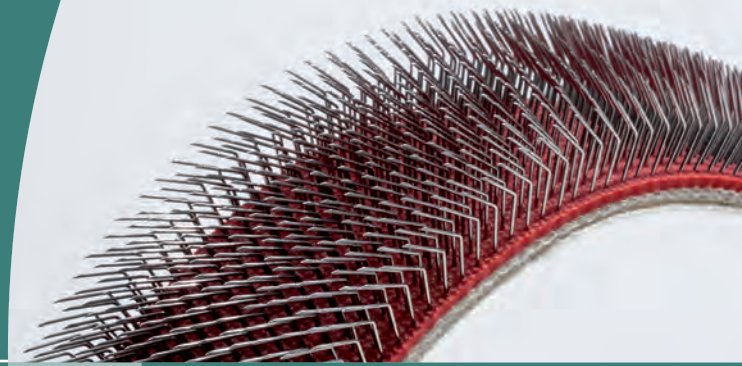




# RAISING FILLET



# RAISING FILLET

Raising fillets continue to be increasingly important in finishing.

The **right fillet** will allow the customer to obtain **improved results** in the raising while at the same time decrease the number of passes required, thus **increasing production**.

To determine the exact raising fillet to be used it is necessary to know the material processed, the type and weight of the fabric that is to be worked on the raising machine. The

type of machine, the working width and the number of rollers (pile/coun-ter) will determine the quantity necessary.

The choice of **foundation and steel wire used is fundamental** in the raising fillets. Tinned or stainless (inox) wire is used with wet fibers.

The angle, the treatment of the points, the grinding and polishing, and extra hardened points will give the raising fillet its final structure.

## wool fabrics

WIDTH (MM)	FOUNDATION	WIRE	DIAMETER (MM)	ROWS	PPSI	TOTAL H (MM)	ANGLES A - B
23	4 RR	18 R	0.355	18	240	10.5	45° - 76°
23	3 RR	20 R	0.330	18	245	10.0	45° - 76°
23	3 RR	22 R	0.305	18	260	10.0	45° - 76°
23	3 RR	24 R	0.280	18	280	10.0	45° - 76°
23	3 RR	26 R	0.255	18	310	10.0	45° - 76°
23	3 RR	28 R	0.230	18	340	10.0	45° - 76°

## acrylic blankets

WIDTH (MM)	FOUNDATION	WIRE	DIAMETER (MM)	ROWS	PPSI	TOTAL H (MM)	ANGLES A - B
23	4 RR	25/29 BC	0.530/0.380	12	100	10.5	40° - 82°
23	3 RR	26/30 BC	0.480/0.355	12	130	10.0	40° - 82°
23	3 RR	27/31 BC	0.430/0.330	12	145	10.0	45° - 76°
23	3 RR	28/32 BC	0.405/0.305	12	150	10.0	45° - 76°
23	3 RR	29/33 BC	0.380/0.280	12	155	10.0	45° - 76°
23	3 RR	22 R	0.305	12	155	10.0	45° - 76°

## cotton flannel

WIDTH (MM)	FOUNDATION	WIRE	DIAMETER (MM)	ROWS	PPSI	TOTAL H (MM)	ANGLES A - B
23	4 RR	26/30 BC	0.480/0.355	18	230	10.5	40° - 89°
23	3 RR	27/31 BC	0.430/0.330	18	245	10.0	45° - 82°
23	3 RR	28/32 BC	0.405/0.305	18	260	10.0	45° - 76°
23	3 RR	29/33 BC	0.380/0.280	18	280	10.0	45° - 76°
23	3 RR	30/34 BC	0.355/0.255	18	300	10.0	48° - 76°
20	3 RR	30/34 BC	0.355/0.255	18	380	10.0	48° - 76°

## nylon - polyester

WIDTH (MM)	FOUNDATION	WIRE	DIAMETER (MM)	ROWS	PPSI	TOTAL H (MM)	ANGLES A - B
20	5 F	22 R	0.305	18	270	11.0	55° - 82°
20	5 F	24 R	0.280	18	310	11.0	45° - 82°
20	5 F	22 R	0.305	18	310	10.7	48° - 82°
20	5 F	24 R	0.280	18	340	10.7	45° - 82°
19	3 RR	30/34 BN	0.355/0.255	18	380	10.5	45° - 82°

## knitted fabrics

WIDTH (MM)	FOUNDATION	WIRE	DIAMETER (MM)	ROWS	PPSI	TOTAL H (MM)	ANGLES A - B
23	3 RR	24 R	0.280	18	300	10.5	48° - 72°
23	3 RR	30/34 BC	0.355/0.255	18	310	10.5	48° - 72°
23	3 RR	29/33 BC	0.380/0.280	18	280	10.5	48° - 72°
23	3 RR	28/32 BC	0.405/0.305	18	280	10.5	45° - 76°
20	3 RR	22 R	0.305	18	280	11	48° - 76°
20	5 F	24 R	0.280	18	300	11	45° - 76°
20	5 F	20 R	0.330	18	260	11	48° - 80°
20	5 F	22 R	0.305	18	280	11	48° - 80°
20	5 F	24 R	0.280	18	300	11	50° - 80°
20	5 F	22 R	0.305	18	240	11	48° - 80°

## U.S.A. style raising fillet

WIDTH (" - MM)	FOUNDATION	WIRE	DIAMETER (MM)	ROWS/ TWILL	PPSI	TOTAL H (MM)	ANGLES A - B
¾ - 19	3 RR	28/32	0.405/0.305	2 / 3	220	11.5	45° - 80°
¾ - 19	3 RR	30/34	0.355/0.255	3 / 3	360	11.5	45° - 80°
¾ - 19	3 RR	30	0.355	3 / 3	260	11.5	90° - 0°
¾ - 19	3 RR	28/32	0.405/0.305	3 / 3	280	11.5	45° - 80°
¾ - 19	3 RR	26/30	0.480/0.355	3 / 3	280	11.5	45° - 80°
¾ - 19	3 RR	27/31	0.430/0.330	3 / 3	280	11.5	45° - 80°

Standard foundation: 3 and 4 ply Red Rubber face 1 mm & white backing cloth.

**OPEN SET** 2 rows / 3 twill

**CLOSE SET** 3 rows / 3 twill

## brushes for raising fillets on napping machines

WIDTH (" - MM)	FOUNDATION	WIRE	DIAMETER (MM)	ROWS/ TWILL	PPSI	TOTAL H (" - MM)	ANGLES A - B
1 ½ - 38	3 RR	30	0.355	4 / 3	100	1 ⅛ - 28.5	45° - 80°
1 ½ - 38	4 RR	28	0.405	4 / 3	100	1 ⅛ - 28.5	45° - 80°
1 ½ - 38	4 RR	28	0.405	4 / 3	100	1 ¼ - 32.0	90° - 0°

Brushes sheets available on 4-5 RR or 4-5 Felt, all sizes.

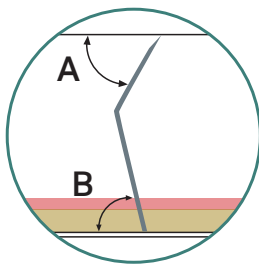
## Far East style raising fillet

TYPE	WIDTH (MM)	FOUNDATION	WIRE	DIAMETER (MM)	ROWS	PPSI	TOTAL H (MM)	ANGLES A - B
B 1	23	3 RR	27/31	0.430/0.330	18	310	9.5	45° - 82°
B 2	23	3 RR	27/31	0.430/0.330	18	310	10.0	40° - 89°
B 3	23	3 RR	28/32	0.405/0.305	18	330	9.5	48° - 72°
B 4	23	3 RR	30	0.355	18	260	11.0	80° - 10°
B 5	23	5 F	33	0.280	18	260	11.5	65° - 80°
B 6	23	5 F	31	0.330	18	280	11.5	45° - 85°
B 15	23	3 RR	28/32	0.405/0.305	18	360	9.5	48° - 72°

## brushes

TYPE	WIDTH (MM)	FOUNDATION	WIRE	DIAMETER (MM)	PPSI	TOTAL H (MM)	ANGLES A - B
TIGER	26	6 VULC	27/31	0.430/0.330	310	30.5	85° - 5°

## Angles

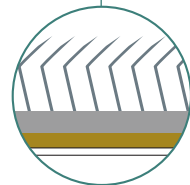


## Foundations

### raising fillet

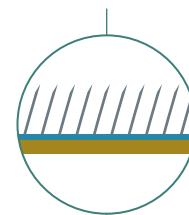


**RED RUBBER**  
3 - 4 - 5  
PLY + PLY BACK

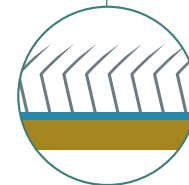


**FELT**  
4 - 5  
PLY + PLY BACK

### auxiliary raising fillet



**VULC**  
3 - 4 - 5  
PLY + PLY BACK -  
4 - 5  
PLY + FELT



**VULC**  
3 - 4 - 5  
PLY + PLY BACK



**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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