

FIRAT

SÜRME 70-75

TEKNİK

KATALOG

SÜRME SİSTEMLERİ 70-75



Kasa Profil Geniřlięi (mm)	70-75
Conta	TPE
Ses Yalıtımı (db)	32
Hava Geçirgenlik Sınıfı	3
Su Sızdırmazlık Sınıfı	3A
Profil Isı Yalıtımı (W/m ² °K)	1,45
Pencere Isı Yalıtımı (W/m ² °K)	2,20
Rüzgar Yüküne Dayanım Sınıfı	C2
Cam Kalınlıkları (mm)	5,20,24

04 Ana Profiller

05 Detay Profiller

06 Yardımcı Profiller

07 Çıta Uygulamaları

08 Kanat Kapama Kullanım Yeri

11 Destek Sacları

12 Detay Profili Uygulamaları

19 Pencere Kesitleri

43 Su Tahliye Kanalları

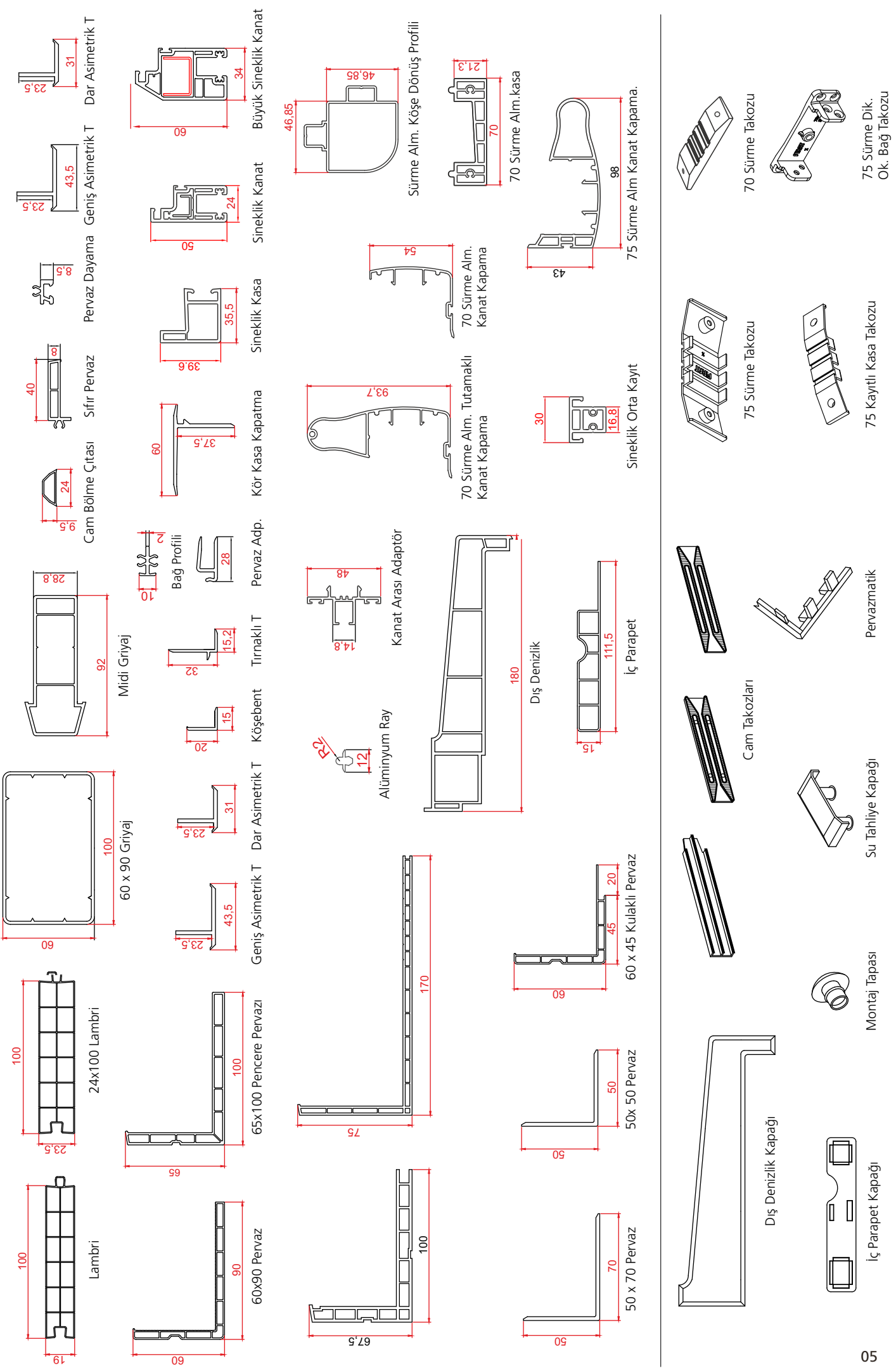
44 Kol Yeri Hazırlama

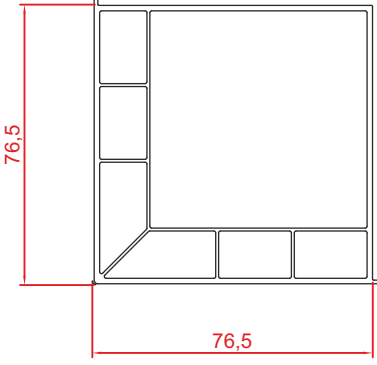
45 Kaynak

	Sürme 75 Kasa		Sürme 75 Dikey Orta Kayıt		Sürme 75 Kayıtlı Kasa		Sürme 75 Pervazlı Kayıtlı Kasa		Sürme 75 Yalıtımlı Kasa
	Sürme 70 Kasa		Sürme 70 Pervazlı Kasa		Sürme 70 Kayıtlı Kasa		Sürme 70 Kasalı Orta Kayıt		Sürme 70 Sinekli Kasa
	Sürme 75 İçten Sinekli Pervazlı Kasa		Sürme 75 Dıştan Sinekli Pervazlı Kasa		Sürme 70 Üçlü Sürme Kasa		Sürme 70 C. Kanat Kapama		Sürme 70 Kanat Kapama
	Sürme 75 Fix Profil		Sürme 70 Fix Profil		Sürme 70 Kapı Kanat Kapama		Sürme 75 Kapı Kanat Kapama		Sürme 75 Kapı Kanat Kapama
	Sürme 75 Kapı Kanat Kapama		Sürme 70 Kapı Kanat Kapama		Sürme 75 Kapı Kanat Kapama		Sürme 70 Kapı Kanat Kapama		Sürme 75 Kapı Kanat Kapama
	Sürme 75 Kapı Kanat Kapama		Sürme 70 Kapı Kanat Kapama		Sürme 75 Kapı Kanat Kapama		Sürme 70 Kapı Kanat Kapama		Sürme 75 Kapı Kanat Kapama

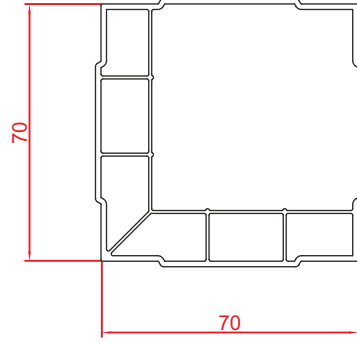
SÜRME SİSTEMLERİ 70-75

Detay Profiller

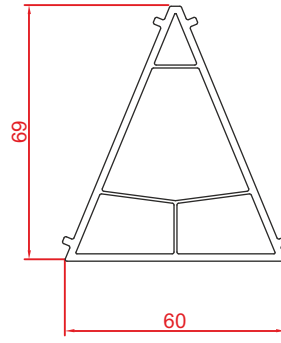




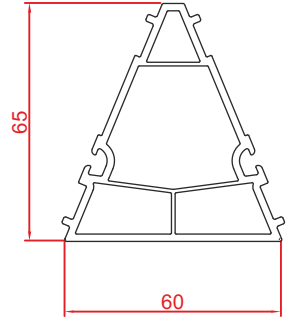
75 Köşe Dönüş Profili



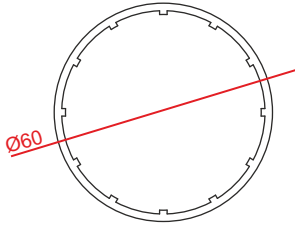
70 Köşe Dönüş Profili



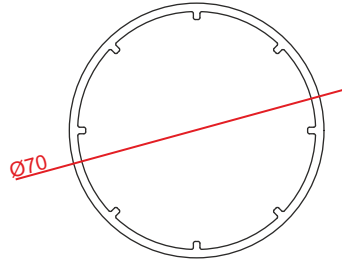
75 135° Köşe Dönüş Profili



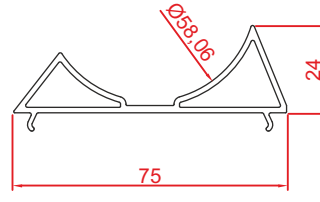
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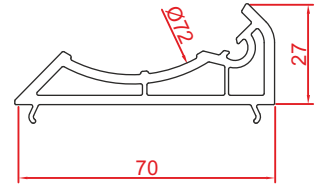
75 Boru Profili



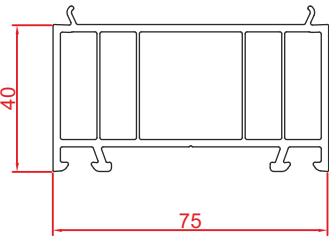
70 Boru Profili



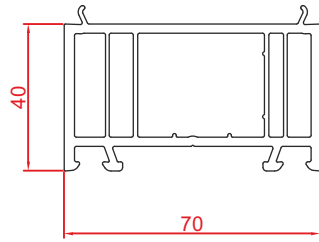
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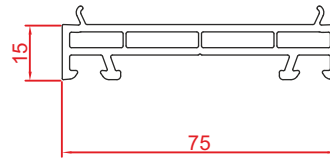
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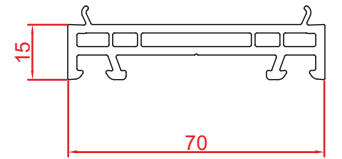
75 40 mm Kasa Kaldırma



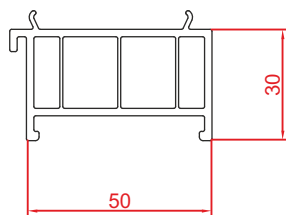
70 40 mm Kasa Kaldırma



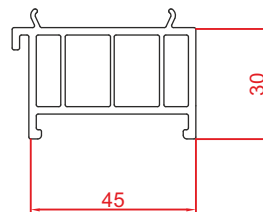
75 15 mm Kasa Kaldırma



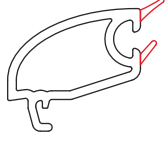
70 15 mm Kasa Kaldırma



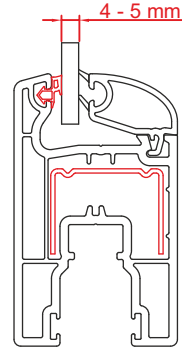
75 Kasa Taban Montaj Profili



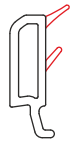
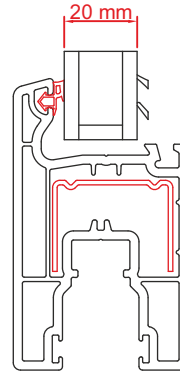
70 Kasa Taban Montaj Profili



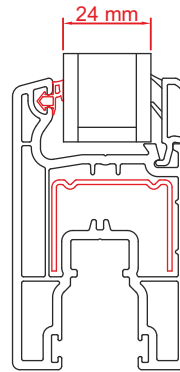
5 mm Çıta



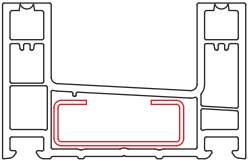
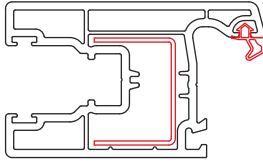
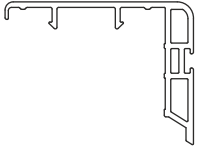
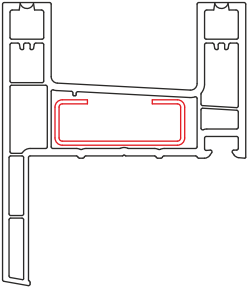
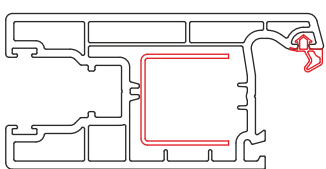
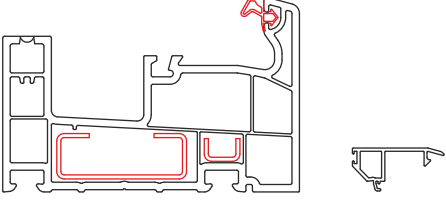
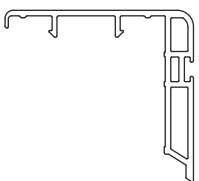
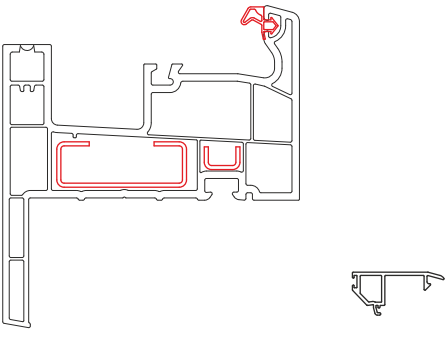
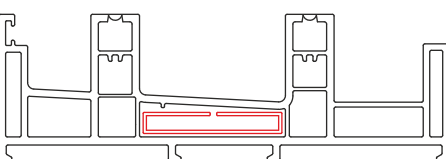
20 mm Çıta



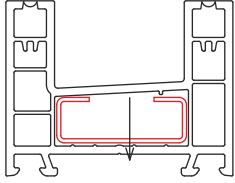
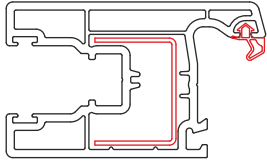
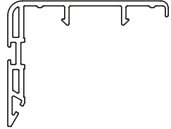
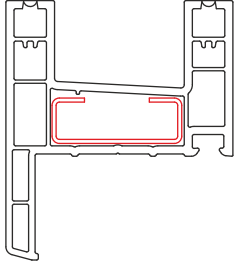
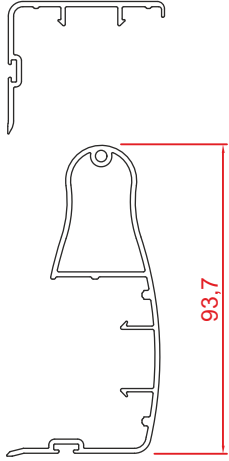
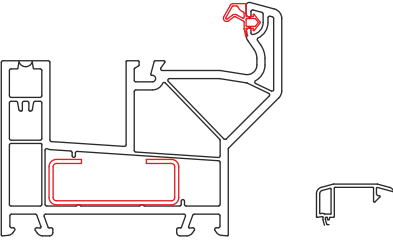
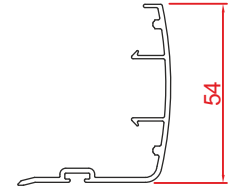
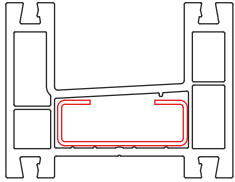
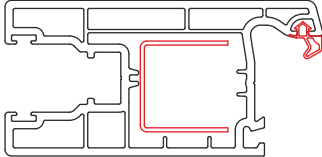

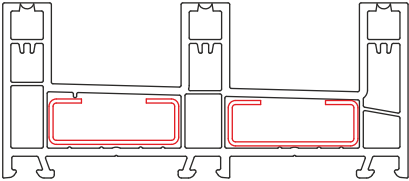
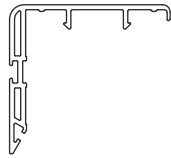
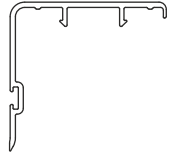
24 mm Çıta



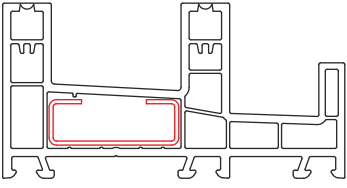
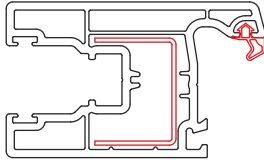
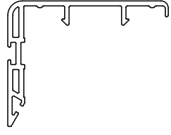
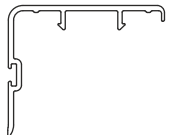
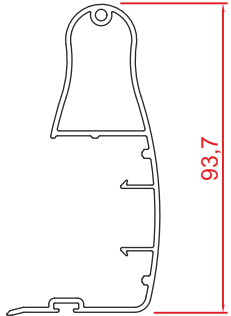
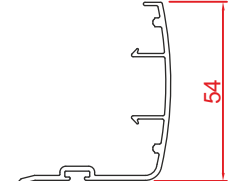
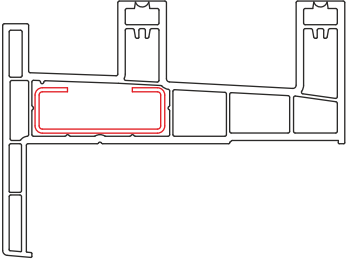
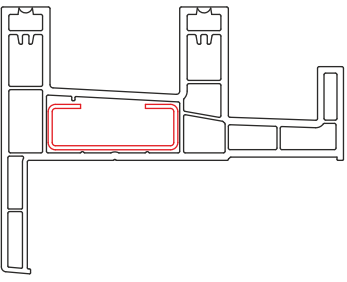
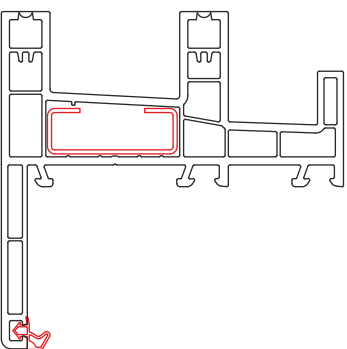
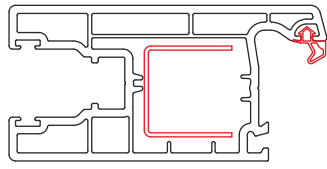
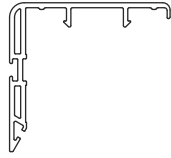
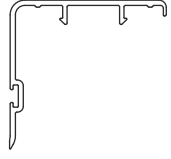
1. 75 ve 70 mm sürme sistemlerinde ortak kanat ve kapı kanat profilleri kullanılmaktadır.
2. Sadece kullanacağınız kasa profiline uygun 70 lik yada 75 lik kanat kapama profillerini kullanmanız gerekmektedir.
3. 1,8 mt den yüksek olan kanat boyutlarında kapı kanadı kullanmanız gerekmektedir.
4. 2,2 mt den yüksek olan kapı kanadı uygulamalarında alüminyum kapatma profillerini kullanmanız gerekmektedir.

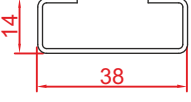
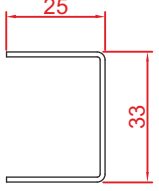
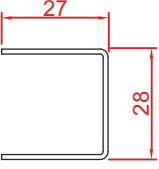
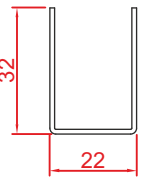
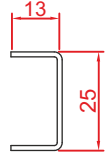
Sürme Kasa Profilleri	Kullanılabilecek Kanat Profilleri	Kullanılabilecek Kapatmalar
<p>75 Sürme Kasa</p> 	<p>Sürme Kanat</p> 	<p>75 Sürme Kanat Kapama</p> 
<p>75 Sürme Pervazlı Kasa</p> 		<p>Sürme Kapı Kanat</p> 
<p>75 Sürme Kayıtlı Kasa</p> 	<p>75 Sürme Kapı Kanat Kapama</p> 	
<p>75 Sürme Pervazlı Kayıtlı Kasa</p> 		
<p>75 Sürme Yalıtımlı Kasa</p> 		

1. 75 ve 70 mm sürme sistemlerinde ortak kanat ve kapı kanat profilleri kullanılmaktadır.
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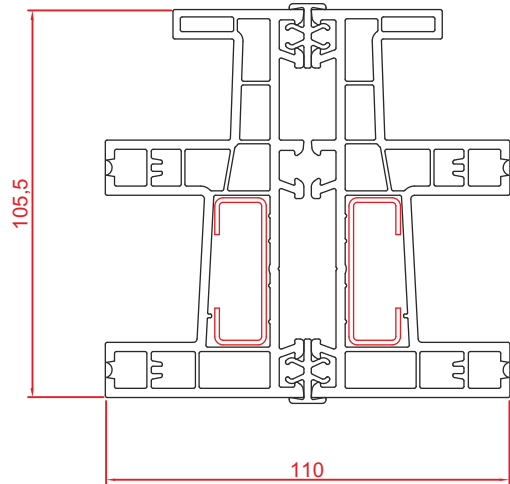
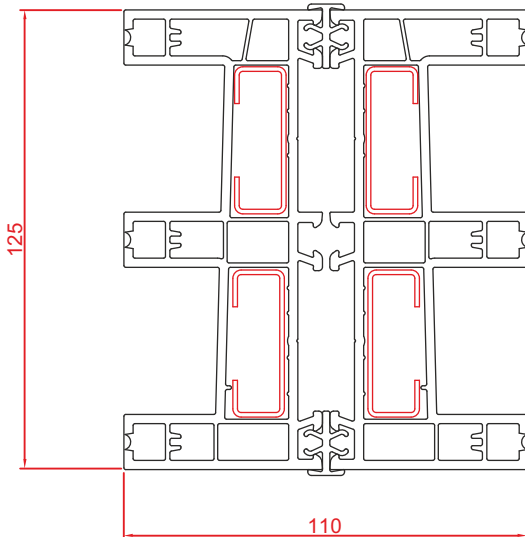
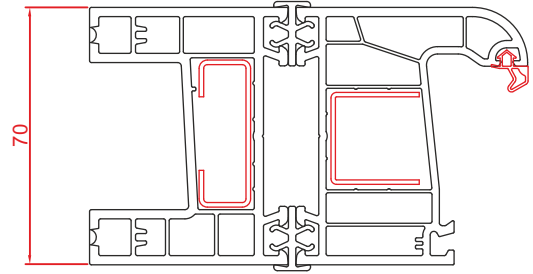
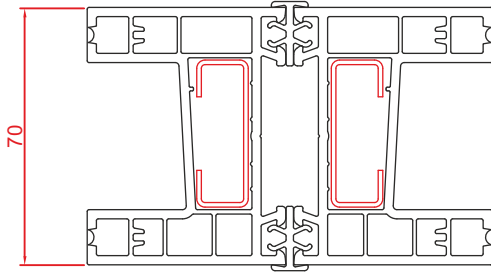
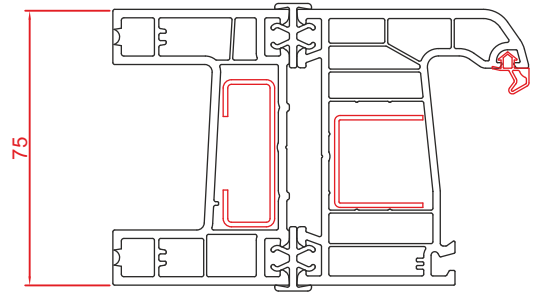
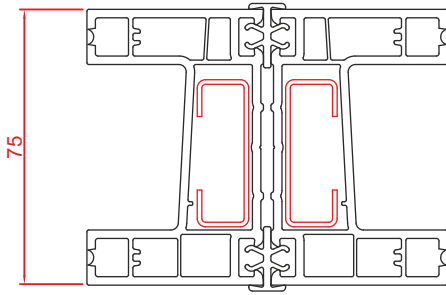
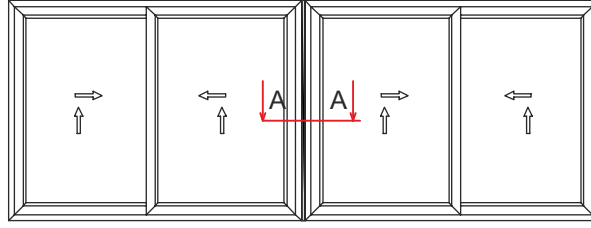
Sürme Kasa Profilleri	Kullanılabilecek Kanat Profilleri	Kullanılabilecek Kapatmalar
70 Sürme Kasa 	Sürme Kanat 	70 Sürme C. Kanat Kapama 
70 Sürme Pervazlı Kasa 		70 Sürme Kanat Kapama 
70 Sürme Kayıtlı Kasa 		70 Sürme Alm. Tutamaklı Kanat Kapama 
70 Sürme Pervazlı Kayıtlı Kasa 	Sürme Kapı Kanat 	70 Sürme Alm. Kanat Kapama 
Üçlü Sürme Kasa 		70 Sürme C. Kapı Kanat Kapama 
		70 Sürme Kapı Kanat Kapama 

1. 75 ve 70 mm sürme sistemlerinde ortak kanat ve kapı kanat profilleri kullanılmaktadır.
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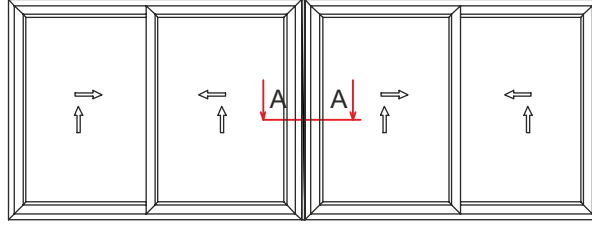
Sürme Kasa Profilleri	Kullanılabilecek Kanat Profilleri	Kullanılabilecek Kapatmalar
<p>Sürme Sineklikli Kasa</p> 	<p>Sürme Kanat</p> 	<p>70 Sürme C. Kanat Kapama</p>  <p>70 Sürme Kanat Kapama</p>  <p>70 Sürme Alm. Tutamaklı Kanat Kapama</p>  <p>93,7</p> <p>70 Sürme Alm. Kanat Kapama</p>  <p>54</p>
<p>İçten Sinklikli Pervazlı Kasa</p> 		
<p>Dıştan Sinklikli Pervazlı Kasa</p> 		
<p>50 mm Dıştan Sinklikli Pervazlı Kasa</p> 	<p>Sürme Kapı Kanat</p> 	<p>70 Sürme C. Kapı Kanat Kapama</p>  <p>70 Sürme Kapı Kanat Kapama</p> 

Şekli	Kullanım Yeri	Kalınlıklar	Atalet Değerleri
	Sürme Kasa Sürme Pervazlı Kasa Sürme Kayıtlı Kasa Sürme Pervazlı Kayıtlı Kasa Kasalı Orta Kayıt 3'lü Sürme Kasa Sineklikli Kasalar	1,2 mm	$I_x : 0,28 - I_y : 1,86$
		1,5 mm	$I_x : 0,33 - I_y : 2,26$
		2 mm	$I_x : 0,40 - I_y : 2,88$
	Sürme Kanat	1,2 mm	$I_x : 1,76 - I_y : 0,63$
		1,5 mm	$I_x : 2,16 - I_y : 0,77$
		2 mm	$I_x : 2,77 - I_y : 1,00$
	Sürme Kapı Kanat	1,2 mm	$I_x : 1,30 - I_y : 0,73$
	75 Sürme Dikey Orta Kayıt	1,5 mm	$I_x : 1,59 - I_y : 0,90$
	2 mm	$I_x : 2,03 - I_y : 1,16$	
	Sürme Kanat İçi Orta Kayıt	1,2 mm	$I_x : 1,07 - I_y : 0,90$
		1,5 mm	$I_x : 1,32 - I_y : 1,09$
		2 mm	$I_x : 1,71 - I_y : 1,37$
	Sürme Fix Profilleri	1,2 mm	$I_x : 0,54 - I_y : 0,1$
		1,5 mm	$I_x : 1,0,65 - I_y : 0,11$
		2 mm	$I_x : 0,82 - I_y : 0,14$

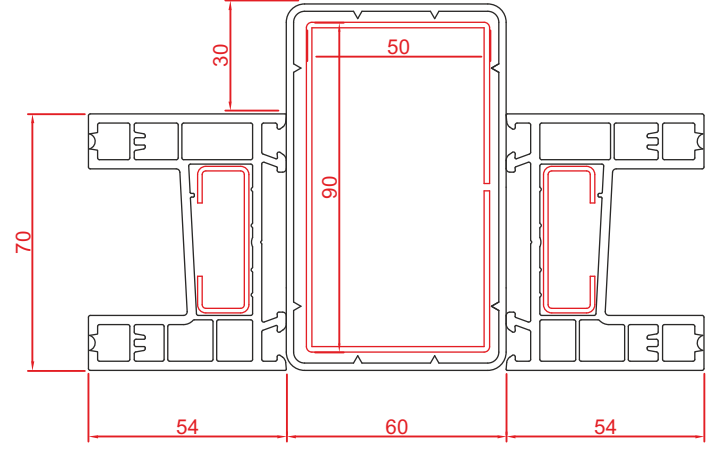
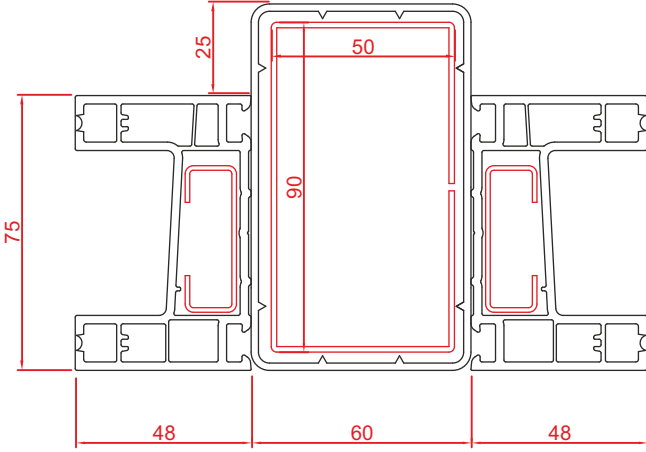
Bağ Profili Uygulamaları



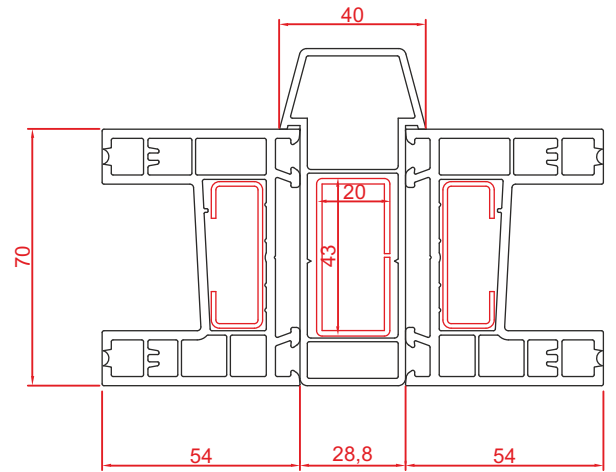
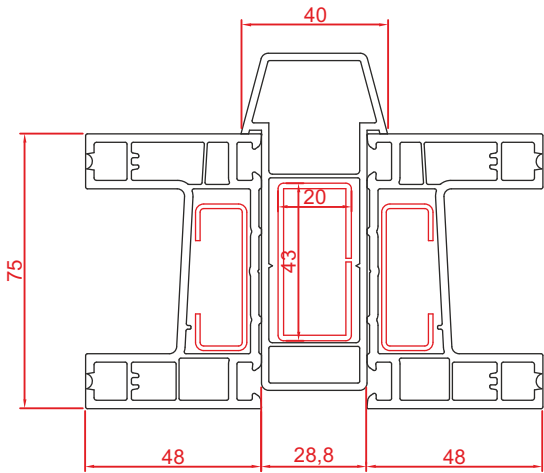
Griyaj Uygulamaları



60x100 Griyaj Uygulaması

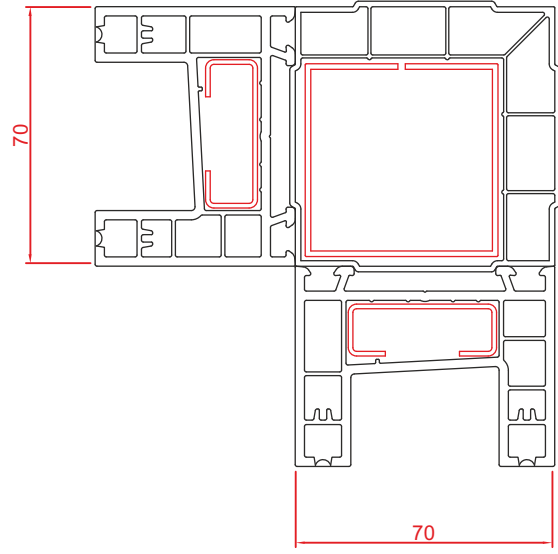
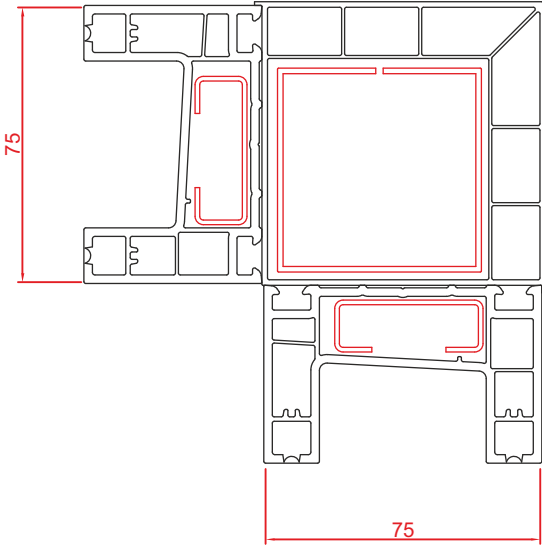
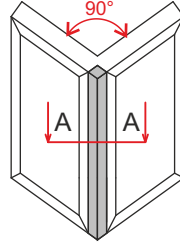


Midi Griyaj Uygulaması

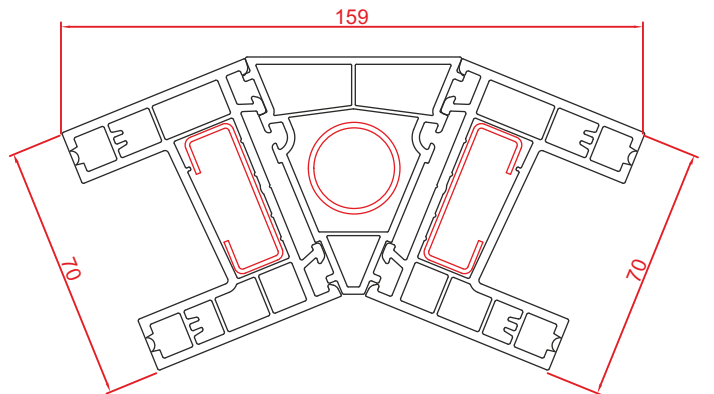
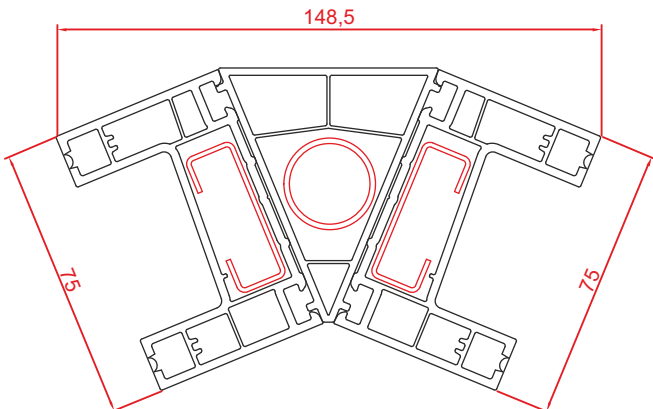
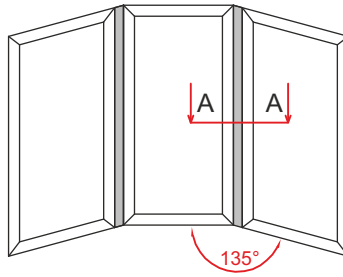


Köşe Dönüş Uygulamaları

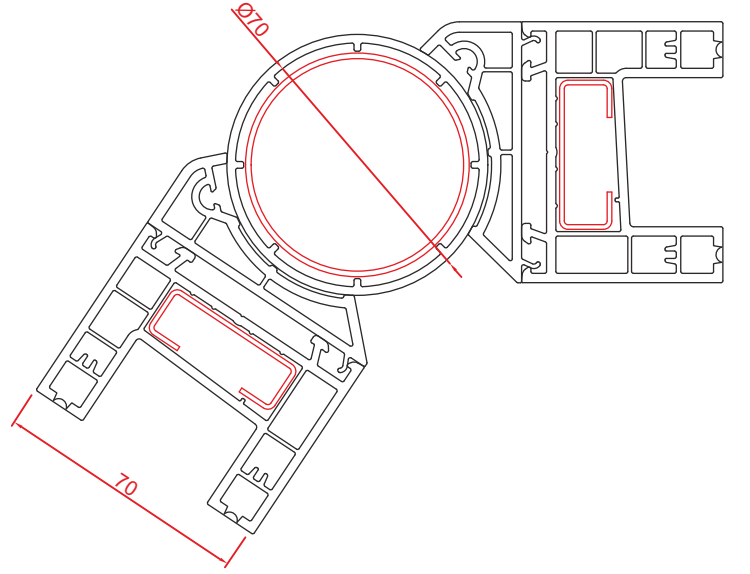
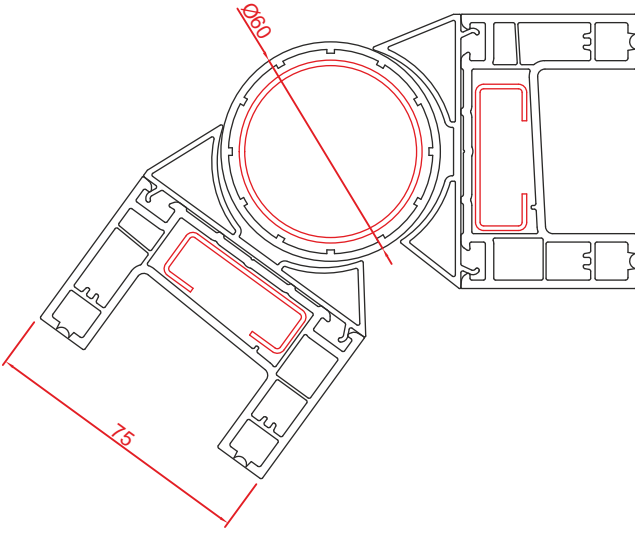
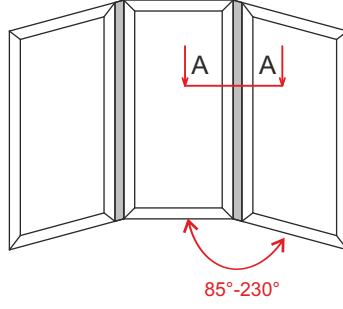
90° Köşe Dönüş Uygulaması



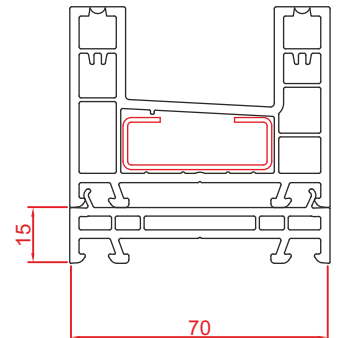
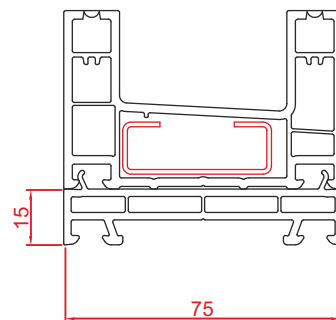
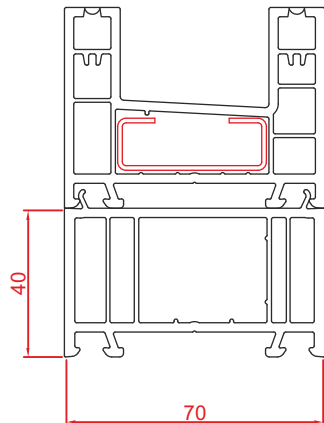
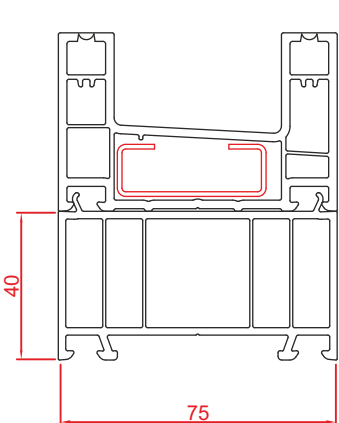
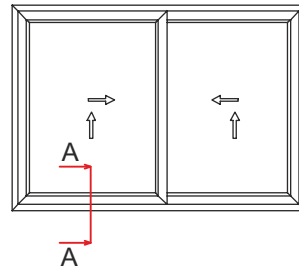
135° Açılı Dönüş Uygulaması

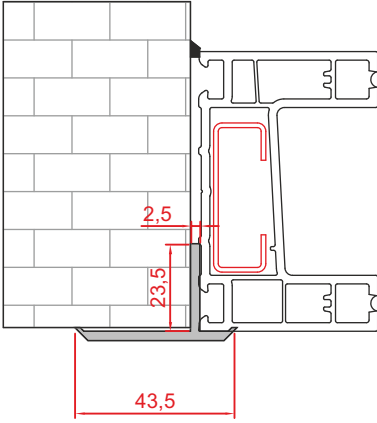


Açılı Dönüş Boru ve Adaptör Uygulaması

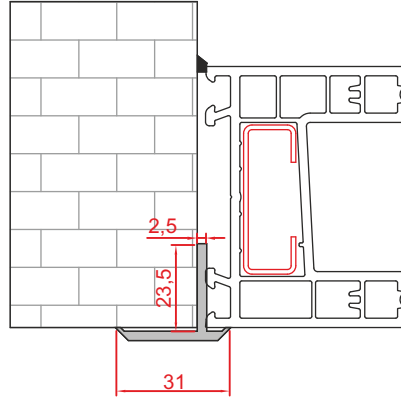


Kasa Kaldırma Uygulaması

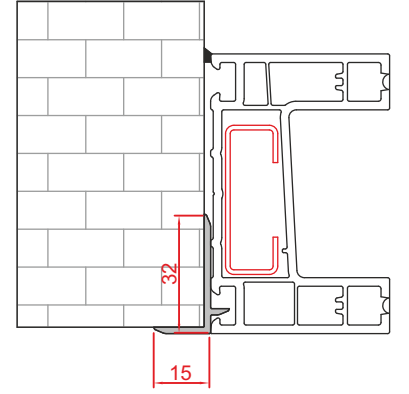




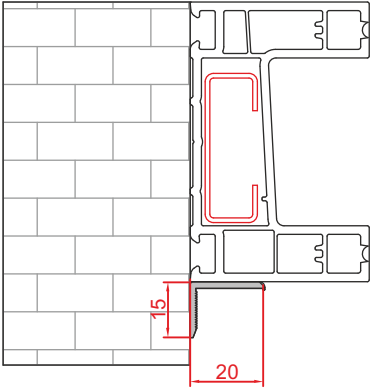
Geniş Asimetrik T Uygulaması



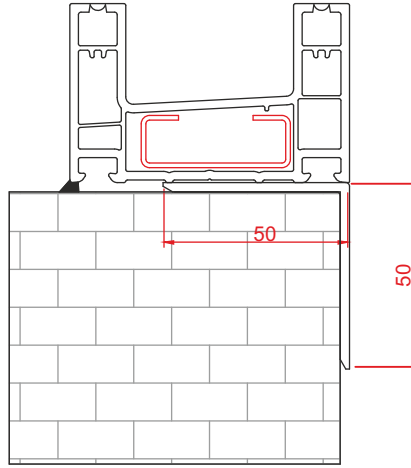
Dar Asimetrik T Uygulaması



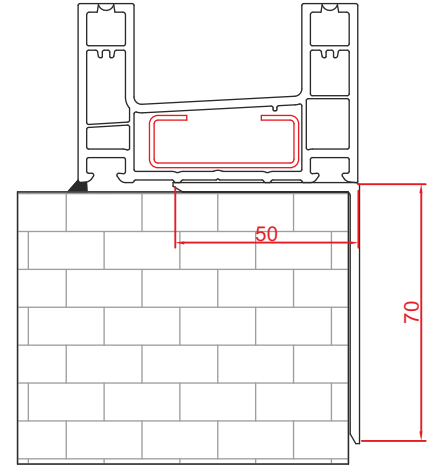
Tırnaklı T Uygulaması



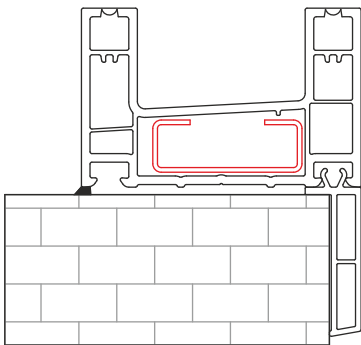
Köşebent Uygulaması



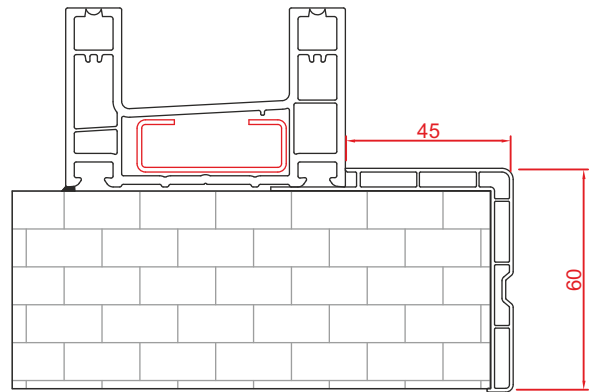
50x50 Pervaz Uygulaması



50x70 Pervaz Uygulaması



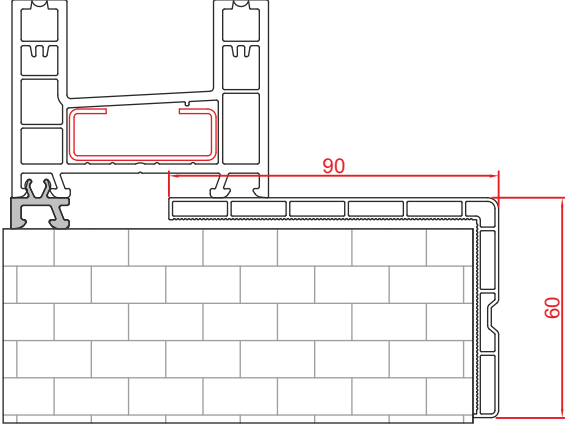
Sıfır Pervaz Uygulaması



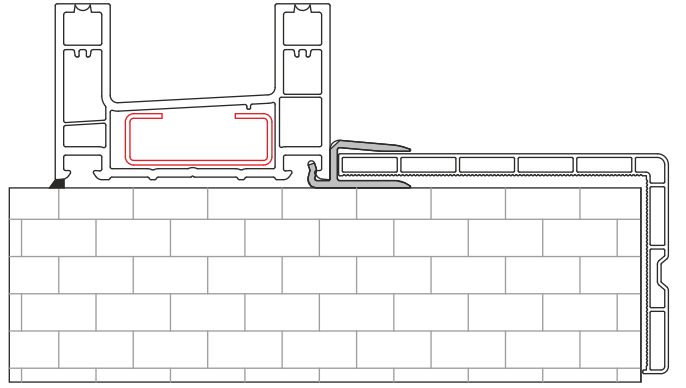
60x45 Kulaklı Pervaz Uygulaması

60 x 90 Pervaz Uygulaması

Pervaz Dayama Profili Uygulaması

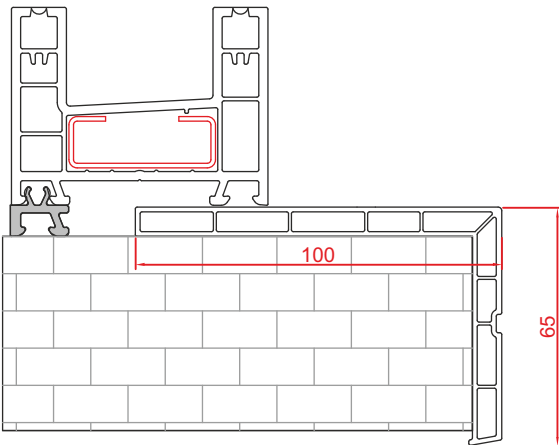


Pervaz Adaptör Profili Uygulaması

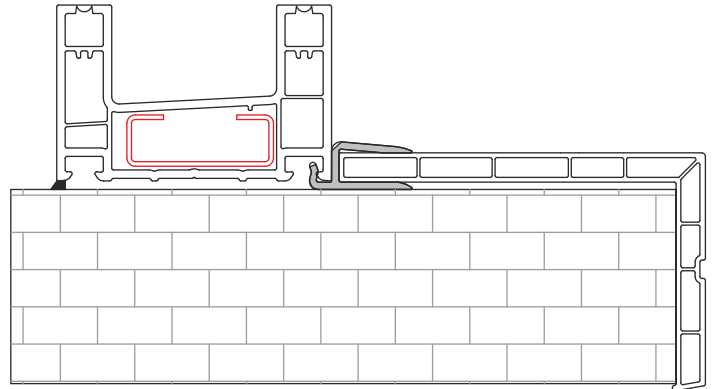


65 x 100 Pervaz Uygulaması

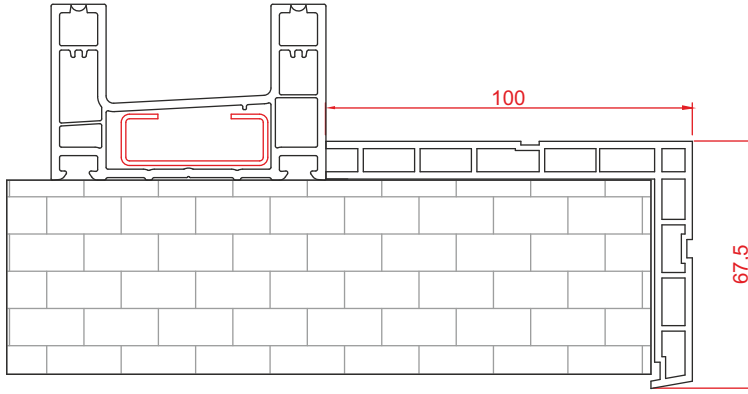
Pervaz Dayama Profili Uygulaması



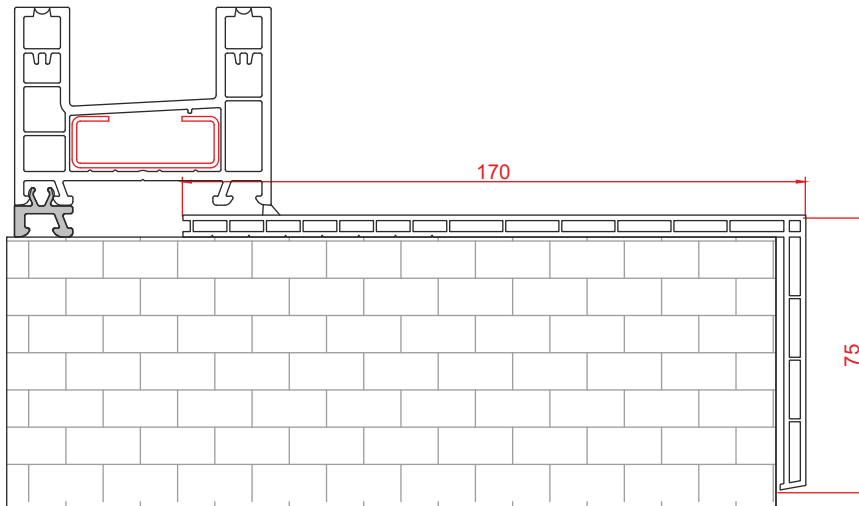
Pervaz Adaptör Profili Uygulaması



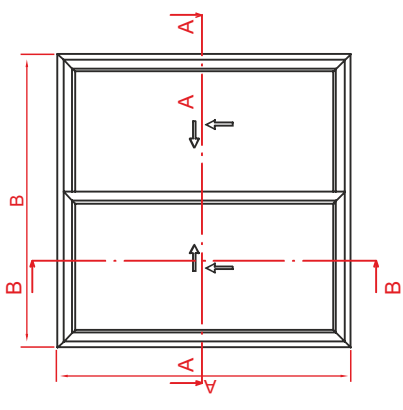
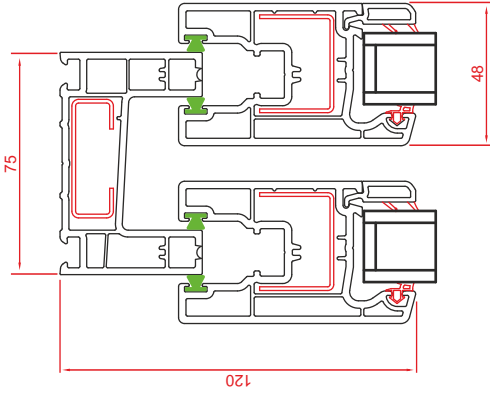
67,5 x 100 mm Pervaz Uygulaması



75 x 170 mm Pervaz Uygulaması



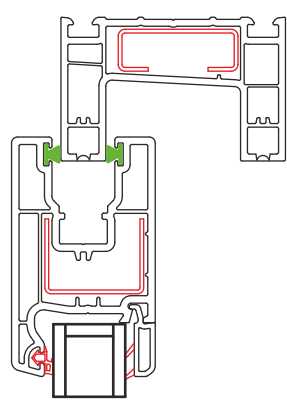
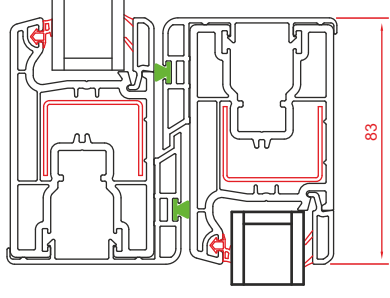
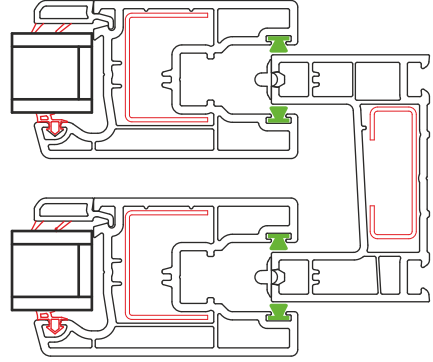
Sürme 75 Kasa Uygulaması



Kanat Kesim Ölçüsü	Dikey		Yatay	
	Ölçü (mm)	Ad.	Ölçü (mm)	Ad.
A-74	A-74	4	(B/2)+5	4

B-B

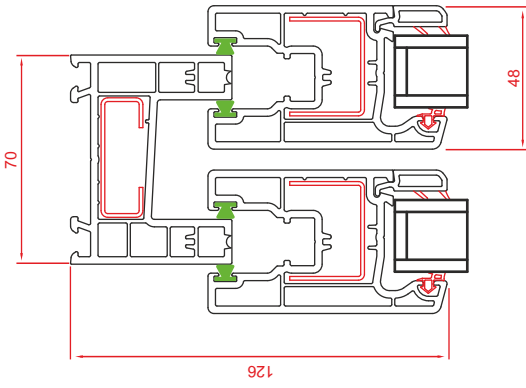
A-A



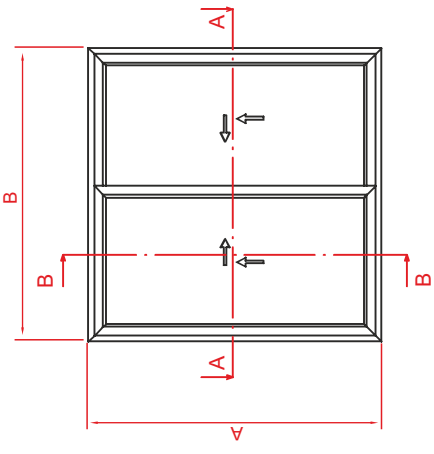
SÜRME SİSTEMLERİ 70-75

Pencere Kesitleri

Sürme 70 Kasa Uygulaması

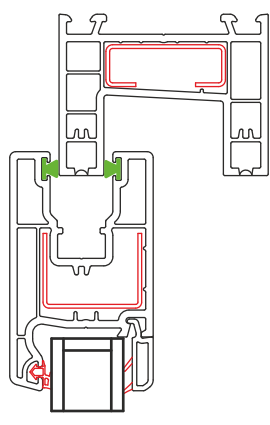
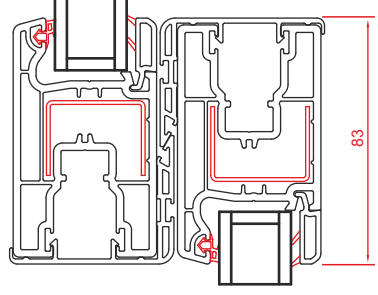
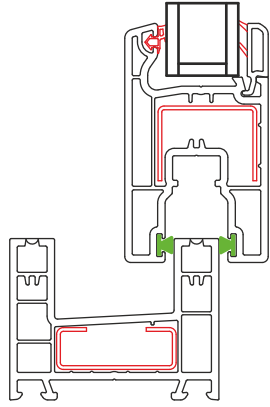
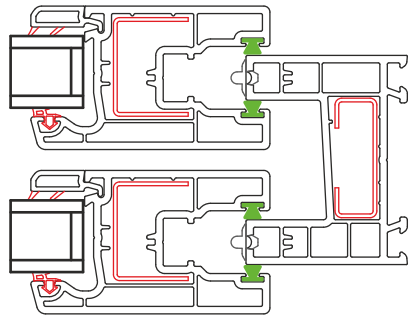


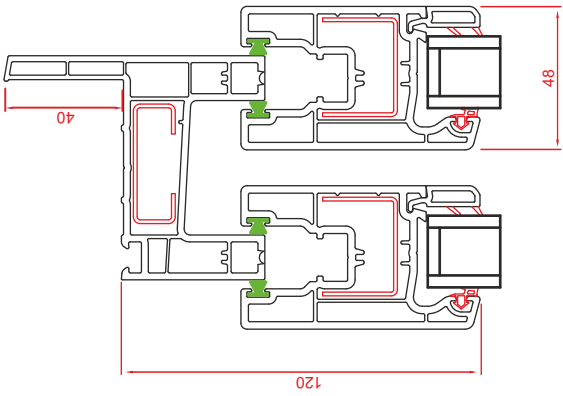
Kanat Kesim Ölçüsü	Dikey		Yatay	
	Ölçü (mm)	Ad.	Ölçü (mm)	Ad.
A-86	A-86	4	B/2	4



B-B

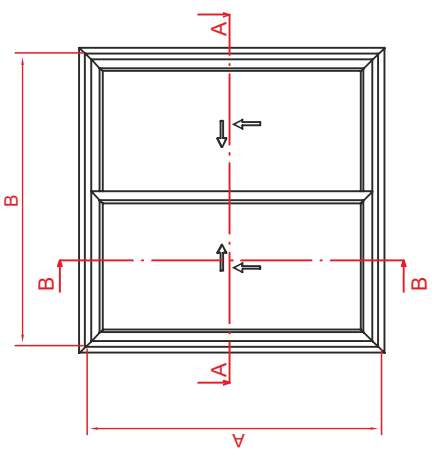
A-A





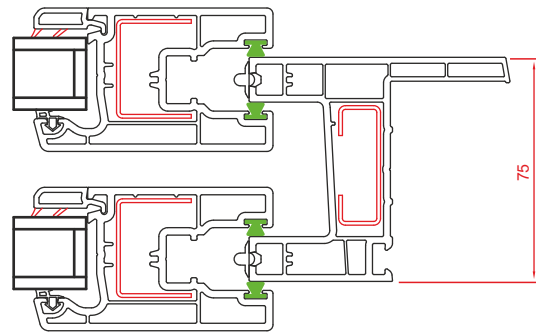
Sürme 75 Pervazlı Kasa Uygulaması

Kanat Kesim Ölçüsü	Dikey		Yatay	
	Ölçü (mm)	Ad.	Ölçü (mm)	Ad.
A-74	A-74	4	(B/2)+5	4

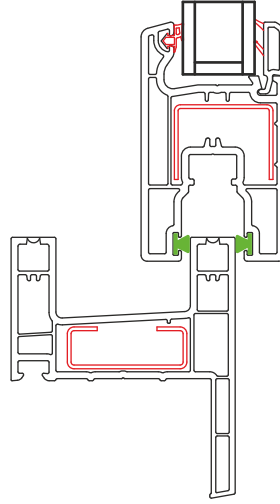
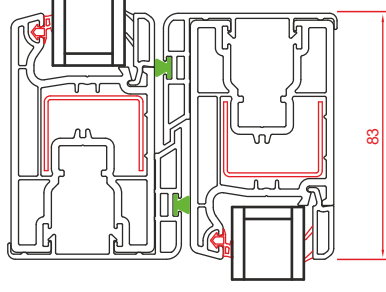


B-B

A ve B ölçüleri, pervaz hariç, kasanın dıştan dışa ölçüleridir.

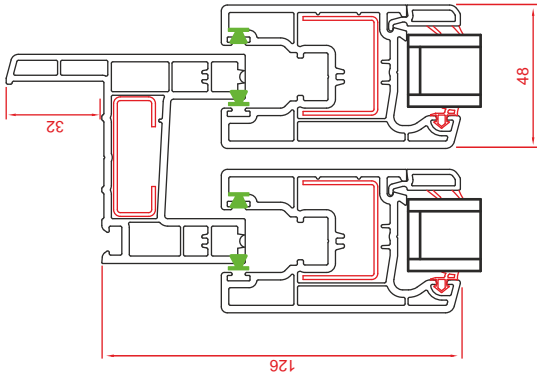


A-A



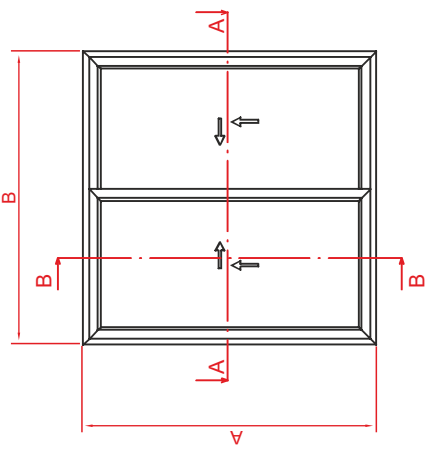
SÜRME SİSTEMLERİ 70-75

Pencere Kesitleri



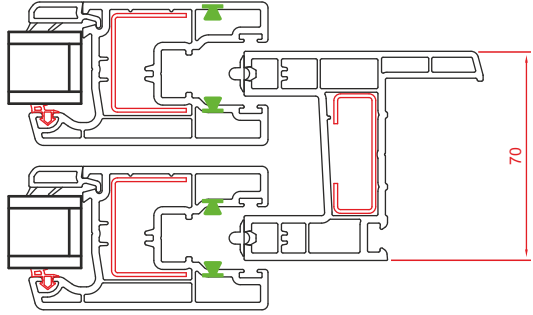
Sürme 70 Pervazlı Kasa Uygulaması

Kanat Kesim Ölçüsü	Dikey		Yatay	
	Ölçü (mm)	Ad.	Ölçü (mm)	Ad.
A-74	A-74	4	(B/2)+5	4

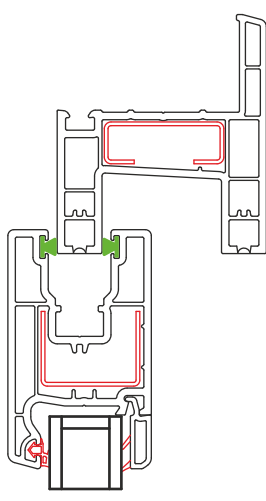
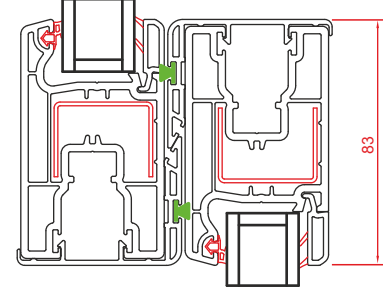
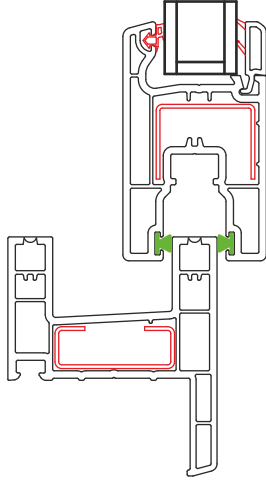


B-B

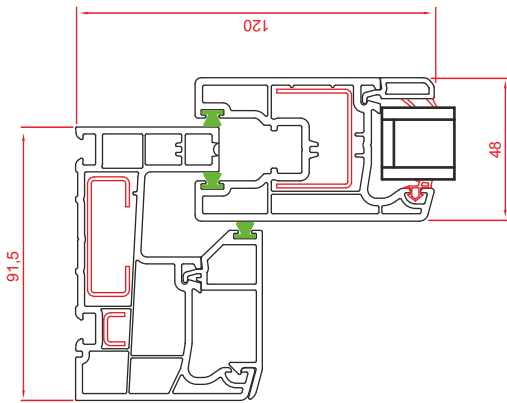
A ve B ölçüleri, pervaz hariç, kasanın dıştan dışı ölçüleridir.



A-A

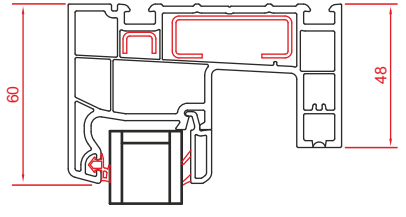
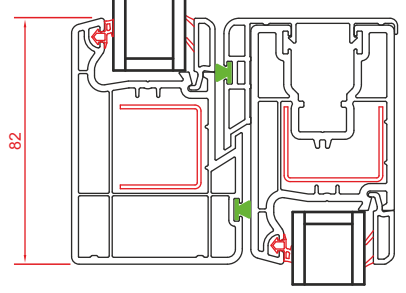
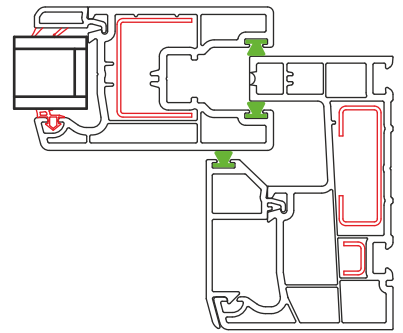
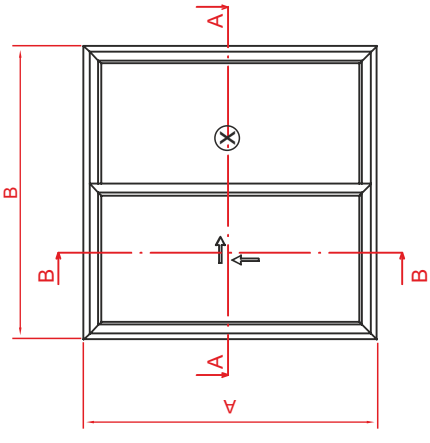
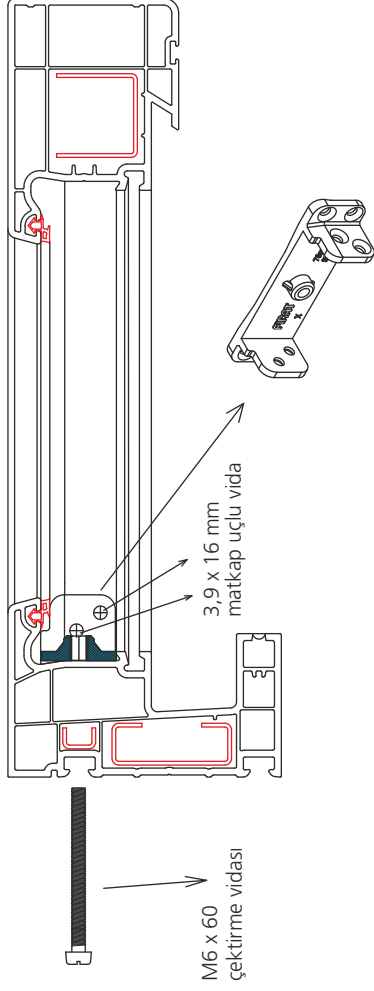


Sürme 75 Kayıtlı Kasa Uygulaması



B-B

Kanat Kesim Ölçüsü	Dikey		Yatay	
	Ölçü (mm)	Ad.	Ölçü (mm)	Ad.
A-74	2	(B/2)+5	2	2

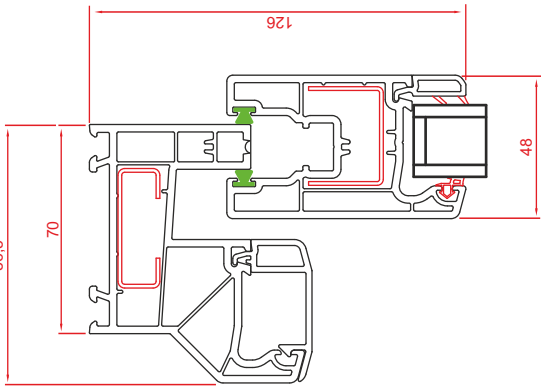


A-A

SÜRME SİSTEMLERİ 70-75

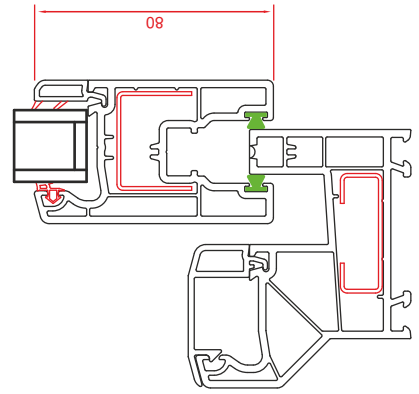
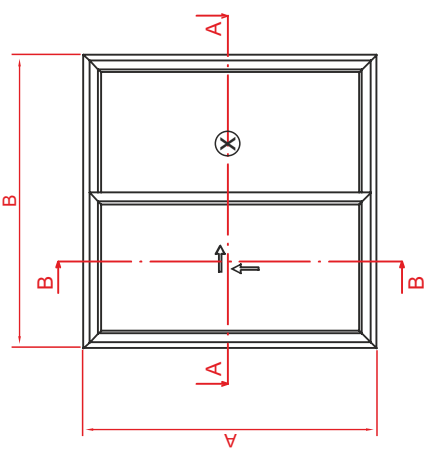
Pencere Kesitleri

Sürme 70 Kayıtlı Kasa Uygulaması

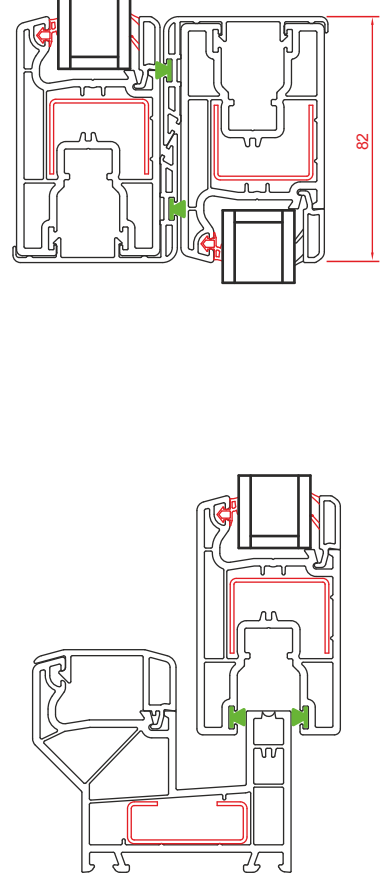


B-B

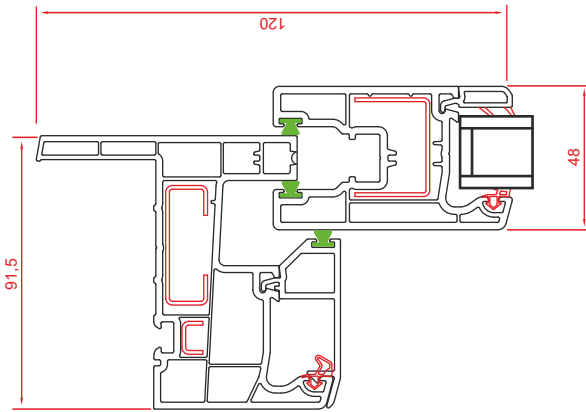
Kanat Kesim Ölçüsü	Dikey		Yatay	
	Ölçü (mm)	Ad.	Ölçü (mm)	Ad.
A-86	2	2	B/2	2



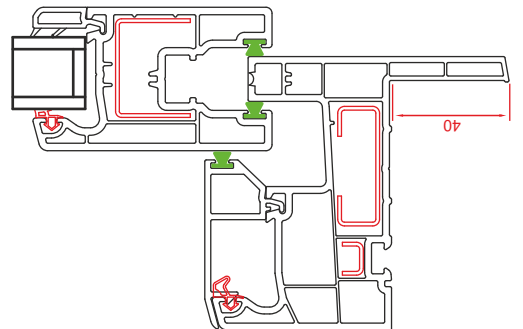
A-A



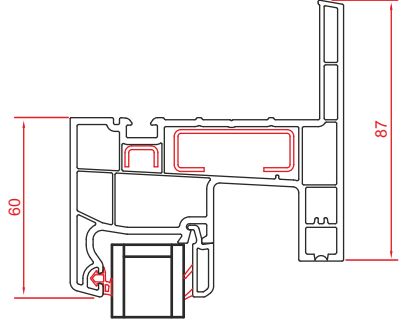
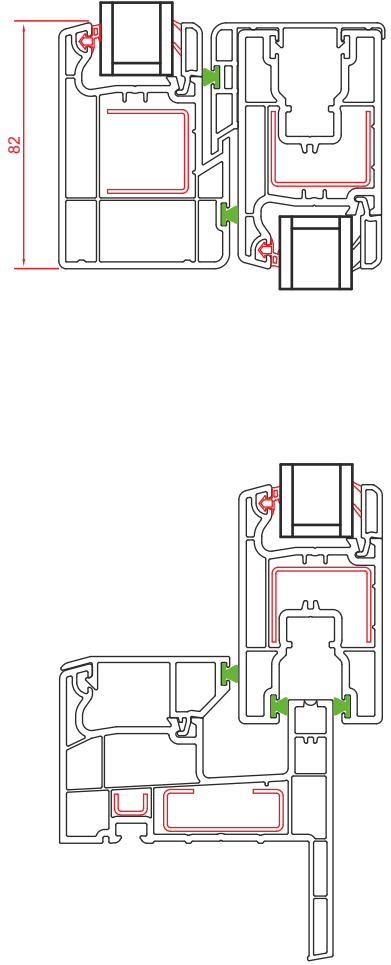
SÜRME SİSTEMLERİ 70-75



B-B



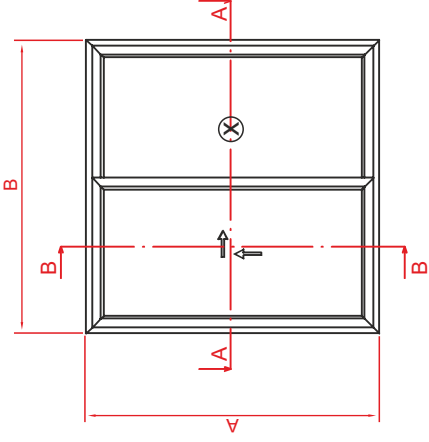
A-A



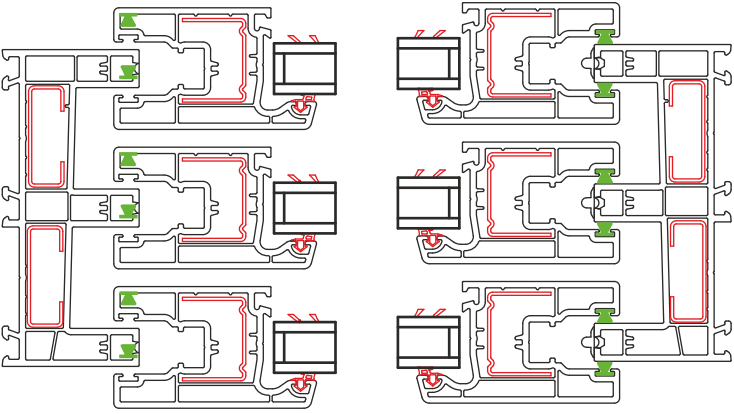
Pencere Kesitleri

Sürme 75 Pervazlı Kayıtlı Kasa Uygulaması

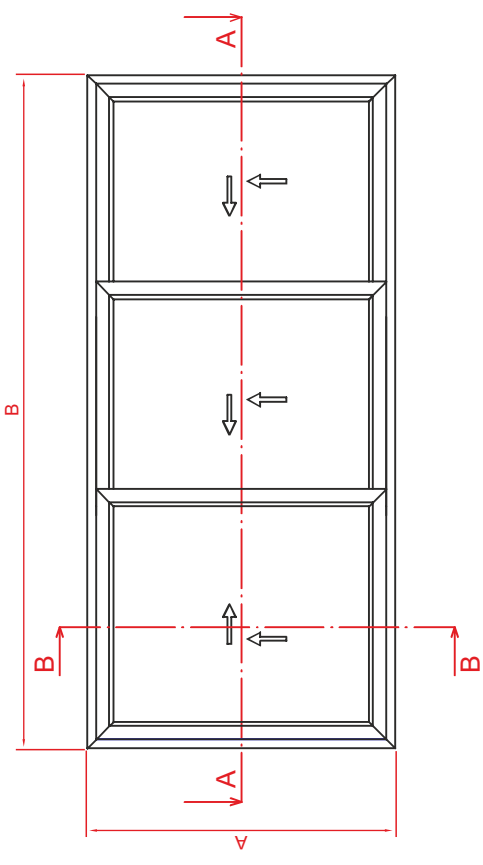
Kanat Kesim Ölçüsü	Dikey		Yatay	
	Ölçü (mm)	Ad.	Ölçü (mm)	Ad.
A-74	A-74	2	(B/2)+5	2



A ve B ölçüleri, pervaz haric, kasanın dıştan dış ölçüleridir.



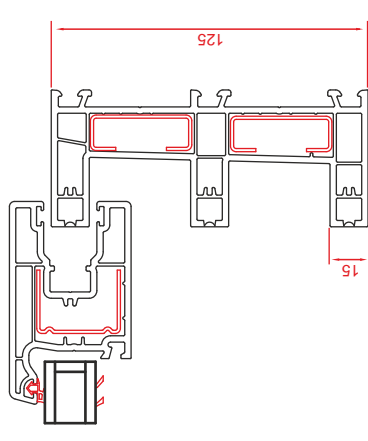
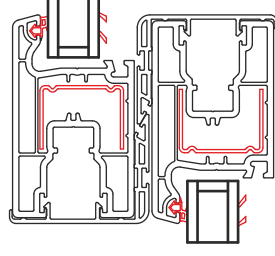
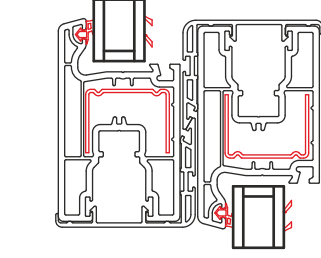
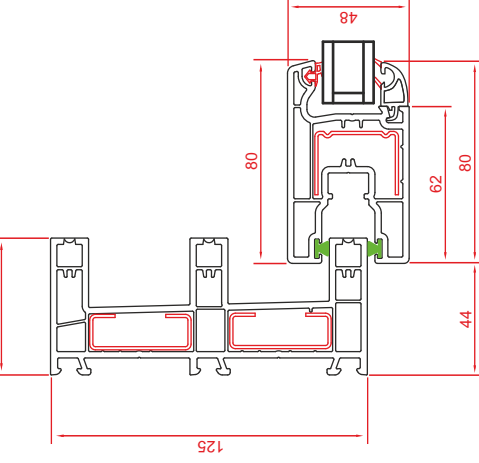
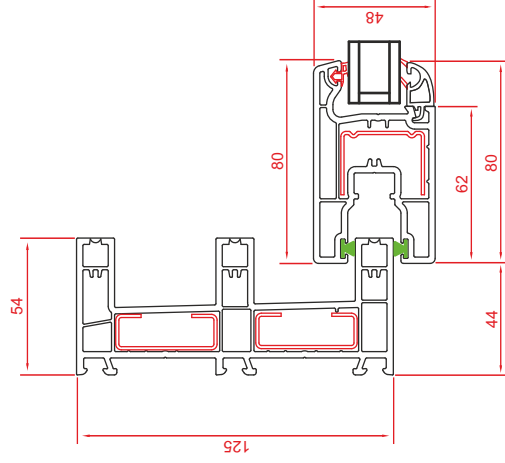
Üçlü Sürme Uygulaması

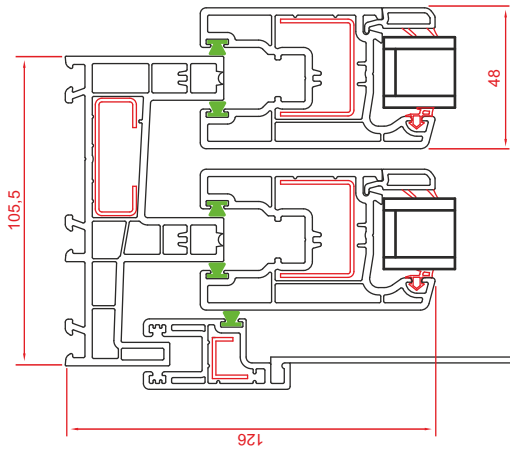


B-B

Kanat Kesim Ölçüsü	Dikey		Yatay	
	Ölçü (mm)	Ad.	Ölçü (mm)	Ad.
A-86	A-86	2	(B/3)+28	6

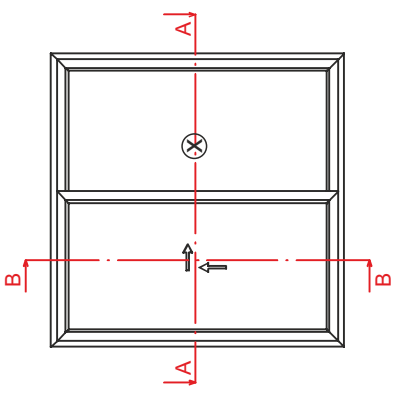
A-A



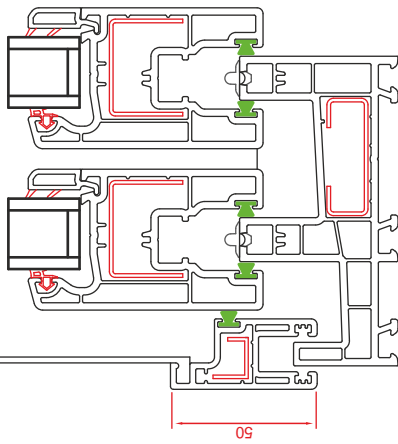


Sürme Sineklikli Kasa Uygulaması

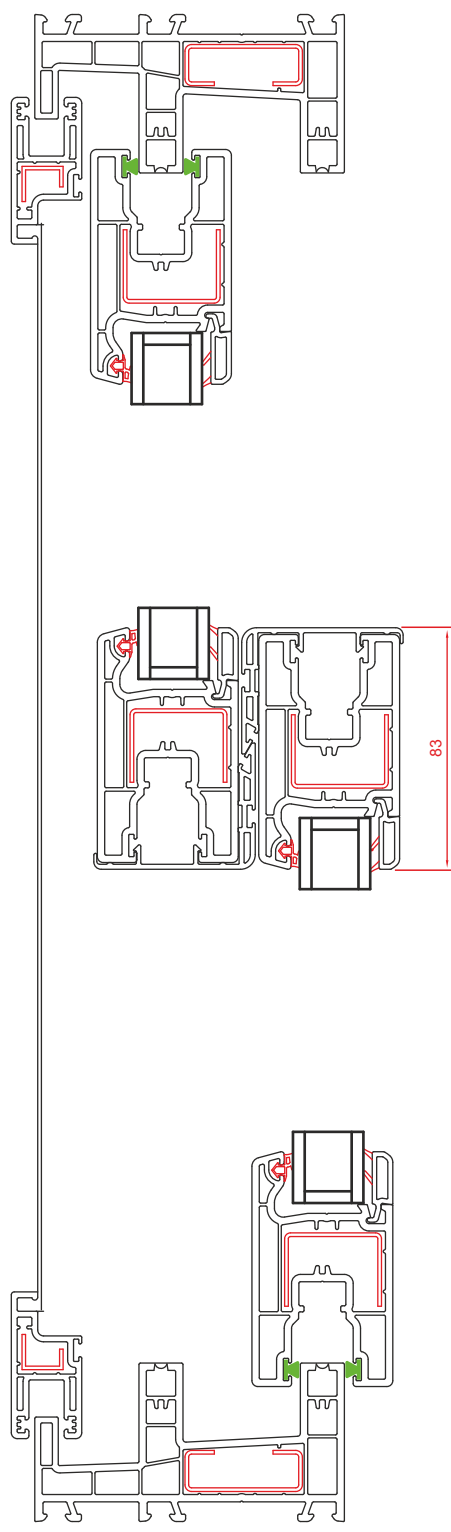
Kanat Kesim Ölçüsü	Dikey		Yatay	
	Ölçü (mm)	Ad.	Ölçü (mm)	Ad.
A-86	A-86	4	B/2	4



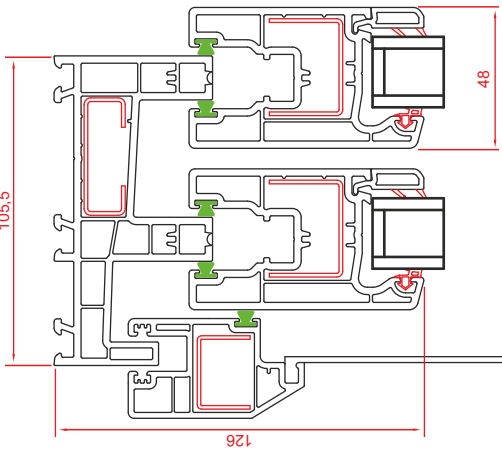
B-B



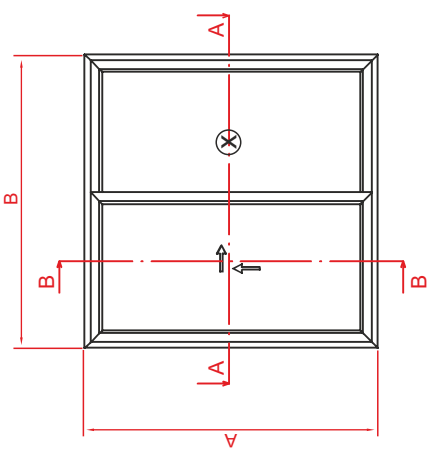
A-A



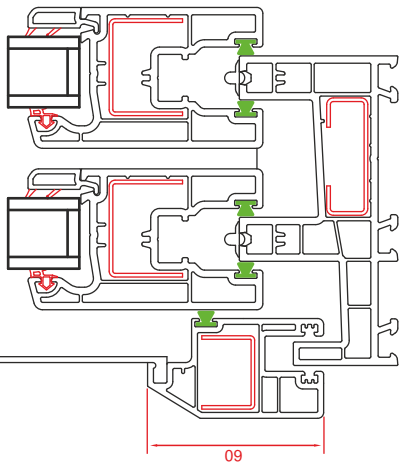
Sürme Büyük Sineklik Kanat ve Sineklik Orta Kayıt Uygulaması



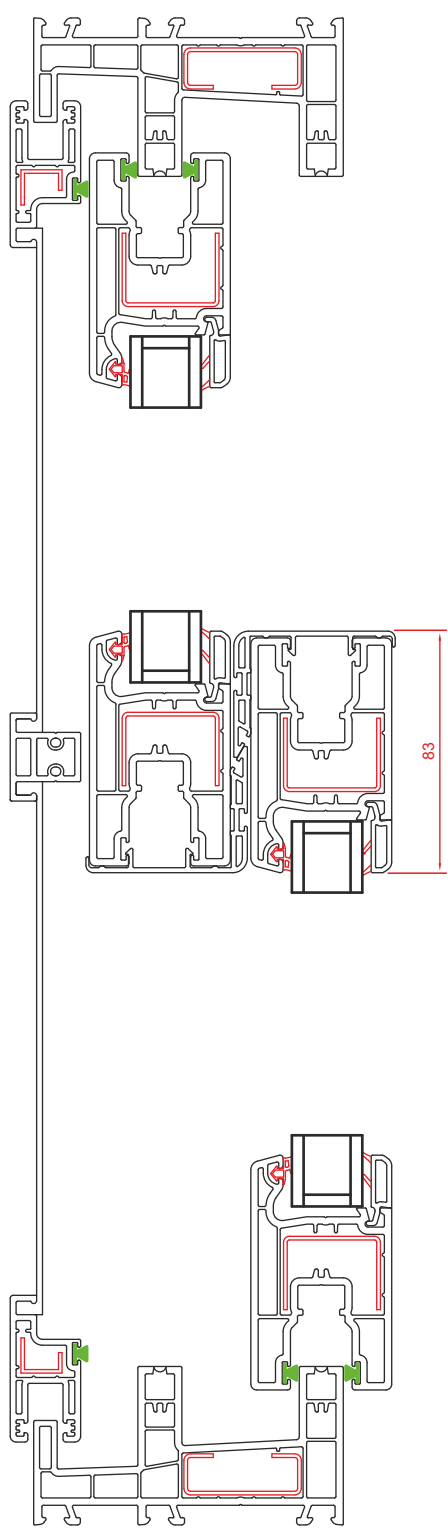
Kanat Kesim Ölçüsü	Dikey		Yatay	
	Ölçü (mm)	Ad.	Ölçü (mm)	Ad.
A-86	A-86	4	B/2	4



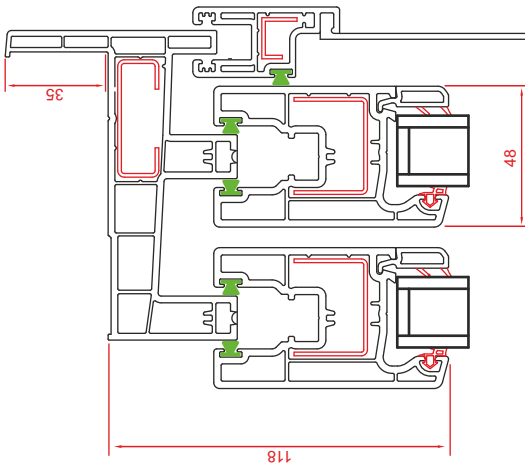
B-B



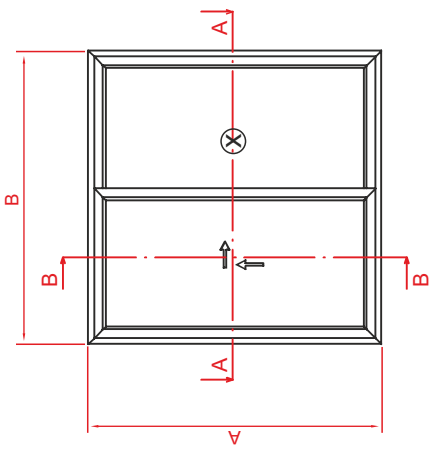
A-A



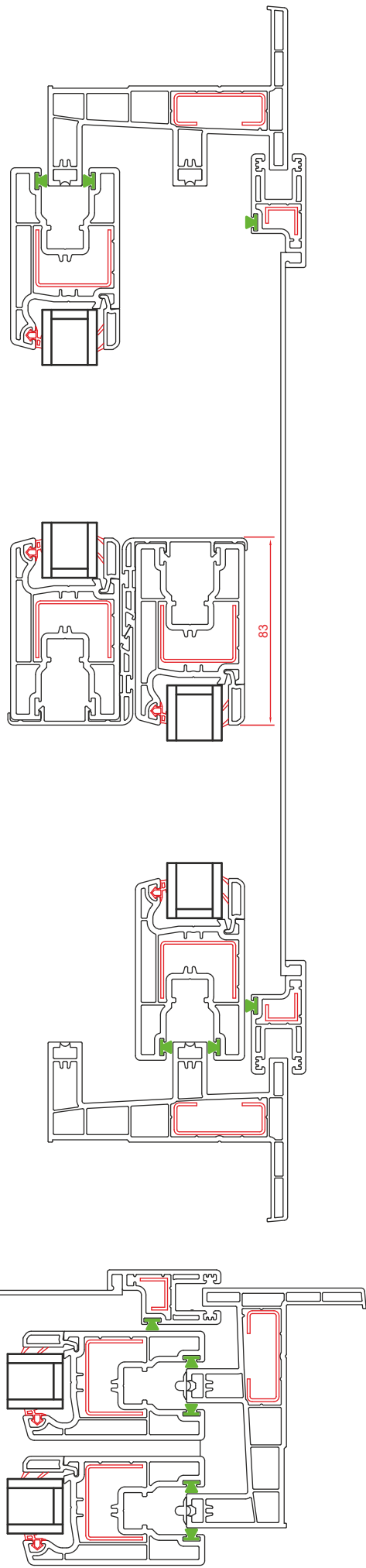
İçten Sineklikli Sürme Pervazlı Kasa Uygulaması



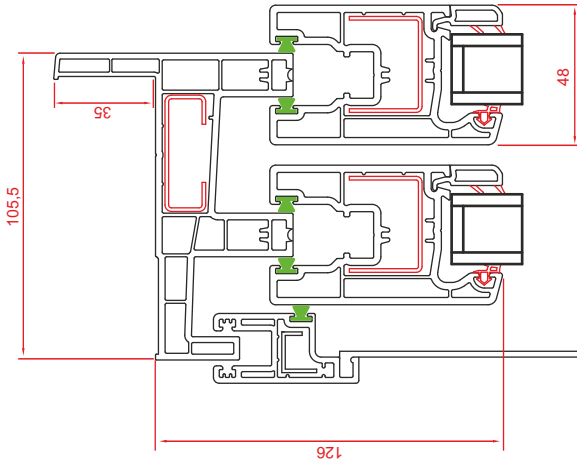
Kanat Kesim Ölçüsü	Dikey		Yatay	
	Ölçü (mm)	Ad.	Ölçü (mm)	Ad.
A-66	A-66	4	(B/2)+8	4



A ve B ölçüleri, pervaz hariç, kasanın dıştan dış ölçüleridir.

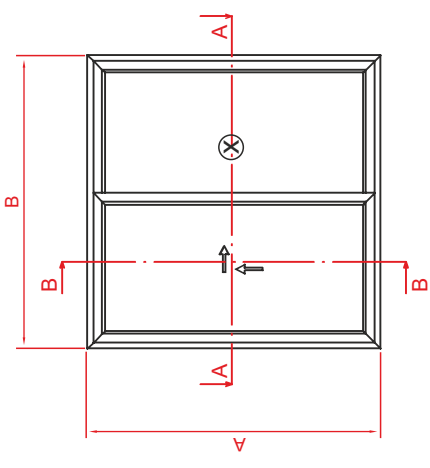


Dıştan Sineklikli Sürme Pervazlı Kasa Uygulaması



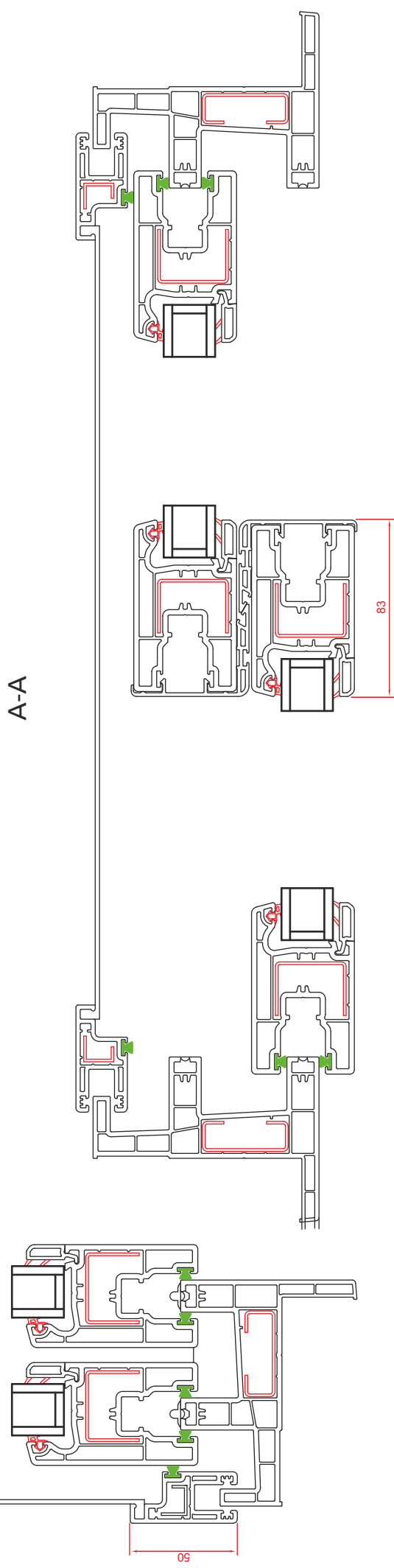
B-B

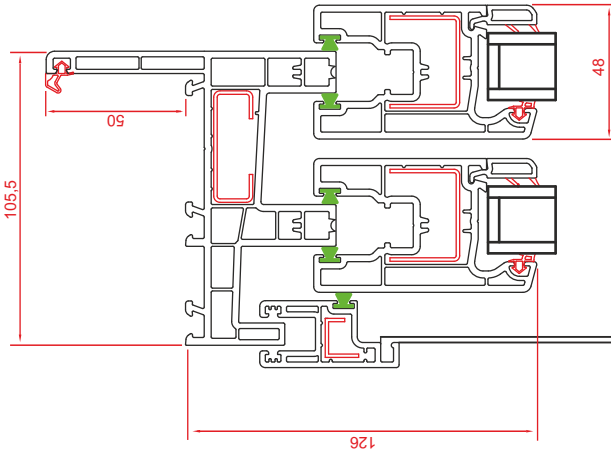
Kanat Kesim Ölçüsü	Dikey		Yatay	
	Ölçü (mm)	Ad.	Ölçü (mm)	Ad.
A-72	A-72	4	(B/2)+6	4



A ve B ölçüleri, pervaz hariç, kasanın dıştan dış ölçüleridir.

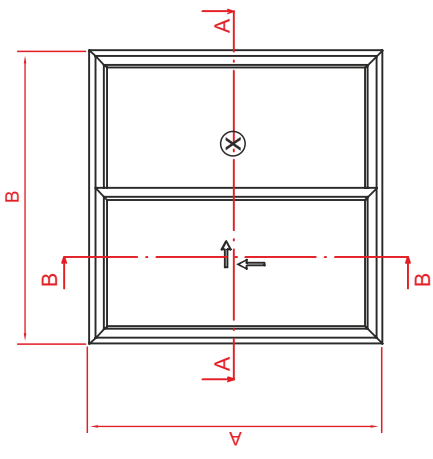
A-A





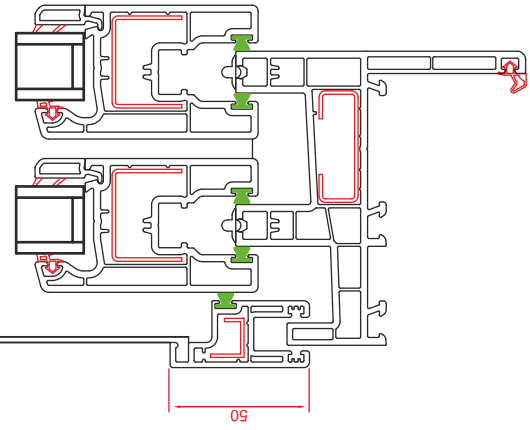
50 mm Dıştan Sineklikli Sürme Pervazlı Kasa Uygulaması

Kanat Kesim Ölçüsü	Dikey		Yatay	
	Ölçü (mm)	Ad.	Ölçü (mm)	Ad.
A-86	A-86	4	(B/2)	4

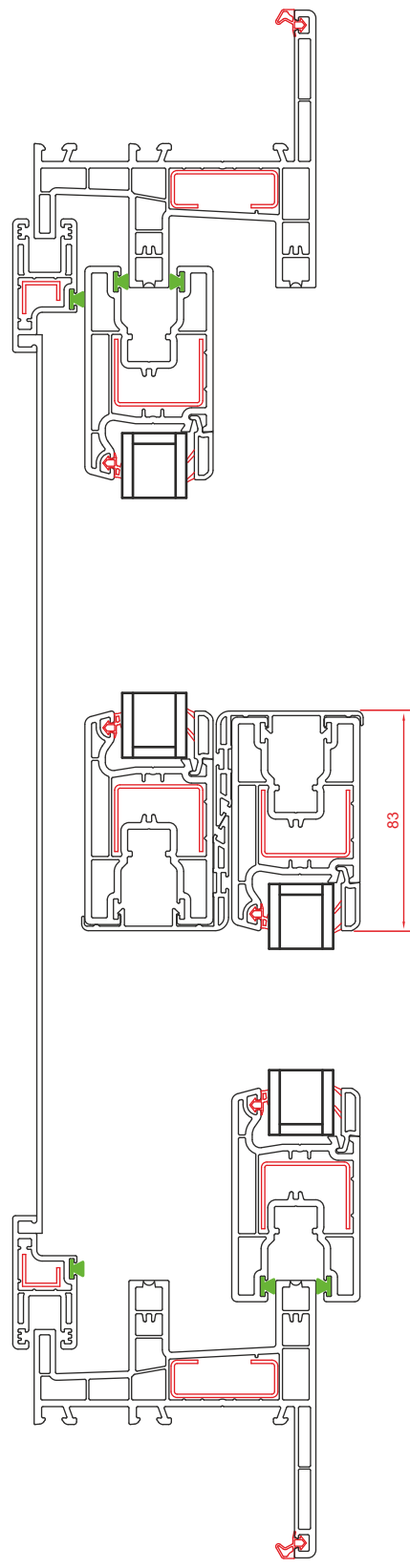


B-B

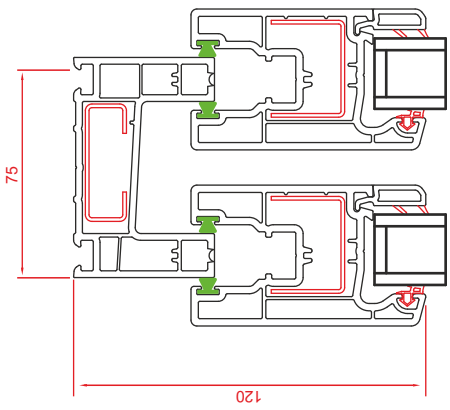
A ve B ölçüleri, pervaz haric, kasanın dıştan dış ölçüleridir.



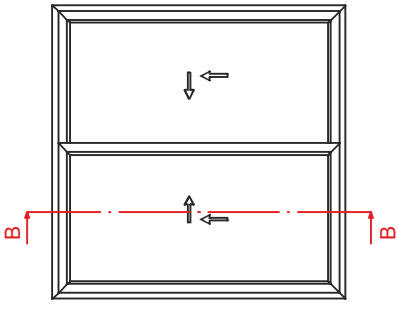
A-A



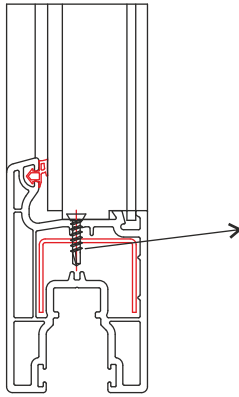
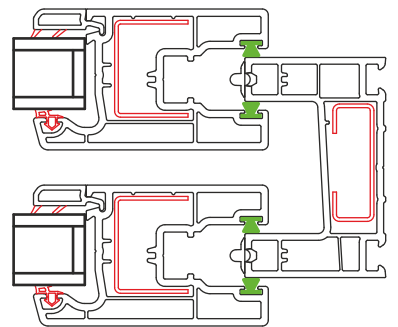
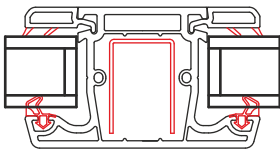
SÜRME SİSTEMLERİ 70-75



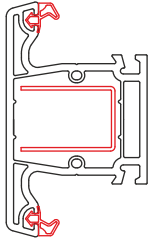
Kanat İçi Orta Kayıt Uygulaması



B-B



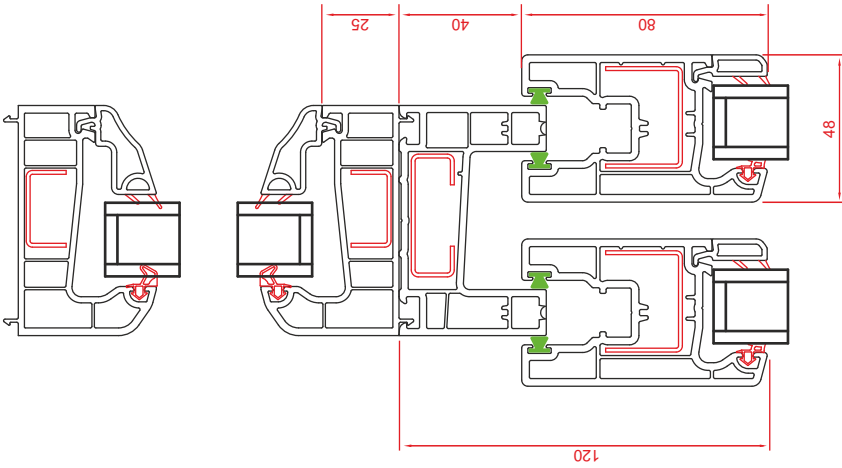
3,9 x 22 mm matkap uçlu vida



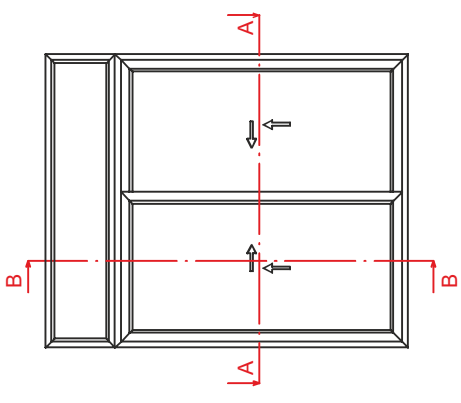
Pencere Kesitleri

Kanat içi orta kayıt içerisinde bulunan vida delikleri sayesinde bağlantı takozu kullanılmadan kanat ile birleştirilmesi sağlanabilir.

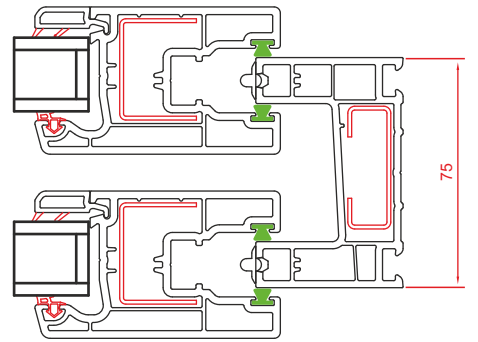
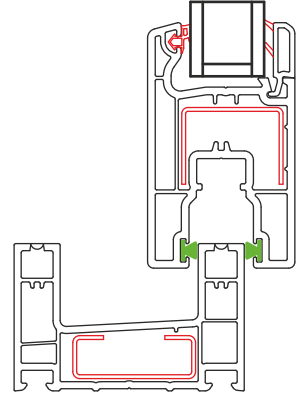
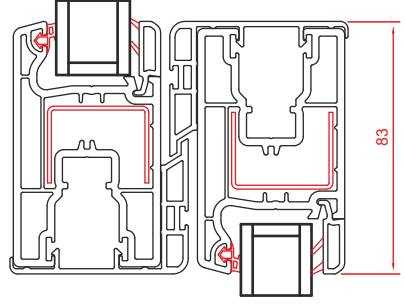
75 Sürme Fix Uygulaması



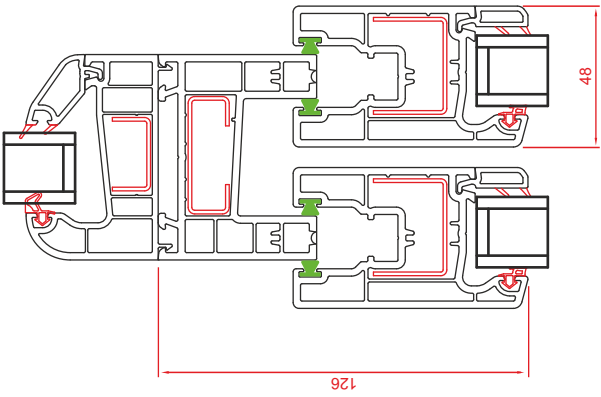
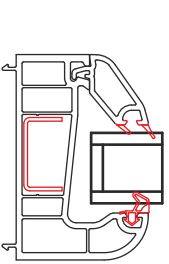
B-B



A-A

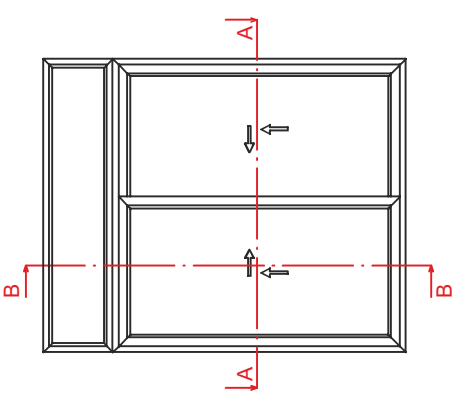


SÜRME SİSTEMLERİ 70-75

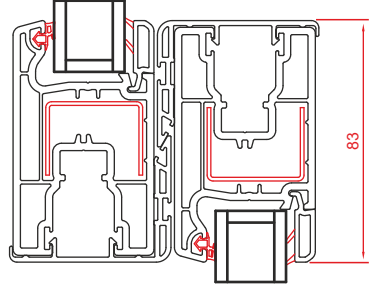
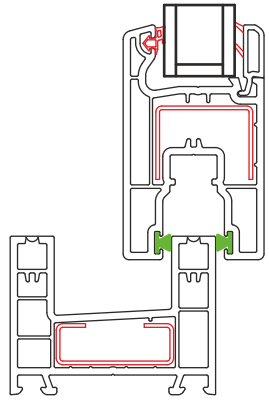
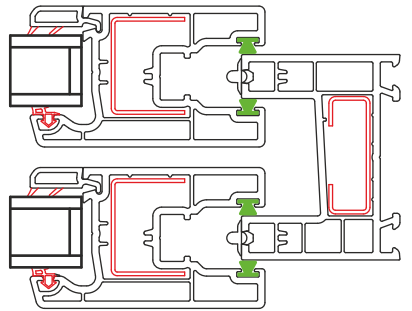


B-B

70 Sürme Fix Uygulaması

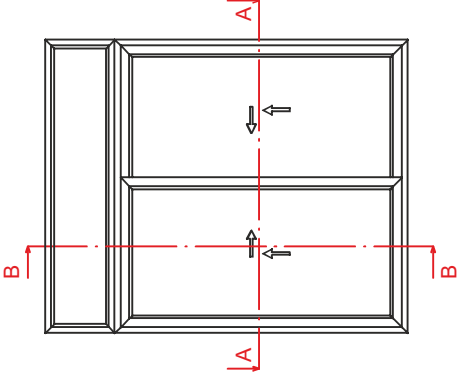
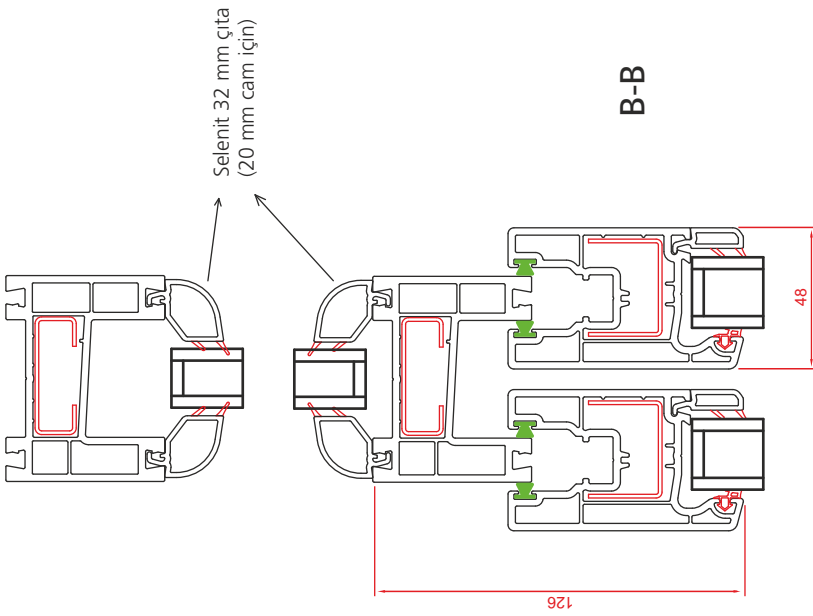


A-A

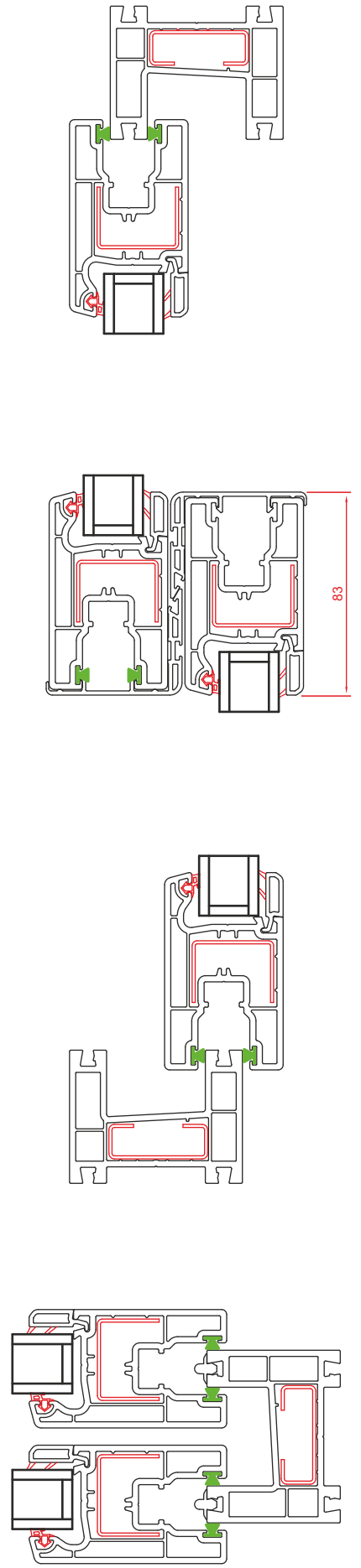


Pencere Kesitleri

Sürme 70 Kasalı Orta Kayıt Uygulaması



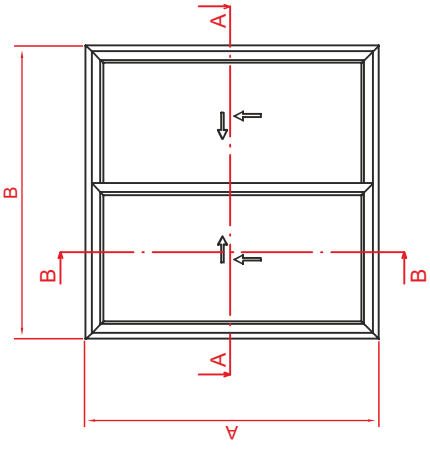
A-A



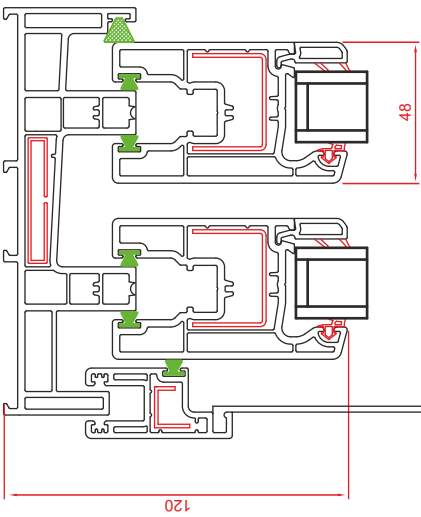
SÜRME SİSTEMLERİ 70-75

Pencere Kesitleri

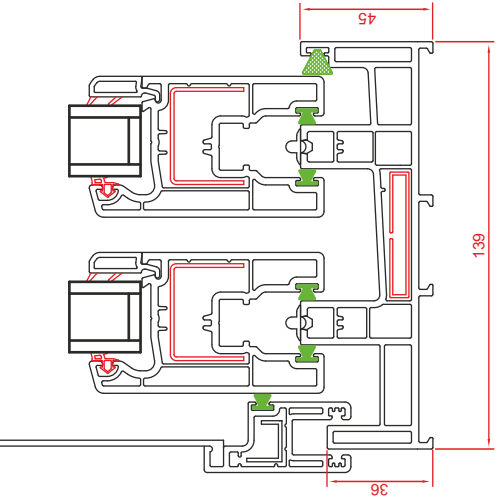
Sürme 75 Yalıtımlı Kasa Uygulaması



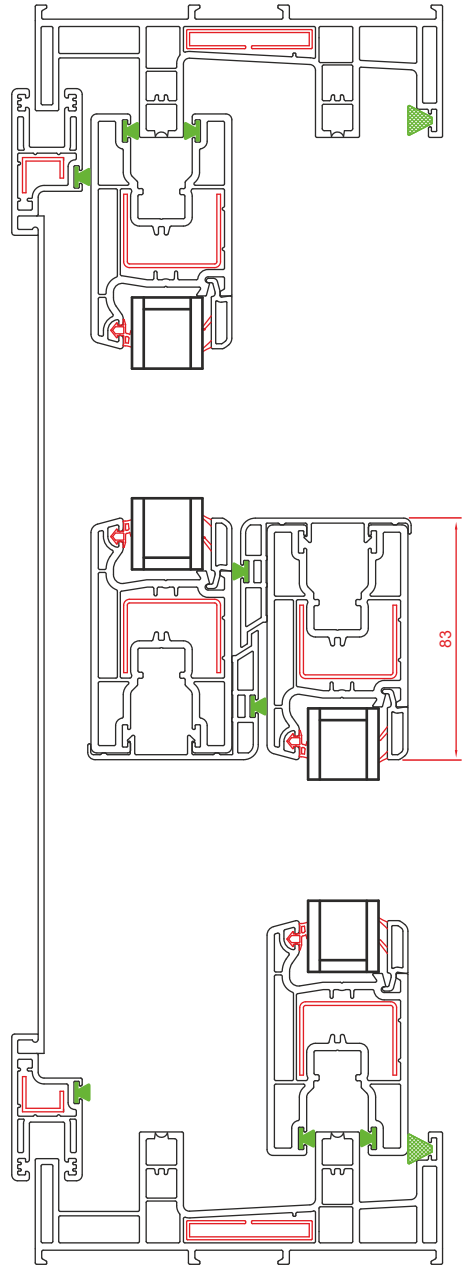
Kanat Kesim Ölçüsü	Dikey		Yatay	
	Ölçü (mm)	Ad.	Ölçü (mm)	Ad.
A-68	A-68	4	(B/2)+8	4



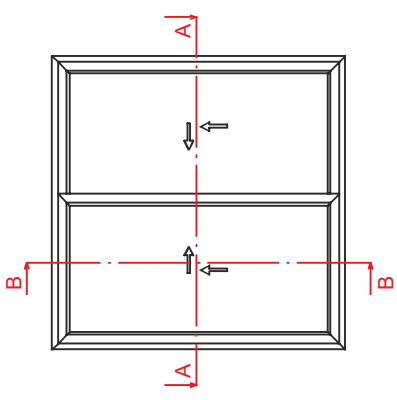
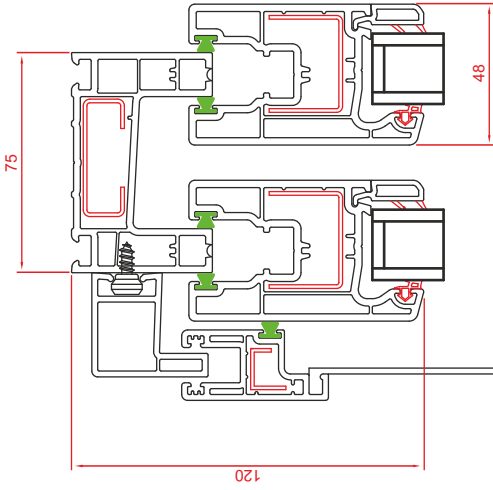
B-B



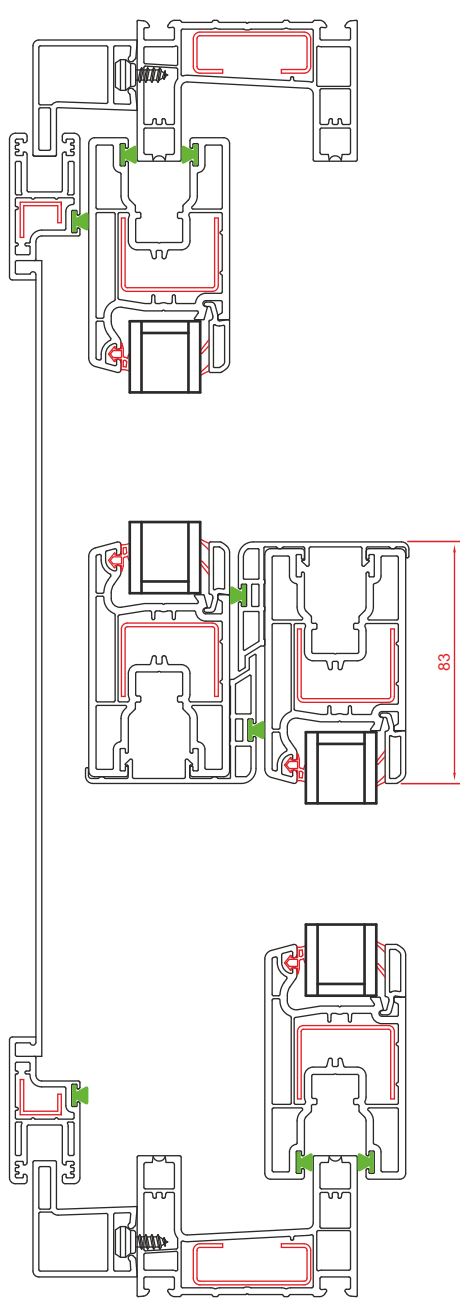
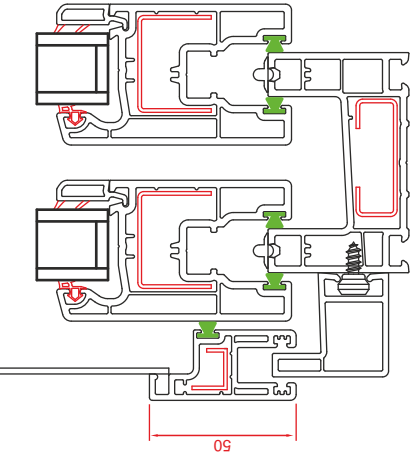
A-A



Sineklik Kasa Uygulaması

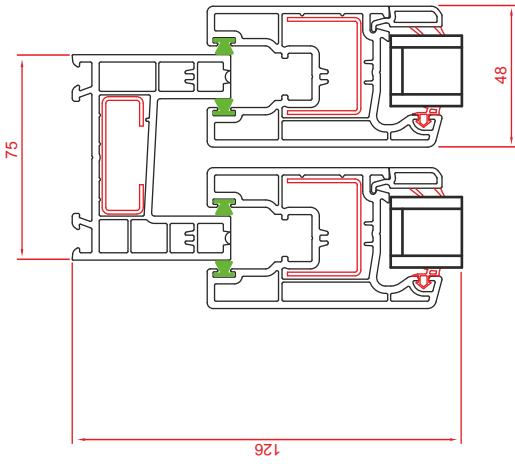


B-B

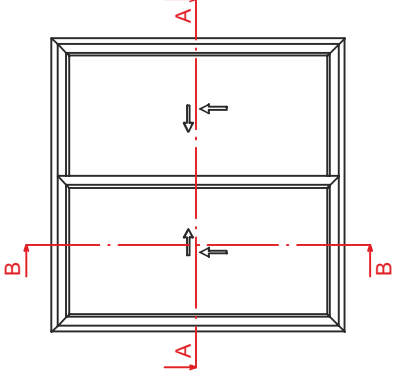


SÜRME SİSTEMLERİ 70-75

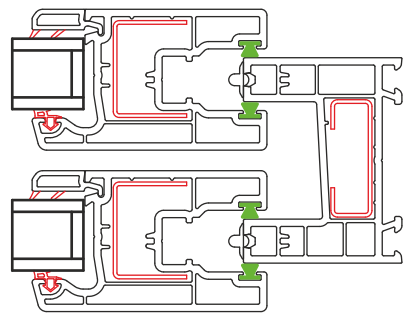
Sürme 70 Alüminyum Kanat Kapama Uygulaması



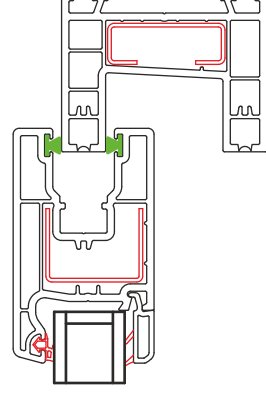
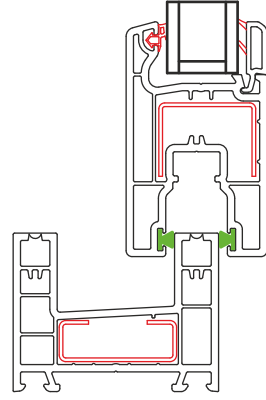
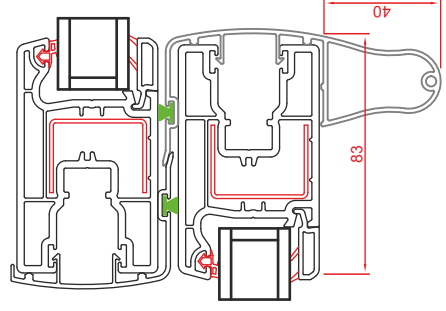
B-B



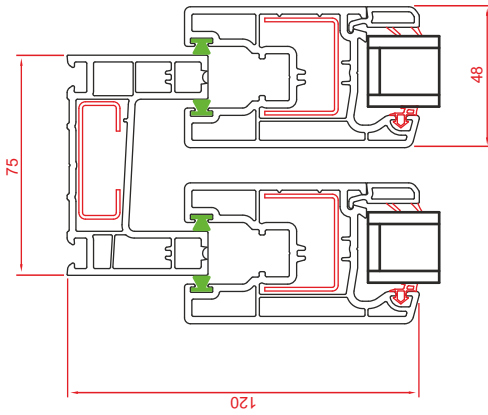
Pencere Kesitleri



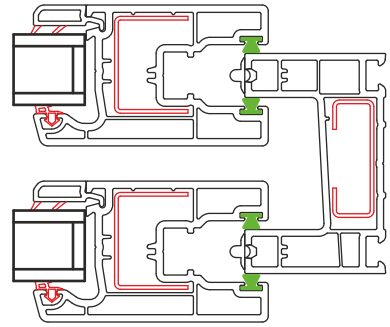
A-A



SÜRME SİSTEMLERİ 70-75

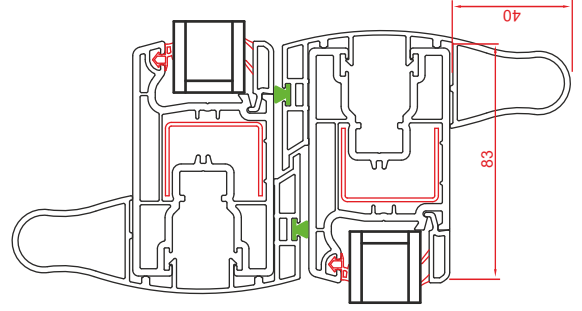
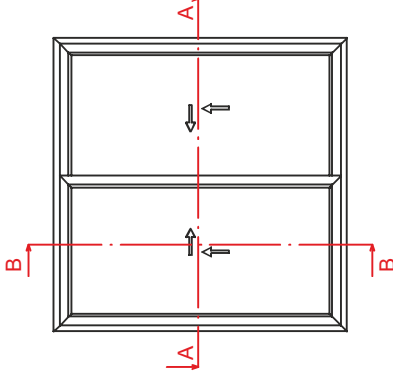


B-B

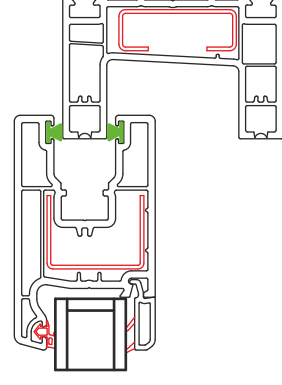
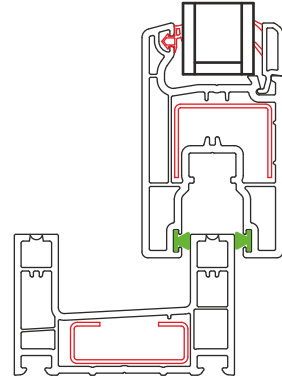


Sürme 75 Alüminyum Kanat Kapama Uygulaması

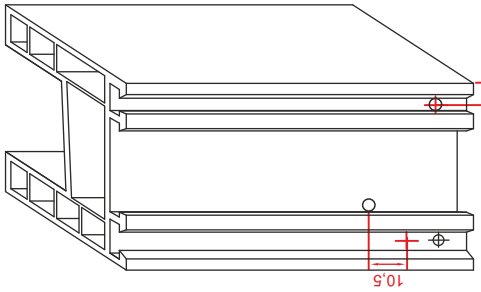
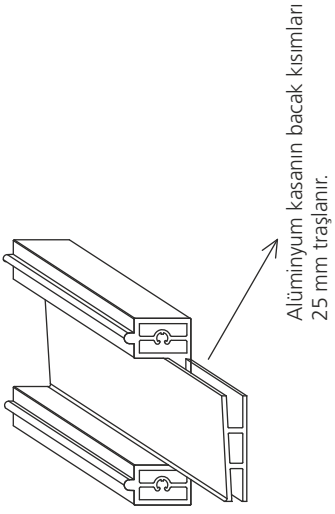
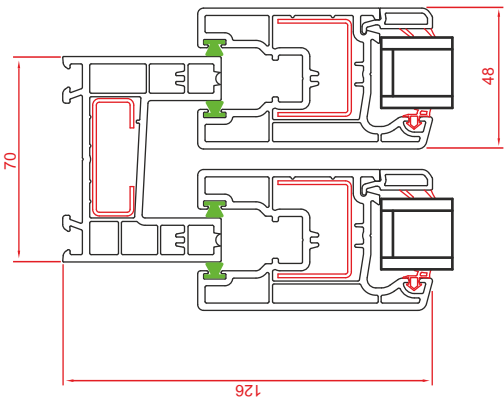
Pencere Kesitleri



A-A

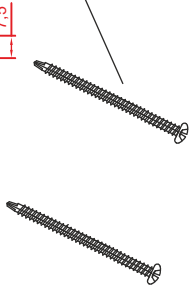


Sürme 7o Alüminyum Kasa Uygulaması

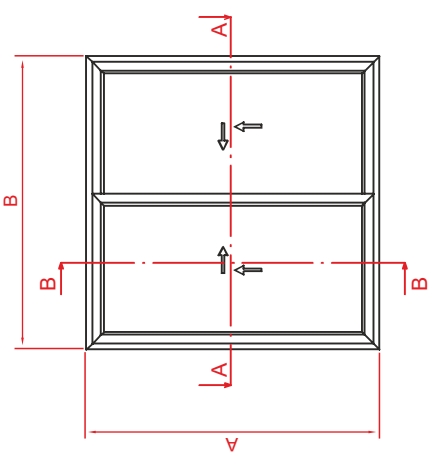


B-B

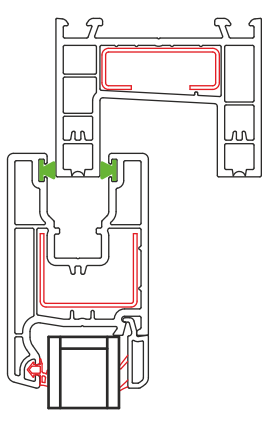
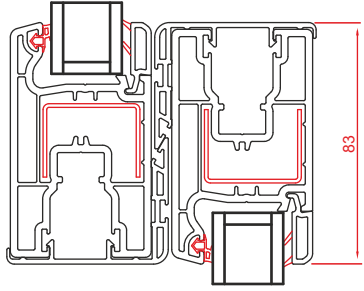
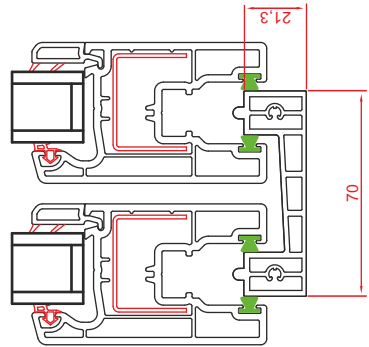
4,2x60 mm ölçüsünde matkap uçlu vida ile kasa sırtından alüminyum kasa vida yuvalarına vida atılarak birleştirme sağlanır.



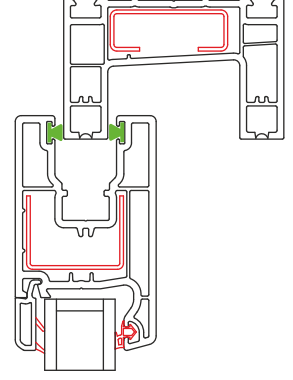
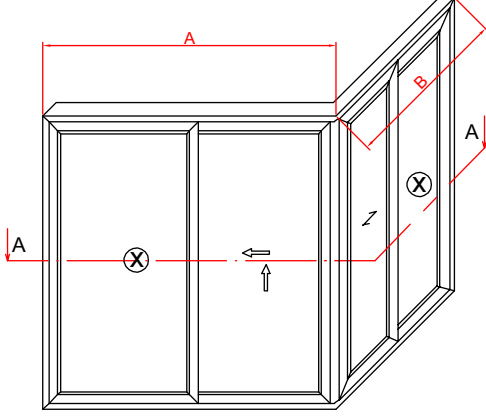
A-A



Kanat Kesim Ölçüsü	Dikey		Yatay	
	Ölçü (mm)	Ad.	Ölçü (mm)	Ad.
A-53	4	4	B/2	4



Sürme Alüminyum Köşe Dönüş Profil Uygulaması

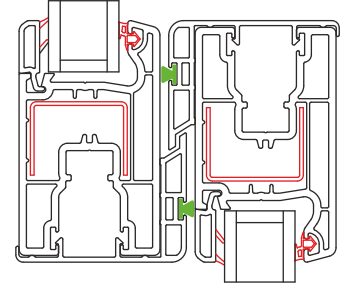


75 Sürme Kasa İçin

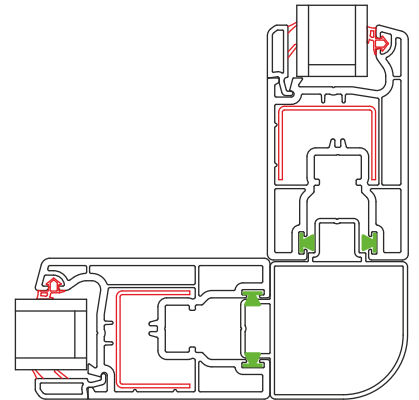
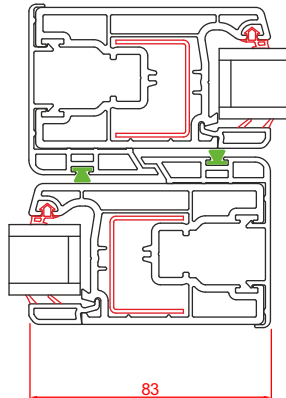
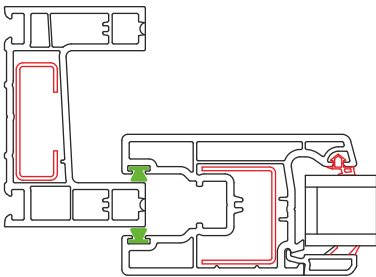
	Dikey		Yatay	
	Ölçü (mm)	Adet	Ölçü (mm)	Adet
Kanat Kesim Ölçüsü	A-74	8	(B/2)+2	8

70 Sürme Kasa İçin

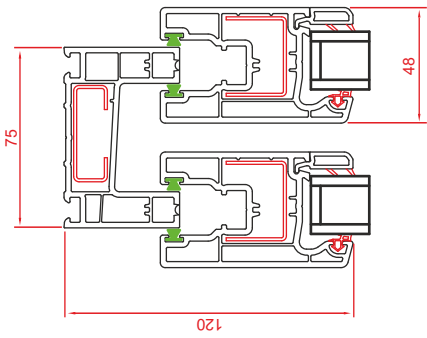
	Dikey		Yatay	
	Ölçü (mm)	Adet	Ölçü (mm)	Adet
Kanat Kesim Ölçüsü	A-86	8	(B/2)-1,5	8



A-A



Sürme Kanat Arası Adaptör Uygulaması



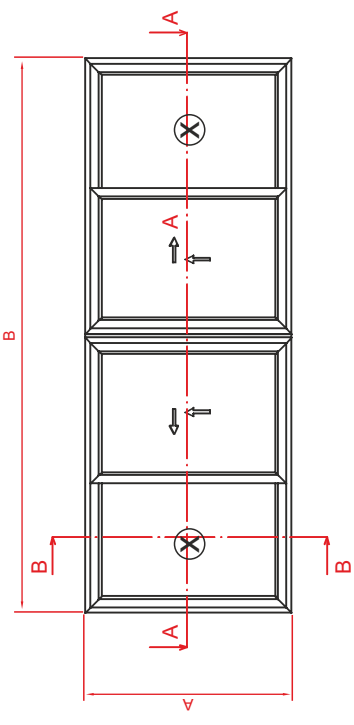
Sürme 75 Kasa İçin

Kanat Kesim Ölçüsü	Dikey		Yatay	
	Ölçü (mm)	Ad.	Ölçü (mm)	Ad.
A-74	8	8	(B/4)+23	8

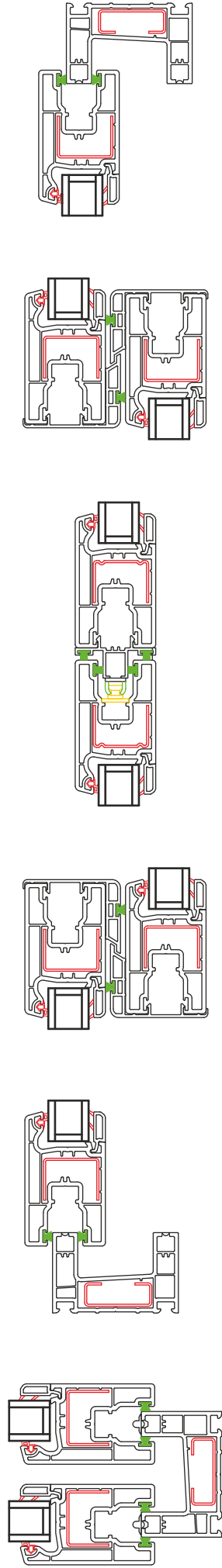
Sürme 70 Kasa İçin

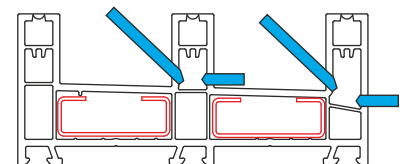
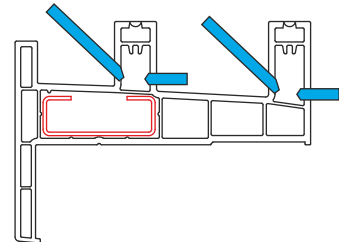
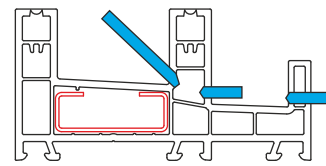
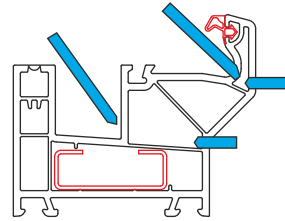
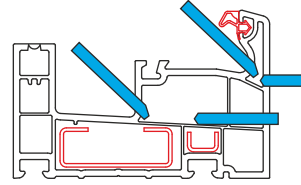
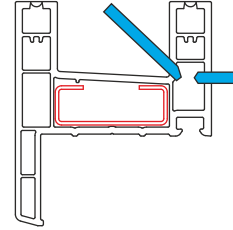
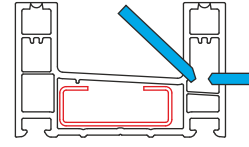
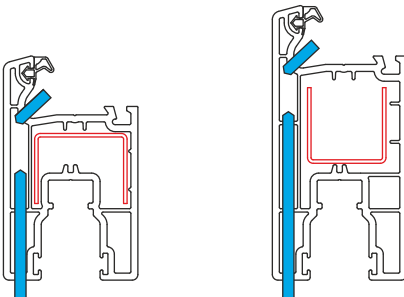
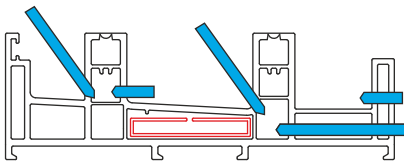
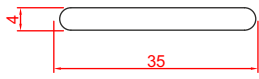
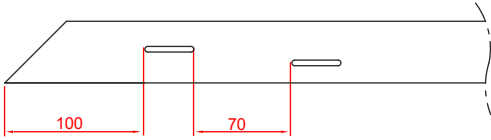
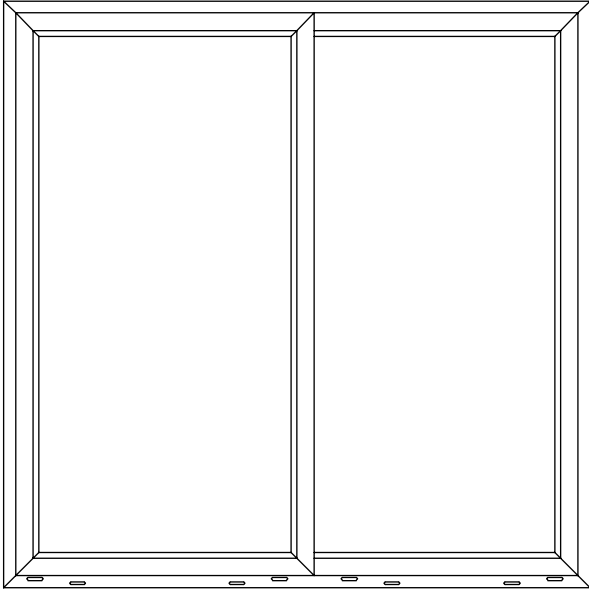
Kanat Kesim Ölçüsü	Dikey		Yatay	
	Ölçü (mm)	Ad.	Ölçü (mm)	Ad.
A-86	8	8	(B/4)+20	8

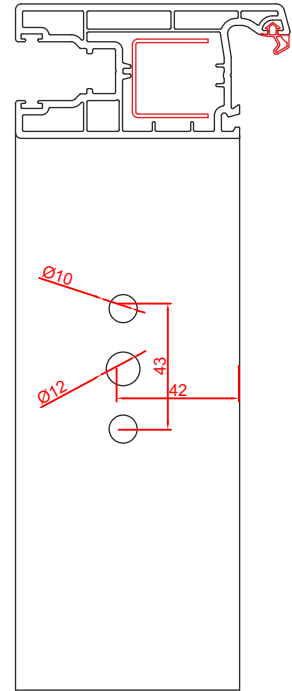
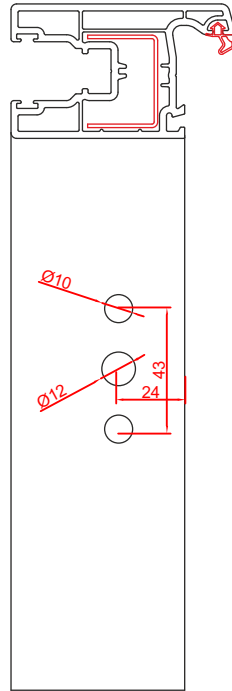
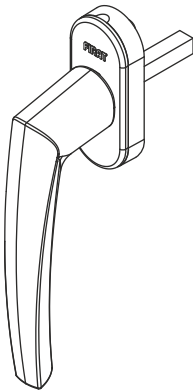
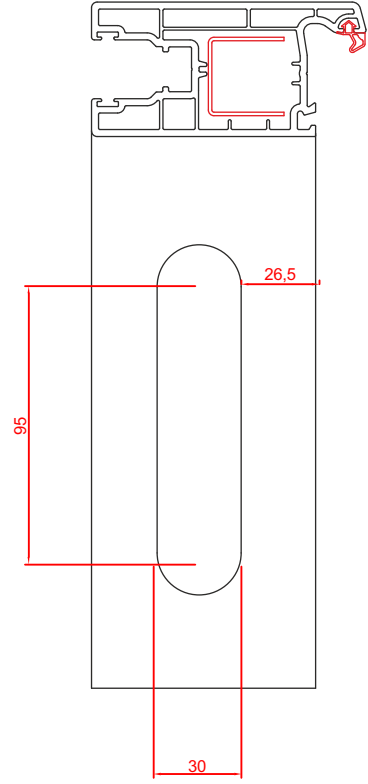
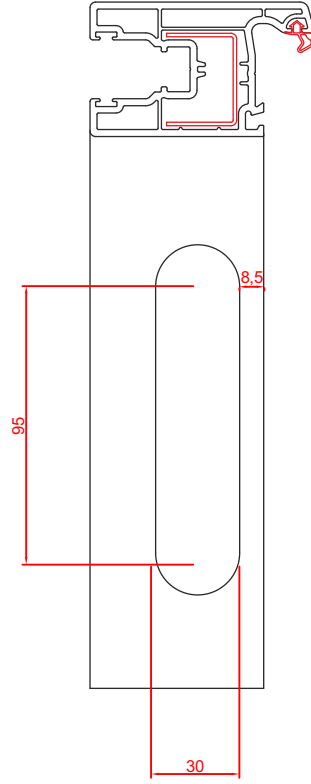
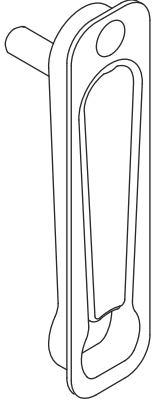
B-B



A-A

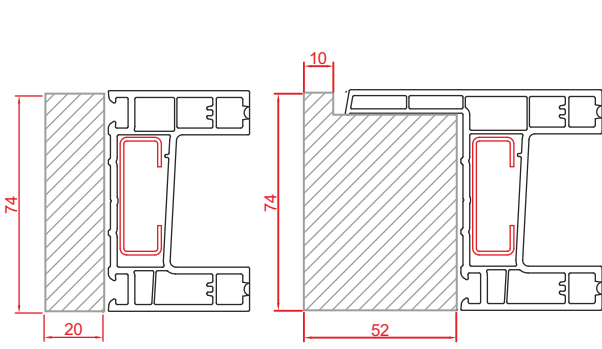




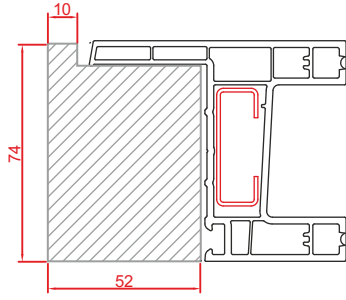


1. Profil kesim açısı tam 45° olmalıdır. Aksi taktide kaynak olacak yüzeyler birbirini tam olarak karşılayamadığı için kaynak zafiyeti oluşacaktır.
2. Kaynak makinesi pleyt yüzeyleri düzgün ve terazide olmalıdır.
3. Rezistans teflonları temiz olmalı ve yırtık olmamalıdır.
4. Kaynak yüzeylerinde profil talaşları olmamalı ve yüzeyler temiz olmalıdır.
5. Kaynak rezistans sıcaklığı 230 - 250 °C aralığında olmalıdır.
6. Kaynak süresi 25 sn, soğutma süresi 25 sn. olmalıdır.
7. Dikey piston baskıları 6 bar, eritme baskısı (arada rezistans varken) 3 bar, kaynak baskısı 6 bar olmalıdır.

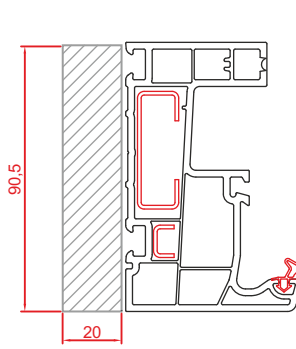
Standartlara uygun bir kaynak işlemi yapılabilmesi için aşağıda belirtilen kaynak dayama kalıplarının kaynak işlemi esnasında kullanılması gerekmektedir;



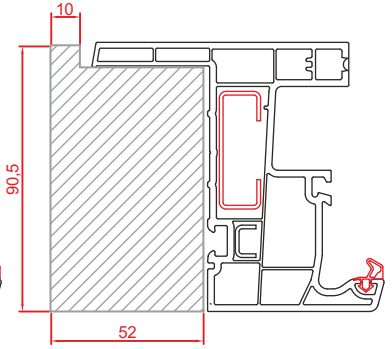
75 Sürme Kasa



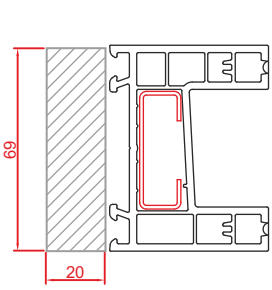
75 Sürme Pervazlı Kasa



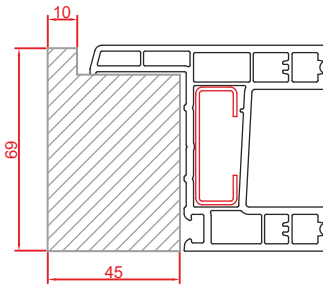
75 Sürme Kayıtlı Kasa



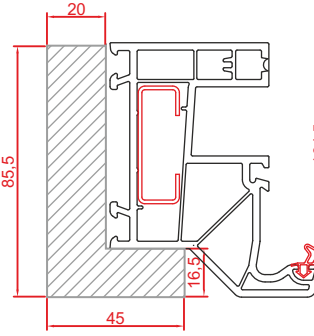
75 Sürme Kayıtlı Pervazlı Kasa



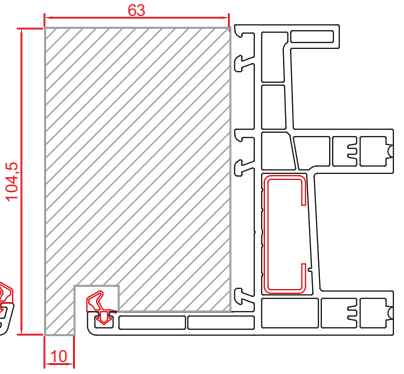
70 Sürme Kasa



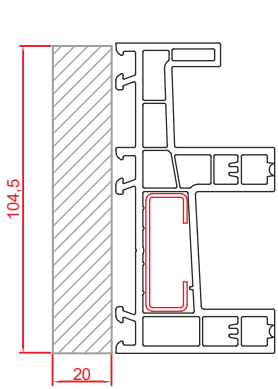
70 Sürme Pervazlı Kasa



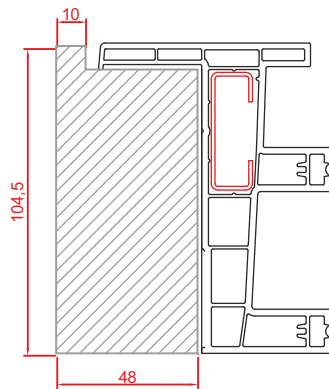
70 Sürme Kayıtlı Kasa



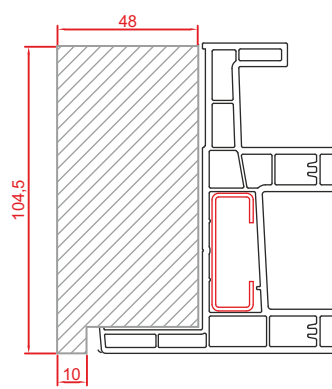
50 mm Dıştan Sineklikli Pervazlı Kasa



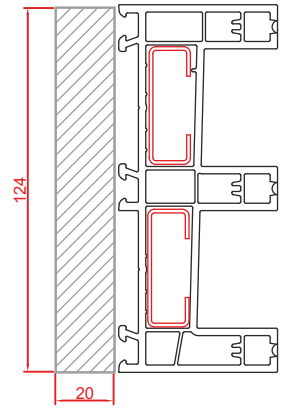
70 Sürme Sineklikli Kasa



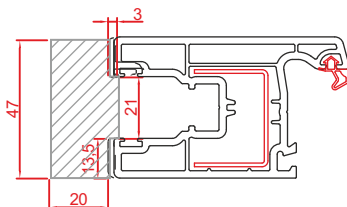
70 İçten Sineklikli Pervazlı Kasa



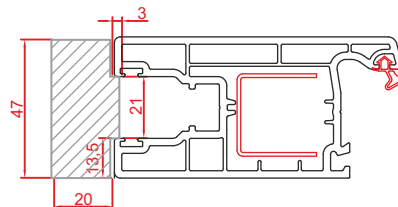
70 Dıştan Sineklikli Pervazlı Kasa



Üçlü Sürme Kasa



Sürme Kanat



Sürme Kapı Kanat

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