3640 x 03880 M838	3.60	40	3.80	0.80	212	
3640 x VAR80 MR80	3.60	40	VAR	0.80	180	

## TRANSFERRING

The transferring flexible card wire is made from 7 ply or 9 ply of cotton cloth and 1 ply of linseed oil resistant cushion.

Steel wire standard: 20/24,21/25,22/26,23/27

Side ground with extra hardened points

Densities: first transfer is 50 ppsi, and second transfer is 80 ppsi.



## TECHNICAL SUPPORT

Grandtexco technical service department are very experienced, and can design the card clothing based on customers' carding requirement.

The optimum plan needs you to provide the following information:

- the carding machine manufacturer and model
- machine draft with the working width and the roller diameter
- the speed of cylinder, doffer and roller
- material to be processed
- fibre length
- fibre fineness
- producing speed (kg/h)
- the speed and gram weight of the web

## FLEXIBLE CARD CLOTHING

Wire		Felt	PPSI	Rubber	PPSI	Sponge	PPSI
No(CWG)	Dia(mm)						
Cylinder / Doffer							
21 18x22	0.81 1.215x0.71	FF7	80	V7		S8	80
22 18x22	0.71 1.215x0.71		80		80		
23 20x24	0.63 0.91x0.58		120		120		
24 20x24	0.58 0.91x0.58		120		120		
25 22x26	0.53 0.71x0.48		160		160		
26 22x26	0.48 0.71x0.48		160		160		
27 24x28	0.43 0.58x0.405		200		200		
28 26x30	0.405 0.48x0.355		240		240~250		
29 28x32	0.38 0.405x0.305		280		280~300		
30	0.355		320		320~350		
31	0.33		360		360~400		
32	0.305		400		400~450		
33	0.28		440		440~500		
34	0.255		480		480~550		
35	0.23		520		520~600		
36	0.205		560		560~650		

Wire		Felt	PPSI	Rubber	PPSI	Sponge	PPSI
No(CWG)	Dia(mm)						
Transporter / Worker / Stripper / Cleaner							
21	0.81	F6	80	V6		S7	80
18x22	1.215x0.71		80		80		
22	0.71		120		120		
18x22	1.215x0.71		120		120		
23	0.63		160		160		
20x24	0.91x0.58		160		160		
24	0.58		200		200		
20x24	0.91x0.58		240		240		
25	0.53		280		280		
22x26	0.71x0.48		320		320		
26	0.48		360		360		
22x26	0.71x0.48		400		400		
27	0.43		440		440		
24x28	0.58x0.405		480		480		
28	0.405		520		520		
26x30	0.48x0.355		560		560		
29	0.38						
28x32	0.405x0.305						
30	0.355						
31	0.33						
32	0.305						
33	0.28						
34	0.255						
35	0.23						
36	0.205						

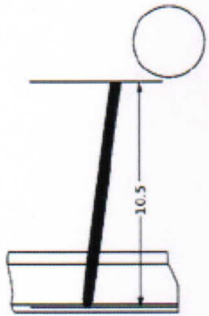
Wire		Felt	PPSI	Rubber	PPSI	Sponge	PPSI
No(CWG)	Dia(mm)						
Fancy (bend tooth)							
26 22x26	0.48 0.71x0.48	FV5	60	V6	60	S7	60
27 24x28	0.43 0.58x0.405		60		60		
28 26x30	0.405 0.48x0.355		80		80		
29 28x32	0.38 0.405x0.305		100		100		
30	0.355		120		120		
31	0.33		140		140		
32	0.305		160		160		
33	0.28		180		180		
34	0.255		200		200		
35	0.23		220		220		
36	0.205		240		240		

Wire		Felt	PPSI	Rubber	PPSI	Sponge	PPSI
No(CWG)	Dia(mm)						
Fancy (Straight tooth)							
26 22x26	0.48 0.71x0.48	FV5	60	V6	60	S7	60
27 24x28	0.43 0.58x0.405		60		60		
28 26x30	0.405 0.48x0.355		80		80		
29 28x32	0.38 0.405x0.305		100		100		
30	0.355		120		120		
31	0.33		140		140		
32	0.305		160		160		
33	0.28		180		180		
34	0.255		200		200		
35	0.23		220		220		
36	0.205		240		240		

## RAISING FILLET

Type RT-15

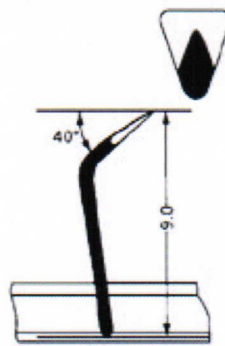
Applicable for working with R-27/31、RA-2



Technical Parameter	
Foundation	VCLC
Width	23mm
Wire No	30#
Plyback	Red
PPSI	270
Total Height	11mm

Type RA-1

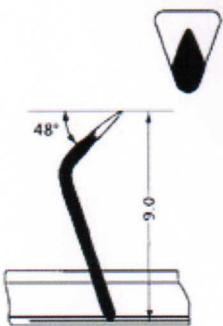
Applicable for raising of blanket, wool fabrics, cotton fabrics and synthetic fabrics.



Technical Parameter	
Foundation	VCLC
Width	23mm
Wire No	27#/31#
Plyback	Red
PPSI	310
Total Height	9.5mm

Type RA-3

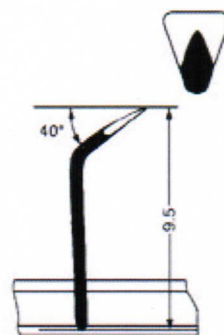
Applicable for raising of wool fabrics and micro-suede fabric.



Technical Parameter	
Foundation	VCLC
Width	23mm
Wire No	28#/32#
Plyback	Red
PPSI	330-390
Total Height	9.5mm

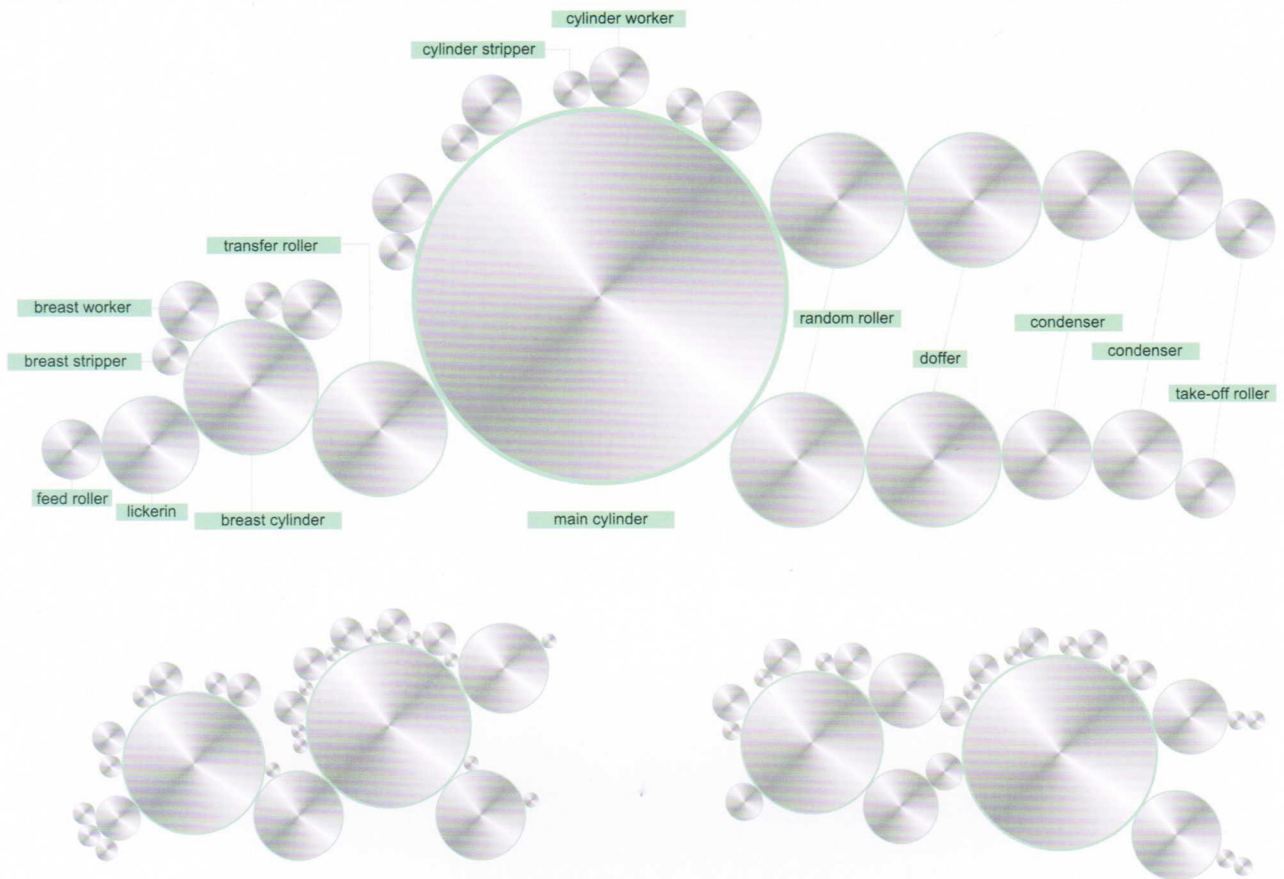
Type RA-2

Applicable for raising of polar fleave fabrics, cotton fabrics and knitted fabrics.



Technical Parameter	
Foundation	VCLC
Width	23mm
Wire No	27#/31#
Plyback	Red
PPSI	310
Total Height	10mm

Note: We can arrange production as per your special request.



## NUMBERING SYSTEM

Grandtexco Card Clothing for nonwovens is generally classified into plain wire and interlocking wire.

### Plain card clothing

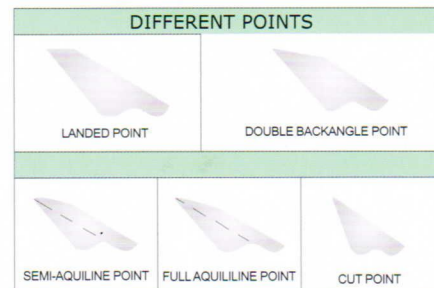
Cylinder		32	20	x	32	90	
Doffer		40	30	x	25	90	
Stripping		41	-27	x	32	18	CS4
	Plain profile	Height	Angle	x	Pitch	Rib	Design

### Interlocking card clothing

Cylinder	V24	40	10	x	32	90	
	V28	47	40	x	25	90	
	Interlock profile	Height	Angle	x	Pitch	Rib	Design

### Specially processed card clothing

CODE	TREATMENT
AT	arched tooth
MB	mechanically brushed
EM	eagle mouth
FT	flat tip
HH	high heat
MP	mechanically Polish
SP	pinned finish
SR	striations
RP	reinforced point
SB	sand blasted





## INTERLOCKING CARD CLOTHING

The interlocking card clothing is widely used on the pre-opening part of the carding machine such as the feed roller, chest cylinder and so on. And will help to avoid the damage to the carding machine.

## FEED ROLLERS, FEED ROLLER CLEANING, PRE-OPENING ROLLER AND LICKERIN WIRES

Interlocking wires are recommended for these applications.








Height	8.5-5.5mm
Working Angle	10-40
Density	13-40 ppsi
Specials	Brushed Perfecto

Wire type	 Height	 Angle	 Pitch	 Rib	 PPSI	Tooth shape
V5 8525 x 01051	8.50	25	10.00	5.08	13	
V5 8515 x 01051	8.50	15	10.00	5.08	13	
V6 6010 x 08542	6.00	10	8.50	4.23	18	
V8 5540 x 06532	5.50	40	6.50	3.17	31	
V8 5520 x 06532	5.50	20	6.50	3.17	31	

## TRANSFERRING

These wires need to strip the doffer completely and also ensure proper transfer of the fibres.










Height	3.2mm
Working Angle	10-20
Density	225-400 ppsi
Specials	IMPORTED ALLOY STEEL Brushed Perfecto

Wire type	 Height	 Angle	 Pitch	 Rib	 PPSI	Tooth shape
V10 6020 x 06525	6.00	20	6.50	2.54	39	
V10 4730 x 05525	4.70	30	5.50	2.54	48	
V10 4720 x 05525	4.70	20	5.50	2.54	48	
V12 4730 x 05021	4.70	30	5.00	2.12	61	
V12 4720 x 05021	4.70	20	5.00	2.12	61	
V12 4730 x 03621	4.70	30	3.60	2.12	85	
V16 4730 x 03616	4.70	30	3.60	1.59	113	

## CYLINDERS

Highend cylinder uses imported alloy steel wire which will be processed with special technology, greatly improving the carding performance when having high output.








Height breast	6.0-4.0mm
Height finisher	3.2-2.5mm
Working Angle	10-20
Density	32-550 ppsi
Specials	IMPORTED ALLOY STEEL Brushed Perfecto

Wire type	 Height	 Angle	 Pitch	 Rib	 PPSI	Tooth shape
V10 4720 x 05525	4.70	20	5.50	2.54	48	
V12 4715 x 04021	4.70	15	4.00	2.12	76	
V16 4515 x 04016	4.50	15	4.00	1.59	102	
V16 3815 x 04216	3.80	15	4.25	1.59	96	
V20 3815 x 03613	3.80	15	3.60	1.27	141	
V20 3820 x 03013	3.80	20	3.00	1.27	169	
V24 3820 x 03211	3.80	20	3.20	1.06	191	
V24 3815 x 03011	3.80	15	3.00	1.06	203	
V28 4010 x 03290	4.00	10	3.20	0.90	224	
V28 4015 x 03090	4.00	15	3.00	0.90	239	
V30 4015 x 02785	4.00	15	2.70	0.85	282	
V30 4015 x 01885	4.00	15	1.80	0.85	423	
3210 x 03290	3.20	10	3.20	0.90	224	
3220 x 03290	3.20	20	3.20	0.90	398	
3220 x 02785	3.20	15	2.70	0.85	281	
2815 x 01865	2.80	15	1.80	0.65	551	
2512 x 02850	2.50	12	2.80	0.50	461	

## WORKER/DOFFERS

Both design in selection of special processing technology and wale surface, can greatly improve the wire performance such as the transferring performance, output and the web evenness.







Height	6.0-4.0mm
Working Angle	10-20
Density	32-550 ppsi
Specials	IMPORTED ALLOY STEEL
	Brushed
	Perfecto

Wire type	 Height	 Angle	 Pitch	 Rib	 PPSI	Tooth shape
V12 4740 x 03621	4.70	40	3.60	2.12	85	
V16 4540 x 03616	4.50	40	3.60	1.59	113	
V18 5040 x 03614	5.00	40	3.60	1.41	127	
V20 4540 x 03613	4.50	40	3.60	1.27	141	
V20 4540 x 02513	4.50	40	2.50	1.27	203	
V24 4540 x 03611	4.50	40	3.60	1.06	169	
V28 4740 x 02590	4.70	40	2.50	0.90	287	
V28 4740 x 02190	4.70	40	2.10	0.90	341	
4035 x 02595	4.00	35	2.50	0.95	272	
4025 x 02090	4.00	25	2.00	0.90	358	

## HIGH CAPACITY WORKER/DOFFERS

The designs have been developed to maximise the carding action required and are available in a selection of finishes and striations.

Height	4.0-5.0mm
Working Angle	30-45
Density	150-550 ppsi
Specials	Brushed
	Perfecto
	Striations
	Eagle-mouth
	Arched tooth

Wire type	 Height	 Angle	 Pitch	 Rib	 PPSI	Tooth shape
V16 5040 x 03616	5.00	40	3.60	1.59	112	
V20 5540 x 03613	5.50	40	3.60	1.27	141	
V24 5540 x 03611	5.50	40	3.60	1.06	169	
V24 5540 x 02511	5.50	40	2.50	1.06	244	
V24 5530 x 03011 L9S	5.50	30	3.00	1.06	203	
V24 5540 x 03111 L10	5.50	40	3.10	1.06	197	

## RANDOM ROLLERS







Random wires can be subject to increased wear and they are available in WELCC steel and special finishes to increase their life time.

Height	3.3-2.5mm
Working Angle	10-20
Density	450-550 ppsi
Specials	IMPORTED ALLOY STEEL
	Perfecto
	Brushed

Wire type	 Height	 Angle	 Pitch	 Rib	 PPSI	Tooth shape
3225 x 01390	3.20	25	1.30	0.90	551	
3220 x 01390	3.20	20	1.30	0.90	551	
3215 x 01390	3.20	15	1.30	0.90	551	
3210 x 01390	3.20	10	1.30	0.90	551	







## STRIPPER

The design of the stripper wire aims to improve the stripping performance, and are available of special processing technology wire and wale surface wire .

Height breast	6.0-5.0mm	Wire type	 Height	 Angle	 Pitch	 Rib	 PPSI	Tooth shape
Height finisher	4.0-3.2mm	V10 6010 x 06525	6.00	10	6.50	2.54	39	
Working Angle	25-40	V12 4715 x 04021	4.70	15	4.00	2.12	76	
Density	32-300 ppsi	V14 5020 x 04018	5.00	20	4.00	1.81	89	
Specials	Brushed	V16 4515 x 04016	4.50	15	4.00	1.59	102	
	Perfecto	V16 3815 x 04216	3.80	15	4.25	1.59	96	
	Striations	V16 3814 x 04116	3.80	14	4.10	1.59	99	
		V20 3820 x 03013	3.80	20	3.00	1.27	169	
		V24 3815 x 03011	3.80	15	3.00	1.06	203	







## TAKE OFF ROLLERS

The take-off roller wire has been polished, so the web transfer smoothly and effectively.

Height	4-3.5mm	Wire type	 Height	 Angle	 Pitch	 Rib	 PPSI	Tooth shape
Working Angle	negative 27-40	41-27 x 03218 CS4	4.06	-27	3.15	1.80	114	
Density	90-210 ppsi	28-25 x 03918 CS5	2.80	-25	3.85	1.80	93	
Specials	Brushed	V14 45-30 x 03318	4.50	-30	3.30	1.81	106	
	Perfecto							

## CONDENSER ROLLERS

The condenser roller should be maintained in perfect condition by using special tooth geometry as well as polished surfaces.

Height	4.0-5.5mm	Wire type	 Height	 Angle	 Pitch	 Rib	 PPSI	Tooth shape
Working Angle	40-45	7040 x 06015	7.00	40	6.00	1.50	72	
Density	95-170 ppsi	5540 x 04214	5.50	40	4.20	1.40	110	
Specials	Brushed	5540 x 04212	5.50	40	4.20	1.20	128	
	Perfecto	5540 x 04213	5.50	40	5.00	1.30	99	
		5040 x 03612	5.00	40	3.60	1.25	143	
		5040 x 03610	5.00	40	3.60	1.00	179	
		V20 5540 x 04213	5.50	40	4.20	1.27	121	
		V20 5540 x 05013	5.50	40	5.00	1.27	102	

## TECHNICAL SUPPORT

Grandtexco technical service department are very experienced, and can design the card clothing based on customers' carding requirement.

The optimum plan needs you to provide the following information:

- the carding machine manufacturer and model
- machine draft with the working width and the roller diameter
- the speed of cylinder, doffer and roller
- material to be processed
- fibre length
- fibre fineness
- producing speed (kg/h)
- the speed and gram weight of the web