



The Indian Card Clothing Co. Ltd.



**WITNESS THE CARDING  
REVOLUTION WITH ICC!**

**PRODUCT CATALOGUE**

ICC has mastered change to keep its position as a leader. With products developed to handle the evolving needs of increased rates of outputs - going as high as 150 kg/hour and to meet more exacting quality standards worldwide. INNOVATION has become an ongoing process at ICC... a state-of-the-mind instilled in every employee, in every department, in every stage of the production process.

The result. A wide range of wires, tops and flexible card clothing to suit every requirement, depending on the type of fibre being processed and the quality parameters needed. In fact, ICC is one of the few companies in the world that manufactures card clothing to process every fibre, natural or man-made on every type of carding machine, be it conventional card or super high production cards.

The R & D cell at ICC is constantly tuned to market needs, experimenting with newer ideas and technologies, making significant breakthroughs in tooth geometry, surface treatment etc. Recent developments include special alloy steel wires in the Maxus Plus series, a new generation of Progressive Triumph Tops, Nextra Tops and Specially developed cleaned Aerodoffer Wires for

effective doffing performance at high production rate.

Thanks to their efforts, ICC now has a line of Cardroom machineries e.g. All roller mounting machine, Clipit flat clipping machine, Sharprite wire re-sharpening device, Sharprite Tops, Tops height measurement device etc. to maintain card clothing in best possible condition. ICC's X Trac assemblies have added significantly to the returns at hundreds of mills, where they have been installed in the last few years. More such innovations are on the testing line.

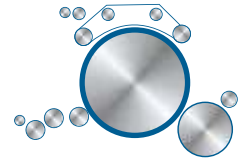
ICC has started its new production facility at Nalagarh, Himachal Pradesh, India, that will serve clients in the northern region.

The ICC stamp of quality, recognised the world over, is further endorsed by the ISO 9001:2008 Certification from BVC, ICC has satisfied clients in virtually every part of the globe-the Far East Asia, South East Asia, Africa, Europe and the Americas.

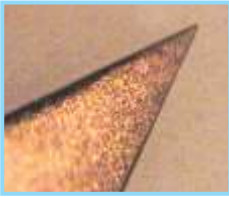
As you will see in the following pages, your search for fault-free card clothing ends at ICC. Please contact ICC's nearest office and we will help you find the optimal and complete card clothing solution.

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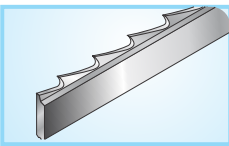


## Cylinder Wires

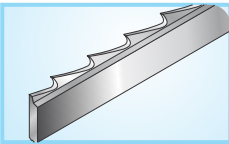


Cylinder wires are the mainstay of the carding process, doing the bulk of the work. Modern cards are clothed with very fine wire points and a card could have as many as 12 million wire points! Good carding requires all these wire points to be of exact size, height and strength.

ICC manufactures a wide range of metallic cylinder wires for different needs. Use of high grade raw materials, precision engineering and established tooth geometry combine to give wires that are tough, wear-resistant and economical.

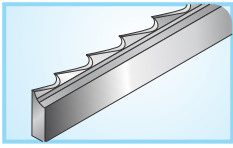
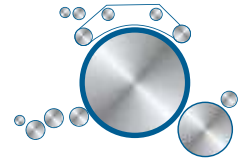


**Primus Series:** Suitable for very high production rates. Primus is manufactured with high grade micro alloy steel. The special tooth design is ideal for processing cotton over a wide count range.

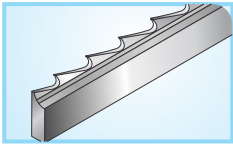


**Maxus+ Series:** Suitable for very high production rates with consistent quality. Maxus cylinder wires are made from micro-alloy steel with fine-grained crystalline structure for very high wear resistance and long life. An advanced heat treatment process provides an even and consistent hardness. The new 'cut-to-point' tooth geometry ensures tough wire tips which withstand high production rates.

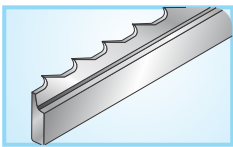
Description	Height	Rib	Angle	PPSI
64 17 20 57	2.0	0.4	57°	1090
64 16 20 53	2.0	0.4	53°	1025
64 15 20 55	2.0	0.4	55°	950
51 20 20 55	2.0	0.5	55°	1020
51 17 20 57	2.0	0.5	57°	860
51 16 20 53	2.0	0.5	53°	785
42 17 20 57	2.0	0.6	57°	720
42 16 20 53	2.0	0.6	53°	652
51 17 25 60	2.5	0.5	60°	860
51 17 25 65	2.5	0.5	65°	860
51 15 25 70	2.5	0.5	70°	760
51 15 25 65	2.5	0.5	65°	760
42 17 25 60	2.5	0.6	60°	720
42 17 25 65	2.5	0.6	65°	720
42 17 25 70	2.5	0.6	70°	720
42 15 25 70	2.5	0.6	70°	630
36 17 25 70	2.5	0.7	70°	610
32 20 25 65	2.5	0.8	65°	640



**Tenace Series :** Made from long life alloy steel for strength and wear resistance, Tenace wires are available in height options of 2.0 mm and 2.5 mm. Tenace series wires undergo an advanced heat treatment process, which ensures an even and consistent hardness. Besides they have special tooth geometry with low tooth depth.



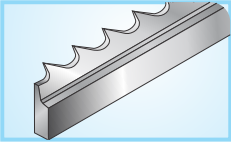
**Stylus Series :** Stylus cylinder wires are made from high carbon steel to provide a cost-effective option for high speed cards.







**Crystal Series :** Made from high carbon steel, this series of 'cut to point' cylinder wire have a zero land area. Designed with additional features like reduced blade thickness and lower tooth depth for better penetration, these wires are recommended for use in cards with cylinder speed up to 350 rpm. The 'cut to point' tips also ensure wire sharpness for consistent carding quality. Frequent stripping during working of the cards can be avoided.

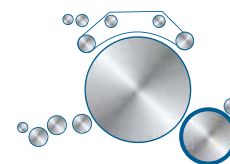
Primus	Maxus	Tenace	Stylus	Crystal
	✓	✓	✓	
✓				
	✓	✓	✓	
		✓	✓	
	✓	✓	✓	
✓				
		✓		
✓				
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	✓	✓		✓
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				✓
				✓

## Cylinder Wires

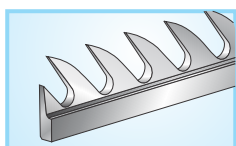


Standard Series: Developed almost three decades ago, this series of metallic cylinder wires has stood the test of time. Made from high carbon steel, the wires are the ideal choice for slow speed cards and certain special applications. ICC has a full range of these wires which cover almost every make of card in the world.

				
Type of wire	Height (mm)	Rib (mm)	Front Angle	PPSI
4765	2.80	0.65	70°	765
4615	2.80	0.70	70°	615
208 SP	2.80	0.80	76°	505
505	2.80	0.80	80°	265
504	3.18	0.90	70°	225
501	3.18	0.90	80°	225
202	3.18	0.90	80°	400
201	3.18	0.90	70°	400



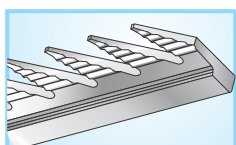
## Doffer Wires



For positive and efficient transfer of fibres, ICC has a wide range of doffer wires to complement the cylinder wires.

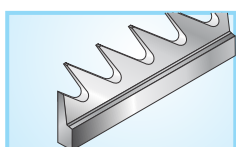
**Aerodoffer :** These wires have a special aerodynamic design which enables transference at high speeds. Cut to point' technology and reinforced tips ensure that they can withstand higher production rates.

Type of wire	Height (mm)	Rib (mm)	Front Angle	PPSI
32 10 40 55	4.0	0.80	55°	320
25 11 40 55	4.0	1.00	55°	275
32 13 40 60 (4410)	4.0	0.80	60°	405
32 10 50 55	5.0	0.80	55	320
25 12 47 60	4.7	1.00	60	301



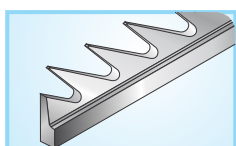
**Serrated:** These wires are recommended for synthetics fibres at slow production rate. The serrations on the wire blade restrict slippage of the fibres and allow it to remain on the working surface. The tips are reinforced to prevent wire damage.

32 13 40 62	4.0	0.80	62°	405
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**Standard:** Recommended for universal application over a wide range of speeds.

28 13 40 60	4.0	0.90	60°	365
32 13 40 60	4.0	0.80	60°	405

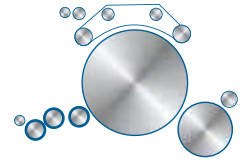


**PPS:** These wires are recommended for Roller/Clearer Cards for processing long staple fibres.

PPS	4.0	0.90	55°	285
PPS-558	4.0	0.80	55°	325

**We also supply cleaned Doffer Wires**

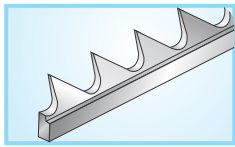
## Lickerin Wires



Opening of tangled mass of fibres involves heavy work. Lickerin wire has to be very strong, with the ability to penetrate the fibre flock. ICC lickerin wires are made tough with hardened and tempered points to impart these properties.

ICC has lickerin wires in Special series for all applications for grooved lickerin rolls. The Rapier series has a special design for better opening of fibres.

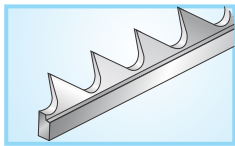
For plain lickerin rolls, ICC has a wide range of Interlocking wires.



### Standard Series

Type of wire	Height (mm)	Front Angle	TPI
10 SP	5.5	78°	5.0
11 SP	5.5	85°	4.5
15 SP	5.5	90°	3.3
5 TPI	5.5	90°	5.0

(Alloy Steel available in 1.10 and 1.20mm only)

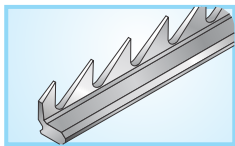


### Rapier Series

5 TPI	5.5	80°	5.0
4 TPI	5.5	85°	4.0

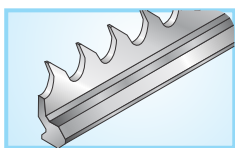
### Special Series

6 STL 70 DEG.	5.5	70°	4.5
4 SAL 65 DEG.	5.5	65°	3.5
6 TPI 70 DEG	5.5	70°	6.0



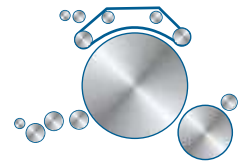
### Interlocking Lickerin Wire

V-08035090	5.0	90°	3.0
V-08045085	5.0	85°	4.0
V-08055080	5.0	80°	5.0
V-08055090	5.0	90°	5.0
V-10055080	5.0	80°	5.0
V-12085080	5.0	80°	8.0
V-16105070	5.0	70°	10.0
V-16135070	5.0	70°	13.0



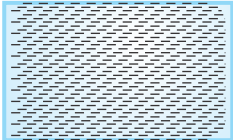


## Flat Tops



For best results, proper selection of flat tops is as critical as choosing the cylinder wire. ICC manufactures a wide range of tops to suit different fibres on various makes of card.

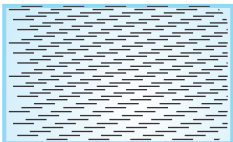
ICC has one of the most sophisticated facilities for the manufacture of these tops, where each top is individually checked to ensure that it conforms to the required specifications. For Consistent quality over extended periods of high production levels, ICC offers the flat tops with High Tensile (HT), High fatigue life G and Micro Alloy Steel (MAS) wires.



**Nextra Tops :** The effective removal of neps, short fibres and trash without rupturing fibres at high production rate requires unique positioning of wire points of the tops.

The Nextra tops with its unique matrix of wire tips of the revolving tops is able to work with cylinder speeds above 450 RPM to produce quality of output from the latest generation of carding machines. Made from raw material which has a high fatigue life, it is ideally suited for today's carding machines.

Type	Height (mm)	Angle	PPSI RANGE
NEXTRA 55	8.0	70°	530
NEXTRA 400	7.5	75°	350

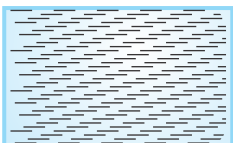


**Triumph Progressive :** Highly successful working of Triumph tops has spurred the development of a new series in the Triumph tops range with an enhanced performance suitable for very high product cards.

One of the most critical requirement for maintaining the consistency in quality at high production rate is maintaining cleanliness of tops. It is also equally critical that the fibres in a tuft should not be subjected to heavy strain during the opening and individualisation process.

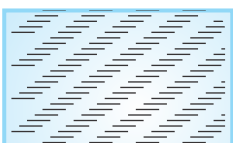
The well proven Triumph configuration has been improved to reduce strain on fibre. The wire population has been increased gradually from entry to exit zone of fibre passage through tops. The smooth lance in the wire points also allows air flow to keep the tops clean during operation.

Type	Height (mm)	Angle	PPSI RANGE
TRIUMPH 450 Progressive	8.0	70°	300-530
TRIUMPH 550 Progressive**	8.0	70°	400-570



**Endura:** Endura tops have a unique setting pattern, which distribute the wire points in the carding direction to give maximum carding power. Recommended for both cotton and synthetics, these tops have needle-sharp points made from High Tensile wires to withstand high carding force.

ENDURA 35S HT	8.0	75°	350
ENDURA 45 HT*	8.0	70°	435
ENDURA 55 HT**	8.0	70°	530
ENDURA 30	7.8	80°	300



**XL:** These tops have a standard twill pattern and are available in High Tensile wires. They are recommended for use in cotton and synthetics.

XL 30S	8.0	75°	290
XL 300 PROGRESSIVE	7.5	75°	311
XL 400S HT*	8.0	75°	390
XL 450S HT*	7.5	75°	450
XL 460 MAS	7.5	75°	460
XL 500 HT**	8.0	70°	510

\*available in G&\*\*MAS execution also

## Special Wires

ICC also supplies various types of End Wires for use in cylinder, doffer, lickerin and stripper roller. Suitable ones may be selected to replace the existing end wires on the rollers.

Special wires such as CS4 have found universal acceptance for stripper roller on various makes of card. Other special wires include CS6, CRC and interlocking Feed Roller wire.

### End Wires

Wire	Height (mm)	Thickness (mm)
Antiflock Wire	5.39	2.74 X 1.00
Antiflock Wire 1501- Trützscher Cyl/Dof/Strp	3.2	1.2
Antiflock Wire 1504 - Trützscher Lickerin	6.5	1.5
Bead Wire	3.35	1.00
'Z' Wire	5.39	2.79

### Special Wires

Type of Wire	Height (mm)	Rib (mm)	Front Angle	TPI	Standard Supply (Kg)
Stripper Roller Wire CS4	4	1.8	62°	7.7	50
Stripper Roller Wire CS6	3.5	1.0	60°	8.0	50
Uniopener Wire-CRC	4.5	1.7	70°	10	50
Interlocking Feed Roller Wire	5.0	4.2	75°	2	21

## Metallic Wires For NON WOVENS

With over 60 years of experience in manufacturing of precision metallic card clothings for revolving flat card ICC introduced metallic wires for non woven cards. ICC believes that the market for non woven products and technical textiles has now entered the high growth stage and the demand will increase exponentially in the coming years.

As pioneers in manufacturing metallic card clothing in India. ICC is ready with its offering for the non woven industry. The metallic wires for the non wovens are manufactured from refined high carbon steel to the same exacting standards that ICC is reputed for.

A selection of the common metallic wires presently available are given. ICC is also in a position to customise the specifications to your requirements.

DESCRIPTION	RIB	HEIGHT	ANGLE	PPSI	REMARKS
NWC 23 12 35 80	1.10	3.50	80°	280	For Cylinder
NWC 21 10 35 80	1.20	3.50	80°	215	For Cylinder
NWC 18 09 35 80	1.40	3.50	80°	165	For Cylinder
NWD 25 09 50 55	1.00	5.00	55°	230	For Doffer
NWD 24 07 50 50(S)	1.05	5.00	50°	170	For Doffer
NWD 23 12 43 55	1.10	4.30	55°	280	For Doffer
NWD 21 09 50 55	1.20	5.00	55°	190	For Doffer
NWS 17 08 33 65	1.50	3.30	65°	135	For Stripper
NVWV 21 12 43 65	1.20	4.30	65°	255	For Worker
NWL 23 05 56 75	1.10	5.65	75°	5 TPI	For Lickerin
NWL 21 07 57 50	1.20	5.70	50°	7 TPI	For Lickerin

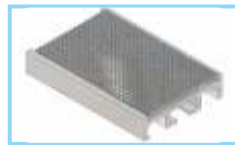
## Accura Carding Elements

The Accura Carding Elements are manufactured from stabilized, hardened aluminium alloy for long trouble-free life. Available in standard wire densities (PPSI) indicated below, these are for replacement of the existing carding elements. ICC manufactures the carding elements conforming to the standard dimensions for all known pre and post carding systems.

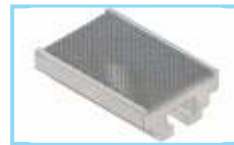
### FRONT AND BACK CARRIERS



SF-580



SF-581, 582, 590,  
591, 2036



SF-583, 589



CLIP ON CARRIER  
SF - 2467

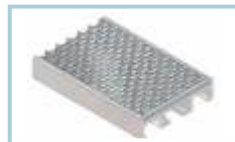


SF-2225

### LICKERIN CARRIERS



SF-580, 583,  
589, 2437



SF-582, 590, 591



SF-581



SF-967

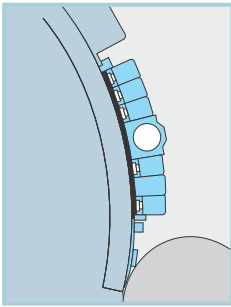
Drawing No.	Used on
580	Trützscher DK 760, DK 780, DK 803
581	Rieter C4, C10, C50, C51
582	Trützscher, DK 780, DK 800, DK 903, TC 03, TC 5/3, TC 07, TC 08, Rieter / LR, C1/2, C1/3, Rieter C60, Loyal, Textool, Platts, MMC Toyoda, Marzoli, Ingolstadt, Mewada, NSE, Howa
583	Rieter/LR C1/2, C1/3, LC 100/LC 300, Loyal, Textool, MMC, Howa
589	Rieter C4, C10, C50, C51
590	Trützscher DK 740
591	Crosrol MK4, MK5 and ICC Accura Assemblies
967	Trützscher DK 803, DK 903
2467	Replacement for Clipped Carrier
2225	LC 300A, LC 333, LC 361, LC 363, LC 300AV3
2472	TCO3, TCO5, TC5/3, TC06, TC07, TC08, TC11
2437	Blow room CVT3/CVT4
2036	Rieter C60, C70



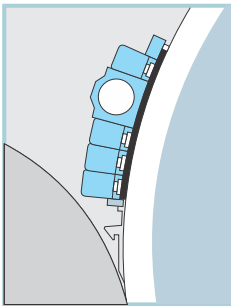
SF-2472

PPSI AVAILABLE
66
90
139
240
285
330
400
450
550
630

## XTRAC System



**XTRAC - XBZ**



**XTRAC - XFZ**

### XTRAC System - for front & Back Zone

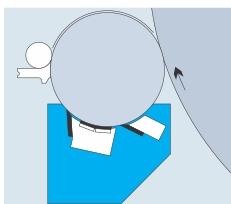
After the success of Accura Carding Elements retrofits on the older models of card, ICC has now introduced XTRAC Systems for the later models of cards. The construction, layout and components have been designed keeping in mind the high production rates, high precision requirements of the modern cards.

Depending on the space available and the material being processed, different configurations are available for installation on Trützschler DK 740, DK 760, DK 780 DK 800 and DK 803 cards and Rieter C4, C10, C50 and C51 cards. XTRAC Systems can also be supplied to other make of cards upon request.



The main advantages of XTRAC Systems over available stationary flat systems are :

- Modular construction facilitates complete usage freedom. After installation the position of the extraction unit can be altered easily depending on the mixing
- Highly efficient trash & short fibre extraction system
- Stable sections with improved heat dissipation properties, less prone to distortion and more accurate and stable settings
- Provision for self-adjustment under variable load conditions for individual sections with carriers, resulting in better maintenance of gauges and reduction of wearing of metallic wires
- Micro-adjustment of carrier in individual section ensures perfect maintenance of gap between working surfaces at any time of usage leading to consistent quality of sliver
- Excellent surface finish resulting in cleaner surface over longer period
- Suitable to process all types of fibres



### Accura XLZ - For the Lickerin Zone:

Accura XLZ Carding System opens fibre tufts as they enter the carding machine. It is supplied as a single unit of two or more Carding Elements and two mote knives with side support and lickerin undercasing.

The first mote knife removes heavy trash particles from the fibre tufts, while the Carding Elements facilitate intensive opening of the fibre tufts. The second mote knife removes finer trash particles before the fibres are passed on to the cylinder. This improves the cleaning efficiency of the card.

ACCURA XLZ



## General Fillets

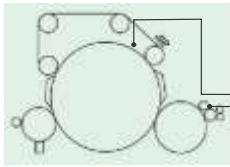
For superior carding efficiency, clean and well-maintained wires and tops are a must. To enable achieve this, ICC supplies a complete range of Fillets and Sundries. Fillets which are used in various makes of card for stripping, burnishing and cleaning of wires and tops are categorized under General Fillets.

Fillets and wires, which are card specific are also available.

Item	Wire	Foundation	Total Width mm	Height mm	Length	Standard Supply (mtrs./pcs.)
Metallic Stripping	29s	4 PLY VIR	40	17	40 m	40
Burnishing	33s	3 PLY VIR	40	20	40 m	40
Flat Stripping-Zig Zag	32s	3 PLY VIR	40	19.5	34.5 m	34.5
Flat Stripping-High & Low	29s	4 PLY VIR	35	25.5	40 m	40
Flat Stripping Fillet 26.5 mm	31s	4 PLY VIR	40	26.5	11.5 /34.5 m	11.5/34.5
Hand Stripping Card	27s	4 PLY VIR	90/63		578/559	6 pcs.
Hand Cleaning Card	30s	4 PLY VIR	90/63		265/260	6 pcs.
Hand Cleaning Cards Clipped	30s	4 PLY VIR	90/63		265/260	6 pcs.
Hand Cleaning Brush Clipped	30s	4 PLY VIR	90/63		80/75	6 pcs.
Philipson Top Clearer Strip	27s	4 PLY VIR	As required	18		
Handle for Hand Cleaning Card	-	-	-		-	1pc.
Rotary Drum fillet for Luwa Waste Collection System	31s	3 PLY VIR	70/35	8	1750/1570	6 pcs.

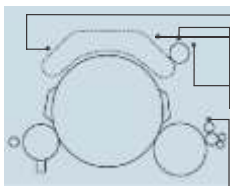
## Card Specific Sundries

### CROSROL MK4/MK5



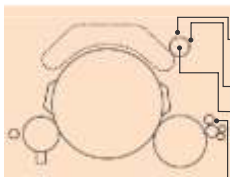
Description	Wire	Foundation	Total width mm	Height mm	Length mm	Qty Card
8 Row Clipped 1020	26s	4 PLY VIR IL	33	18	1020 mm	2 pcs
Dicky Fillet	33s	3 PLY VIR	20	10	16 m	16m

### Lakshmi LC 100/LC 300/LC 300A/LC 333/ LC 363



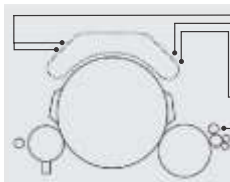
FB 24 (LC 100)	27s	4 PLY VIR	47.5	10	1030 m	1 pc
FB 25 Clipped (LC 300/ LC 300A)	27s	4 PLY VIR	58.5	10	1000mm	1 pc
8 Row Clipped 1010	26s	4 PLY VIR 1L	33	18	1010mm	2 pcs
FB 14	30s	4 PLY VIR	30	26	1045mm	2 pcs
DB 24 (LC 100)	26s	7 PLY VIR	46	8	8m	8m
Doffer Cleaning Fillet (LC 300/ LC 300A)	33s	3 PLY VIR	20	17	15m	15 m

### Rieter/ LR C-1/2 & C-1/3



8 Row Clipped 1010	26s	4 PLY VIR 1L	33	18	1010 mm	1 pc
FB 14	30s	4 PIY VIR	30	26	1045 mm	2 pcs
Flat Cleaning Fillet 26.5 mm	31s	4 PLY VIR	40	26.5	8m	8m
Doffer Cleaning Fillet	33s	3 PLY VIR	20	17	15m	15m

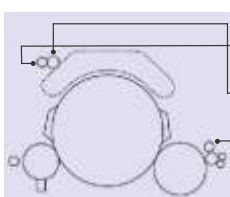
### Rieter C4/C10/C50/C51



8 ROW Clipped 1010	26s	4 PLY VIR 1L	33	18	1010 mm	1 pc
FB 15 (C4, C4A, C10)	30s	4 PLY VIR	30	26	1030 mm	2 pcs
FB 24	27s	4 PLY VIR	47.5	10	1030 mm	2 pcs
DB-24 (C4)	26s	7 PLY VIR	46	8	8m	8m
DB-25 (C4A/C 10)	30s	5 PLY VIR	28	7	11 m	11m
DB-26 (C-50)	33s	3 PLY VIR	20	17	17 m	17 m
DB-27 (C-50/C-51)	33s	3 PLY VIR	20	15	13 m	13 m

### Trützschler DK 740/760/803/903/TC 03/ TC 05/ TC 07/TC 11

#### Trumac DK 740/780/800, Rieter C70



Clearer Roller Fillet	30s	4 PLY VIR	28	17	10.5 m	10.5m,13.5m
Stripper Roller Fillet	32s	3 PLY VIR	40	20	9 m	9m,12.5m
Doffer Cleaning Fillet	33s	3 PLY VIR	20	17	15 m	15 m

### Rieter C60/C70

FB 60	30s	3 PLY VIR	34	22.5	1540 mm	1 pc
FB 61	27s	6 PLY VIR	34	8.5	1540 mm	1 pc

## Hand Cleaning Cards & Burnishing Pads

### Clipped Hand Cleaning Cards

Clipped hand cleaning cards and handles are used for fettling of woollen fillets and stripping of metallic wires. Now there is no need for nailing the hand cleaning cards to wooden pieces, which leads to improper mounting and uneven cleaning. Their main features are:

- Special design allows the clipped hand cleaning cards to slide on to the handle and to be tightened properly
- Ergonomically designed handle for easy handling
- Provides correct curvature to wire points of hand cleaning card for quick cleaning
- Handle allows user to exert right amount of force in required direction and avoids damage to the wire points



HCC Counts	Recommendation
24/28s 12s	For fillets on breaker part of shoddy/ carpet/cotton waste cards
14s 16s	For fillets on intermediate part of shoddy and finisher part of carpet / cotton waste card
18s 20s	For finisher part of shoddy, worsted and cotton cards
24s tinned 26s tinned	For metallic wires of Garnetts and cotton cards

### Card Wire Burnishing Pad

To help with better maintenance of metallic wires and improve carding efficiency, ICC provides special Card Wire Burnishing Pad, developed in association with 3M, world leaders in abrasives and surface finishing products.

The Burnishing Pad is used regularly on cylinder and doffer wires for resharpener of wire points. This gives consistent quality of carding inspite of longer intervals between grinding. Their main features are :



- Made from synthetic fibres and abrasive particles bonded together
- Gives even burnishing of wire points without damage to the base
- Reduces frequency of grinding, leading to increased life of wires
- Reduced stoppage time for grinding leading to better productivity
- Easy to use for cylinder and doffer wires
- Does not alter the dimensions of the wires
- Also helps remove trash particles and wax deposits on the wires
- Comes with a special handle for easy use



## Web Catcher

The Web Catcher, a part of ICC's range of products that help to enhance carding efficiency, is a simple device that replaces the Apron Doffing on the carding machine and increases carding machine's uptime.



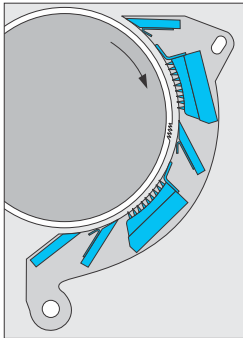
The main features of the ICC Web Catcher are:

- Simple to install
- Requires zero maintenance as there are no moving parts
- Web quality can be viewed easily
- Very nominal, one time cost and no recurring expenses
- Requires no electrical power
- Can be used at any doffer speed

ICC manufactures Web Catcher for Rieter and LR C1/ 2 and C1/3 cards.

## Accura Beater Segment

Good carding is heavily dependent on the amount of trash content and impurities that come in with fibre tufts from the Blow Room. If not removed, such impurities get further crushed in the card, and enmeshed with the fibres thus hampering their easy removal. ICC's design engineers have developed an improved method of trash elimination, which can be adapted for all popular Beaters.



The ACCURA Beater Segment is a replacement to the existing grid assembly in Rieter/LMW ERM Cleaners, LMW Flexiclean and Trützschler RSK Beater. The Beater Segments consists of grid bars and two beater segments having pins spread over the width and length of the beam.

The ACCURA Beater Segment, which is harsh on trash, but gentle to the fibres, offers the following advantages :

- Increased elimination of waste and trash particles
- Reduced loss of lint
- Reduced choking of chutes
- Lesser damage to wire points on the carding machine
- Reduced load of trash on the card

### For ERM and Flexiclean








**For RSK**

## Blow Room Wires

ICC offers an entire range of Blow Room Wires that are made by Garnett Wire Limited, UK and Marketed in India by ICC. These Wires are produced with a soft rib - necessary for easy and secure mounting - and high precision, hardened teeth which provide wear resistance and durability.

Besides the entire range of Blow room wires featured below, which are available from us on demand, we can also supply other wires for use in non-woven, worsted/woolen and waste reclamation fibres.

					
Code	Rib Thickness (mm)	Height (mm)	Pitch (mm)	Front Angle (Degree)	PPSI
<b>Interlocking Wires</b>					
TR 11	4.20	5.60	5.50	100°	28
TR 13	4.20	7.50	15.00	80°	10
V6/3270	4.20	6.00	7.75	70°	19
V8/470	3.17	5.70	6.35	70°	32
<b>Ribbed Wires</b>					
R 10/10	2.46	9.52	10.00	80°	-
R 20/10	2.46	9.52	20.00	80°	-
R 10/10	2.46	9.52	10.00	90°	-
R 20/0	2.46	9.52	20.00	90°	-
REF 356	2.18	10.00	12.50	80°	-

## Applications

Wire	Organ	Qty./Roll	Card	Wire	Organ	Qty./Roll	Card
		Kgs.				Kgs.	
TR 11	FBK	1200mm	10	V8-470	CVT 3 III Roll		Trützscher/
		1600mm	14		CNT 3 III Roll		Trumac
	RSK Feed Roll	1200mm	6		CVT 4 IV Roll 1200 mm	14	Blow Room
		1600mm	8		1600 mm	18	
TR 13	RSK Beater	1200mm	32	R 10/10	ERM, UNIMIX, MBO	15	
		1600mm	42	R 20/10	ERM, UNIMIX, MBO	15	Rieter/ LR
	CVT 3 II Roll			R 10/10	MBO	15	Blow Room
	CVT 4 II Roll	1200mm	20	R 20/10	MBO	15	
		1600mm	25	R 10/10 & 10/0	Flexiclean	17	LMW
				R20/10 & 20/0	Flexiclean	15	LMW
V6-3270	CNT 3 II Roll			TR 13	Beater	45	Crosrol
	CNT 4II Roll	1200 mm	20	REF356	Beater Roller	6	Blow Room Crosrol
		1600 mm	25				

## Recommendation Chart

SL. NO.	MATERIAL	STAPLE LENGTH MM	FINENESS MIC /DENIER	CYLINDER	PRODUCTION>40KGS PER DOFFER	HOURLY TOPS	LICKER IN
<b>A</b>	<b>COTTON</b>						
	<b>OPEN END</b>	20 -22	upto 5	42172057 / 51172057	25114055	Nextra 400	10SP/ RAP 5TPI
				64162053		E45 G	V08055080
	<b>CARDED</b>					T 450 Progressive	V10055080
	20s - 30s	20 - 25	4.2 - 5	42172057 / 51172057	25114055	Nextra 55	10SP/ RAP 5TPI
				64152055	32104055	E55 MAS	V08055080
	above 30s	upto 27	4.0 - 5.0	51 172057	32104055	Nextra 55	10SP/ RAP 5TPI
				64152055		E55 MAS	V08055080
						T 550 Progressive	
	<b>COMBED</b>						
	Below 40s	upto 27	above 3.5	51 172057	32104055	Nextra 55	10SP/ RAP 5TPI
				64152055		E55 MAS	V08055080
	40s -60s	upto 30	2.5 -3.0	51172057 / 51202055	32104055	Nextra 55	10SP/ RAP 5TPI
				64152055		T 550 Progressive	V08055080
	Above 60s	above 30	2.0 -3.0	51 172057 / 51202055	32104055	T 550 Progressive	11SP/ RAP 4TPI
				64152055 / 641 72057			V08045085
<b>B</b>	<b>SYNTHETICS</b>		Denier				
	POLYESTER	38 -55	upto 1.0	42172565 / 51152565	32104055	XL 450S G	15SP
						XL 400S G	V08035090
						E 45 G	
	POLYESTER	38 - 55	1.2 -3.0	42172565 / 51152570	32104055	XL 400S G	15SP/ 11SP
						XL 450S G	V08035090
						E45 G	
	POLYESTER/ VISCOSE	38 -55	1.2 -3.0	42172565 / 51152565	32104055	XL 400S G	15SP/ 11SP
						XL 450S G	V08035090
						E45 G	V08045085
<b>C</b>	<b>BLENDS</b>						
	SYNTHETICS/ COTTON	38 -55	1.2 -3.0	42172565 / 51172565	32104055	XL 400S G	11SP
	Predominantly Synthetic					XL 450S G	V08045085
						E45 G	
	COTTON / SYNTHETICS	38 -55	1.2 -3.0	51172565 32104055		XL 450S G	11SP
	Predominantly Cotton			42172057		E45 G	V08045085
							V08055080
<b>D</b>	<b>REGENERATED</b>						
				42172565 / 42172560	28134060	Nextra 400	10SP
							V08055080

NOTE: For Rieter C60 card 25124760; For Rieter C51 card Licker-in wire - V12085080

For 2nd L.I. Roller in Trützschler card - V 16105070; For 3rd L.I. Roller in Trützschler card - V16135070

The recommendation chart is for general guidelines only. However, the specifications finally chosen will depend on fibre length, micronaire, trash content, production rates and such allied factors. For the most optimum combination applicable to your needs, please contact the nearest ICC branch office.

PRODUCTION 20 KGS - 40KGS PER HOUR				PRODUCTION < 20 KGS PER HOUR			
CYLINDER	DOFFER	TOPS	LICKER IN	CYLINDER	DOFFER	TOPS	LICKERIN
42172560 / 42172057	28134060	XL300 Progressive	10SP	208SP/ 4615	28134060	XI300 Progressive/E355 HT	10 SP
	25114055	E45 HT	V08055080				
		TR450 Progressive	V10055080				
42172560/ 51172560	28134060/ 25114055	Nextra 55	10SP/ RAP 5TPI	4615/ 42172560	28134060	XL30S	10SP
42172057/ 51172057	32104055	E45 HT	V08055080	42172057		E35S HT/ E45 HT	RAP 5TPI
51172057	32134060	Nextra 55	10SP/ RAP 5 TPI	51172560	32134060	XI500 HT	10SP
51202055/ 64152055	32104055	E55 HT	V08055080	51172057		E45 HT/ E55 HT	RAP 5TPI
51172560/ 51172057	32134060	Nextra 55	10SP/RAP 5TPI	4765/ 51172560	32134060	XL00 HT/ E45 HT	10SP
51202055/ 64152055	32104055	E55 HT/ XL 500HT	V08055080	51172057		E55 HT	RAP 5TPI
51172560/ 51172057	32134060	TR 550 Progressive	10SP/ RAP 5 TPI	51172560/ 51172057	32134060	XL500 HT	10SP/11SP
51202055/ 64152055	32104055	E55 HT	V08055080	51202055		E55 HT	RAP 5 TPI
51172560/ 51172057	32134060	TR 550 Progressive	11SP/ RAP 4 TPI	51172560/ 51172057	32134060	XL500HT	11SP
51202055/ 64152055	32104055	E55 HT	V08045085	51202055/ 64152055		E55 HT	RAP 4TPI
64172057							
42172565/ 51152570	32134062(S)	XL450S HT	15SP	4615/ 42152570	32134062(S)	XL400S HT	15SP
		XL400S HT	V08035090			E35S HT	
		E 45 HT					
36172570/ 42152570	28134060/ 32134062(s)	XL400S HT	15SP/ 11SP	4615/ 42152570	28134060	XL400S HT	15SP
42172565/ 51152570		E45 HT	V08035090	208SP	32134062(s)	E30/ E35S HT	
36172570/ 42172565	28134060/32134062(S)	XL400S HT	15SP/11SP	4615/42152570	32134062(S)	XL400S HT	15SP
51152570/ 42182163		E 30/ E35S HT	V08035090	208SP		E30/ E35S HT	
		E45 HT	V08045085				
42172565/51172565	32134062(S)	XL400S HT	11SP	4615/ 42172565	32134062(S)	XL400S HT	11SP
		E35S HT/ E45 HT	V08045085			E35S HT	
51172565	32134060/32134062(S)	E35S HT	11SP	42172565	32134060	XI300 Progressive	11SP
42172057		E45 HT	V08045085	42172057	32134062(S)		
			V08055080				
42172565/ 42172560	28134060	XI300 Progressive	10SP	42172565	28134060	XI300 Progressive	10SP
		E45 HT	V08055080			E35S HT	

## General Maintenance of card clothing

To achieve optimum performance of card clothing care has to be taken right from its mounting operation.

### PREMOUNTING PREPARATIONS

True bare cylinder and doffer are the most important prerequisites before mounting the precision engineered metallic card clothing. The concentricity of the cylinder and doffer surface must be within  $\pm 0.02\text{mm}$ . In case of any deviation we recommend correction by grinding the bare surface with a good precise grinder. Static balancing should be checked before and after grinding. It is advisable to check periodically dynamic balancing at working speed. Bare flats should be checked for straightness and the surface variations should be maintained within 0.1 mm. The heel and toe if not as per recommended standard should be corrected by end milling.

### Mounting

Mounting of wire is an operation, which needs maximum care. Any fault occurring now, often cannot be corrected subsequently. Hence extra time spent in correct setting and mounting is well its worth. Any modern mounting machine may be used for this purpose after ensuring that the tension plate, pre bending roller and forming roller are in good condition. Recommended mounting tension should be applied to ensure that the wire sits firmly on the roller surface.

Similarly for flat tops, the clipping has to be carried out with a precise machine having correct form rollers.

### POST MOUNTING PREPARATIONS

#### Initial Grinding

After the mounting of metallic card clothing, initial grinding is recommended only for standard series of cylinder and doffer wires having a "land" to create striation on the land. For "Cut to point" wires such as Primus, Maxus, Tenace, Stylus and Crystal a very light grinding to level off high points may be taken. However this may not be necessary if adequate care has been taken before and during mounting. After clipping of flat tops a light grinding may, if necessary, be taken to maintain the surface accuracy within  $\pm 0.025\text{mm}$ .

#### Periodic Resharpener

All metallic wire and tops wear out due to material processing. The degree of wear depends on the material being processed and the type of wire used. To achieve consistent carding quality as well as desired life of card clothing, it is essential to sharpen the wire points at suitable interval. ICC strongly recommends use of Sharprite Wire Resharpener device or similar devices to carry out sharpening of Cylinder and doffer wires and Sharprite Tops to sharpen Tops. Deciding a proper schedule of sharpening is very important. In case of excessive wear of the wire tip, no amount of subsequent sharpening can restore it. Now a days most mills have modern testing facilities and hence monitoring the nep count, scn in a card sliver can be used as a convenient method to ascertain the sharpening schedule. After mounting of wires, the average nep count for the first 6 weeks may be recorded and used as a base value. Depending on mill's norm of nep count the sharpening schedule for cylinder wire, doffer wire and tops can be decided. It would also be possible to ascertain the proper time of sharpening, by checking the wire points with illuminated Microscope.

Licker in wire, stripper wire, stationary flats and feed roll wire should not be ground. These are to be replaced as per recommendation. The condition of flat cleaning, doffer cleaning and other fillets should be checked regularly and replaced if damaged.





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