

**TONG HE**



**高精度罗拉**

**HIGH PRECISION BOTTOM ROLLER**

# 产品说明

## PRODUCTS IN TRODUCTION

同和纺织机械制造有限公司是中国纺织机械协会副会长单位、中国棉纺织行业协会常务理事单位，国家高新技术企业。专注纺织器材成套装备及专件器材研发、制造、销售实现一体化。主要产品为各系列棉纺粗纱机、各系列细纱机、各系列粗细联，各系列棉纺细络联、各系列无机械波罗拉、高性能摇架和新型集聚纺纱装置。

同和公司现有棉纺细纱罗拉、棉纺粗纱罗拉、毛纺细纱罗拉、毛纺粗纱罗拉、绢纺机罗拉、精梳罗拉、并条罗拉、捻线罗拉、花式捻线罗拉、条并卷罗拉、紧密纺专用罗拉、紧密纺网孔罗拉以及特种罗拉等28大系列、198个品种，同和罗拉为国内知名主机厂和国外瑞士、德国、意大利、日本等主机配套，全球70%的用户正在使用同和罗拉，同和罗拉的产量、品种、质量均居世界第一，替代进口。公司已成为全球最大的纺纱机罗拉生产基地。同和罗拉原材料按照国际标准由上海宝钢定点特质；罗拉的加工设备均为引进瑞士、德国、美国、日本等世界顶级的成套数控设备，采用工序少、流程短的独特加工工艺；罗拉表面光滑、表面沟槽几何形状合理；热处理硬度理想、加工精度精确、圆整度好、耐磨损、无需校调，适合重加压、大牵伸、长机型；同和罗拉在使用中不变形、不挂花、无机械波，运转平稳。

同和公司是中华人民共和国纺机罗拉国家标准和行业标准的主要起草单位，已获得ISO9001 - 2008质量体系标准认证证书。同和罗拉均经中华人民共和国纺织机械质量监督检验中心检测认定。

同和公司将不断创新，挑战自我，挑战极限，向全球用户提供高附加值、高品质的纺机罗拉，为全人类的发展和进步贡献同和人的智慧！

Tonghe Textile Machinery Manufacture Co.,Ltd. is the vice-chairman of China Textile Machinery Association , the standing director of China Cotton Textile Association, and a high and new tech enterprise in China Province. Tonghe company integrates the research, development, manufacture and sales. Its main products include series cotton roving frames, series cotton ring spinning frames, series cotton bobbin transportation systems series cotton coner-link systems, series no-mechanical-wave bottom rollers, series high performance pendulum arms, and series new compact spinning devices.

Tonghe company has bottom rollers for cotton ring spinning frame, cotton roving frame, wool ring spinning frame, wool roving frame , silk spinning frame, combing machine, drawing machine, twisting machine, fancy twisting machine, article lap machine, compact spinning frame, and Rieter compact spinning frame, 28 series and 198 varieties in total. Tonghe bottom rollers have been mated for domestic well-known textile machines, and Swiss, German, Italian, Japanese machines, etc. Almost 70% global customers are using Tonghe bottom rollers, and Tonghe bottom roller's output, variety and quality are the first in the world.

Tonghe bottom roller's material is specially supplied by Shanghai Bao Steel in accord to international standard. Its process devices are imported top class CNC machines from Switzerland, Germany, America, Japan, etc., with few procedure, short technological process and unique craft. Its surface is smooth with reasonable geometry shape groove. It has ideal hardness after heat treatment, accurate process precision, fine roundness, wear resistance, needing no adjustment. It is applicable to heavy weighed and long drafting fame. It runs steadily without deformation, winding and mechanical wave .

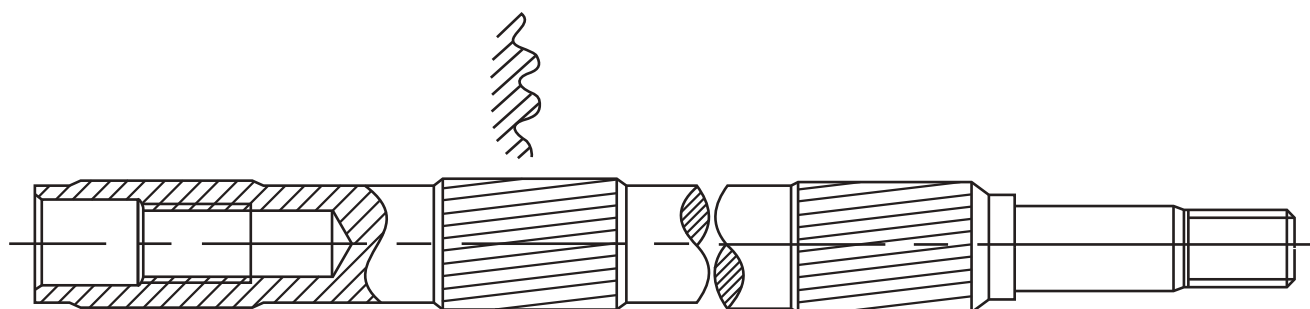
Tonghe company is the main draft member of pendulum arm national industrial standard and has already obtained ISO9001-2008 QS certificate. Tonghe bottom rollers are totally detected and affirmed by National Textile Machinery Quality Supervision Inspection Center.

Tonghe company will make continual creation, self-challenge, limitation-challenge, and supply the high value-added, high-quality bottom rollers to global customers, and contribute Tonghe people's wisdom for development and progress of the whole mankind.

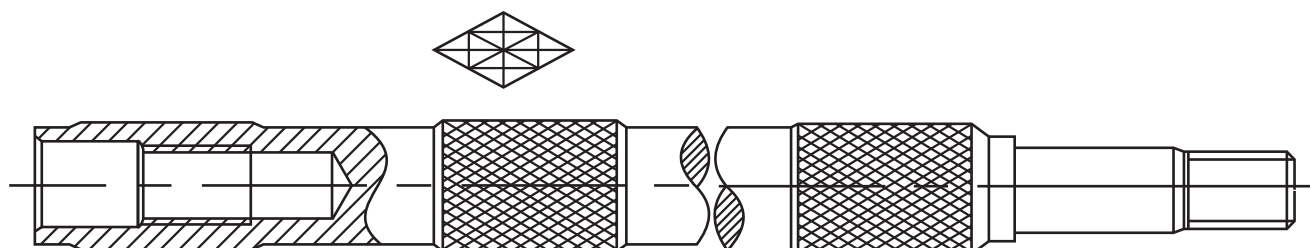
# 主要产品

## MAIN PRODUCTS

- > 棉纺细纱机罗拉
- > 棉纺粗纱机罗拉
- > 毛纺细纱机罗拉
- > 毛纺粗纱机罗拉
- > 绢纺机罗拉
- > 精梳机罗拉
- > 并条机罗拉
- > 捻线机罗拉
- > 花式捻线机罗拉
- > 条并卷机罗拉
- > bottom roller for cotton ring spinning frame
- > bottom roller for cotton roving frame
- > bottom roller for wool ring spinning frame
- > bottom roller for wool roving frame
- > bottom roller for silk spinning frame
- > bottom roller for combing machine
- > bottom roller for drawing machine
- > bottom roller for twisting machine
- > bottom roller for fancy twisting machine
- > bottom roller for article lap machine



斜齿沟槽罗拉 Helical Grooved Bottom Roller



菱形滚花罗拉 Crossing Knurled Bottom Roller

## TONGHE BOTTOM ROLLER



名称：棉纺细纱机罗拉

型号：FA506、F1520、EJM178、DTM139  
 长度：458(462)mm，直径： $\phi 25(\phi 27)$ mm  
 锭数：6 锭距：70mm  
 Name: bottom roller for cotton ring spinning frame  
 Type: FA506、F1520、EJM178、DTM139  
 Length: 458(462)mm, Diameter:  $\phi 25(\phi 27)$ mm  
 Spindles: 6 Gauge: 70mm



名称：德国棉纺细纱机罗拉

长度：599mm，直径： $\phi 27(\phi 30.45)$ mm  
 锭数：8 锭距：70mm  
 Name: bottom roller for German cotton ring spinning frame  
 Length: 599mm Diameter:  $\phi 27(\phi 30.45)$ mm  
 Spindles: 8 Gauge: 70mm



名称：瑞士棉纺细纱机罗拉

长度：738mm，直径： $\phi 32.4$ mm  
 锭数：10 锭距：140mm  
 Name: bottom roller for Swiss cotton ring spinning frame  
 Length: 738mm Diameter:  $\phi 32.4$ mm  
 Spindles: 10 Gauge: 140mm



名称：棉纺粗纱机罗拉

型号：FA458  
 长度：474mm、470mm，直径： $\phi 25$ 、 $\phi 28$ mm  
 锭数：4 锭距：108mm  
 Name: bottom roller for cotton roving frame  
 Type: FA458  
 Length: 474mm, 470mm Diameter:  $\phi 25$ ,  $\phi 28$ mm  
 Spindles: 4 Gauge: 108mm



名称：毛纺细纱机罗拉

型号：FB502  
 长度：497mm、492mm，直径： $\phi 30$ mm、 $\phi 35$ mm  
 锭数：6 锭距：75mm  
 Name: bottom roller for wool ring spinning frame  
 Type: FB502  
 Length: 497mm, 492mm Diameter:  $\phi 30$ mm,  $\phi 35$ mm  
 Spindles: 6 Gauge: 75mm



名称：意大利毛纺细纱机罗拉

长度：656.9mm，直径： $\phi 40$ mm  
 锭数：8 锭距：75mm  
 Name: bottom roller for Italian wool ring spinning frame  
 Length: 656.9mm Diameter:  $\phi 40$ mm  
 Spindles: 8 Gauge: 75mm

## TONGHE BOTTOM ROLLER



名称: 圣安德烈纺机罗拉  
 型号: N60101  
 长度: 660mm, 直径:  $\phi$  45mm  
 锭数: 4 锭距: 150mm  
 Name: Bottom roller for San Andre Textile Machinery  
 Type: N60101  
 Length: 660mm, Diameter:  $\phi$  45mm  
 Spindles: 4 Guage: 150mm



名称: 圣安德烈纺机罗拉  
 型号: N60701  
 长度: 660mm, 直径:  $\phi$  44.9mm  
 锭数: 4 锭距: 150mm  
 Name: Bottom roller for San Andre Textile Machinery  
 Type: N60701  
 Length: 660mm Diameter:  $\phi$  44.9mm  
 Spindles: 4 Guage: 150mm



名称: 毕加力纺机罗拉  
 型号: N60501  
 长度: 660mm, 直径:  $\phi$  26mm  
 锭数: 4 锭距: 150mm  
 Name: Bottom roller for Bigagli Textile Machinery  
 Type: N60501  
 Length: 660mm Diameter:  $\phi$  26mm  
 Spindles: 4 Guage: 150mm



名称: 毕加力纺机罗拉  
 型号: N60300  
 长度: 660mm, 直径:  $\phi$  26mm  
 锭数: 4 锭距: 150mm  
 Name: Bottom roller for Bigagli Textile Machinery  
 Type: N60300  
 Length: 660mm, Diameter:  $\phi$  26mm  
 Spindles: 4 Guage: 150mm



名称: 毕加力纺机罗拉  
 型号: N45101  
 长度: 1186mm, 直径:  $\phi$  40mm  
 锭数: 8 锭距: 150mm  
 Name: Bottom roller for Bigagli Textile Machinery  
 Type: N45101  
 Length: 1186mm Diameter:  $\phi$  40mm  
 Spindles: 8 Guage: 150mm



名称: 毕加力纺机罗拉  
 型号: N55002  
 长度: 1186mm, 直径:  $\phi$  40 mm  
 Name: Bottom roller for Bigagli Textile Machinery  
 Type: N55002  
 Length: 1186mm Diameter:  $\phi$  40mm

## TONGHE BOTTOM ROLLER



名称: 立达并条机罗拉  
 型号: D30  
 长度: 430mm, 直径:  $\phi$  30mm  
 Name: Bottom roller for Rieter drawing machine  
 Type: D30  
 Length: 430mm, Diameter:  $\phi$  30mm



名称: 立达并条机罗拉  
 型号: D40  
 长度: 434mm, 直径:  $\phi$  40mm  
 Name: Bottom roller for Rieter drawing machine  
 Type: D40  
 Length: 434mm, Diameter:  $\phi$  40mm



名称: 日本精梳机罗拉 (分段组装总长4421)  
 长度: 4421mm, 直径:  $\phi$  28.5mm  
 Name: Bottom roller for Japanese combing machine  
 (total assembling length: 4421mm)  
 Length: 4421mm, Diameter:  $\phi$  28.5mm



名称: 特吕茨施勒并条机罗拉  
 长度: 453.2mm, 直径:  $\phi$  35mm  
 Name: Bottom roller for Truetzschler drawing machine  
 Length: 453.2mm, Diameter:  $\phi$  35mm



名称: 特吕茨施勒并条机罗拉  
 长度: 443.5mm, 直径:  $\phi$  29.285mm  
 Name: Bottom roller for Truetzschler drawing machine  
 Length: 443.5mm, Diameter:  $\phi$  29.285mm



名称: 特吕茨施勒并条机罗拉  
 长度: 452.5mm, 直径:  $\phi$  70mm  
 Name: Bottom roller for Truetzschler drawing machine  
 Length: 452.5mm, Diameter:  $\phi$  70mm

## TONGHE BOTTOM ROLLER



名称: 精梳机罗拉 (分段组装总长3202)  
 型号: A201D  
 长度: 3202mm, 直径:  $\phi$  23mm  
 锭数: 6 锭距: 500mm  
 Name: bottom roller for combing machine (totally assembling length: 3202mm)  
 Type: A201D  
 Length: 3202mm, Diameter:  $\phi$  23mm  
 Spindles: 6 Gauge: 500mm



名称: 条并卷机罗拉  
 型号: FA366  
 长度: 426mm, 直径:  $\phi$  32mm  
 Name: bottom roller for article lap machine  
 Type: FA366  
 Length: 426mm Diameter:  $\phi$  32mm



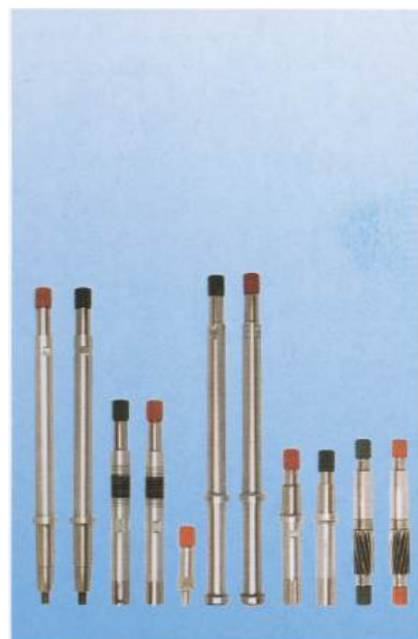
名称: 并条机罗拉  
 型号: FA306  
 长度: 497.5 mm, 直径:  $\phi$  35mm  
 Name: bottom roller for drawing machine  
 Type: FA306  
 Length: 497.5mm Diameter:  $\phi$  35mm



名称: 捻线机罗拉  
 型号: A631  
 长度: 808mm, 直径:  $\phi$  45mm  
 Name: bottom roller for twisting machine  
 Type: A631  
 Length: 808mm Diameter:  $\phi$  45mm



名称: 涡流纺机罗拉  
 长度: 418mm, 458mm, 117mm 直径:  $\phi$  32mm、 $\phi$  25mm  
 Name: bottom roller for vortex spinning machine  
 Length: 418mm, 458mm, 117mm  
 Diameter:  $\phi$  32mm,  $\phi$  25mm



名称: 棉、毛、绢、粗、细纱机罗拉头尾  
 Name: head and tail of bottom roller for cotton, wool, silk ring spinning frames and roving frames

# 罗拉规格及主要技术参数

## SPECIFICATIONS AND MAIN PARAMETERS OF BOTTOM ROLLERS

单位 mm

序号 No.	罗拉名称 name of bottom roller	罗拉型号 type of bottom roller	罗拉主要技术参数 specification					备注 notes
			直径 diameter	锭距 spindle gauge	锭数 number of spindle	镀铬 chromium- plating	配用轴承 fitted bearing	
1	棉纺细纱机 罗拉 bottom roller for cotton ring frame	TH518/578 FA506/1508 JWF1510/1516	φ25 φ27	70	6	镀铬 chromium- plating	LZ2822 LZ3224	沟槽齿为圆弧 滚花齿为密齿 arcual groove dense knurl
		TH598 TH698	φ27	70	8	镀铬 chromium- plating	LZ3224	沟槽齿为圆弧 滚花齿为密齿 arcual groove dense knurl
		FA507 EJM128K EJM128A	φ25 φ27	70	6	镀铬 chromium- plating	LZ2822 LZ3224	沟槽齿为圆弧 滚花齿为密齿 arcual groove dense knurl
		EJM128JL EJM138JL EJM178JL	φ27	70	6	镀铬 chromium- plating	LZ3224	沟槽齿为圆弧 滚花齿为密齿 arcual groove dense knurl
		FA507A FA507B DTM1 29	φ25 φ27	70	6	镀铬 chromium- plating	LZ2822 LZ3224	沟槽齿为圆弧 滚花齿为密齿 arcual groove dense knurl
		DTM1 39	φ27	70	6	镀铬 chromium- plating	LZ3224	沟槽齿为圆弧 滚花齿为密齿 arcual groove dense knurl
		FA502 FA503	φ25	70	6	镀铬 chromium- plating	LZ2822	沟槽齿为圆弧 滚花齿为密齿 arc teeth on grooved roller close teeth on knurled roller
		A512 A512A A512B A512C	φ25	70	6	镀铬 chromium- plating	LZ2822	老机改造型 old machine modification
		A513F	φ25 φ27	70	6	镀铬 chromium- plating	LZ2822 LZ3224	老机改造型 old machine modification
		A515 FA504	φ25	66.675	6	镀铬 chromium- plating	LZ2822	老机改造型 old machine modification
		A513C A513E A513W	φ25 φ27	70	6	镀铬 chromium- plating	LZ2822 LZ16.5 LZ3224	老机改造型 长导柱 46 短导柱 34 old machine modification long guide post 46 short guide post 34
		1291 1292 1293 1294	φ25	66.7 66.675	8	镀铬 chromium- plating	LZ2822 LZ16.5	老机改造型 长导柱 46 短导柱 34 old machine modification long guide post 46 short guide post 34
		1291 1292 1293 1294	φ27	66.7 66.675	8	镀铬 chromium- plating	LZ3224 LZ19	短导柱 37 short guide post 37
		国外机型 国内改造 foreign machine modified domestically	φ25 φ26 φ27 φ28	来图纸或来样实测 manufactured in accordance with the technical drawings or samples	4 6 8	镀铬 chromium- plating	来图纸或来样实测 manufactured in accordance with the provided sample or technical drawing	德国 日本 瑞士 意大利 美国 法国 German Japan, Switzerland, Italy USA France

# 罗拉规格及主要技术参数

## SPECIFICATIONS AND MAIN PARAMETERS OF BOTTOM ROLLERS

单位 mm

序号 No.	罗拉名称 name of bottom roller	罗拉型号 type of bottom roller	罗拉主要技术参数 specification					备注 notes
			直径 diameter	锭距 spindle gauge	锭数 number of spindle	镀铬 chromium- plating	配用轴承 fitted bearing	
2	棉纺粗纱机 罗拉 bottom roller for cotton roving machine	FA401 TJFA458	φ 28 φ 25	108	4	镀铬 chromium- plating	LZ3224 LZ2822	沟槽齿为圆弧 滚花齿为密齿 arcual groove dense knurl
		FA402 TJFA457	φ 28 φ 25	90	4	镀铬 chromium- plating	LZ3224 LZ2822	沟槽齿为圆弧 滚花齿为密齿 arcual groove dense knurl
		FA415A	φ 28.5	110	4	镀铬 chromium- plating	LZ3224	沟槽齿为圆弧 滚花齿为密齿 arcual groove dense knurl
		FA415	φ 28 φ 25	110	4	镀铬 chromium- plating	LZ3224 LZ2822	沟槽齿为圆弧 滚花齿为密齿 arcual groove dense knurl
		FA416	φ 28 φ 25	97	4	镀铬 chromium- plating	LZ3224 LZ2822	沟槽齿为圆弧 滚花齿为密齿 arcual groove dense knurl
		ASFA411 HY491 HY492	φ 28.5	97	4	镀铬 chromium- plating	LZ3224	沟槽齿为圆弧 滚花齿为密齿 arcual groove dense knurl
		FA421	φ 28.5	110	4	镀铬 chromium- plating	LZ3224	沟槽齿为圆弧 滚花齿为密齿 arcual groove dense knurl
		FA423	φ 28.5	97	4	镀铬 chromium- plating	LZ3224	沟槽齿为圆弧 滚花齿为密齿 arcual groove dense knurl
		FA496	φ 28.5	110	4	镀铬 chromium- plating	LZ3224	沟槽齿为圆弧 滚花齿为密齿 arcual groove dense knurl
		国外机型 国内改造 foreign machine modified domestically	来技术图纸或来样实测 manufactured in accordance with the technical drawings or samples					
3	毛纺细纱机 罗拉 bottom roller for wool ring spinning frame	FB502	φ 35 φ 30	75	6	镀铬 chromium- plating	LZ3224 LZ3624	沟槽齿为圆弧 滚花齿为密齿 arcual groove dense knurl
		FB504	φ 35	82.5	6	镀铬 chromium- plating	LZ3624	沟槽齿为圆弧 滚花齿为密齿 arcual groove dense knurl
		B583C	φ 35	75	6	镀铬 chromium- plating	LZ3624	沟槽齿为圆弧 滚花齿为密齿 arcual groove dense knurl
		FB505	φ 35	75	6	镀铬 chromium- plating	LZ22	沟槽齿为圆弧 滚花齿为密齿 arcual groove dense knurl
		意大利 Italy	φ 32 φ 35 φ 40	75	8	镀铬 chromium- plating	进口轴承 importded bearing	出口罗拉配意大利主机厂 exported bottom roller fitted with Italian machinery manufacturers

# 罗拉规格及主要技术参数

## SPECIFICATIONS AND MAIN PARAMETERS OF BOTTOM ROLLERS

单位 mm

序号 No.	罗拉名称 name of bottom roller	罗拉型号 type of bottom roller	罗拉主要技术参数 specification					备注 notes
			直径 diameter	锭距 spindle gauge	锭数 number of spindle	镀铬 chromium- plating	配用轴承 fitted bearing	
4	毛纺粗纱机 罗拉 bottom roller for wool roving frame	FB441	φ23 φ40	214	2	镀铬 chromium- plating	LZ3224 LZ3264	沟槽直齿 straight groove
		国外机型 国内改造 foreign machine modified domestically	来技术图纸或来实样实测 manufactured in accordance with the technical drawings or samples					美国 德国 日本 法国 意大利 USA Germany Japan FranceItaly
5	苧麻罗拉 ramie bottom roller	FZ501	φ35	70	6	镀铬 chromium- plating	用户自配 fitted by customer	沟槽齿为圆弧 滚花齿为密齿 arcual groove dense knurl
6	绢纺机罗拉 bottom roller of silk spinning machine	FK501	φ35	70	6	镀铬 chromium- plating	LZ4526 LZ4024	沟槽齿为圆弧 滚花齿为密齿 arcual groove dense knurl
7	精梳机罗拉 bottom roller of combing machine	A201D PX2	φ23	500	6 8	镀铬 chromium- plating	用户自配 fitted by customer	分段连接式(斜齿) sectional connection type (helical teeth)
		FA261	φ25	470	6 8	镀铬 chromium- plating	用户自配 fitted by customer	分段连接式(斜齿) sectional connection type (helical teeth)
		HJS300			8	镀铬 chromium- plating	用户自配 fitted by customer	分段连接式(斜齿) sectional connection type (helical teeth)
		HY68			8	镀铬 chromium- plating	用户自配 fitted by customer	分段连接式(斜齿) sectional connection type (helical teeth)
8	并条机罗拉 bottom roller for drawing machine	FA306	φ35 φ40	365	1	镀铬 chromium- plating	用户自配 fitted by customer	斜齿 helical teeth
		FA311	φ35	294	1	镀铬 chromium- plating	用户自配 fitted by customer	斜齿 helical teeth
		FA313	φ35	211	1	镀铬 chromium- plating	用户自配 fitted by customer	斜齿 helical teeth
		FA315 FA317A FA319	φ35 φ40 φ59	446 525 833	1	镀铬 chromium- plating	用户自配 fitted by customer	斜齿 helical teeth
		FA303 FA305	φ35 φ40	180 170	1	镀铬 chromium- plating	用户自配 fitted by customer	直齿斜齿 spur type, helical teeth
9	捻线机罗拉 bottom roller for twisting machine	A631	φ45	721	1	镀铬 chromium- plating	用户自配 fitted by customer	光圆 Smooth roundness
		FA721	φ45	1176	1	镀铬 chromium- plating	用户自配 fitted by customer	光圆 Smooth roundness

# 罗拉规格及主要技术参数

## SPECIFICATIONS AND MAIN PARAMETERS OF BOTTOM ROLLERS

单位 mm

序号 No.	罗拉名称 name of bottom roller	罗拉型号 type of bottom roller	罗拉主要技术参数 specification					备注 remarks
			直径 diameter	锭距 spindle gauge	锭数 number of spindle	镀铬 chromium- plating	配用轴承 fitted bearing	
10	花式捻线机 罗拉 bottom roller for fancy twisting machine	SKV304C	φ40	977 1111 1117.5 1013.5	1 1 1 1	镀铬 chromium- plating	用户自配 fitted by customer	光圆 smooth roundness
		FZZ032	φ45	925 280	1 1	镀铬 chromium- plating	用户自配 fitted by customer	光圆 smooth roundness
		N60101 N60300 N60501 N60701 N55002 N45101	φ45 φ26 φ26 φ44.9 φ40 φ40	150 150 150 150 1186 150	4 4 4 4 1 8	镀铬 chromium- plating	用户自配 fitted by customer	出口罗拉配意大利主机厂 exported bottom roller fitted with Italian machinery manufacturers
11	条并卷机 罗拉 bottom roller for article lap machine	SR80J HY51 E2/4 TBL100	φ27	170	1	镀铬 chromium- plating	用户自配 fitted by customer	斜齿 helical teeth
12	非标罗拉 non- standard bottom roller	319SL	φ27	70	8	镀铬 chromium- plating	用户自配 fitted by customer	斜齿 helical teeth
		凡进口纺机设备或国产老设备的罗拉，请用户来技术图纸或邮寄实样实测制造 Bottom rollers for imported spinning machines or domestic old ones are manufactured in accordance with the provided drawings or samples.						
13	织机、纺机、 电机各种高精 度轴类 all kinds of highly precision shafts for weaving machines textile machines, motors	来技术图纸或邮寄实样实测制造 manufactured in accordance with the technical drawings or samples						

# 产品介绍 I

## 高精度无害机械波罗拉

### 适用范围:

- 40 支以下纱线的生产。
- 各类普梳纱线的生产。
- 其他要求纱线的生产。

### 罗拉优点:

- 采用国内一流的加工手段。
- 采用国内最优质的原材料。
- 合理的罗拉表面沟槽几何形状。
- 理想的罗拉热处理硬度。
- 精确的罗拉加工精度。
- 最佳的罗拉圆整度。
- 优良的罗拉表面处理。
- 先进的检测技术。



### 质量承诺:

- 两节罗拉镶接静态测试跳动 $\leq 0.05\text{mm}$ ，上机安装无需垫片。
- 罗拉上机前无需预校调，可直接上机连接、扭紧、不经校调每锭打跳动 95% 均在  $0.02\text{mm}$  范围内，最大不超过  $0.05\text{mm}$ 。
- 罗拉表面色泽一致，光滑无毛刺、无磕碰、不挂花。
- 机械波拉网检测 95% 以上达到无害机械波幅，最大波幅不超过  $8\text{mm}$ 。
- 长期使用不走动，运转平稳，一致性好。

# INTRODUCTION OF PRODUCTS I

## High-Precision and Non-mechanical Wave Bottom Roller

### Applicable Range

- For production of yarn  $\leq 40$  Ne
- For production of carded yarn
- For production of other yarns

### Bottom Roller Features

- Manufactured in domestic first class processing means
- Adopt highest grade material from domestic market
- Reasonable geometry shape groove
- Perfect heat treated hardness
- Accurate processing precision
- Optimized roundness
- Excellent surface treatment
- Advanced inspection technology

### Quality Commitment

- Runout of spliced two pieces of bottom rollers under static testing  $\leq 0.05$ mm, no need of pad for installation
- No need of presetting before bottom rollers installed on the machine, only need to link tightly 95% of each spindle runout range within 0.02mm, maximum volume not exceed 0.05mm
- Smooth surface without bur or wound
- Rate of non-mechanical wave amplitude is higher than 95%, maximum wave volume not exceed 8mm
- Running smoothly with good uniformity

# 产品介绍 II

## 超级高精度无机机械波罗拉

### 适用范围:

- 40支~80支纱线的生产。
- 各类精梳纱线的生产。
- 其他较高要求纱线的生产。

### 罗拉优点:

- 部分工序采用世界顶级的加工手段。
- 采用国内最优质的原材料。
- 合理的罗拉表面沟槽几何形状。
- 理想的罗拉热处理硬度。
- 精确的罗拉加工精度。
- 最佳的罗拉圆整度。
- 优良的罗拉表面处理。
- 先进的检测技术。



### 质量承诺:

- 优质原材料抗弯强度比常规罗拉提高 9.1%。
- 两节罗拉镶接静态测试跳动 $\leq 0.05\text{mm}$ ，上机安装无需垫片。
- 罗拉上机前无需预校调，可直接上机连接、扭紧、不经校调每锭打跳动 95% 均在 $0.02\text{mm}$ 范围内，最大不超过  $0.05\text{mm}$ 。
- 罗拉表面色泽一致，光滑无毛刺、无磕碰、不挂花。
- 机械波拉网检测95%以上达到无机机械波幅（平波幅），最大不超过 $5\text{mm}$ 。
- 选用超级高精度无机机械波罗拉前、中、后三列罗拉，条干、粗节、棉结、毛羽、锭差显著改善。
- 优质主机配置超级高精度无机机械波罗拉，常规品种均可达到 2013 乌斯特公报 5% 水平。
- 长期使用不走动，运转平稳，一致性好。

# INTRODUCTION OF PRODUCTS II

## Super High-Precision Non-mechanical Wave Bottom Roller

### Applicable Range

- For production of yarn from 40 Ne to 80 Ne
- For production of combed yarn
- For production of other yarns with higher requirement

### Bottom Roller Features

- Partial working procedures are adopted with first level means in the world
- Adopt highest grade material from domestic market
- Reasonable geometry shape groove
- Perfect heat treatment hardness
- Accurate processing precision
- Optimized roundness
- Excellent surface treatment
- Advanced inspection technology

### Quality Commitment

- Made of high grade material, its anti-bending strength is 9.1% higher than that of ordinary roller
- Runout of spliced two pieces of bottom rollers under static testing  $\leq 0.05\text{mm}$ , no need of pad for installation
- No need of presetting before bottom rollers installed on the machine, only need to link tightly, 95% of each spindle runout range within 0.02mm, maximum volume not exceed 0.05mm.
- Smooth surface without bur or wound
- Rate of non-mechanical wave (even wave) amplitude is higher than 95%, maximum volume not exceed 5mm
- By using these front, middle and rear bottom rollers, CV%, thick knot, cotton knot, hairiness and CVB% can be markedly improved.
- If the excellent machine equipped with super high-precision non-mechanical wave bottom roller, ordinary varieties all reach 5% level of 2013's Uster communique.
- Running smoothly with good uniformity

# 产品介绍 III

## 新一代超级高精度无机械波罗拉

### 适用范围：

- 80支以上高支纱线的生产。
- 紧密纺纱线的生产。
- 其他较高要求纱线的生产。

### 罗拉优点：

- 采用世界顶级全流程原装各类进口设备加工。
- 采用与世界同步的最优质的原材料。
- 最合理的罗拉表面沟槽几何形状。
- 最理想的罗拉热处理硬度。
- 最精确的罗拉加工精度。
- 最佳的罗拉圆整度。
- 最优良的罗拉表面处理。
- 最先进的检测技术。



### 质量承诺：

- 优质原材料抗弯强度比常规罗拉提高9.1%。
- 两节罗拉镶接静态测试跳动 $\leq 0.05\text{mm}$ ，上机安装无需垫片。
- 罗拉上机前无需预校调，可直接上机连接、扭紧、不经校调每锭打跳动 98% 均在  $0.02\text{mm}$  范围内，最大不超过  $0.05\text{mm}$ 。
- 罗拉表面色泽一致，光滑无毛刺、无磕碰、不挂花。
- 机械波拉网检测 98% 以上达到无机械波幅（平波幅），最大不超过  $3\text{mm}$ 。
- 选用新一代超级高精度无机械波罗拉前、中、后三列罗拉，条干可下降  $0.2\% \sim 1\%$ ；各项粗节、细节、棉结、毛羽、锭差显著改善。
- 优质主机配置新一代超级高精度无机械波罗拉，常规品种均可达到 2013 乌斯特公报 5% 水平。
- 长期使用不走动，运转平稳，一致性好。

# INTRODUCTION OF PRODUCTS III

## New Generation Super High-Precision Non-mechanical Wave Bottom Roller

### Applicable Range

- For production of yarn  $\geq 80$  Ne
- For production of compact spinning yarn
- For production of other yarns with higher requirement

### Tonghe Bottom Roller Features

- Manufactured by various world' s top imported equipment during the whole processing
- Material grade the same as the top one in the world
- The most optimal geometry shape groove
- Best heat treatment hardness
- The most accurate processing precision
- The most optimized roundness
- Best surface treatment
- The most advanced inspection technology

### Quality Commitment

- Made of high grade material, its anti-bending strength is 9.1 % higher than that of ordinary bottom roller
- Runout of spliced two pieces of bottom rollers under static testing  $\leq 0.05$  mm, no need of pad for installation
- No need of presetting before bottom rollers installed on the machine, only need to link tightly, 98% of each spindle runout range within 0.02mm, maximum volume not exceed 0.05 mm
- Smooth surface without bur or wound.
- Rate of non-mechanical wave ( even wave amplitude) is higher than 98%, maximum volume not exceed 3mm.
- By using these front,middle and rear bottom rollers,CV% can decrease 0.2% -1%, and thick knot, cotton knot, hairiness and CVB% can be markedly improved.
- If the excellent machine equipped with new generation super high-precision non-mechanical wave bottom roller, ordinary varieties all reach 5% level of 2013's Uster communique.
- Running smoothly with good uniformity

# 产品介绍 IV

## INTRODUCTION OF PRODUCTS IV

### 新一代超级高精度无机械波紧密纺罗拉

#### 特点：

- 采用新工艺、新材料，抗弯强度比原有罗拉提高 9.1%。
- 罗拉表面处理采用新技术、新工艺，光滑、无毛刺、不挂花。
- 罗拉上机前无需预校调，可直接上机连接拧紧，  
不经校调，每锭打跳动98%均在0.02mm范围内，最大不超过 0.05mm。
- 罗拉无机械波率达到98%以上。
- 机械波拉网检测，98%以上达到无机械波幅（平波幅），最大不超过3mm。
- 为棉纺织厂全面提升纺纱质量，达到2013乌斯特公报5%水平提供保障。



### New Generation Super High-Precision Non-mechanical Wave Compact Bottom Roller

#### Features

- Anti-bending strength has been improved by 9.1% by adopting new craft and materials.
- New technology and craft for the surface treatment, making it smooth without bur or wound
- No need of presetting before bottom rollers installed on the machine, only need to link tightly, 98% of each spindle runout range within 0.02mm, maximum volume not exceed 0.05mm.
- Rate of non-mechanical wave reaches more than 98%.
- Rate of non-mechanical wave(even wave) amplitude reaches more than 98%, maximum volume not exceed 3mm
- Improving yarn quality for cotton textile mills and reaching 5% level of 2013' s Uster communicate.

# 产品介绍 V

## INTRODUCTION OF PRODUCTS V

### 网孔紧密纺罗拉

#### 特点:

- 采用新工艺、新材料。
- 罗拉表面处理采用新技术、新工艺，光滑、无毛刺、不挂花。
- 罗拉上机前无需预校调，可直接上机连接拧紧，
- 罗拉无机械波率达到98%以上。
- 机械波拉网检测，98% 以上达到无机械波幅（平波幅），最大不超过3mm。
- 为棉纺织厂全面提升纺纱质量，达到 2013 乌斯特公报 5% 水平提供保障。



### Perforated Bottom Roller

#### Features

- Adopting new craft and materials
- New technology and technique for the surface treatment, making it smooth without bur or wound  
No need of presetting before bottom rollers installed on the machine, only need to link tightly
- Rate of non-mechanical wave reaches more than 98%.
- Rate of non-mechanical wave(even wave) amplitude reaches more than 98%,  
maximum volume not exceed 3mm
- Improving yarn quality for cotton textile mills and reaching 5% level of 2013's Uster communicate.



# 国际先进的加工设备》》

INTERNATIONAL ADVANCED PROCESS EQUIPMENTS



德国高精度自动矫直机  
Germany Auto Straightening Machine



德国高精度自动轧齿机  
Germany Auto Rolling Machine

# 国际先进的加工设备》》

## INTERNATIONAL ADVANCED PROCESS EQUIPMENTS



德国进口全自动双通道淬火机  
Germany Imported Automatic Double Channel Quench Machine



德国进口全自动外圆磨床  
Germany Imported Automatic Cylindrical Grinder



日本进口全自动无心磨床  
Japan Imported Automatic Centerless Grinder

# 国际先进的加工设备》》

## INTERNATIONAL ADVANCED PROCESS EQUIPMENTS



美国进口数控车床  
American Imported CNC Turning Machine



全自动数控磨齿机  
Automatic CNC Tooth Grinder



真空淬火炉  
Vacuum Quench Stove

# 国际先进的检测仪器

## INTERNATIONAL ADVANCED INSPECTION INSTRUMENT

同和公司致力于产品质量的控制与提升，花巨资引进了国际先进的试验和检测仪器，用于新产品的开发试验和常规产品的日常检验。

Tonghe company devotes itself to the control and improvement of products' quality, and spends more investment to introduce international advanced testing inspection instruments for the development of new products and daily inspection of conventional products.



1	2	1、显微硬度计 Micro Hardness Tester
3	4	2、英国泰勒圆度测试仪 British Taylor Roundness Tester
5		3、高精度影像测绘仪 High Precision Vision Mapper
		4、投影仪 Projector
		5、轮廓仪 Contourgraph

# 新一代超级高精度无机械波罗拉

该产品经安徽华茂纺织股份有限公司、无锡长新纺织有限公司（无锡市第一纺织厂）、华芳集团棉纺有限公司、江苏大生集团有限公司、鲁泰纺织股份有限公司、山东魏桥创业集团有限公司、华润纺织（集团）有限公司、山东如意科技集团有限公司、青岛纺联控股集团有限公司、泰丰纺织集团、百隆东方股份有限公司、河南舞钢银龙纺织有限公司、河南新野纺织股份有限公司、石家庄常山纺织集团有限公司、天津天纺投资控股有限公司、湖南东信集团有限公司、际华三五四二纺织有限公司、新疆溢达纺织有限公司、福建长乐金源纺织有限公司等千余家知名企业广泛使用（累计千余万节），并随同和公司自配主机配套出口，在国内外用户中引起了强烈反响、并给予高度评价，普遍认为该新品具有如下特点：

- 该罗拉成功地解决了纺高支纱产生机械波的难题，为生产高档织物创造了良好的条件，采用该新品可有效地提高纺织品市场竞争力，有利于扩大出口。
- 可增加纺织品的附加值，提高企业的经济效益。
- 该新品罗拉不经校调即可直接上车、大大减少维修工作量，提高工作效率。
- 该新品罗拉各项技术指标均已达到国际先进水平，因此可以替代进口。

欢迎新老客户使用“**新一代超级高精度无机械波罗拉**”！本公司将竭诚为您提供一流的服务。

## New Generation Super High-Precision Non-mechanical Wave Bottom Roller

This product has been widely adopted by more than 1,000 well-known enterprises such as Anhui Huamao Textile Co.,Ltd., Wuxi Changxin Textile Co.,Ltd., (Wuxi No.1 Textile Mills), Huafang Cotton Spinning Co.,Ltd., Jiangsu Dasheng Group, Lutai Textile Co.,Ltd., Shandong Weiqiao Pioneering Group, China Resource Textile (Holdings) Co.,Ltd., Shandong Ruyi Science & Technology Group, Qingdao Textiles Group, Shandong Taifeng Textile Co.,Ltd., Bros Holding Limited, Henan Wugang Yinlong Textile Co.,Ltd., Henan Xinye Textile Co.,Ltd., Shijiazhuang Changshan Textile Co.,Ltd., Tianjin Tianfang Investment Holding Co.,Ltd., Hunan Dongxin Group, Jihua3542 Textile Co.,Ltd., Xinjiang Esquel Textile Co.,Ltd., Fujian Changle Jinyuan Textile Co.,Ltd etc., accumulatively providing them with more than 10,000,000 bottom rollers. Moreover, this product also has been exported along with Tonghe frames. Customers at home and abroad speak highly of this product and all think it has features as follows.

- This bottom roller has successfully solved the problem of mechanical wave appearing in high counts spinning, which provide a favorable foundation of superior textile products. Adopting this bottom roller could improve marketing competition and expand export business.
- Increasing textile products' additional value to improve enterprises' financial profits.
- This bottom roller could be installed without presetting, which greatly reduces maintainance and improves efficiency
- The technical specifications of this product have reached the world level. As a result, it can be as a substitution of imported one.

Welcome all customers to use “**New Generation Super High-Precision Non-mechanical Wave Bottom Roller**”！Tonghe Company will heartedly serve you.

# 公司承诺 >>

## 质量承诺:

- 严格按照中华人民共和国行业标准 FZ/T92019 制造。
- 产品实行全数检验，确保件件合格。
- 产品装箱合格率 100%，开箱合格率 100%，开机合格率 100%。
- 高精度无害机械波罗拉：无害机械波率 $\geq 95\%$ ，最大波幅不超过 8mm。
- 超级高精度无害机械波罗拉：无机机械波率 $\geq 98\%$ ，拉网检测无机机械波幅达到 95%以上（平波幅），最大不超过 5 mm。
- 新一代超级高精度无害机械波罗拉：无机机械波率 $\geq 98\%$ ，拉网检测无机机械波幅达到 98%以上（平波幅），最大不超过 3 mm。

## 交货期承诺:

- 为主机厂配套的罗拉和纺织厂所需备配件，严格按合同期限执行。
- 纺织厂所需急件，根据实际情况及时加工、迅速发货。

## 价格承诺:

- 实行全国统一销售价格
- 向长期配套的主机厂提供最优惠的价格。
- 向大批量整台订购罗拉的棉纺织厂提供最优惠的价格。
- 向订购配件或非标罗拉的客户仅增收所需的工装和刀具费用，基本价格仍维持不变。

## 售后服务承诺:

- 售后服务宗旨：用户满意是本公司唯一的追求目标。
- 售后服务方针：快速、果断、准确、彻底、满意。
- 售后服务效率：接到用户的服务指令后，凡江苏省内的用户，服务人员在24小时之内到达；凡江苏省外的用户，服务人员在24小时之内出发。用户来电、来函，4小时之内答复。
- 售后服务理念：终身服务、终身跟踪、终身负责。

## OUR COMMITMENTS

### Commitment to Quality

- Manufacturing in accordance with the industry standard of the People's Republic of China, FZ/T92019.
- Performing 100% products inspection to guarantee each product to be qualified.
- Guaranteeing qualified rate of final inspection 100%, qualified rate of customer inspection 100%, qualified rate of running 100%.
- High precision non-mechanical wave bottom roller: rate of non-mechanical wave  $\geq 95\%$ , maximum wave volume not exceed 8mm
- Super high-precision non-mechanical wave bottom roller: rate of non-mechanical wave  $\geq 98\%$ , rate of non-mechanical wave amplitude  $\geq 95\%$ , maximum volume not exceed 5mm
- New generation super high-precision non-mechanical wave bottom roller: rate of non-mechanical wave  $\geq 98\%$ , rate of non-mechanical wave amplitude  $\geq 98\%$ , maximum volume not exceed 3mm

### Commitment to Delivery Time

- Strictly complying with contract to deliver bottom rollers requested by machinery manufacturers and fittings or spare parts by textile mills
- Processing and delivering rapidly according to textile mills' urgent demands.

### Commitment to Price

- Implementing uniform price all over China
- Offering best favorable price to machinery manufacturers with long-term cooperation
- Offering best favorable price to textile mills that order entire sets of bottom rollers
- Only charging necessary expense of special moulds and tools from customers purchasing fittings and non-standard bottom rollers, keeping basis price unchanged

### Commitment to After-sales Service

- Aim of after-sales service: customer satisfaction is the only objective our company pursues.
- Policy of after-sales service: speediness, decision, accuracy, thoroughness and satisfactoriness.
- Efficiency of after-sales service: once receiving customer's requirement of service, clerk should arrive within 24 hours for customers inside Jiangsu Province, and set out within 24 hours for customers outside Jiangsu Province. All customers' feedbacks should be replied within 4 hours.
- Theory of after-sales service: lifelong service, lifelong tracking and lifelong responsibility.

# 订货须知 >>

## INSTRUCTIONS FOR ORDER

### 尊敬的客户

为了更好地提供服务，做到及时、优质、准确提供各种机型的罗拉，减少不必要的损失，请您认真按照订货须知规定的内容，来电、来信、来函、来人订货和洽谈。

### 棉纺织厂订货时

- 凡棉纺织厂需订购罗拉作配件和备件，应注明主机厂家、主机型号、主机出厂年月、罗拉件号、直径、锭距、锭数、每一台套中不同规格的数量。订购头尾段时，需提供图。
- 凡棉纺织厂需订购罗拉作老机改造时，请注明主机厂家、主机型号、主机出厂年月、罗拉件号、直径、锭距、锭数、每一台套中不同规格的数量。若进口机型，需提供罗拉图纸或罗拉实样。

### 主机厂订货时

- 主机厂成套配套罗拉订货时，需提供成套主机配套罗拉图纸，我公司按成套图纸和技术标准要求，制造、包装、装箱和发货。
- 双方签订经济合同，双方按合同条款履行。

### 外贸出口订货时

- 外贸订货时，应注明国籍、主机厂家、主机型号、主机出厂年月、罗拉件号、直径、锭距、锭数、每一台套中不同规格的数量。
- 若国外机型，需提供实样或图纸。标准按照中华人民共和国行业标准 FZ/T92019 执行。
- 双方签订合同，双方按合同条款履行。
- 本公司承接各种纺织系统中的织机、纺机、高精度传动轴类产品加工，价格比主机厂低 5%~10%。若需要订货，请来实样或图纸洽谈。

# 订货须知 >>

## INSTRUCTIONS FOR ORDER

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### Respectable customers

Please order bottom rollers that you need in accordance with the content stipulated in the instructions for order through telephone, letter or sending people to meet with us in order to serve you better and supply bottom rollers in time and accurately.

### When ordered by textile mills

- If textile mills that need bottom rollers as fittings or spare parts, please mark machine manufacturer, machine model, machine production date, bottom roller model, diameter, spindle gauge, spindles, the amount of different bottom rollers of each set. When order the head or tail, bottom rollers please provide the drawing.
- If textile mills need bottom rollers to modify the old machine, please mark machine manufacturer, machine model, machine production date, bottom roller model, diameter, spindle gauge, spindles, the amount of different bottom rollers of each set. If the machine is imported, please provide drawings or samples of bottom rollers.

### When ordered by machinery manufacturers

- If machinery manufacturers order complete sets of bottom rollers, please provide complete drawings of bottom rollers that are matched with their machine. Our company will manufacture, pack and deliver bottom rollers in accordance with the technical standards.
- Both parties must sign and implement the contract.

### When ordered by trade company

- When ordered by trade company, please mark the nationality, machine manufacturer, machine model, machine production date, bottom roller model, diameter, spindle gauge, spindles, the amount of different bottom rollers of each set.
- If the machine is imported, please provide samples or drawings. The quality standard will be implemented in accordance with the industry standard of PRC.FZ/T02019.
- Both parties must sign and implement the contract.
- The company can manufacture high precision shafts for weaving machines and textile machines. The price will be 5%~10% cheaper compared with the same products supplied by machine manufacturers. If order, please provide samples or drawings.

# 让全球纺织厂都爱上同和产品

LOVE TEXTILE, LOVE TONGHE.



## 同和纺织机械制造有限公司

Tonghe Textile Machinery Manufacture Co., Ltd

地址：中国江苏常州经济开发区兴东路 198 号

Add: NO.198.Xing Dong Road Economic Development Zone.

ChangZhou City, Jiangsu, China

邮编 P. C: 213025

总机 Company: 86-519-88406666                      86-519-88401388

营销部 Sales Dep.: 86-519-88405688            86-519-88400578

传真 FAX: 86-519-88405666                      86-519-88401618

电子信箱 E-MAIL: [tonghesales@throller.com](mailto:tonghesales@throller.com)

网址 Website: //www.throller.com

技术参数如有变更，恕不另行通知

Technical parameters are subject to change without prior notice.

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