



# METALLIC WIRE FOR FLAT CARD



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The application for metallic card clothing onto spinning carding machines has **no limits** and is used in the production of low, medium and high quality yarns.

Since there are **numerous solutions available** for flat cotton cards we always ask our customers for the following information in order to accurately determine the type of card clothing to use:

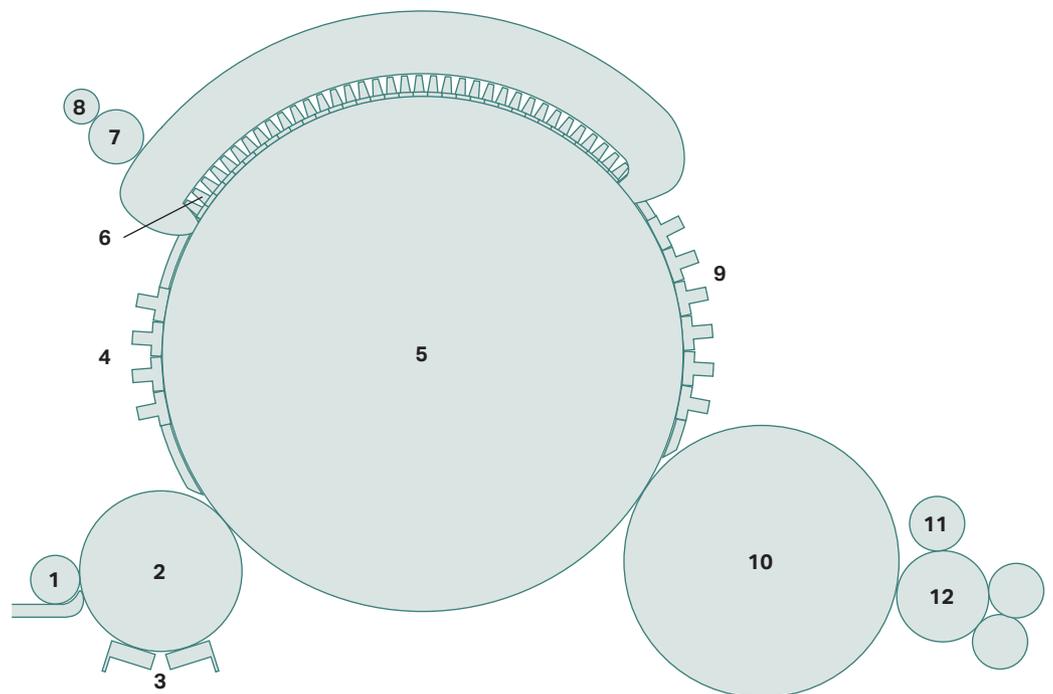
- material to be processed
- microns
- type and staple length in mm of fibers
- deniers.

And technical data concerning the machinery:

- type of machine and brand name
- working width
- diameter of rollers
- production in kilos per hour
- speed of cylinder/doffer
- number of flat tops.

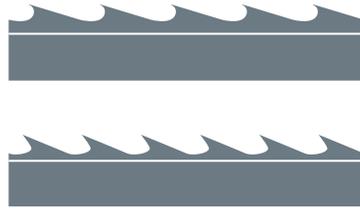
Once supplied with this information **we can suggest the best combination of metallic wire** for any type of fibers to be processed, thanks to the research and experience we have acquired in carding over the years.

## Card clothing specifications



- 1 FEED ROLLER
- 2 LICKERIN (SINGLE OR TRIPLE LICKERIN CARDS)
- 3 LICKERIN SEGMENTS
- 4 PRE-CARDING ABOVE LICKERIN
- 5 CYLINDER
- 6 REVOLVING FLAT TOPS
- 7 FLAT CLEANING ROLLERS
- 8 FLAT CLEANING ROLLERS
- 9 FRONT CARDING ABOVE DOFFER
- 10 DOFFER
- 11 CLEANING ROLLER
- 12 STRIPPING ROLLER

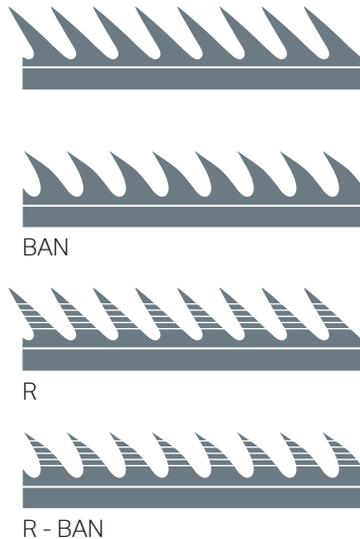
## Cylinder wire selection



CODE	TECHNICAL SPECS	PPSI
CYL 1080	0.4 x 2.0 x 30°/35°	1080
CYL 960	0.4 x 2.0 x 30°/40°	960
CYL 860	0.5 x 2.0 x 30°	860
CYL 860	0.5 x 2.5 x 25°/30°	860
CYL 720	0.6 x 2.0 x 20°/30°	720
CYL 720	0.6 x 2.5 x 20°/30°	720
CYL 620	0.7 x 2.5 x 15°/30°	620
CYL 620	0.8 x 2.8 x 15°/25°	620
CYL 540	0.8 x 2.5 x 15°	540
CYL 540	0.8 x 2.8 x 15°	540
CYL 440	0.8 x 2.8 x 15°	440
CYL 400	0.9 x 3.2 x 15°	400

All cylinders are available with special steel alloy "LL" Long Life for high production cards.

## Universal doffer wire selection



CODE	TECHNICAL SPECS	PPSI
DOF 340	0.9 x 4.0 x 25°/30°	340
DOF 360	0.9 x 4.0 x 25°/30°	360
DOF 385	0.9 x 4.0 x 25°/30°	385
DOF 400	0.9 x 4.0 x 25°/30°	400
DOF 350	0.9 x 5.0 x 25°/30°	350

All doffers are available as Striaton (R) and Banana Shape (BAN).

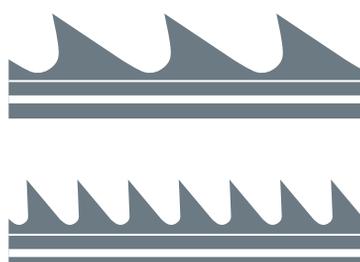
## Lickerin wire selection



CODE	ANGLE	H 5.5 X PPI
LK	10°/5°	4 to 5.5
LK	0°/-5°	4 to 5.5

Standard grooved lickerin.  
Wire base to be confirmed and checked.  
Rib thickness available from 1.0 to 1.4 mm.

## Interlocking lickerin wire selection



CODE	ANGLE	H 5.0 X PPSI
V 8	10°	44
V 8	5°	35 to 44
V 8	0°	24 to 35
V 12	10°	60 to 90
V 12	5°	60 to 90
V 16	20°	160 to 210
V 20	20°	210 to 240

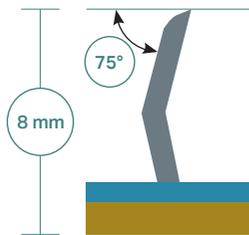
## Revolving flat tops

CODE	TYPE	PPSI	USE
FT 270	B - FLAT WIRE 80°	270	POLYESTER FIBERS > 3.0 DTEX
FT 330	B - FLAT WIRE 80°	330	POLYESTER FIBERS 1.0 TO 3.0 DTEX
FT 350	A - BICONVEX WIRE 75°	350	POLYESTER / BLENDS
FT 380	A - BICONVEX WIRE 75°	380	POLYESTER / BLENDS
FT 400	A - BICONVEX WIRE 75°	400	OE / POLYESTER / BLENDS
FT 420	A - BICONVEX WIRE 75°	420	OE / RING SPUN
FT 450	A - BICONVEX WIRE 75°	450	OE / RING SPUN / COMBED
FT 480	A - BICONVEX WIRE 75°	480	RING SPUN / COMBED
FT 500	A - BICONVEX WIRE 75°	500	COMBED COTTON
FT 520	A - BICONVEX WIRE 75°	520	COMBED COTTON

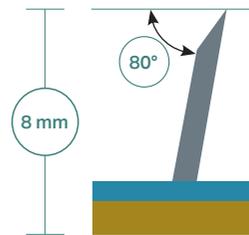
## flat tops available with progressive setting (PRG)

CODE	TYPE	PPSI	USE
FT 33/44 prg	A - BICONVEX WIRE 72°	330-440	BLENDS / OE / RING SPUN
FT 38/52 prg	A - BICONVEX WIRE 72°	380-520	OE / RING SPUN / COMBED
FT 38/55 prg	A - BICONVEX WIRE 75°	380-550	RING SPUN / COMBED COTTON
FT 42/60 prg	A - BICONVEX WIRE 75°	430-600	FINE COMBED COTTON

type A



type B



## Stationary flat wire

CODE	TYPE	PPSI	POSITION
FFT 65	D	65	LICKERIN SEGMENT
FFT 85	D	85	LICKERIN SEGMENT
FFT 100	A/B/C	100	PRE-CARDING ABOVE LICKERIN
FFT 150	A/B/C	150	PRE-CARDING ABOVE LICKERIN
FFT 250	A/B/C	250	PRE-CARDING ABOVE LICKERIN
FFT 350	A/B/C	350	PRE-CARDING ABOVE LICKERIN
FFT 250	A/B/C	250	FRONT CARDING ABOVE DOFFER
FFT 350	A/B/C	350	FRONT CARDING ABOVE DOFFER
FFT 450	A/B/C	450	FRONT CARDING ABOVE DOFFER
FFT 550	A/B/C	550	FRONT CARDING ABOVE DOFFER
FFT 650	A/B/C	650	FRONT CARDING ABOVE DOFFER

type A



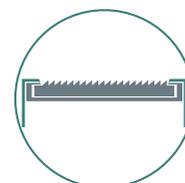
**SCREW TYPE**  
h 11 mm

type B



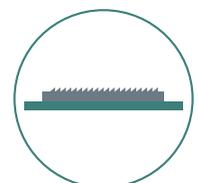
**SCREW TYPE**  
h 16.8 mm

type C



**CLIPPED TYPE**  
h 7.0 mm

type D



**UNDER LICKERIN**  
h 7.5 mm

# Metallic wire selection

## cotton

P < 15 KG/H	OPEN END	RING SPUN	COMBED
CYLINDER	CYL 720	CYL 720	CYL 860
DOFFER	DOF 360 B	DOF 360 B	DOF 385 B
LICKERIN	LK 10° - V8 10°	LK 10° - V8 10°	LK 10° - V8 10°
FLAT TOPS	FT 400 - FT 420	FT 420 - FT 450	FT 450 - FT 38/52 PRG

15 < P < 40 KG/H	OPEN END	RING SPUN	COMBED
CYLINDER	CYL 720/860	CYL 720/860	CYL 960
DOFFER	DOF 360 B	DOF 360 B	DOF 360 B/385 B
LICKERIN	LK 10° - V8 10°	LK 10° - V8 10°	LK 10° - V8 10°
FLAT TOPS	FT 420 - FT 33/44 PRG	FT 33/44 - FT 38/52 PRG	FT 38/52 PRG

P > 40 KG/H	OPEN END	RING SPUN	COMBED
CYLINDER	CYL 860/960	CYL 860/960	CYL 960/1080
DOFFER	DOF 360 B	DOF 360 B/385 B	DOF 385 B/400 B
LICKERIN	LK 10° - V8 - V12 - V16	LK 10° - V8 - V12 - V16	LK 10° - V8 - V12 - V16
FLAT TOPS	FT 450 - FT 38/55 PRG	FT 480 - FT 38/52 PRG	FT 38/52 PRG - FT 38/55 PRG

## synthetic fibers

1.0 < DTEX < 1.8	P < 15 KG/H	15 < P < 40 KG/H	P > 40 KG/H
CYLINDER	CYL 620	CYL 720	CYL 860
DOFFER	DOF 340 R:B	DOF 360 R:B	DOF 360 R:B
LICKERIN	LK 5° - V8 - V12	LK 5° - V8 - V12	LK 5° - V8 - V12
FLAT TOPS	FT 330	FT 350	FT 380

DTEX > 1.8	P < 15 KG/H	15 < P < 40 KG/H	P > 40 KG/H
CYLINDER	CYL 400	CYL 440	CYL 540
DOFFER	DOF 340 R:B	DOF 340 R:B	DOF 360 R:B
LICKERIN	LK 0° - V8 0°	LK 0° - V8 0°	LK 0° - V8 0°
FLAT TOPS	FT 270	FT 270 - FT 330	FT 330

## blends

	P < 15 KG/H	15 < P < 40 KG/H	P > 40 KG/H
CYLINDER	CYL 720	CYL 720	CYL 860
DOFFER	DOF 340 R:B	DOF 360 R:B	DOF 360 R:B
LICKERIN	LK 5° - V8 5°	LK 5° - V8 5°	LK 5° - V8 5°
FLAT TOPS	FT 350 - FT 380	FT 380 - FT 400	FT 400 - FT 33/44 PRG



**BIOTTI Card Clothing** was founded back in 1879 and over the years has gradually become the most up-to-date and efficient manufacturer of flexible card clothing, metallic wire and raising fillets in Italy. The Company's success is due to the **constantly high quality** of its product which is made possible by using the **finest raw materials** combined with the **efficiency** and **modernity** of its production facilities and the professionalism of its employees, as well as the rigorous control of its finished product.

Once recognized as a leader in its field in Italy, the Company decided to expand into foreign markets and its products are now sold in all continents, in over **60 countries** around the world.

Today, thanks also to effective management, **BIOTTI Card Clothing** has been able to consolidate this success which allows it to confidently look to a future of continuing growth and development.

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