

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION R 98

DIAMETERS OF
DRAFTING ROLLERS
FOR COTTON, WOOL, SPUN SILK AND STAPLE FIBRE

1st EDITION

February 1959

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BRIEF HISTORY

The ISO Recommendation R 98, *Diameters of Drafting Rollers for Cotton, Wool, Spun Silk and Staple Fibre*, was drawn up by Technical Committee ISO/TC 72, *Textile Machinery and Accessories*, the Secretariat of which is held by the Association Suisse de Normalisation (SNV).

At its very first meeting, held in Zurich, in July 1950, the Technical Committee decided to include in its programme of work the item of diameters of drafting rollers for cotton, wool, spun silk and staple fibre.

At its second meeting, held in Scheveningen, in September 1951, the Technical Committee assigned the study of this question to a Working Group, composed of Belgium, France, Netherlands, United Kingdom, Switzerland and, as from 1952, Germany. This Working Group met several times to prepare a draft proposal.

At the third plenary meeting of the Technical Committee, held in Brussels, in July 1955, this draft proposal was unanimously adopted by the delegates present as a Draft ISO Recommendation.

On 10 August 1956, the Draft ISO Recommendation was distributed to all the ISO Member Bodies and was approved, by the following 23 (out of a total of 37) Member Bodies:

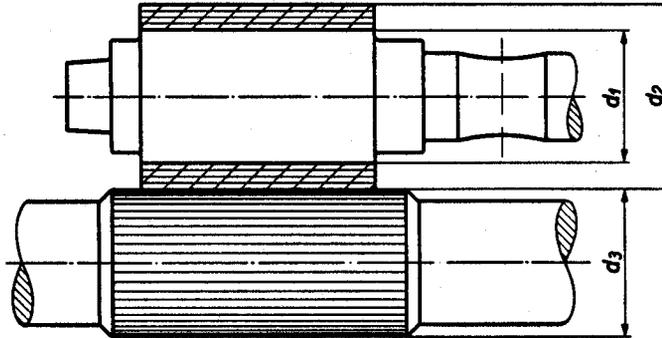
Austria	Hungary	Spain
Belgium	India	*Sweden
Bulgaria	*Ireland	Switzerland
*Canada	Japan	Turkey
*Denmark	Netherlands	United Kingdom
France	Pakistan	*U.S.A.
Germany	Poland	*U.S.S.R.
*Greece	Romania	

No Member Body opposed the approval of the Draft.

The Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided, in February 1959, to accept it as an ISO RECOMMENDATION.

* These Member Bodies stated that they had no objection to the Draft being approved.

**DIAMETERS OF
DRAFTING ROLLERS**
FOR COTTON, WOOL, SPUN SILK AND STAPLE FIBRE



Dimensions in millimetres

Dimensions in inches

Dimensions in millimetres			Dimensions in inches		
Bottom roller	Top roller with covering		Bottom roller	Top roller with covering	
Bottom roller diameter	Bare roller diameter	Outside diameter of synthetic cots	Bottom roller diameter	Bare roller diameter	Outside diameter of synthetic cots
d_3	d_1	d_2	d_3	d_1	d_2
16	—	—	$\frac{5}{8}$	$\frac{1}{2}$	$\frac{3}{4}$
18	—	—	—	$\frac{9}{16}$	$\frac{13}{16}$
—	16	23	$\frac{3}{4}$	$\frac{5}{8}$	$\frac{7}{8}$
20	18	25	$\frac{13}{16}$	$\frac{11}{16}$	$\frac{15}{16}$
22	—	—	$\frac{7}{8}$	$\frac{3}{4}$	1
25	20	28	1	$\frac{13}{16}$	$1\frac{1}{16}$
27	22	30	$1\frac{1}{16}$	$\frac{7}{8}$	$1\frac{1}{8}$
—	—	—	$1\frac{1}{8}$	$\frac{15}{16}$	$1\frac{3}{16}$
30	25	34	$1\frac{3}{16}$	1	$1\frac{1}{4}$
32	—	—	$1\frac{1}{4}$	$1\frac{1}{16}$	$1\frac{5}{16}$
35	28	37	$1\frac{3}{8}$	$1\frac{1}{8}$	$1\frac{3}{8}$
38	—	—	$1\frac{1}{2}$	$1\frac{1}{4}$	$1\frac{1}{2}$
40	32	41	$1\frac{9}{16}$	$1\frac{3}{8}$	$1\frac{5}{8}$
50	35	44	2	$1\frac{1}{2}$	$1\frac{3}{4}$
66	40	50	$2\frac{5}{8}$	$1\frac{11}{16}$	$1\frac{15}{16}$
75	45	55	3	—	—
100	50	60	4	$1\frac{15}{16}$	$2\frac{3}{16}$
—	55	70	—	$2\frac{3}{16}$	$2\frac{7}{16}$
—	60	75	—	$2\frac{7}{16}$	$2\frac{11}{16}$
—	70	85	—	$2\frac{11}{16}$	$2\frac{15}{16}$
—	—	—	—	$2\frac{15}{16}$	$3\frac{3}{16}$
—	80	95	—	—	—
—	90	105	—	$3\frac{7}{16}$	$3\frac{11}{16}$
—	100	115	—	$3\frac{15}{16}$	$4\frac{3}{16}$
—	110	125	—	$4\frac{7}{16}$	$4\frac{11}{16}$
—	120	135	—	$4\frac{11}{16}$	$4\frac{15}{16}$

The outside diameters of rollers with synthetic cots are the minimum diameters after the first grinding.
For felt-leather or felt-paper covering: $d_2 = d_1 + 4 \text{ mm}$ $d_2 = d_1 + \frac{3}{16} \text{ in.}$