Combing
High level of vertical manufacturing integration, reliable processes

Graf has become the world's leading supplier thanks to its high-quality products. Graf has been manufacturing innovative flat clothings and metallic card clothings for cards as well as roller cards and combs for combers since 1917.

As a system supplier, Graf’s offer of services covers the entire range, from products and technical assistance to service and service machinery. In addition, Graf supports its customers with individual solutions for all areas of application. Everything, from profile wires and carding wires to foundation material and end products, is manufactured at Graf’s own production facilities in Europe. Thanks to this in-depth vertical integration, the Graf group ensures comprehensive process control and superior quality.
**Circular Combs**

- Graf Circular Combs in Use
  - Overview

**PRIMACOMB**

- 5014 & 5025
- 7015 & 8011
- 8014 & 8015
- 9015 & 9030
- 5015 & 5030

**COMB-PRO**

- F14 & H15
- F15

**Ri-Q-Comb flex**

- i400 flex & i500 flex
- i700 flex

**Top Combs**

**Accessories**

**Service and Quality**
Circular Combs

Graf offers a comprehensive range of high-performance circular combs, for combers of both Rieter and numerous other machine manufacturers.

Developed in Switzerland and manufactured in Europe, Graf combs stand for a high level of quality, stability and longevity.
Graf Circular Combs in Use

- **Staple length [in]**
  - 1 1/16" - 1/4" - 3/16" - 1/8" - 1/16"
  - 1 1/8" - 1 3/16" - 1 1/16" - 1 7/16" - 1 5/32"
  - 1 9/16" - 1 5/16" - 1 1/2" - 1 7/16" - 1 3/8"
  - 1 11/16" - 1 6/8" - 1 8/16" - 1 10/16" - 1 12/16"

- **Nails [%]**
  - FIXPRO C26
  - Ri-Q-Top 2026
  - FIXPRO C30 & C35
  - Ri-Q-Top 2030 & 2035
  - PRIMACOMB 5030 & 9030
  - Ri-Q-Comb i700 flex
  - PRIMACOMB 5015, 5025, 7015, 8015 & 9015
  - COMB-PRO F15 & H15
  - Ri-Q-Comb i500 flex
  - PRIMACOMB 8011
  - the Quality-Champions
  - PRIMACOMB 5015, 5025, 7015, 8015 & 9015
  - COMB-PRO F15 & H15
  - Ri-Q-Comb i500 flex
  - PRIMACOMB 5014 & 8014
  - COMB-PRO F14
  - Ri-Q-COMB i400 flex
  - PRIMACOMB 8014 & 8015
  - COMB-PRO F14
  - Ri-Q-COMB i400 flex

- **the Specialists**
  - PRIMACOMB 5030 & 9030
  - Ri-Q-Comb i700 flex

- **the Quality-Champions**
  - PRIMACOMB 5015, 5025, 7015, 8015 & 9015
  - COMB-PRO F15 & H15
  - Ri-Q-Comb i500 flex

- **the Economists**
  - PRIMACOMB 8014 & 8015
  - COMB-PRO F14
  - Ri-Q-COMB i400 flex
## Overview

<table>
<thead>
<tr>
<th>Type of comb</th>
<th>Staple length (&quot;)</th>
<th>Circular comb shaft (in mm)</th>
<th>Sections</th>
<th>Density</th>
<th>Conic in-feed</th>
<th>Combing surface (°)</th>
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<td>27–41.3</td>
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<td>Medium- Extra long</td>
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PRIMACOMB high-performance circular combs can be used on the combers of all manufacturers designed for 90° and 111° circular combs. This innovative accessory is particularly suited for fiber qualities in the medium to extra long staple range and is specially geared towards spinning mills with work processes that require the highest quality demands.
Developed for high productivity and extraordinary quality

The high-performance circular combs fitted with the latest technology ensure a high degree of productivity as well as extraordinary quality for an optimal spinning process and first-rate yarns.

- The distribution of the teeth defined by numerous field trials and an ideal tooth shape lower the number of neps and reduce thick and thin places
- The alternating slanting of the sections allows for more intensive noil extraction
- The special surface treatment significantly reduces the running-in period. This also extends cleaning intervals, which also considerably increases the lifetimes of the cleaning brushes
- Type recognition by way of colored cover plates

Customer benefits:

- Intensive combing for high-quality yarn products
- Low number of neps as well as reduced thick and thin places thanks to the optimum distribution of the teeth and tooth shape
- Fast and safe replacement of the circular combs by way of narrow manufacturing tolerances
- Latest technology also for older-generation combing machines
- Lifetimes of 800–1000 t / comber are easily achieved in the short and medium staple range
- Lifetimes from 600–800 t are achieved in the long staple range >1 1/4"
### 5014

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<td>4</td>
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<td>22'580</td>
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Product details:
- Comb with 4 sections
- 90° combing surface
- Noil range 10–22%
- End plate: Aluminum

Application area:
Use for short to medium staple fibers
1 – 1 7/32" (25.4 – 31 mm)

### 5025

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Product details:
- Comb with 5 sections
- 90° combing surface
- Noil range 14–22%
- End plate: Purple

Application area:
Use for medium to long staple fibers
1 1/16 – 1 1/2" (27 – 38.1 mm)
### 7015

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**Product details:**
- Comb with 4 sections
- 90° combing surface
- Noil range 14–22%
- End plate: Red

**Application area:**
Use for medium to long staple fibers
1 1/16 – 1 1/2” (27 – 38.1 mm)

### 8011

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**Product details:**
- Comb with 4 sections
- 90° combing surface
- Noil range 7–11%
- Conical in-feed in section 1
- End plate: Brown

**Application area:**
Use for medium staple fibers
1 1/16 – 1 7/32” (27 – 31 mm)
### 8014

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**Product details:**
- Comb with 4 sections
- 90° combing surface
- Noil range 10–22%
- Conical in-feed in section 1
- End plate: Anthracite

**Application area:**
Use for short to medium staple fibers
1–1 7/32” (25.4–31 mm)

### 8015

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**Product details:**
- Comb with 4 sections
- 90° combing surface
- Noil range 14–22%
- Conical in-feed in sections 1 and 2
- End plate: Yellow

**Application area:**
Use for medium to long staple fibers
1 1/16 – 1 1/2” (27–38.1 mm)
9015

Section | Shape | Position | Density
---|---|---|---
1 | | | 28'270
2 | | | 
3 | | | 
4 | | | 
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Product details:
- Comb with 5 sections
- 90° combing surface
- Noil range 14–22%
- Conical in-feed in sections 1 and 2
- End plate: Turquoise

Application area:
Use for medium to long staple fibers
1 1/16 – 1 1/2" (27 – 38.1 mm)

9030

Section | Shape | Position | Density
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1 | | | 31'550
2 | | | 
3 | | | 
4 | | | 
5 | | | 
6 | | | 

Product details:
- Comb with 6 sections
- 90° combing surface
- Noil range 16–21%
- Conical in-feed in sections 1 and 2
- End plate: Black

Application area:
Use for long to extra long staple fibers
13/8 – 1 5/8" (34.9 – 41.3 mm)
### 5015

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**Product details:**
- Comb with 5 sections
- 111° combing surface
- Noil range 14–22%
- End plate: Aluminum

**Application area:**
Use for medium to long staple fibers
1 1/16 – 1 1/2" (27 – 38.1 mm)

### 5030

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**Product details:**
- Comb with 6 sections
- 111° combing surface
- Noil range 16–21%
- End plate: Aluminum

**Application area:**
Use for long to extra long staple fibers
1 3/8 – 1 5/8" (34.9 – 41.3 mm)
The COMB-PRO circular comb series was developed for combing machines from a variety of manufacturers such as Jingwei, Kaigong, Lakshmi, Taihang, Marzoli, Hongxi, etc. Suitable for use of up to 400 nips/min and a circular comb shaft diameter of 85 mm, the combs of this series are true all-rounders.
### F14

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**Product details:**
- Comb with 4 sections
- 90° combing surface
- Noil range 10–22%
- End plate: Dark blue

**Application area:**
Use for short to medium staple fibers
1 – 1 7/32" (25.4–31 mm)

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### H15

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**Product details:**
- Comb with 4 sections
- 90° combing surface
- Noil range 14–22%
- End plate: Light green

**Application area:**
Use for medium to extra long staple fibers
1 1/16 – 1 5/8" (27 – 41.3 mm)
Product details:
- Comb with 5 sections
- 111° combing surface
- Noil range 14–22%
- End plate: Light blue

Application area:
Use for medium to extra long staple fibers
1 1/16 – 1 5/8” (27 – 41.3 mm)
Ri-Q-Comb flex

The Ri-Q-Comb flex series is especially developed for the latest generation of Rieter combing machines. The largest active combing surface achieves an unrivaled quality of the yarn. The optimized clothing design allows for a more gentle feed and a consistent fiber load despite longer circular combing.
The right solution for every application

Whether it’s particular levels of noil extraction or staple lengths – the Ri-Q-Comb flex series covers all needs.

- Higher active combing surface of 130° for the best quality
- Type recognition by way of colored cover plates and bodies
- Patented design for the best possible running behavior
- Adjustable distance between the circular comb and the nipper
- Easy adjustment according to the relevant requirements
- The same setting of all combing positions is possible
- For Rieter combing machines from the E80 and later generations

Customer benefits:
- Up to 1% fewer noils at the same level of quality
- 20% fewer imperfections with the same amount of noils
- Up to 15% longer lifetime than the average products on the market
- Precise height adjustment for ideal combing qualities
- Lifetimes of 800 – 1000 t in the short and medium staple range/combing machine are easily achieved
- Lifetimes from 600 – 800 t are achieved in the long staple range >1 1/4"
### i400 flex

**Section** | **Shape** | **Position** | **Density** | 
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3 | | | | 
4 | | | | 
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**Product details:**
- Comb with 5 sections
- 130° combing surface
- Noil range 10–22%
- Conic feed in section 1 and 2
- Color: Blue

**Application area:**
Use for short to medium staple fibers
1 – 1 7/32" (25.4 – 31 mm)

### i500 flex

**Section** | **Shape** | **Position** | **Density** | 
--- | --- | --- | --- | 
1 | | | | 
2 | | | | 
3 | | | | 
4 | | | | 
5 | | | |

**Product details:**
- Comb with 5 sections
- 130° combing surface
- Noil range 14–22%
- Conic feed in section 1 and 2
- Color: Purple

**Application area:**
Use for medium to long staple fibers
1 1/16 – 1 1/2" (27 – 38.1 mm)
### i700 flex

#### Section Shape Position Density

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<tr>
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<th>Shape</th>
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<th>Density</th>
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</table>

#### Product details:
- Comb with 6 sections
- 130° combing surface
- Noil range 16–21%
- Conic feed in section 1 and 2
- Color: Brown

#### Application area:
Use for long to extra long staple fibers
13/8 – 1 5/8" (34.9 – 41.3 mm)
The top comb series FIXPRO and Ri-Q-Top complement the Graf circular comb product range and offer customers exceptional quality in the combing process. The reduced soiling thanks to the higher tooth profile significantly extends the cleaning cycles.
For the best yarn quality

The main difference to traditional top combs is flat teeth instead of round needles

- The large tooth profile prevents short fibers from wrapping around the tooth and therefore has significantly less soiling
- With two series, the Graf top combs are suitable for Rieter combing machines as well as numerous combers of other manufacturers
- The product range includes top combs with 26, 30, 35 and 40 teeth / cm for all needs

Customer benefits:
- Longer lifetime due to lateral reinforcement of the end pieces
- Nep values can be improved by up to 30%
- More consistent values in the comb sliver
- Cleaning intervals extended by up to 4 times
- Lifetimes of 400–500 t / comber are easily reached in the short and medium staple range
- Lifetimes of 300 – 400 t are achieved in the long staple range >1 1/4"
<table>
<thead>
<tr>
<th>Model</th>
<th>Staple length</th>
<th>Batt weight</th>
<th>Teeth / cm</th>
<th>Color</th>
</tr>
</thead>
<tbody>
<tr>
<td>FIXPRO C26/Ri-Q-Top 2026</td>
<td>Short to medium staple fibers 1–1 1/4“ (25.4–31.8 mm)</td>
<td>60–80 g/m</td>
<td>26</td>
<td>Orange / Red</td>
</tr>
<tr>
<td>FIXPRO C30/Ri-Q-Top 2030</td>
<td>Medium to extra long staple fibers 1 1/4–1 5/8“ (31.8–41.3 mm)</td>
<td>60–72/76 g/m</td>
<td>30</td>
<td>Turquoise / Blue</td>
</tr>
<tr>
<td>FIXPRO C35/Ri-Q-Top 2035</td>
<td>Medium to extra long staple fibers 1 1/4–1 5/8“ (31.8–41.3 mm)</td>
<td>60–72/76 g/m</td>
<td>35</td>
<td>Light yellow / Olive-brown</td>
</tr>
<tr>
<td>FIXPRO C40/Ri-Q-Top 2040</td>
<td>Long to extra long staple fibers 1 3/8–1 5/8“ (34.9–41.3 mm)</td>
<td>60–72 g/m</td>
<td>40</td>
<td>Light green / Anthracite</td>
</tr>
</tbody>
</table>
Accessories

The combing quality also depends on the settings and regular maintenance alongside high-quality top and circular combs. The original accessories available from Graf are perfectly matched for every combing machine.
The two-part circular comb brush consists of natural bristles. These bristles guarantee a clean circular comb that achieves a 100-percent combing result. The quality and structure of the bristles as well as the length and thickness are crucial criteria for achieving ideal cleaning results. The circular comb brush fulfills these requirements in every regard.

Seed-coat fragments embedded between the teeth of the top comb can be removed quickly and easily with the top comb cleaner. To clean the top comb, swipe the cleaning device from top to bottom through the teeth.

Cleaning unit for removing seed-coat fragments or wooden particles from clothing of the circular comb. To remove such particles, swipe the cleaning device from the back to the front through the teeth.
As a DIN EN ISO 9001 2015-certified company, we produce clothings according to the latest quality assurance principles. As our customer, you can rely on the consistently high quality standard of Graf's high-performance clothings, worldwide.

Continuing demands on performance while retaining consistently high levels of quality pose high requirements on the products in terms of strain, hardness and stability. According to these requirements, we continuously implement improvement measures in everyday operations.

Constant checks, such as the inspection of incoming goods, material and implementation inspections and production monitoring form an integral part of our quality assurance process. Thanks to our own wide range of facilities, we always retain 100% control over our manufacturing processes.

**Individual, sustainable solutions**

The choice of the correct clothing is of key importance to high productivity, quality and economic efficiency. The large variety in rollers and specific applications in the short staple and long staple sector requires experienced specialists.

Qualified Graf specialists (TKB) competently advise and support you in selecting the application-specific clothings, and work with you to develop a solution that is in line with the your requirements and expectations. Long-standing experience in the textile sector and continuous further education make our specialists the crucial factors for the success of spinning mills, nonwoven manufacturers and machine builders.

Today’s cards and roller cards place the highest demands on the clothings and their maintenance. To ensure trouble-free operation in the spinning mill/nonwoven manufacturing plant, you can always call upon our worldwide service network with our qualified service specialists. This considerably reduces downtimes and the related high costs.

**Your quality benefits:**

- Worldwide service stations enable on-site dismantling and fitting on site
- Short downtimes thanks to the use of experienced assembly and service teams
- Rather than standard solutions, we provide custom-made quality products tailored to your needs
- Our competent support, combined with our high-quality products make us your ideal partner in fiber processing