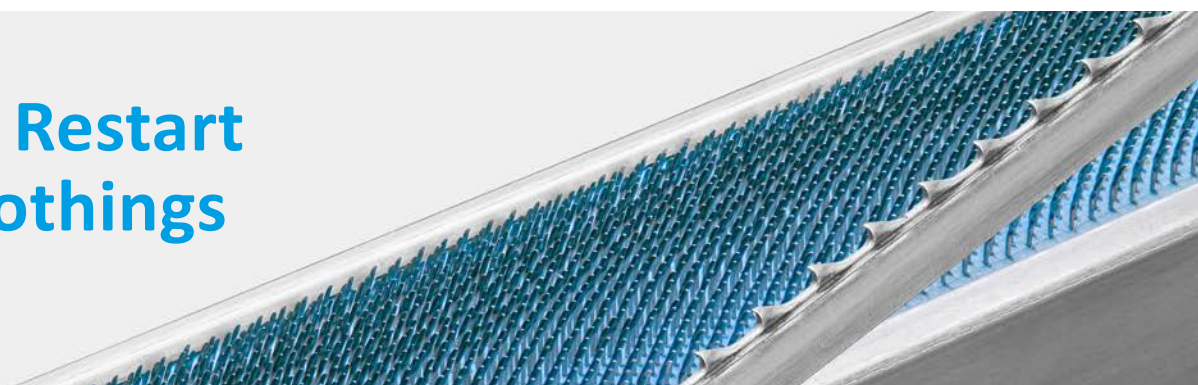


How to Restart Card Clothings



Tips and Hints

In an earlier bulletin we had recommended protective measures for technology components like Card Clothings during machine standstill in spinning mills. Graf experts have now collected a few tips and hints to restart Card Clothings after reduced business activity.

1

Prepare the Flats

1. Re-mount all flexible flats into the card
2. Check flexible and stationary flats visually and clean if necessary
3. Check flexible flats with microscope and re-sharp with Graf service machine DSW if needed
4. Open the carding gap for restart

Prepare Cylinder and Licker-In

5. Check the clothing visually for corrosion and sharpness of clothing teeth
6. Clean cylinder/licker-in with brush (no metal)

Prepare Doffer

7. Activate the doffer with Graf service machines ASG or TSG like after re-winding
8. Clean the doffer wire with a brush (no metal)

2

Restart the Card

1. Follow the instructions of your machinery supplier
2. Run the card smoothly with open carding gap
3. After a half-filled can check cylinder/doffer
4. Check card sliver for residues
5. Set the carding gap and check Uster CV% throughout the day

Possible Challenges

Doffer and cylinder wire are filled with fibers after half-filled can:

- Check doffer wire again and activate with Graf service machines ASG or TSG.
- Cylinder and doffer wire have residues from grease. Clean again.

Do you require any assistance or additional information? Graf + Cie AG as well as our partner located close to you are happy to support. We thank you for your continuous trust in our company, and wish you and your company a prospering business.