

TEHNIČKI KATALOG / TECHNICAL CATALOGUE / ТЕХНИЧЕСКИЙ КАТАЛОГ

aluminijumski sistemi za prozore i vrata
aluminium systems for doors and windows
алюминиевые системы для окон и дверей

DESIGNED AND MANUFACTURED BY TEHNOMARKET

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pouzdan partner u svetu aluminijuma



TEHNOMARKET posluje više od dvadeset godina u gradu Pančevu, kao kompanija specijalizovana za aluminijumske konstrukcije sa primenom u građevinarstvu. Dugogodišnje iskustvo, najpre u proizvodnji prozora i vrata, a zatim i ostakljenih fasada, pretočeno je tokom vremena u rad na dizajnu i proizvodnji sistema aluminijumskih profila različite namene. Pokretanjem prvog privatnog pogona za ekstrudiranje aluminijumskih profila 2002. godine u Srbiji, TEHNOMARKET započinje novo razdoblje u svom radu, povećavajući obim svog poslovanja i pozicionirajući se u regionu kao značajan industrijski proizvođač u aluminijumskoj branši.

Sistemi koje TEHNOMARKET razvija i nudi na tržištu, namenjeni su na prvom mestu izradi prozora i vrata, ostakljenih fasada, kliznih elemenata, neprobojnih konstrukcija, kao i podkonstrukcije različitih fasadnih obloga. Najnovije i trenutno aktuelne serije proizvoda nastale su primenom novih tehnologija i tehničkih rešenja sa ciljem da zadovolje sve zahtevnije prohteve tržišta u pogledu energetske efikasnosti i zaštite životne sredine.

Pored sistemskih i profila standardne geometrije u pogonu za ekstrudiranje proizvode se i profili posebnih namena, za poznate kupce, po porudžbini, koji dalje pronalaze primenu u velikom broju privrednih grana od auto-industrije, saobraćajne signalizacije, elektro-industrije, proizvodnje nameštaja, telekomunikacija, advetajzinga...

For more than 20 years, TEHNOMARKET has specialized in aluminium constructions that caters to the building and construction industry needs for more than 20 years from their Pančevo-based facilities. Our experience, gained from many years of doors, windows and glazed curtain walls manufacturing successfully transferred to design and development of modern aluminium profile systems for different purposes. By starting a first privately owned aluminium extrusion factory in Serbia in 2002, TEHNOMARKET starts a new chapter, drastically increasing product range and volume and positioning itself as one of the major regional manufacturers of aluminium products.

Systems that TEHNOMARKET develops and offers are foremost meant for manufacturing of windows and doors, glazed curtain walls, sliding elements and bulletproof constructions, as well as substructures for various types of ventilated facades. Our latest lines of products were created with state of the art technologies and technical solutions in order to comply with increasingly demanding energy efficiency and environmental protection standards and regulations.

Beside system and standard dimensioned profiles, a variety of custom designed profiles is extruded for known client and according to their technical drawings. These special profiles are widely used in number of different industrial areas, such as automotive, signage, furniture, telecommunication, electrical and advertising industry...

TEHNOMARKET работает более двадцати лет в городе Панчево, как компания, специализированная для алюминиевых конструкций, которые применяются в строительстве. Многолетний опыт, прежде всего в производстве окон и дверей, а затем остекленных фасадов, с временем преобразованно в работу на проектирование и производство алюминиевых профилей для различных целей. Запуском первого частного цеха для экструзии алюминиевых профилей в 2002 году в Сербии, ТЕХНОМАРКЕТ начинает новый период в своей работе, увеличивая объем своей деятельности и позиционирует себя как значительный промышленный производитель в алюминиевой отрасли в регионе.

Системы, которые ТЕХНОМАРКЕТ разрабатывает и предлагает на рынке, предназначены в первую очередь для изготовления окон и дверей, остекленных фасадов, скользящих элементов, непробиваемых конструкций, как и подконструкций различных фасадных оболочек. Самые новые и в настоящий момент актуальные серии продуктов, настали как результат применения новых технологий и технических решений с целью удовлетворения жестким требованиям рынка с точки зрения энергоэффективности и охраны окружающей среды.

Кроме систематических и профилей стандартной геометрии стандартных профилей, в цехе по экструдированию, производятся и профили специального назначения, для известных клиентов, по заказам, которые дальше находят применение во многих отраслях: как автомобильной промышленности, дорожной сигнализации, электротехнической промышленности, производство мебели, телекоммуникации, рекламы...

Stalno praćenje trendova, saradnja sa kupcima i tehnička podrška klijentima tokom dogodišnjeg poslovanja izdvojili su se kao osnovni principi rada kompanije TEHNOMARKET. Ujedno, konstantna saradnja sa domaćim i evropskim sertifikacionim kućama doprinosi razvoju i uvođenju inovacija u sve aspekte organizacije i proizvodnje firme, a ISO 9001 sertifikacija, koju kompanija poseduje, to i zvanično potvrđuje.

Pozicija sedišta firme i fabrike za ekstruziju nalazi se 17 kilometara od centra Beograda i svega nekoliko kilometara od železničkog kargo-terminala i velike rečne luke na Dunavu, kao i nepunih 30 kilometara od međunarodnog aerodroma „Nikola Tesla“ u Beogradu.

Ongoing trend monitoring, direct communication with clients and technical support have become defining principles of TEHNOMARKET's long term-business philosophy. At the same time, constant cooperation with domestic and European certification institutes further strengthens basic principles of research, development and ongoing innovation throughout all organisational and manufacturing segments of the company, which is confirmed by ISO 9001 certificate.

Company's headquarters and extrusion factory are conveniently located only 17 km from centre of Belgrade, Serbia's capitol, and just a few kilometers from rail cargo terminal and a major river port on Danube. Belgrade International airport "Nikola Tesla" is also less than 30 km away.

Постоянное наблюдение тенденций, сотрудничество с клиентами и техническая поддержка клиентам в течении долгосрочной деятельности, выделились как основной принцип работы компании ТЕХНОМАРКЕТ. В то же время, постоянное сотрудничество с отечественными и европейскими сертификационными компаниями, способствует развитию и введению инноваций во всех аспектах организации и производства компании, а сертификат ISO 9001, который компания имеет, это официально и подтверждает.

Место нахождения компании и завода для экструзии расположен в 17 километрах от центра г.Белграда и всего в нескольких километрах от железнодорожного грузового терминала и большого речного порта на реке Дунай, и меньше чем 30км от международного аэропорта «Никола Тесла» в г. Белграде.



Stalne promene na svetskom tržištu i sve kompleksniji zahtevi krajnjih korisnika, sa jasno izdvojenom potrebom za brzom proizvodnjom i izradom, ujedno i lakoćom i jednostavnošću u obradi, jasno su izdvojili aluminijum kao građevinski materijal budućnosti. Aluminijum kao najzastupljeniji od svih metala na Zemlji, našao je svoju primenu u skoro svim granama industrije i građevinarstva. Većina njegove mase na planeti se nalazi u obliku aluminosilikata. Sa svojom gustoćom od 2700kg/m^3 , oko tri puta je lakši od gvožđa i bakra, pa je iz tog razloga i dominantno prisutniji u lakim građevinskim konstrukcijama. Dobija se elektrolitičkim postupkom u specijalnim električnim pećima, u kojima temperature dostiže i 1000°C . Standardni procesi obrade aluminijuma kako bi se dobili krajnji proizvodi su ekstrudiranje, zavarivanje, toplo i hladno valjanje. U završnoj primeni najčešće se koristi sa površinskom zaštitom od koje su najviše zastupljene eloksaža (anodizacija) i plastifikacija (elektrostatska pulverizacija).

Kao neke od brojnih prednosti aluminijuma izdvajaju se:

- izuzetno lagan materijal, male gustine, stabilan je i ne opterećuje konstrukciju
- poseduje veliku mogućnost oblikovanja, pruža raznovrsnost oblika i široku mogućnost kombinovanja
- trajan je i postojan kao građevinska komponenta bez promena osobina tokom vremena
- reciklabilan, po isteku eksploatacije lako se topi i ponovo vraća u novi ciklus primene
- neotrovan je, ne šteti okolini, nema otrovna isparenja i nezapaljiv je
- ima mogućnost zavarivanja i ne varniči prilikom obrade
- dobar je provodnik toplote i električne energije
- otporan je na koroziju usled atmosferskih uticaja, u sirovom stanju oblaže se tankim slojem oksida
- dopadljivo je srebrnasto-sjajne nijanse, dekorativnog je izgleda i pruža velike mogućnosti kod odabira boje površinske zaštite
- lak je i jednostavan za održavanje i u eksterijeru i u enterijeru

Constant shifts in global market and more complex demands by clients, with distinctly outlined need for fast manufacturing and assembly, followed by simple machining, have clearly selected aluminium as building material of the future. Aluminium, the most common metal on Earth, has found its use in almost all segments of industry and construction. The most of it's mass on planet is found in shape of aluminosilicate. With it's density of 2700kg/m^3 , it is about three times lighter than iron and copper, and therefore far more present in light building constructions. Aluminium is acquired in special electrolytic process conducted in special electric ovens that generate temperatures up to 1000°C . Further aluminium processing into final products includes extrusion, welding, hot and cold rolling. For finished products, aluminium is usually used with anodized or powder coated surface.

Here are some of aluminium's numerous advantages:

- extreme lightweight, low density, stable and it does not present an unnecessary burden for structure
- easily machinable into number of different shapes, optimal for numerous applications
- long lasting and stable as a construction component without change in properties over time
- completely recyclable, easily re-inserted into manufacturing cycle
- it is not toxic, flammable, evaporable and it is safe for the environment
- aluminium can be welded and it does not produce sparks during machining
- good conductor of heat and electricity
- corrosion resistant, covered with thin oxide layer when raw
- it has appealing natural silver shade and offers great flexibility when choosing surface treatment colors
- simple and easy to maintain, both in interior and exterior

Постоянные изменения на мировом рынке и все более сложные требования конечных пользователей, с четко выделенной необходимостью быстрого производства и изготовления, а также легкость и простота в обработке, четко выделили алюминий в качестве строительного материала будущего. Алюминий, как наиболее распространенный из всех металлов на Земле, нашел свое применение практически во всех отраслях промышленности и строительства. Большое количество его массы в мире находится в форме алюмосиликата. С плотностью 2700kgm^3 , алюминий примерно в три раза легче, чем железо и медь, и по этой причине преобладающий материал в легких строительных конструкциях. Алюминий получают электролитической обработкой в специальных электрических печах, где температура достигает и 1000°C . Стандартные процессы обработки алюминия для получения конечных продуктов являются экструзия, сварка, горячая и холодная прокатка. В заключительном применении обычно используется с поверхностной защитой, которая наиболее представлена анодированием и пластичным покрытием (электростатическое распыление).

Некоторые из многих преимуществ алюминия являются:

- очень легкий материал, с низкой плотностью, стабильный и ненагружает конструкцию
- имеет большую возможность формообразования, предоставляет широкий спектр форм и возможность различных комбинаций
- долговечен и стабильный как строительный компонент не изменяя характеристик в течении долгого времени
- он может быть переработан, в конце эксплуатации его можно легко расплавить, а затем обратно применить в новом цикле
- нетоксичен, экологически чист, нет токсичных испарений и не воспламеняется
- имеет возможность свариваться и не искрит при обработке
- хороший проводник тепло и электроэнергии
- обладает высокой устойчивостью к коррозии при атмосферных воздействиях окружающей среды, в сыром виде покрывается тонким слоем оксида
- привлекательно серебристо-яркие оттенки, декоративного вида и обеспечивает большие возможности при выборе красок поверхностной защиты
- легкий и простой в обслуживании экстерьера и интерьера



Sistemi iz grupe LINEAL dizajnirani su na prvom mestu sa ciljem da odgovore zahtevu moderne arhitekture za čistim i jednostavnim linijama gotovih proizvoda, a da u isto vreme ispoštuju nove i poboljšane energetske standarde u građevinarstvu. Osnovna namena ove grupe sistema je izrada aluminijumskih prozora i vrata u svim varijacijama oblika i namene. LINEAL broji šest različitih sistema podeljenih u dve konstruktivne grupe:

A. aluminijum sa termo-prekidom

• ST 54

sa ugradnom dubinom štoka od 54mm

• PLUS 62

sa ugradnom dubinom štoka od 62mm

• THERM 77

sa ugradnom dubinom štoka od 77mm

B. aluminijum-drvo sa termo-prekidom

• W-ST 81

sa ugradnom dubinom štoka od 81mm

• W-PLUS 89

sa ugradnom dubinom štoka od 89mm

• W-THERM 104

sa ugradnom dubinom štoka od 104mm

Systems from LINEAL series are designed as an answer to requirements of modern architecture for clean and minimalist forms of finished elements that, at the same time fulfill new and improved energy efficiency standards in construction industry. Sole purpose of these profile systems is manufacturing of highly energy efficient aluminium windows and doors for all purposes. LINEAL consists of six different systems divided into two main groups:

A. aluminium with thermal break

• ST 54

with frame width of 54mm

• PLUS 62

with frame width of 62mm

• THERM 77

with frame width of 77mm

B. aluminium-wood with thermal break

• W-ST 81

with frame width of 81mm

• W-PLUS 89

with frame width of 89mm

• W-THERM 104

with frame width of 104mm

Системы из группы LINEAL разработаны в первую очередь с целью, чтобы ответить на запрос современной архитектуры с четкими и простыми линиями готовой продукции, в то же время, чтобы соответствовали новым и улучшенным энергетическим стандартам в строительстве. Основная цель групповой системы является производство алюминиевых окон и дверей во всех вариантах, формах и назначений. LINEAL состоит из шести различных систем, которые разделены на две структурные группы:

A. алюминиевые профили с термическим разрывом

• ST 54

с монтажной глубиной косяка от 54мм

• PLUS 62

с монтажной глубиной косяка от 62мм

• THERM 77

с монтажной глубиной косяка от 77мм

B. алюминий - дерево профили с термическим разрывом

• W-ST 81

с монтажной глубиной косяка от 81мм

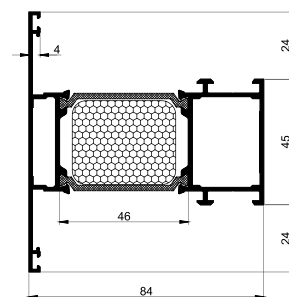
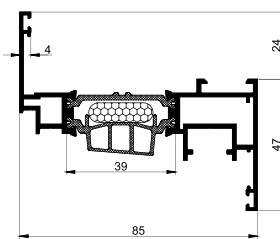
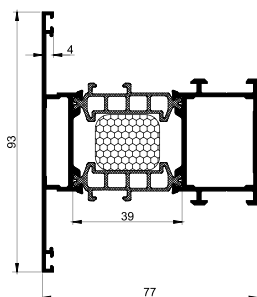
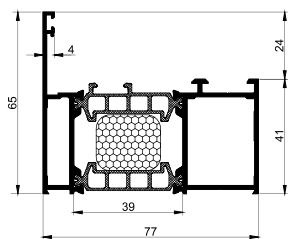
• W-PLUS 89

с монтажной глубиной косяка от 89мм

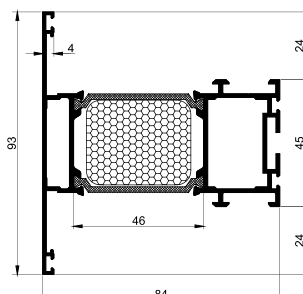
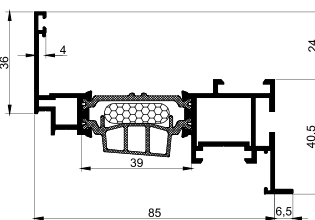
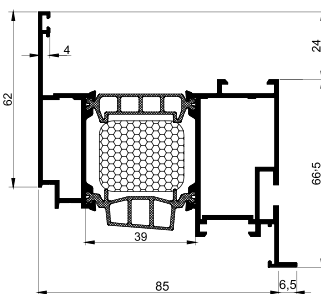
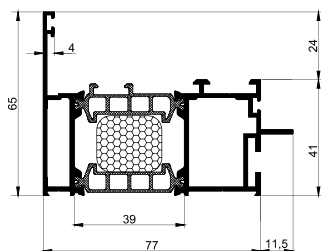
• W-THERM 104

с монтажной глубиной косяка от 104мм

A



B





linija novih standarda
u aluminijumu

line of new standards
in aluminium

линия новых стандартов
в алюминии

Sistemi iz gupe A nude dodatnu mogućnost korisnicima u izboru dva različita tipa krila, prvo sa EURO 1 žlebom za standardni aluminijumski okov i drugo za EURO 16mm žlebom za PVC okov. Za sisteme iz grupe B, zbog specifičnosti u spoju dva materijala, dizajniran je poseban okov za opremanje gotovih prozorskih elemenata.

Kao najbitnije karakteristike LINEAL sistema izdvajaju se:

- širok izbor sistema sa različitim ugradnim dubinama štoka od 54 do 104mm
- poboljšane termičke karakteristike u cilju bolje izolacije objekata. Sistem THERM 77 sa koeficijentom prolaza toplote $U_w=0,93W/m^2K$ i sistem W-THERM 104 sa $U_w=0,87W/m^2K$
- jednostavnost i modularnost profila i pratećeg pribora za lakšu proizvodnju uz idealan odnos cene i kvaliteta
- optimalan odnos statičke nosivosti aluminijumskih profila i širine termo prekida (poliamidi širina 16, 24 i 39mm)
- dizajn ravnih i glatkih površina krila i štoka sa ukupnom zbirnom visinom u opsegu od 106 do 186mm
- mogućnost integrisanja različitih dubina ispune u vidu stakla i panela od 8 do 55mm
- svi elementi i materijali bezbedni su za stanovanje i upotrebu, pa su tim i sistemi verifikovani CE znakom
- potvrđeni parametri izolovanosti na vetar i vazduh, vodu i zvuk
- omogućena ugradnja sigurnosnih protivprovalnih okova klase WK1 i WK2 (za aluminijumske sisteme)
- za opcije sistema aluminijum-drvo unutrašnja obloga je od više vrsta prirodnog drveta u preko 20 različitih nijansi boja
- postojanje mogućnosti pravljenja „pasoša“ proizvoda za domaća i strana tržišta

Systems from group A offer additional option both EURO 1 for aluminium and EURO 16mm groove standards for PVC hardware are available.

A special hardware set is designed for aluminium wood systems in group B, because of highly specific nature of the two combined materials.

The most important LINEAL features are:

- wide array of different systems with frame widths from 54 up to 104mm
- improved thermal performance for more energy efficient buildings. Both THERM 77 with $U_w=0,93W/m^2K$ and W-THERM 104 $U_w=0,87W/m^2K$ systems are suitable for usage in low energy buildings
- simplicity and system modularity of profiles and accessories for simple manufacturing process and improved price/performance ratio
- optimal ratio between good static performance of aluminium profiles and polyamide stripes width (with 16, 24 and 39mm widths available)
- modern and minimalistic design of frame and sash with total combined height from 106 to 186mm
- support for different glass package widths ranging from 8mm to 55mm
- all system elements are safe for use in living and working areas, as confirmed by CE sign
- certified insulation performance against water, air, wind, sound and temperature
- optional installation of WK1 and WK2 safety hardware sets (for aluminium systems)
- aluminium-wood systems feature multiple options for high quality massive wood cladding available in more than 20 different colors
- option of making a „Product passport“ for domestic and foreign markets

Системы из группы А предлагают дополнительную возможность для пользователей в выборе двух различных типов створки, в первом с EURO 1, пазом для стандартных алюминиевых оков и во втором с EURO 16mm желобом для оков из PVC.

Для системы в группе В, в связи со специфическим соединением двух материалов, разработана отдельная окковка для оборудования готовых элементов окна.

Как наиболее важные характеристики LINEAL системы выделяются:

- большой выбор системы с различной монтажной глубиной косяка от 54 до 104mm
- Улучшение тепловых характеристик в целях лучшей изоляции объектов системы THERM 77 с коэффициентом теплопередачи $U_w = 0,93W/m^2K$ и системы W-THERM 104 с коэффициентом теплопередачи $U_w=0,87W/m^2K$ (декларированные как стандарты для низкоэнергетических зданий).
- простота и модульность профилей и аксессуаров для более легкое изготовление с идеальным соотношением цены и качества
- оптимальное соотношение статической грузоподъемности алюминиевых профилей и ширины термического разрыва (ширина полиамидов 16, 24 и 39mm).
- дизайн плоских и гладких поверхностей, створки и косяки с общей совокупной высотой от 106 до 186mm
- возможность интеграции различных глубин заполнением в форме стекла и панели от 8 до 55mm
- все элементы и материалы безопасны для проживания и использования, так что эти системы проверены и маркированы CE обозначением
- подтверждены параметры изоляции на ветер и воздух, воды и звука
- возможен монтаж противоворовских оковок систем типа WK1 и WK2 (для алюминиевых систем)
- для варианта системы алюминий-дерево, внутренняя облицовка от многих типов натурального дерева в более чем 20 различных цветовых оттенков
- существование возможности изготовления „паспорта“ продуктов для внутреннего и внешнего рынка

Uvod
Introduction
Введение

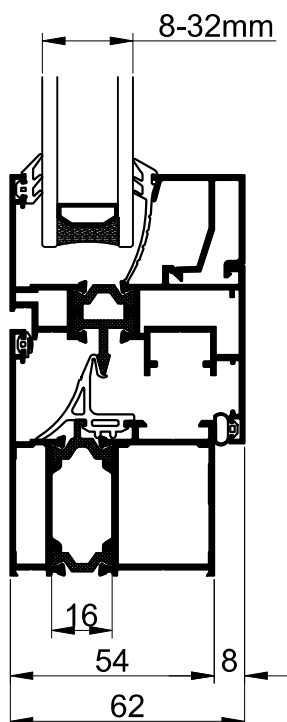


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*Uputstvo
Manual
Руководство*

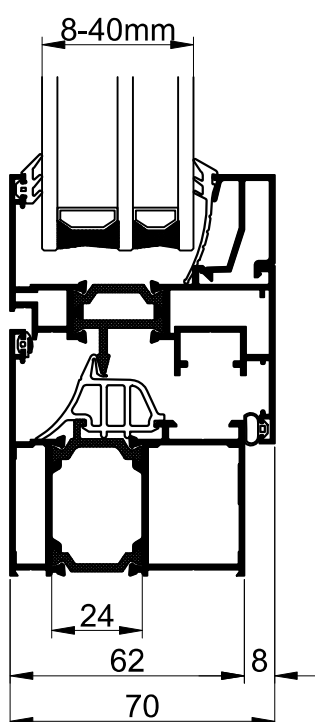


Sistem
System **ST 54**
Система



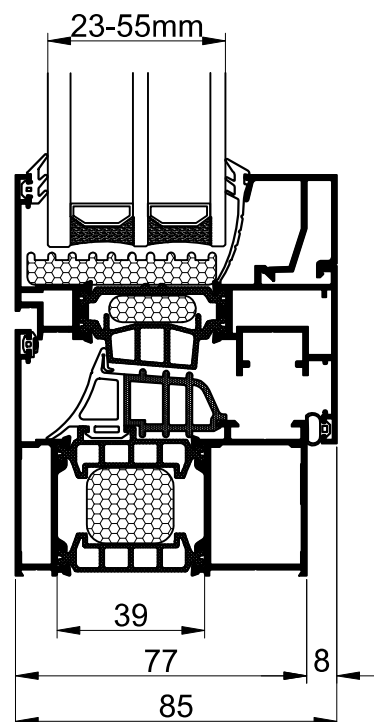
$U_f \sim 2,868 \text{ W/m}^2\text{K}$
 $U_w \sim 1,67 \text{ W/m}^2\text{K}$

Sistem
System **PLUS 62**
Система

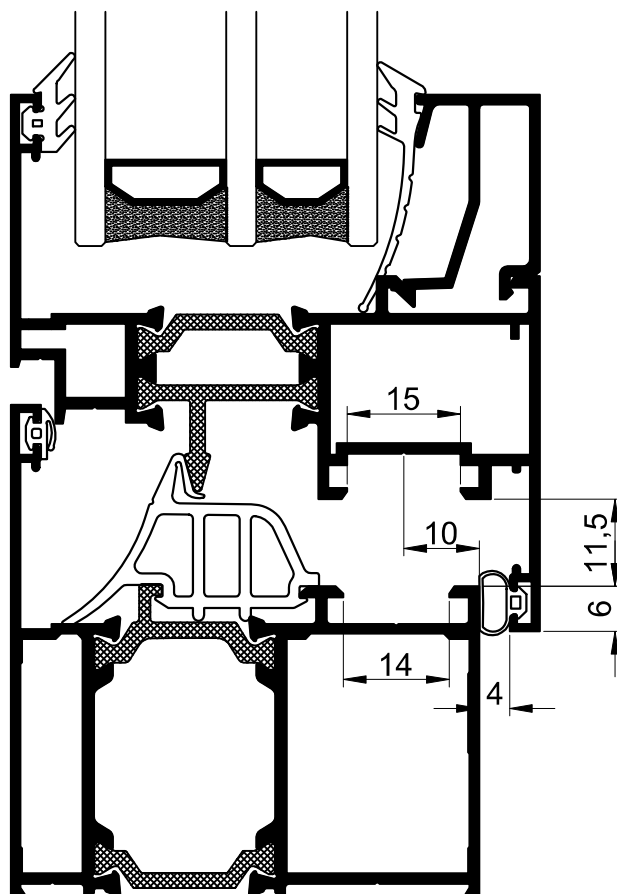


$U_f \sim 2,382 \text{ W/m}^2\text{K}$
 $U_w \sim 1,25 \text{ W/m}^2\text{K}$

Sistem
System **THERM 77**
Система



$U_f \sim 1,344 \text{ W/m}^2\text{K}$
 $U_w \sim 0,93 \text{ W/m}^2\text{K}$

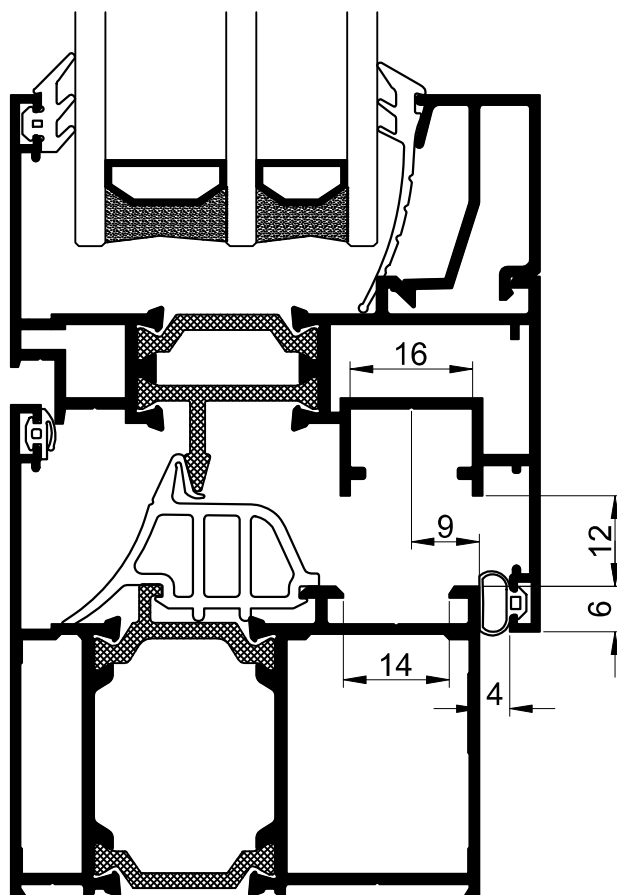


Žleb
Groove
Канавка

ALUMINIUM STANDARD

EURO 1

Giesse
Stublina
Fapim
Laaval
Eugen Notter
Roto
Sobinco
...

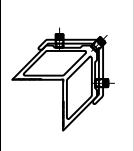
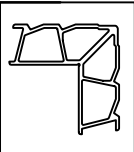
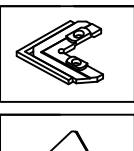
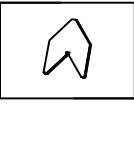
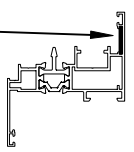
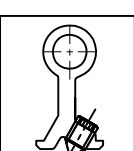
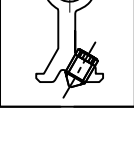
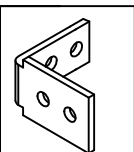


Žleb
Groove
Канавка

PVC STANDARD

EURO 16mm

G-U
Maco
Roto
Siegenia
AGB
Winkhaus
Vabis
...

Moment inercije Moment of inertia Момент инерции				Ugaona spojnica Corner joint Угловое соединение				Profili Profiles Профили		Oznaka Mark Марк	
ST 54											
	Oznaka Mark Марк	Opis Description Описание	cm ⁴ Ix Jy								
	kg/m`										
	501	Štok Frame	11,160	911	908	920					
	1,276	Рамка	3,440	925	923						
	502	Prečka u štoku T profile in frame	18,788		915						
	1,471	T профил в рамке	4,581		905						
	503	Prečka u krilu T profile in casement	18,730		915						
	1,482	T профил в створке	5,049		905						
	504	Prozorsko krilo - EURO 1 Casement -EURO 1	6,814	909	907	920					
	1,181	Оконная створка -EURO 1	2,912	929	926	TMA18					
	505	Prozorsko krilo - EURO 16mm Casement -EURO 16mm	6,658	909	906	920					
	1,191	Оконная створка -EURO 16мм	2,475	929	928	TMA18					
	508	Prag Threshold	1,388								
	1,026	Попор	2,358								
	509	Veza dvokrilnog prozora - EURO 1 French casement adaptor -EURO 1	5,937								
	1,162	Профиль подключения -EURO 1	3,218								
	510	Veza dvokrilnog prozora - EURO 16mm French casement adaptor -EURO 16mm	6,190								
	1,164	Профиль подключения -EURO 16мм	2,976								
	513	Prečka u štoku T profile in frame	6,740		922						
	1,104	T профил в рамке	2,546		905						
2013.A1 4				R1:4							

Aluminijumski profil
Aluminium profile
Алюминиевый профиль

Naš brend
Our brend
Наша марка

Podsystem
Subsystem
Подсистема

Sadržaj
Content
Содержание

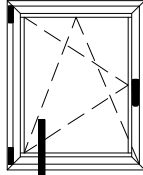
LINEAL

ST 54

Detalj
Detail
Узел

EURO 1

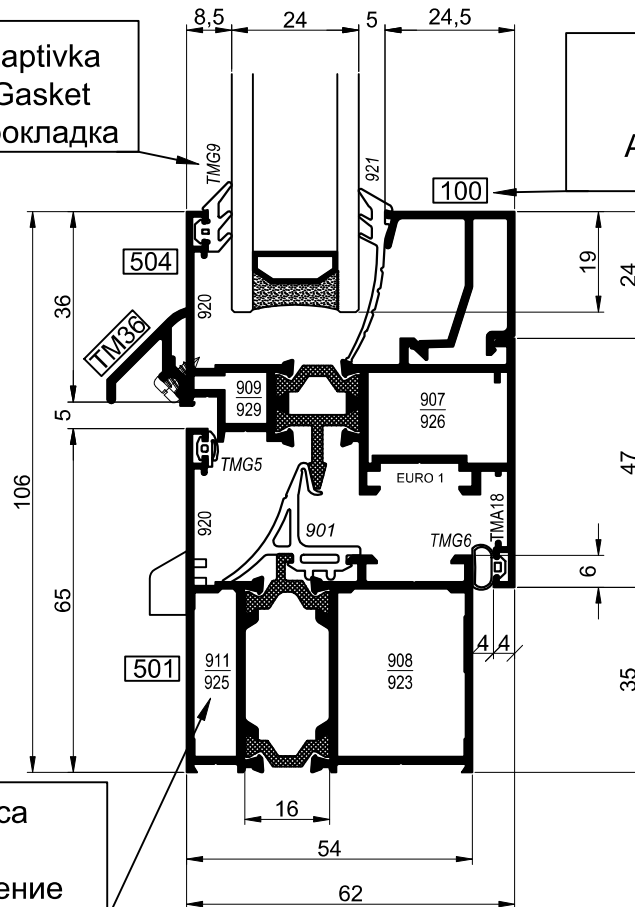
Žleb za okov
Groove fittings
Канавка для фитингов



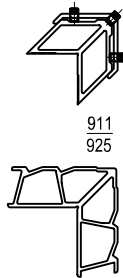
Zaptivka
Gasket
Прокладка

Aluminijumski profil
Aluminium profile
Алюминиевый профиль

Detalj
Detail
Узел



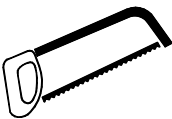
Ugaona spojnica
Corner joint
Угловое соединение



Numeracija strane
Page number
Номер страницы

Revizija kataloga
Revision of the catalog
Пересмотр каталога

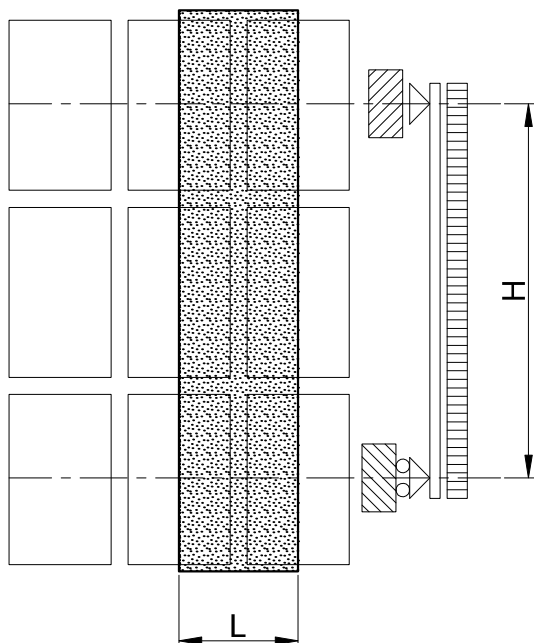
Razmera
Drawing scale
Масштабная линейка

	Pozicija Position Положение
	Iseći Cut Резать
	Izbušiti Drill Сверлить
	Zategnuti Tighten Затянуть
	Ušrafiti Screw in Ввернуть
	Lepiti Glue Клеить
	Zapivna masa Sealant Герметик
	Okrenuti Rotate Вращать
	Opterećenje vetrom Wind load Ветровая нагрузка
	Čistač Cleaner Средство для чистки

MONTAŽA SA OSLONCEM U DVE TAČKE

Two point support

Монтаж опираясь на двух точках



$$f_{\max} = \frac{5}{384} \times \frac{q L H^4}{EI} \leq f_{\text{doz.}}$$

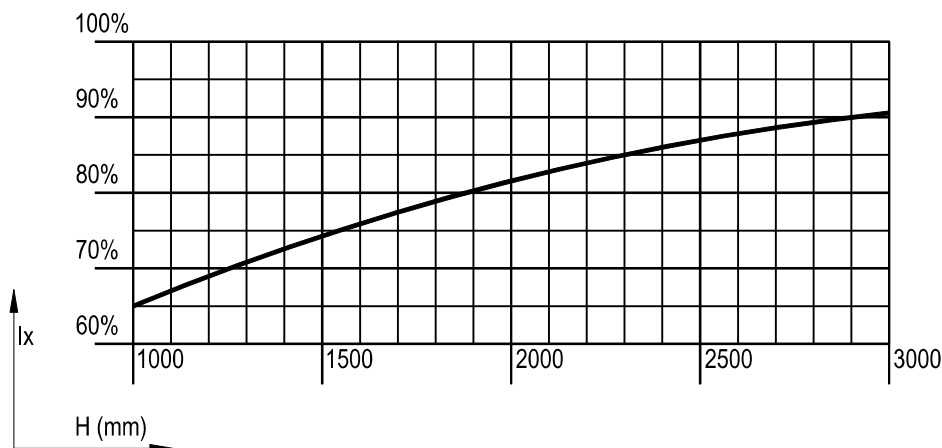
$$\sigma_{\max} = \frac{1}{8} \times \frac{q L H^2}{W} \leq \sigma_{\text{doz.}}$$

H	VERTIKALNI MEĐUOSOVINSKI RASPON Axial spacing - vertical Осевое расстояние по вертикали	cm
L	HORIZONTALNI MEĐUOSOVINSKI RASPON Axial spacing - horizontal Осевое расстояние по горизонтали	cm
q	OPTEREĆENJE loading Нагрузка	N/cm ²
E	MODUL ELASTIČNOSTI ALUMINIJUMA, Aluminium modulus of elasticity Модуль упругости алюминия	7000000 N/cm
I	MOMENT INERCIJE Moment of inertia Момент инерции	cm ⁴
W	OTPORNI MOMENT Modulus of section Модуль сопротивления раздела	cm ³
f max	MAKSIMALNI UGIB Max. deflection Максимальное отклонение	cm
σ max	MAKSIMALAN NAPON Max. pressure Максимальное напряжение	N/cm ²
f doz.	MAKSIMALNI DOZVOLJENI UGIB Max. allowed deflection Максимально допустимое отклонение	cm
σ doz.	MAKSIMALAN DOZVOLJENI NAPON Max. allowed pressure Максимальное допустимое напряжение	N/cm ²

MOMENT INERCIJE UMANJITI UZIMAJUĆI U OBZIR
KOEFIČIJENT ELASTIČNOSTI KOMPOZITA

Moment of inertia lessen by taking into account the
coefficient of elasticity of the composite

Момент инерции уменьшить с учетом коэффициента
упругости композита



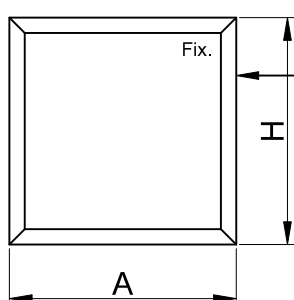
Primer
Example
Пример



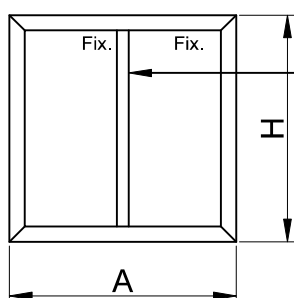
$q = 600 \text{ Pa}$

$f_{\text{doz.}} = \frac{H}{300}$

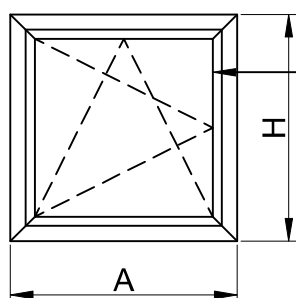
EN 12211



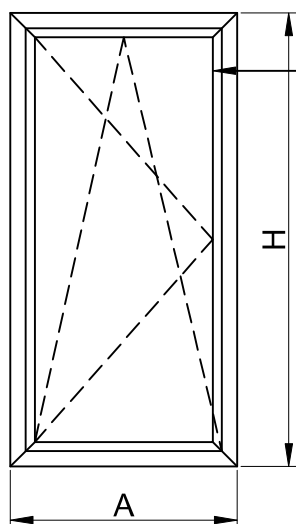
	Max. A (mm)	Max. H (mm)	Min. A (mm)	Min. H (mm)
501	3000	2400	300	300
517	3000	2400	300	300
601	3000	2400	300	300
617	3000	2400	300	300
701	3000	2400	300	300
717	3000	2400	300	300



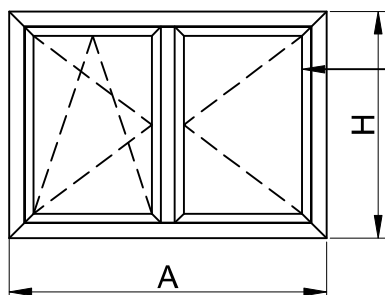
	Max. A (mm)	Max. H (mm)	Min. A (mm)	Min. H (mm)
502	2000	2400	540	300
513	1650	2200	540	300
602	2000	2400	540	300
613	1650	2200	540	300
702	2000	2400	540	300
713	1650	2200	540	300



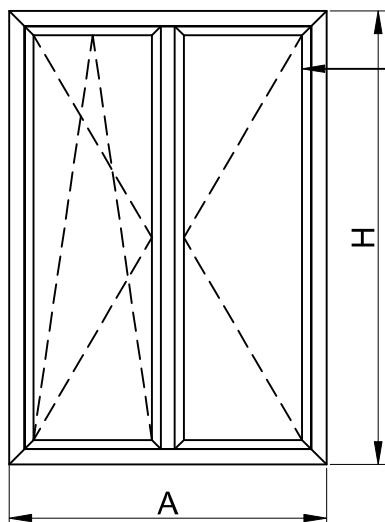
		Max. A (mm)	Max. H (mm)	Min. A (mm)	Min. H (mm)	Max. (kg)	Kрила Casement Створке
504		1300	1600	580	540	130	
505		1300	1600	580	450	100	
514		1500	1800	580	540	130	
515		1500	1800	580	450	100	
519		1500	1800	580	540	130	
520		1500	1800	580	450	100	
604		1300	1600	580	540	130	
605		1300	1600	580	450	100	
614		1500	1800	580	540	130	
615		1500	1800	580	450	100	
619		1500	1800	580	540	130	
620		1500	1800	580	450	100	
704		1300	1600	580	540	130	
705		1300	1600	580	450	100	
714		1500	1800	580	540	130	
715		1500	1800	580	450	100	
719		1500	1800	580	540	130	
720		1500	1800	580	450	100	



		Max. A (mm)	Max. H (mm)	Min. A (mm)	Min. H (mm)	Max. (kg)	Kрила Casement Створке
504		1000	2200	580	540	130	
505		1000	2200	580	450	100	
514		1100	2400	580	540	130	
515		1100	2400	580	450	100	
519		1100	2400	580	540	130	
520		1100	2400	580	450	100	
604		1000	2200	580	540	130	
605		1000	2200	580	450	100	
614		1100	2400	580	540	130	
615		1100	2400	580	450	100	
619		1100	2400	580	540	130	
620		1100	2400	580	450	100	
704		1000	2200	580	540	130	
705		1000	2200	580	450	100	
714		1100	2400	580	540	130	
715		1100	2400	580	450	100	
719		1100	2400	580	540	130	
720		1100	2400	580	450	100	



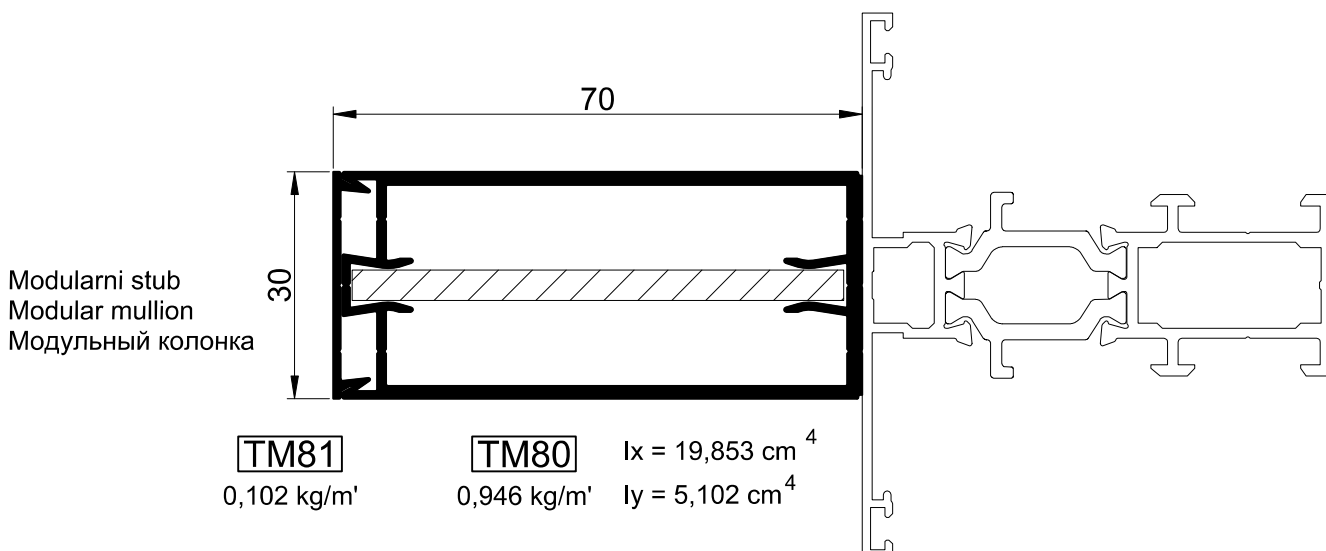
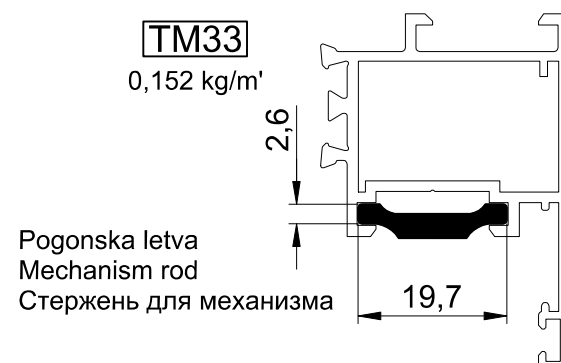
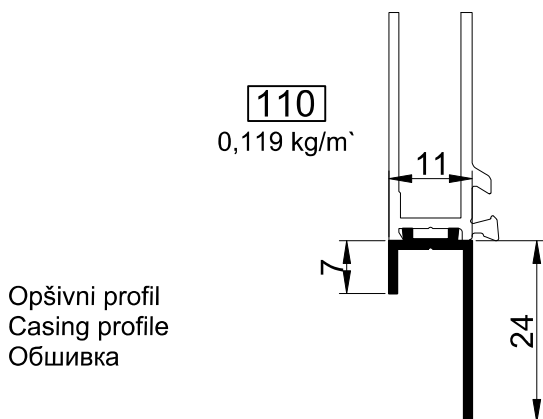
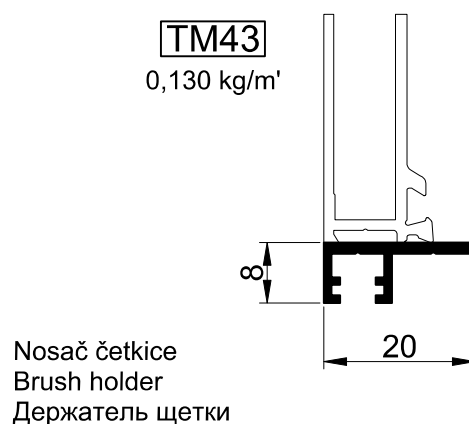
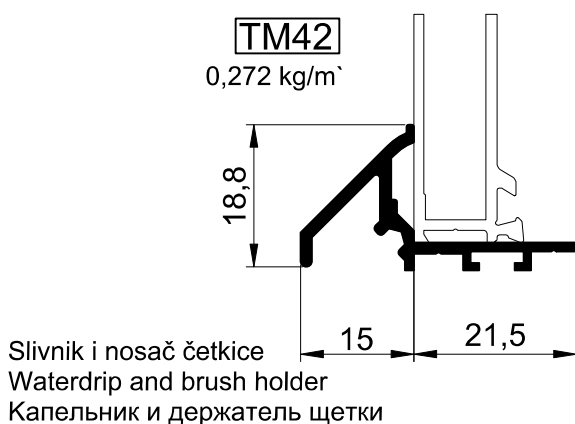
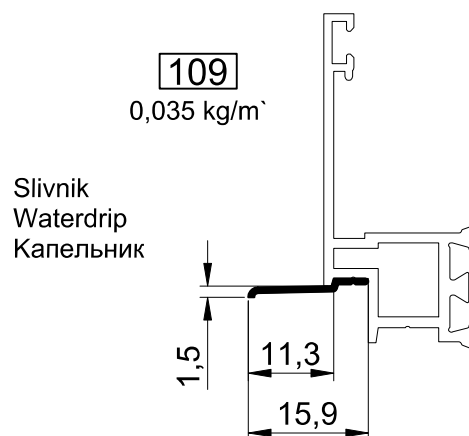
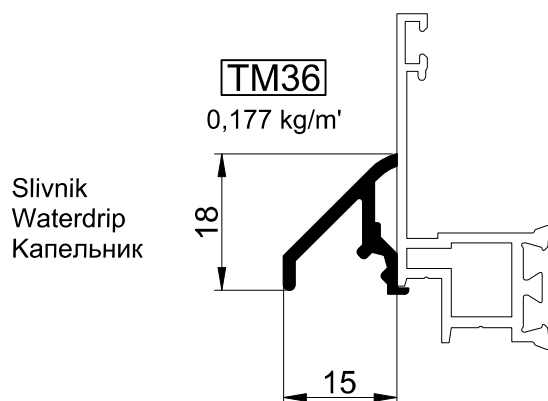
	Max. A (mm)	Max. H (mm)	Min. A (mm)	Min. H (mm)	Max. (kg)	Krila Casement Створке
504	2100	1600	1015	540	130	
505	2100	1600	700	450	100	
514	2300	1800	1015	540	130	
515	2300	1800	700	450	100	
519	2300	1800	1015	540	130	
520	2300	1800	700	450	100	
604	2100	1600	1015	540	130	
605	2100	1600	700	450	100	
614	2300	1800	1015	540	130	
615	2300	1800	700	450	100	
619	2300	1800	1015	540	130	
620	2300	1800	700	450	100	
704	2100	1600	1015	540	130	
705	2100	1600	700	450	100	
714	2300	1800	1015	540	130	
715	2300	1800	700	450	100	
719	2300	1800	1015	540	130	
720	2300	1800	700	450	100	

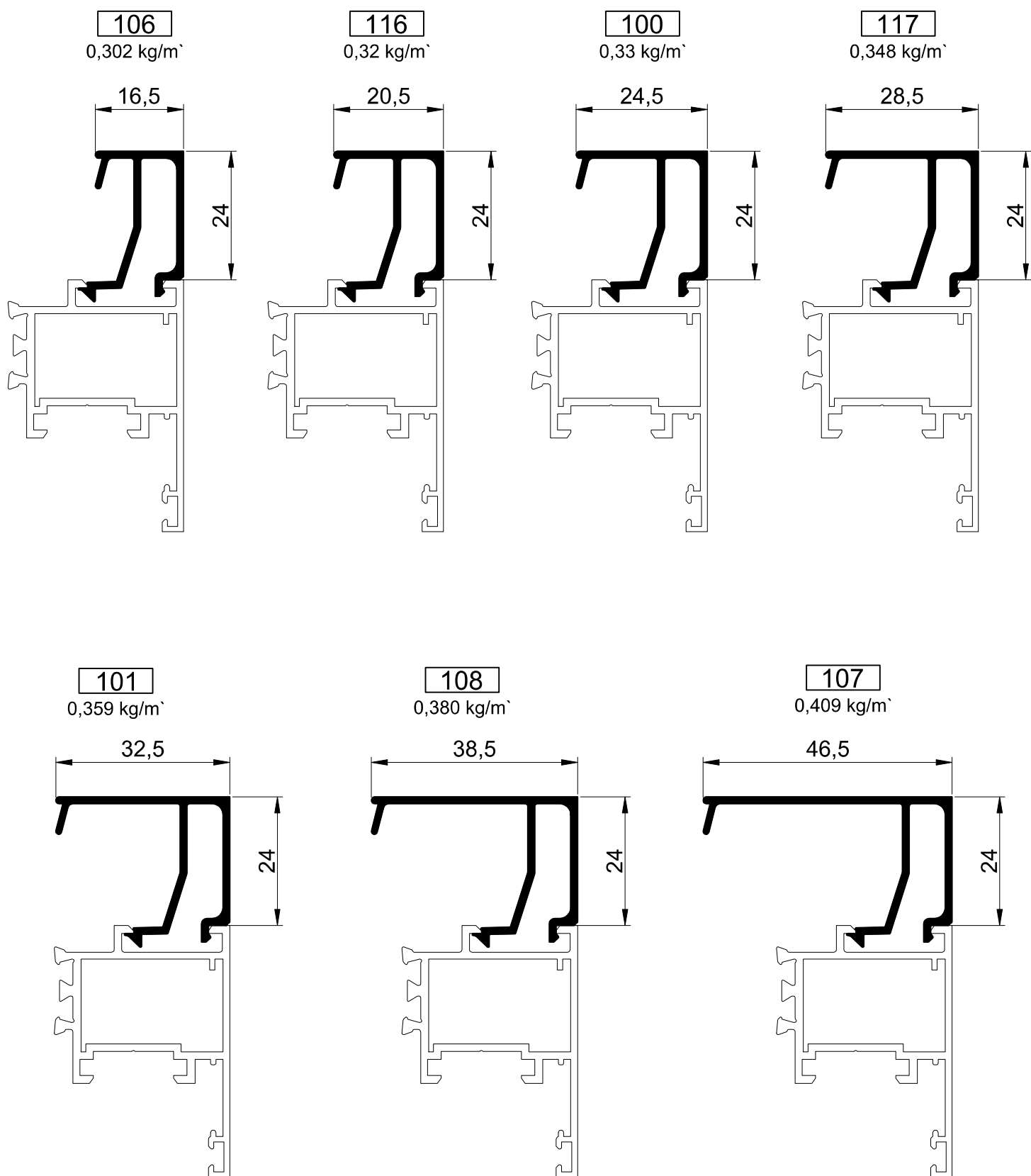


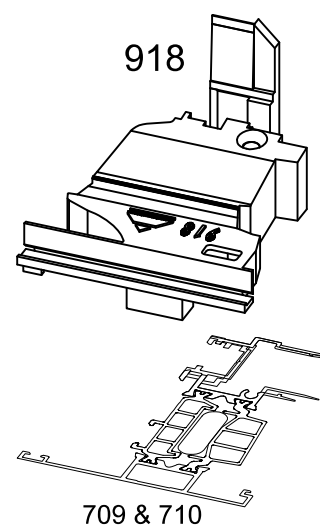
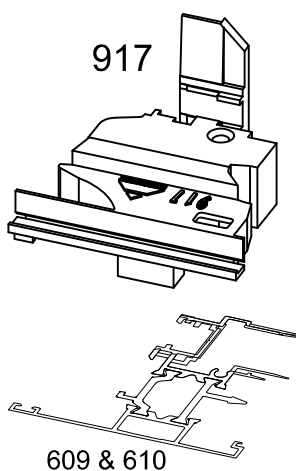
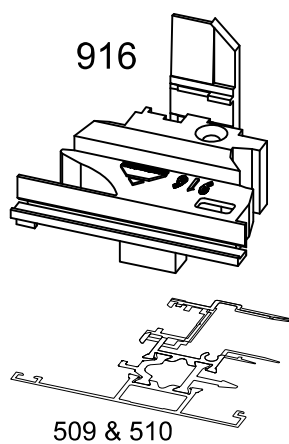
	Max. A (mm)	Max. H (mm)	Min. A (mm)	Min. H (mm)	Max. (kg)	Krila Casement Створке
504	1600	2200	1015	540	130	
505	1600	2200	700	450	100	
514	1800	2400	1015	540	130	
515	1800	2400	700	450	100	
519	1800	2400	1015	540	130	
520	1800	2400	700	450	100	
604	1600	2200	1015	540	130	
605	1600	2200	700	450	100	
614	1800	2400	1015	540	130	
615	1800	2400	700	450	100	
619	1800	2400	1015	540	130	
620	1800	2400	700	450	100	
704	1600	2200	1015	540	130	
705	1600	2200	700	450	100	
714	1800	2400	1015	540	130	
715	1800	2400	700	450	100	
719	1800	2400	1015	540	130	
720	1800	2400	700	450	100	

Lista pratećeg materijala
Accessories list
Список аксессуаров

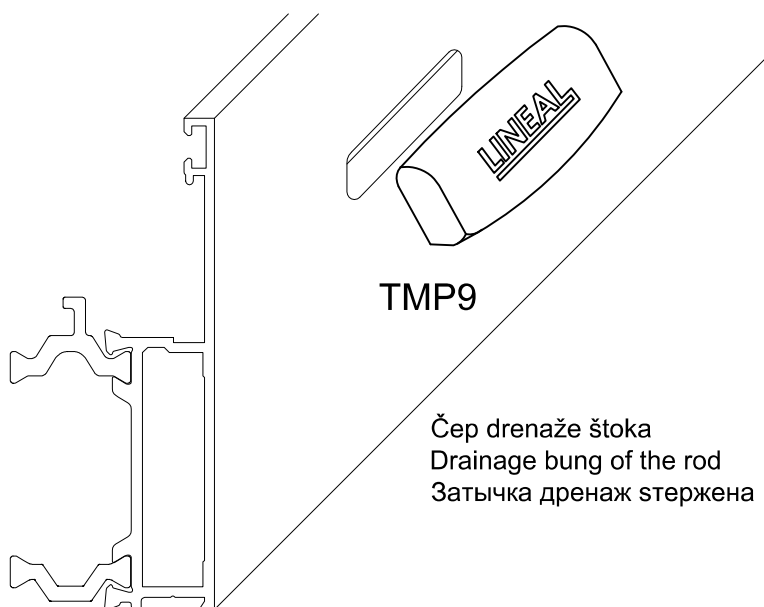




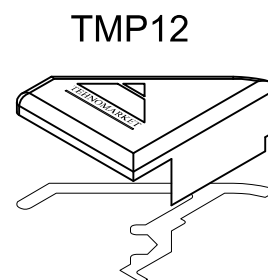




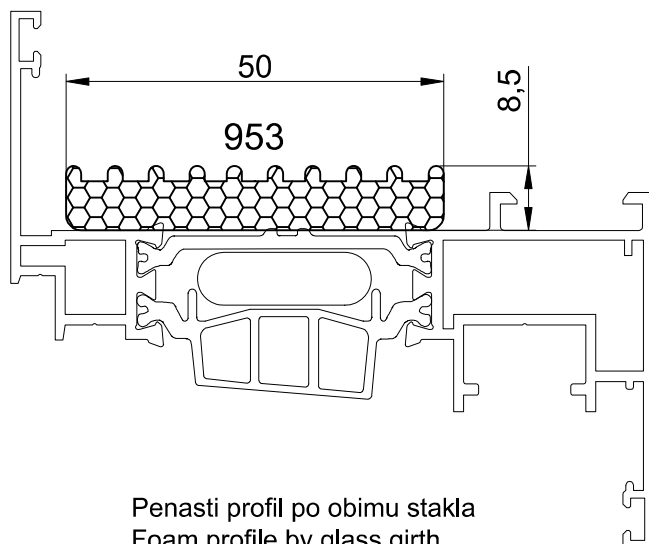
Čep profila veze dvokrilnog prozora
Double casement connection profile bung
Затычка соединительного профиля двойной створки



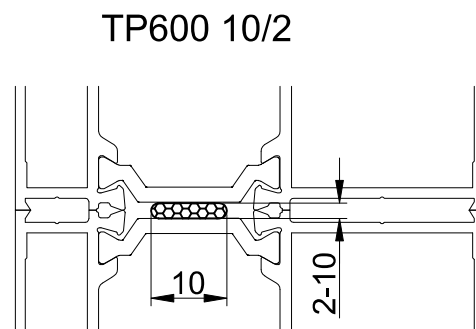
Čep drenaže štoka
Drainage bung of the rod
Затычка дренаж стержена



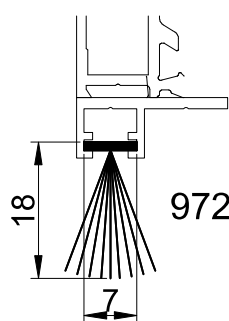
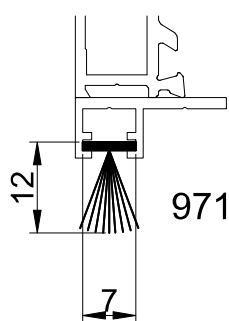
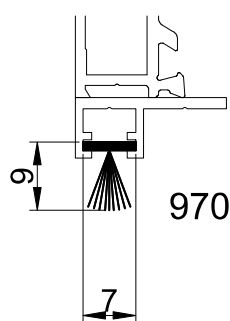
Čep slivnika
Water drip bung
Затычка капельного



Penasti profil po obimu stakla
Foam profile by glass girth
Профиль пены по объему стекла

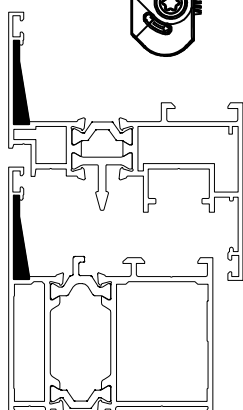
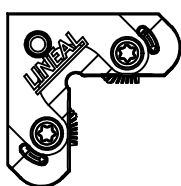


Penasti profil na spoju
Joint foam profile
Профиль пены на суставе



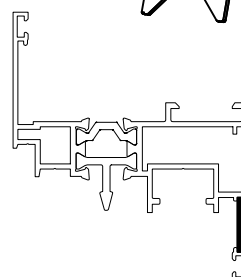
Četkice praga
Rod drainega brush
Шетки порога

920



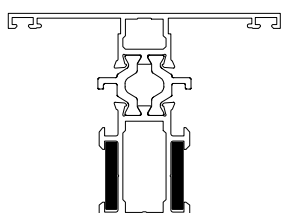
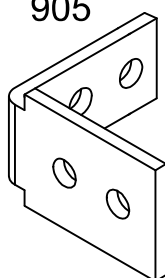
Spojница u peru
Thorn clip
Клип в шипе

TMA18

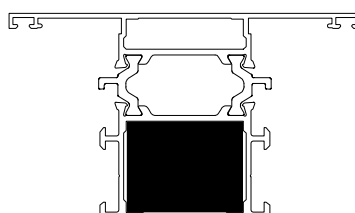
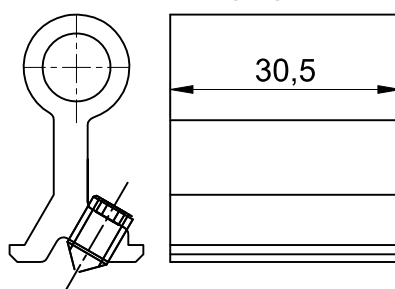


Spojница u peru
Thorn clip
Клип в шипе

905

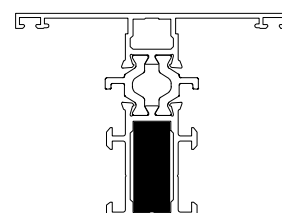
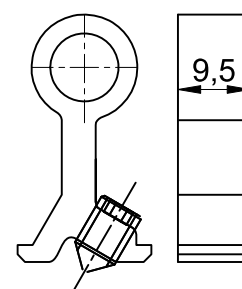


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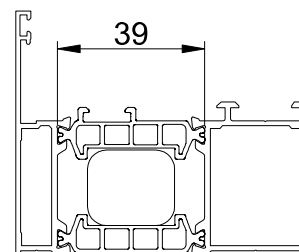
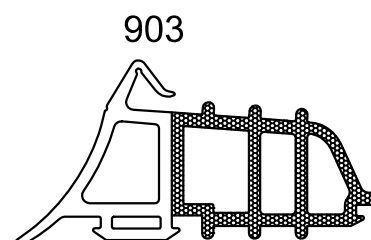
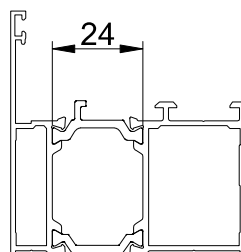
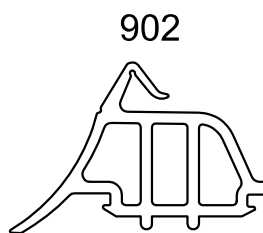
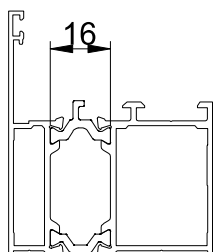
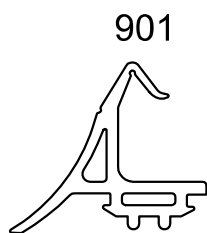


Spojница prečke
Crossbar clip
Клип штанги

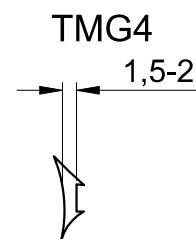
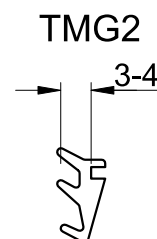
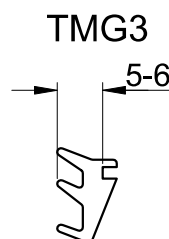
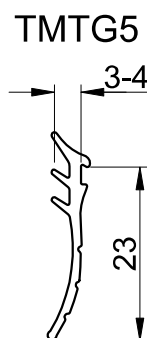
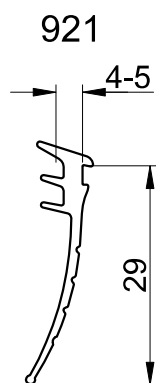
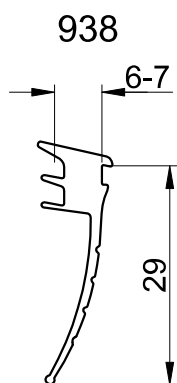
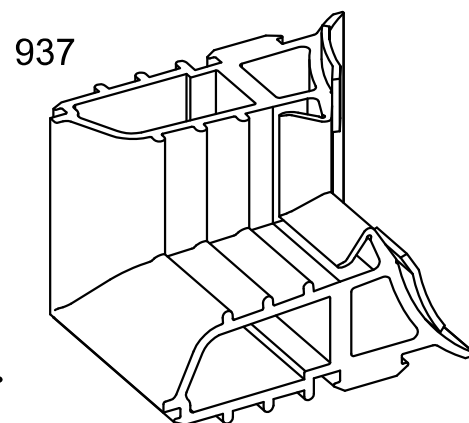
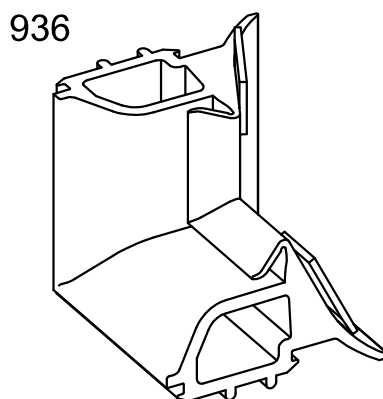
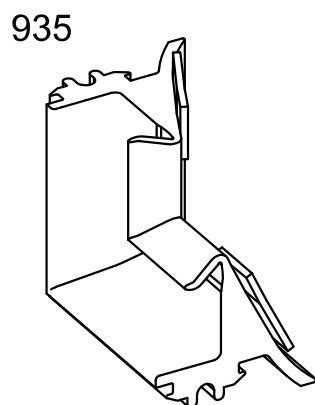
922



Centralna zaptivka
Central seal
Центральна прокладка

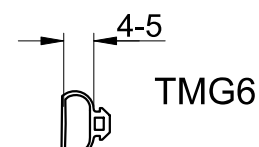
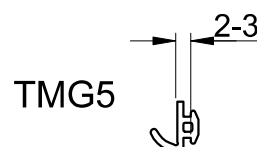
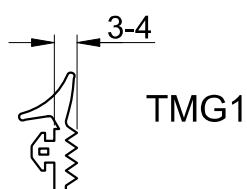
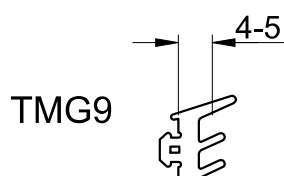
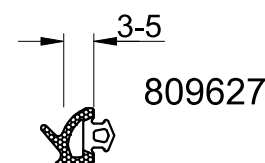


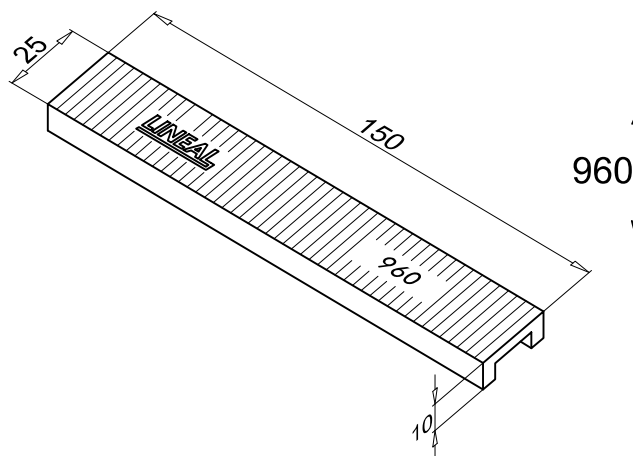
Vulkanizirani ugao centralne zaptivke
Central seal vulcanized angle
вулканиз. угол централ. прокладки



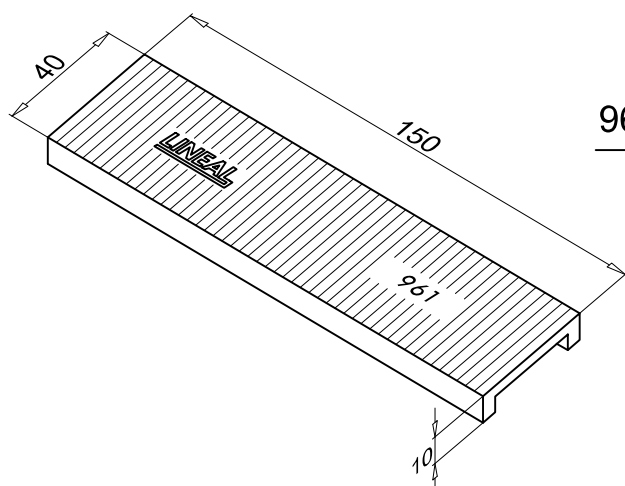
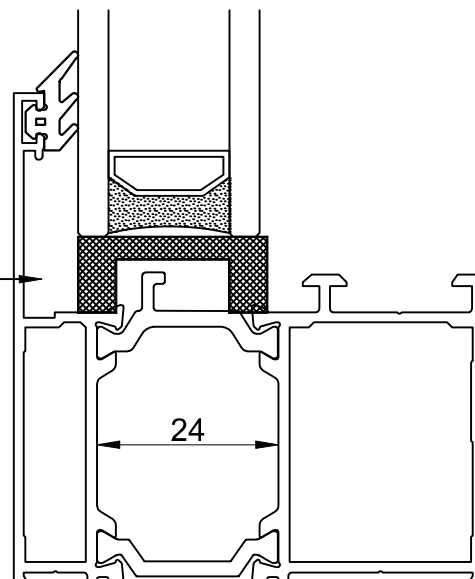
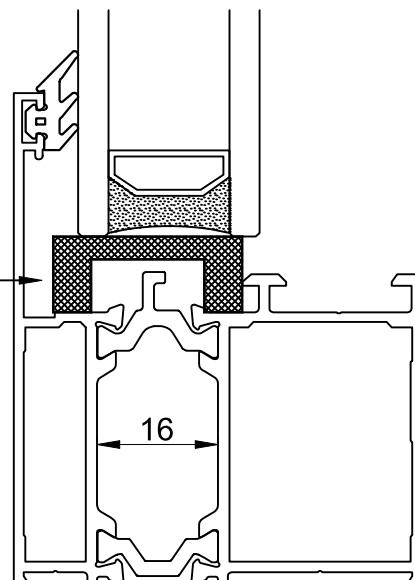
Zaptivke stakla
Glazing gasket
Прокладка остекления

Zaptivke krila
Casement gasket
Прокладка окна

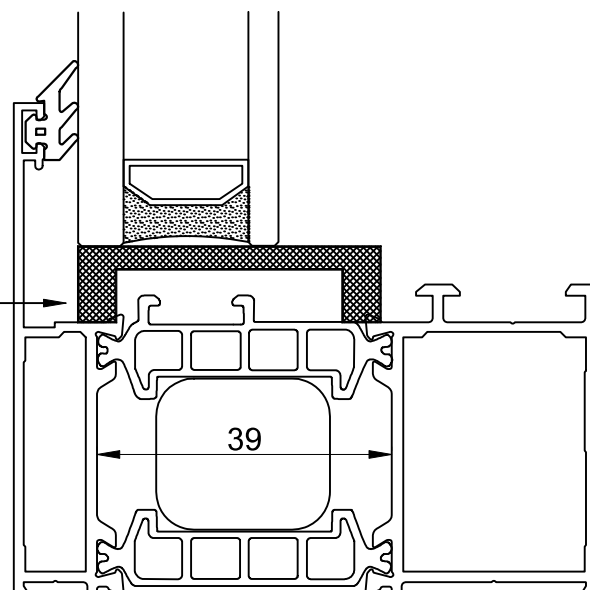


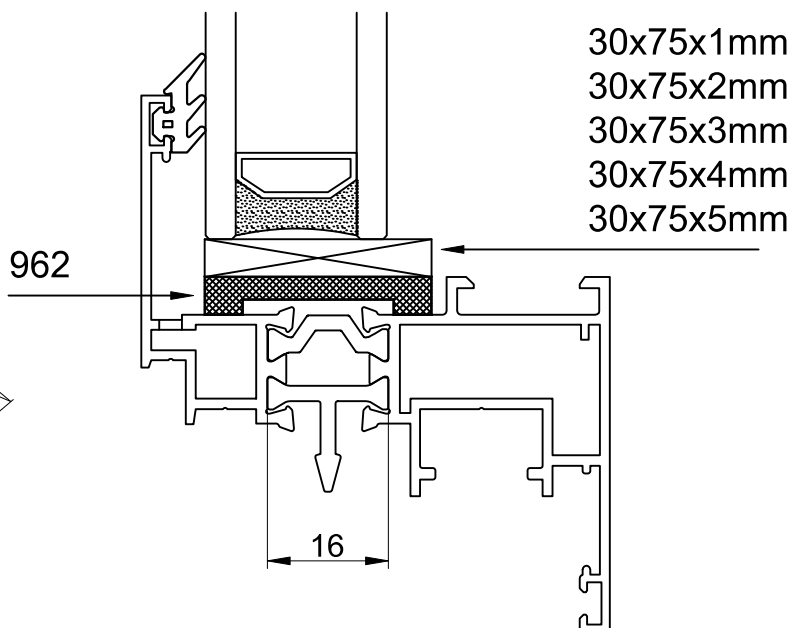
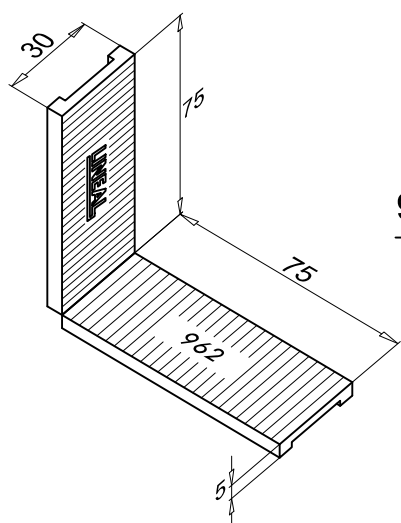


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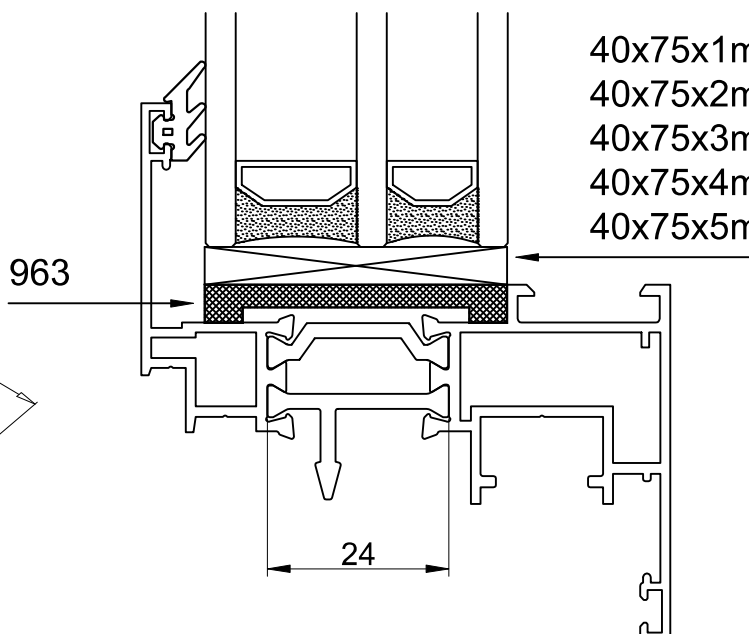
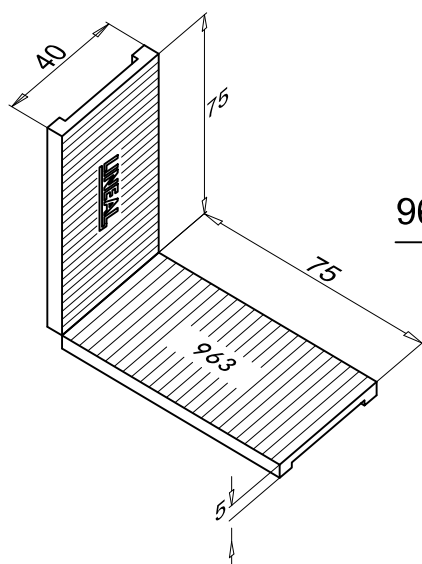
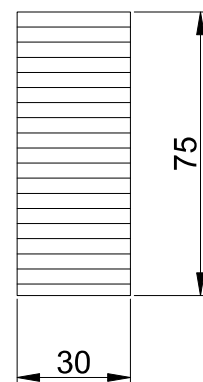


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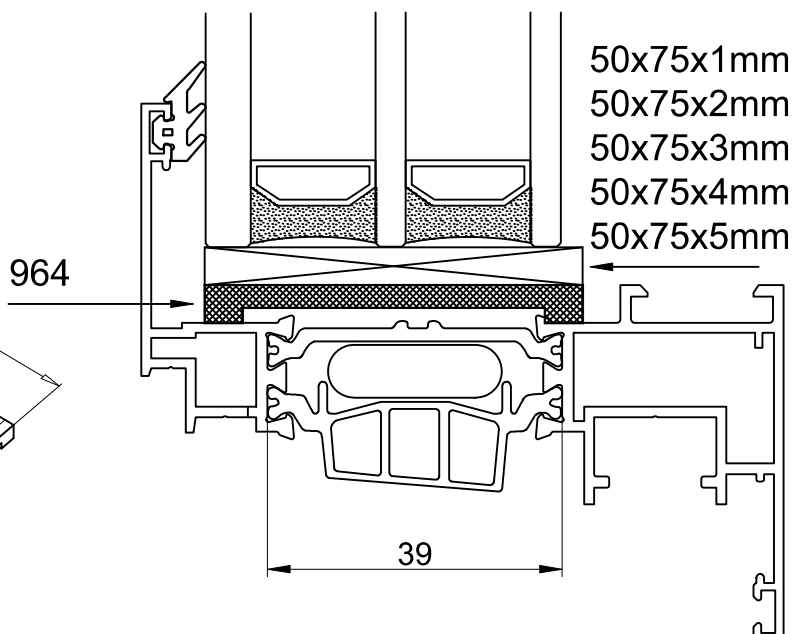
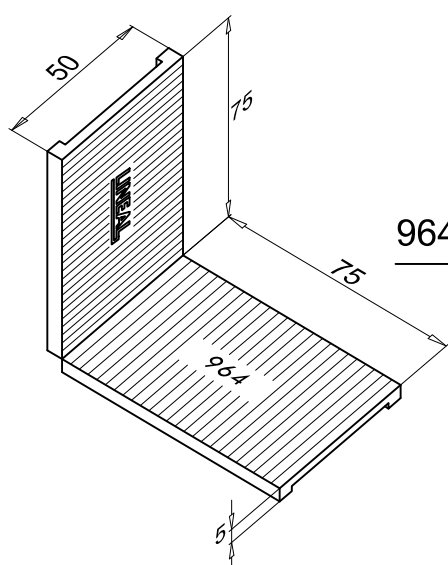
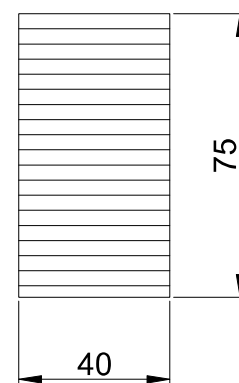




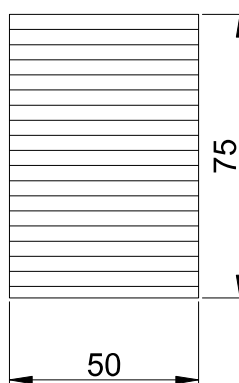
30x75x1mm
30x75x2mm
30x75x3mm
30x75x4mm
30x75x5mm

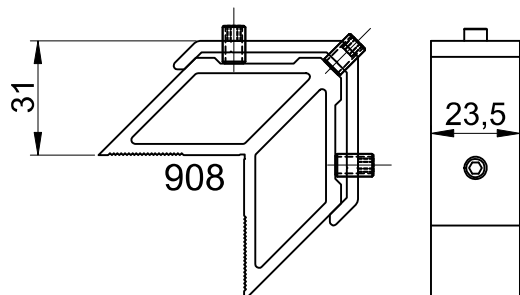


40x75x1mm
40x75x2mm
40x75x3mm
40x75x4mm
40x75x5mm

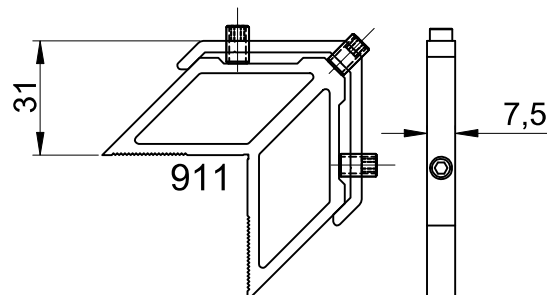
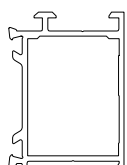


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50x75x3mm
50x75x4mm
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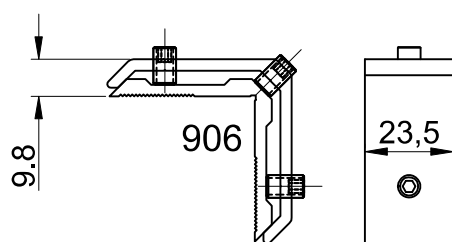




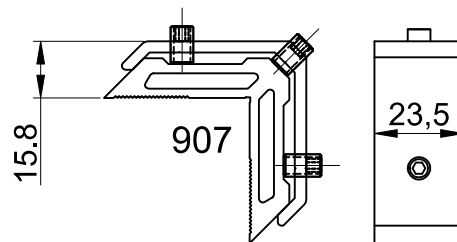
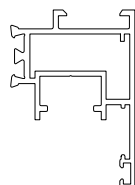
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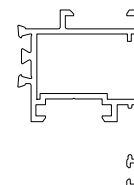
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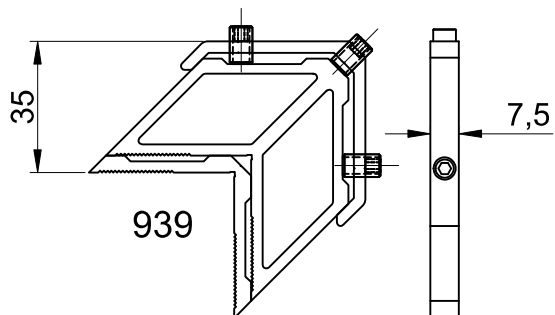


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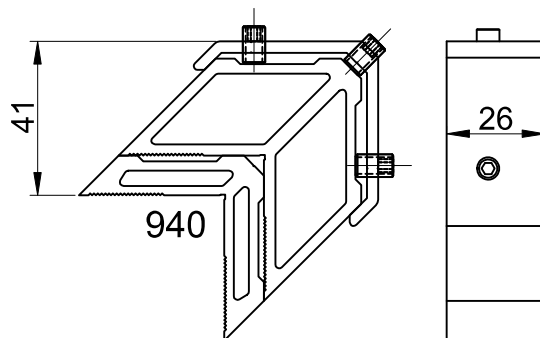
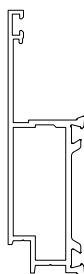


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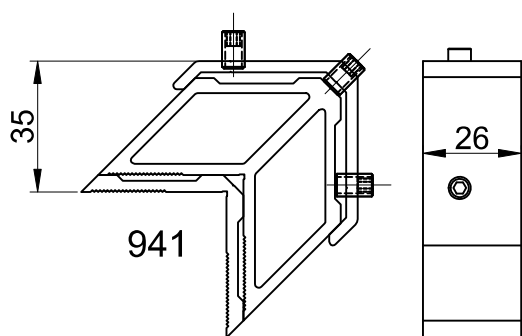
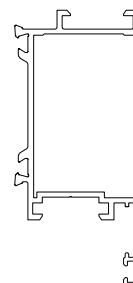




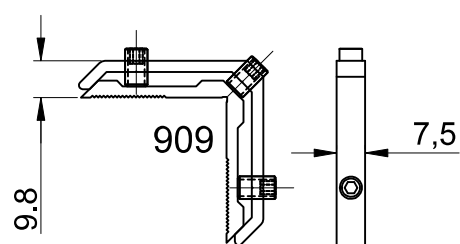
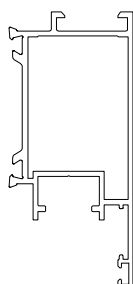
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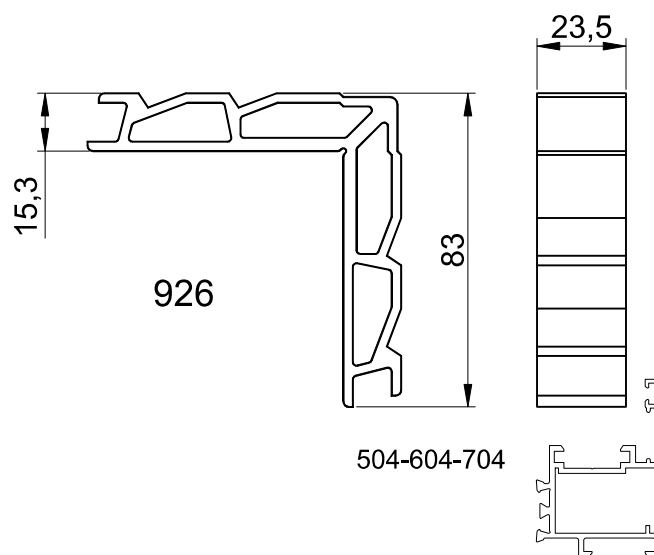
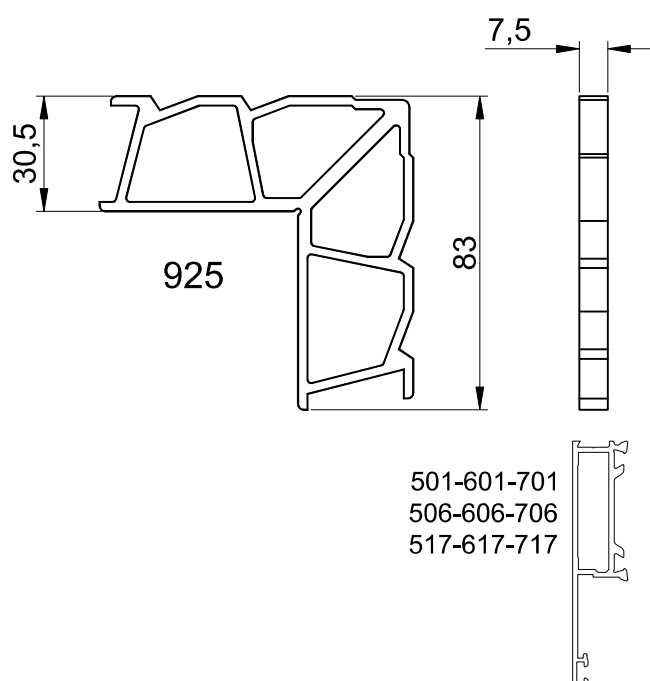
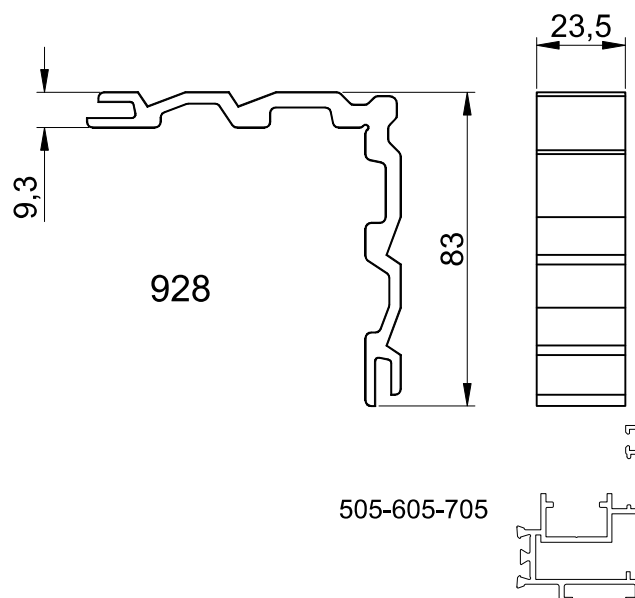
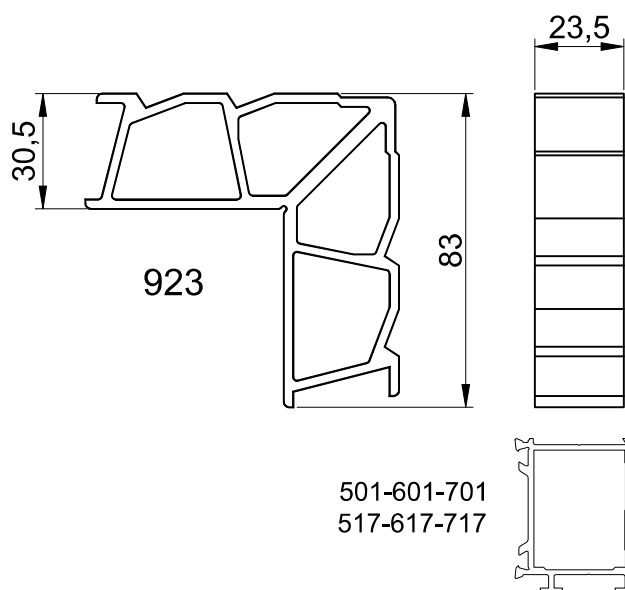


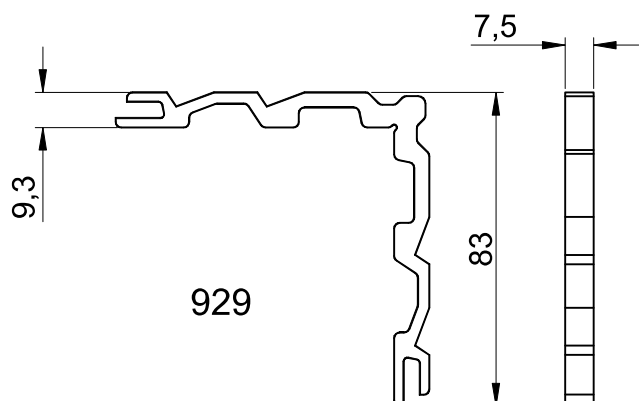
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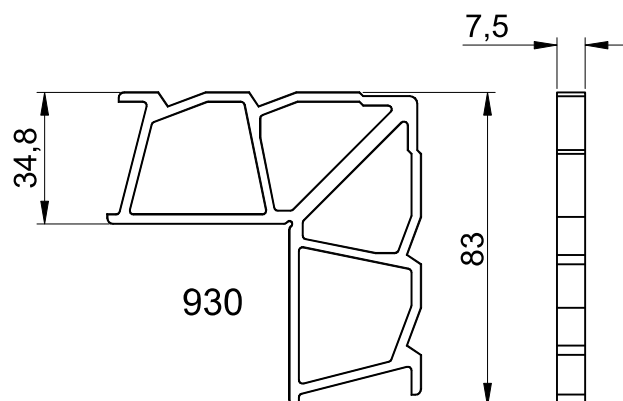
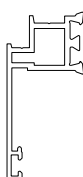






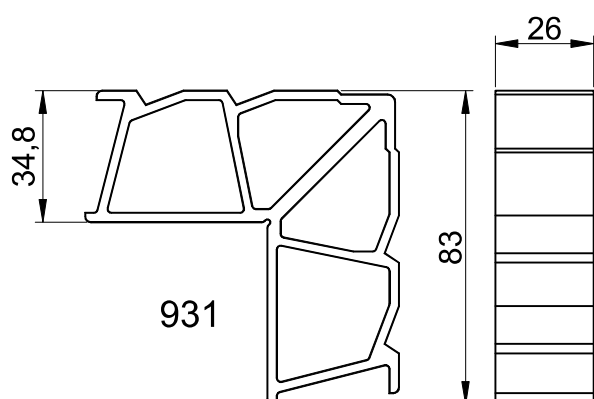
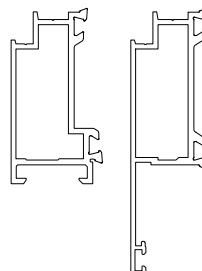
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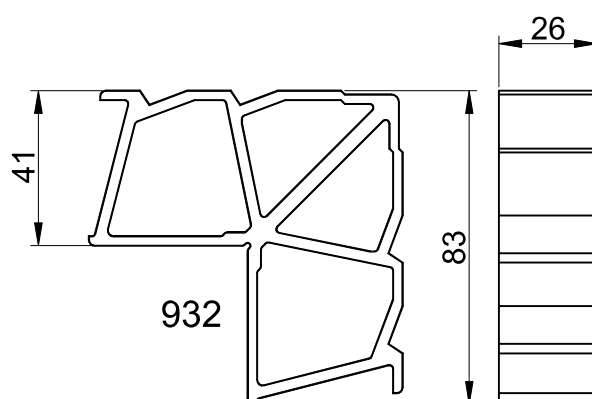
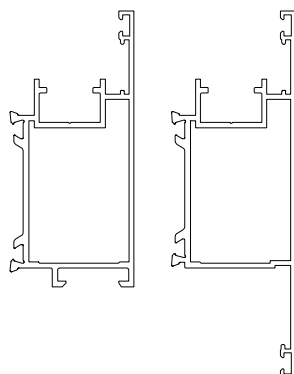
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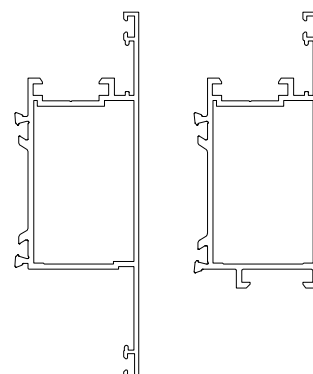
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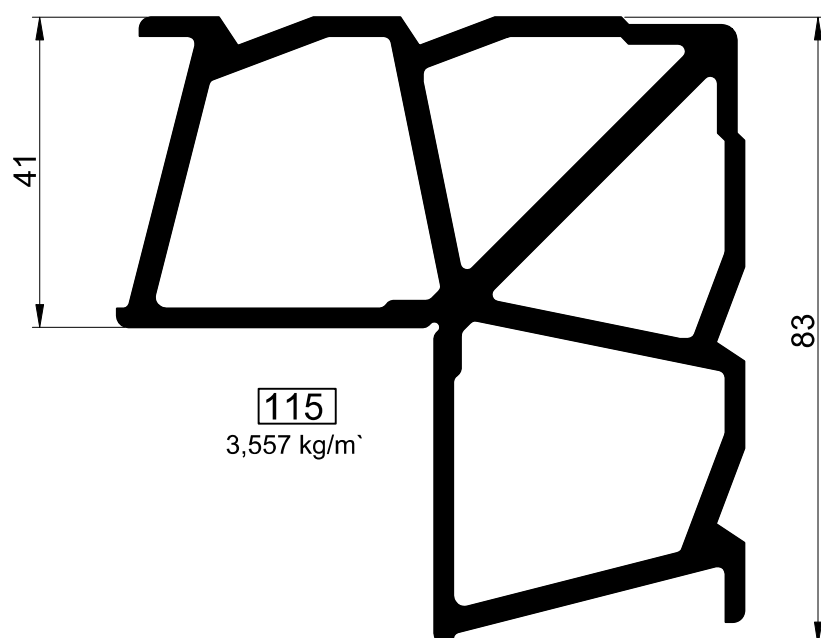
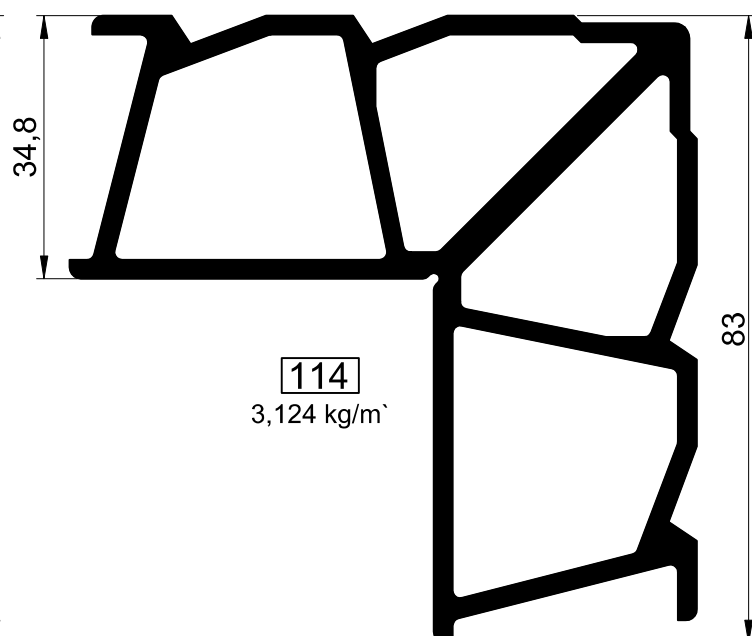
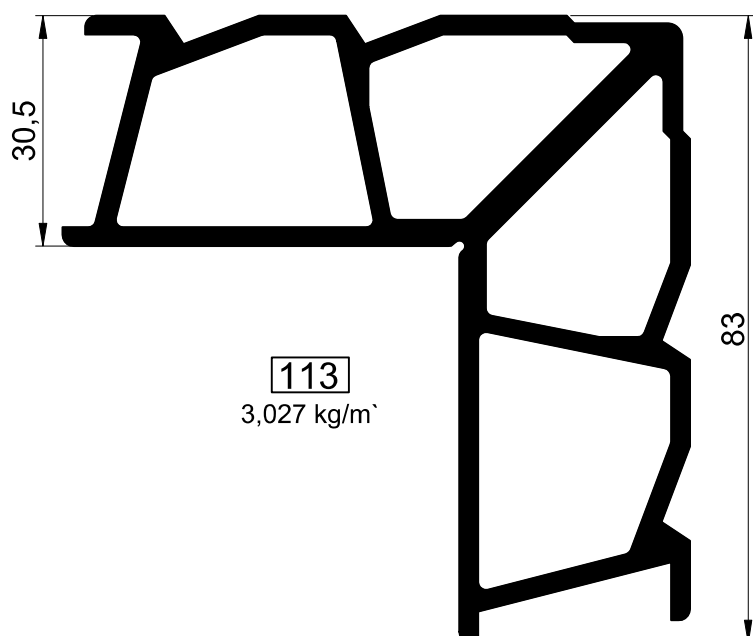
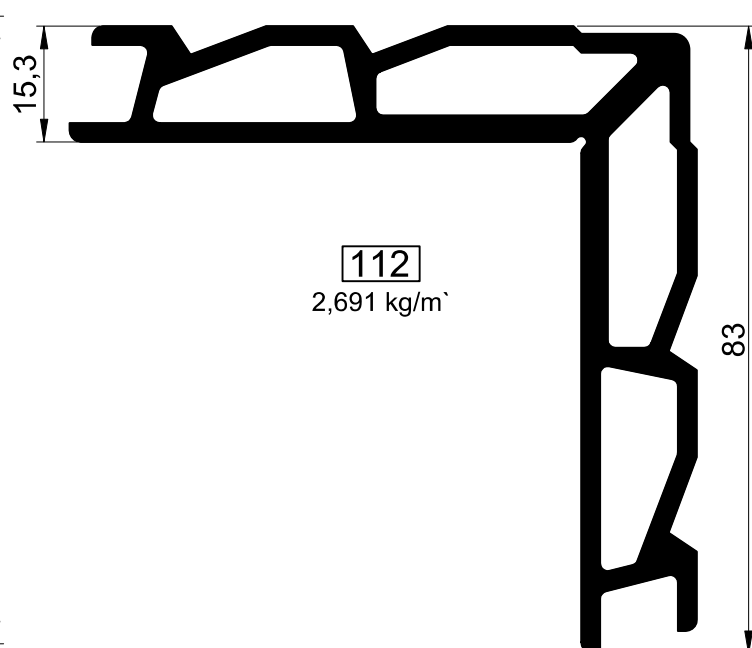
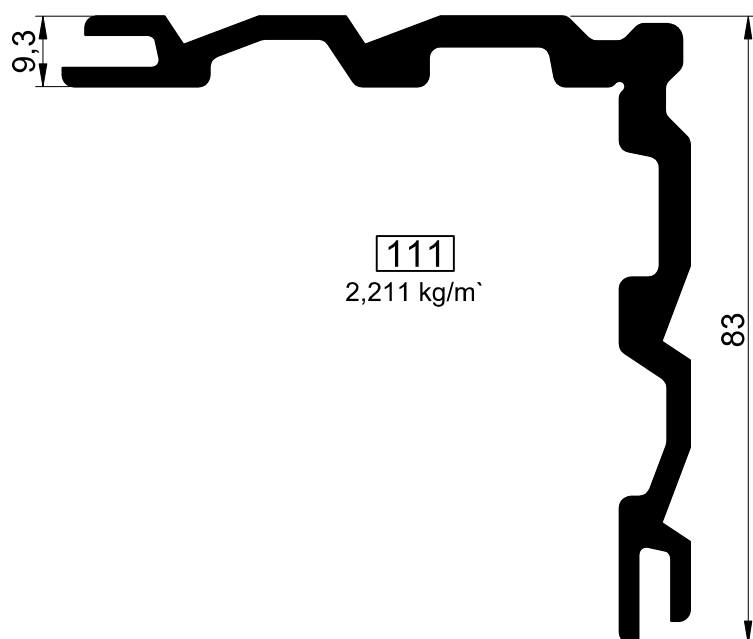
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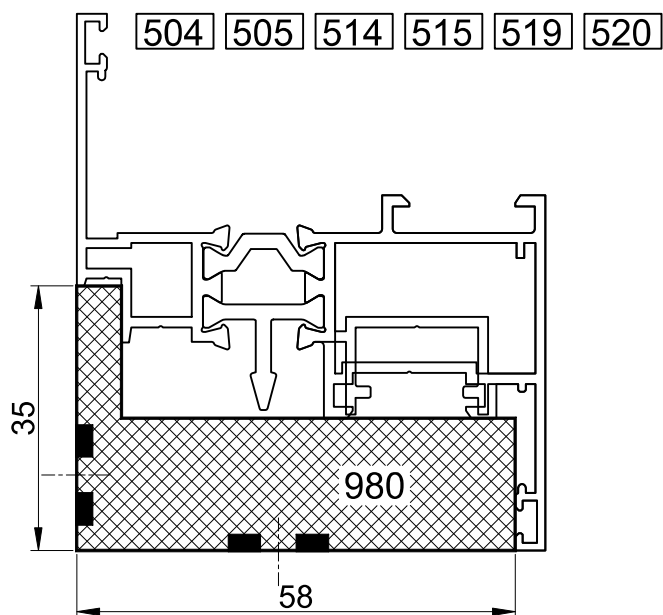
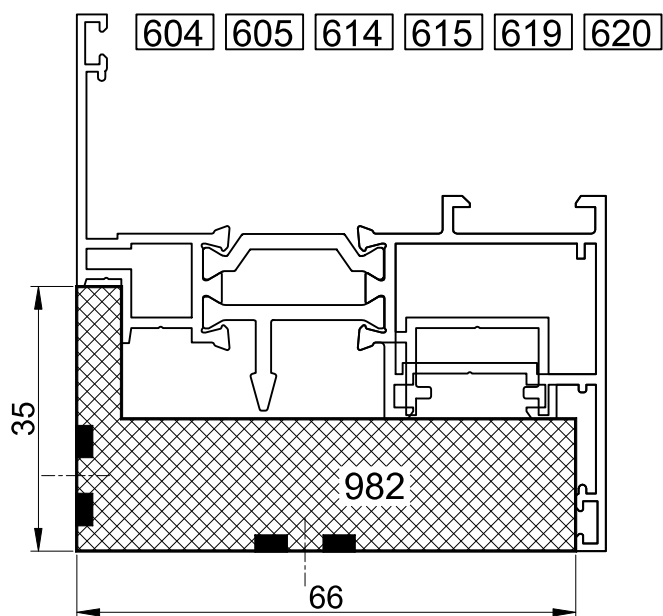
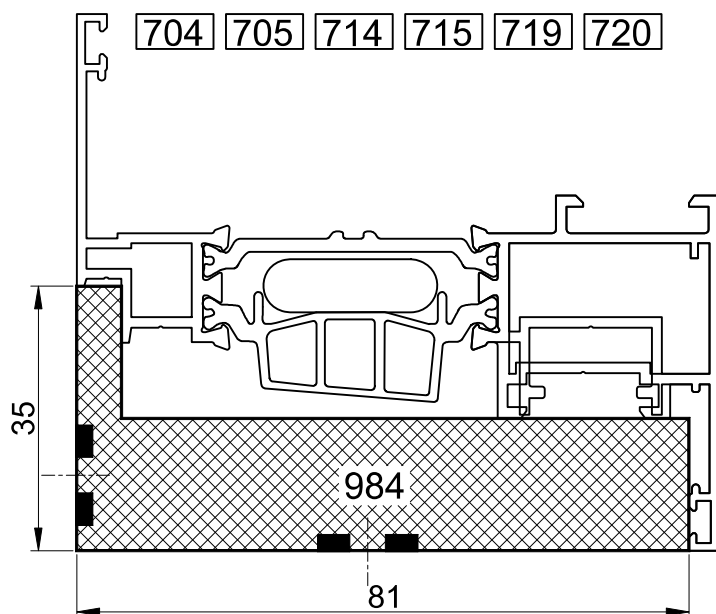


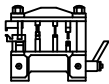
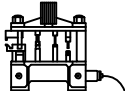
932

514-614-714
519-619-719







Simbol Symbol Символ	Opis Description Описание	Proizvođač Manufacturer Производитель	Oznaka Mark Марк	Pak. Pack Упак.	Boja Color Цвет
	Lepak i zaptivna masa za alumijum Glue and sealent for aluminium Клей и герметик для алюминия	Reca	MS Polymer S78	310 ml	   
		Würth	MS Polymer 089322	310 ml	
	Lepak za spojnice Corner joint glue Клей для углового соединения	3M	Scotch weld poliuretane multi purpose adhesive 5005	310 ml	  
	Lepak za gumu Gasket glue Клей для прокладки	3M	RT3500B	20 g	
		Würth	189309631	20 g	
	Čistač Cleaner Средство для чистки	Reca	Arecal 0895410500	500 ml	
	Ručna presa Hand press Ручной пресс	Bisal	Lineal M1	1	
	Pneumatska presa Pneumatic press Пневматический пресс	Bisal	Lineal P1	1	

-  Crno / Black / Черный
-  Sivo / Gray / Серый
-  Belo / White / Белый
-  Transparentno / Transparent / Прозрачный

Sistem
System
Система

ST 54

Sistem LINEAL ST 54

System LINEAL ST 54

Система LINEAL ST 54



Tehnički opis sistema

Sistem LINEAL ST 54 je jedan od šest iz serije LINEAL i predstavlja sistem aluminijumskih profila sa termičkim prekidom, specijalno projektovanih za izradu elemenata prozora i vrata sa ugradnom dubinom štoka od 54mm. Sistem je dizajniran tako da zadovoljava savremene zahteve na polju energetske efikasnosti, kao i ostale uslove nepohodne za bezbedan i udoban radni i životni prostor. Prilikom projektovanja elemenata sistema posebna pažnja je posvećena odabiru materijala koji vrše funkciju termičkog prekida u sklopu profila. Na ovaj način su postignute maksimalne sistemske termoizolacione karakteristike $U_f \approx 2,868 \text{ W/m}^2\text{K}$, odnosno $U_w \approx 1,67 \text{ W/m}^2\text{K}$.

- Aluminijumski profili su proizvedeni postupkom ekstruzije u pogonima Tehnomarket-a. Sirovina za proizvodnju profila je primarna legura aluminijuma oznake AlMgSi0,5 (AA6063 i 6060) i zateznom čvrstoćom profila od minimalno 210KN/mm².
- Poliamidne trake (PA 6,6 sa 25% staklenih vlakana) širine 16mm međusobno spajaju spoljašnje i unutrašnje aluminijumske delove u gotove profile, a pored funkcije mehaničkog spajanja, obezbeđuju i termički prekid. Garantovana sila smicanja spoljnog i unutrašnjeg aluminijumskog profila, povezanih poliamidnim trakama, se kontroliše u toku proizvodnje.
- Izolaciona svojstva sistema potvrđena su kroz rezultate ispitivanja toplotnih performansi. Takođe, ispitivanja su urađena i za otpornost na udare vetra, propuštanje vazduha i vode, kao i za zvučnu izolaciju.
- Sistem omogućava ugradnju standardnog okova u EURO 1 žljeb i okova za PVC u EURO 16mm žljeb.
- Sistem podržava ispune uključujući i staklo pakete od 8 do 32mm sa EPDM zaptivkama koje poseduju integrisanu barijeru protiv produvanja.
- Zaptivanje u zoni spoja štoka i krila je trostruko, preko tri trajno elastične EPDM zaptivke otporne na UV zračenje. Spajanje uglova pomoću ekstrudiranih patent spojnice ili spojnice za presovanje obezbeđeno je zatezanjem u svim komorama profila, što garantuje siguran ugaoni spoj i preciznu geometriju gotovih elemenata.
- Kanalisanje kondenza i incidentne vode je regulisano preko slobodnih ravnih površina u komorama, dok je ventilisana spoljna komora duboka 20mm.
- Osnovna spoljašnja dimenzija štoka od 65mm omogućava idealan prihvatač vođica roletne i komarnika. Unutrašnja širina štoka obezbeđuje idealan prostor za sabirnik trake roletne.

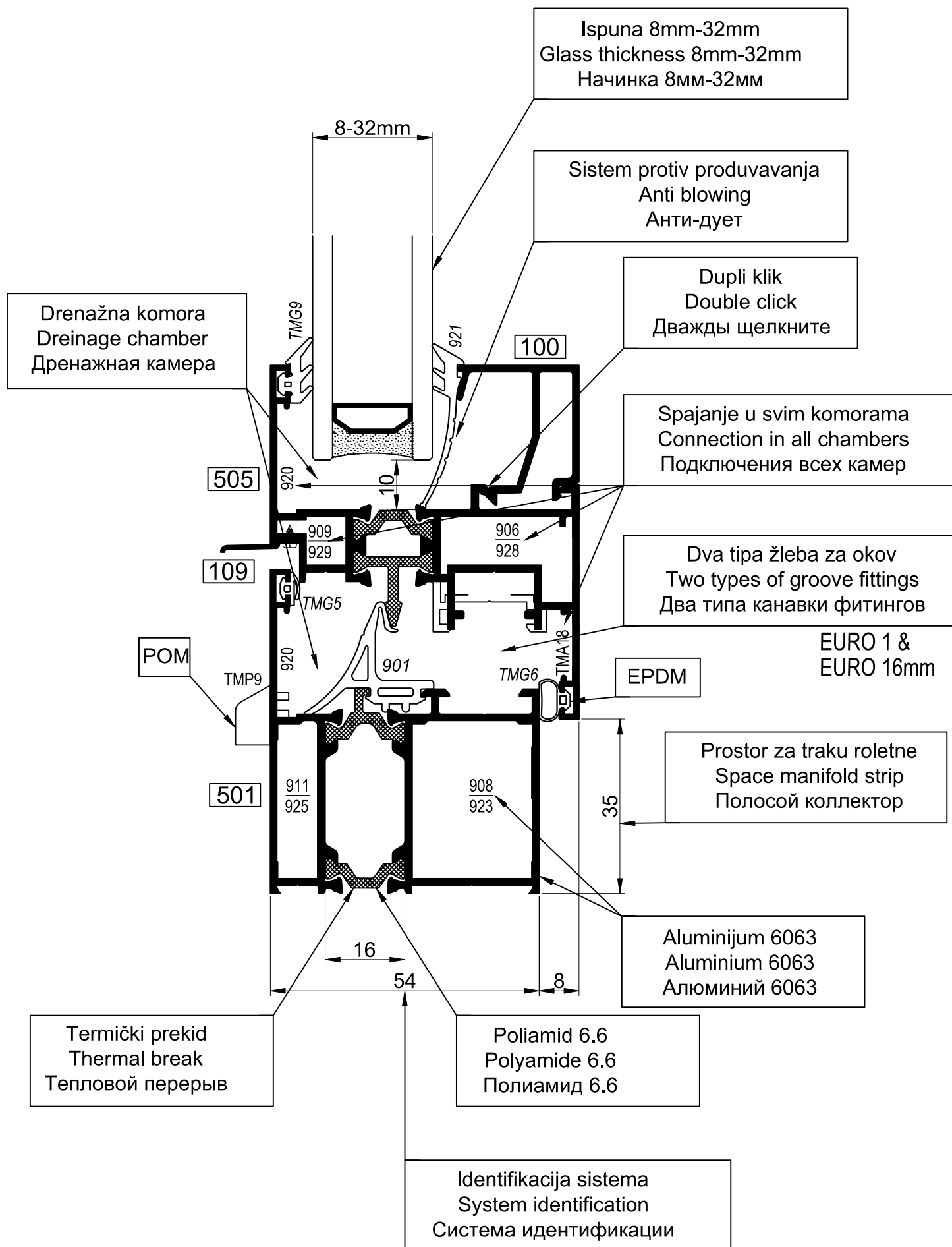
System LINEAL ST 54 is one of six form LINEAL series and it represents aluminium profile system with thermal break, specially designed for manufacturing of windows and doors with frame depth of 54mm. System is designed to satisfy all contemporary demand for energy efficiency, as well as all other requirements for safe and comfortable living and working environment. Special attention was addressed to selection of materials that for the thermal break within the profile. This way, maximal isolation values of $U_f \approx 2,868 \text{ W/m}^2\text{K}$, or $U_w \approx 1,67 \text{ W/m}^2\text{K}$, were achieved.

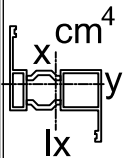
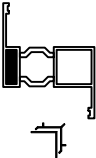
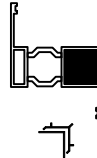
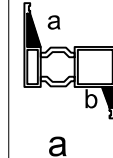
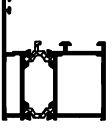
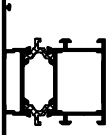
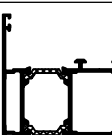
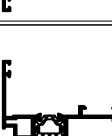
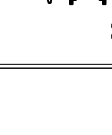
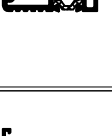
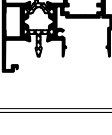
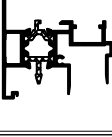
- Aluminium profiles were manufactured in Tehnomarket's own extrusion factory. The raw material used is primary aluminium alloy AlMgSi0.5 (AA6063 and 6060) with minimum tensile strength of 210KN/mm².
- 16mm wide Polyamide stripes (PA 6,6 with 25% glass fibers) connect inner and outer aluminium parts into finished profiles, and beside functioning as a mechanical bond they also provide a thermal break. Guaranteed shearing force for profiles connected with polyamide stripes is strictly controlled during production.
- Insulating performance of the complete system was confirmed through thermal performance testing. At the same time, wind load, air and water permeability and sound insulation were tested as well.
- System is compatible with both EURO 1 and EURO 16mm groove standards for hardware installation.
- System allows glass packages from 8 to 32mm with EPDM gaskets that feature integrated anti-blowing barrier.
- The triple sealing between frame and sash is achieved with three separate EPDM gaskets resistant to UV light.
- Corner joining with extruded patent or press clips is achieved through all profile chambers, thus guaranteeing secure and precise joints and finished element geometry.
- Drainage of condensed and incidental water is regulated via free flat surfaces in profile chambers, while ventilated outer chamber features optimal width of 20mm.
- Basic outer frame width of 65mm allows for an ideal mounting surface for optimal placement of mosquito net and roll-shutter's guides. Internal width of the frame provides an ideal space for tape coiler.

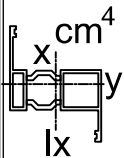
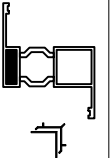
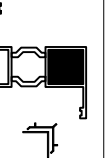
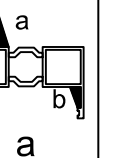
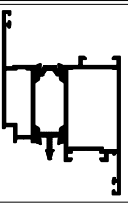
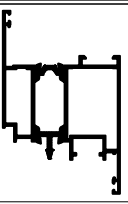
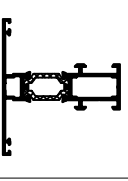
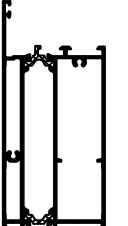
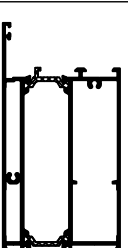
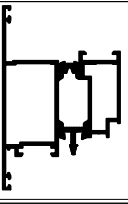
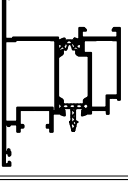
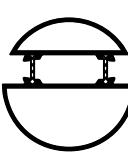
Техническое описание системы

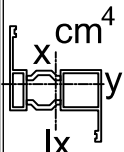
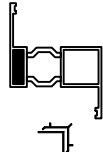
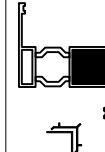
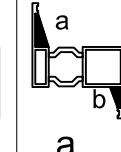
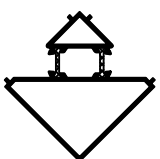
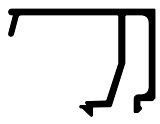
Система LINEAL ST 54 - одна из шести систем серии LINEAL и представляет систему алюминиевых профилей с термическим разрывом, специально разработанная для производства элементов окон и дверей с монтажной глубиной косяка от 54mm. Система разработана для удовлетворения современных требований в области энергоэффективности, как и другие необходимые условия для безопасного и комфортного рабочего и жилого пространства. При проектировании элементов системы, особое внимание было уделено выбору материалов, которые выполняют функцию теплового разрыва внутри профиля. Таким образом, достигнуты максимальные теплоизоляционные свойства $U_f \approx 2,868 \text{ W/m}^2\text{K}$, относительно $U_w \approx 1,67 \text{ W/m}^2\text{K}$.

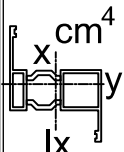
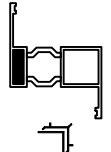
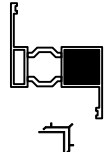
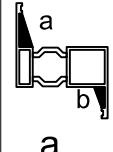
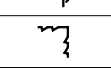
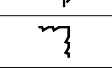
- Алюминиевые профили изготовлены способом экструзии в производственных цехах Техномаркета. Сырьем для производства профилей является первичный алюминиевый сплав с обозначением AlMgSi0,5 (AA6063 и 6060) и с минимальной прочностью на разрыв профиля 210KN/mm².
- Полиамидные полосы (PA 6,6 с 25% стекловолокна) шириной 16mm, взаимосвязывают внешние и внутренние алюминиевые части в готовых профилях, а кроме функции механического соединения и обеспечивают и тепловой разрыв. Гарантированная сила сдвига внешнего и внутреннего алюминиевого профиля, которые связаны полиамидными полосками, контролируется в процессе производства.
- Изоляционные свойства системы подтверждены результатами испытания тепловых характеристик. Кроме того, были проведены испытания устойчивости на удары ветра, пропуск воздуха и воды, как и звукоизоляции.
- Система позволяет установку стандартных оков в EURO 1 желоб и оков для PVC в EURO 16mm желоб.
- Система поддерживает и заполнения, включая и стеклопакеты от 8 до 32mm, с EPDM прокладками, которые имеют интегрированный барьер против выдувания.
- Уплотнение в зонах соединений косяка и створки - трехрядное, с тремя постоянно упругими прокладками EPDM, которые устойчивы к UV-излучению.
- Сцепление углов, с помощью экструдированных сцепных устройств или сцепных устройств для прессовки, обеспеченное затяжкой во всех камерах профиля, что обеспечивает надежное соединение углов и точную геометрию готовых элементов.
- Направление конденсации и случайных вод регулируется через свободные ровные поверхности в камерах, в то время как вентилируемая внешняя камера имеет глубину 20mm.
- Основной внешний размер косяка от 65mm позволяет идеальный прием направляющей жалюзи и противомоскитных сеток. Внутренняя ширина косяка обеспечивает идеальное место для коллектора полосок жалюзи.

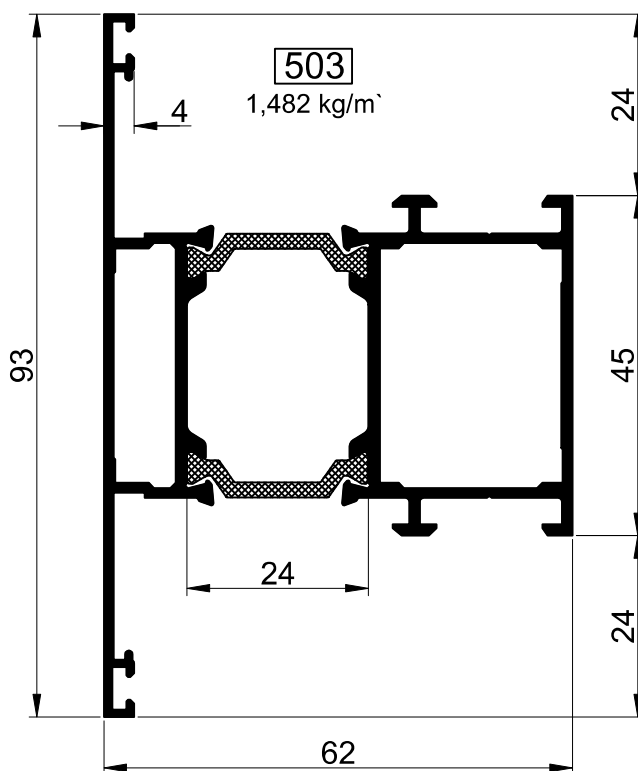
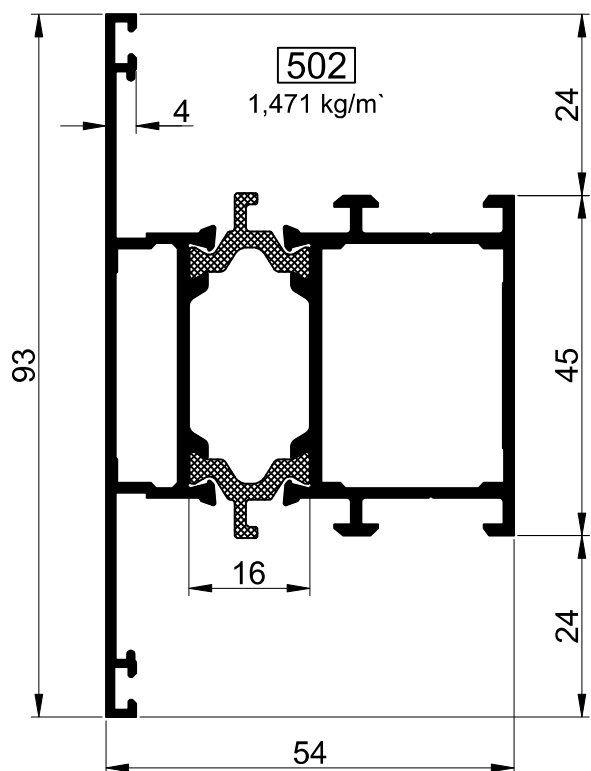
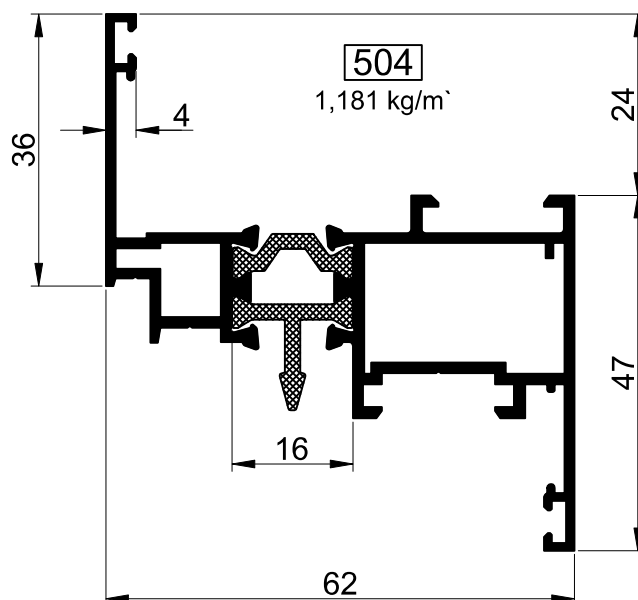
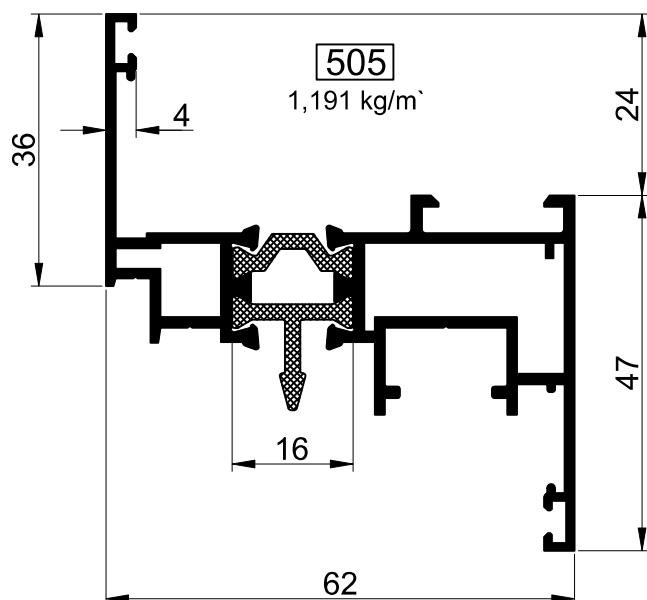
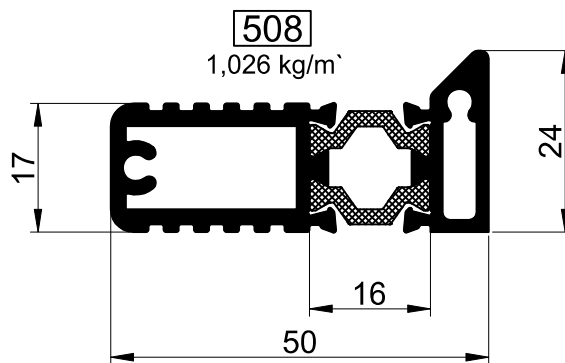
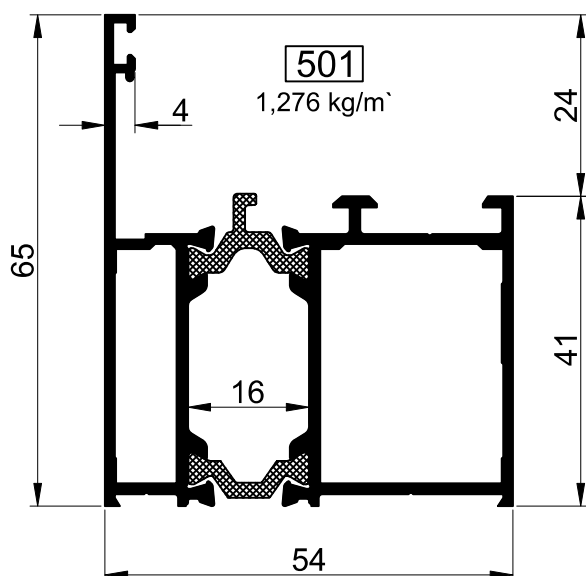


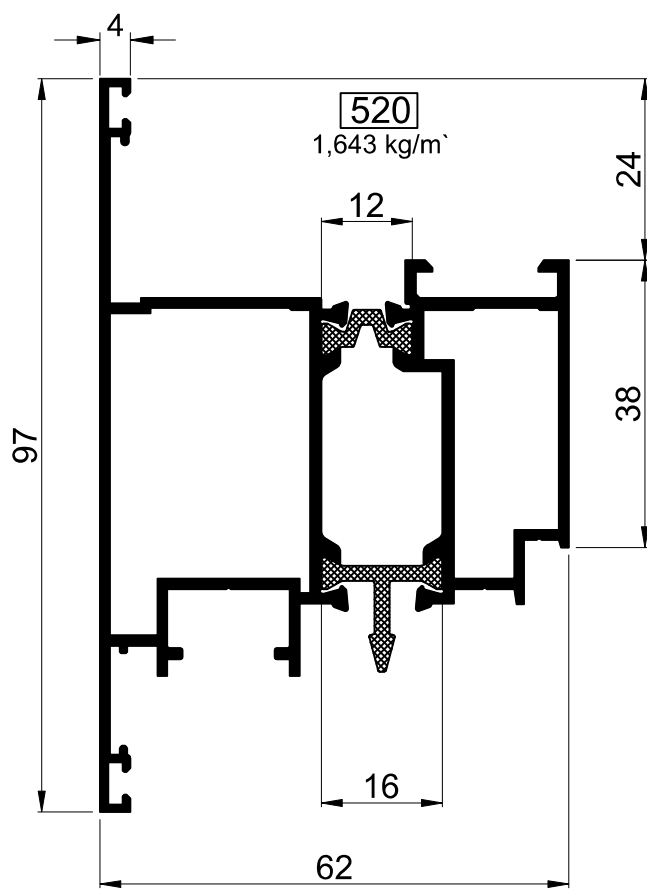
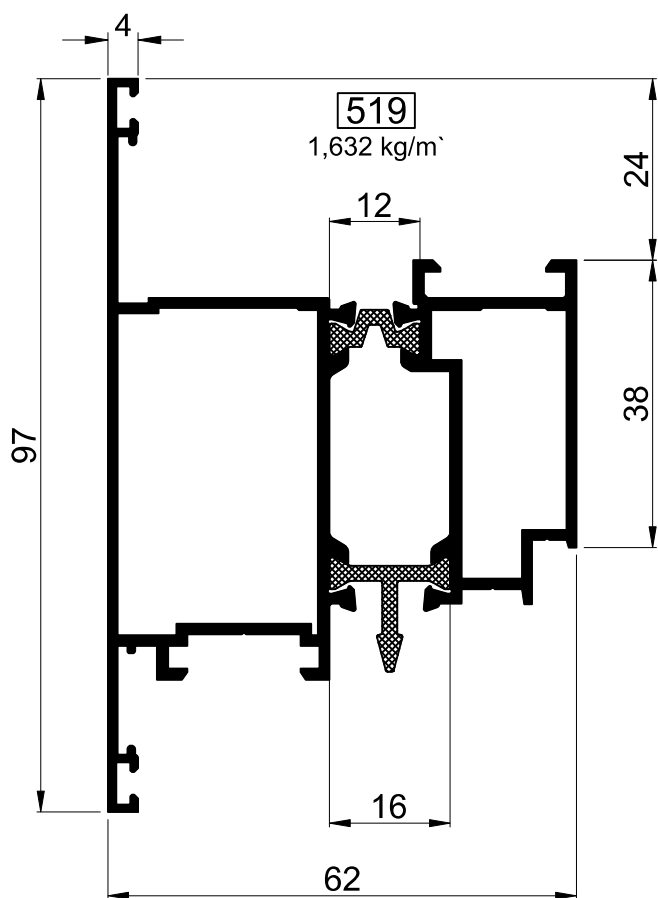
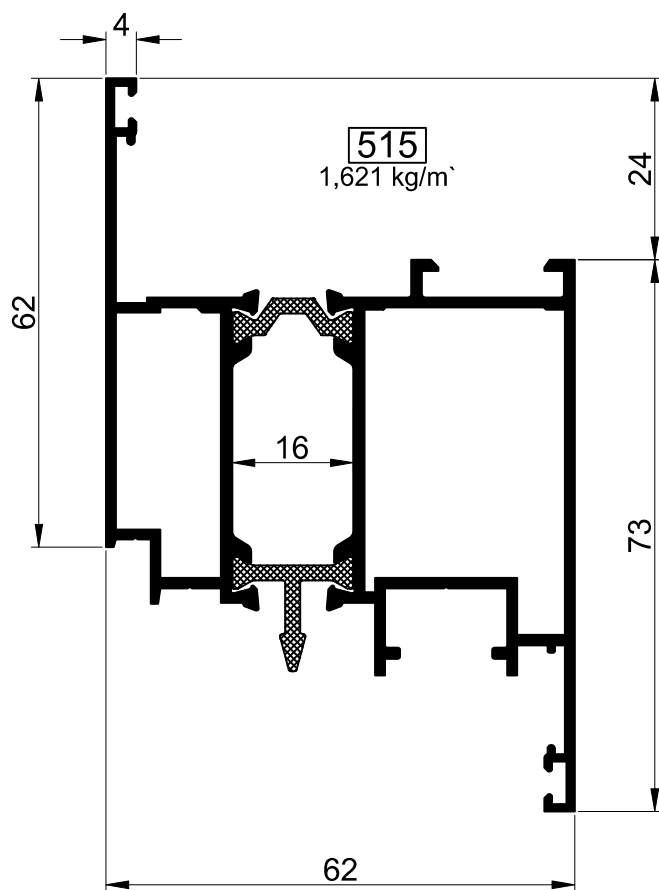
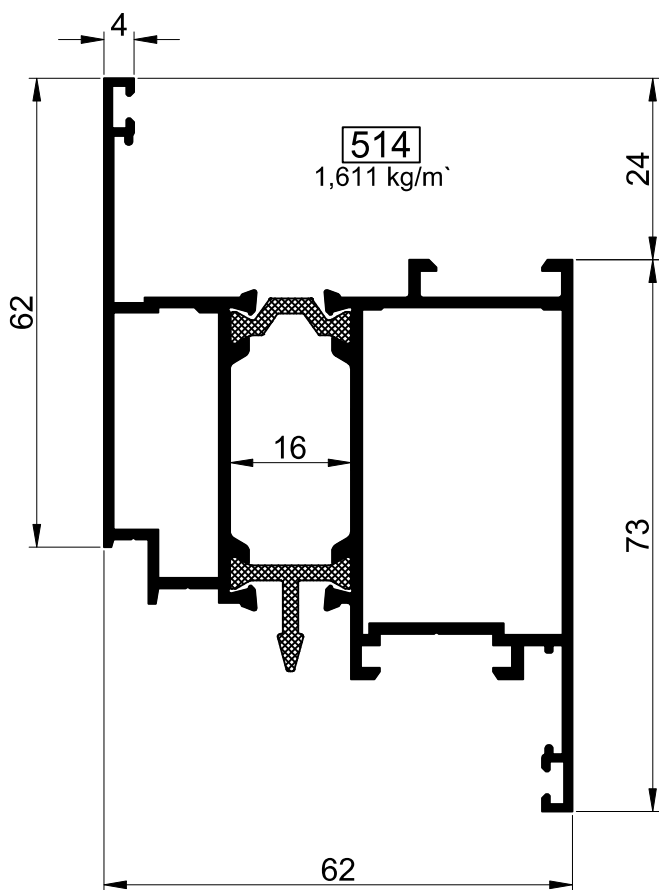
	Oznaka Mark Марк	Opis Description Описание	 cm ⁴			 a b
	kg/m`		ly			
	501	Štok Frame	16,001	911	908	920
	1,276	Рама	10,158	925	923	
	502	Prečka u štoku T profile in frame	19,971		915	
	1,471	T профилъ в раме	18,699		905	
	503	Prečka u krilu T profile in casement	25,420		915	
	1,482	T профилъ в створки	18,699		905	
	504	Prozorsko krilo - EURO 1 Casement -EURO 1	21,630	909	907	920
	1,181	Оконная створка -ЕУРО 1	4,020	929	926	TMA18
	505	Prozorsko krilo - EURO 16mm Casement -EURO 16mm	21,185	909	906	920
	1,191	Оконная створка -ЕУРО 16мм	3,784	929	928	TMA18
	508	Prag Threshold	9,670			
	1,026	Порог	1,352			
	509	Veza dvokrilnog prozora - EURO 1 French casement adaptor -EURO 1	13,441			
	1,162	Соединительный профиль двойног окна -ЕУРО 1	6,048			
	510	Veza dvokrilnog prozora - EURO 16mm French casement adaptor -EURO 16mm	13,096			
	1,164	Соединительный профиль двойног окна -ЕУРО 16мм	6,257			
	513	Prečka u štoku T profile in frame	13,039		922	
	1,104	T профилъ в рамке	6,652		905	

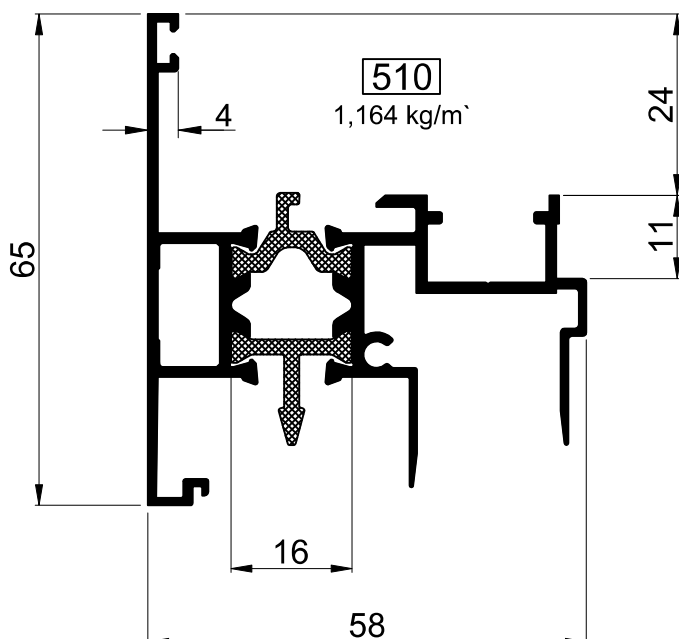
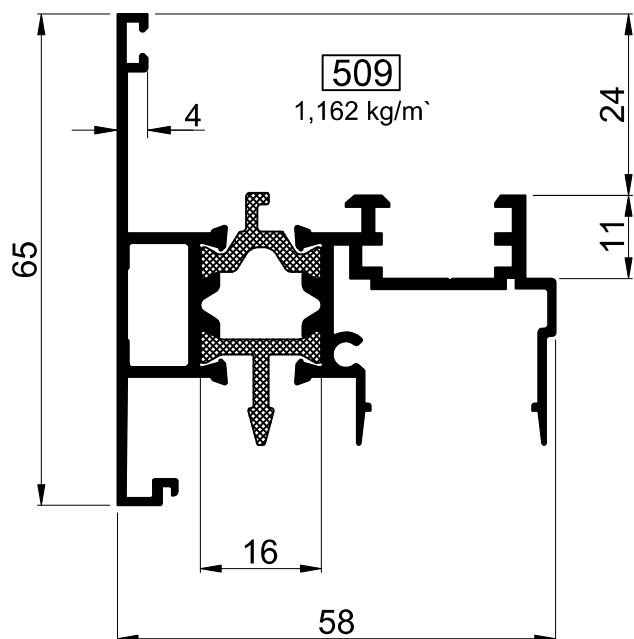
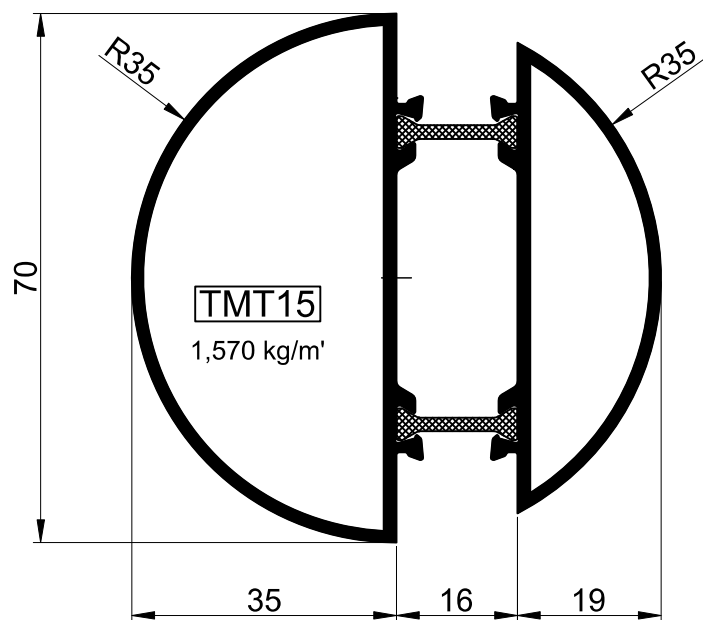
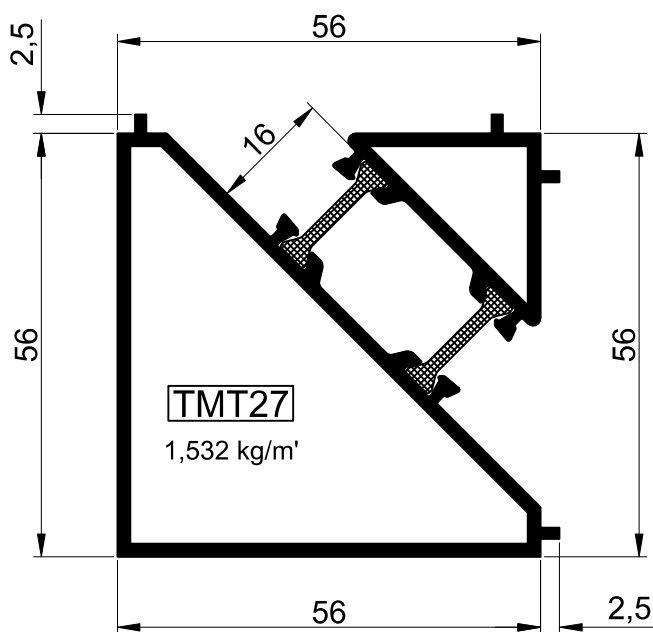
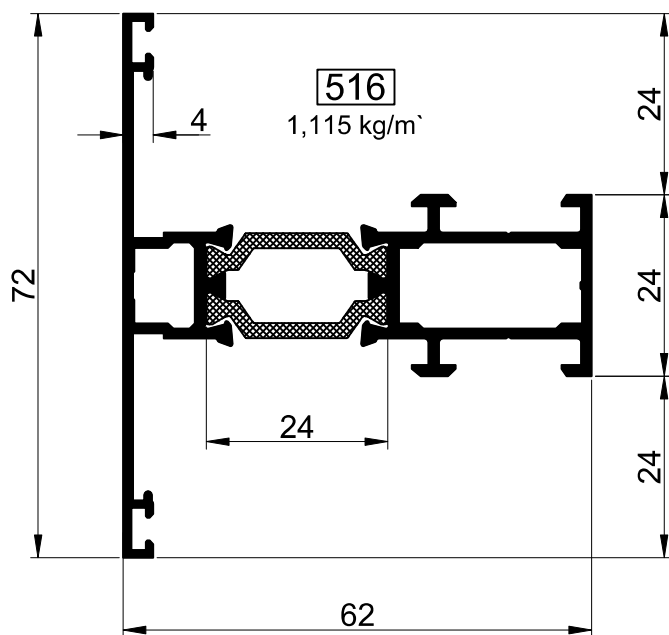
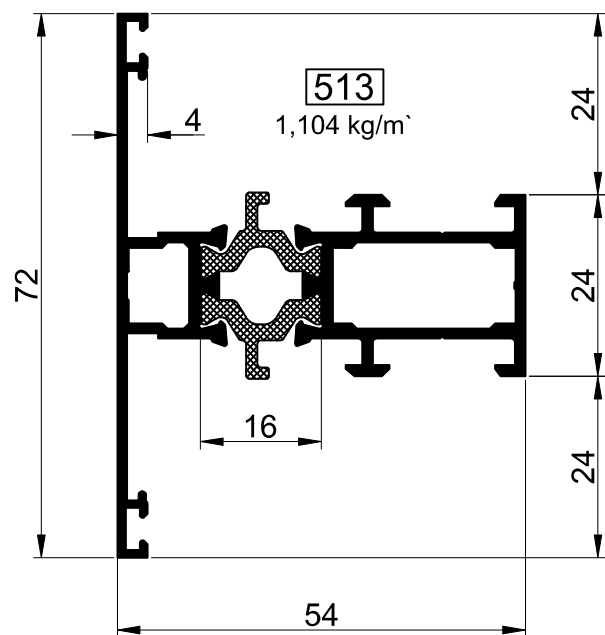
	Oznaka Mark Марк	Opis Description Описание				
	kg/m`		ly			b
	514	Krilo vrata -otvaranjem unutra- EURO 1 Door leaf -open in -EURO 1	35,506	939	940	920
	1,611	Крыло двери, открывающиеся внутрь -ЕУРО1	14,960	930	932	TMA18
	515	Krilo vrata -otvaranjem unutra- EURO 16mm Door leaf -open in -EURO 16mm	35,345	939	941	920
	1,621	Крыло двери, открывающиеся внутрь -ЕУРО16мм	14,626	930	931	TMA18
	516	Prečka u krilu T profile in casement	18,516		922	
	1,115	Препятствие в створки	6,652		905	
	517	Parapetni profil u štoku / Veliki štok Parapet profile in frame / Large frame	27,517	911	908	920
	2,232	Парапет профиль в рамке большой рам	83,484	925	923	
	617	Parapetni profil u krilu Parapet profile in casement	38,921		915	
	2,270	Парапет профиль в створки	83,565		905	
	519	Krilo vrata -otvaranjem spolja- EURO 1 Door leaf -open out -EURO 1	22,636	939	940	920
	1,632	Крыло двери, открывающиеся наружу -ЕУРО1	27,337	930	932	TMA18
	520	Krilo vrata -otvaranjem spolja- EURO 16mm Door leaf -open out -EURO 16mm	27,161	939	942	920
	1,643	Крыло двери, открывающиеся наружу -ЕУРО16мм	22,203	930	933	TMA18
	TMT15	Ugaoni profil Angle connector	21,399			
	1,619	Угловой профиль	22,589			

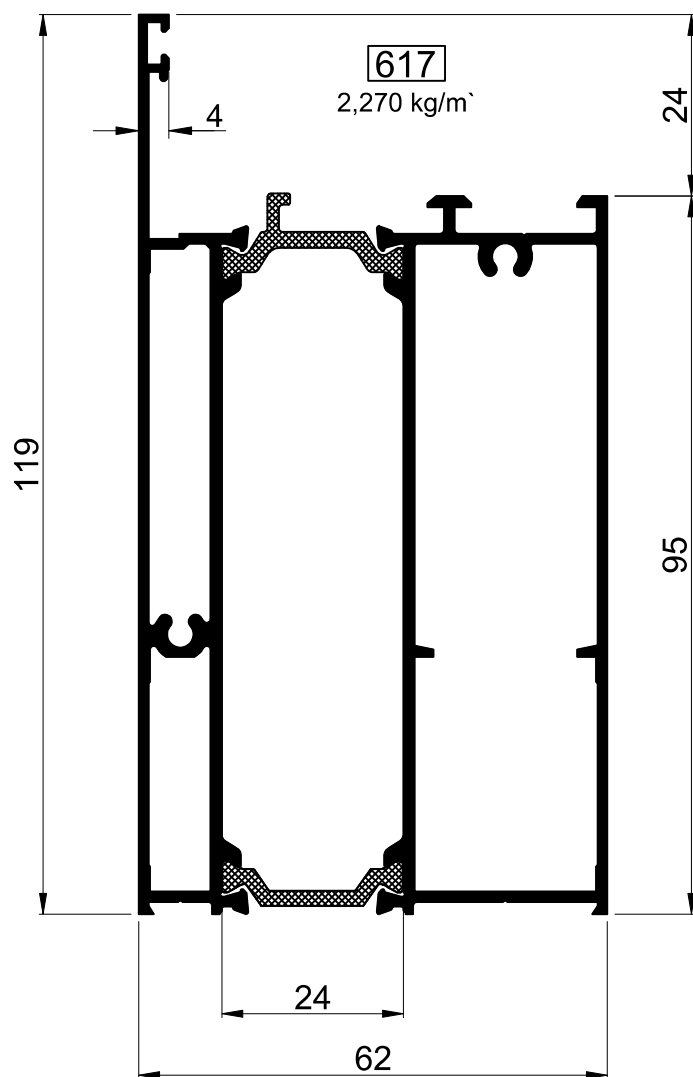
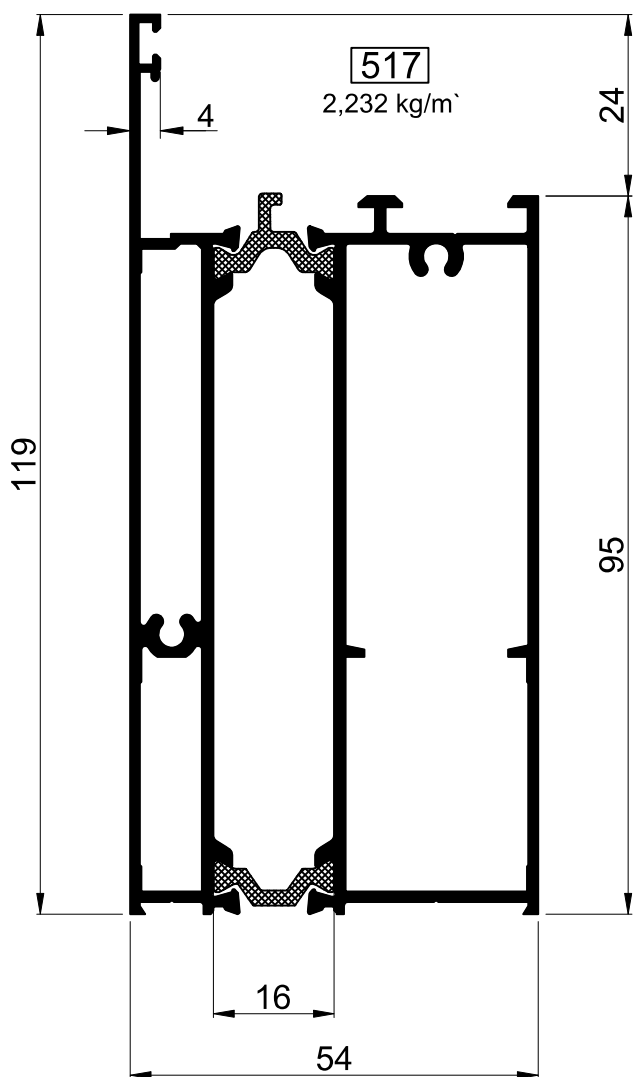
	Oznaka Mark Марк	Opis Description Описание	 cm ⁴			 a b
	TMT27	Ugaoni profil -90° Angle connector -90°	20,907			
	1,665	Угловой профиль - 90°	19,409			
	106	Držáč stakla -16,5mm Glazing bead -16,5mm				
	0,302	Подстаканник -16,5мм				
	116	Držáč stakla -20,5mm Glazing bead -20,5mm				
	0,320	Подстаканник -20,5мм				
	100	Držáč stakla -24,5mm Glazing bead -24,5mm				
	0,330	Подстаканник -24,5мм				
	117	Držáč stakla -28,5mm Glazing bead -28,5mm				
	0,348	Подстаканник -28,5мм				
	101	Držáč stakla -32,5mm Glazing bead -32,5mm				
	0,359	Подстаканник -32,5мм				
	108	Držáč stakla -38,5mm Glazing bead -38,5mm				
	0,380	Подстаканник -38,5мм				
	109	Mali slivnik Waterdrip				
	0,035	Капельник				
	110	Opšivni profil Casing profile				
	0.119	Обшивка				

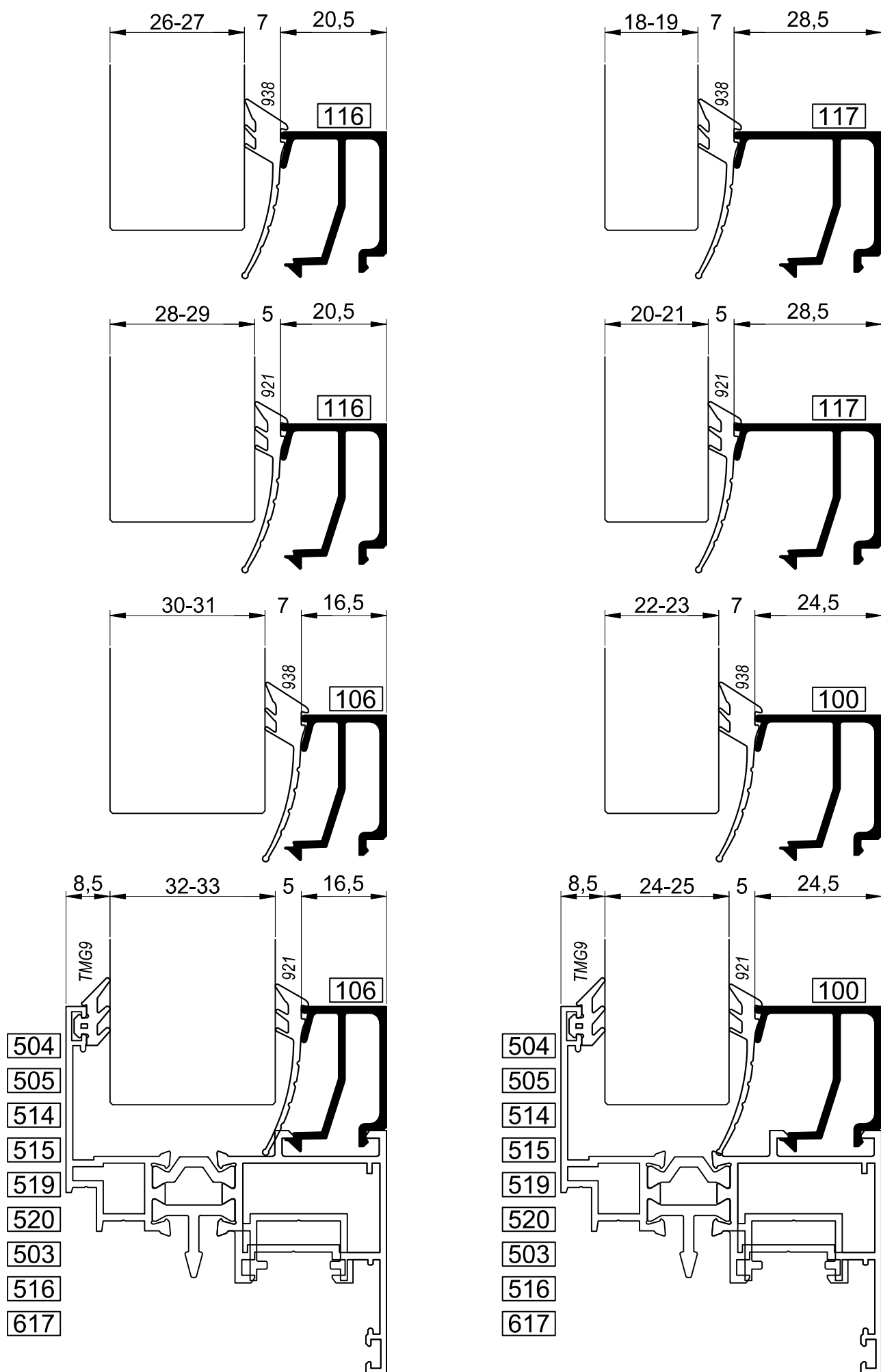
	Oznaka Mark Марк	Opis Description Описание				
	kg/m`		ly			a b
	TM33	Pogonska letva Mechanism rod				
	0,152	Стержень для механизма				
	TM36	Slivnik Waterdrip				
	0,177	Капельник				
	TM42	Slivnik i nosač četkice Waterdrip				
	0,272	Капельник				
	TM43	Nosač četkice Brush holder				
	0,130	Держатель щетки				
	TM80	Modularni stub Modular mullion	19,853			
	0,946	Модульный колонка	5,102			
	TM81	Modularni stub Modular mullion				
	0,102	Модульный колонка				

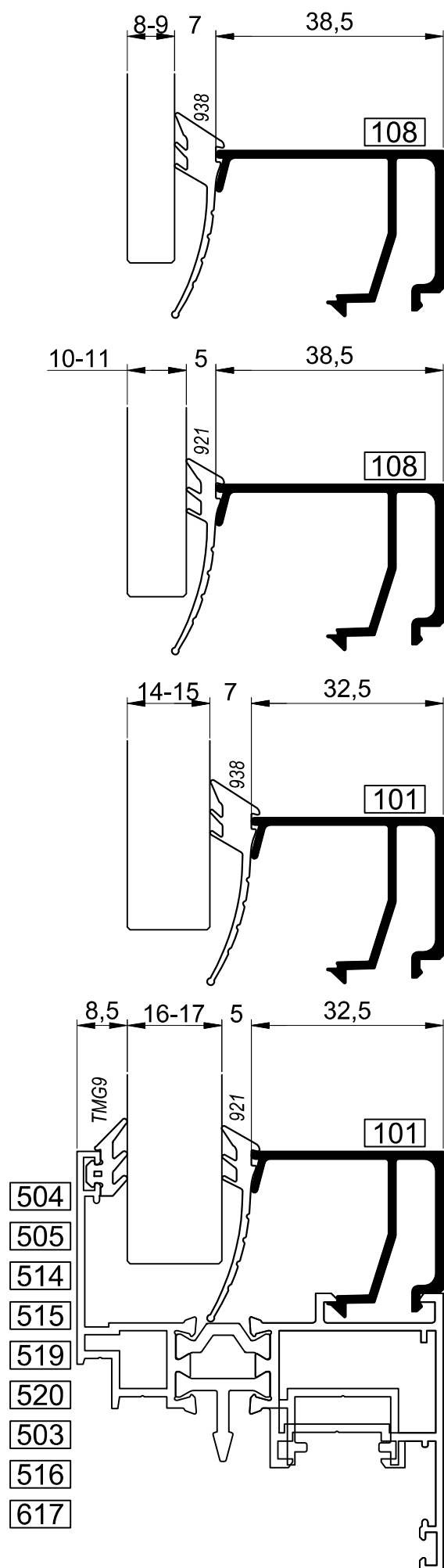


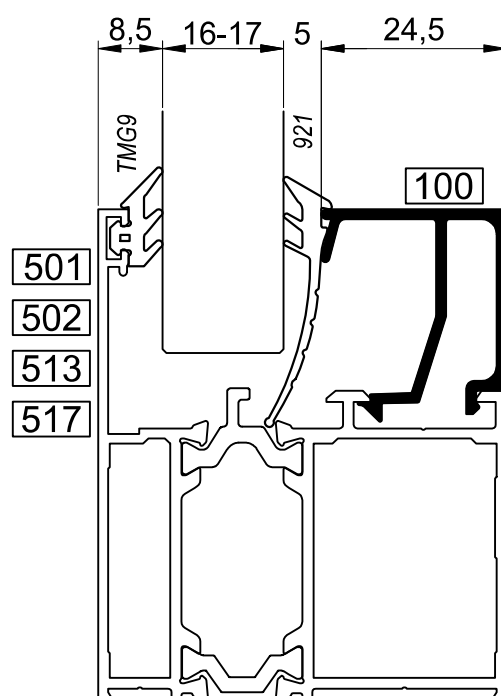
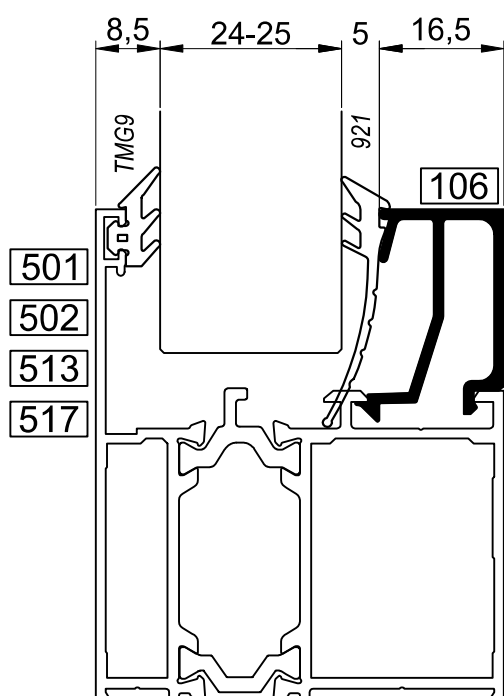
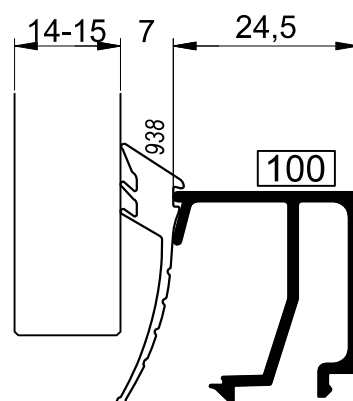
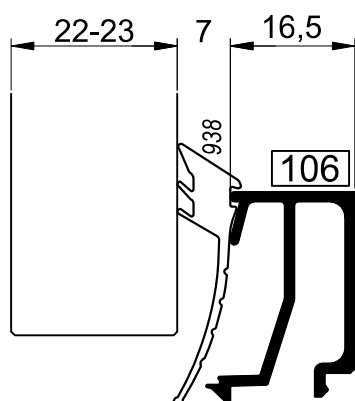
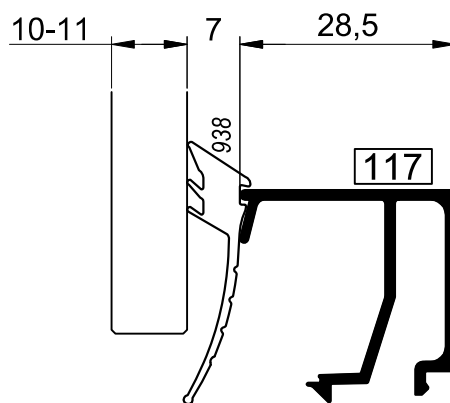
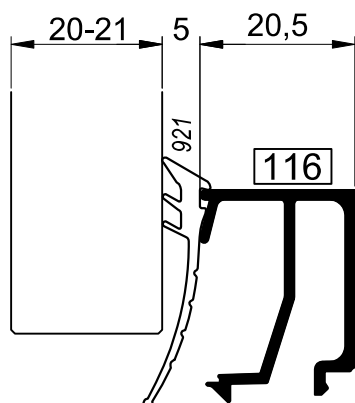
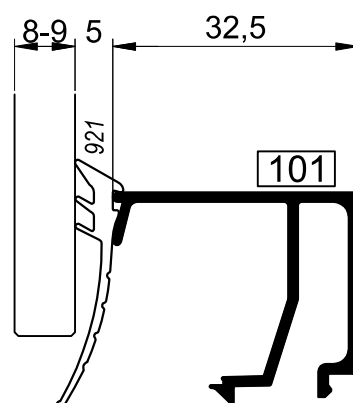
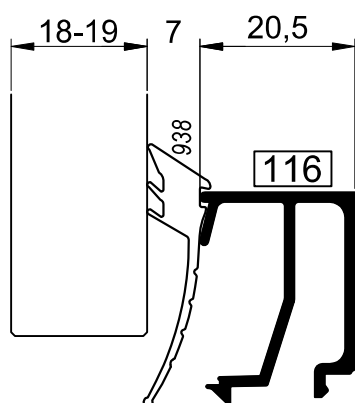


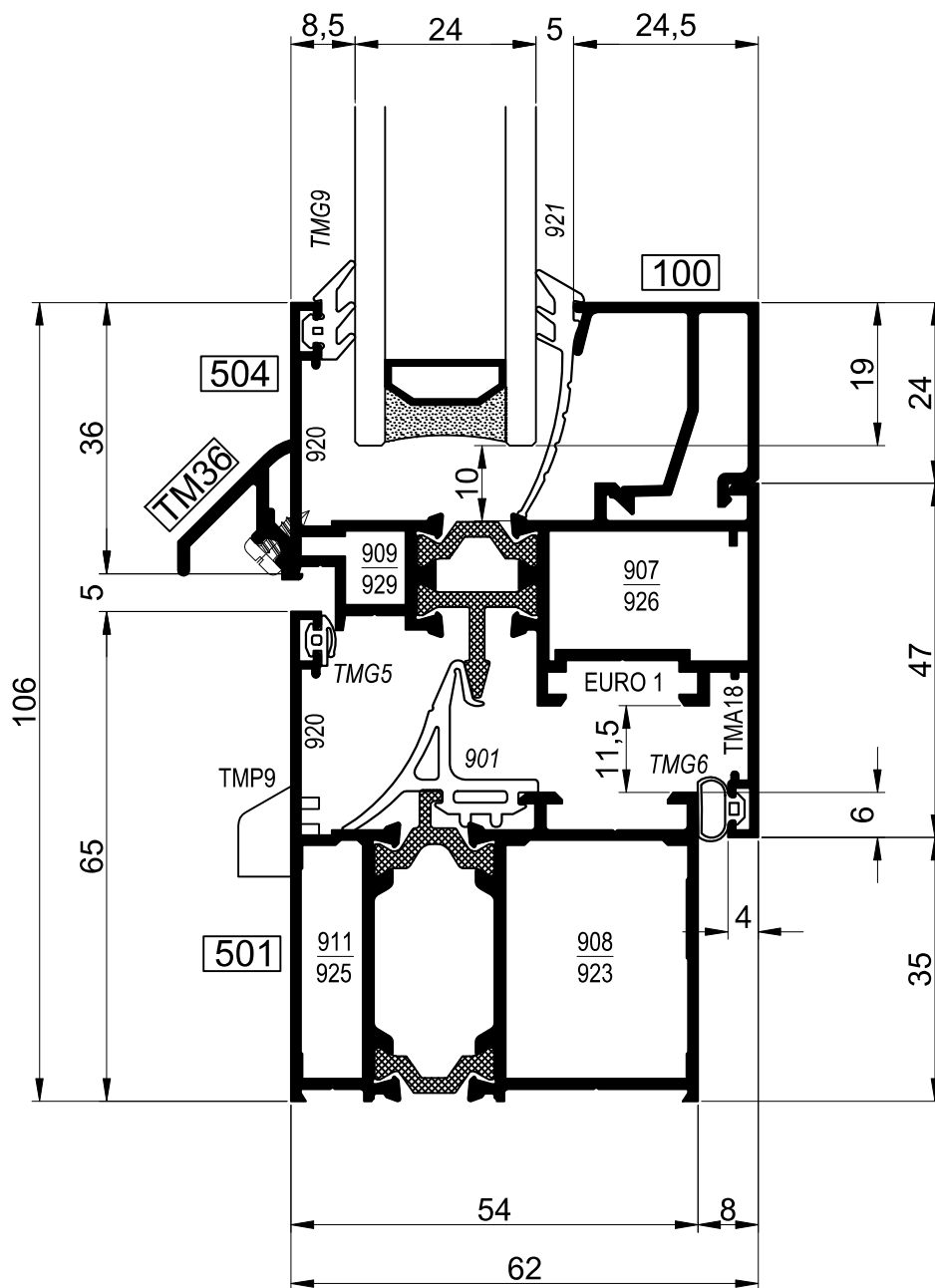
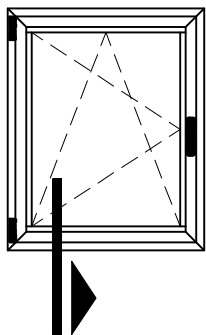


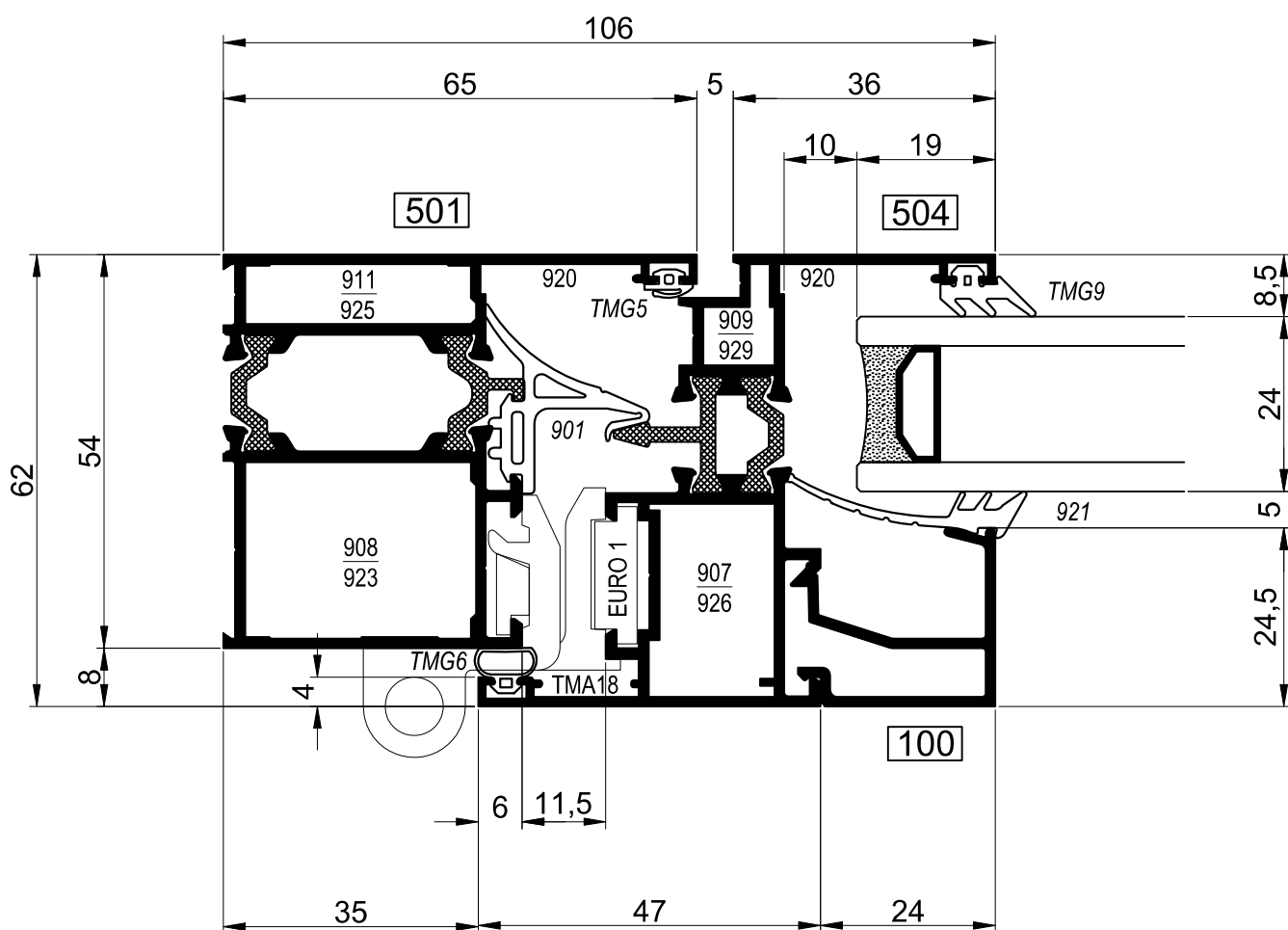
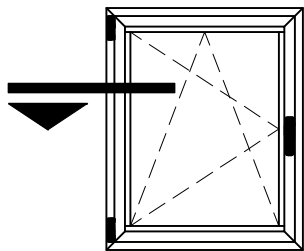


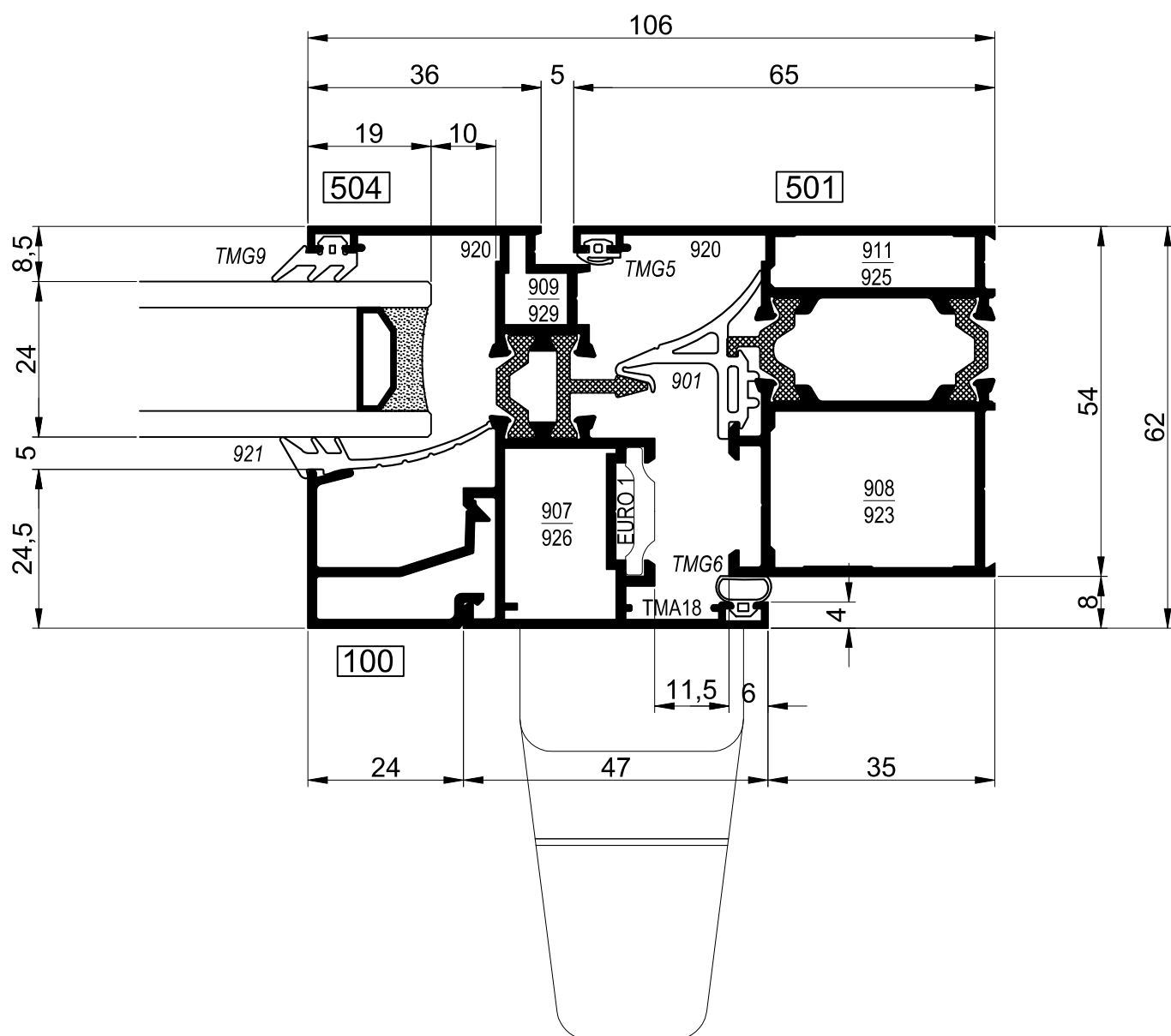
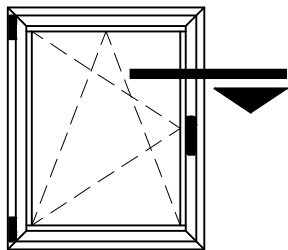


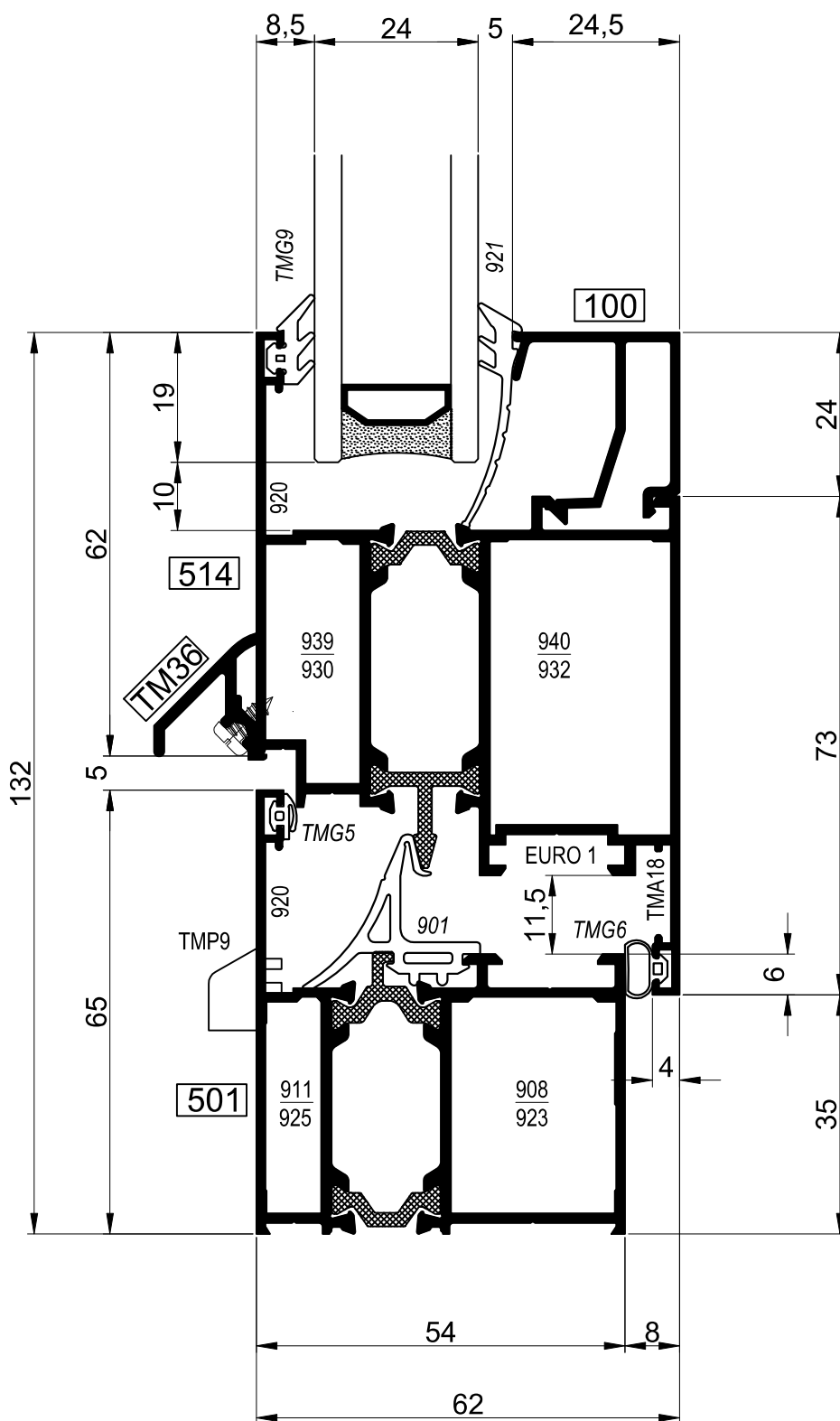
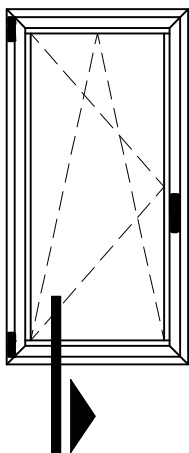


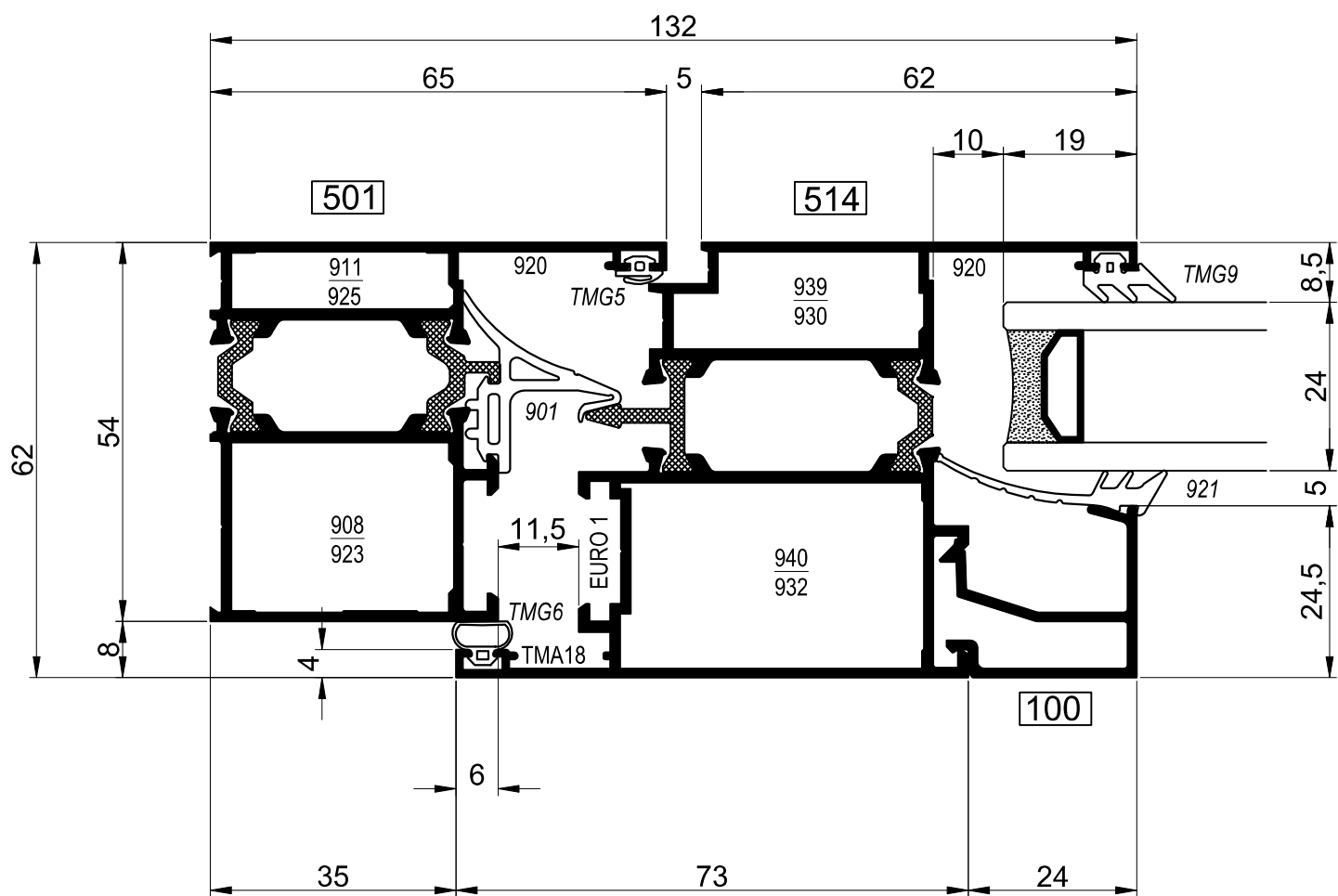
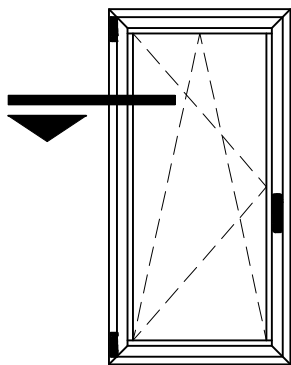


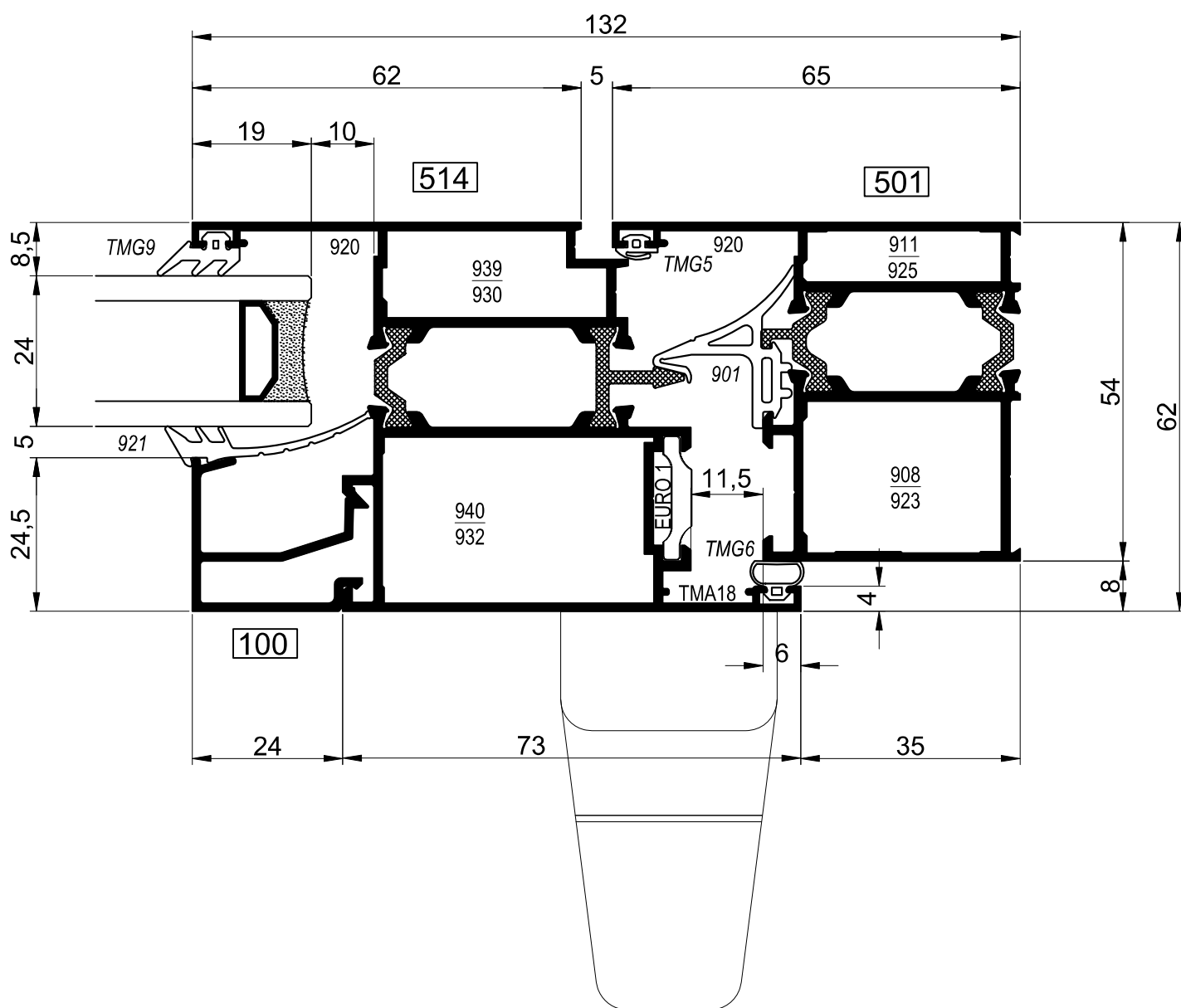
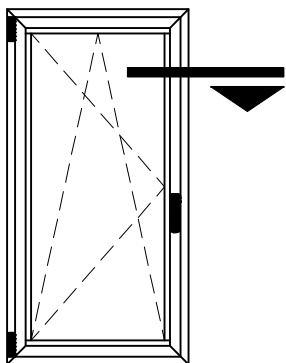


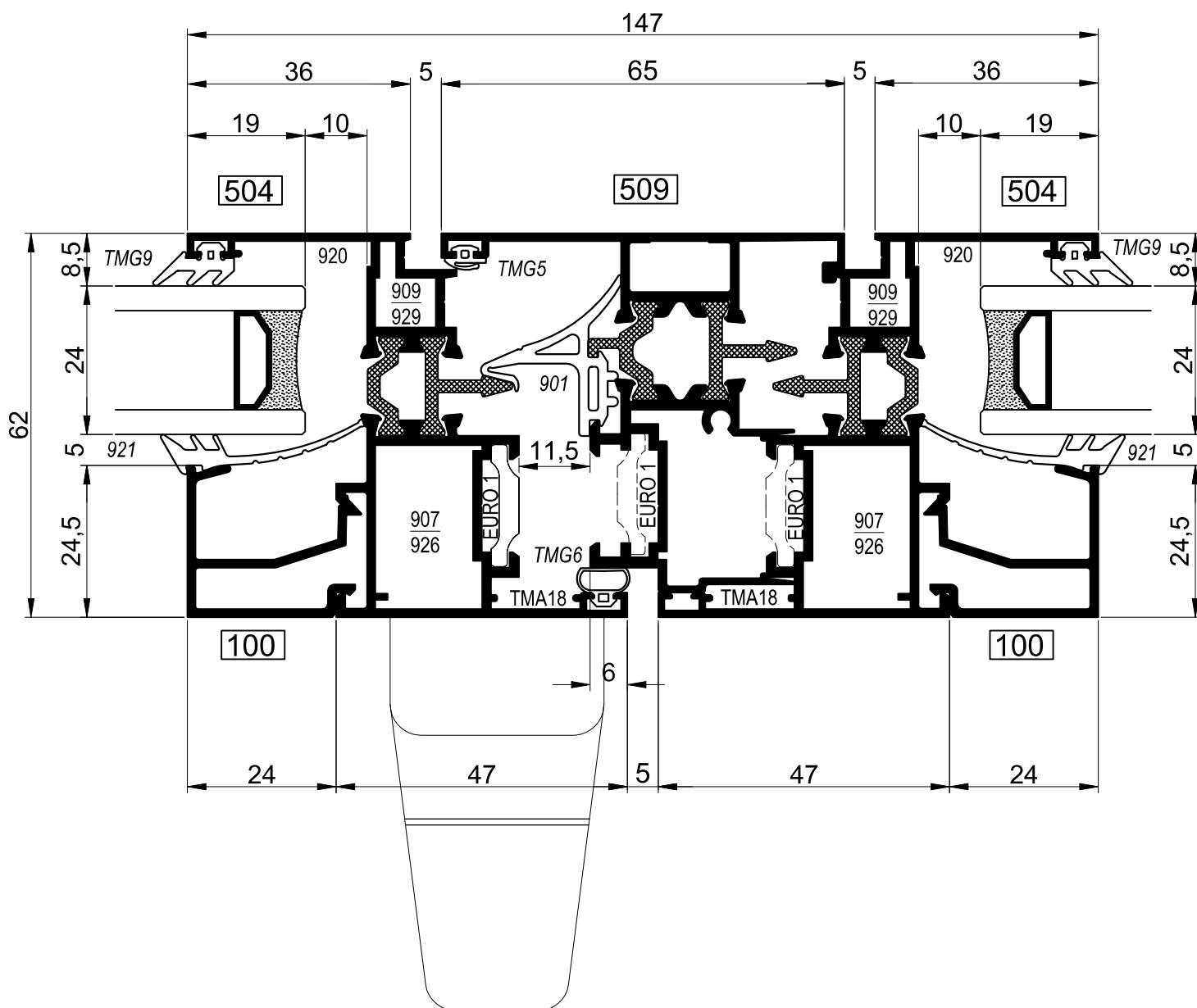
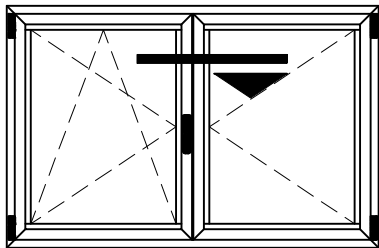




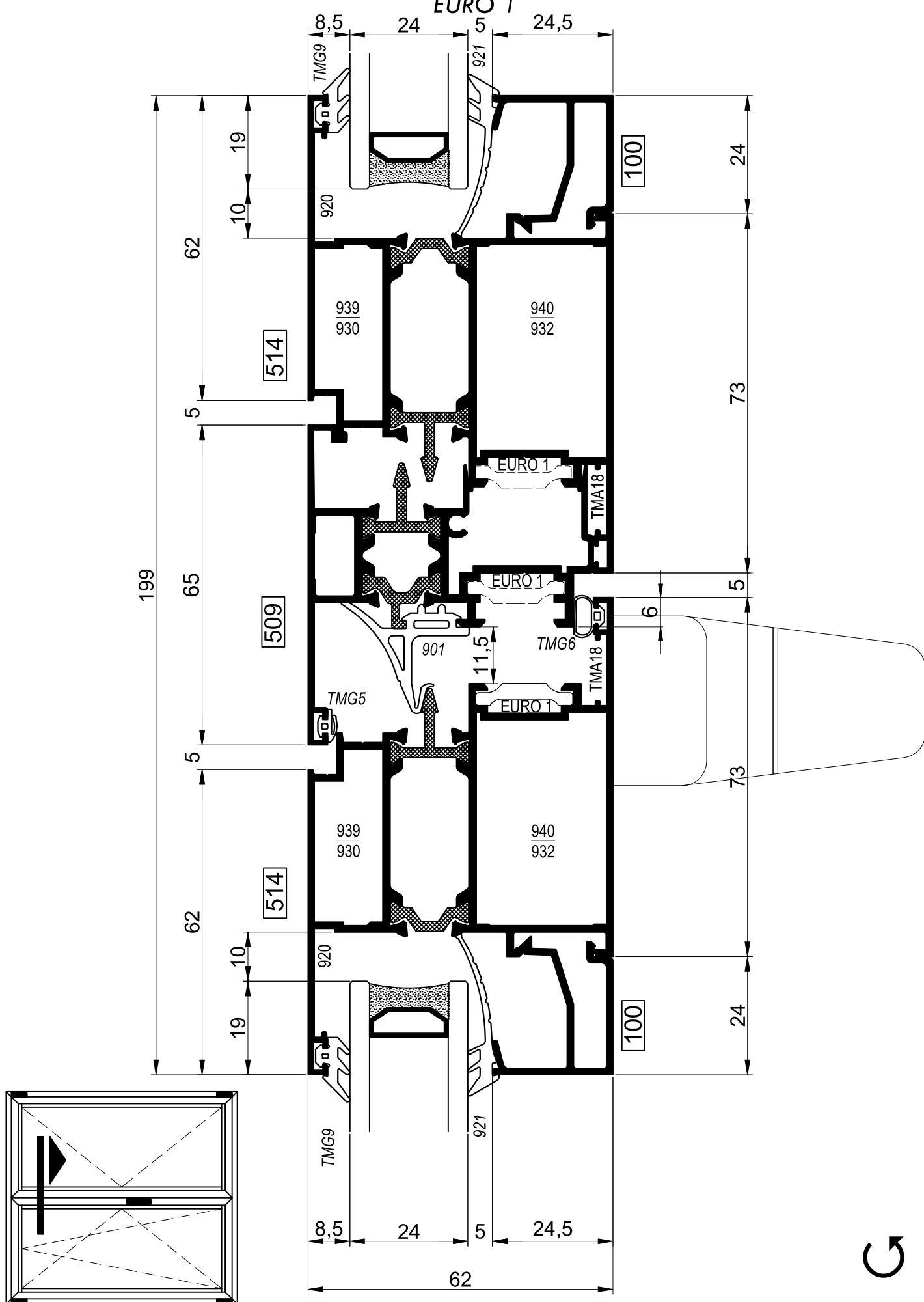


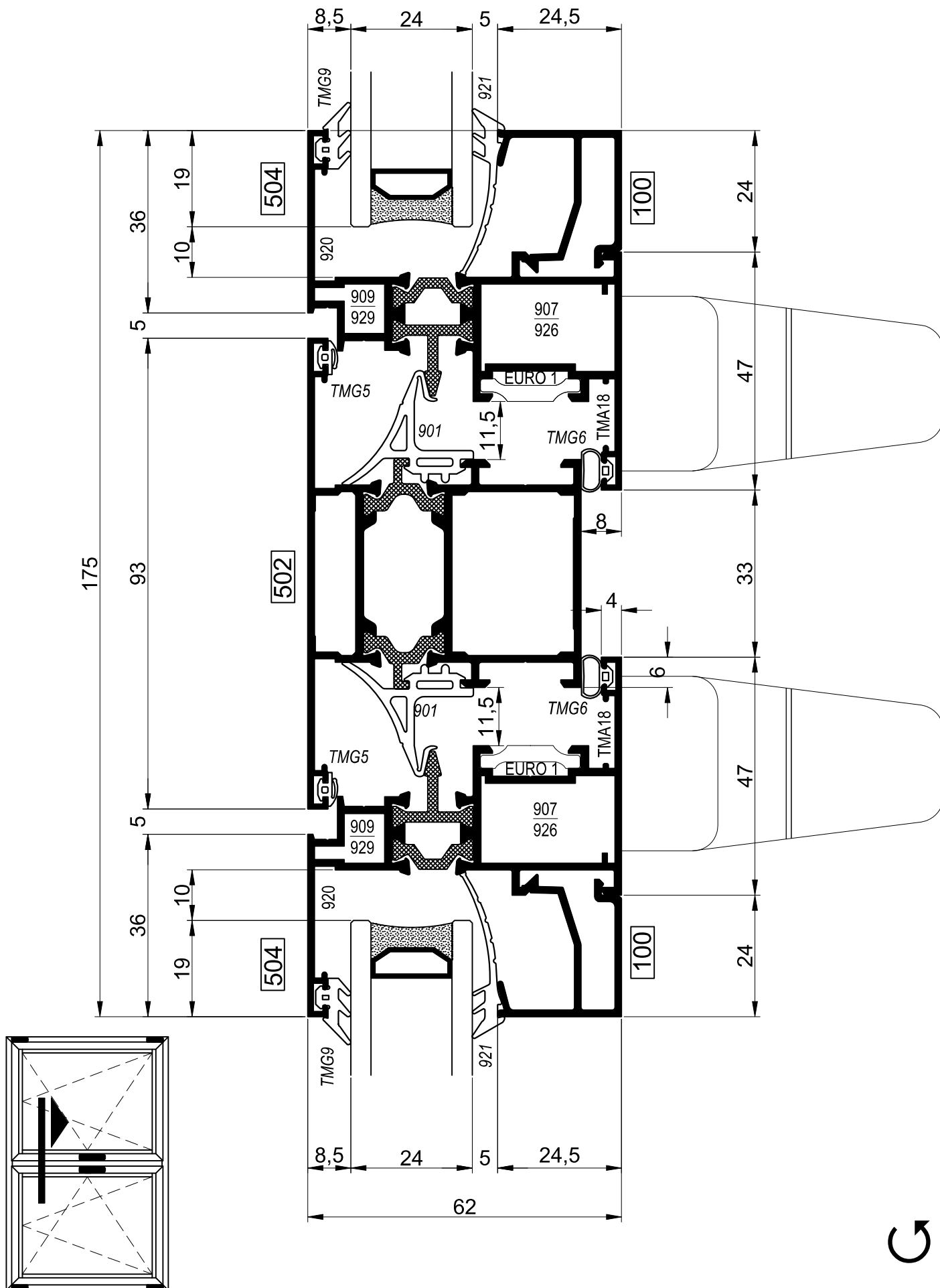


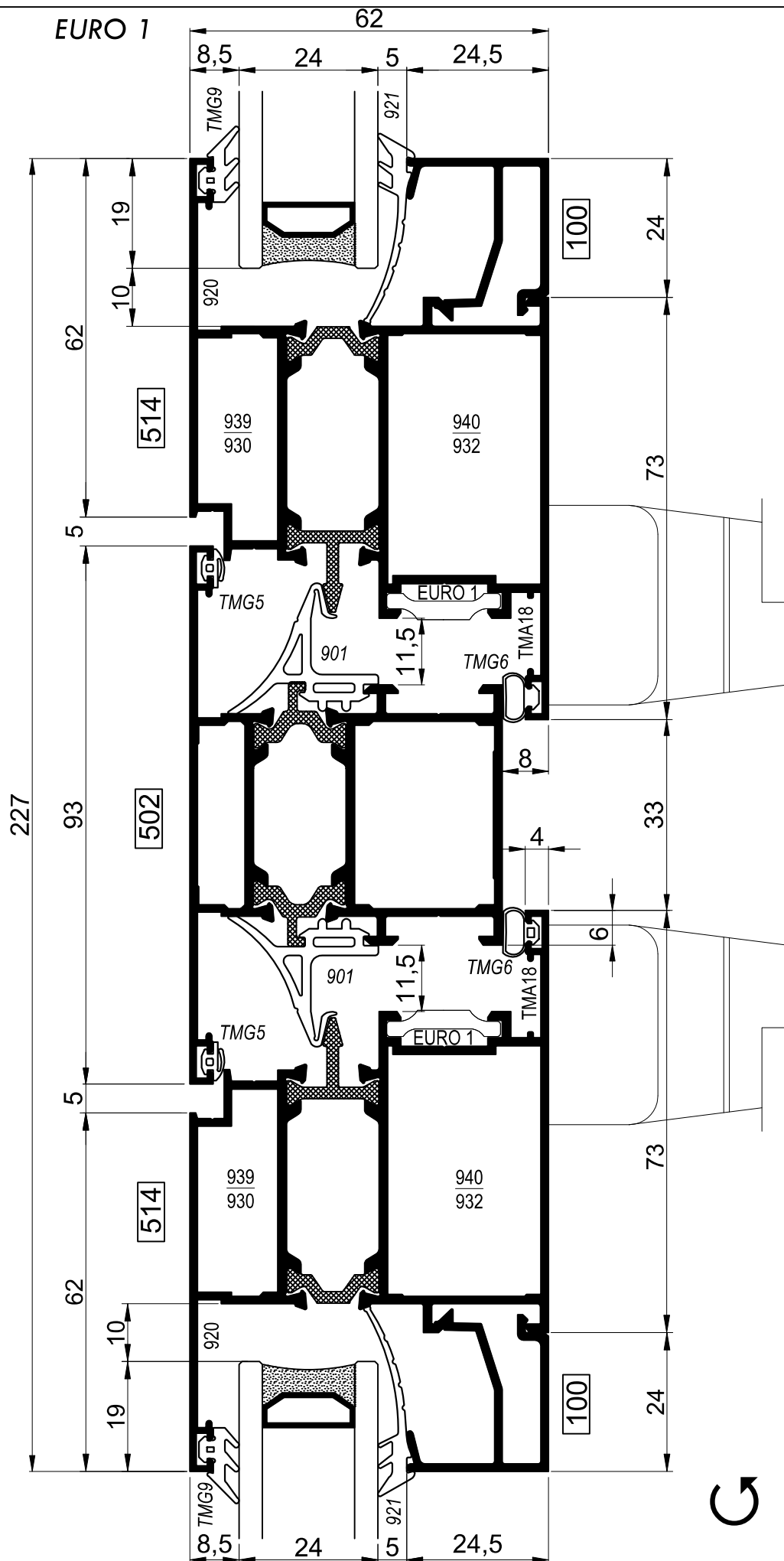
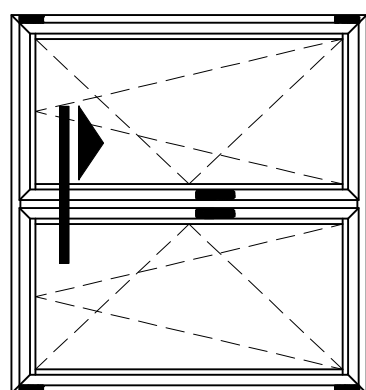


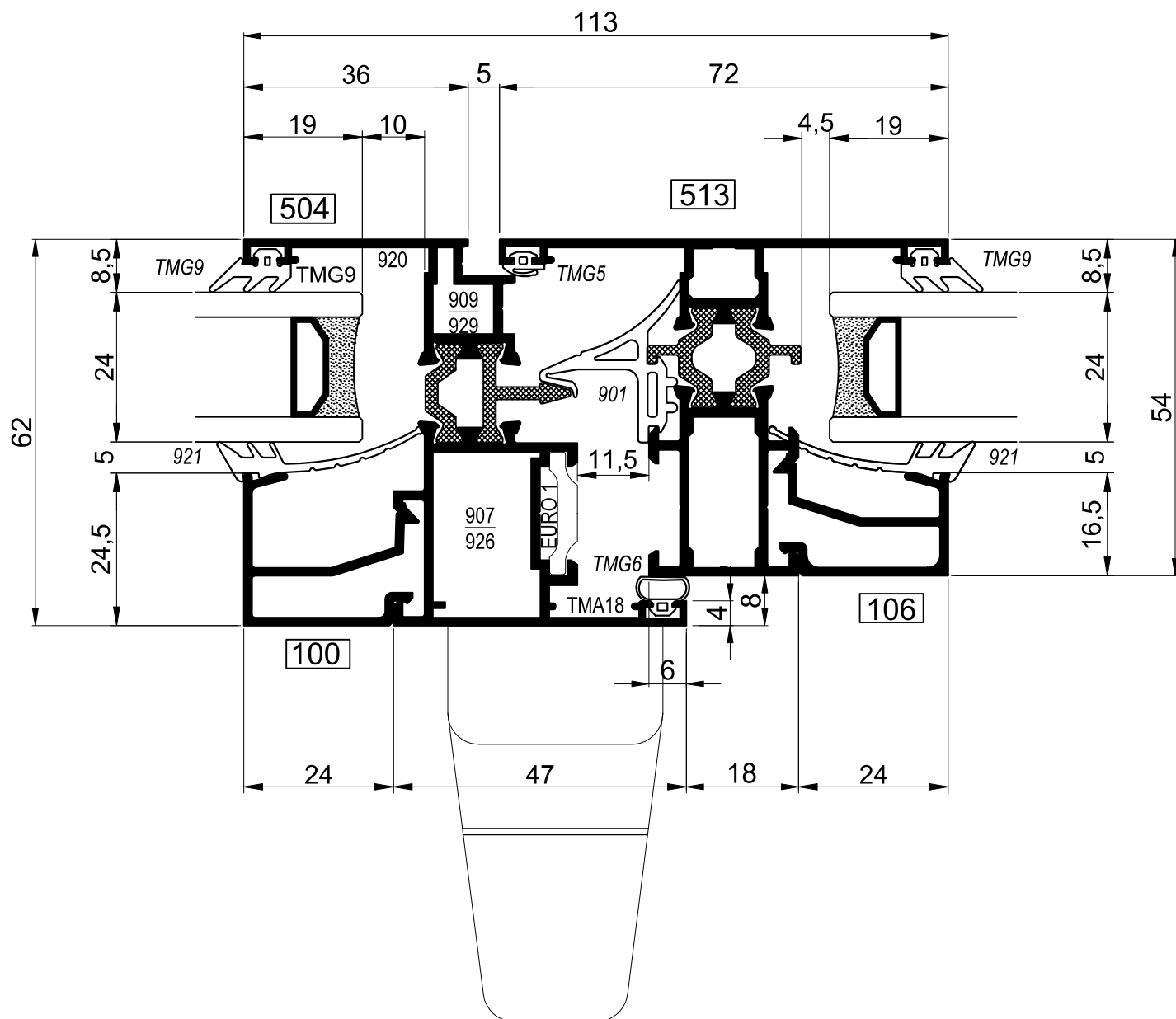
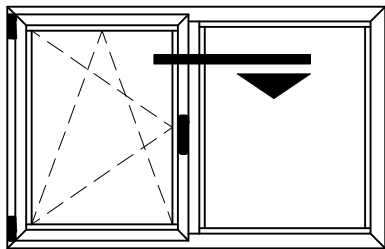


EURO 1

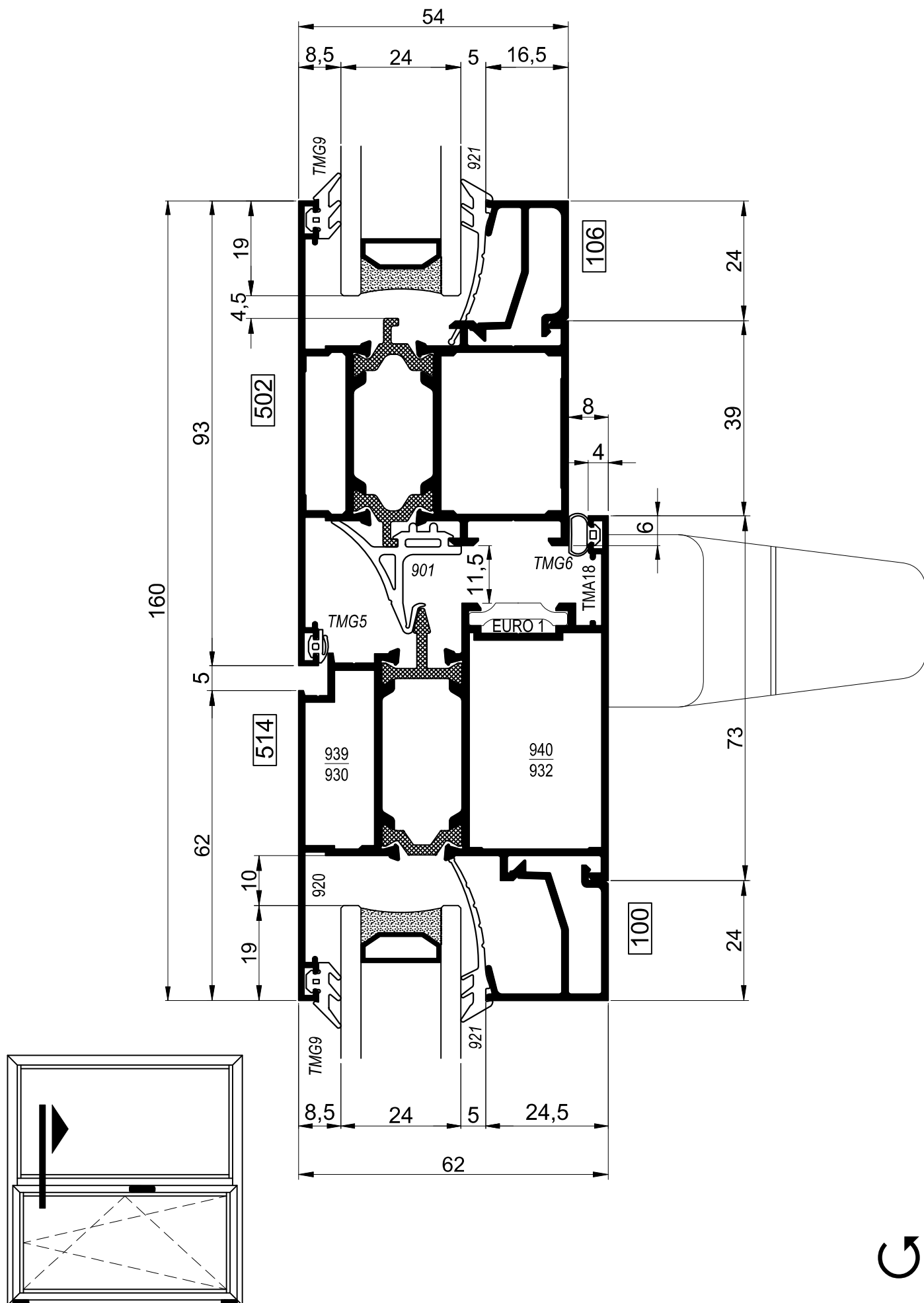


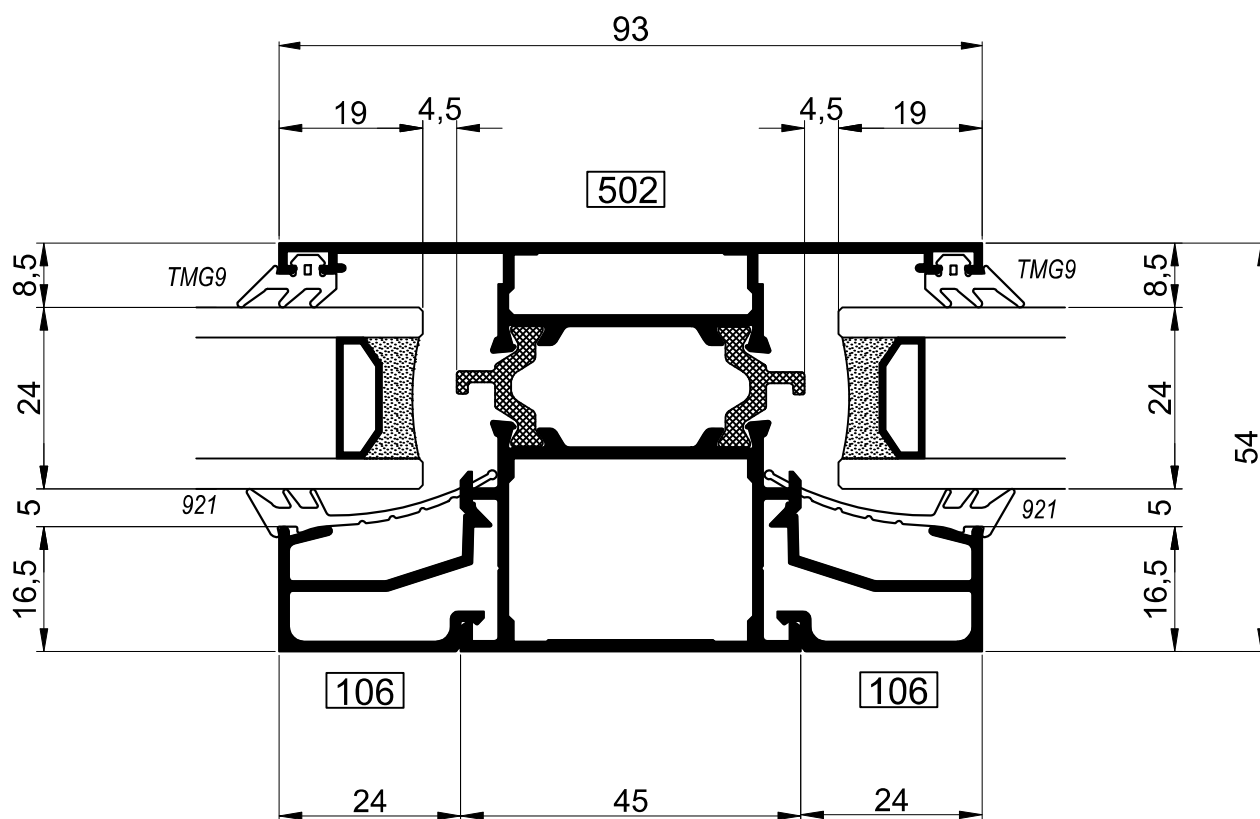
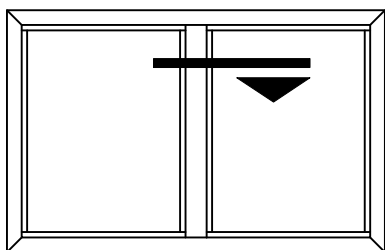


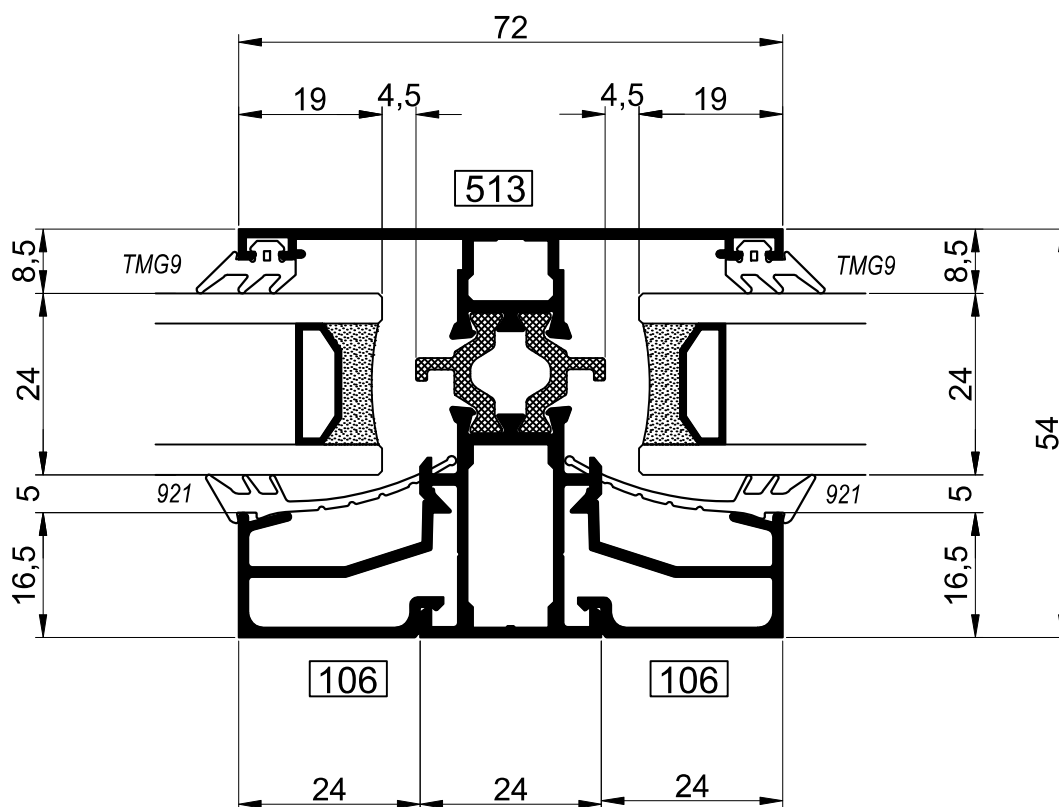
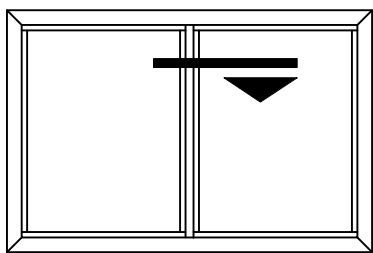


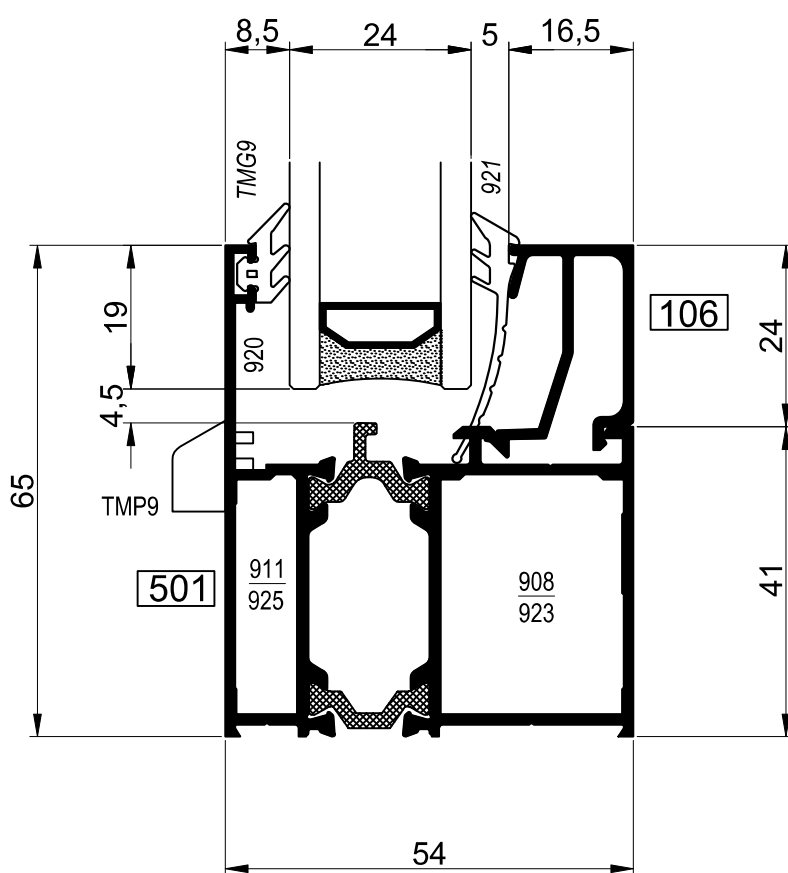
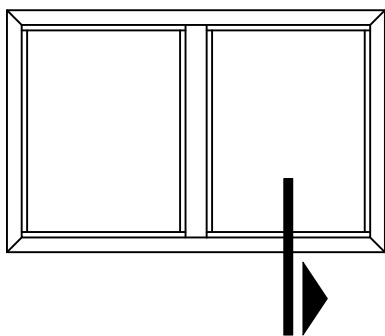


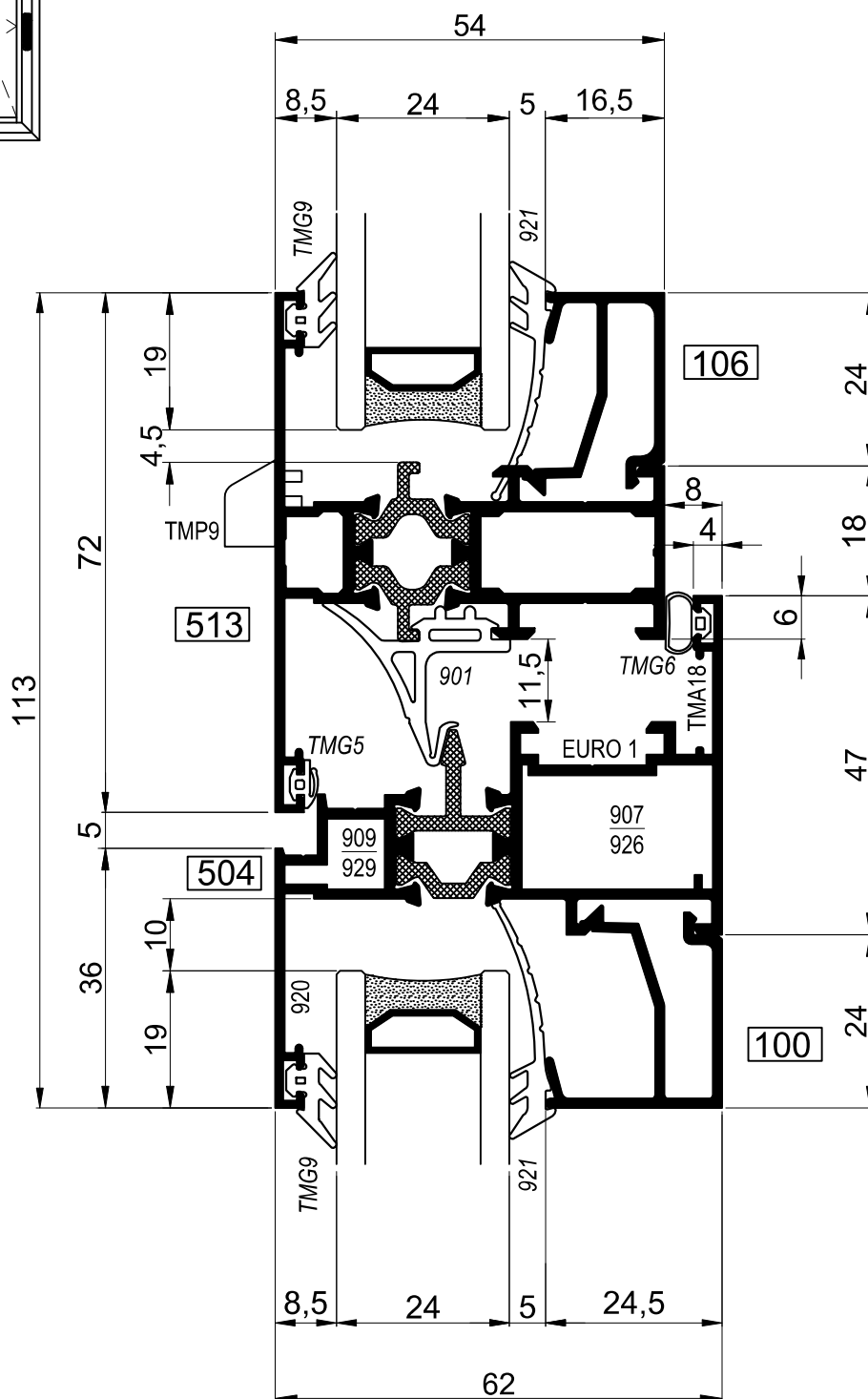
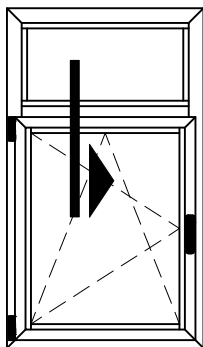
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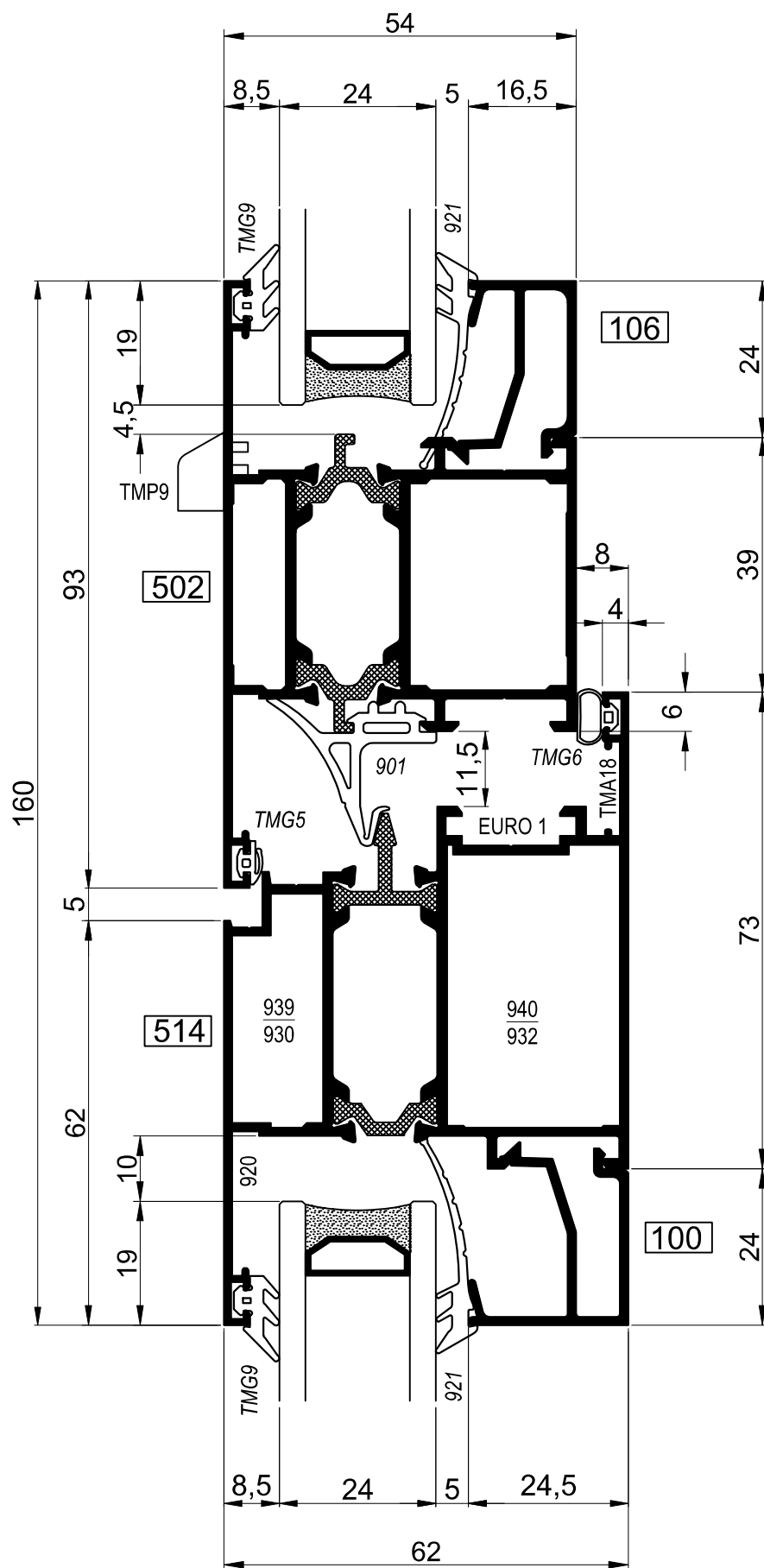
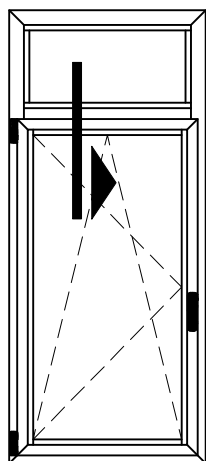


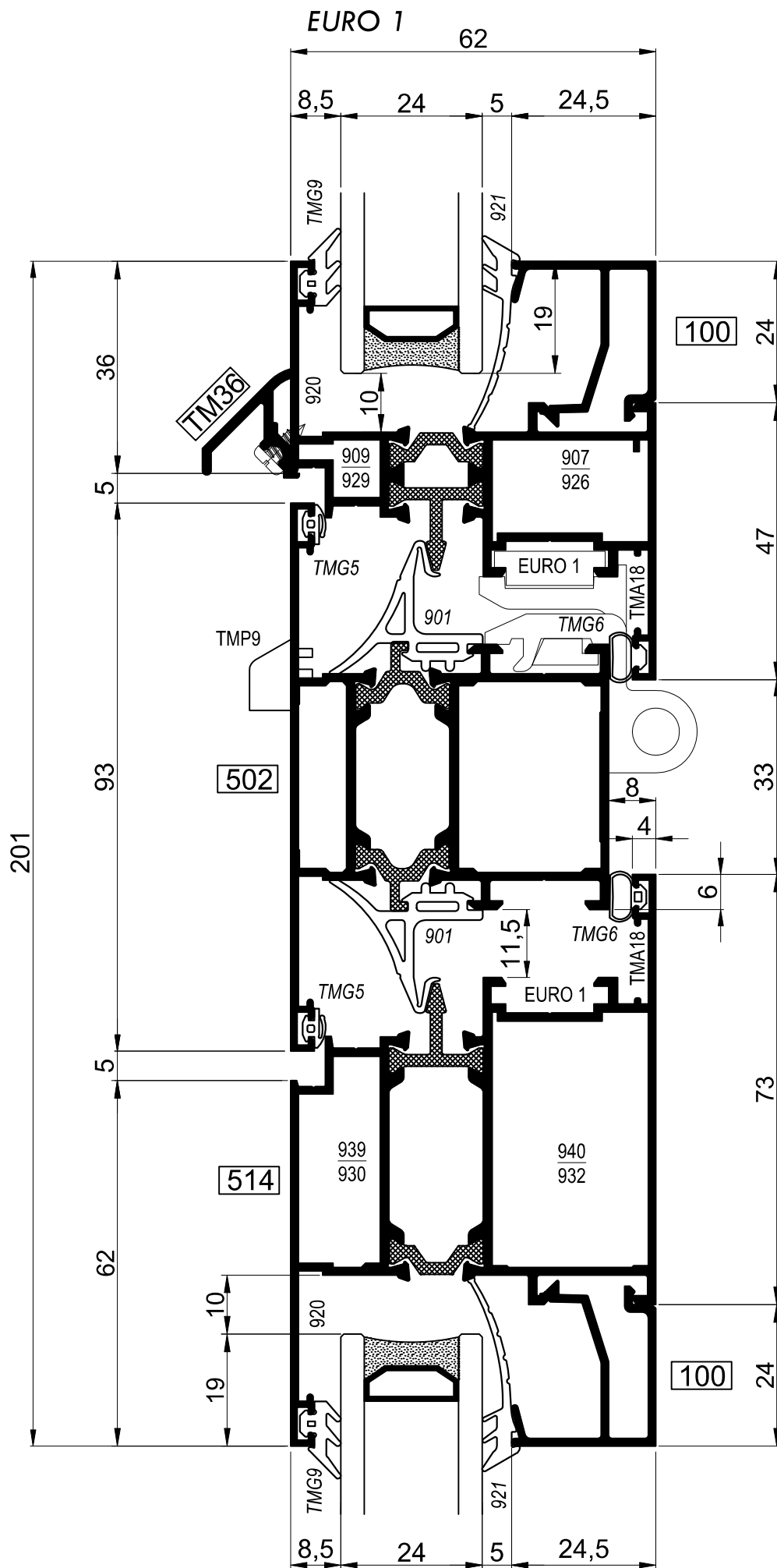
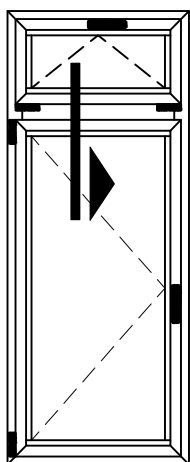


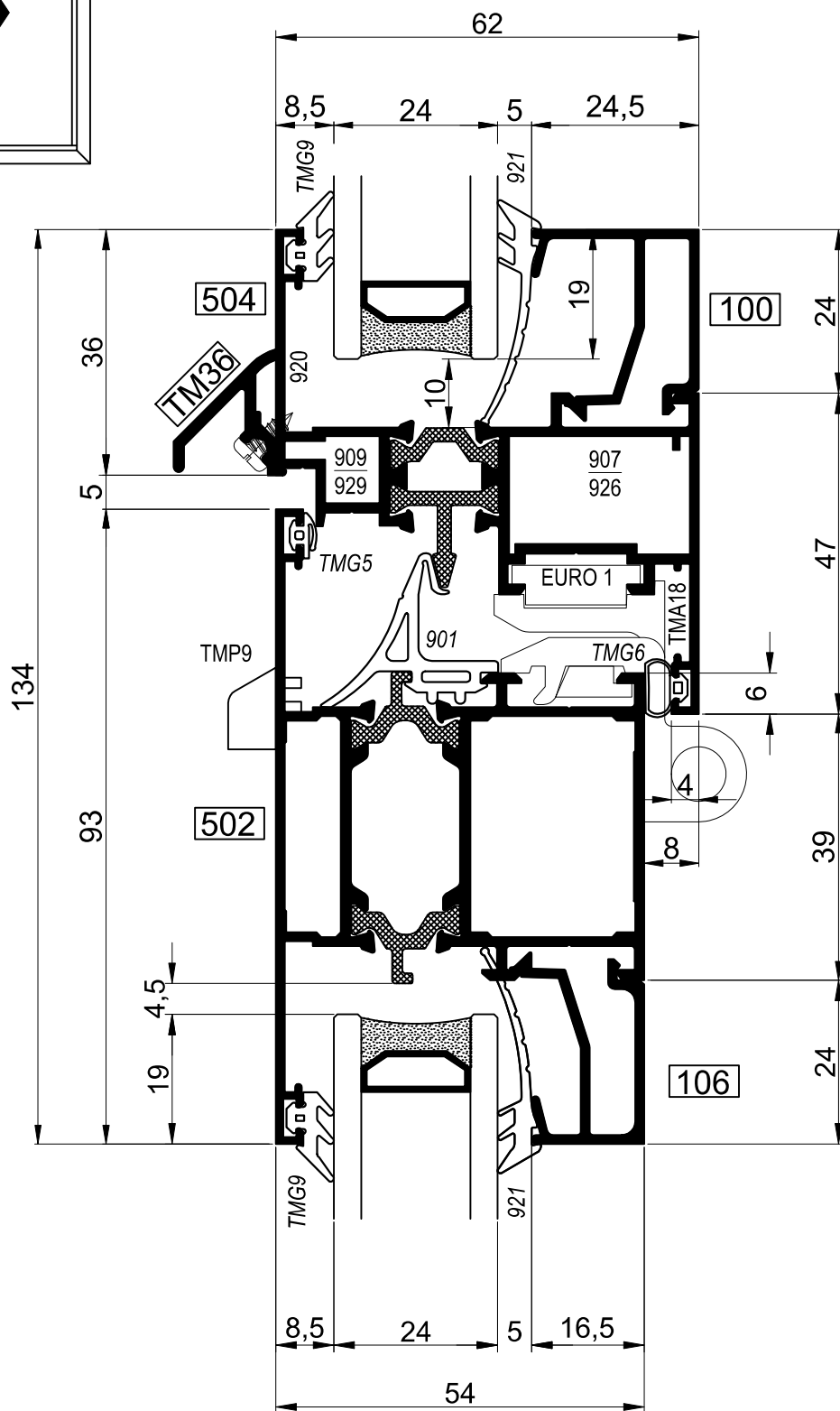
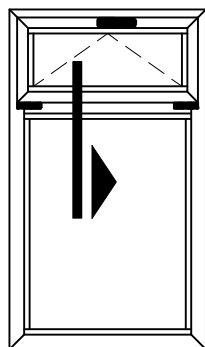


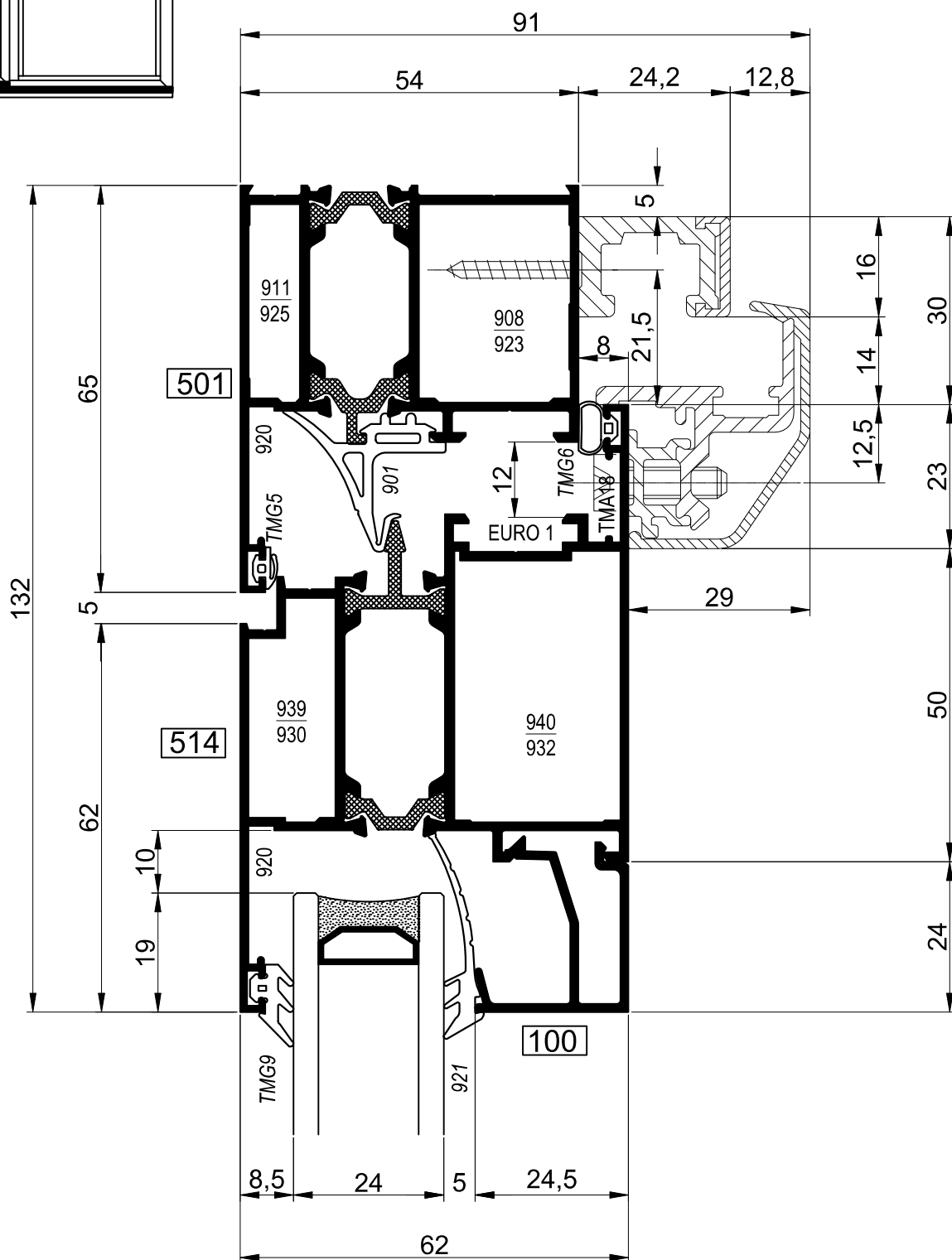
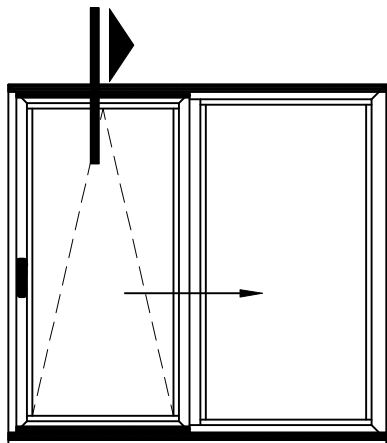


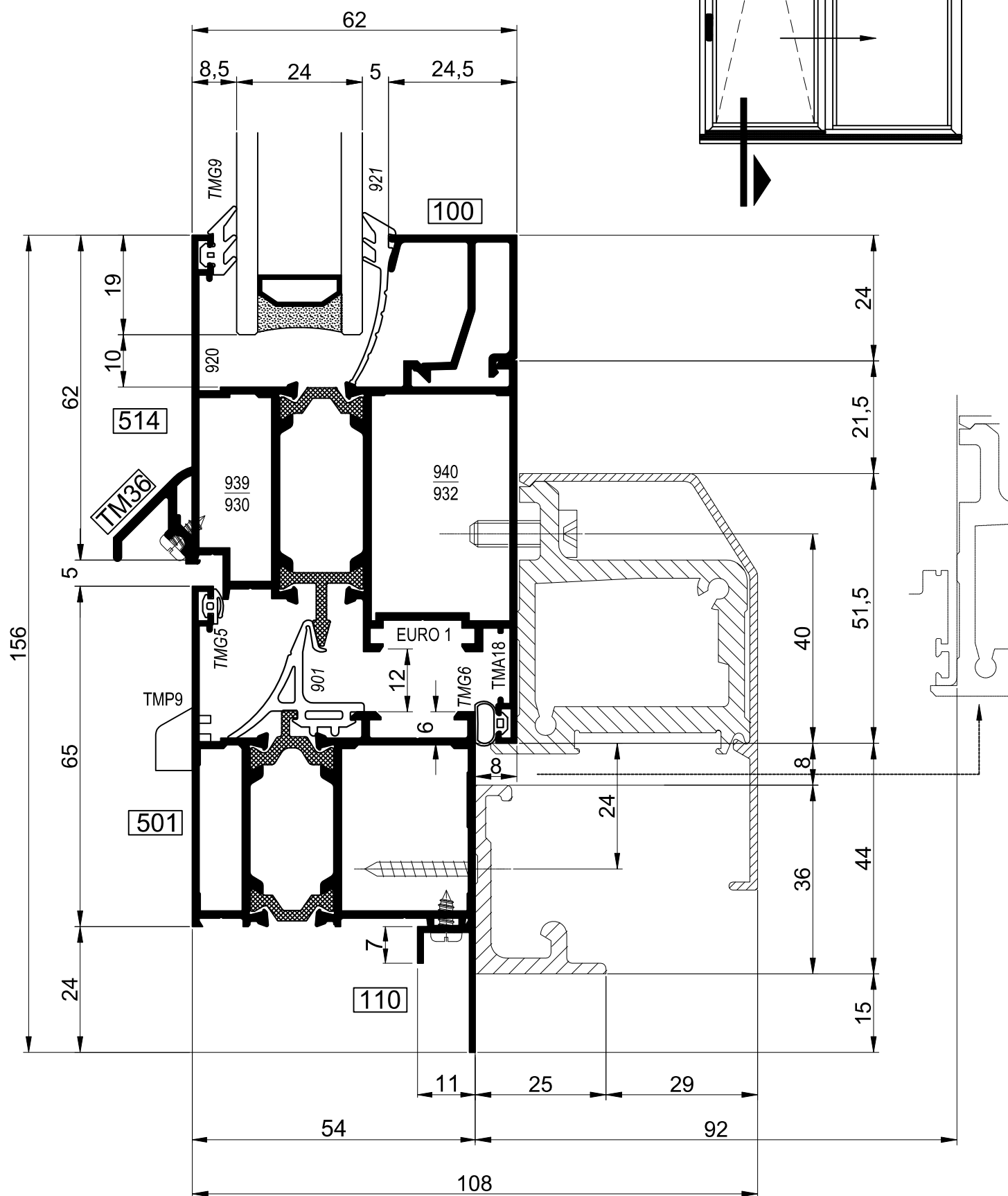


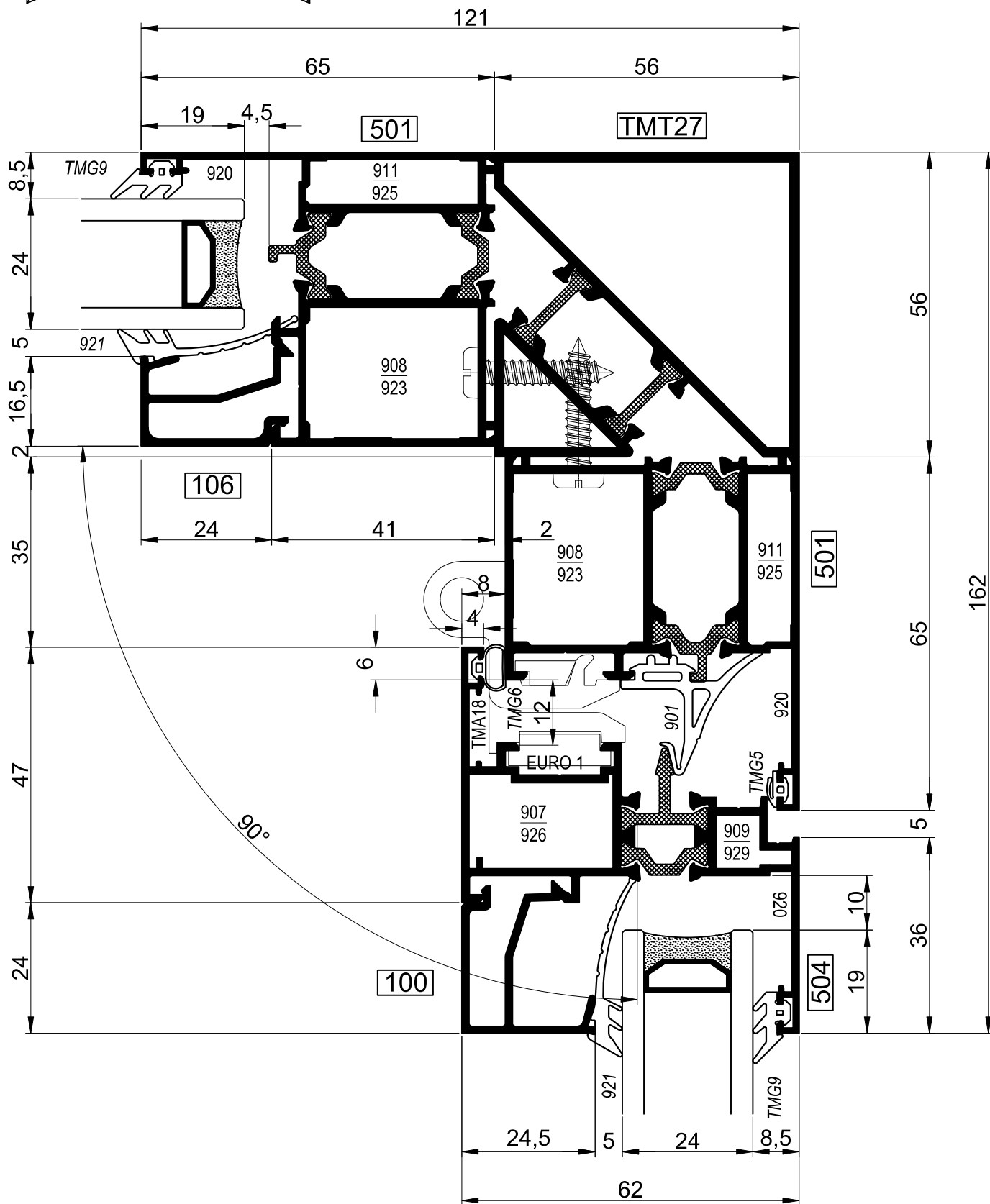
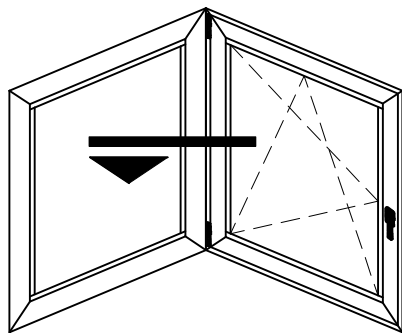


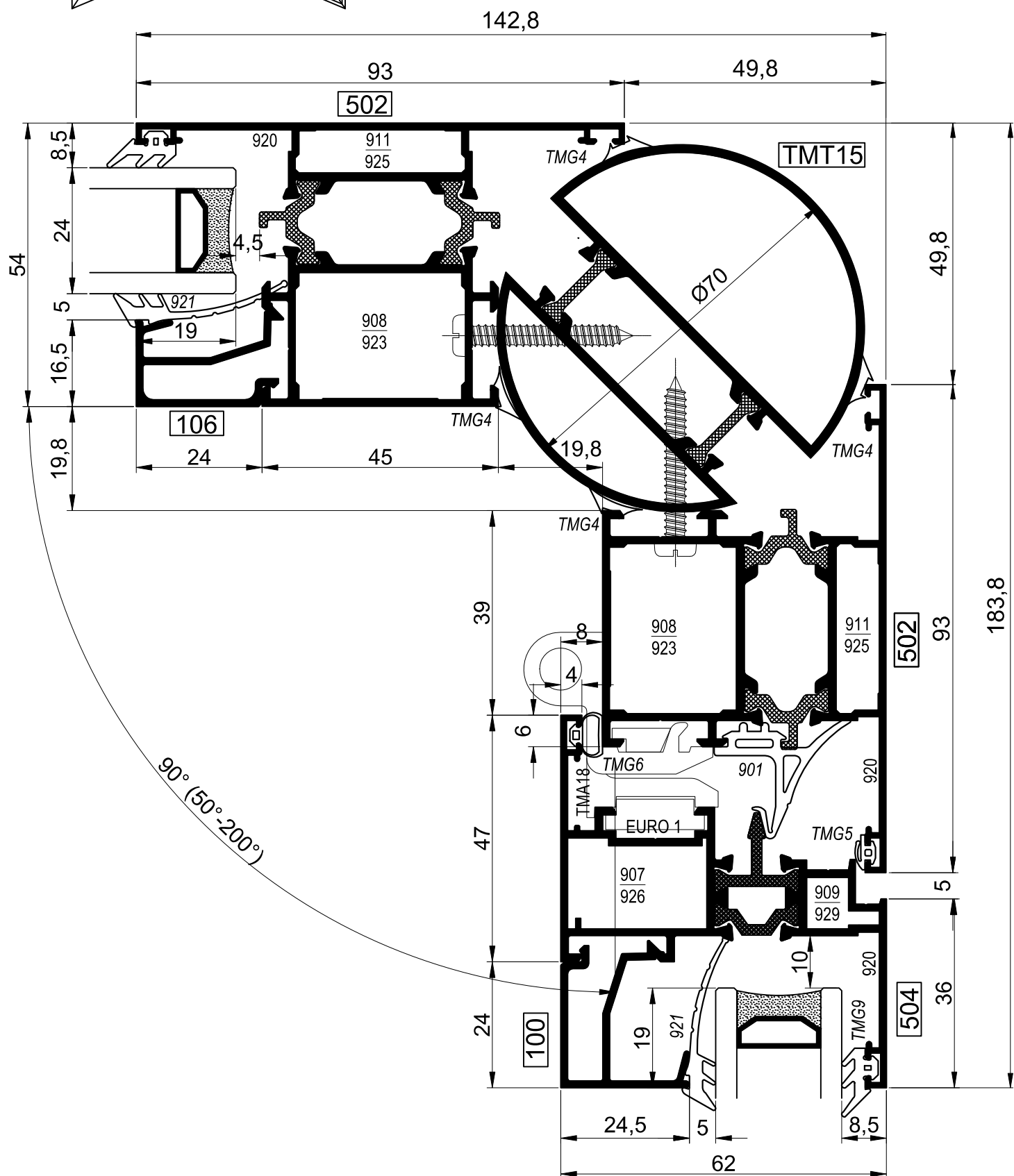
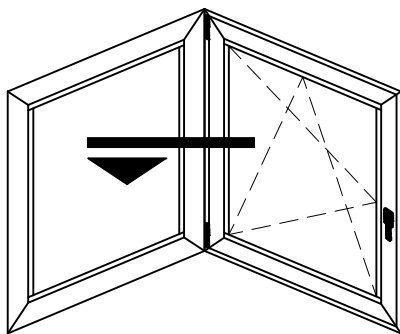




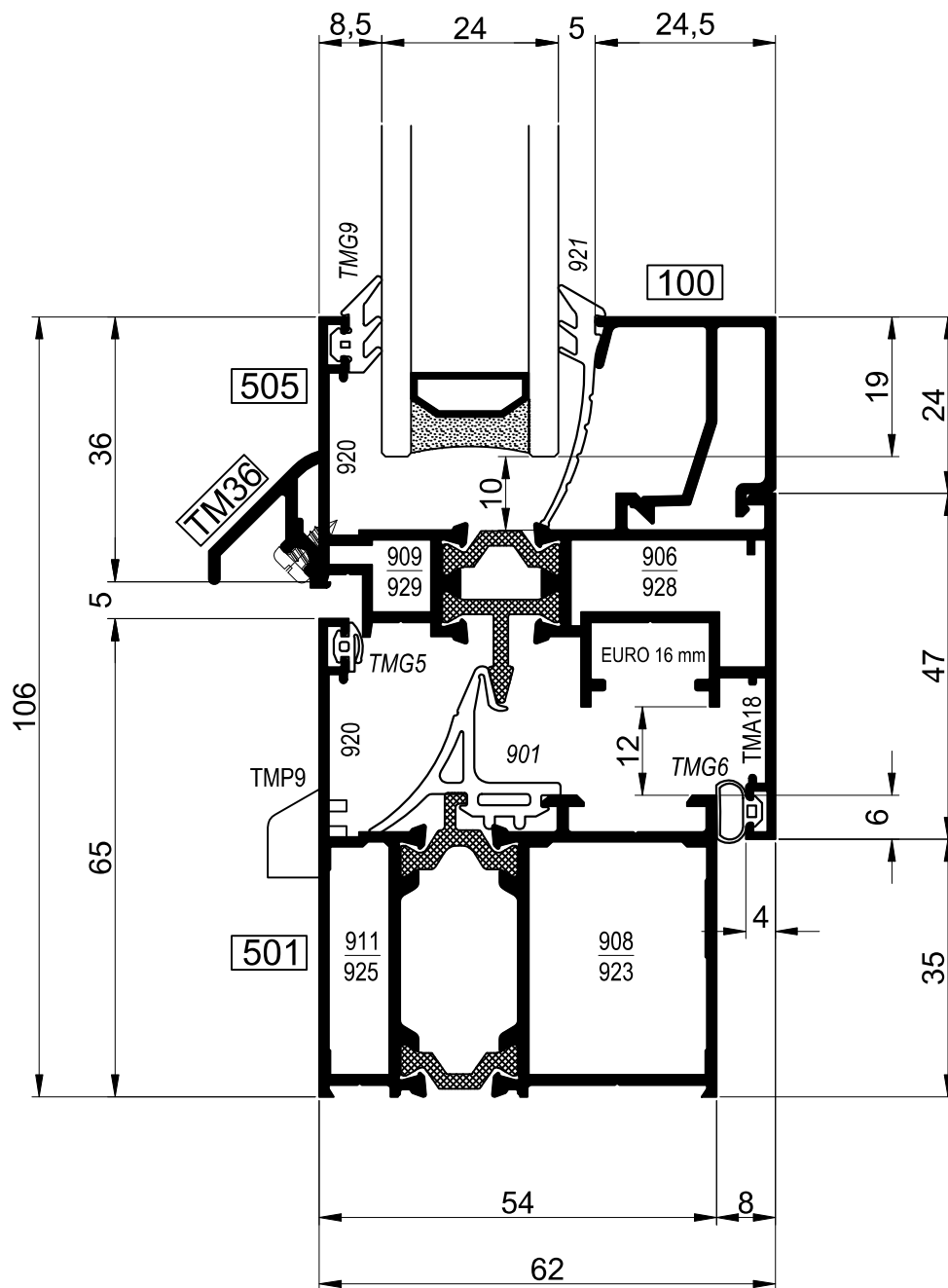
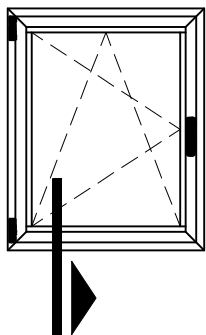




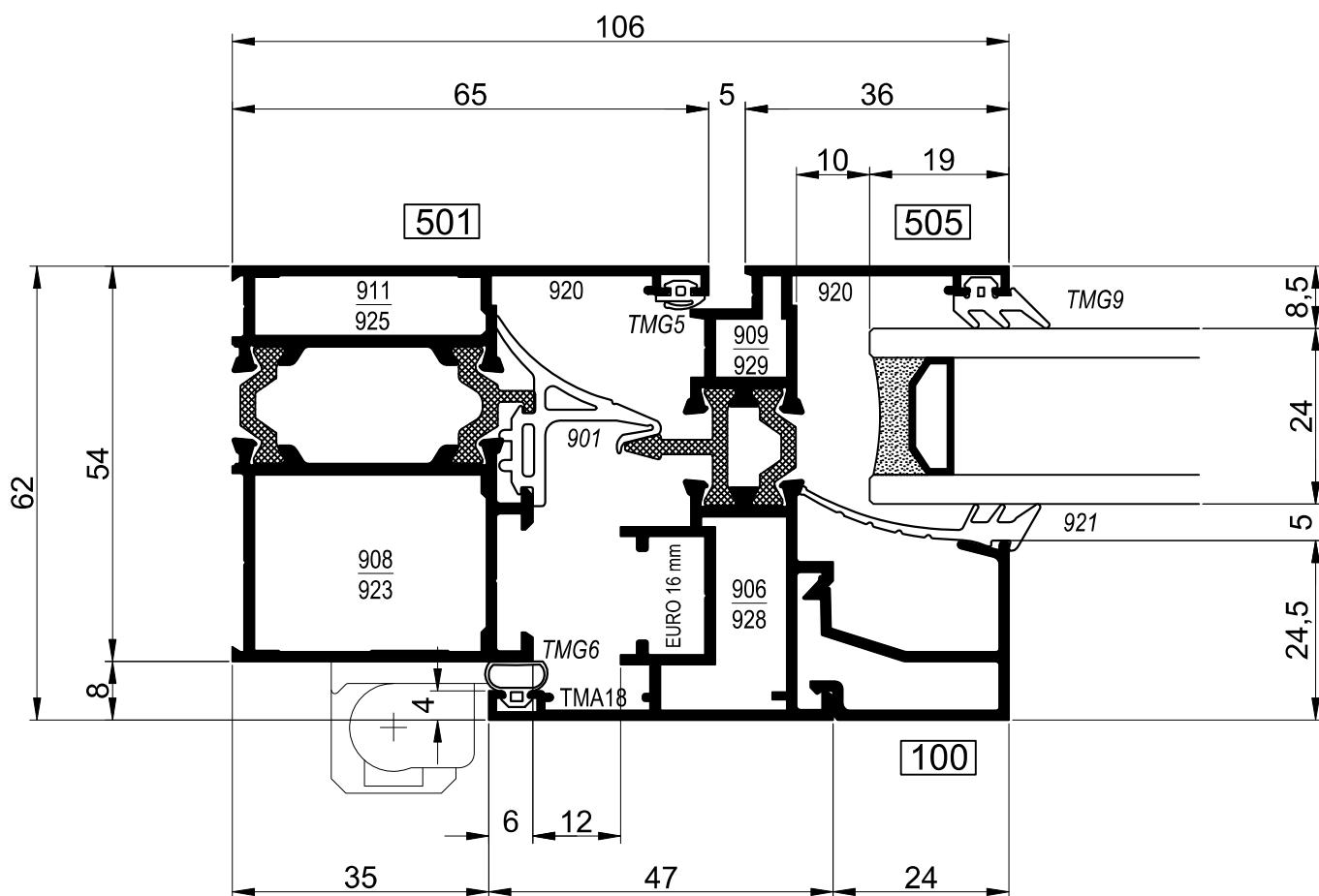
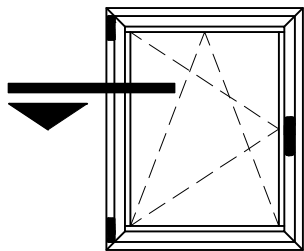




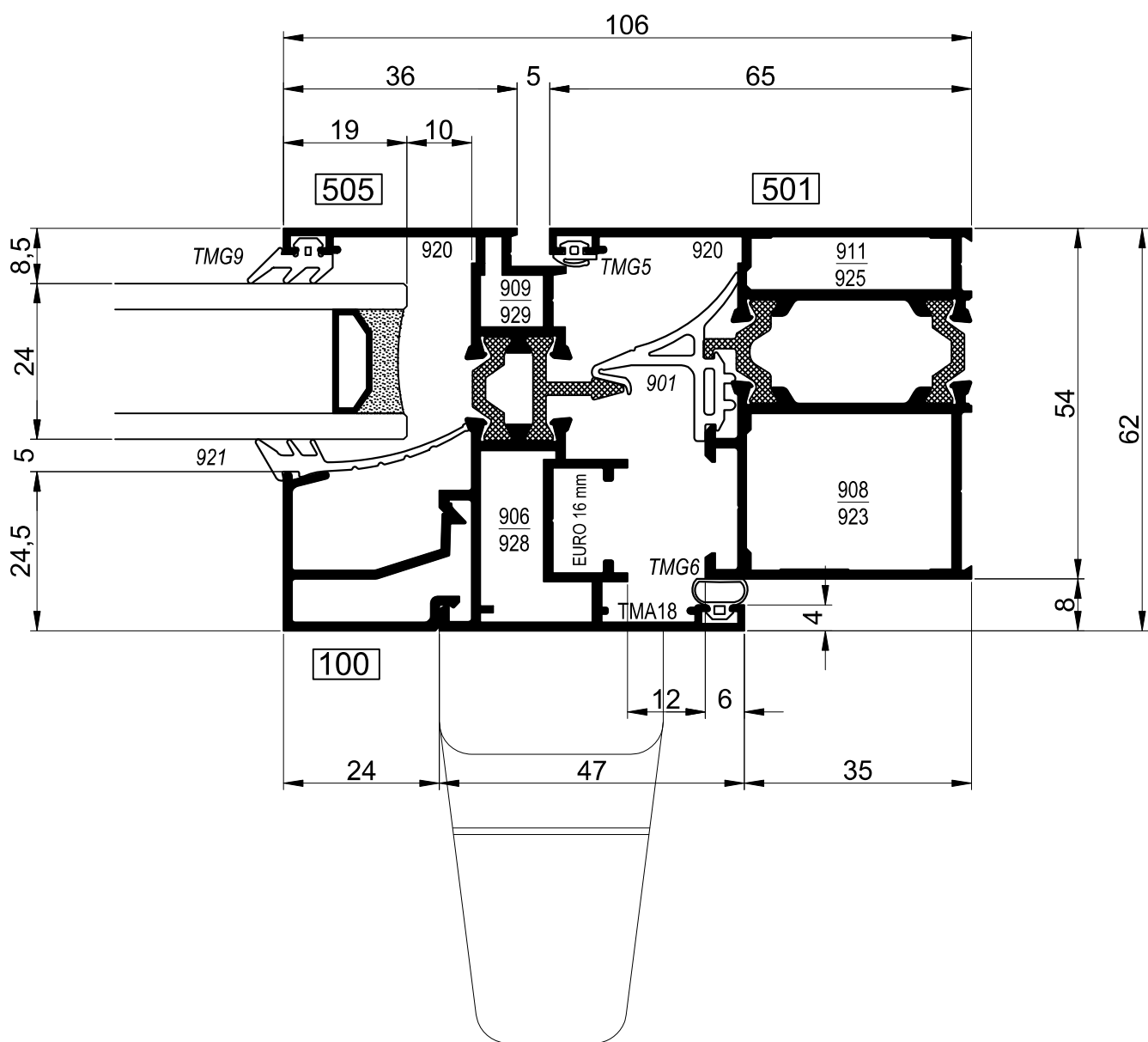
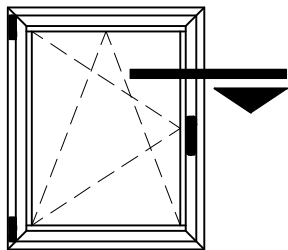
EURO 16 mm



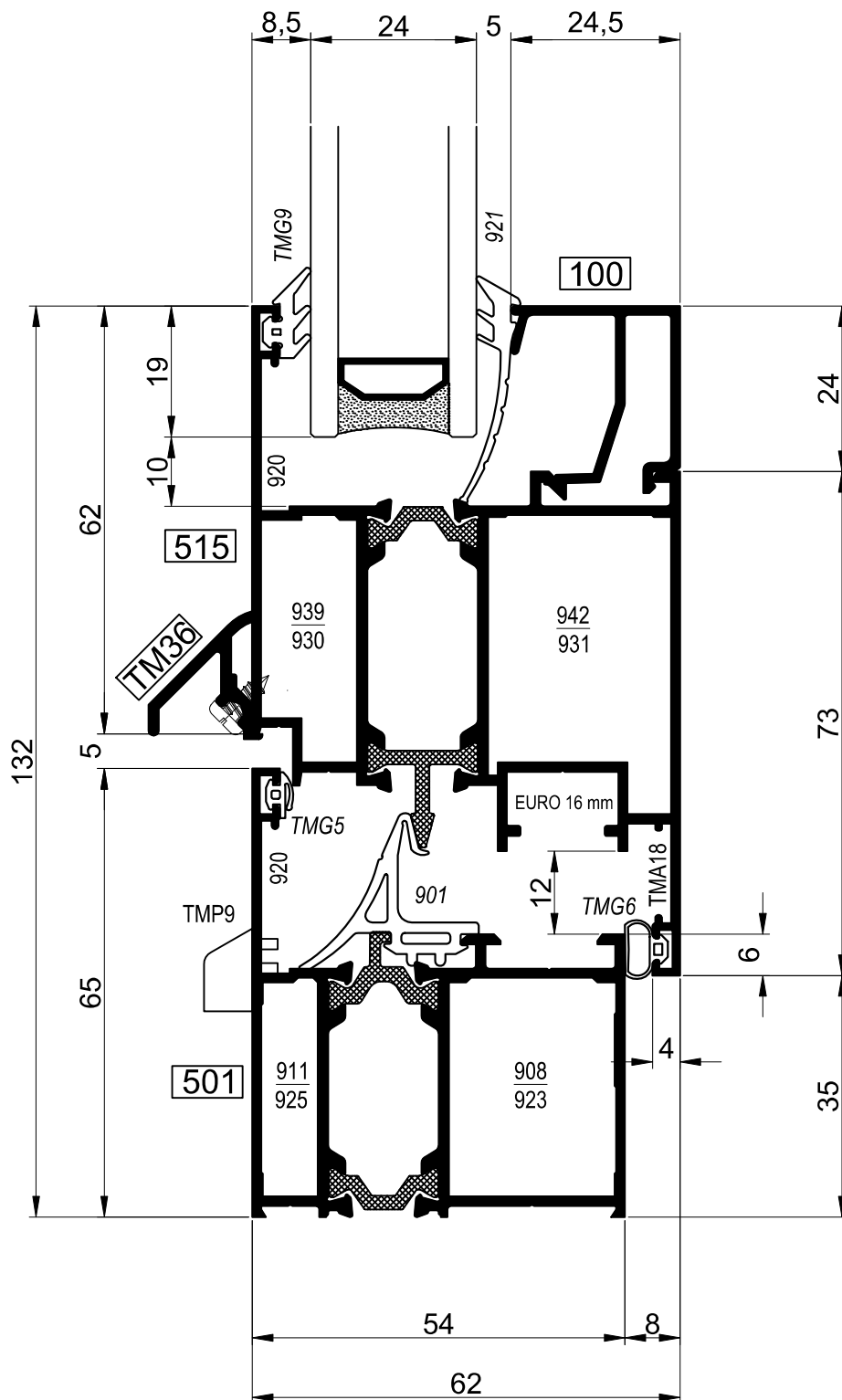
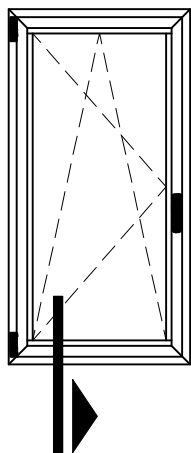
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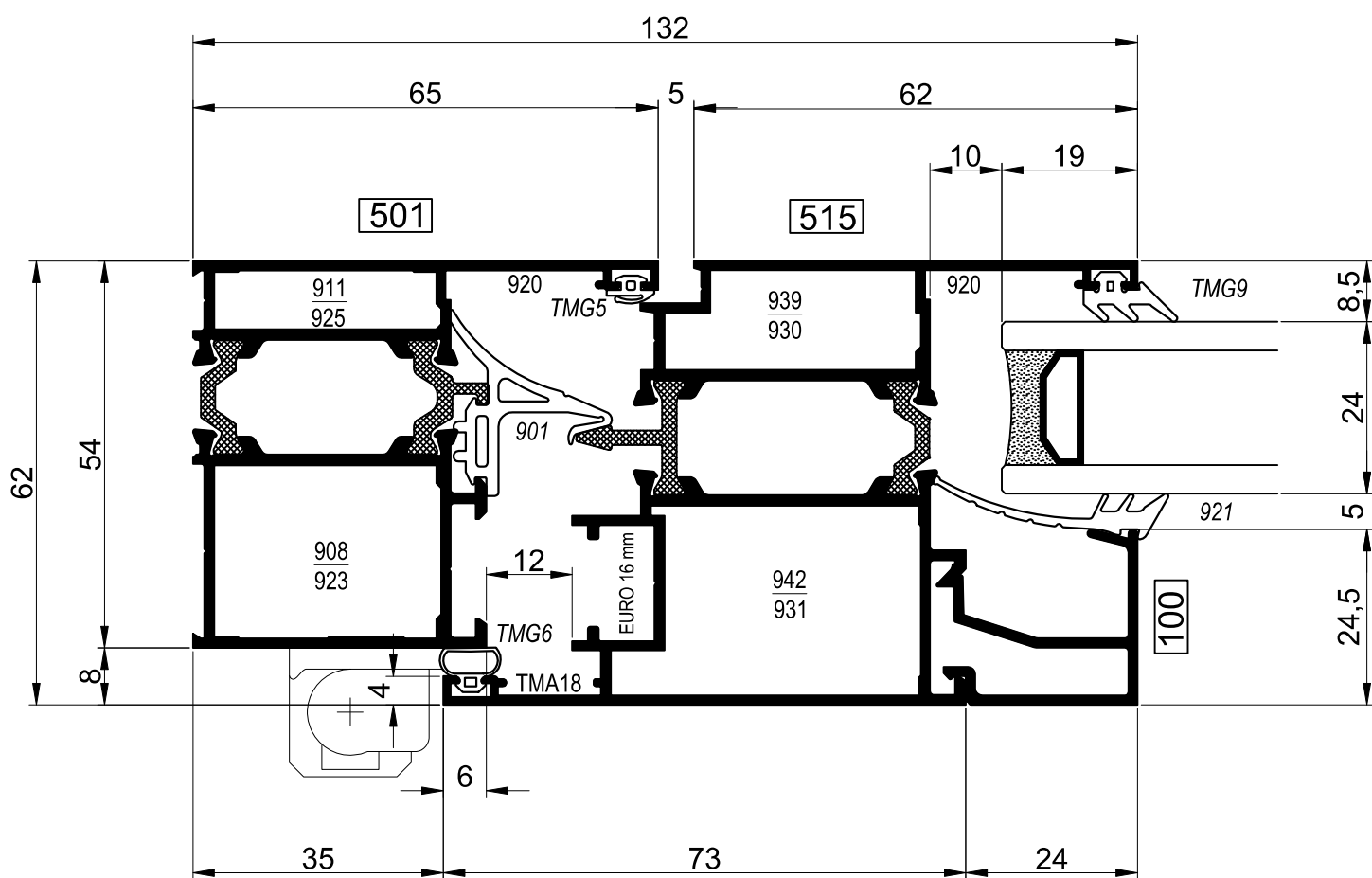
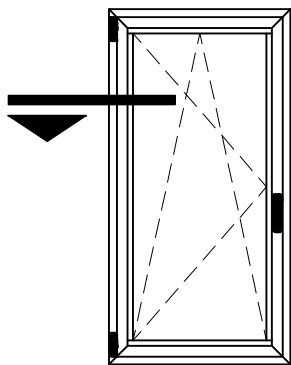
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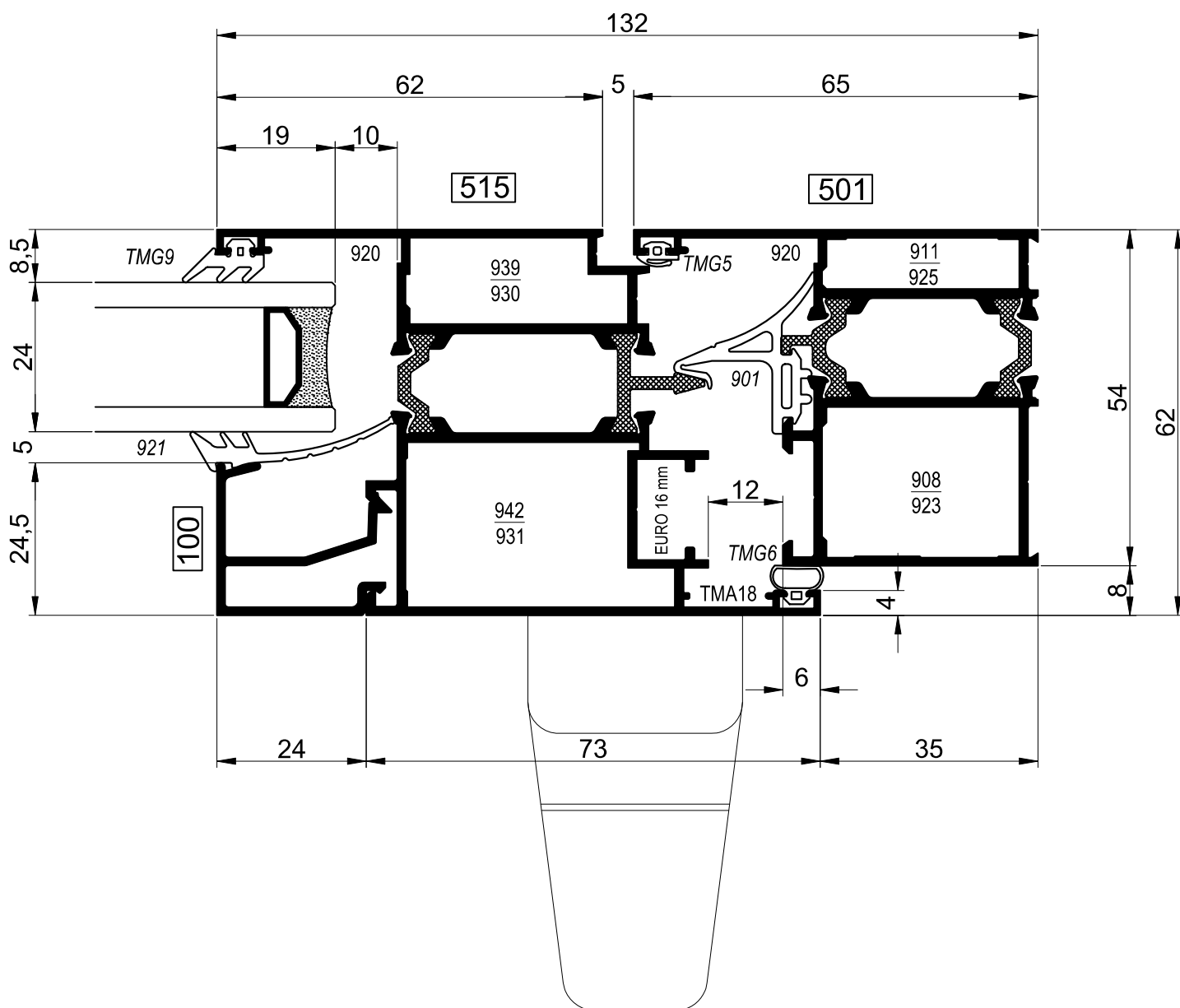
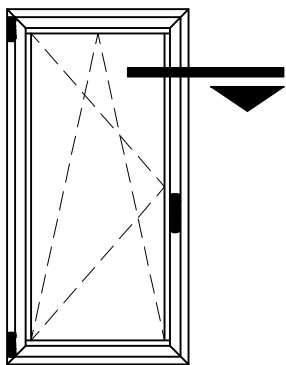
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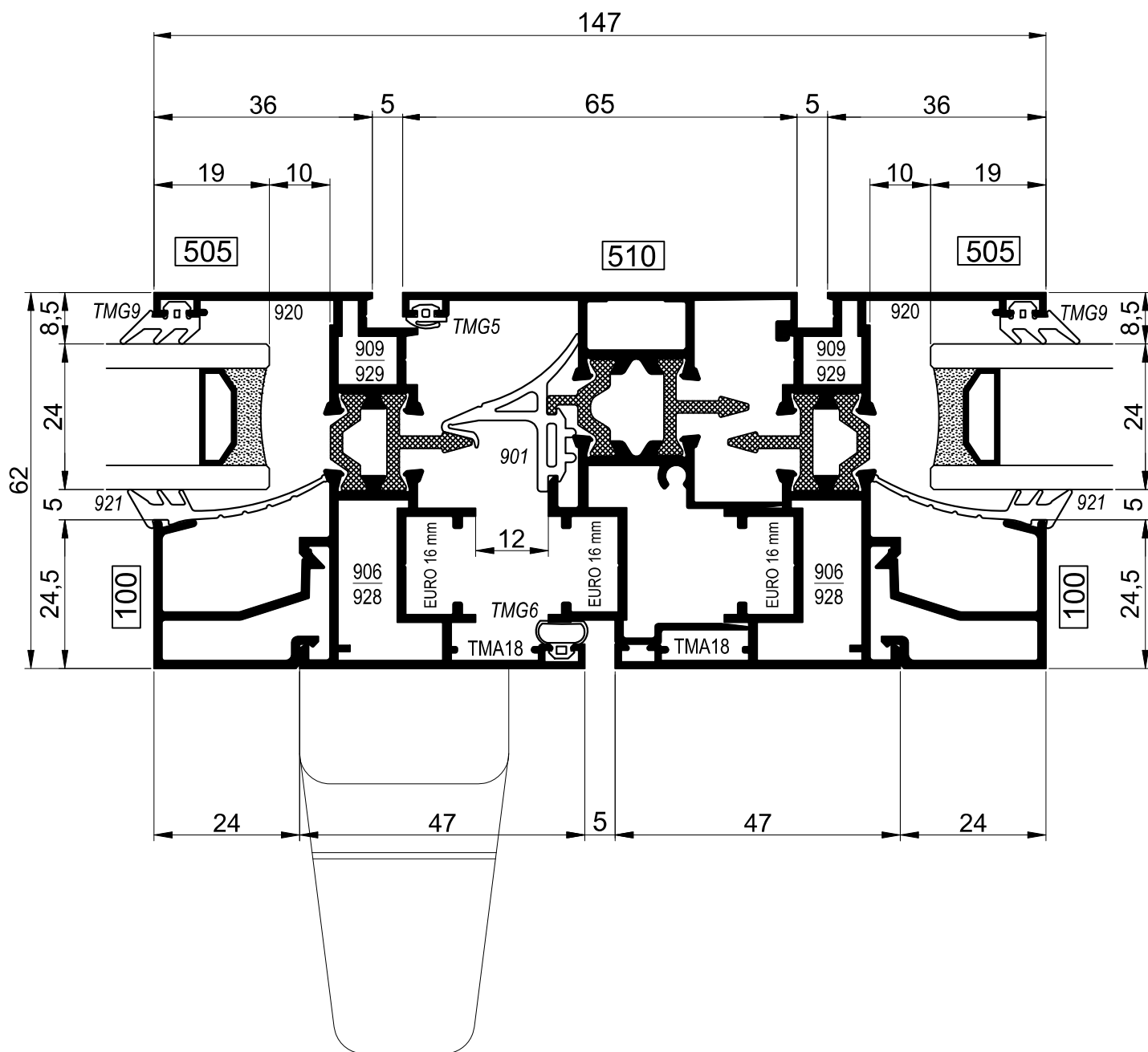
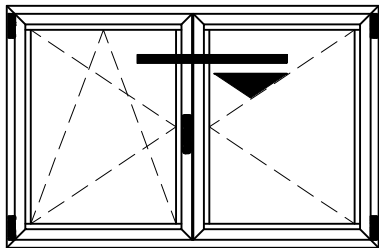
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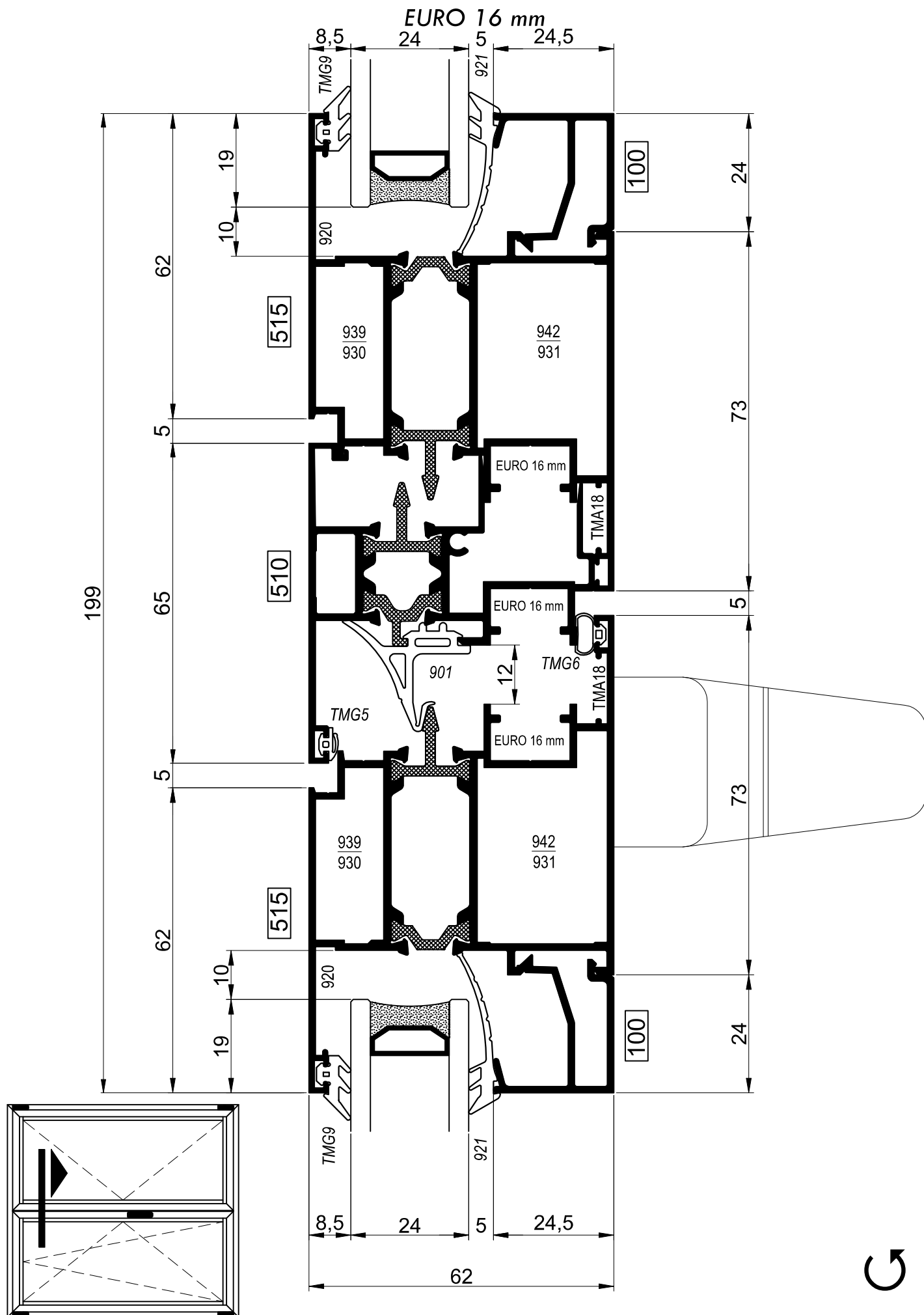


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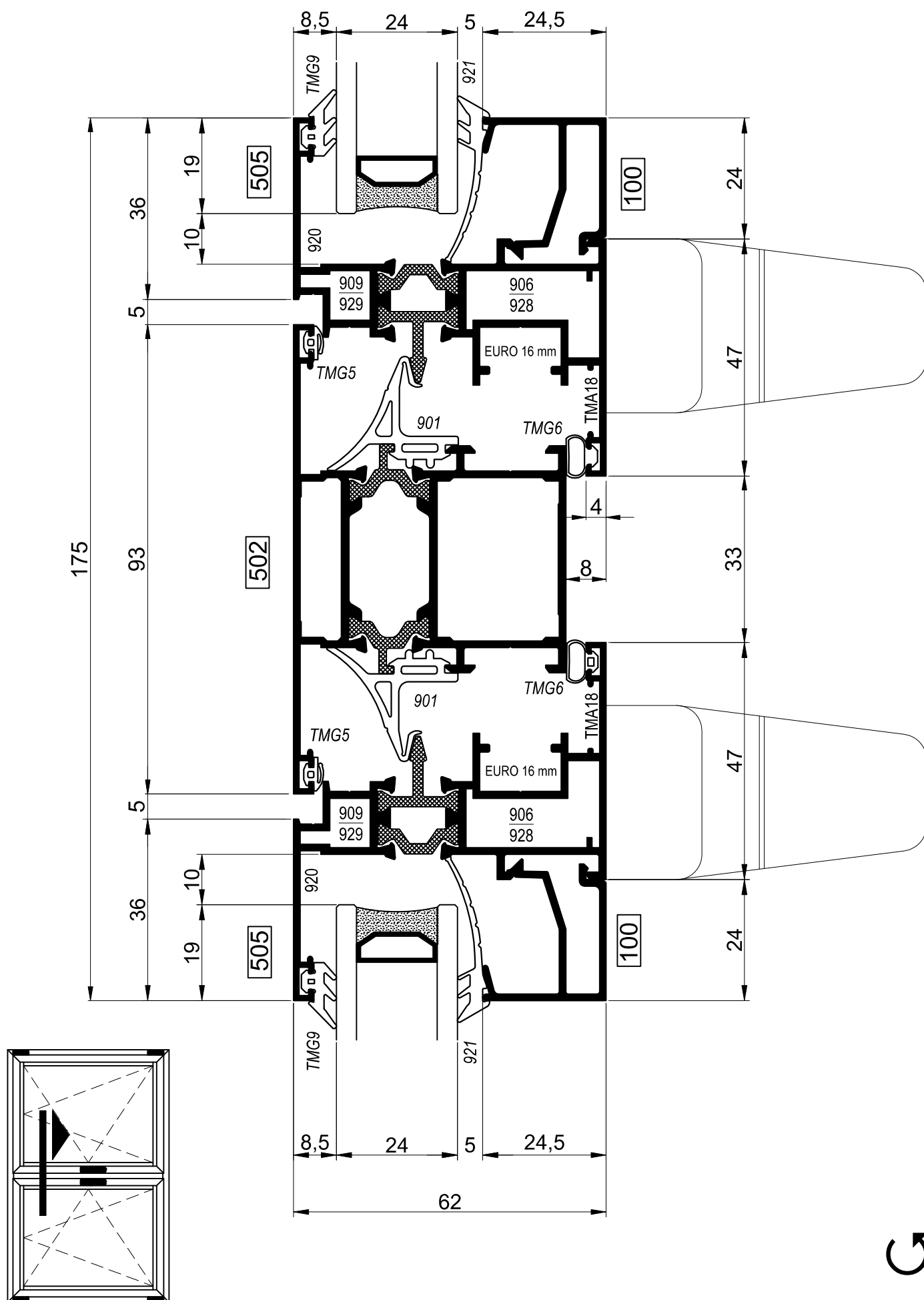


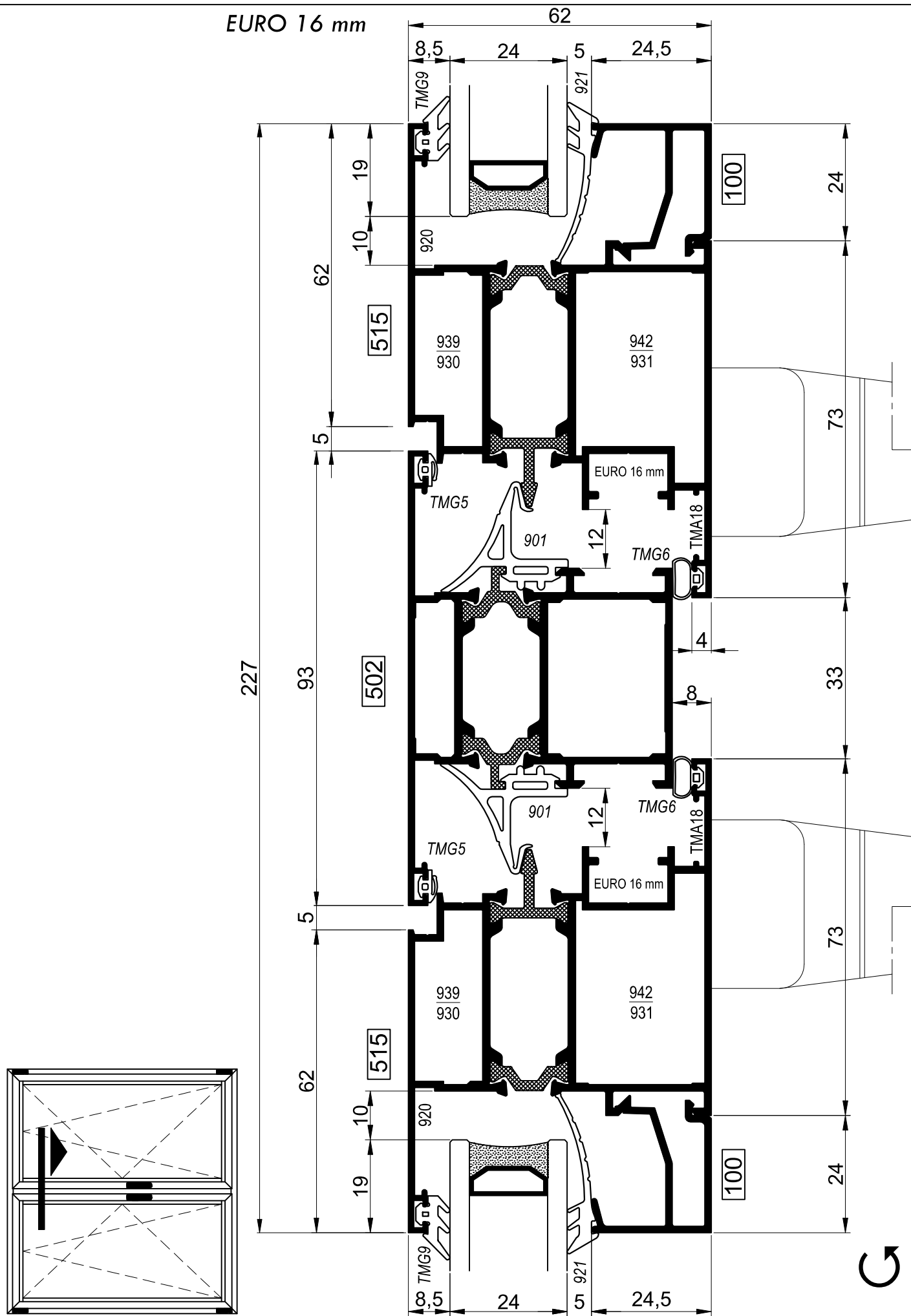
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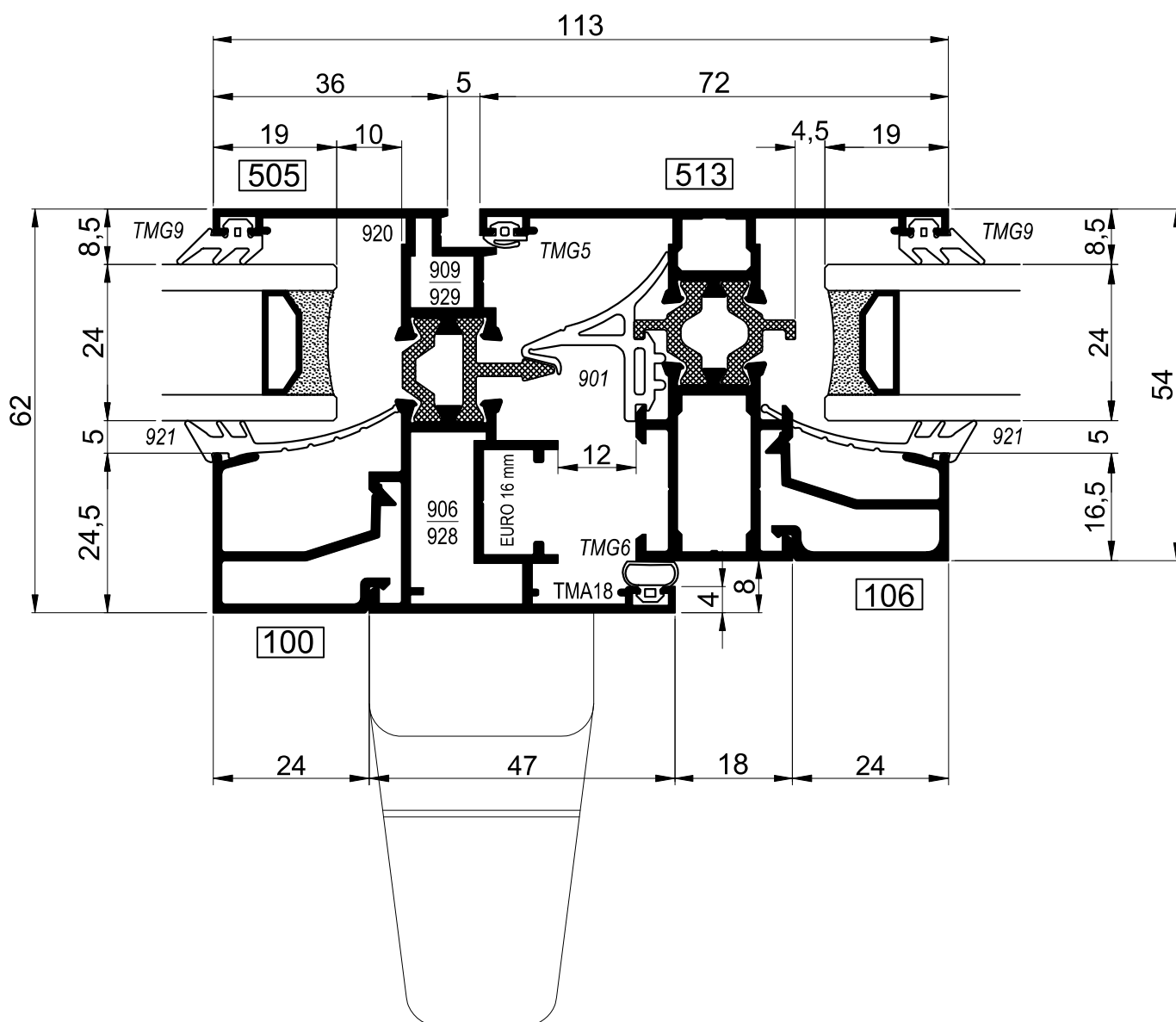
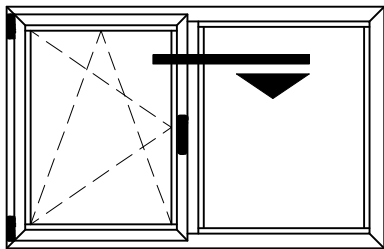


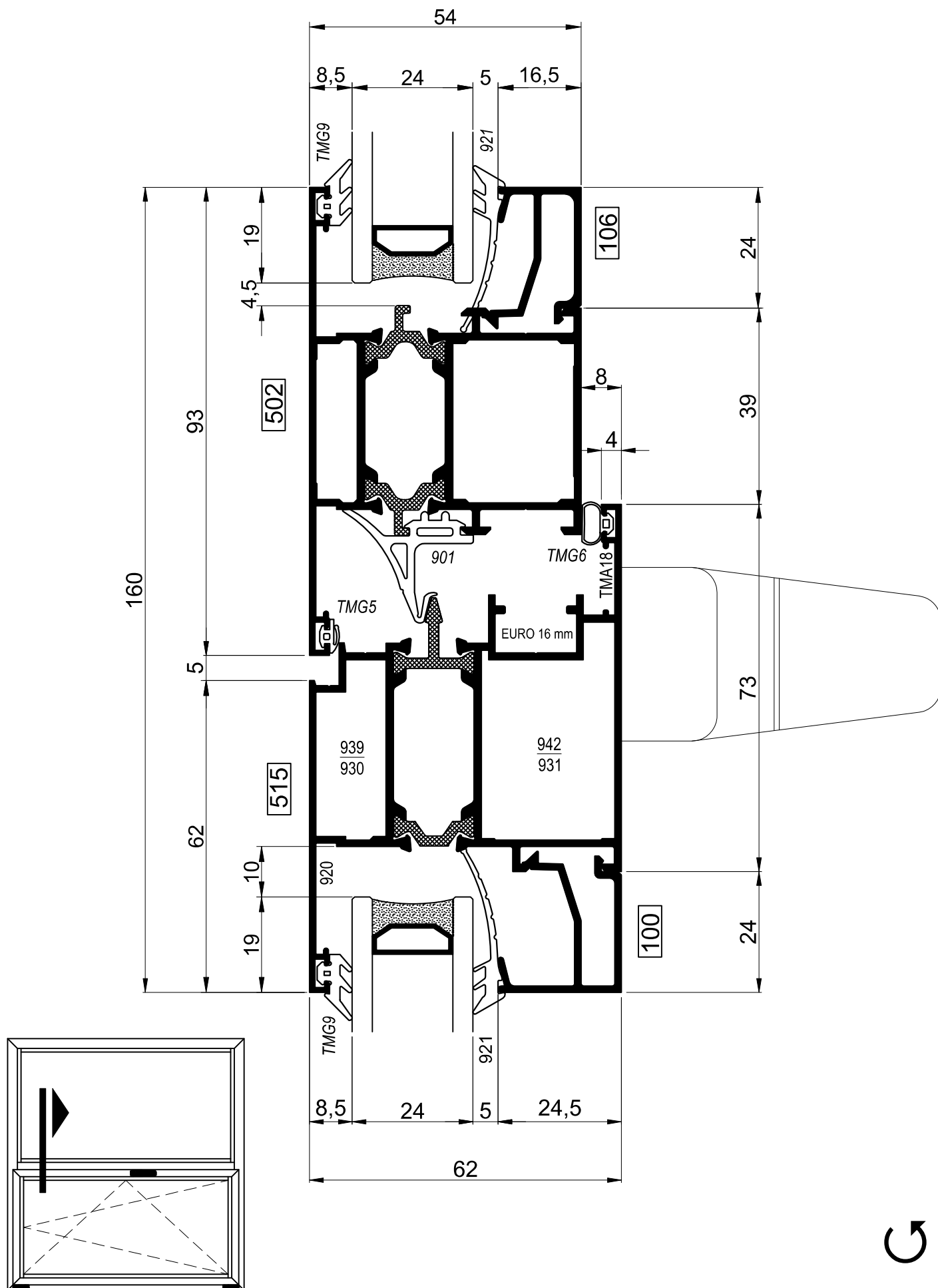
EURO 16 mm

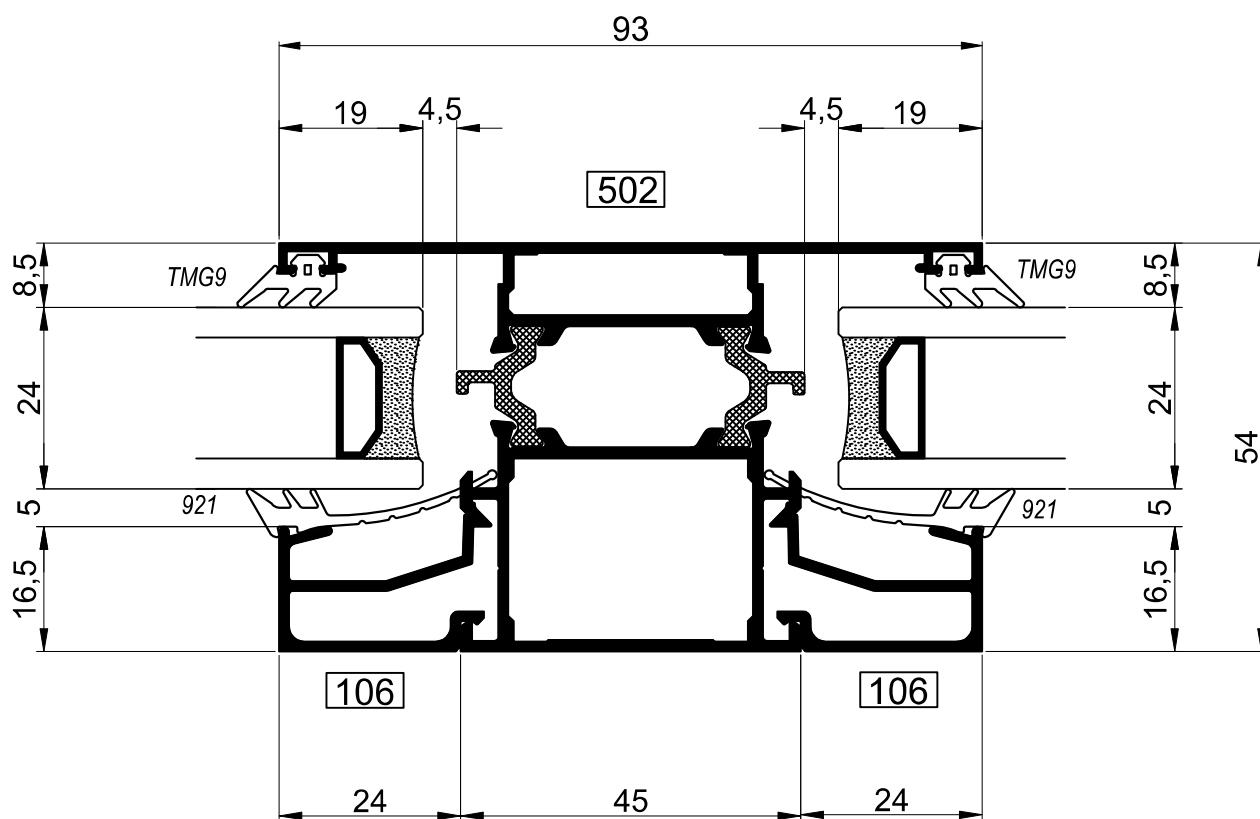
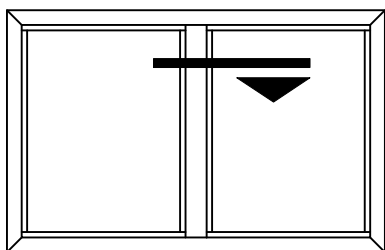


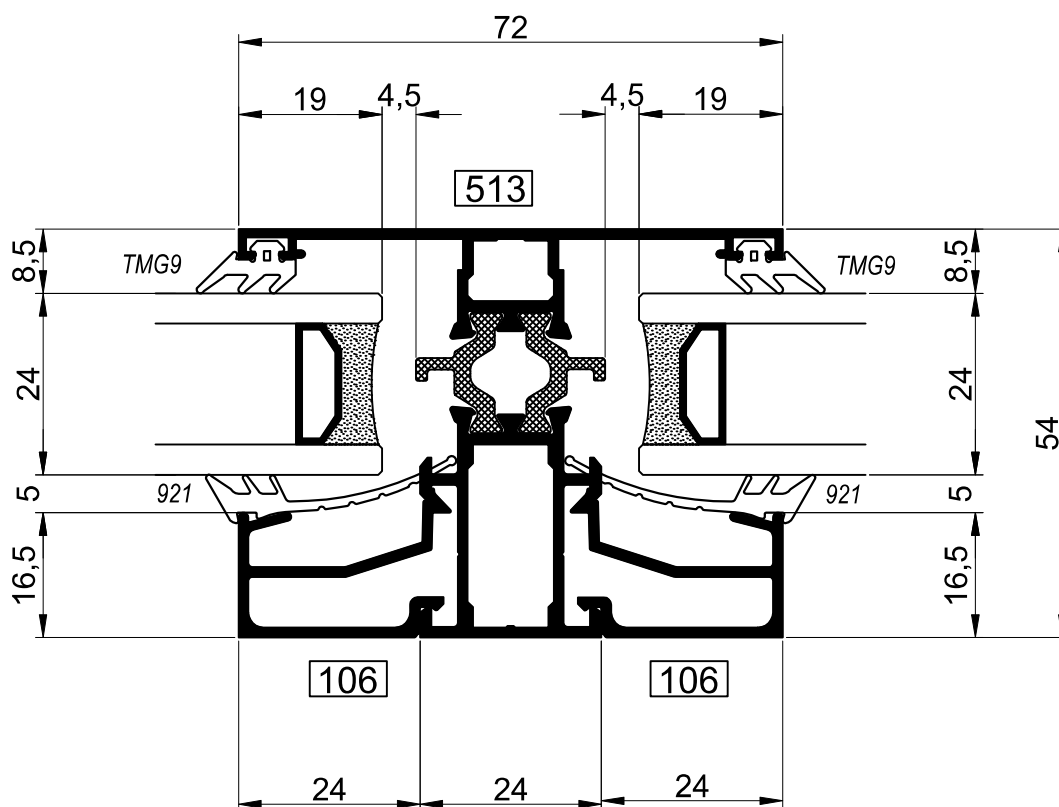
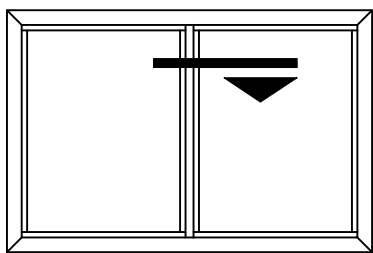


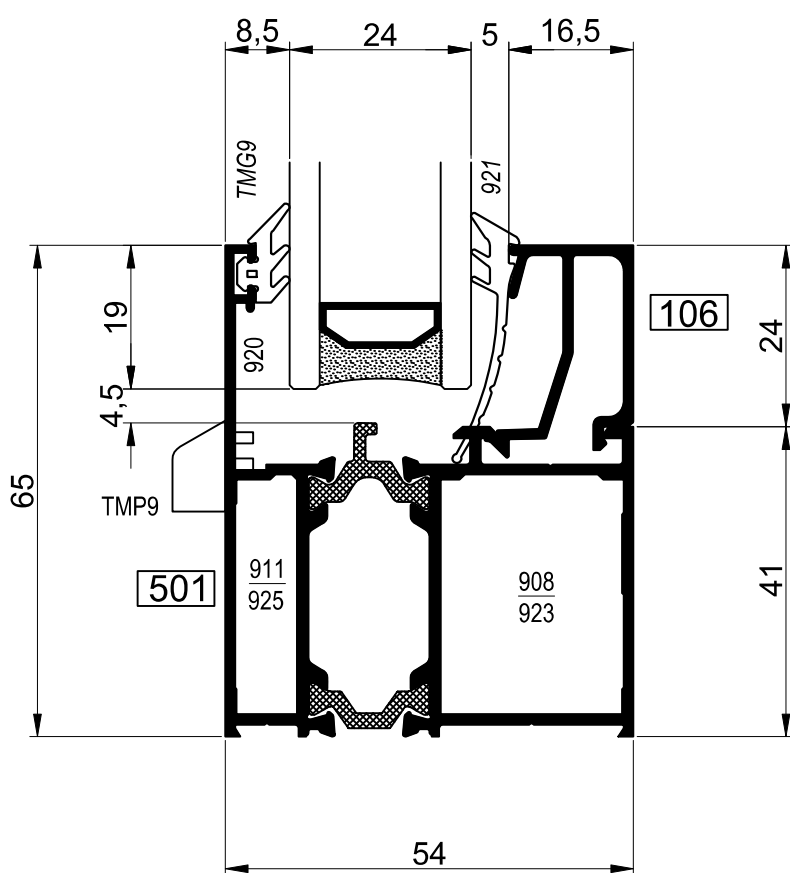
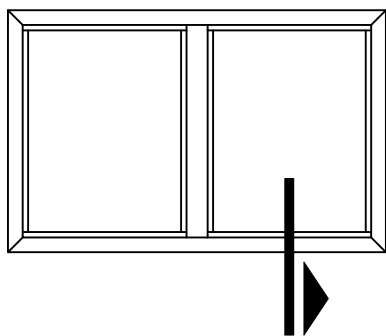
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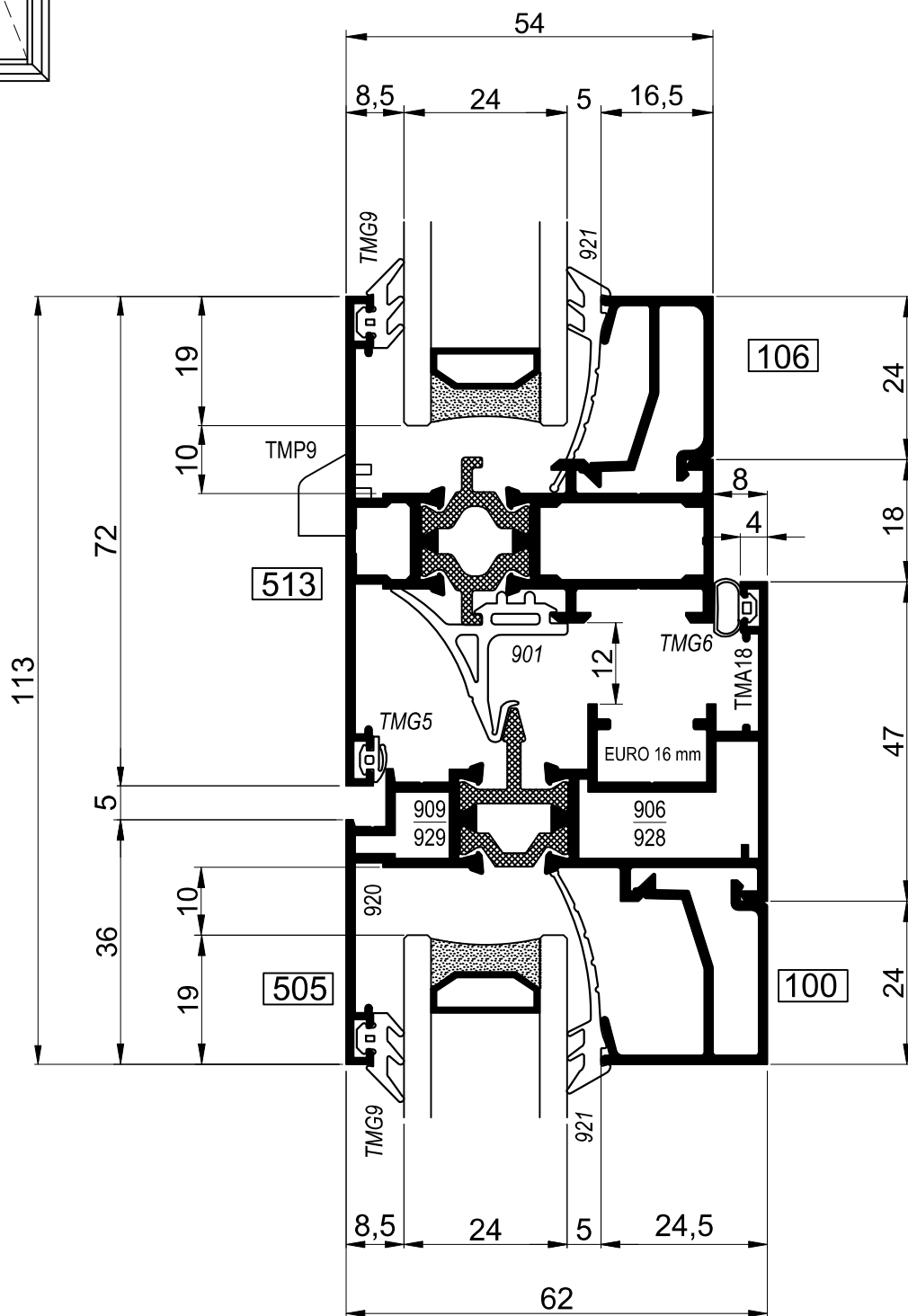
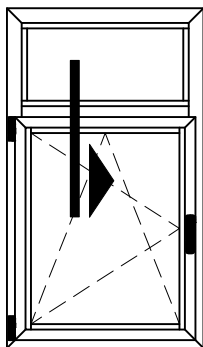




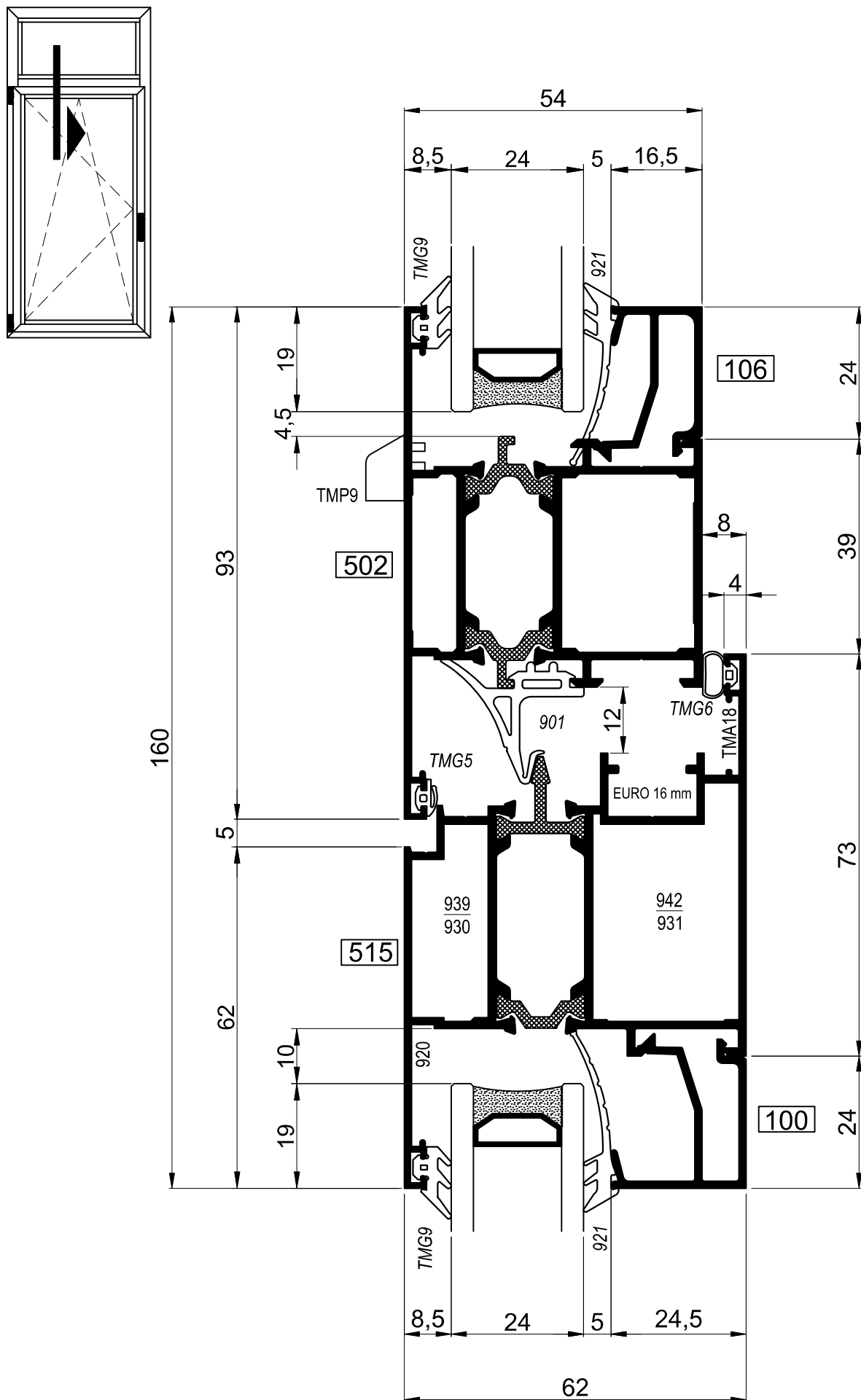


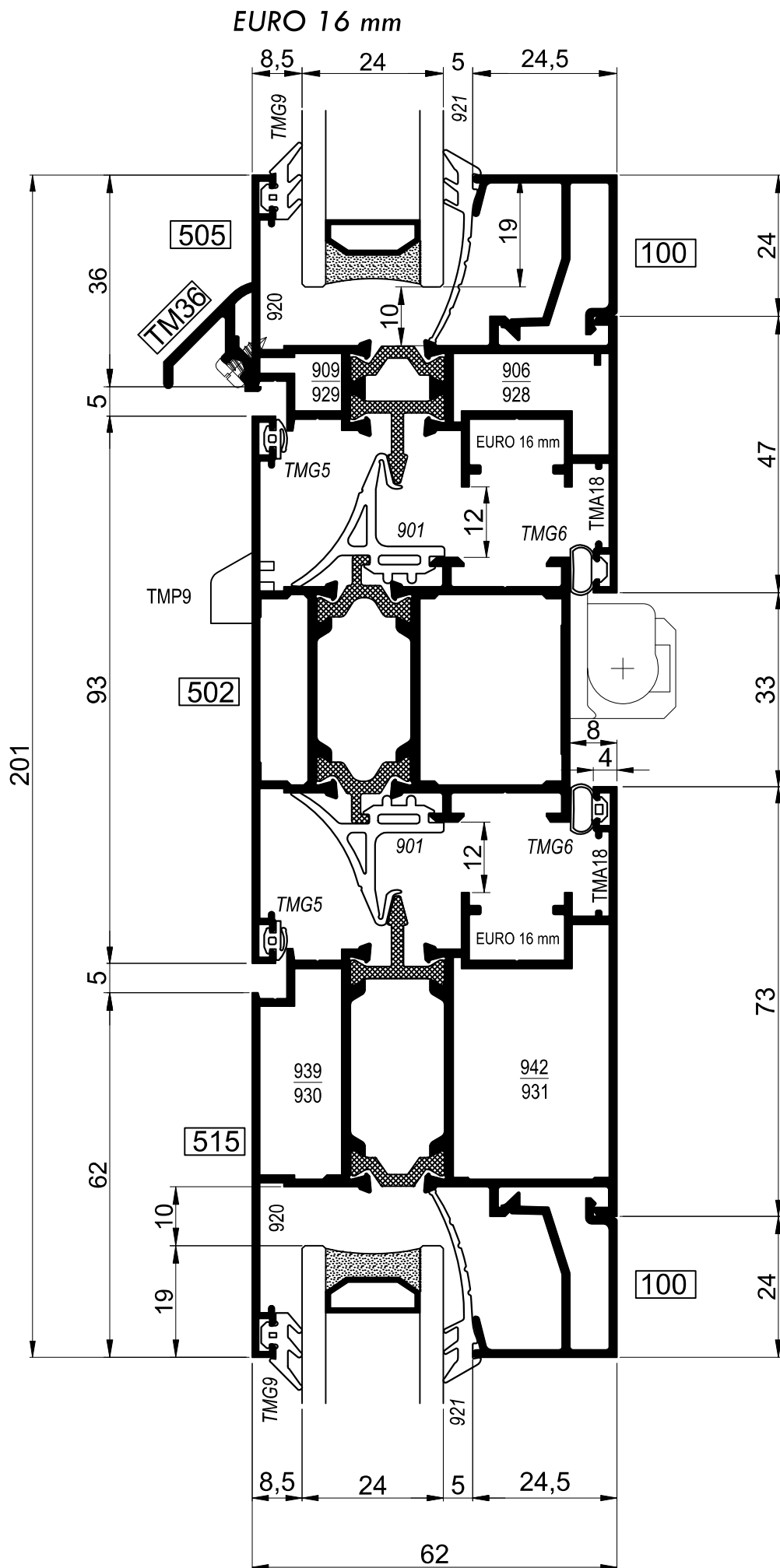
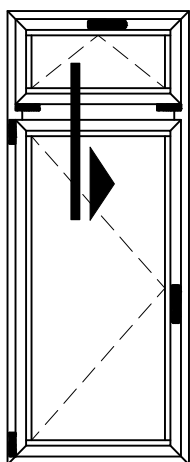




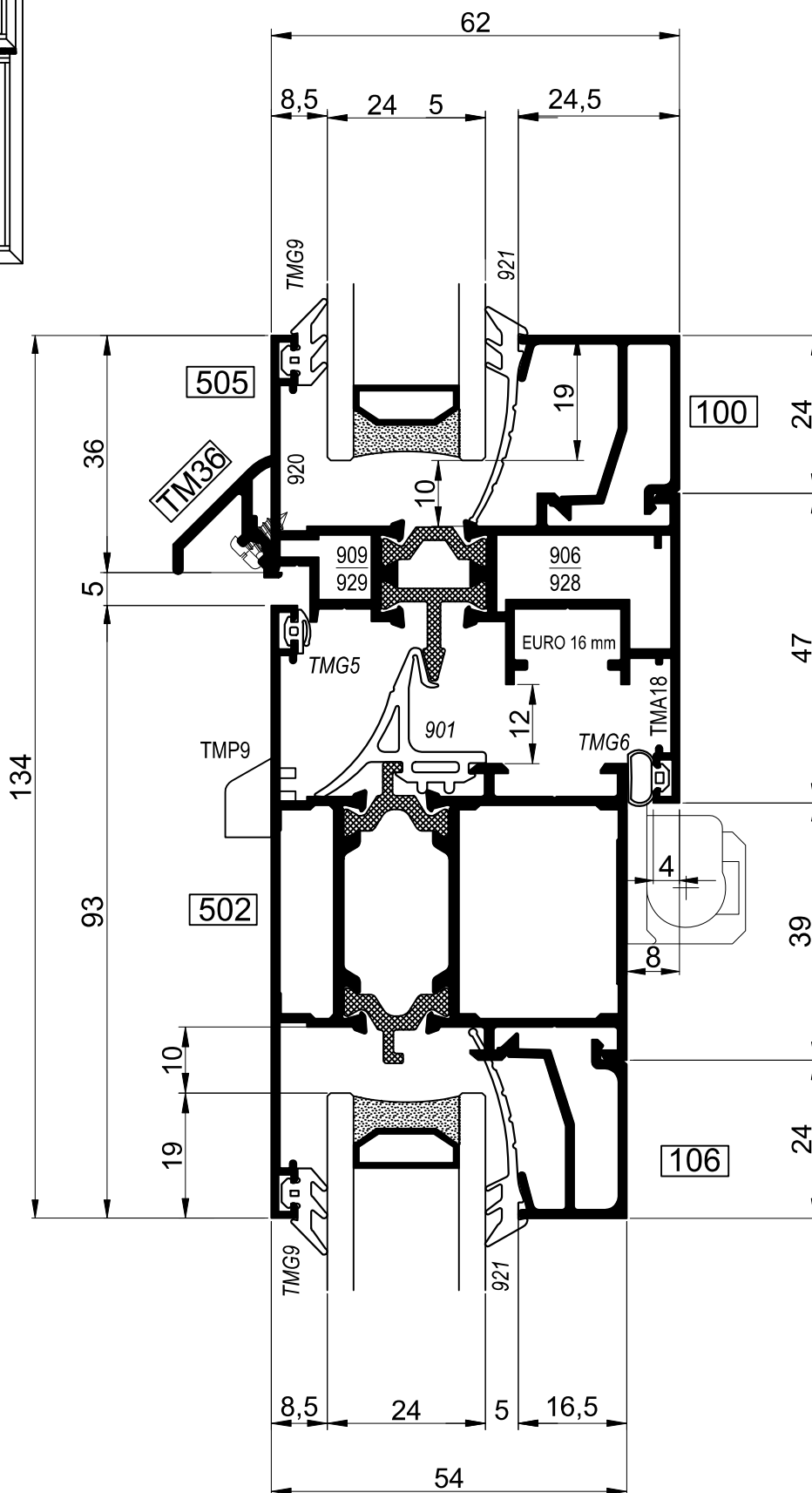
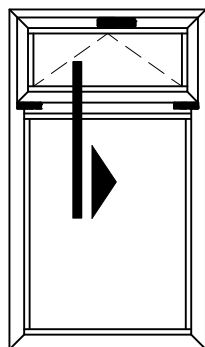


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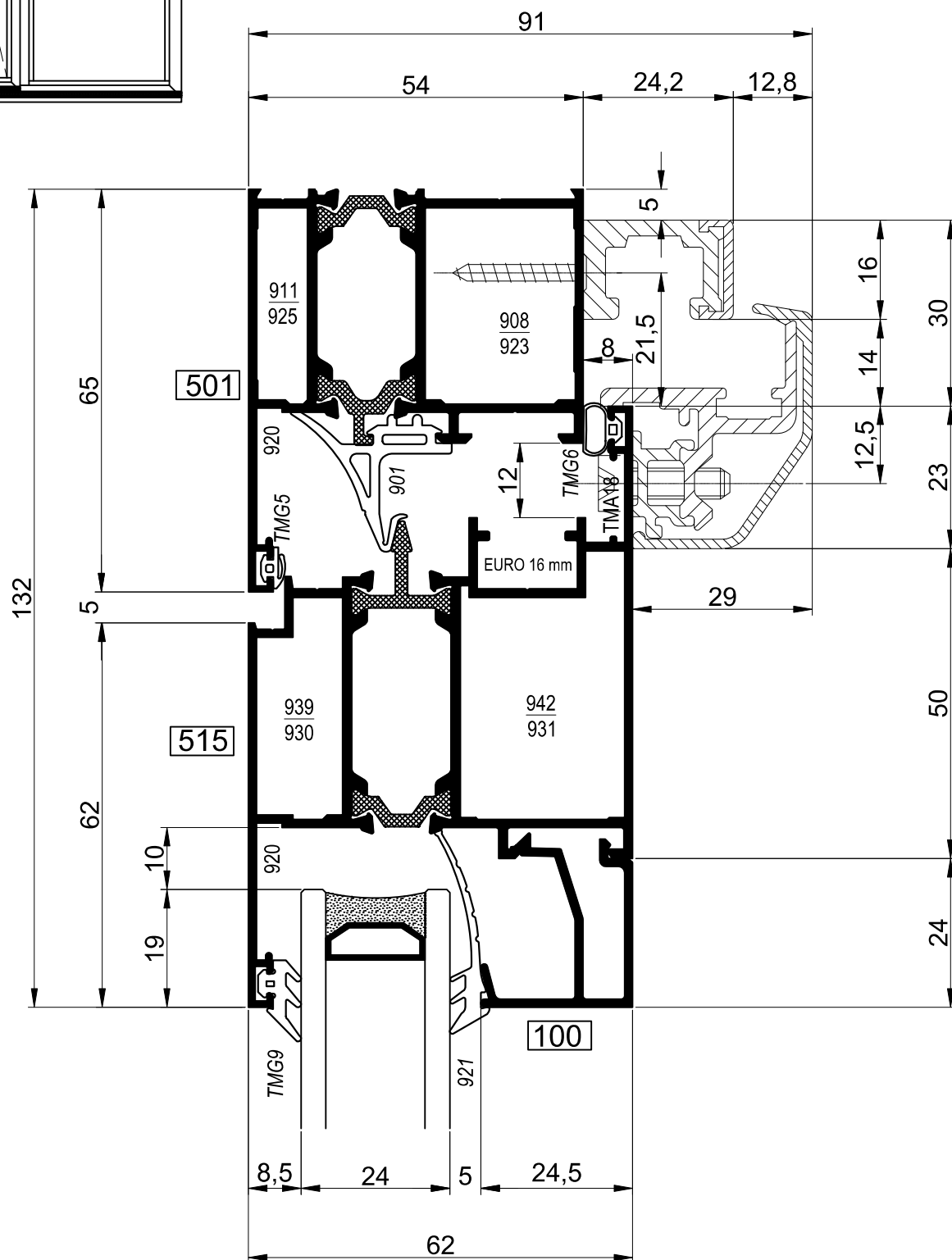
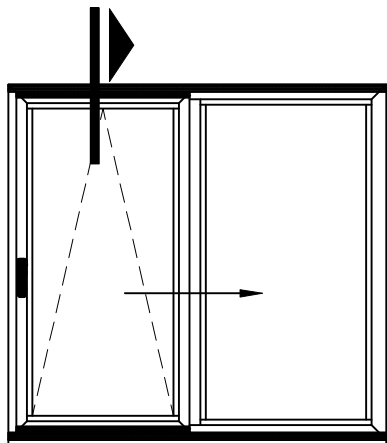


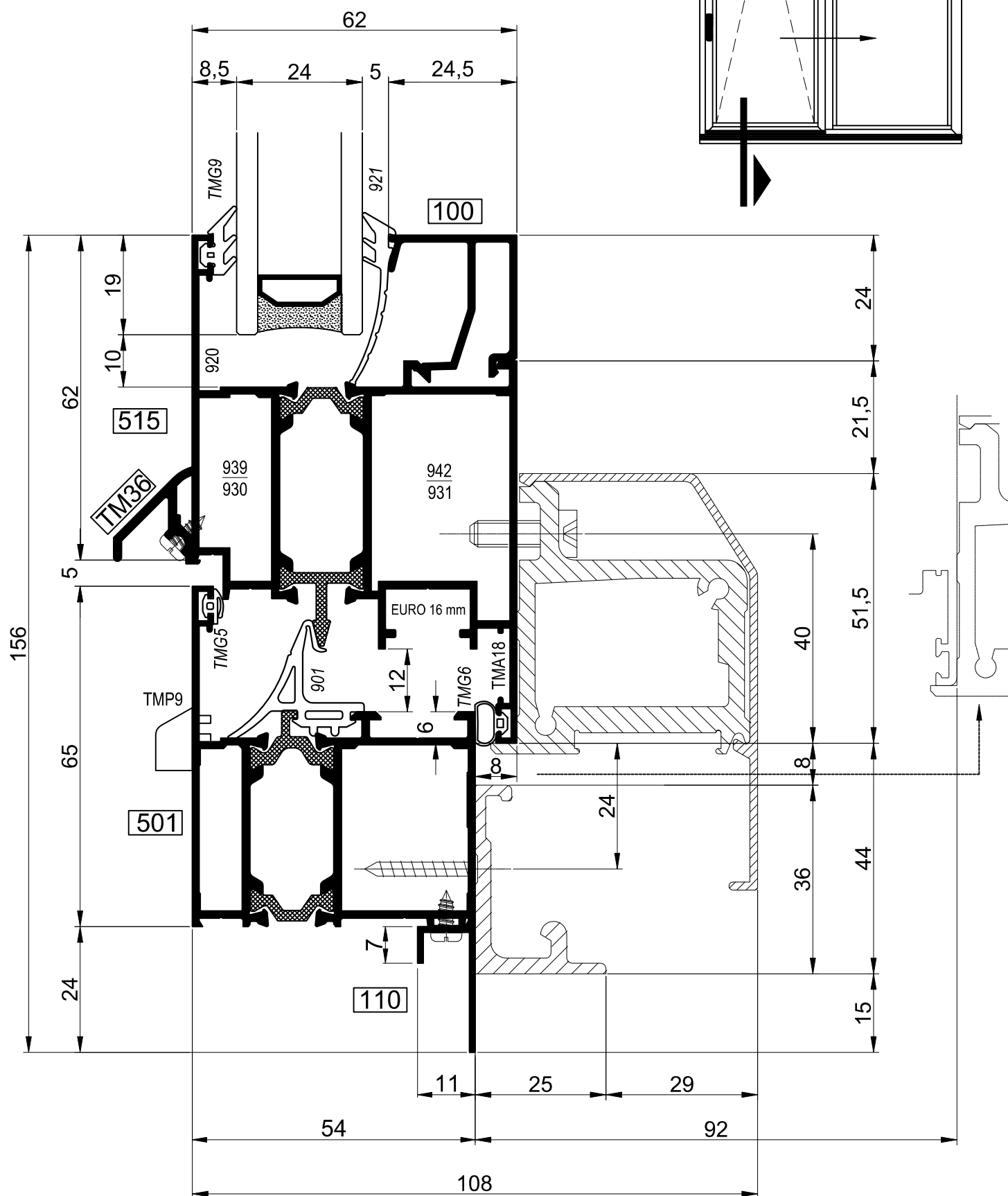


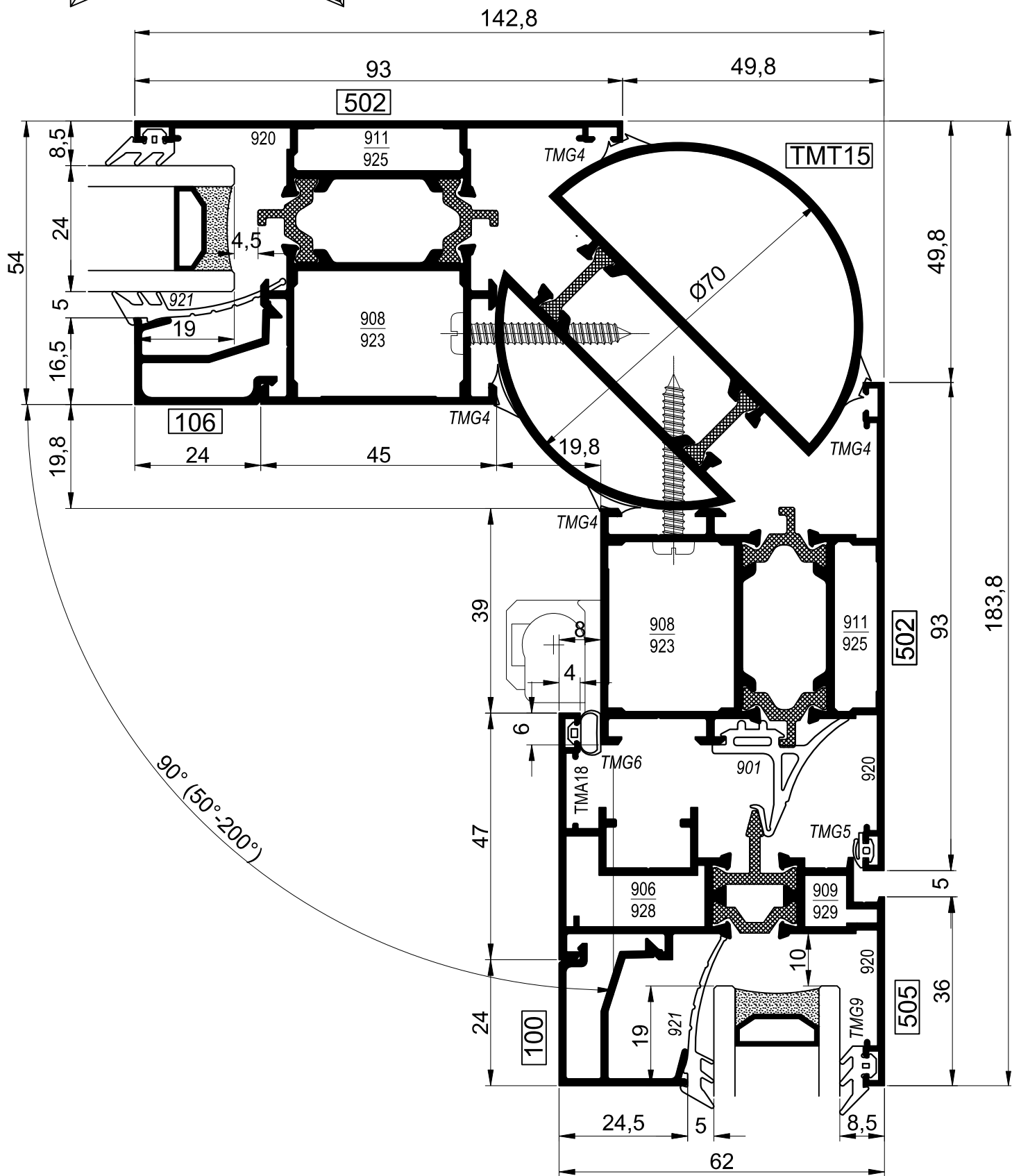
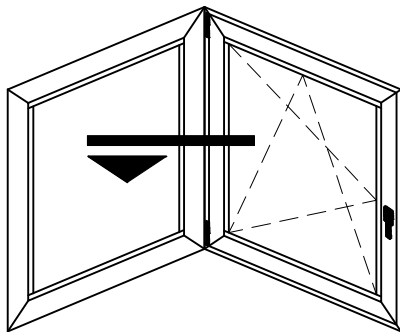
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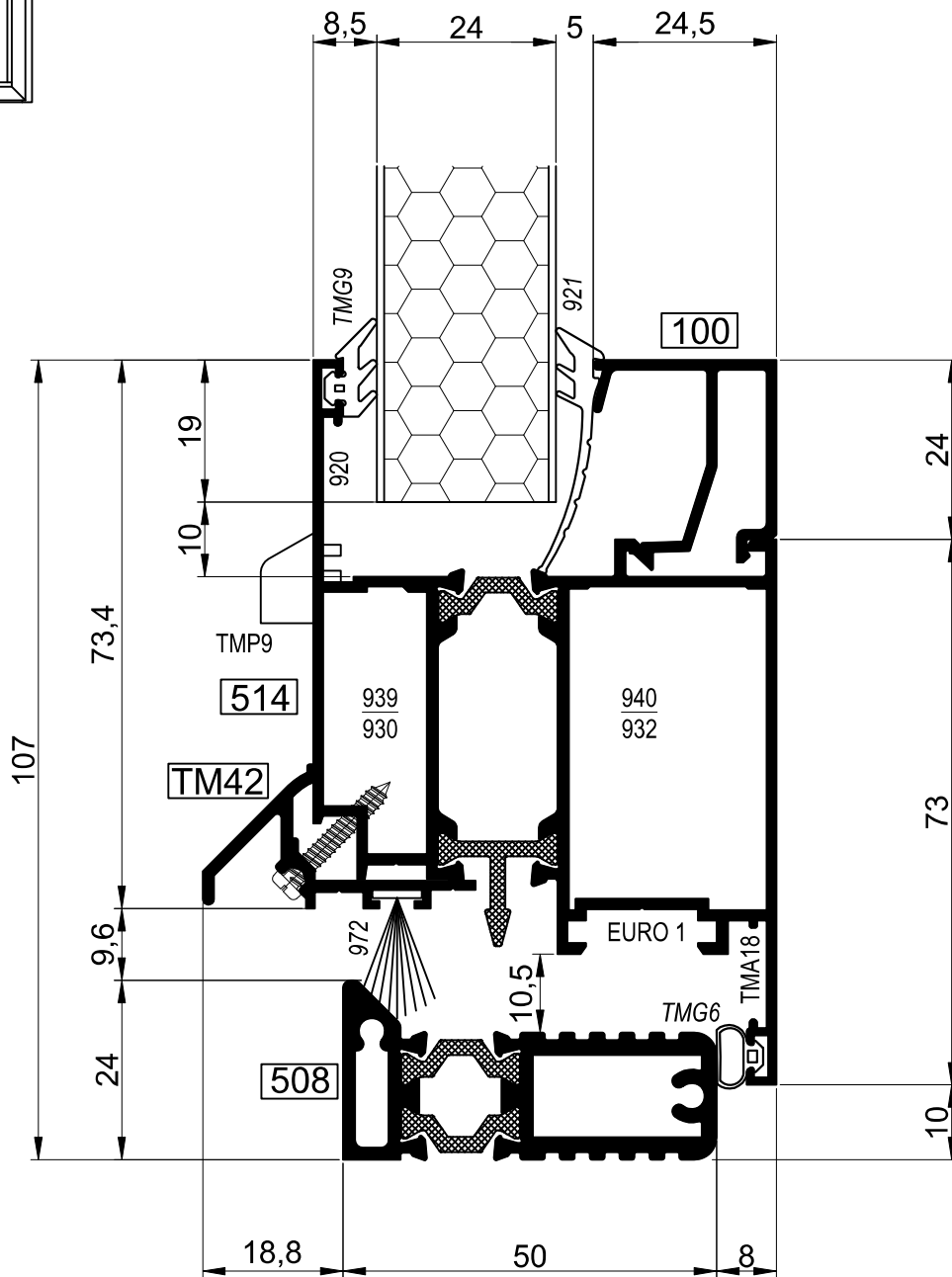
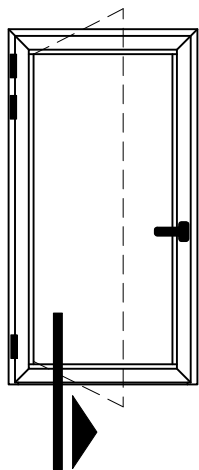


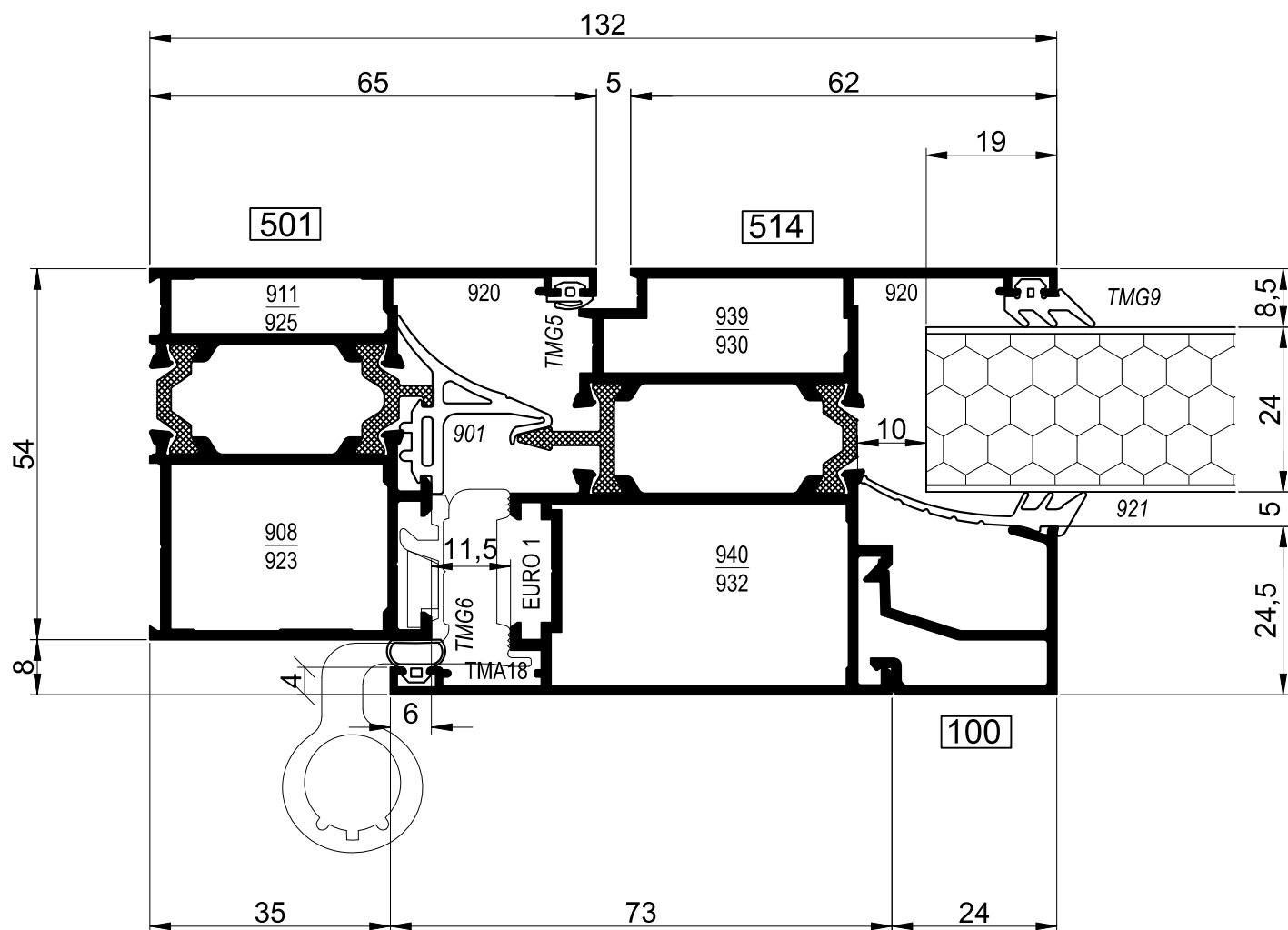
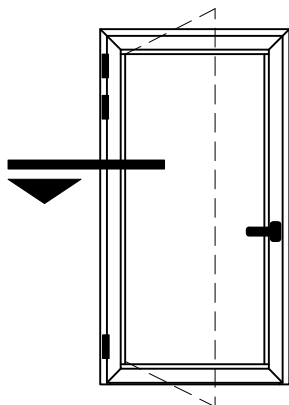
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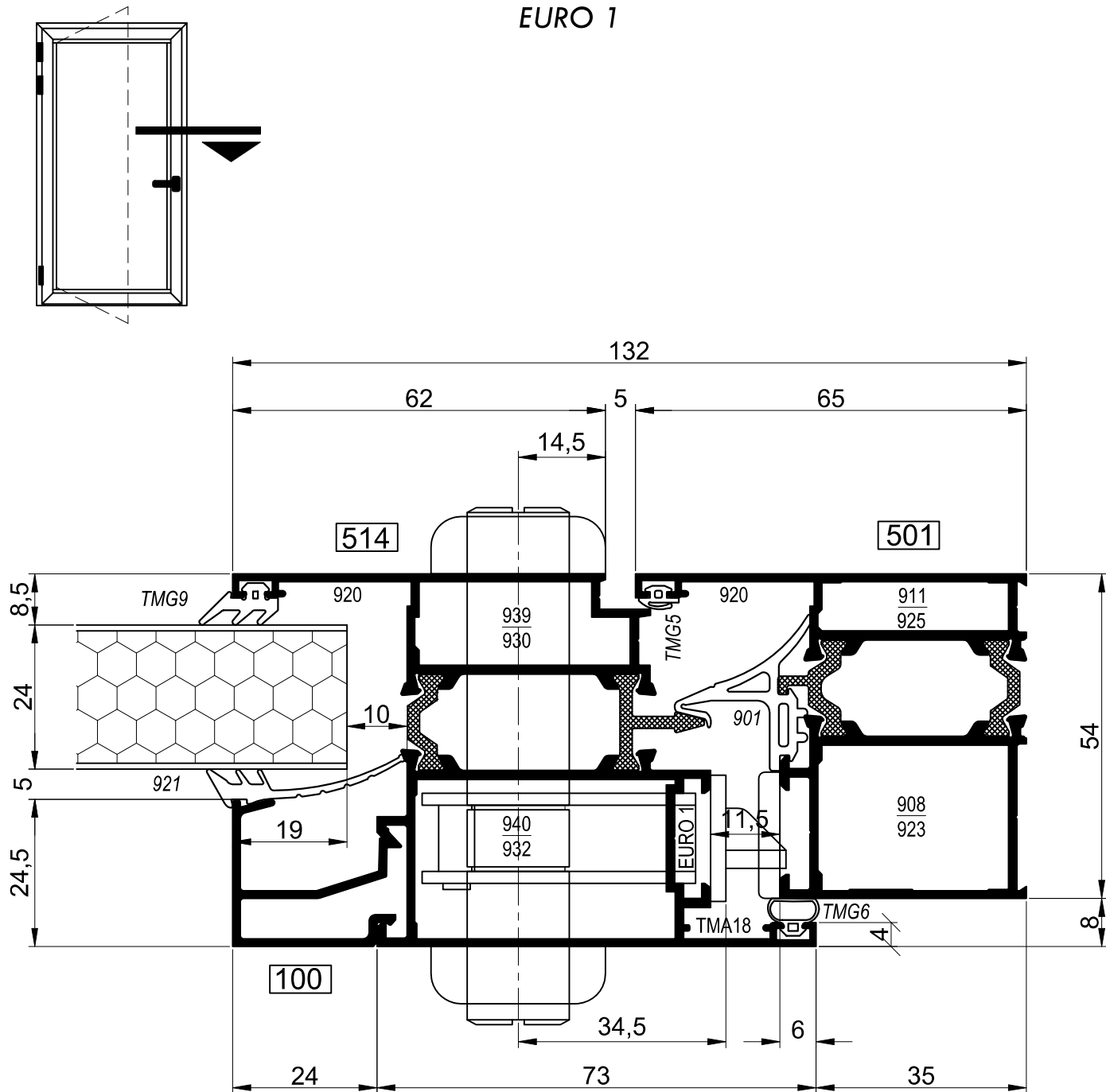


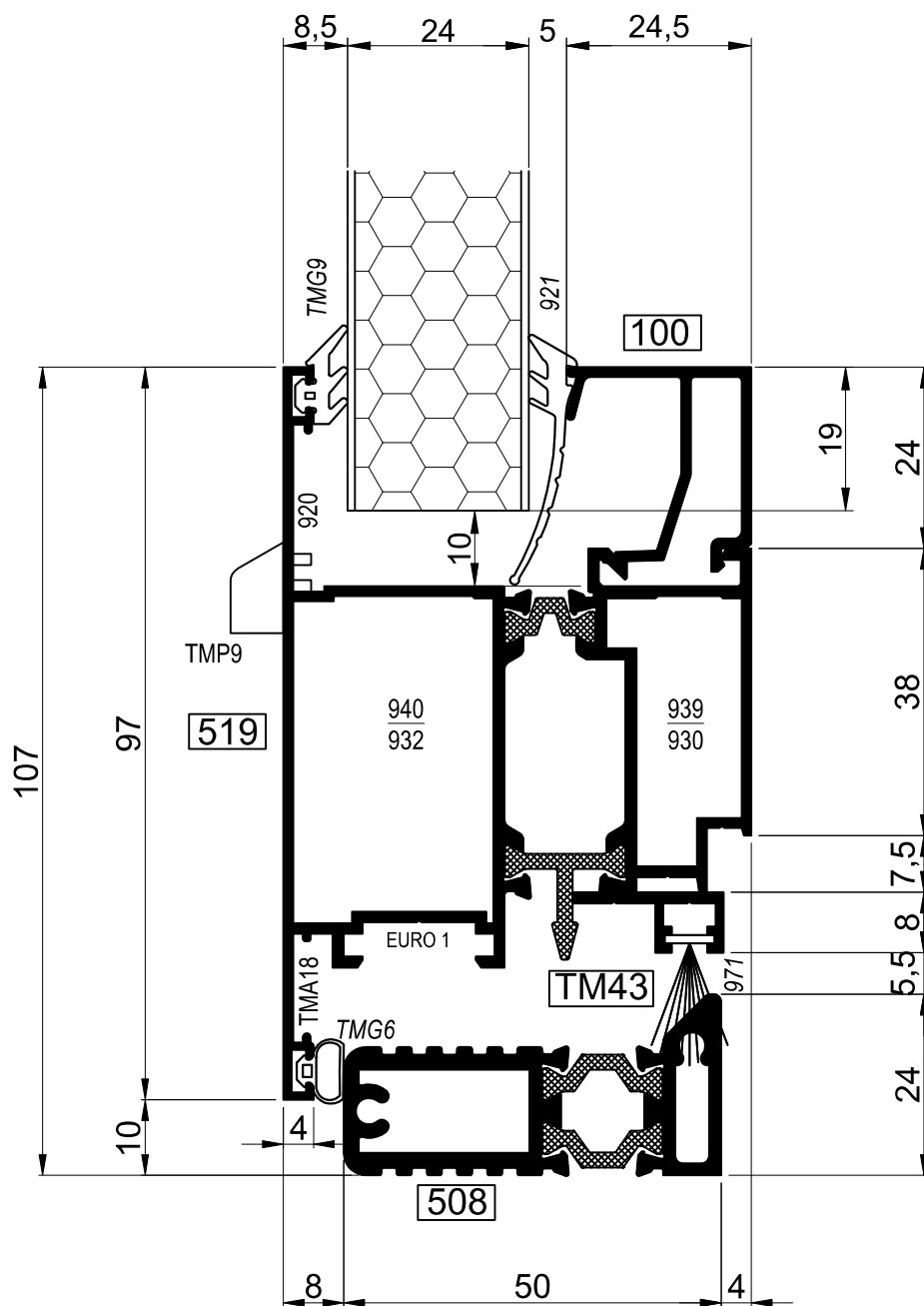
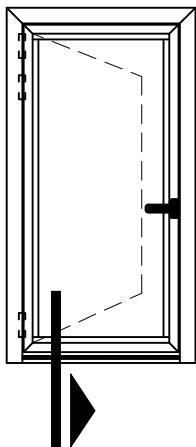


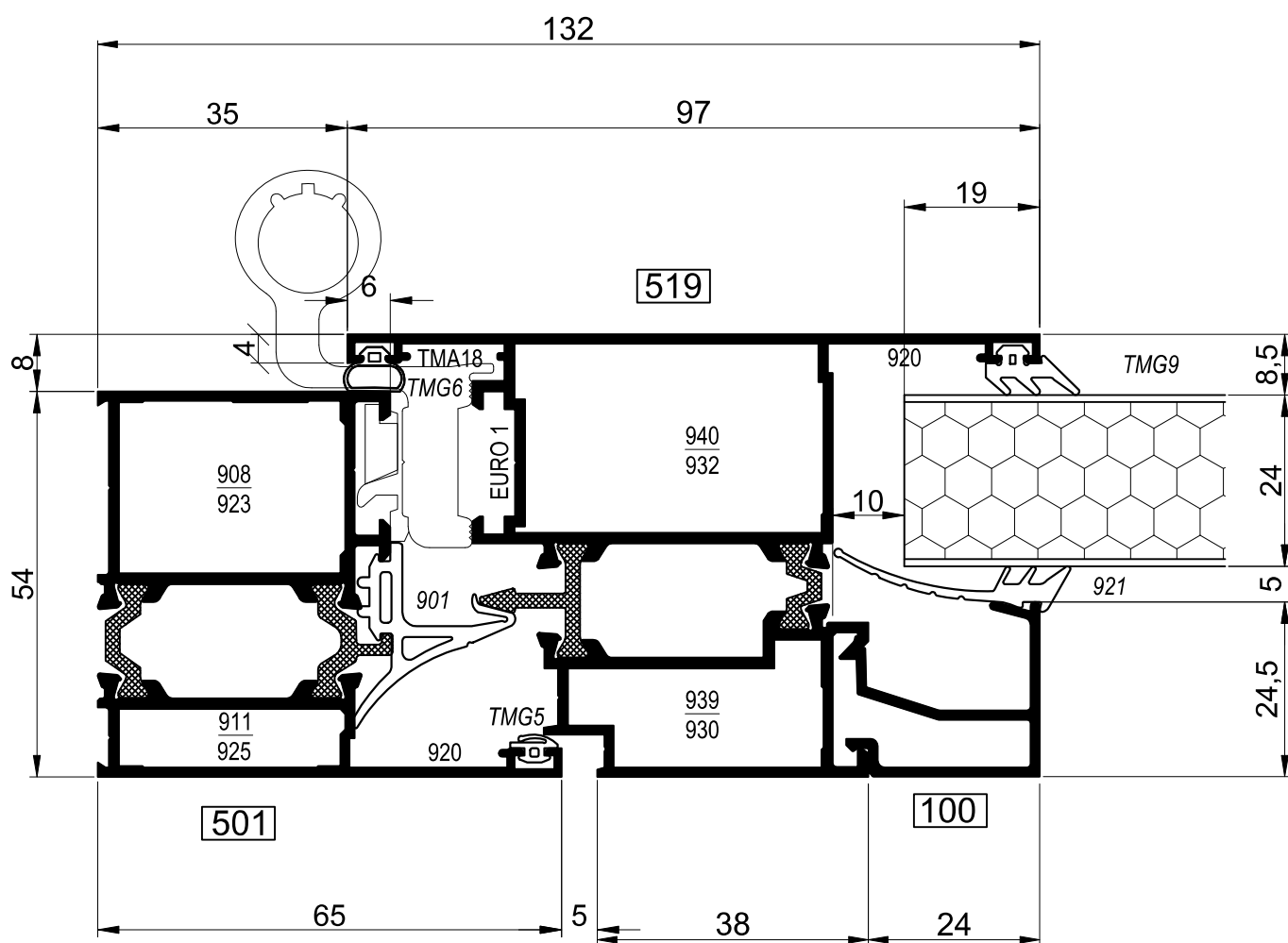
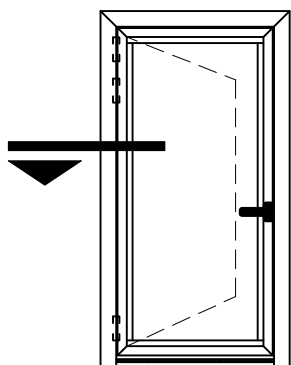


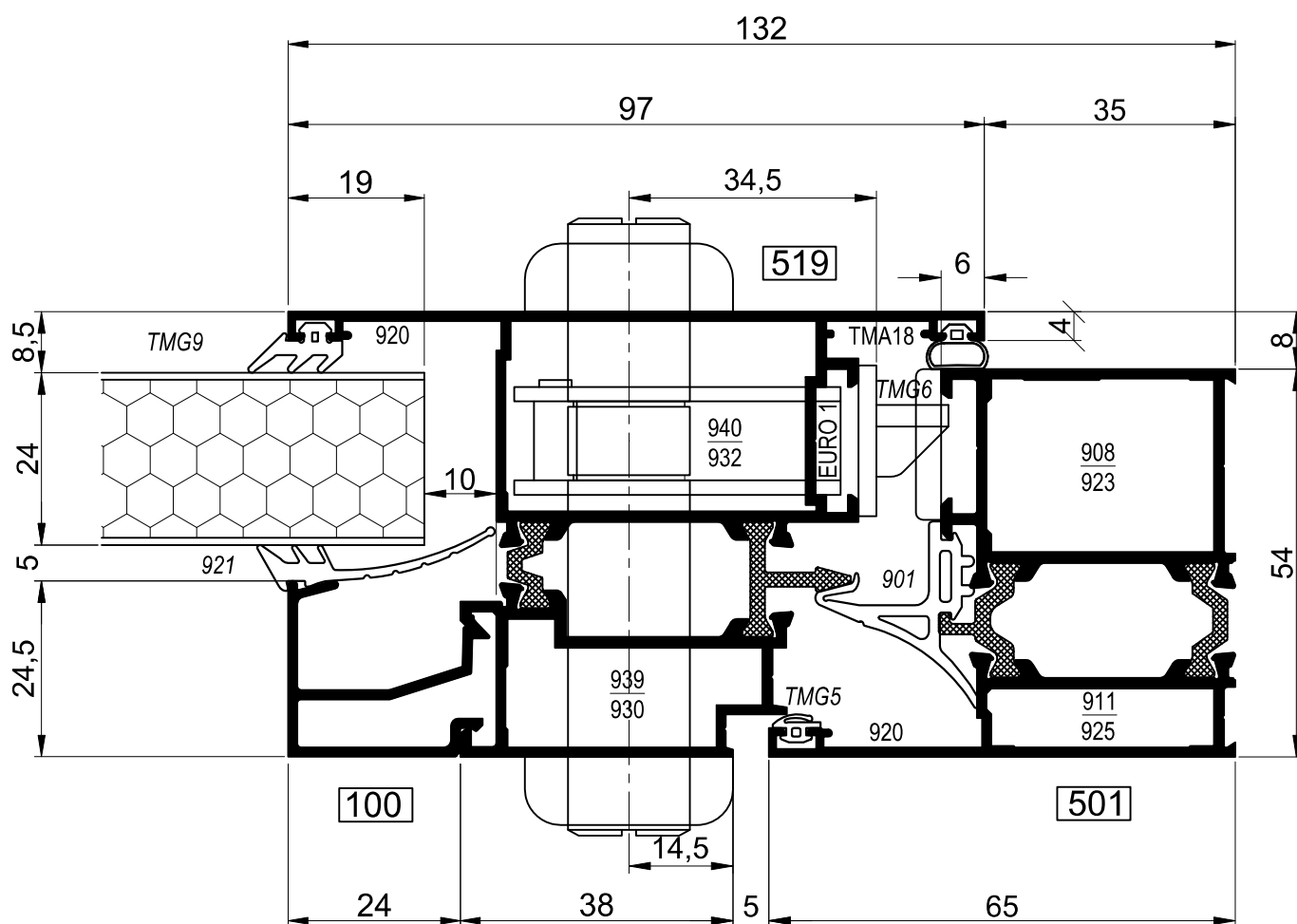
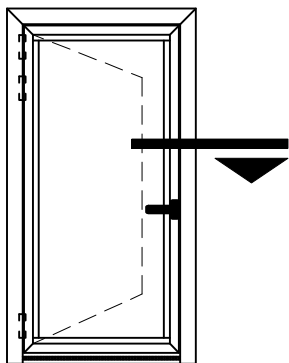


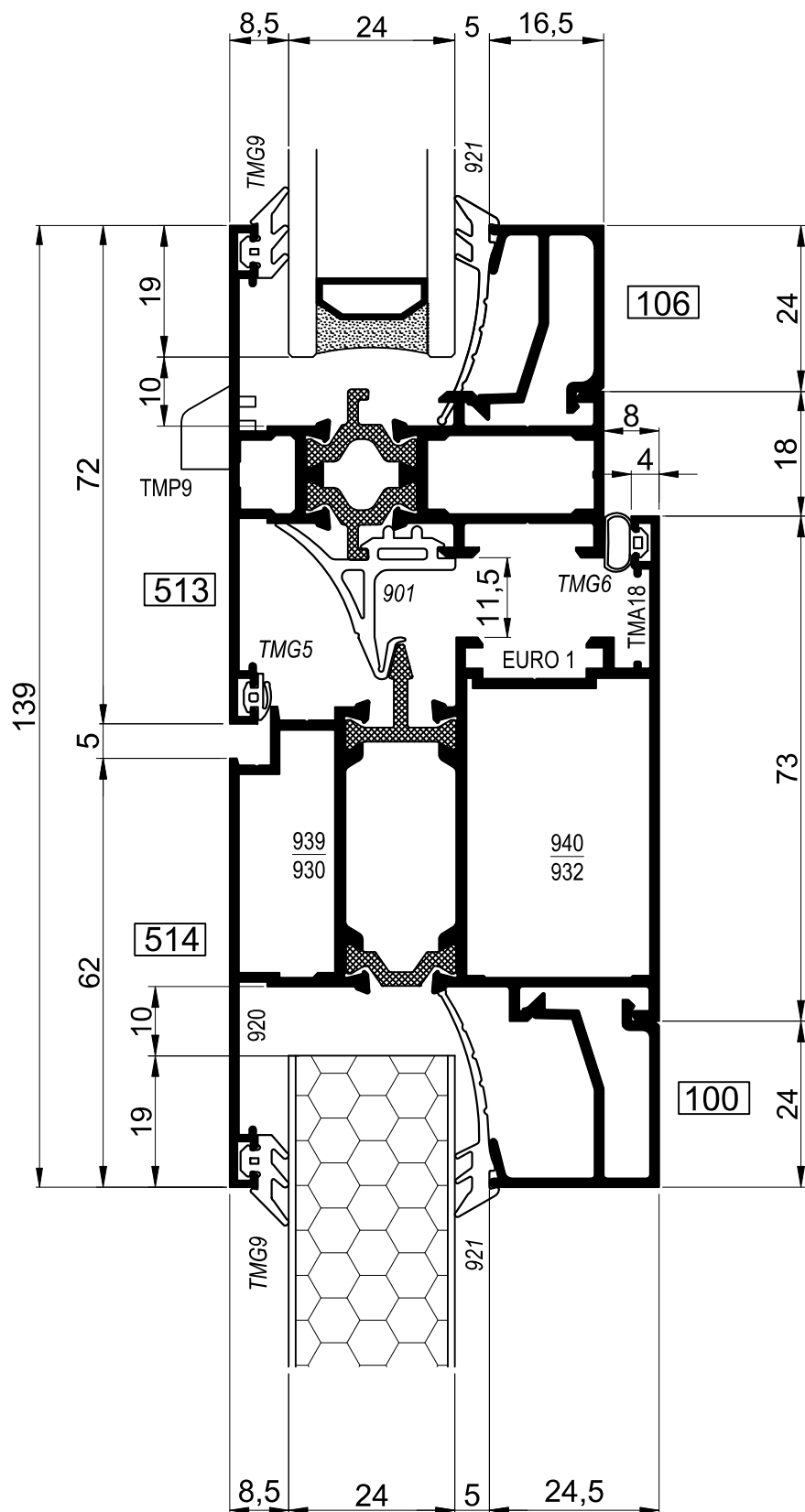
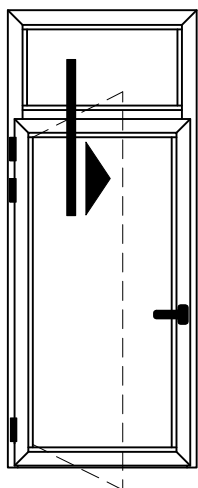




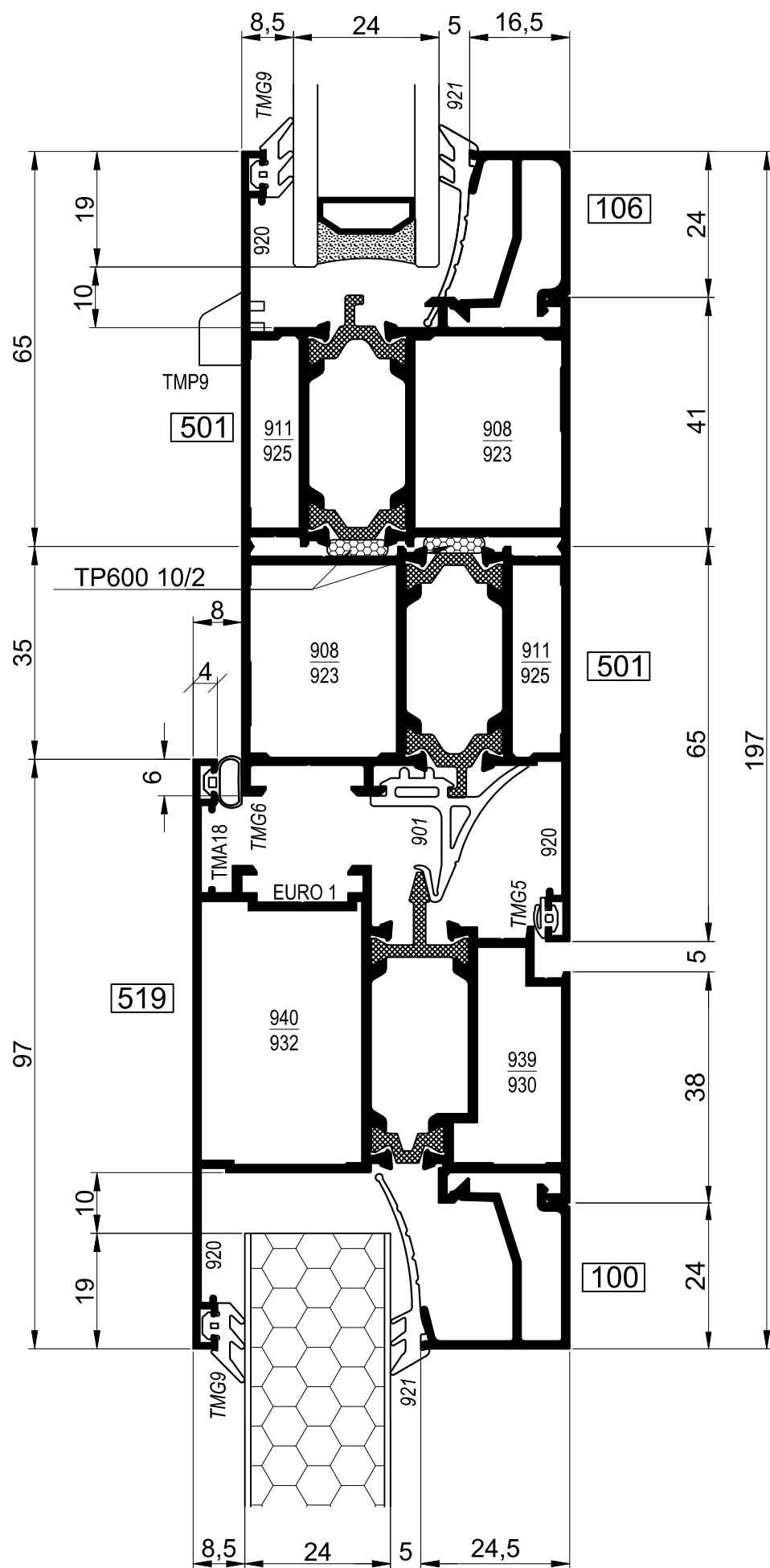
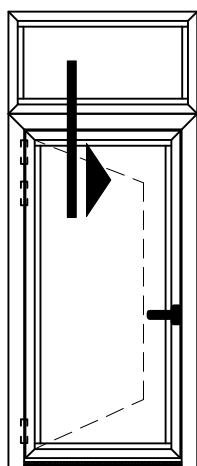




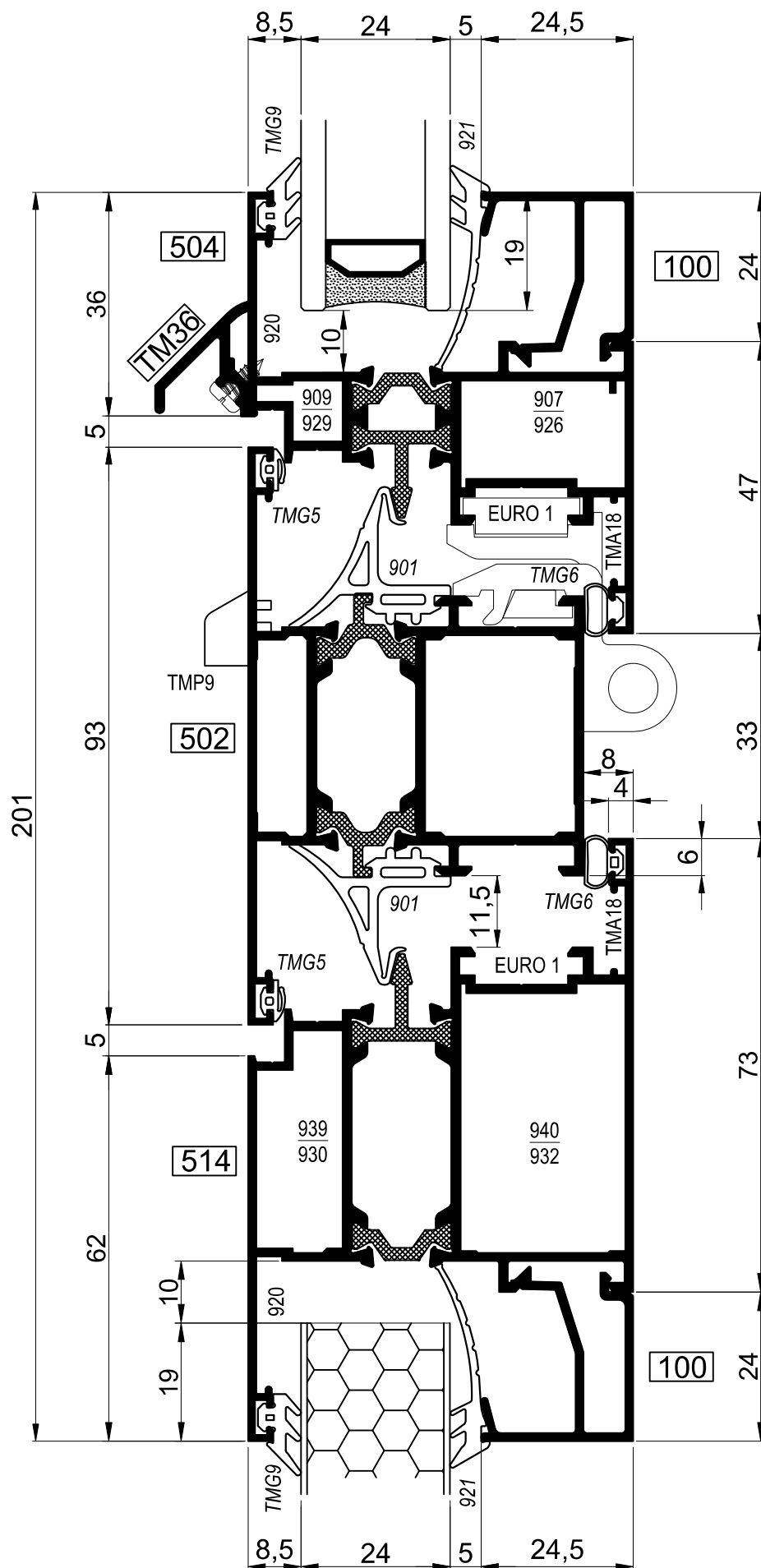
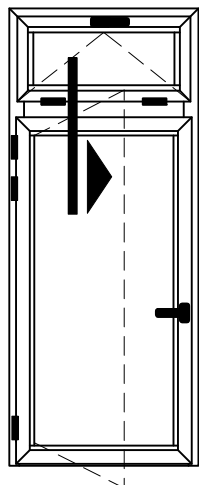




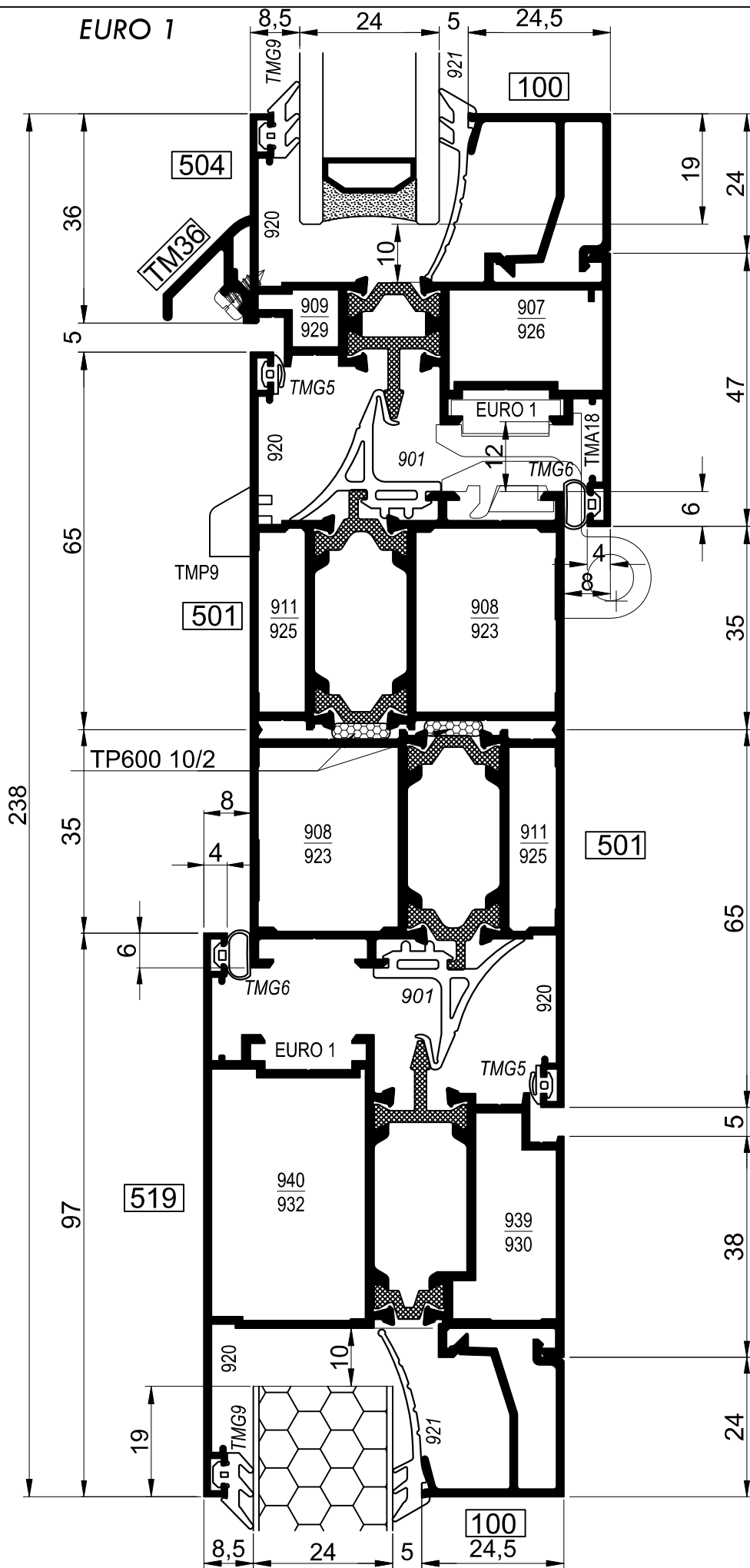
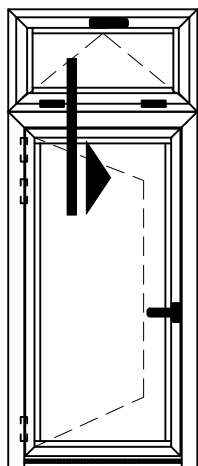
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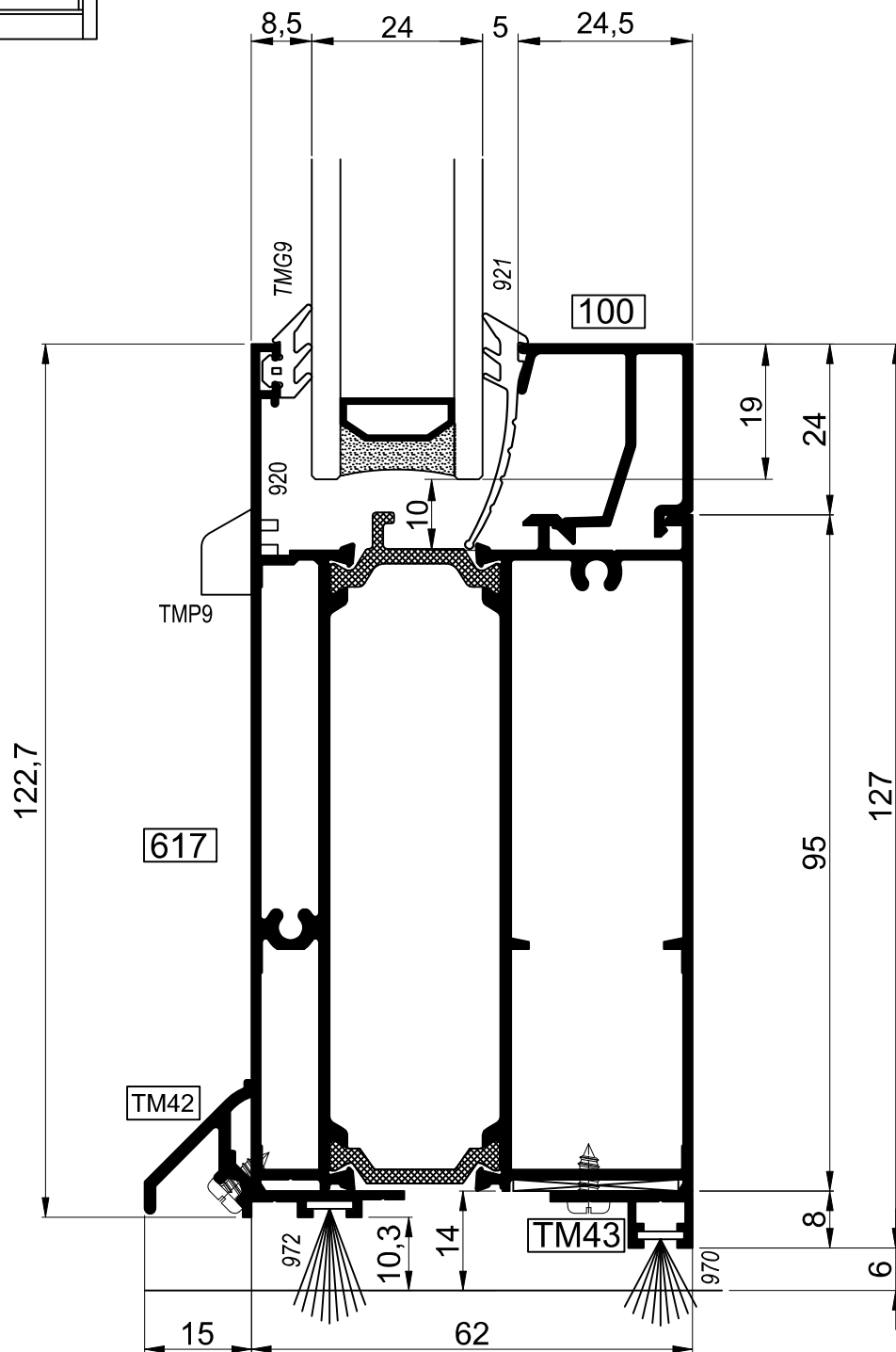
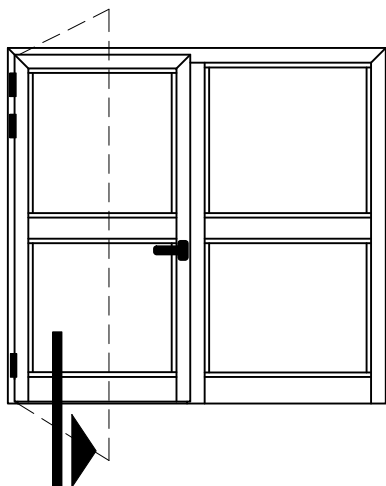


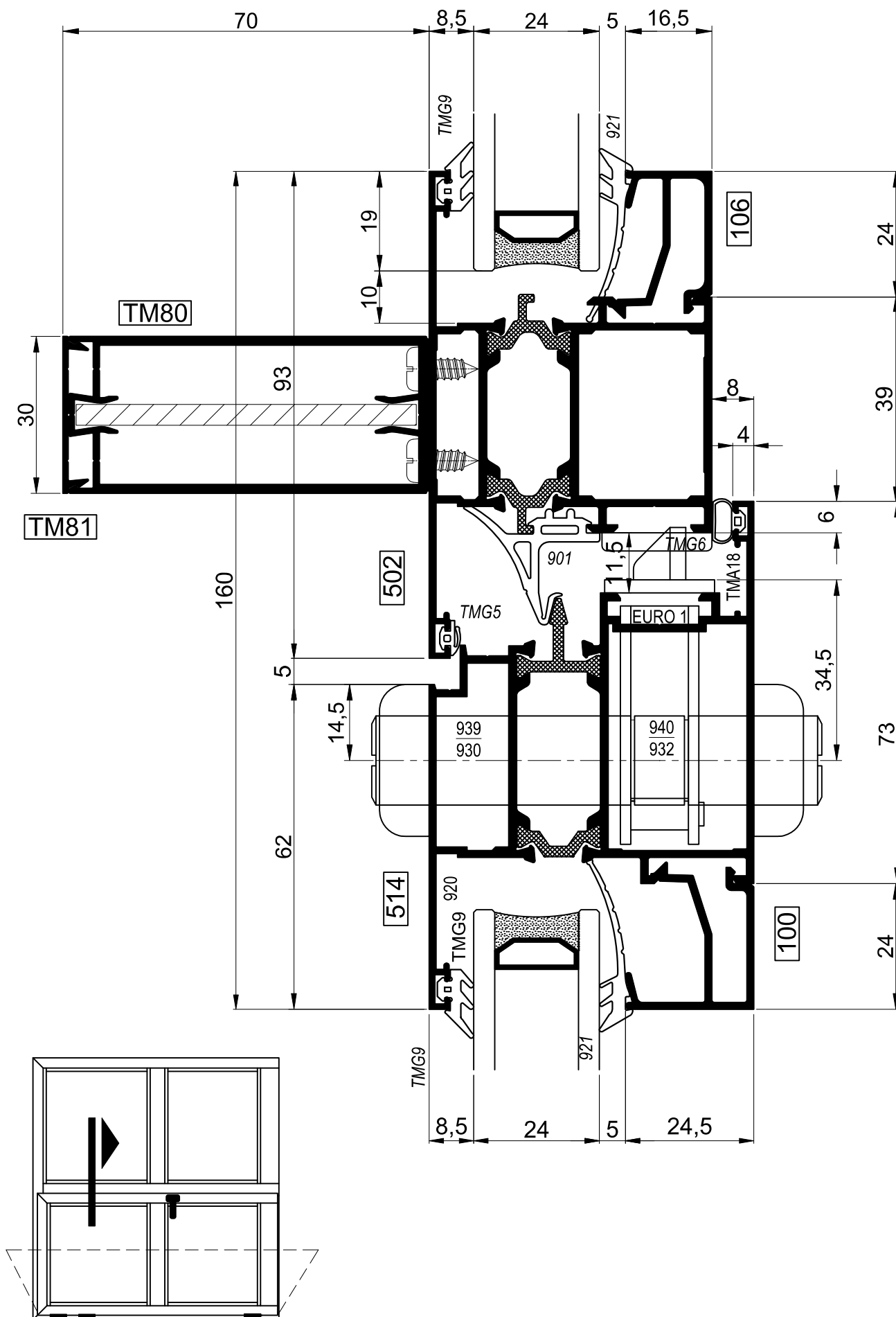
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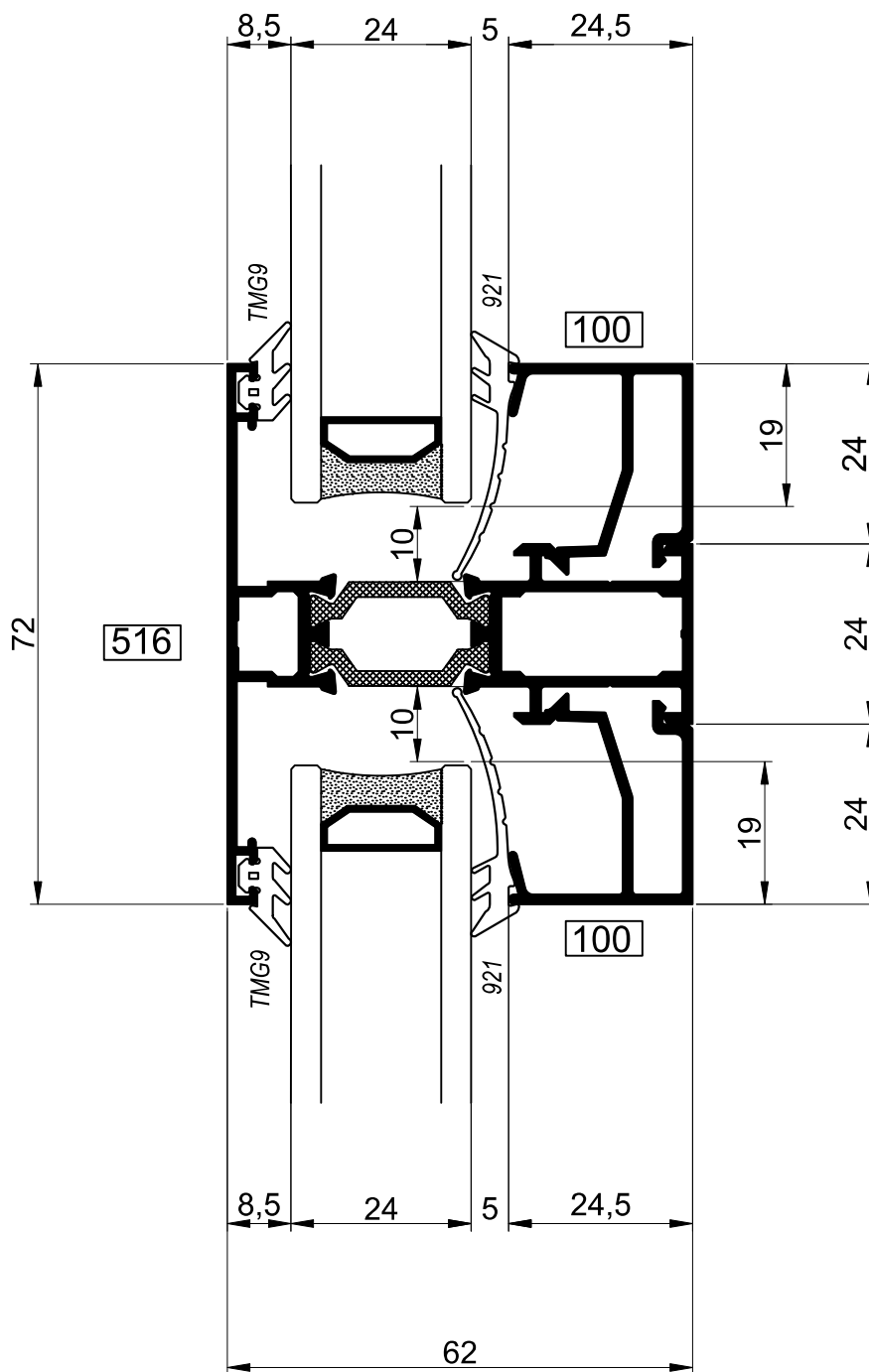
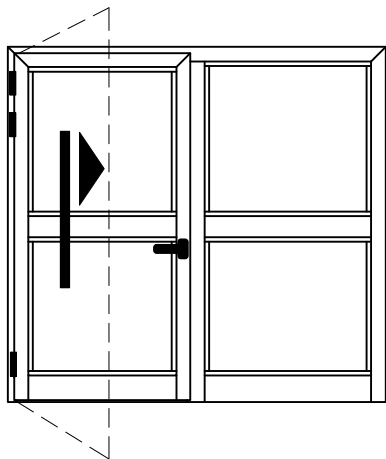


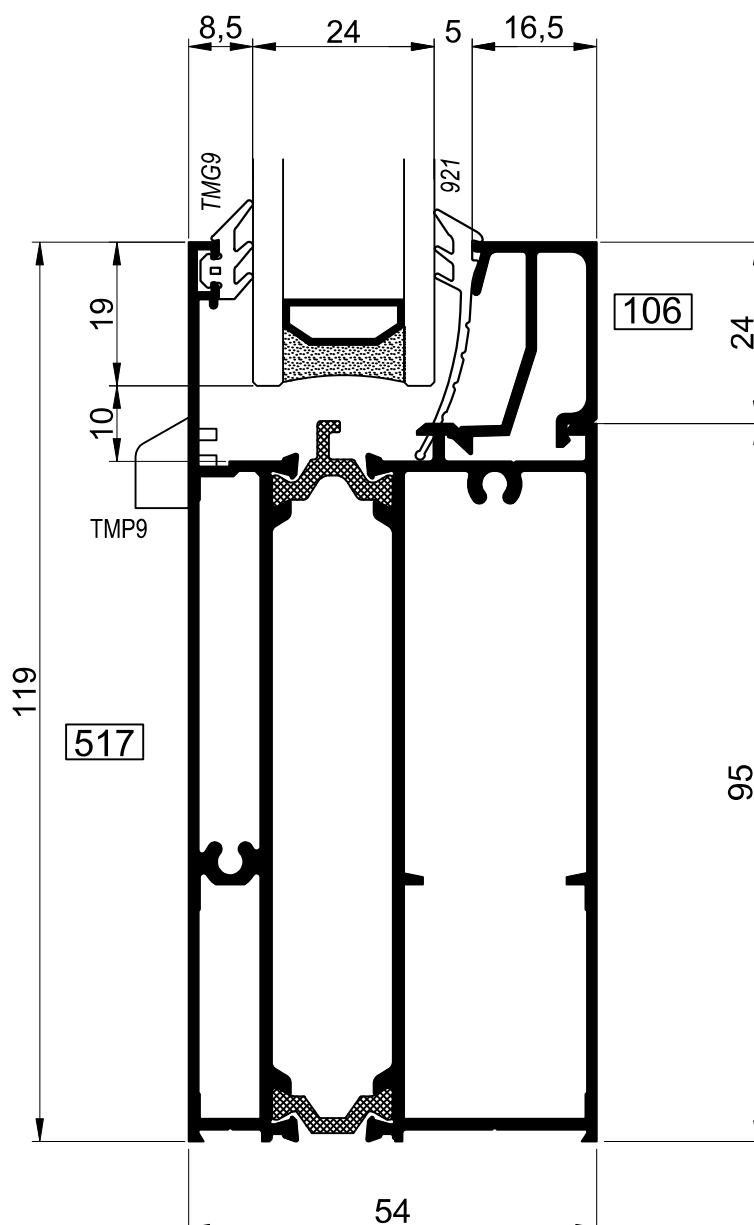
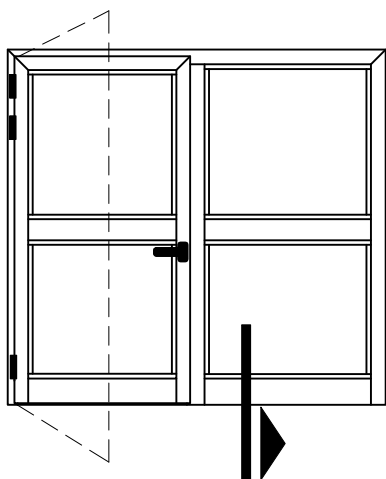
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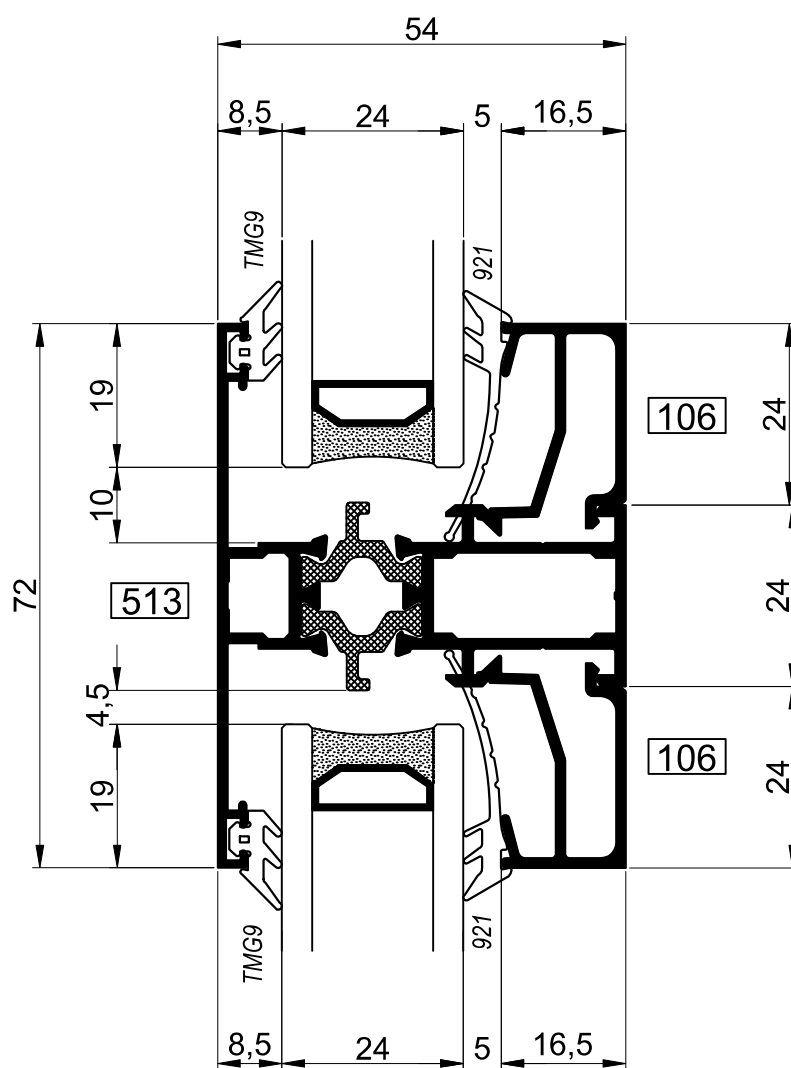
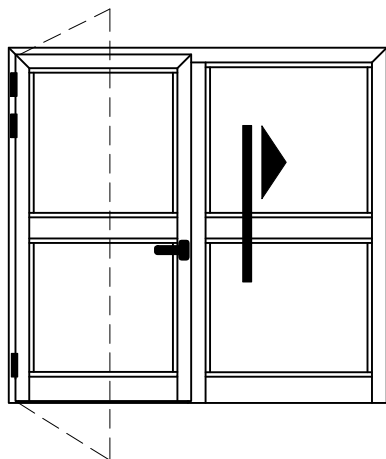


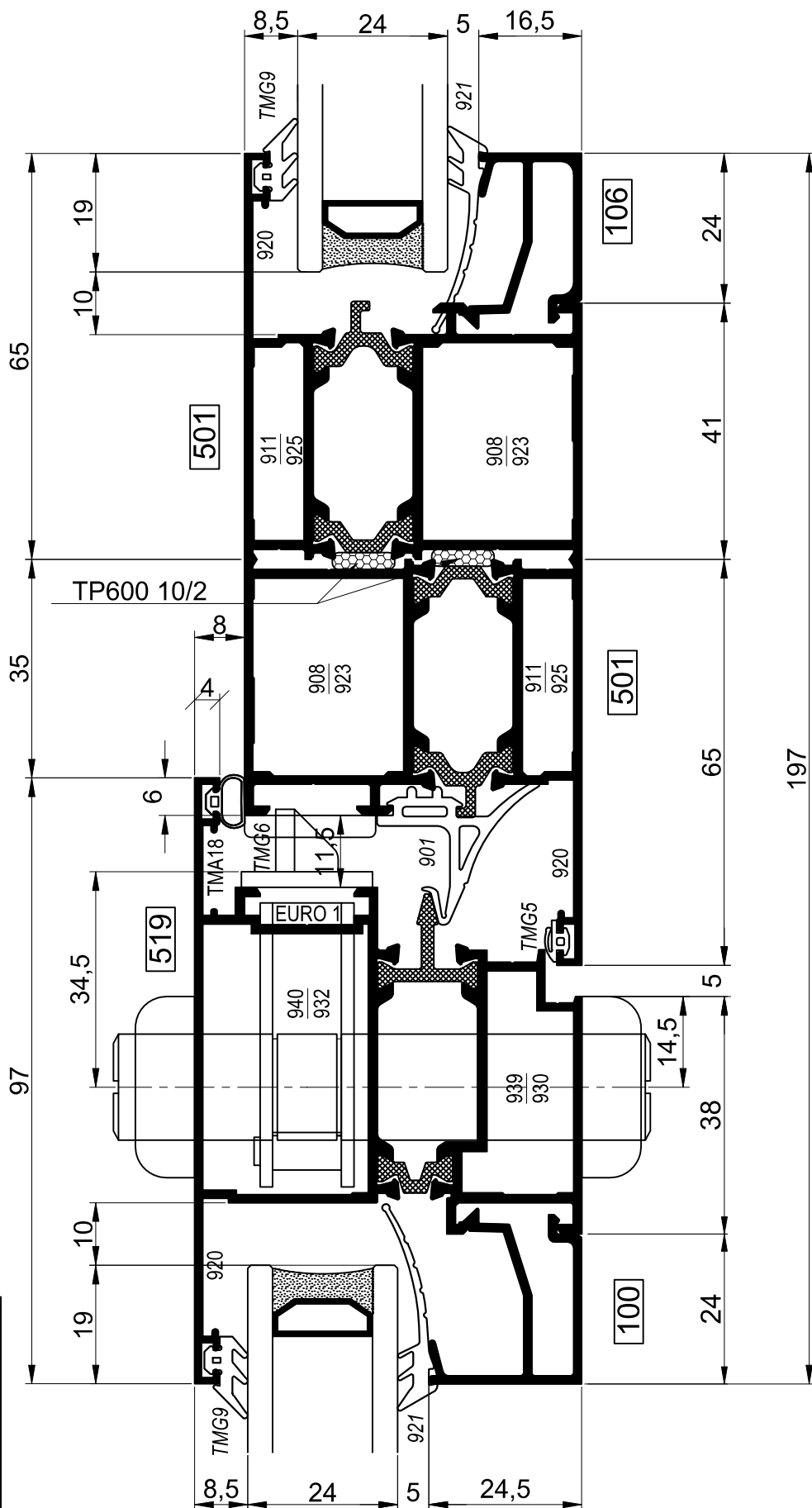
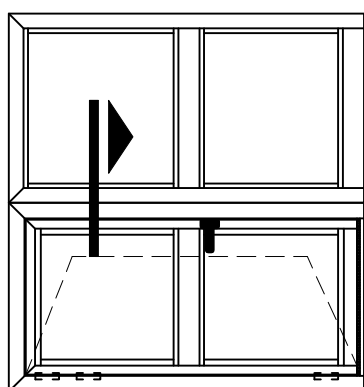




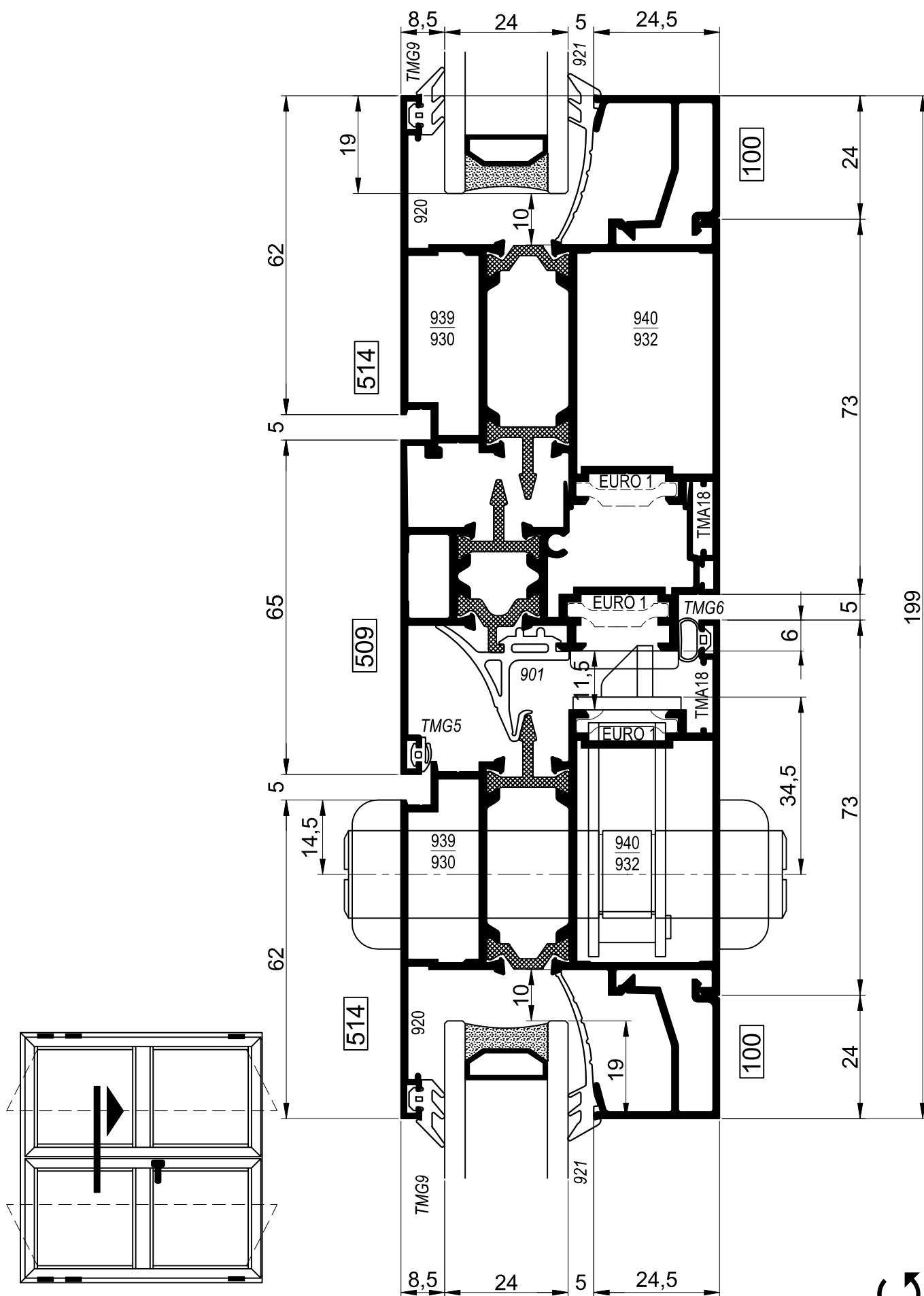


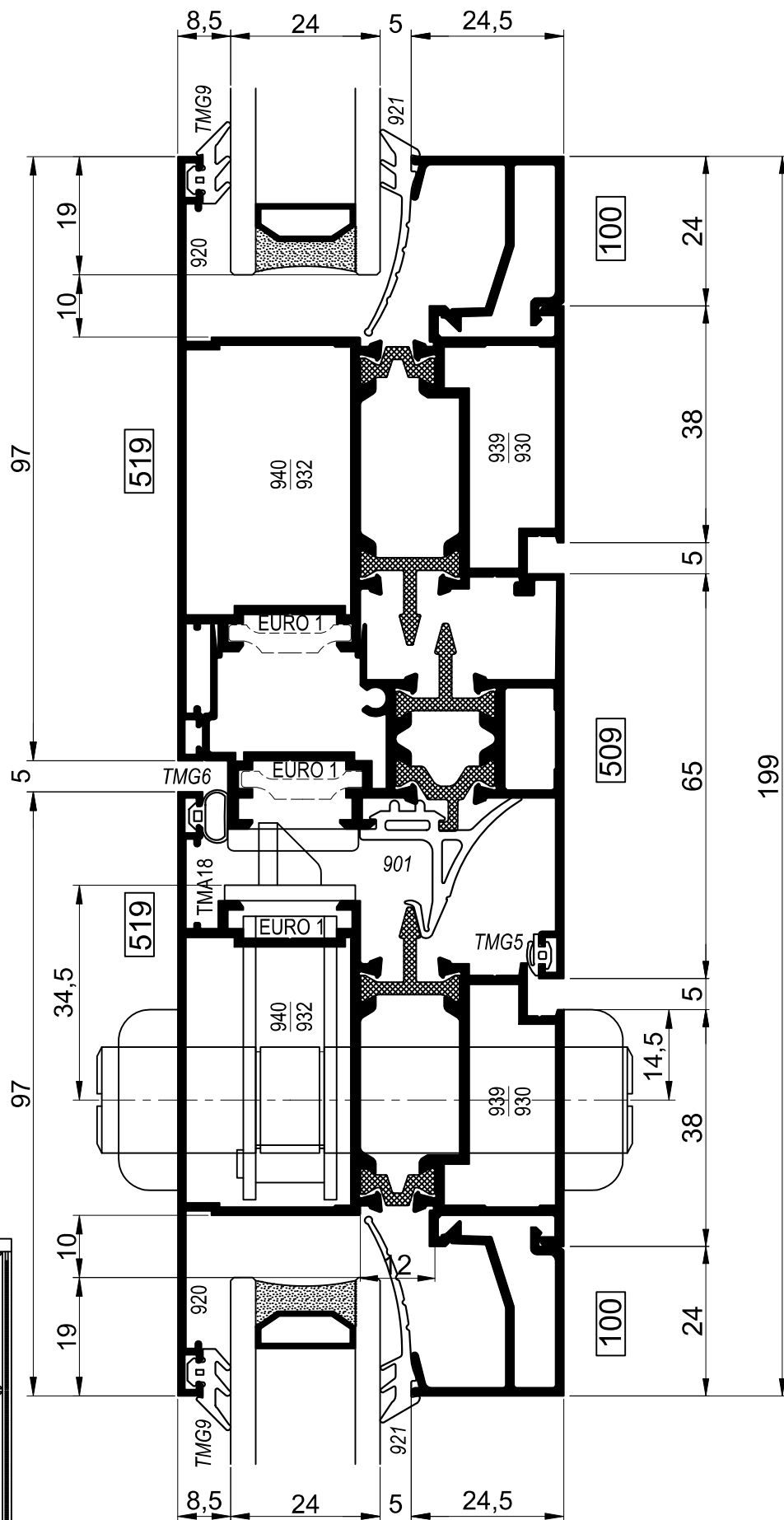
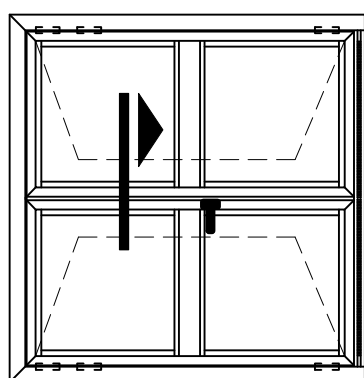




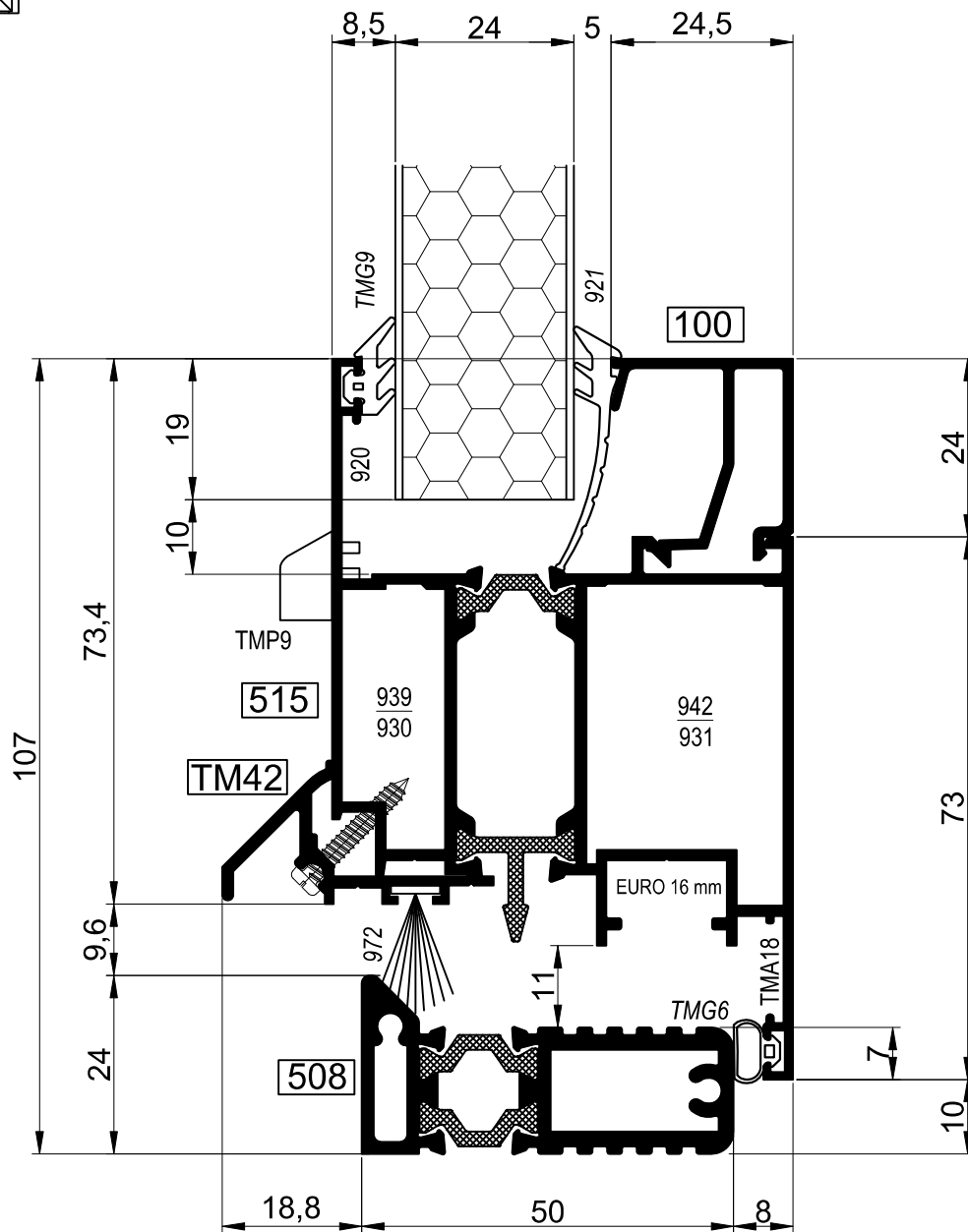
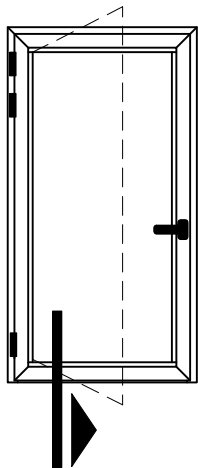


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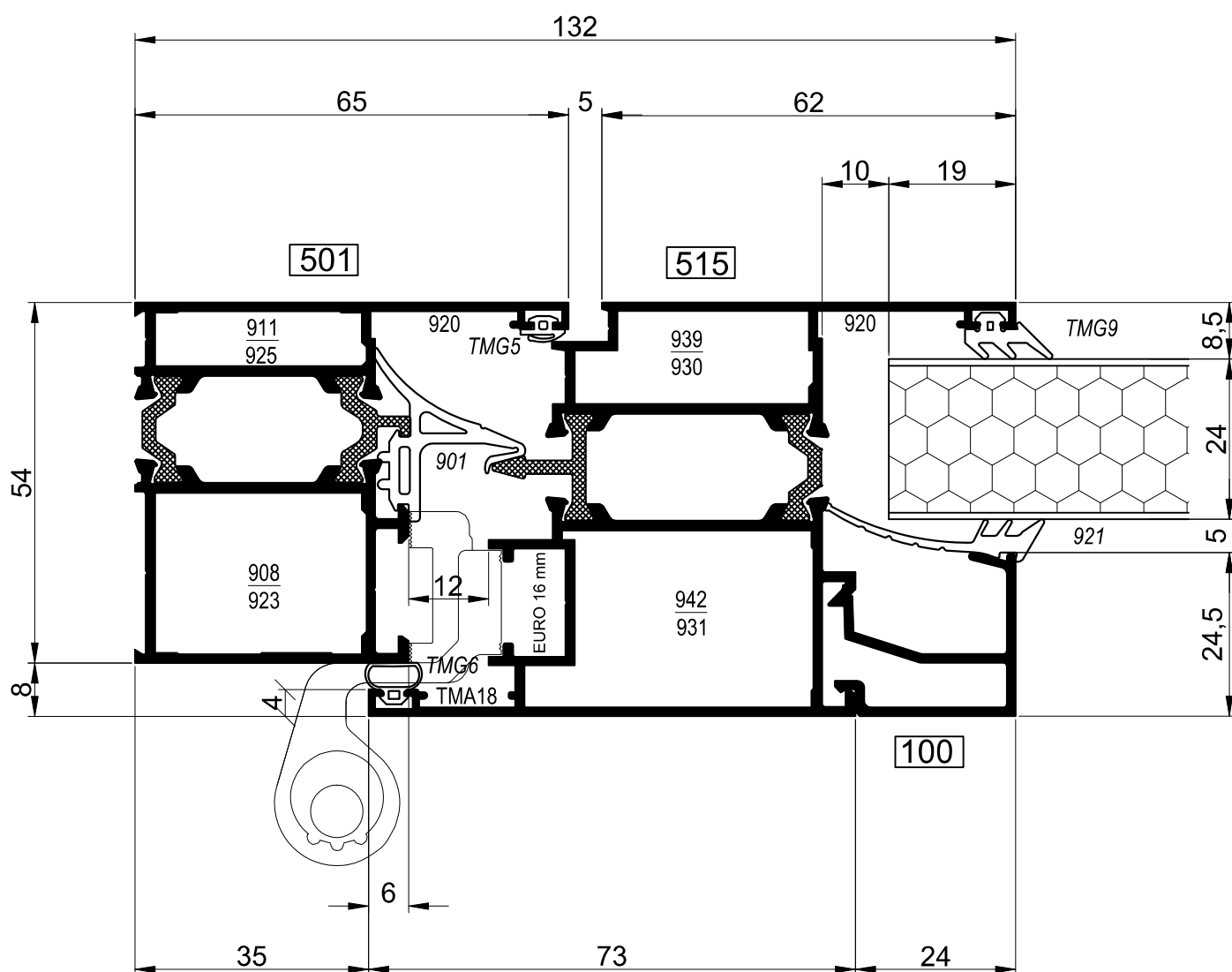
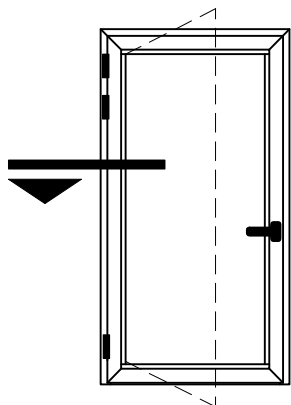




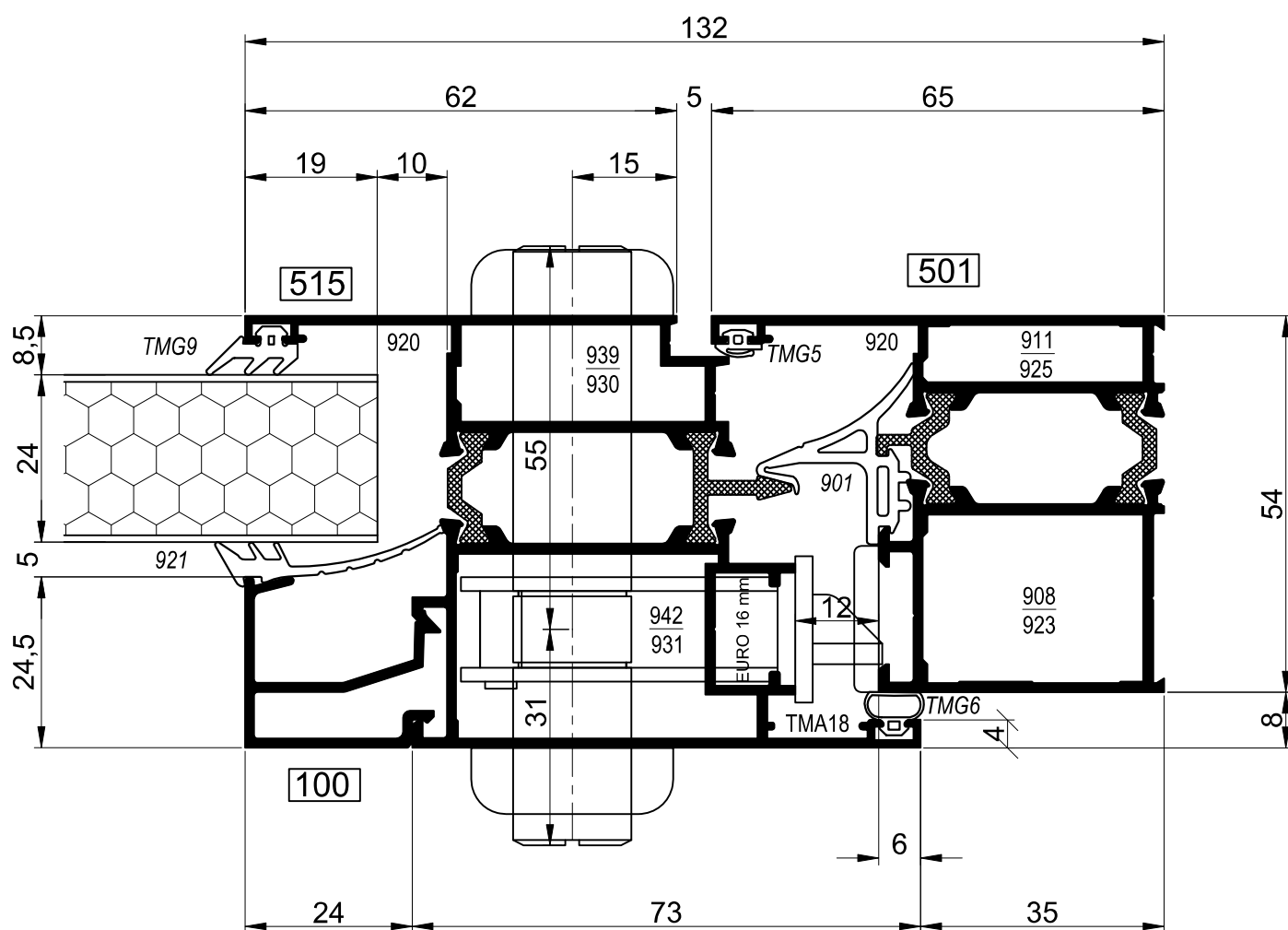
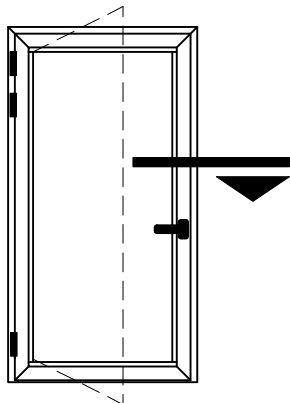
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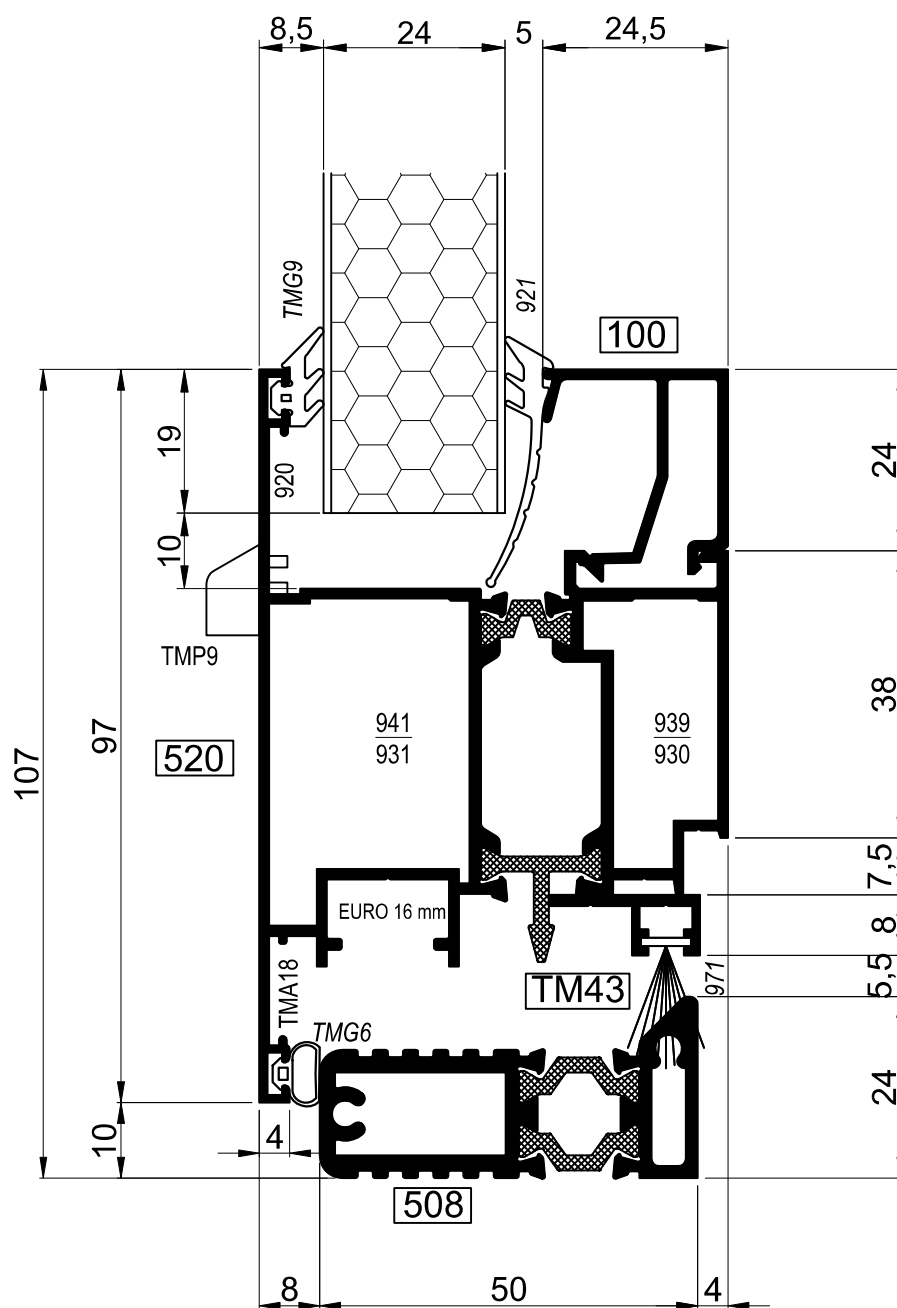
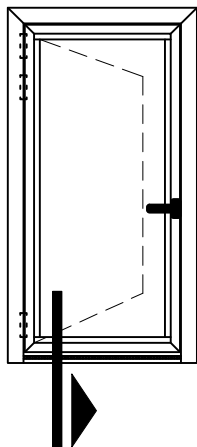


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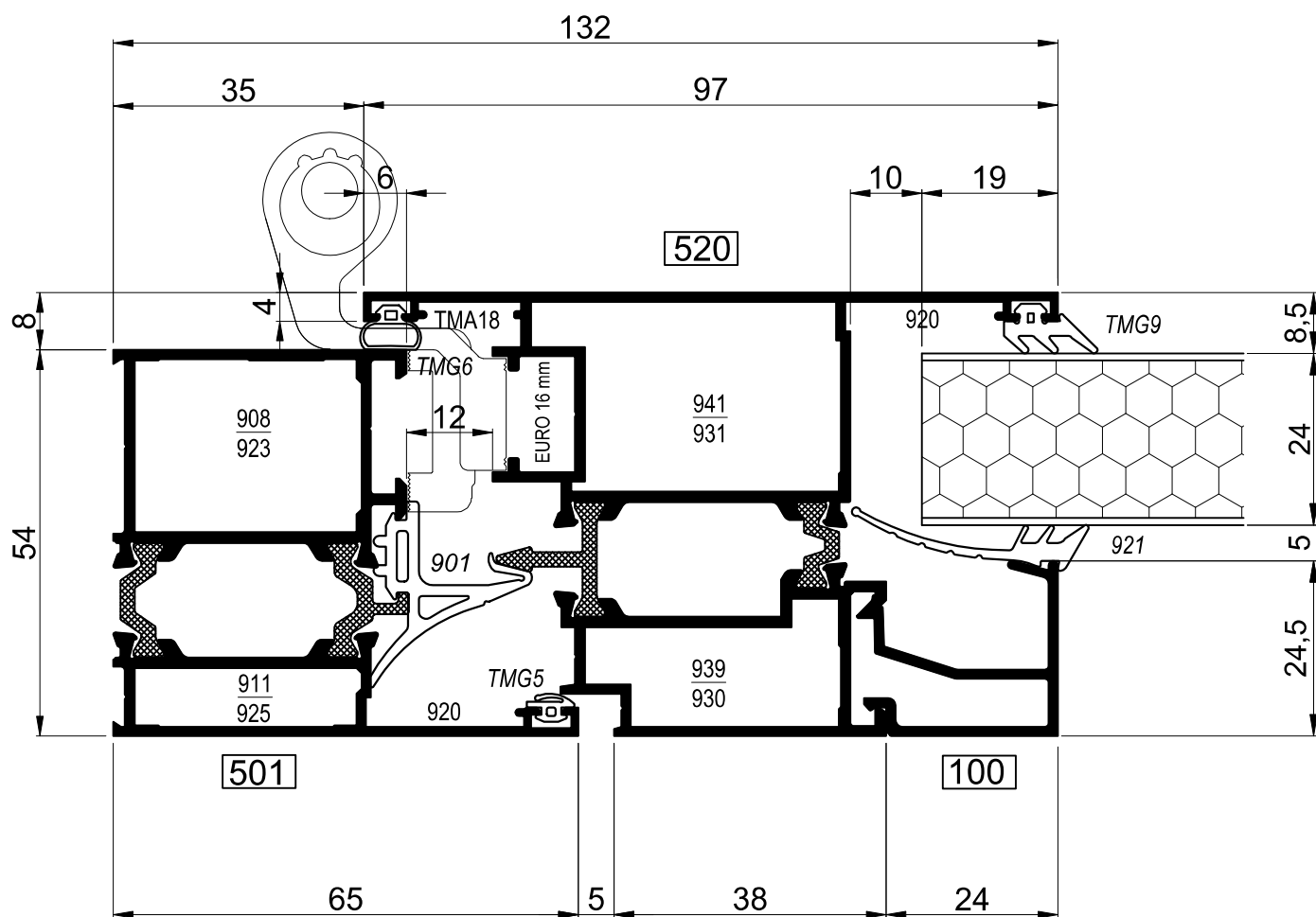
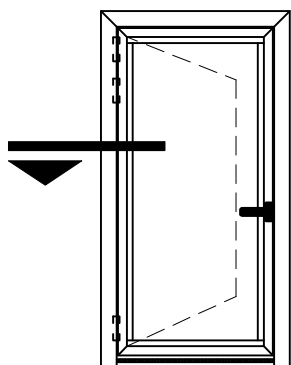


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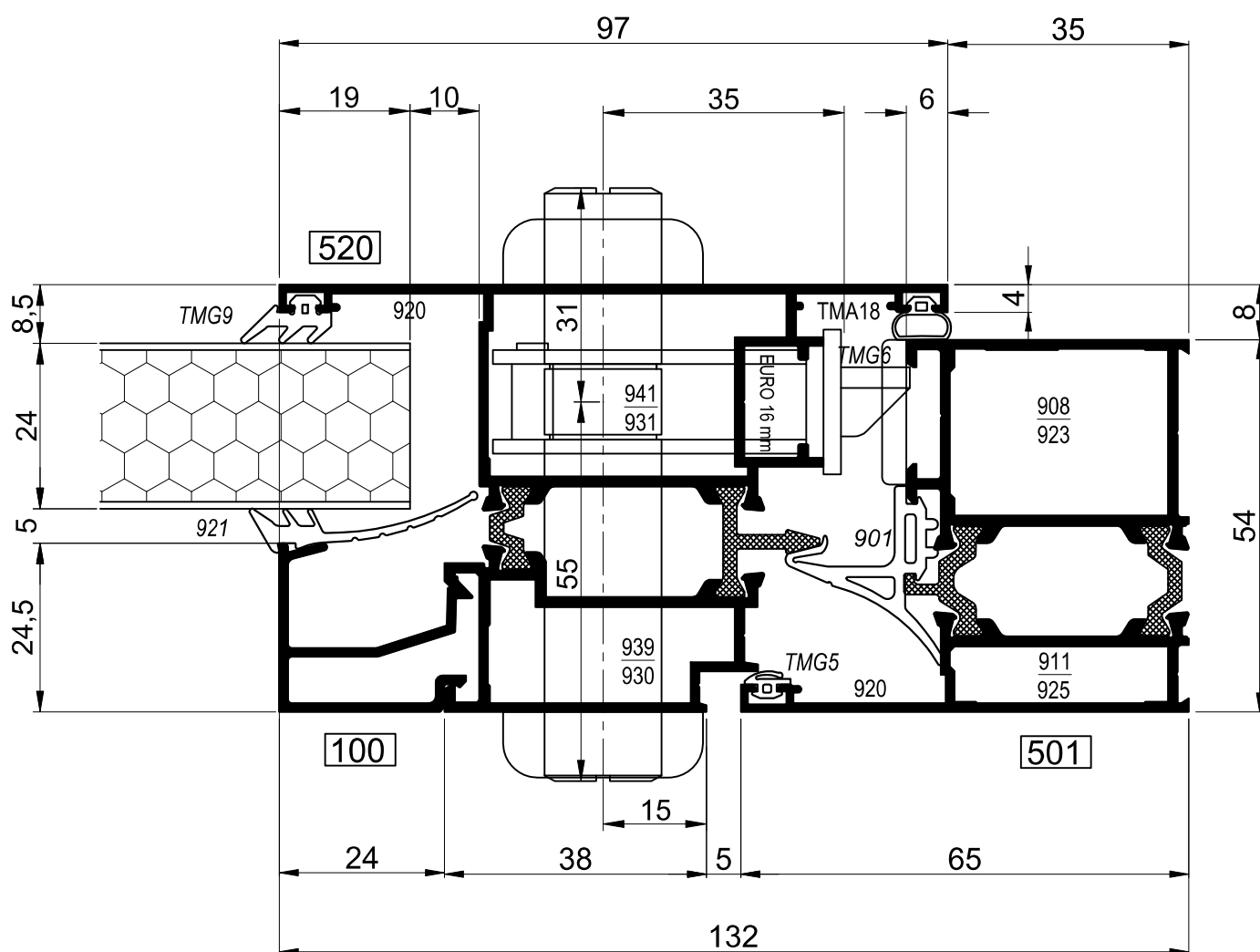
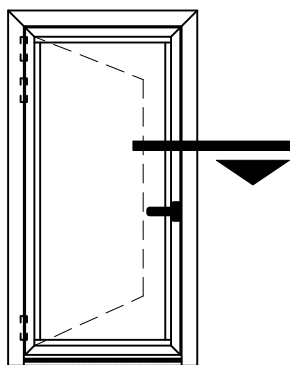




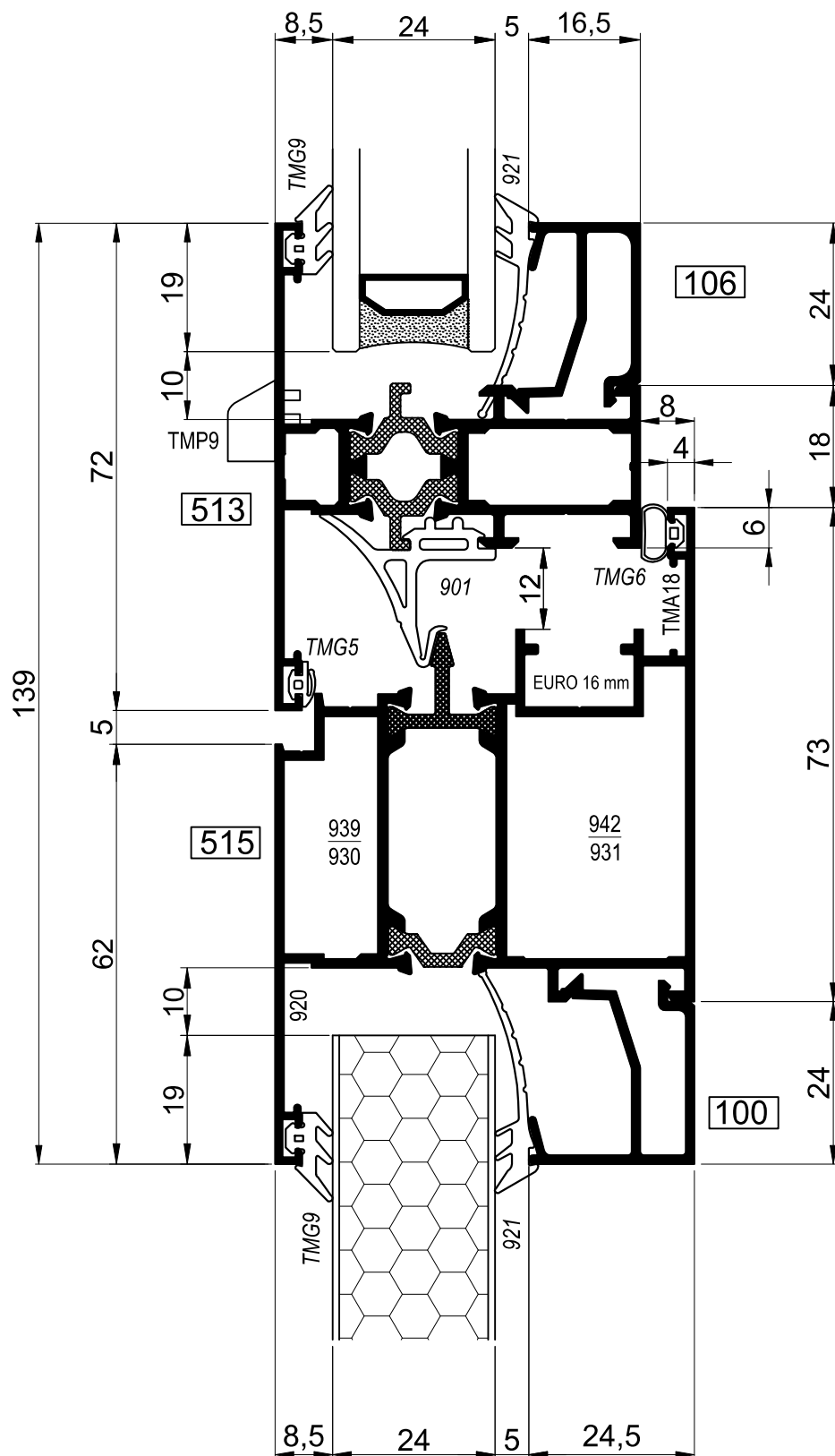
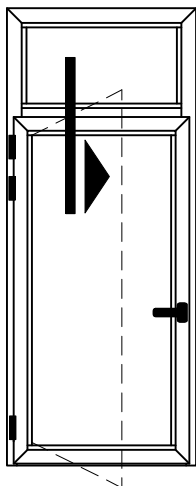
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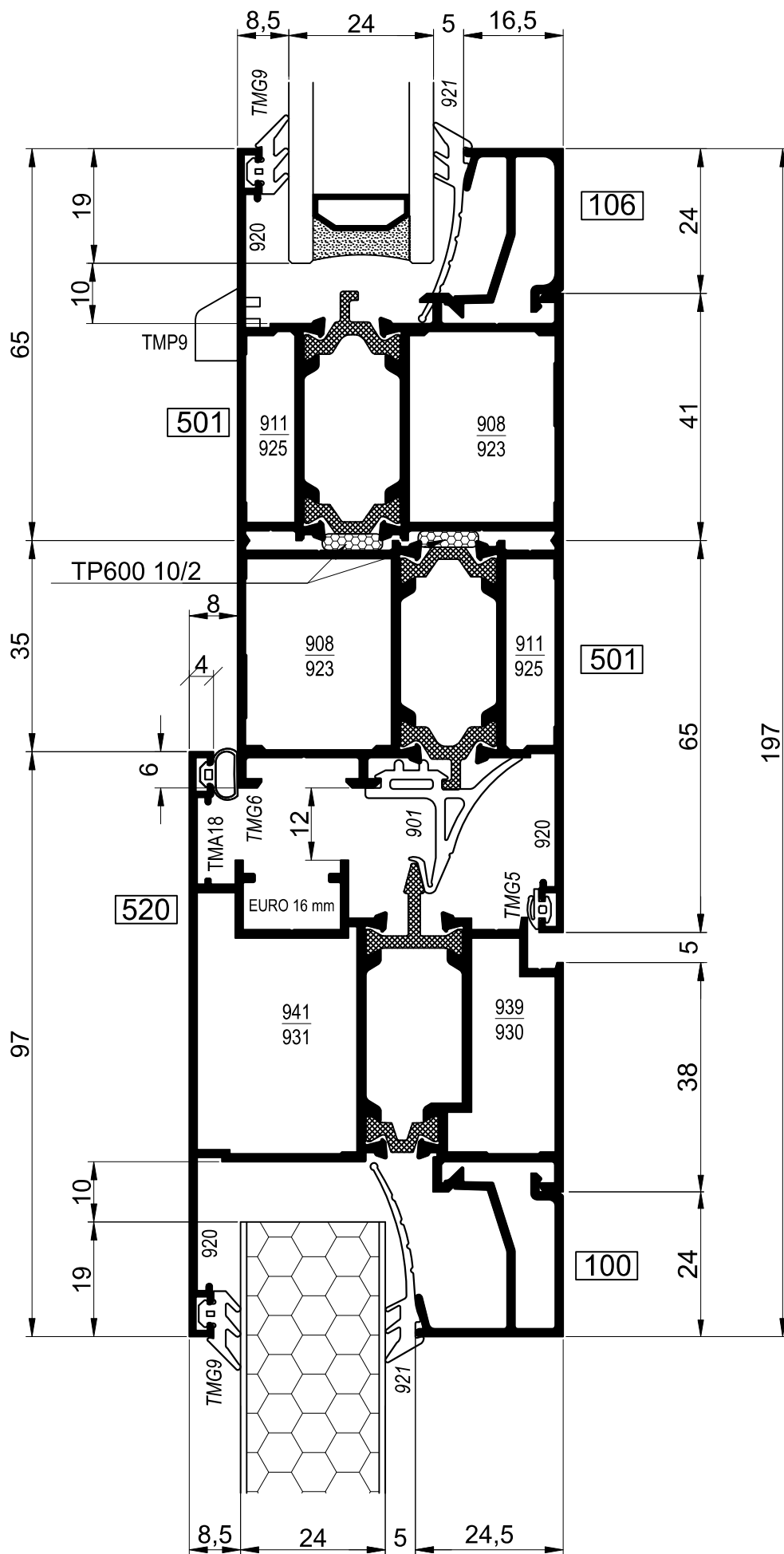
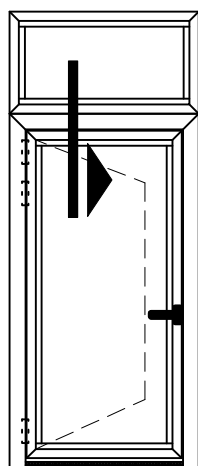
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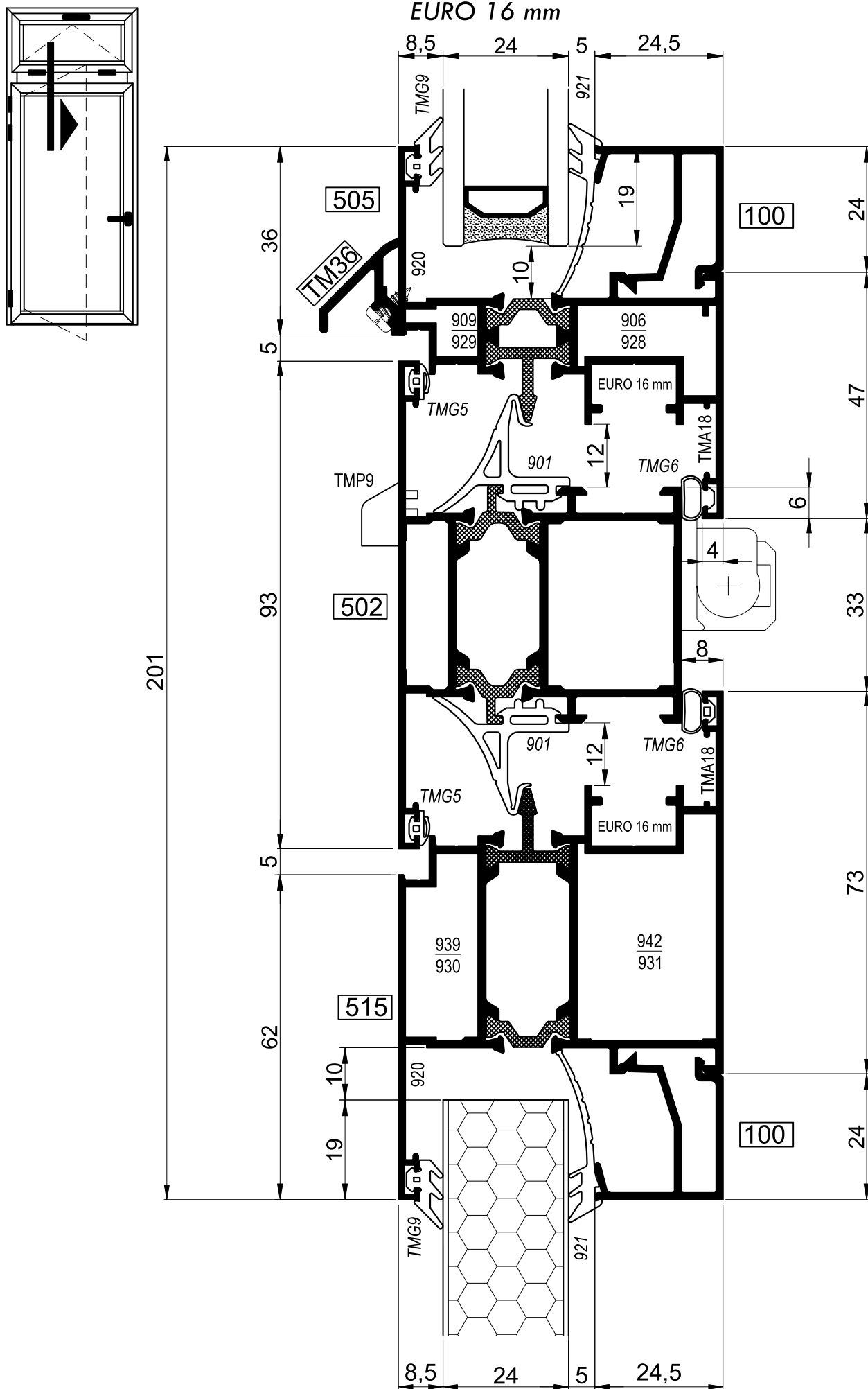


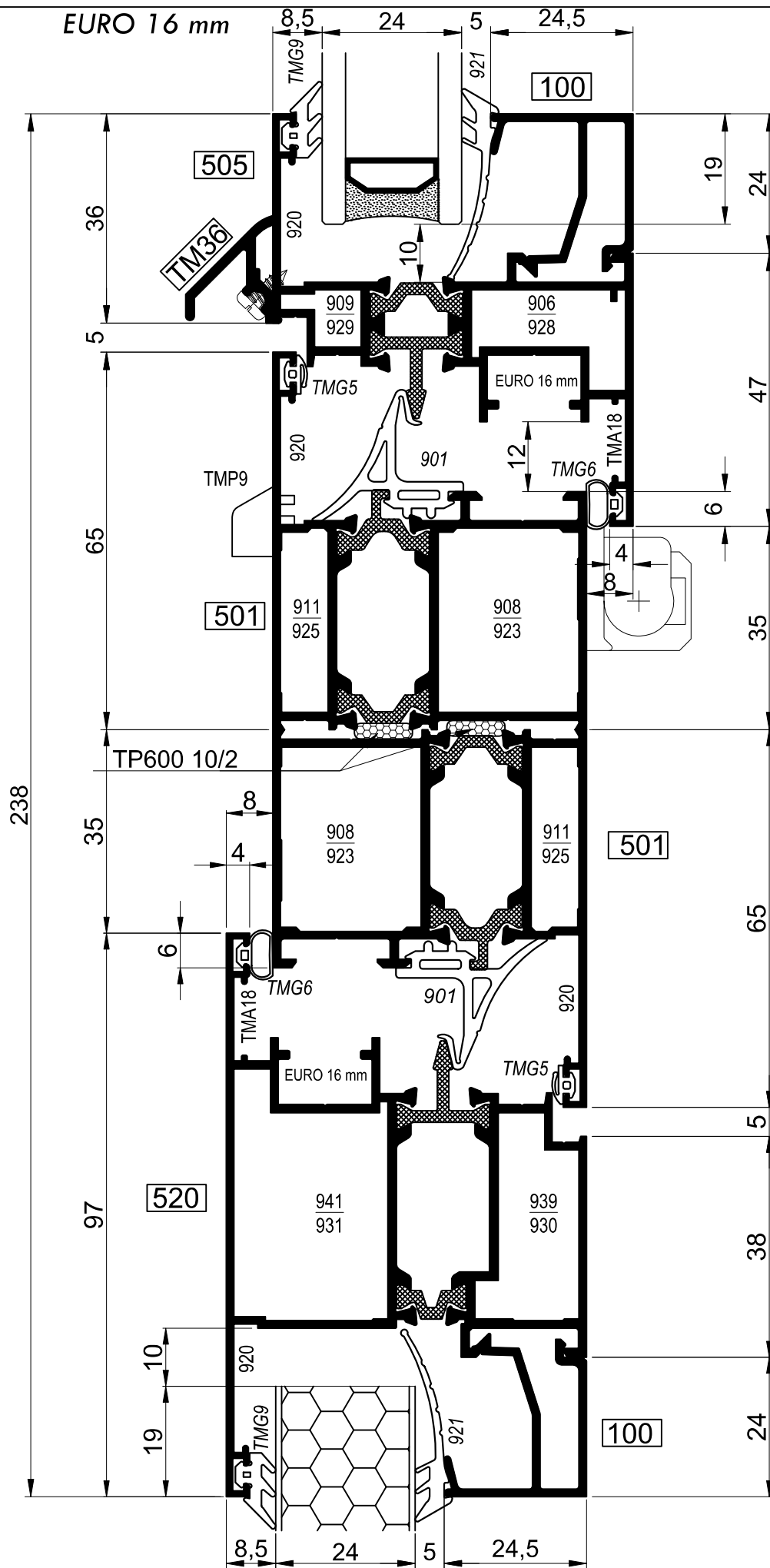
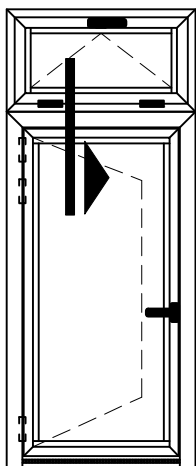
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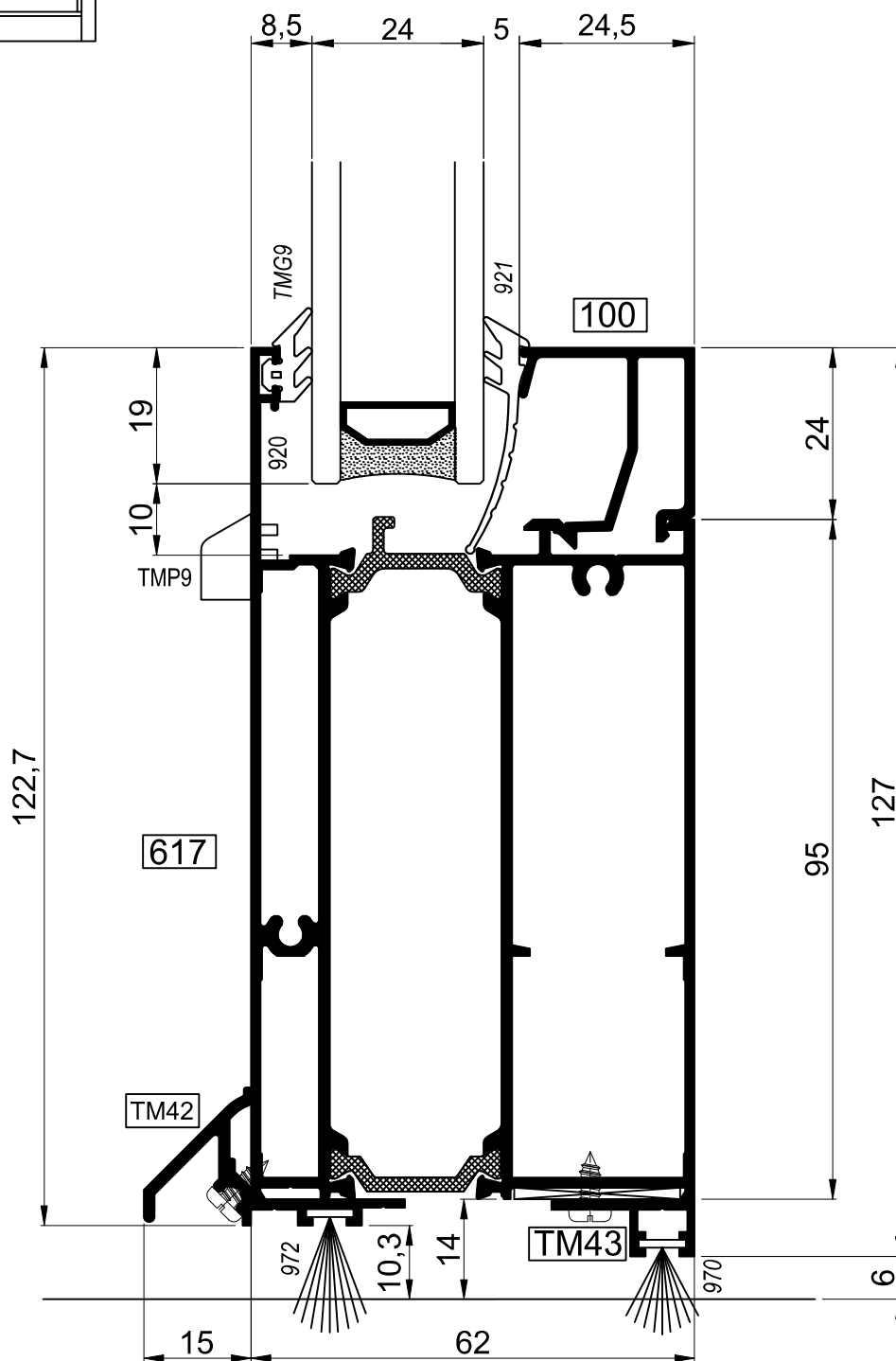
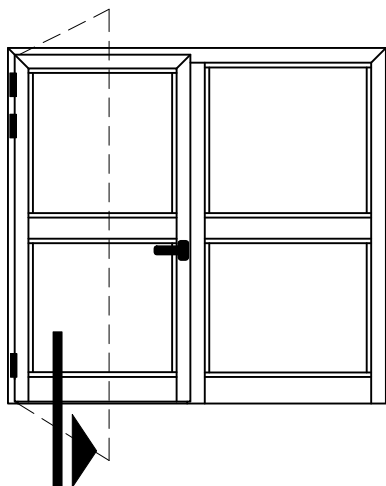
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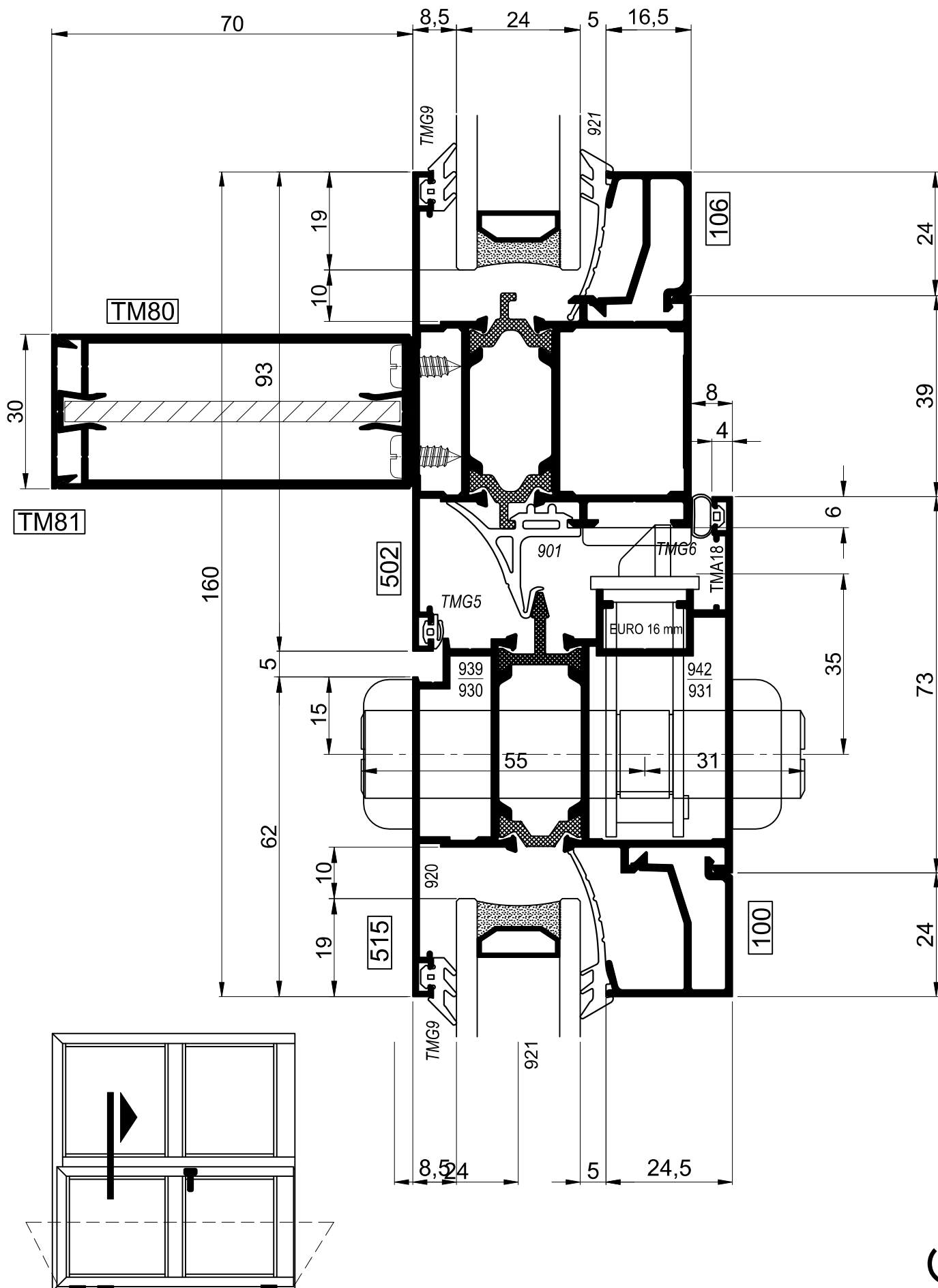




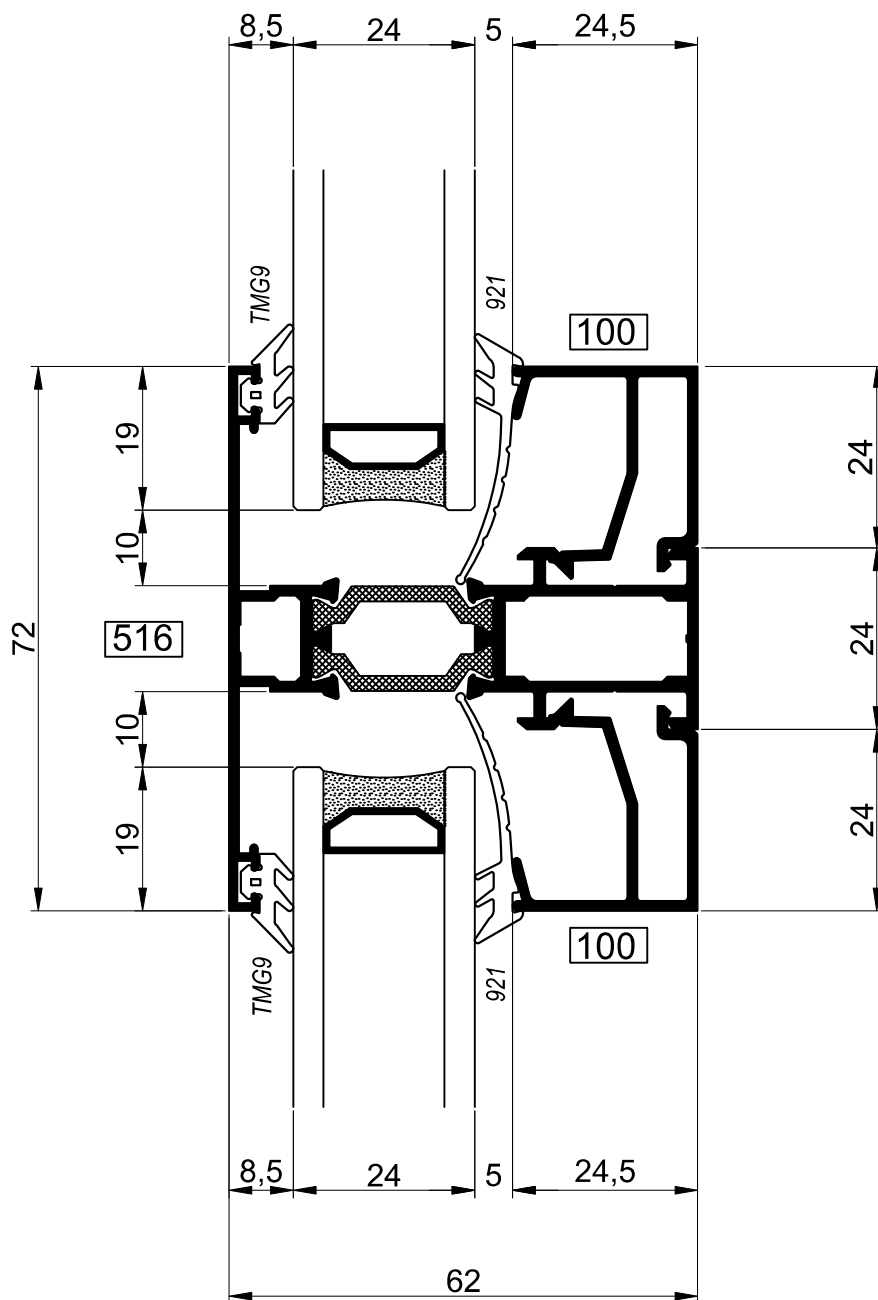
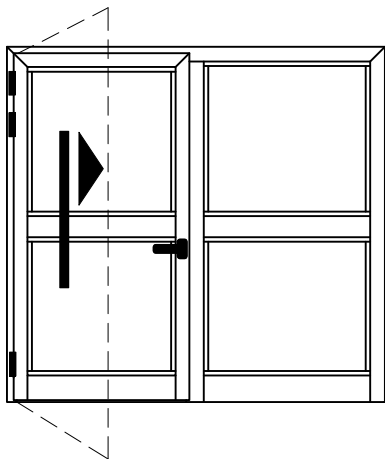
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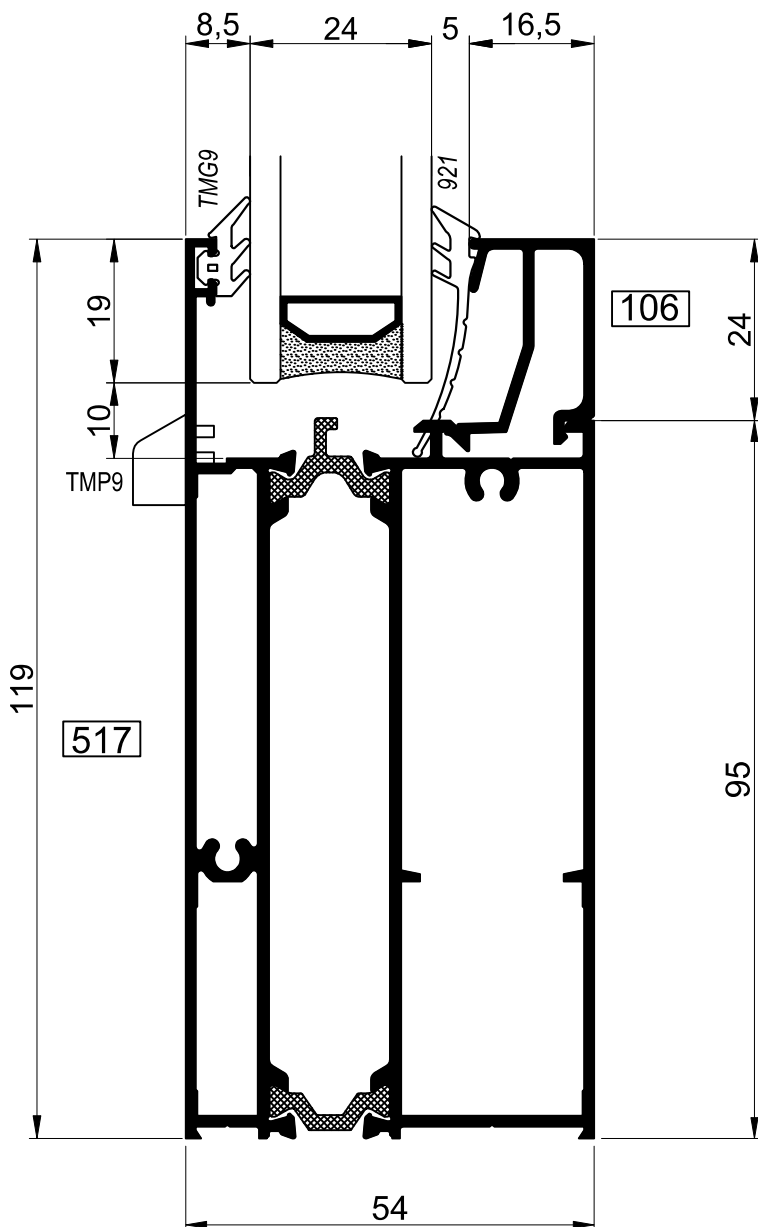
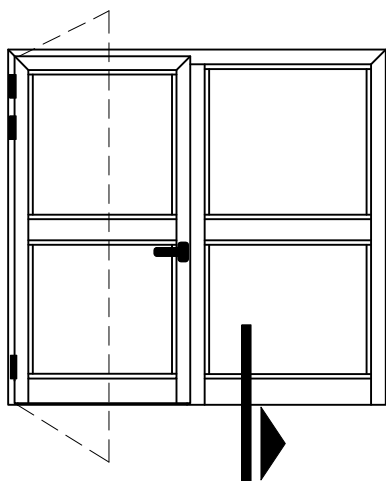
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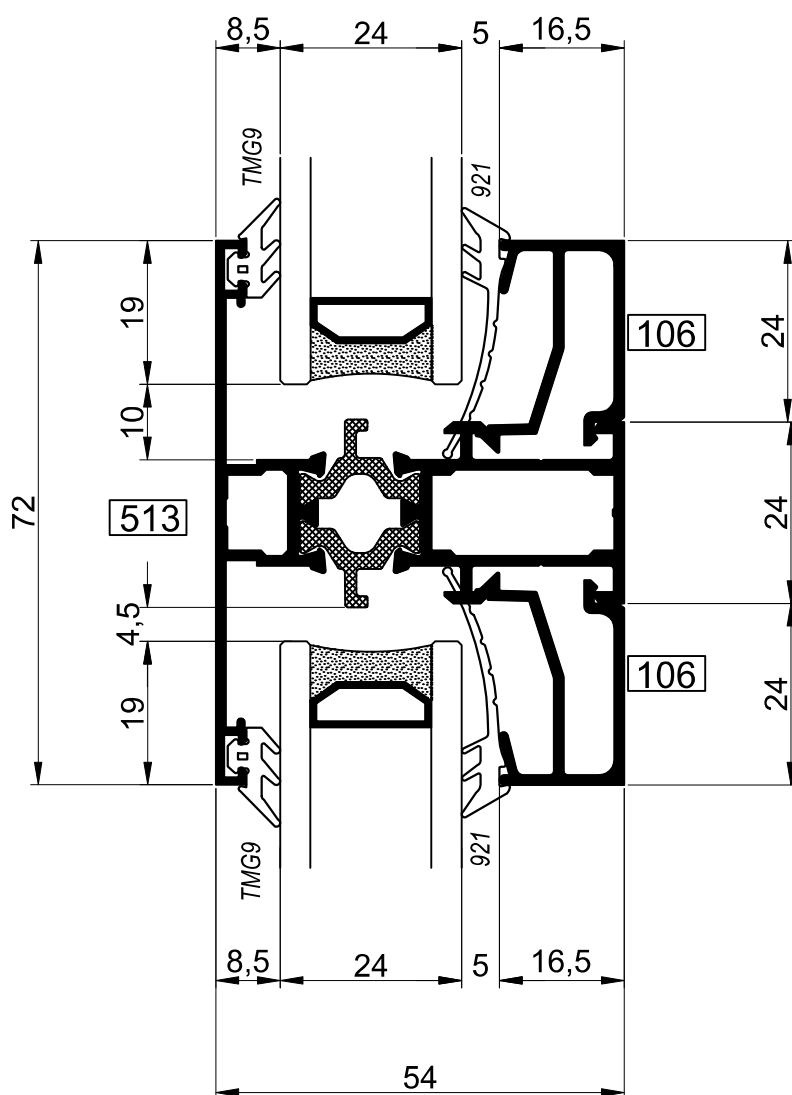
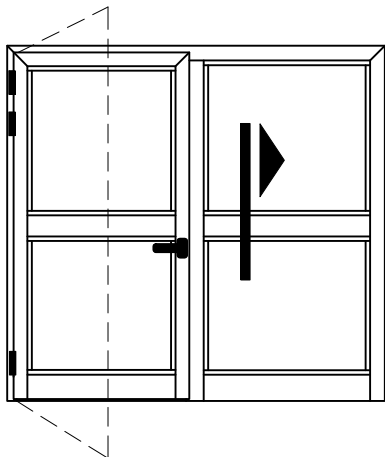
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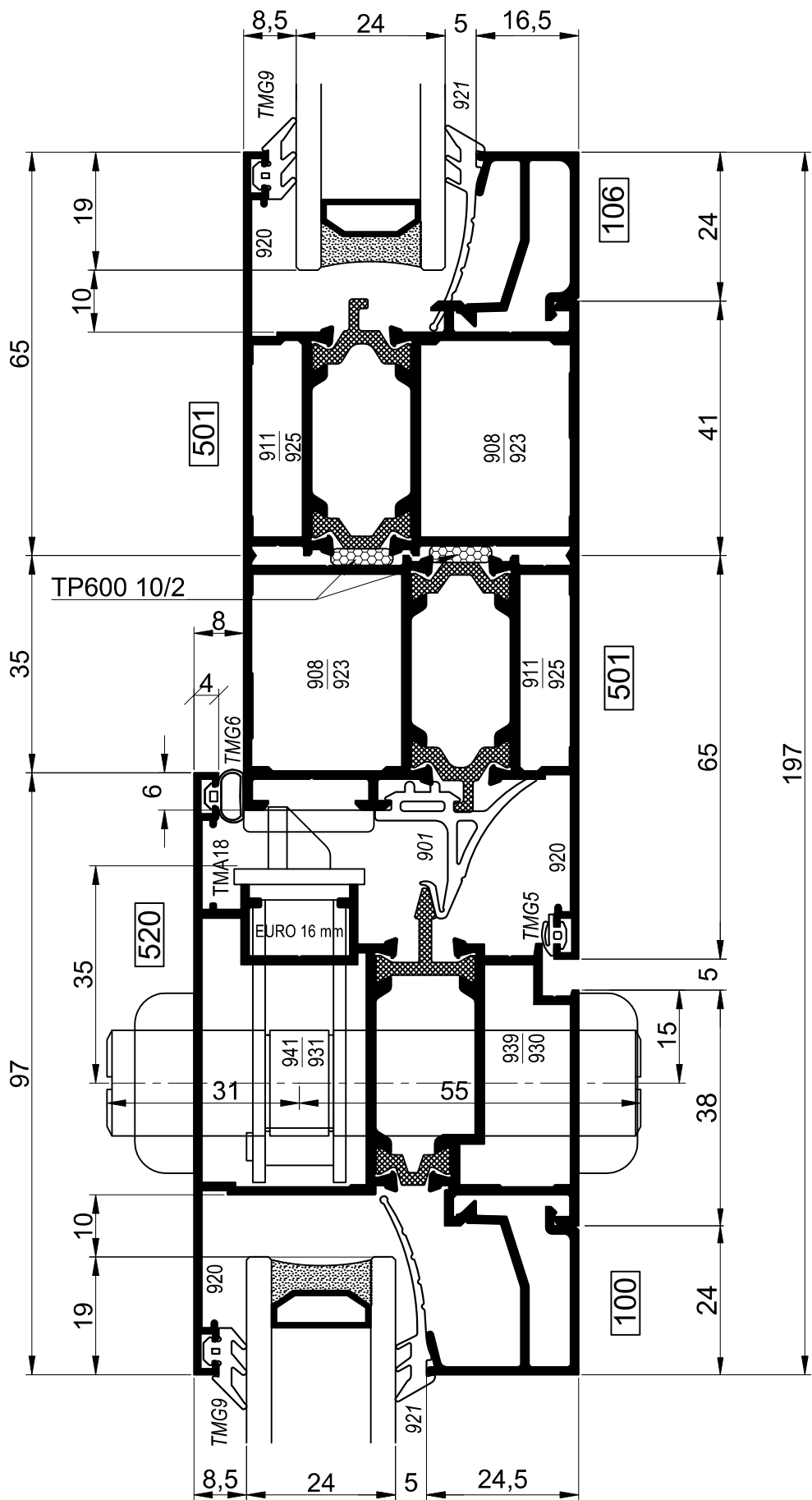
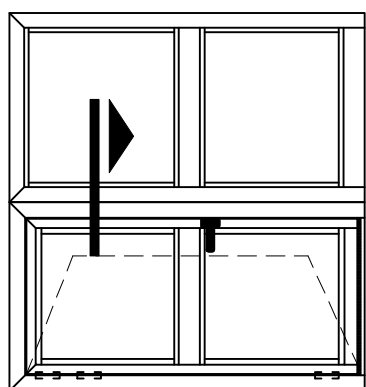
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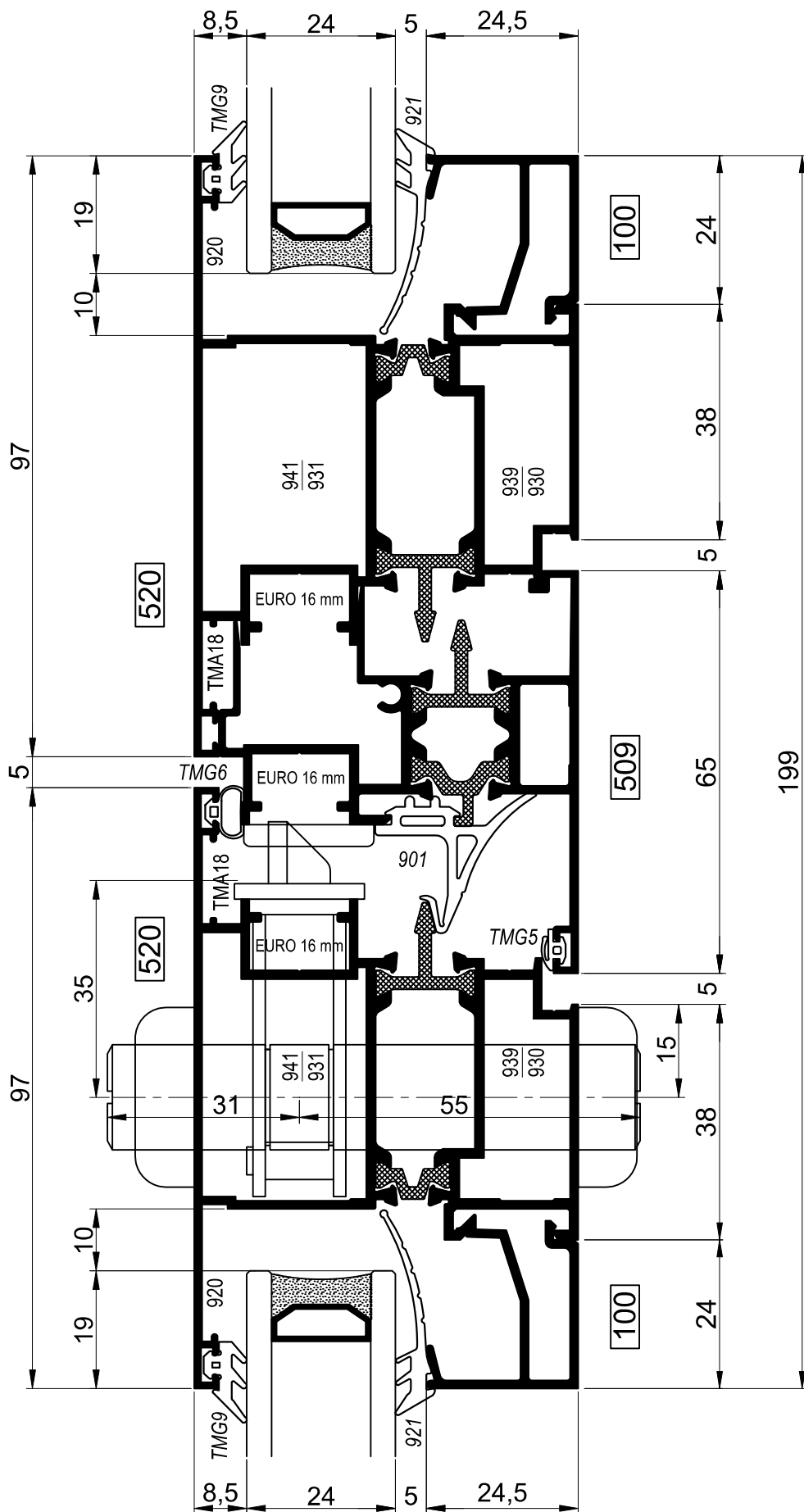
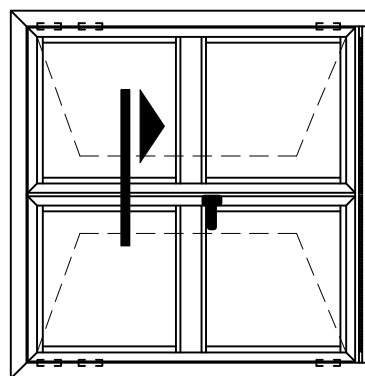
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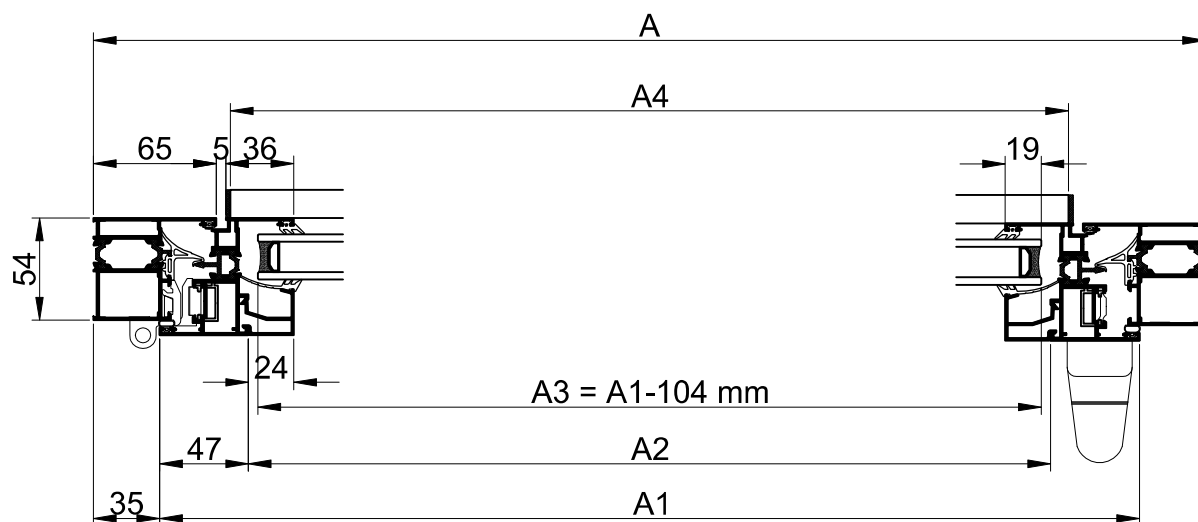
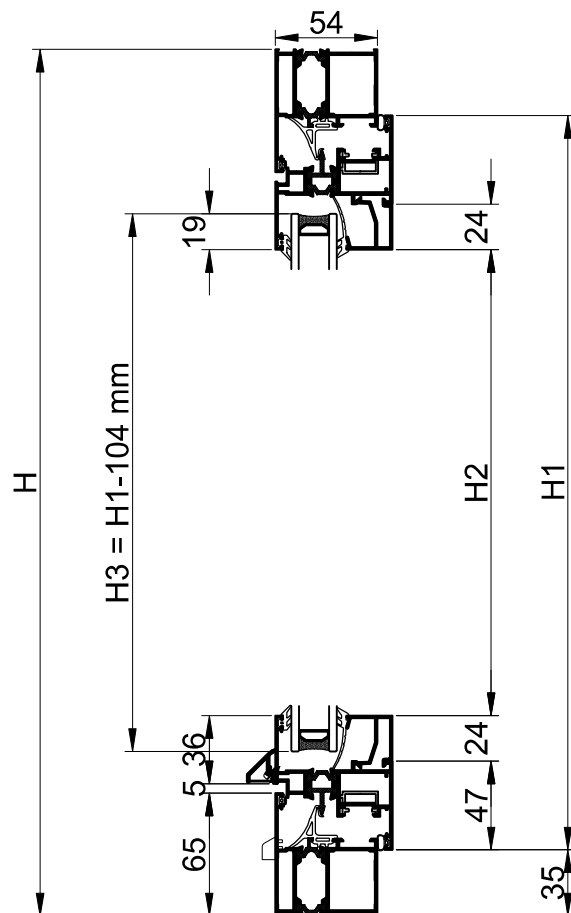
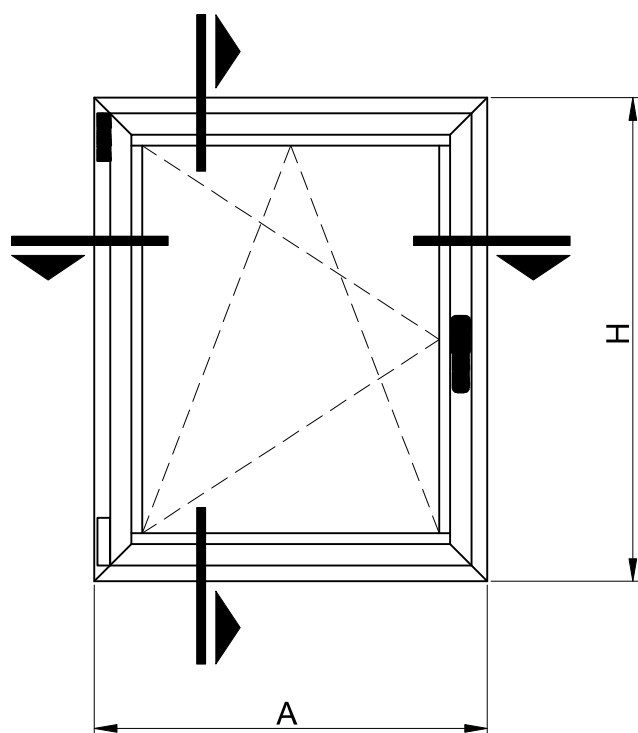


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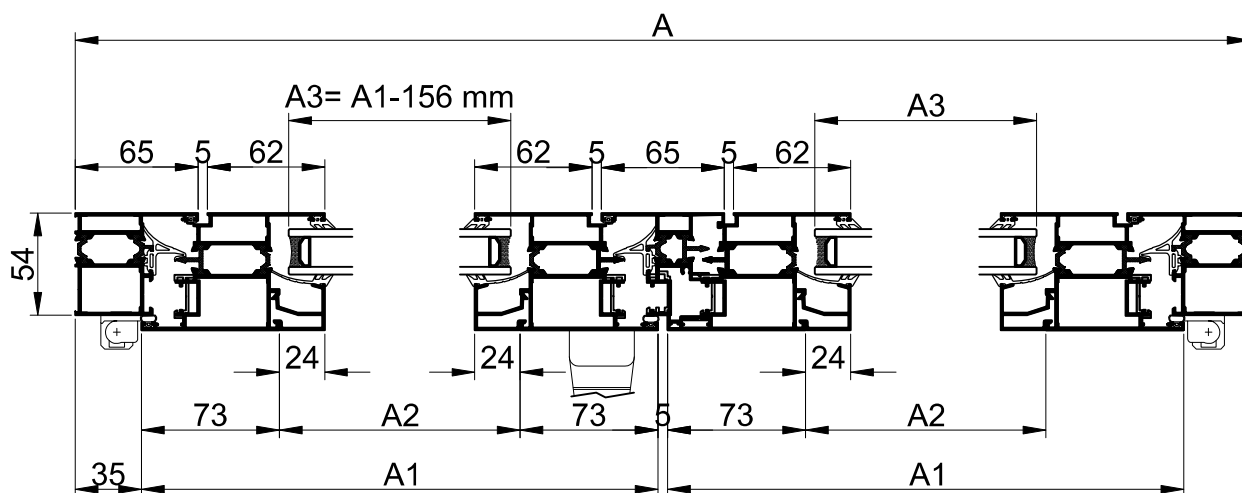
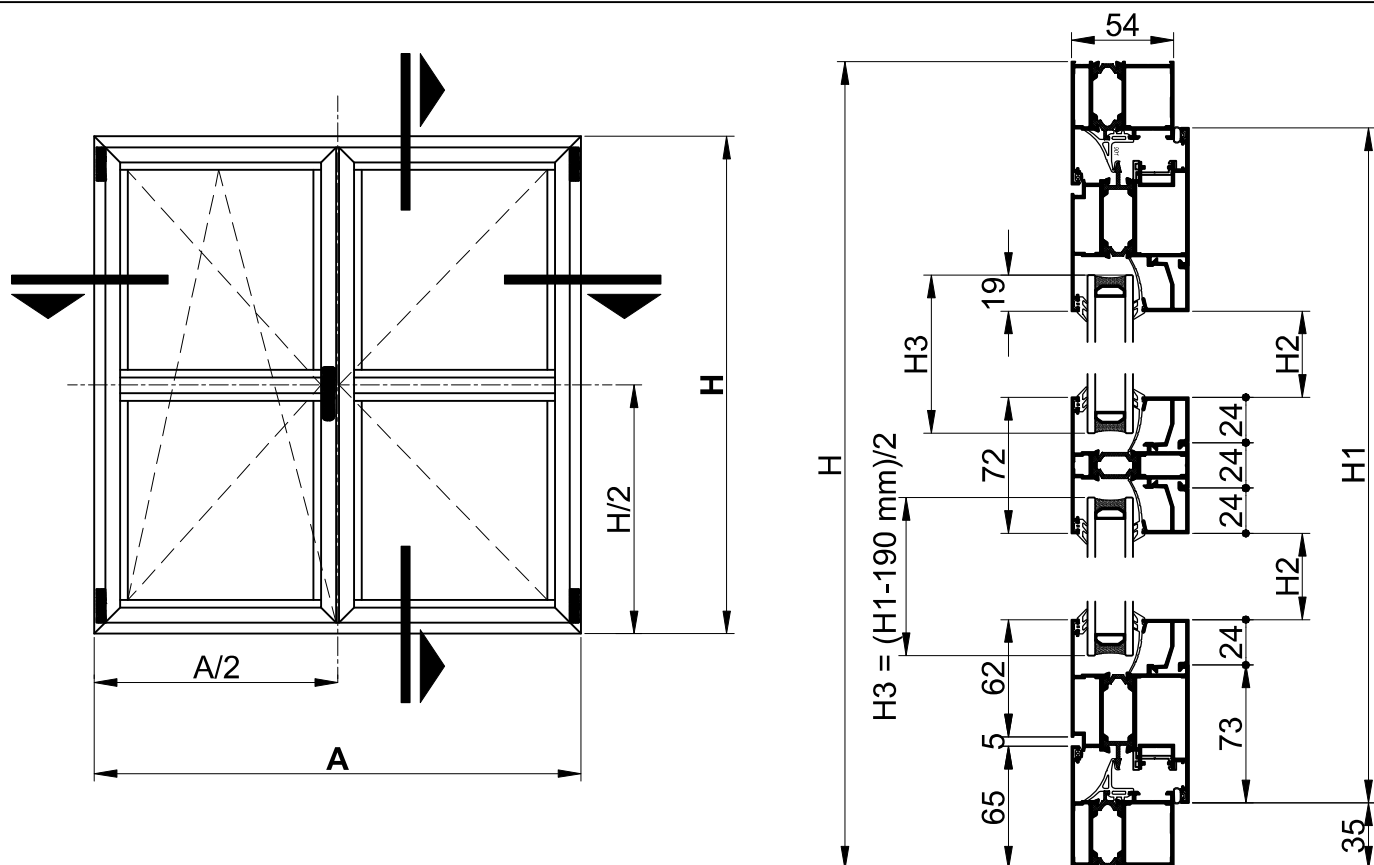


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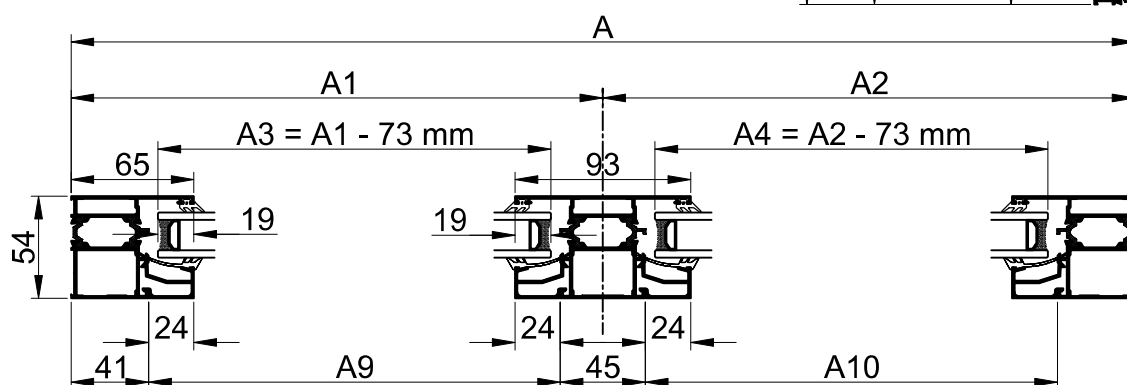
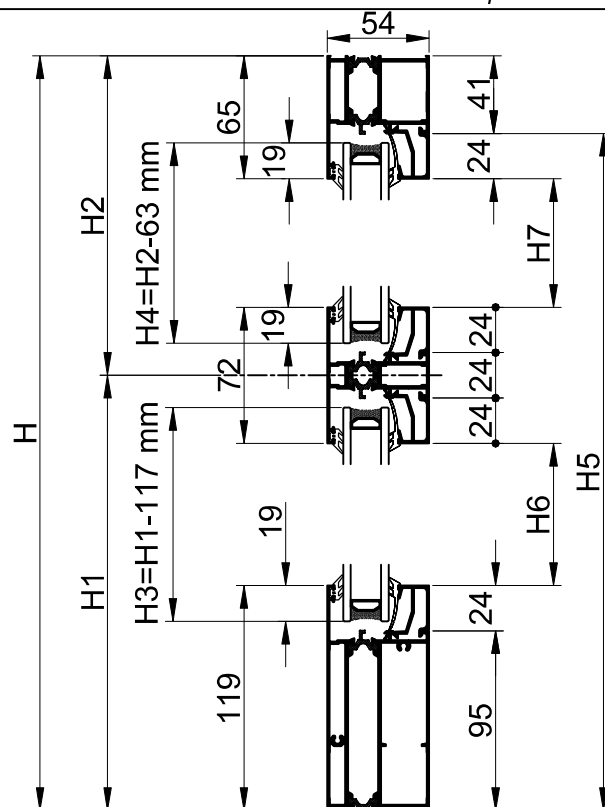
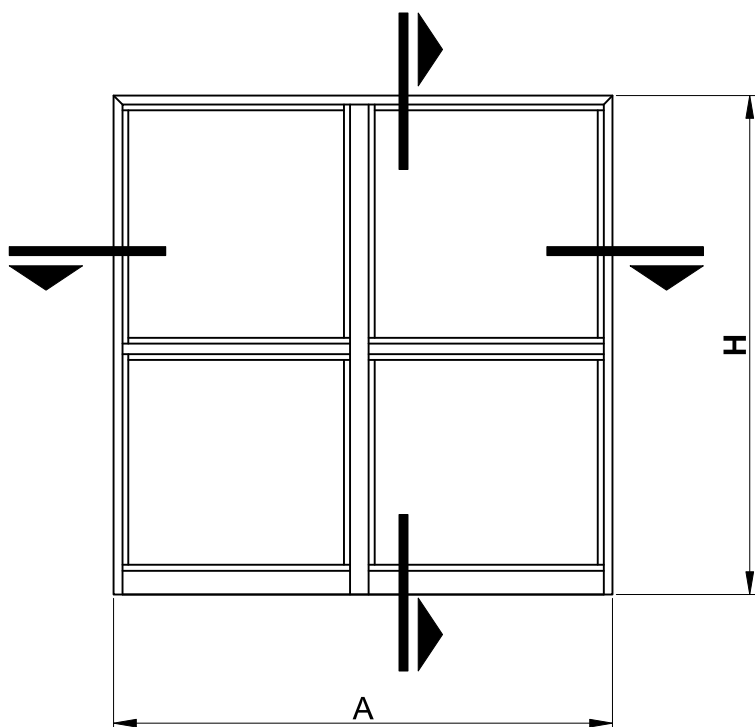


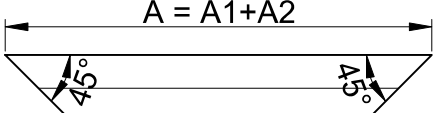
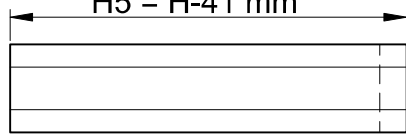
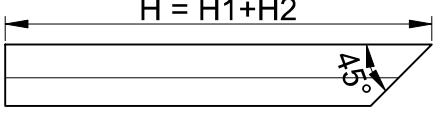
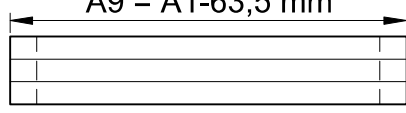
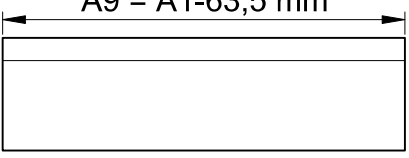
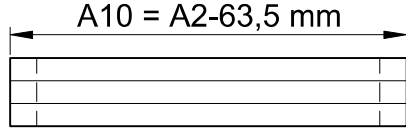
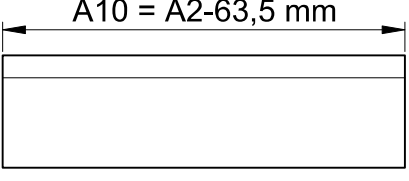
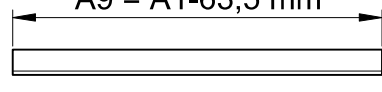
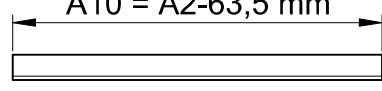
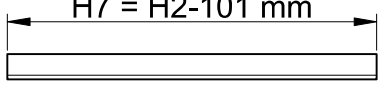
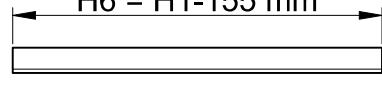


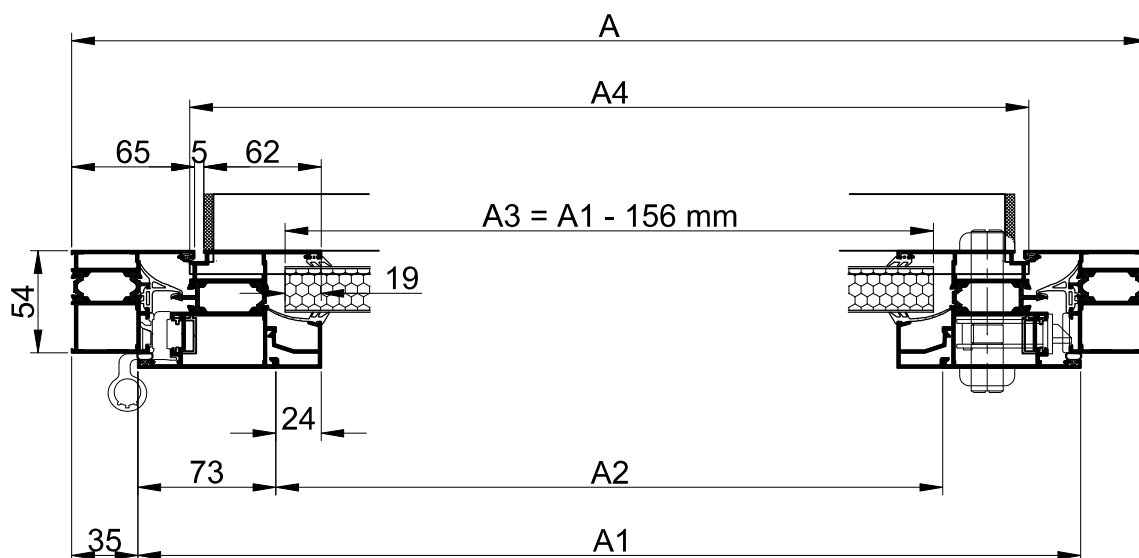
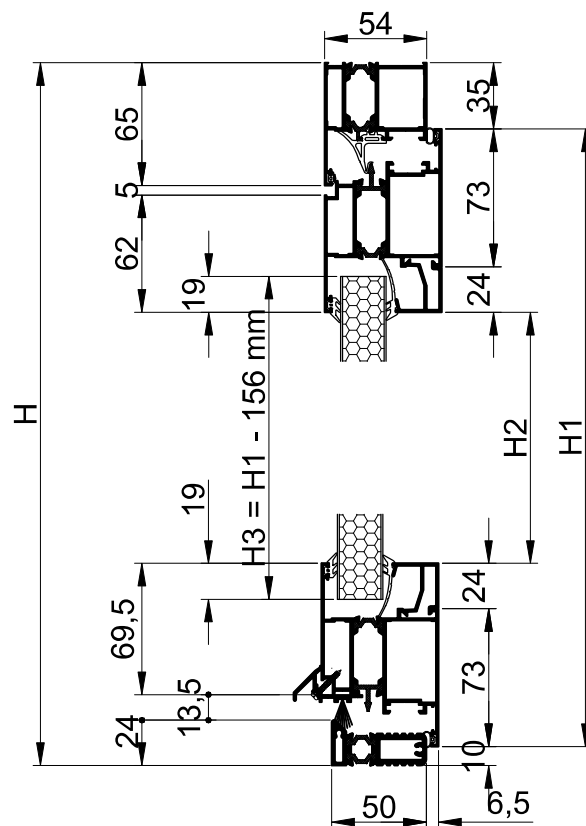
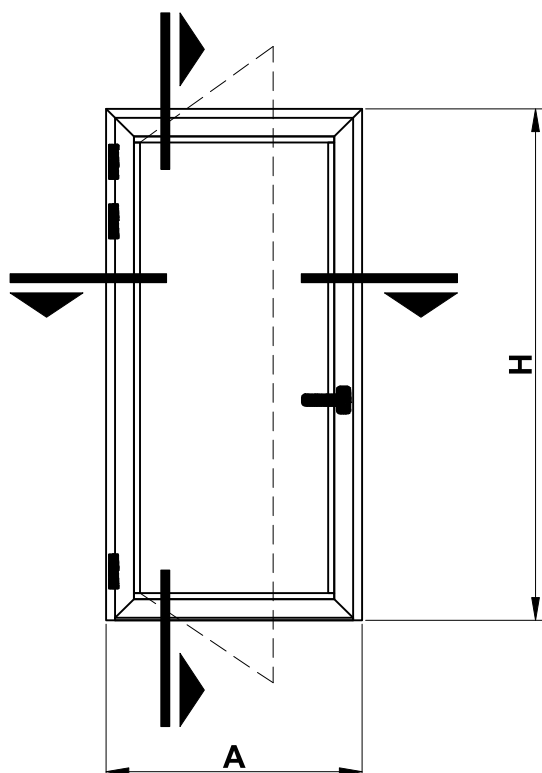
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2 x			501	2 x	
2 x			505	2 x	
2 x			505	1 x	

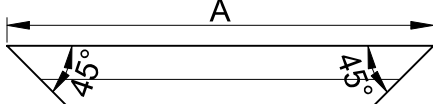
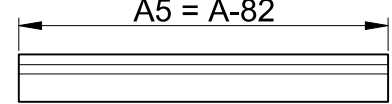
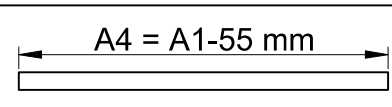
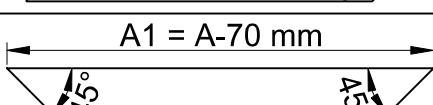
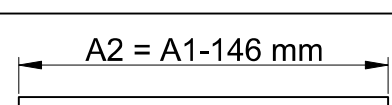
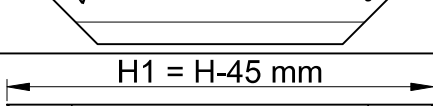
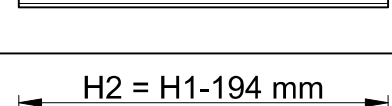


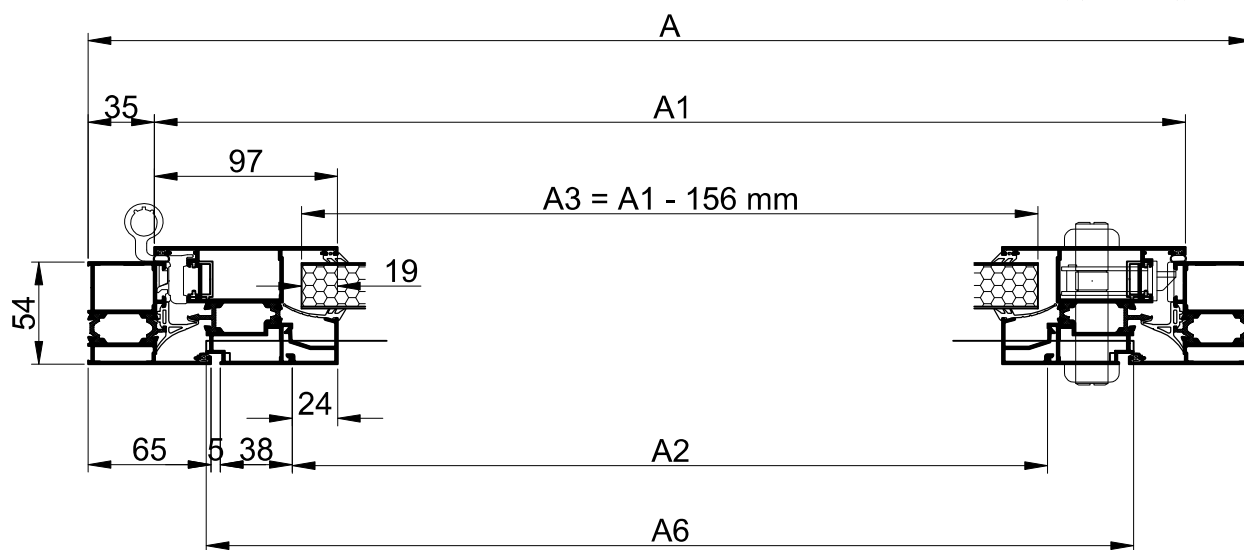
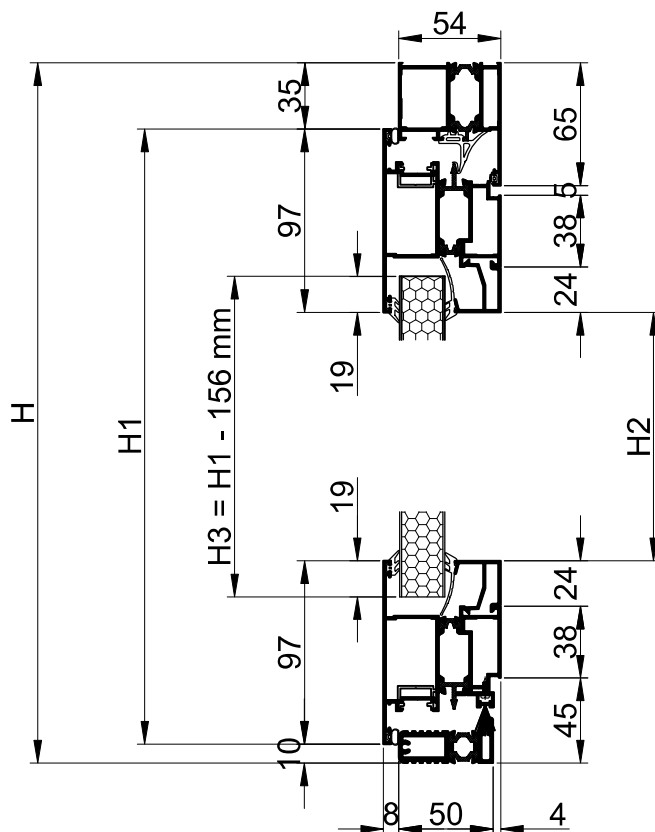
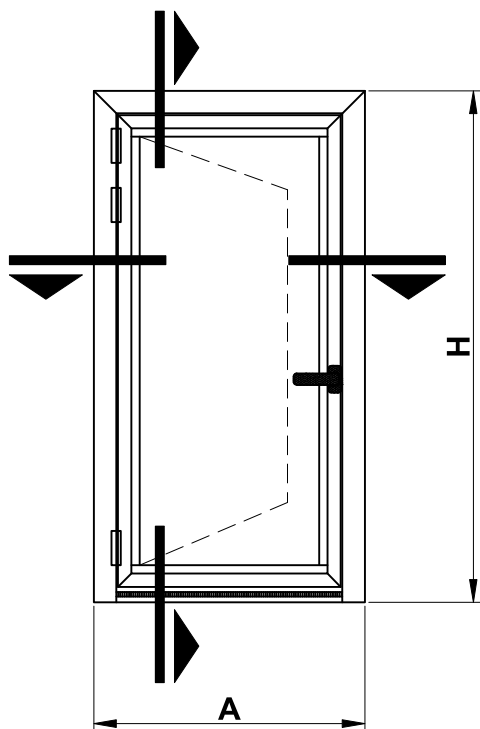
2 x A 45° 45° 501	2 x A2 = A1 - 146 mm 516
2 x H 45° 45° 501	1 x H4 = H1 - 74 mm 509 510
2 x A1 = (A - 75 mm) / 2 45° 45° 514 515	8 x A2 = A1 - 146 mm 100
2 x H1 = H - 70 mm 45° 45° 514 515	8 x H2 = (H1 - 266 mm) / 2 100

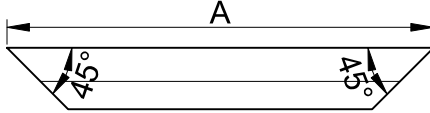
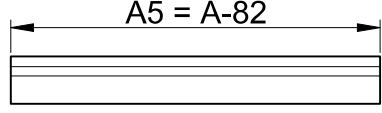
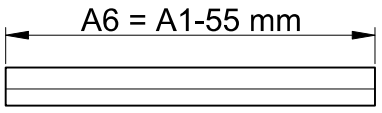
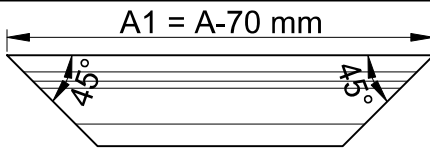
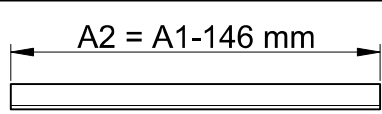
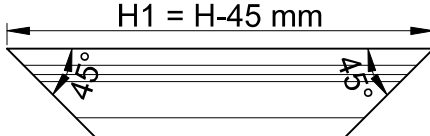
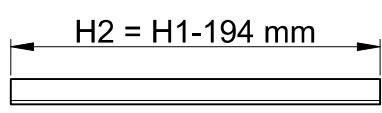


1 x			501	1 x			502
1 + 1			501	1 x			513
1 x			517	1 x			513
1 x			517	4 x			100
				4 x			100
4 x			100	4 x			100



 1 x A 45° 45°  501	 1 x A5 = A-82  508
 1 x 1 H 45° 45°  501	 1 x A4 = A1-55 mm  TM42
 2 x A1 = A-70 mm 45° 45°  515 514	 2 x A2 = A1-146 mm  100
 2 x H1 = H-45 mm 45° 45°  515 514	 2 x H2 = H1-194 mm  100



1 x  A	 501	1 x  A5 = A-82	 508
1 x 1  H	 501	1 x  A6 = A1-55 mm	 TM43
2 x  A1 = A-70 mm	 520  519	2 x  A2 = A1-146 mm	 100
2 x  H1 = H-45 mm	 520  519	2 x  H2 = H1-194 mm	 100

Sistem
System
Система

PLUS 62

Sistem LINEAL PLUS 62

System LINEAL PLUS 62

Система LINEAL PLUS 62



Tehnički opis sistema

Sistem LINEAL PLUS 62 je jedan od šest iz serije LINEAL i predstavlja sistem aluminijumskih profila sa termičkim prekidom, specijalno projektovanih za izradu elemenata prozora i vrata sa ugradnom dubinom štoka od 62mm. Sistem je dizajniran tako da zadovoljava savremene zahteve na polju energetske efikasnosti, kao i ostale uslove nepohodne za bezbedan i udoban radni i životni prostor. Prilikom projektovanja elemenata sistema posebna pažnja je posvećena odabiru materijala koji vrše funkciju termičkog prekida u sklopu sistemskih profila. Na ovaj način su postignute maksimalne termoizolacione karakteristike $U_f \approx 2,38W/m^2K$, odnosno $U_w \approx 1,25W/m^2K$.

- Aluminijumski profili su proizvedeni postupkom ekstruzije u pogonima Tehnomarket-a. Sirovina za proizvodnju profila je primarna legura aluminijuma sa oznakom AlMgSi0,5 (AA6063 i 6060) i zateznom čvrstoćom profila od minimalno 210KN/mm².
- Poliamidne trake (PA 6,6 sa 25% staklenih vlakana) širine 24mm međusobno spajaju spoljašnje i unutrašnje aluminijumske delove u gotove profile, a pored funkcije mehaničkog spajanja, obezbeđuju i termički prekid. Garantovana sila smicanja spoljnog i unutrašnjeg aluminijumskog profila, povezanih poliamidnim trakama, se kontroliše u toku proizvodnje.
- Izolaciona svojstva sistema potvrđena su kroz rezultate ispitivanja toplotnih performansi. Takođe, ispitivanja su urađena i za otpornost na udare vetra, propuštanje vazduha i vode, kao i za zvučnu izolaciju.
- Sistem omogućava ugradnju standardnog okova u EURO 1 žljeb i okova za PVC u EURO 16mm žljeb.
- Sistem podržava ispune uključujući i staklo pakete od 8 do 40mm sa EPDM zaptivkama koje poseduju integrisanu barijeru protiv prodivljanja.
- Zaptivanje u zoni spoja štoka i krila je trostruko, preko tri trajno elastične EPDM zaptivke otporne na UV zračenje.
- Spajanje uglova pomoću ekstrudiranih patent spojnice ili spojnice za presovanje obezbeđeno je zatezanjem u svim komorama profila, što obezbeđuje siguran ugaoni spoj i preciznu geometriju gotovih elemenata.
- Kanalisanje kondenza i incidentne vode je regulisano preko slobodnih ravnih površina u komorama, dok je ventilisana spoljna komora duboka 20mm.
- Osnovna spoljašnja dimenzija štoka od 65mm omogućava idealan prihvatač vođica roletne i komarnika. Unutrašnja širina štoka obezbeđuje idealan prostor za sabirnik trake roletne.

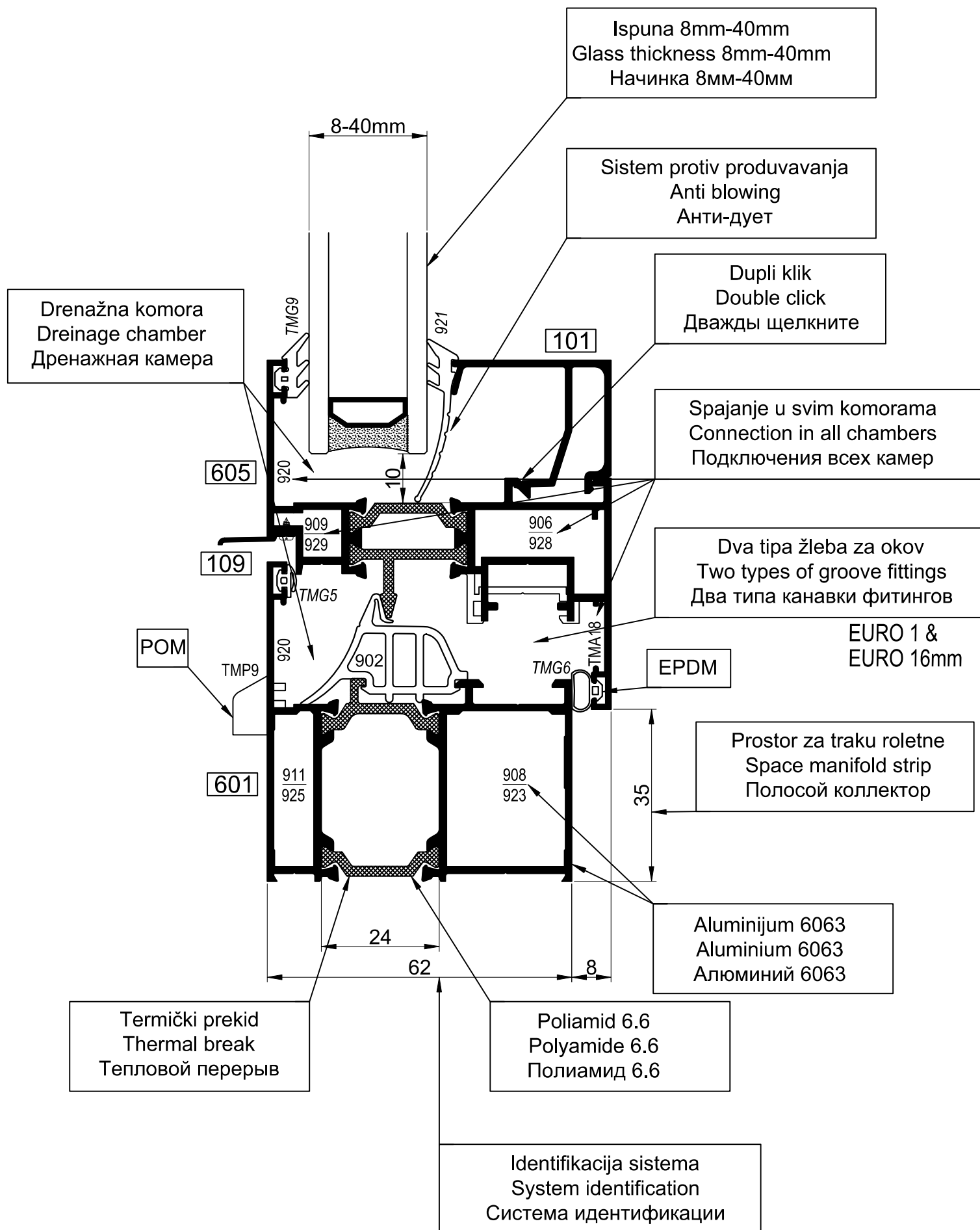
System LINEAL PLUS 62 is one of six from LINEAL series and it represents aluminium profile system with thermal break, specially designed for manufacturing of windows and doors with frame depth of 62mm. System is designed to satisfy all contemporary demand for energy efficiency, as well as all other requirements for safe and comfortable living and working environment. Special attention was addressed to selection of materials that for the thermal break within the profile. This way, maximal isolation values of $U_f \approx 2,38\text{W/m}^2\text{K}$, or $U_w \approx 1,25\text{W/m}^2\text{K}$, were achieved.

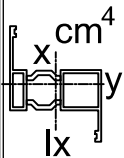
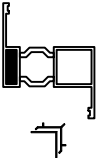
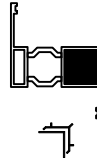
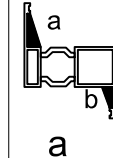
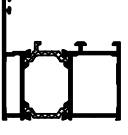
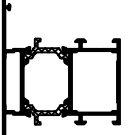
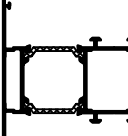
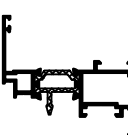
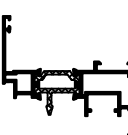
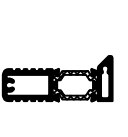
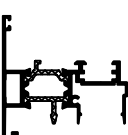
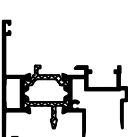
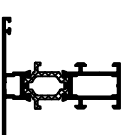
- Aluminium profiles were manufactured in Tehnomarket's own extrusion factory. The raw material used is primary aluminium alloy AlMgSi0.5 (AA6063 and AA6060) with minimum tensile strength of 210KN/mm^2 .
- 24mm wide Polyamide stripes (PA 6,6 with 25% glass fibers) connect inner and outer aluminium parts into finished profiles, and beside functioning as a mechanical bond they also provide a thermal break. Guaranteed shearing force for profiles connected with polyamide stripes is strictly controlled during production.
- Insulating performance of the complete system was confirmed through thermal performance testing. At the same time, wind load, air and water permeability and sound insulation were tested as well.
- System is compatible with both EURO 1 and EURO 16mm groove standards for hardware installation.
- System allows glass packages from 8 to 40mm with EPDM gaskets that feature integrated anti-blowing barrier.
- The triple sealing between frame and sash is achieved with three separate EPDM gaskets resistant to UV light.
- Corner joining with extruded patent or press clips is achieved through all profile chambers, thus guaranteeing secure and precise joints and finished element geometry.
- Drainage of condensed and incidental water is regulated via free flat surfaces in profile chambers, while ventilated outer chamber features optimal width of 20mm.
- Basic outer frame width of 65mm allows for an ideal mounting surface for optimal placement of mosquito net and roll-shutter's guides. Internal width of the frame provides an ideal space for tape coiler.

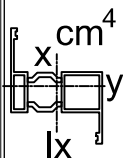
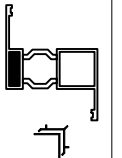
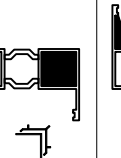
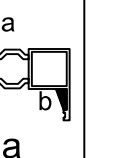
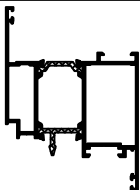
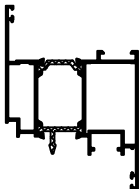
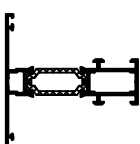
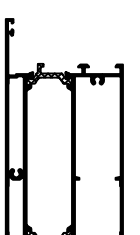
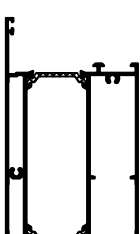
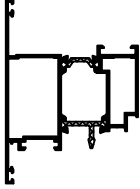
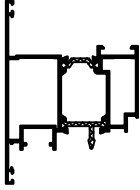
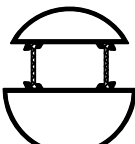
Техническое описание системы

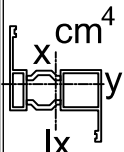
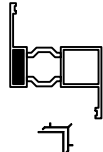
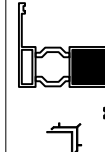
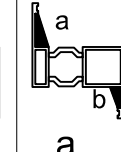
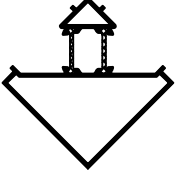
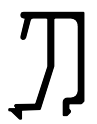
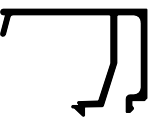
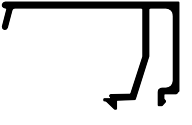
Система LINEAL PLUS 62 - одна из шести систем серии LINEAL и представляет систему алюминиевых профилей с термическим разрывом, специально разработанная для производства элементов окон и дверей с монтажной глубиной косяка от 62mm. Система разработана для удовлетворения современных требований в области энергоэффективности, как и другие необходимые условия для безопасного и комфортного рабочего и жилого пространства. При проектировании элементов системы, особое внимание было уделено выбору материалов, которые выполняют функцию теплового разрыва внутри профиля. Таким образом, достигнуты максимальные теплоизоляционные свойства $U_f \approx 2,38\text{W/m}^2\text{K}$, относительно $U_w \approx 1,25\text{W/m}^2\text{K}$.

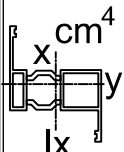
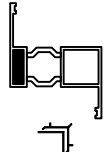
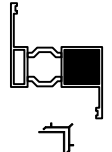
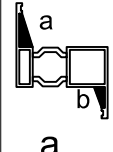
- Алюминиевые профили изготовлены способом экструзии в производственных цехах Техномаркета. Сырьем для производства профилей является первичный алюминиевый сплав с обозначением AlMgSi0,5 (AA6063 и 6060) и с минимальной прочностью на разрыв профиля 210KN/mm^2 .
- Полиамидные полосы (PA 6,6 с 25% стекловолокна) шириной 24mm, взаимосвязывают внешние и внутренние алюминиевые части в готовых профилях, а кроме функции механического соединения и обеспечивают и тепловой разрыв. Гарантированная сила сдвига внешнего и внутреннего алюминиевого профиля, которые связаны полиамидными полосками, контролируется в процессе производства.
- Изоляционные свойства системы подтверждены результатами испытания тепловых характеристик. Кроме того, были проведены испытания устойчивости на удары ветра, пропуск воздуха и воды, как и звукоизоляции.
- Система позволяет установку стандартных оков в EURO 1 желоб и оков для PVC в EURO 16mm желоб.
- Система поддерживает и заполнения, включая и стеклопакеты от 8 до 40mm, с EPDM прокладками, которые имеют интегрированный барьер против выдувания.
- Уплотнение в зонах соединений косяка и створки - трехрядное, с тремя постоянно упругими прокладками EPDM, которые устойчивы к UV-излучению.
- Сцепление углов, с помощью экструдированных сцепных устройств или сцепных устройств для прессовки, обеспеченное затяжкой во всех камерах профиля, что обеспечивает надежное соединение углов и точную геометрию готовых элементов.
- Направление конденсации и случайных вод регулируется через свободные ровные поверхности в камерах, в то время как вентилируемая внешняя камера имеет глубину 20mm.
- Основной внешний размер косяка от 65mm позволяет идеальный прием направляющей жалюзи и противомоскитных сеток. Внутренняя ширина косяка обеспечивает идеальное место для коллектора полосок жалюзи.

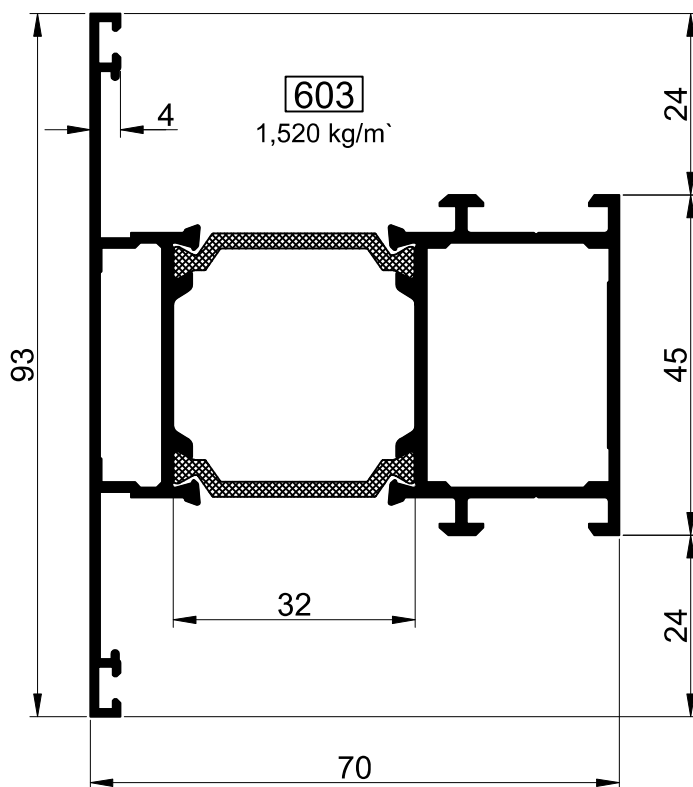
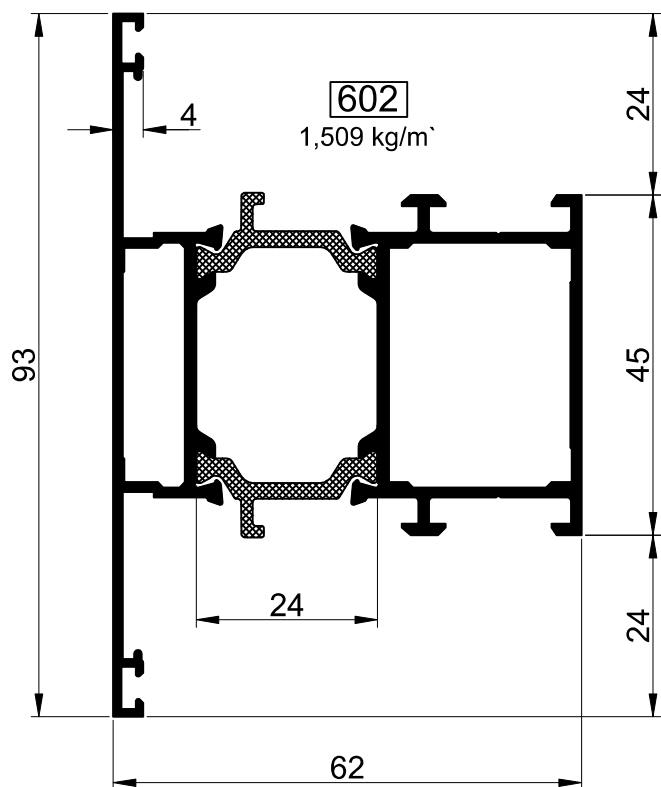
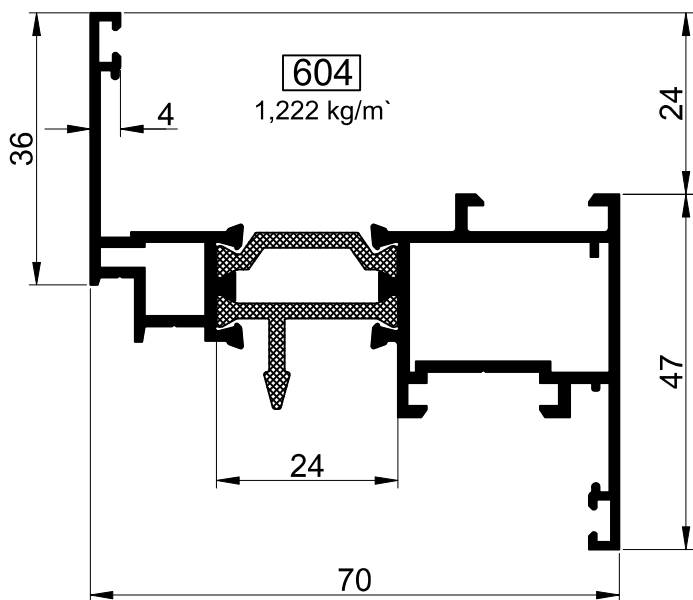
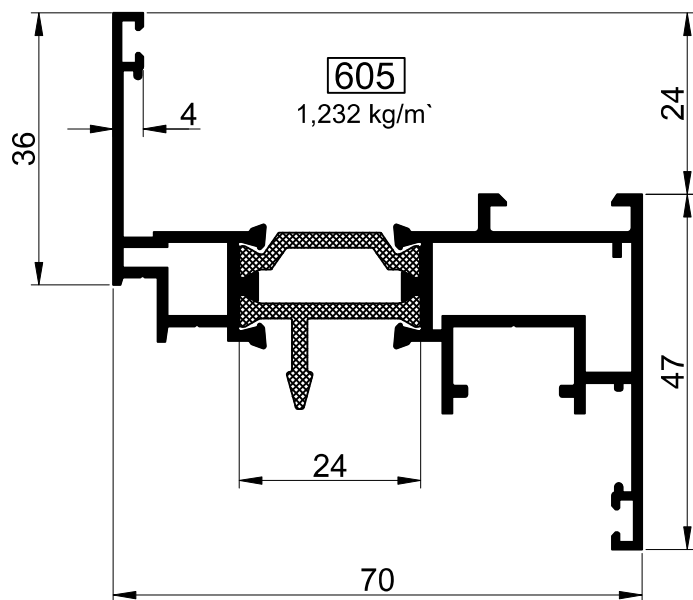
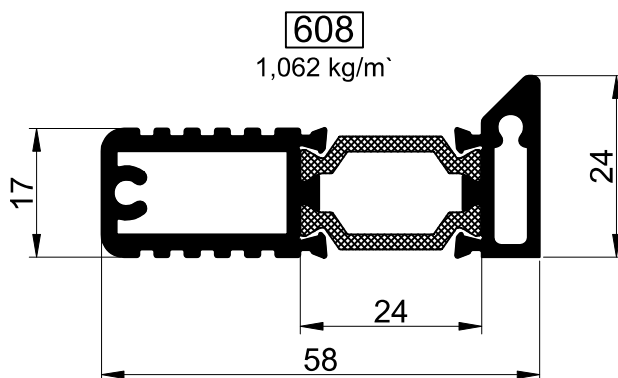
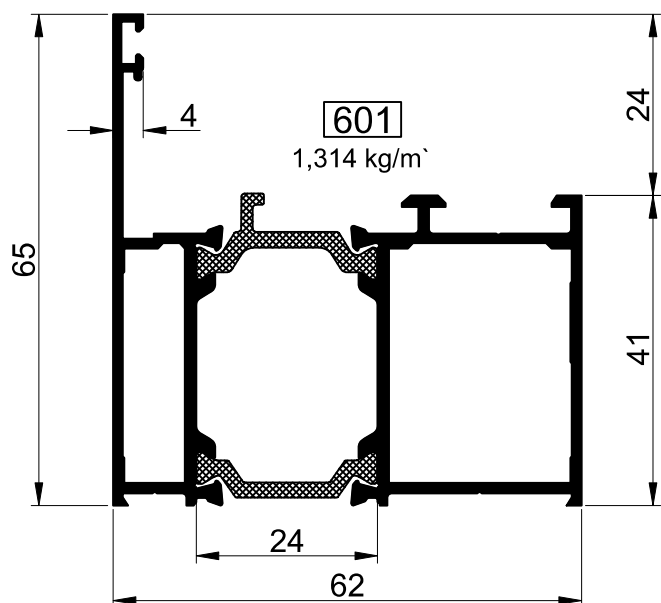


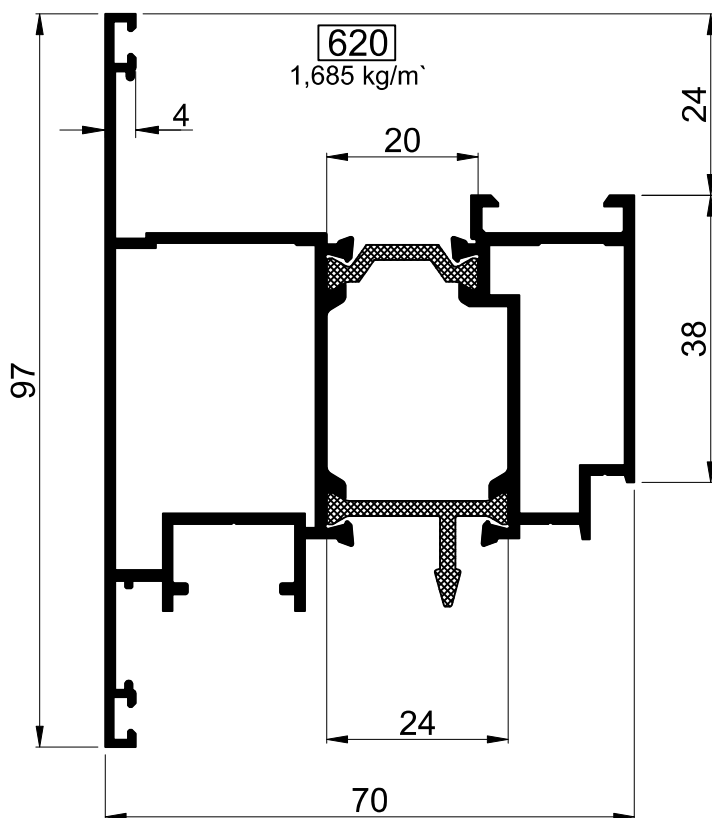
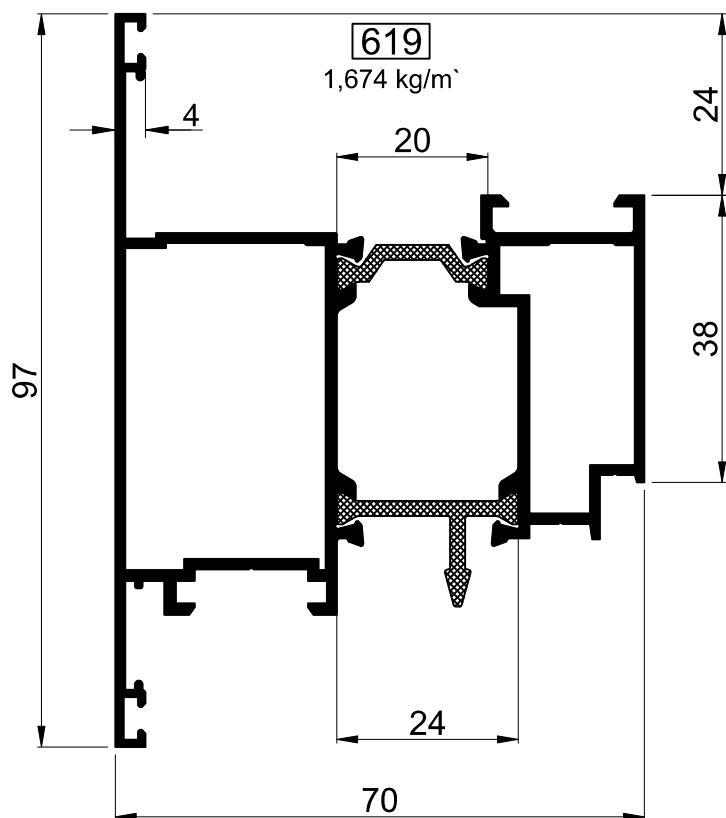
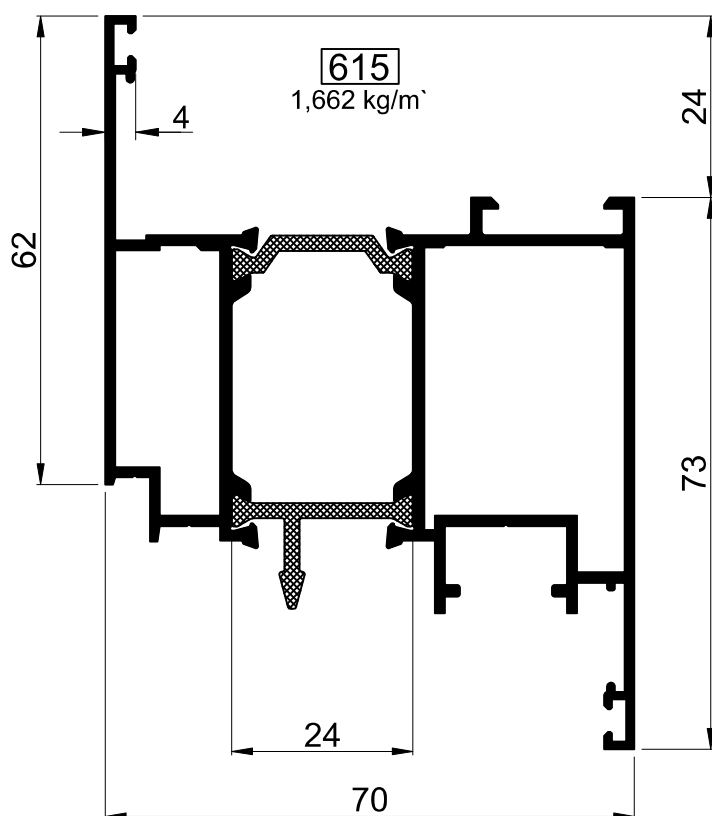
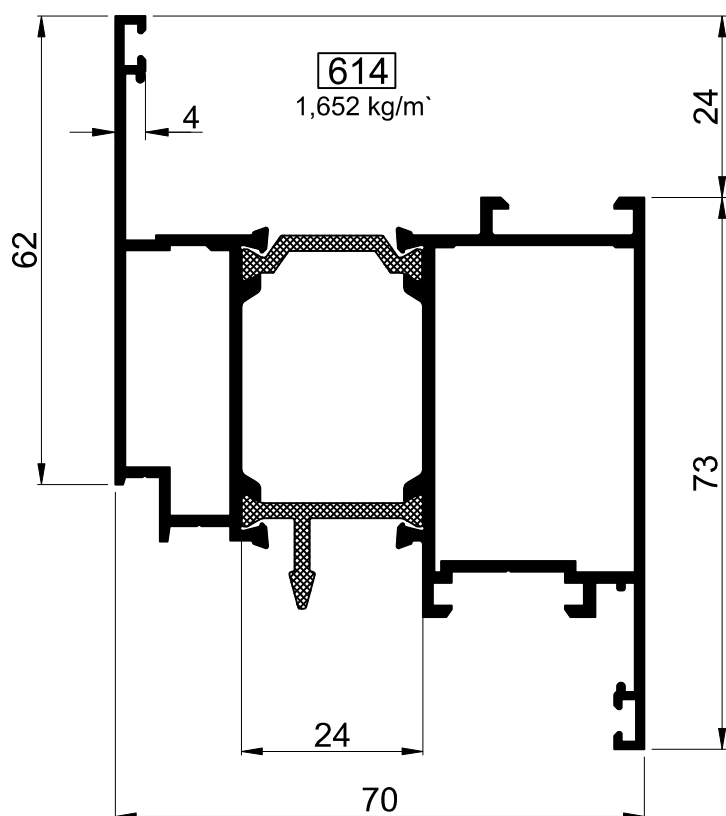
	Oznaka Mark Марк	Opis Description Описание				
	kg/m`		ly			a b
	601	Štok Frame	21,760	911	908	920
	1,314	Рама	10,607	925	923	
	602	Prečka u štoku T profile in frame	25,420		915	
	1,509	T профил в раме	18,699		905	
	603	Prečka u krilu T profile in casement	34,199		915	
	1,520	T профил в створки	18,699		905	
	604	Prozorsko krilo - EURO 1 Casement -EURO 1	27,420	909	907	920
	1,222	Оконная створка -ЕУРО 1	4,254	929	926	TMA18
	605	Prozorsko krilo - EURO 16mm Casement -EURO 16mm	27,328	909	906	920
	1,232	Оконная створка -ЕУРО 16мм	4,037	929	928	TMA18
	608	Prag Threshold	13,992			
	1,064	Порог	13,527			
	609	Veza dvokrilnog prozora - EURO 1 French casement adaptor -EURO 1	18,958			
	1,205	Соединительный профиль двойного окна -ЕУРО 1	6,508			
	610	Veza dvokrilnog prozora - EURO 16mm French casement adaptor -EURO 16mm	18,560			
	1,207	Соединительный профиль двойного окна -ЕУРО 16мм	6,284			
	613	Prečka u štoku T profile in frame	18,516		922	
	1,104	T профил в рамке	6,652		905	

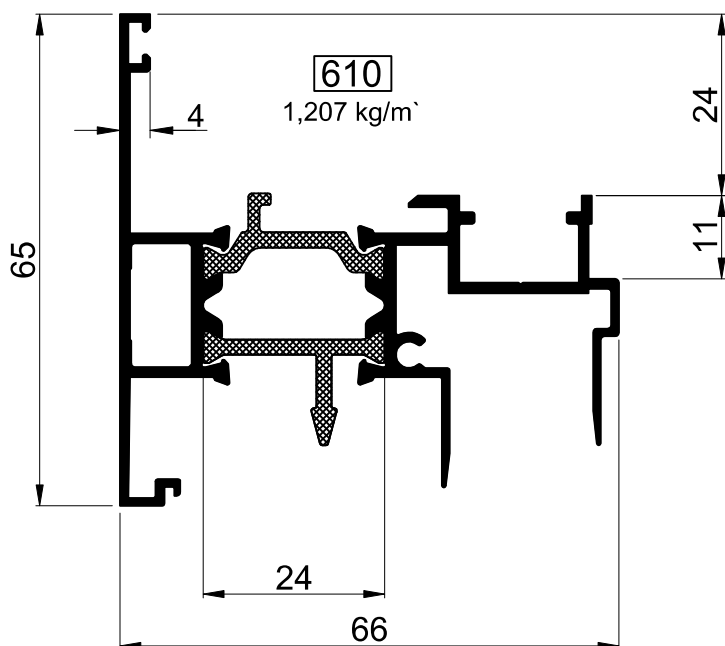
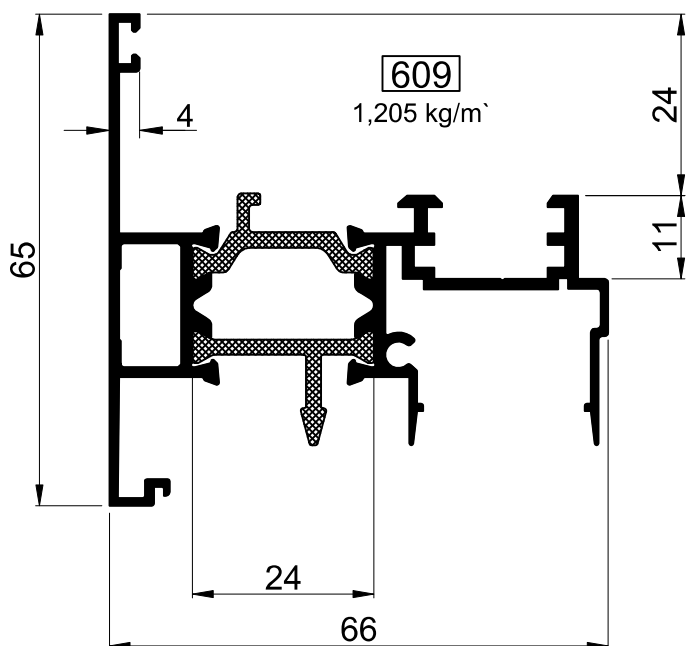
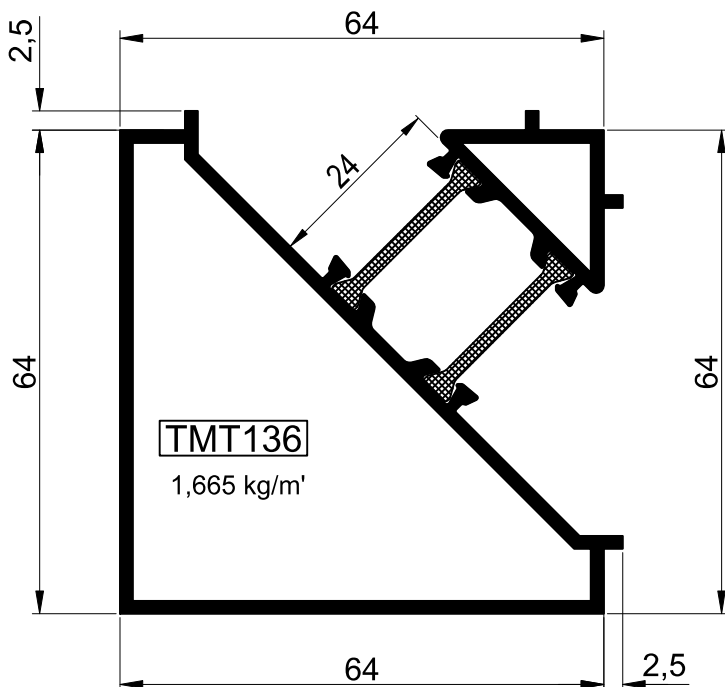
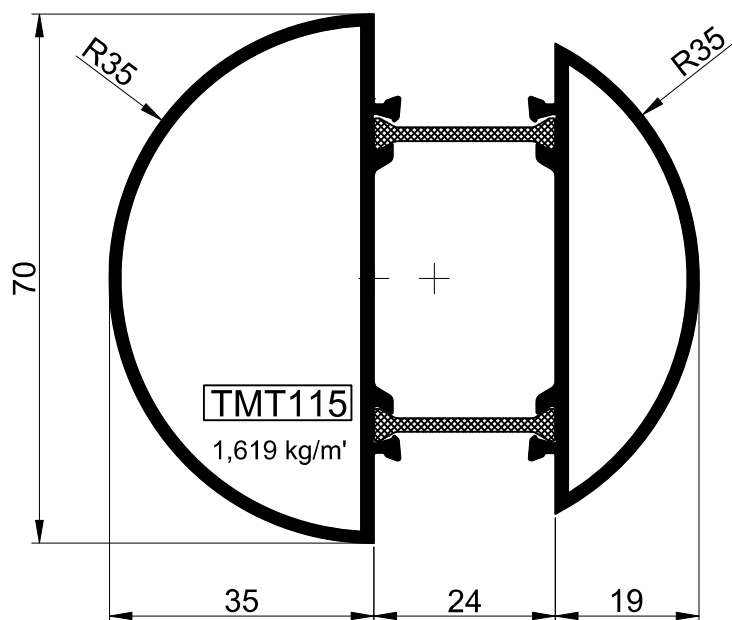
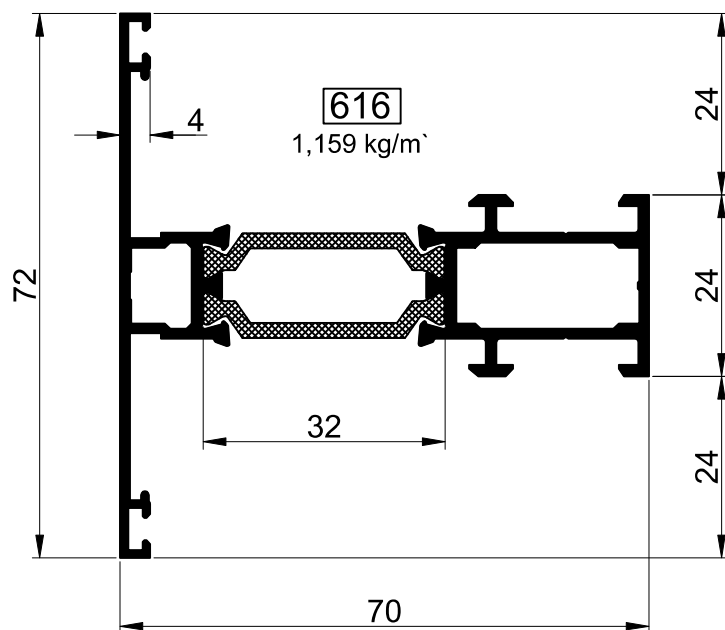
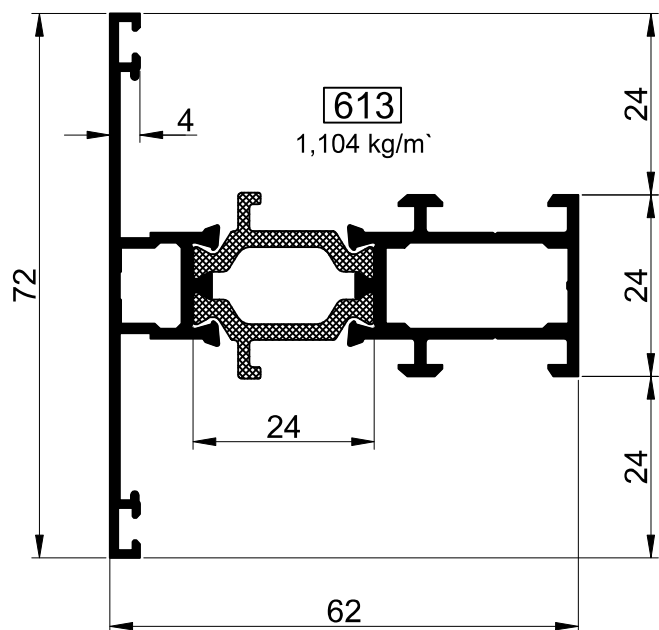
	Oznaka Mark Марк	Opis Description Описание				
	kg/m`		ly			a b
	614	Krilo vrata -otvaranjem unutra- EURO 1 Door leaf -open in -EURO 1	42,409	939	940	920
	1,652	Крыло двери, открывающиеся внутрь -ЕУРО1	16,969	930	932	TMA18
	615	Krilo vrata -otvaranjem unutra- EURO 16mm Door leaf -open in -EURO 16mm	42,464	939	941	920
	1,662	Крыло двери, открывающиеся внутрь -ЕУРО16мм	16,533	930	931	TMA18
	616	Prečka u krilu T profile in casement	25,118		922	
	1,159	Препятствие в створки	6,652		905	
	617	Parapetni profil u štoku / Veliki štok Parapet profile in frame / Large frame	38,921	911	908	920
	2,270	Парапет профиль в рамке большой рам	83,565	925	923	
	618	Parapetni profil u krilu Parapet profile in casement	52,685		915	
	2,300	Парапет профиль в створки	83,738		905	
	619	Krilo vrata -otvaranjem spolja- EURO 1 Door leaf -open out -EURO 1	34,416	939	940	920
	1,674	Крыло двери, открывающиеся наружу -ЕУРО1	24,165	930	932	TMA18
	620	Krilo vrata -otvaranjem spolja- EURO 16mm Door leaf -open out -EURO 16mm	34,649	939	942	920
	1,685	Крыло двери, открывающиеся наружу -ЕУРО16мм	23,420	930	933	TMA18
	TMT115	Ugaoni profil -promenjiv ugao Angle connector	29,374			
	1,619	Угловой профиль - изменяемый угол	22,589			

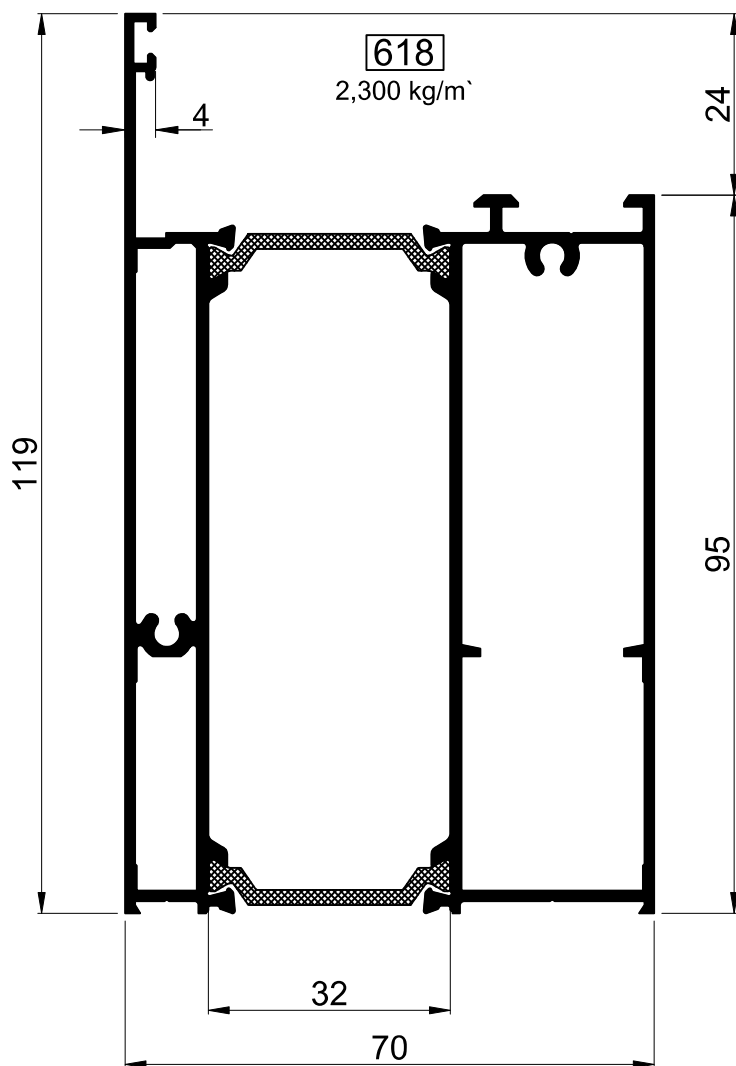
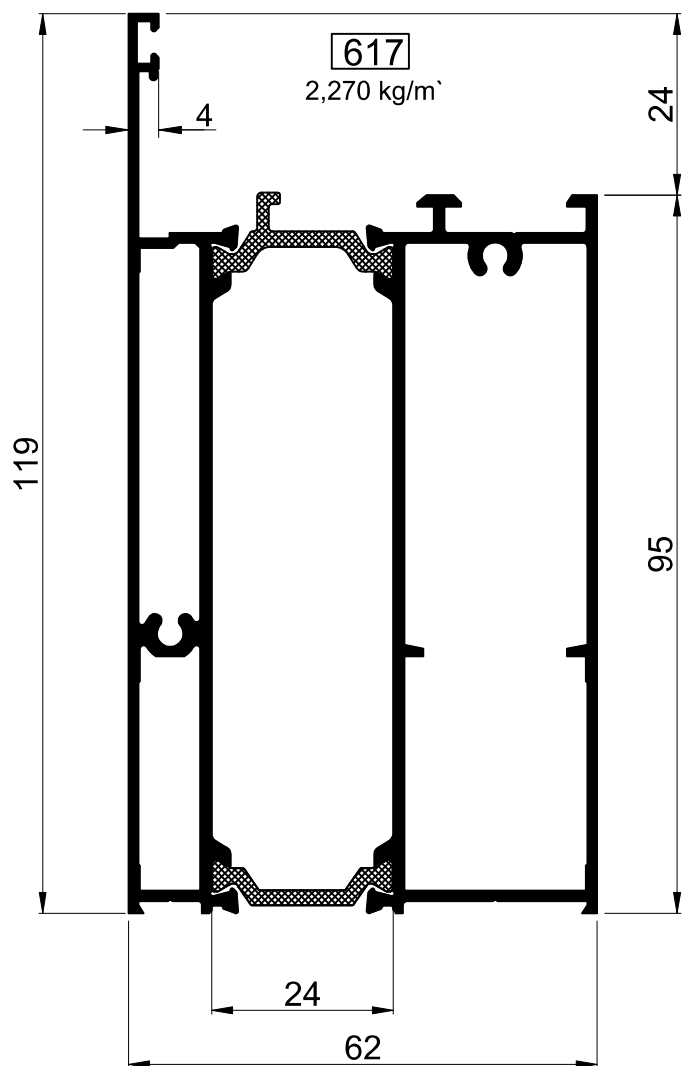
	Oznaka Mark Марк	Opis Description Описание				
	kg/m`		ly			a b
	TMT136	Ugaoni profil -90° Angle connector -90°	30,718			
	1,665	Угловой профиль - 90°	27,801			
	106	Držać stakla -16,5mm Glazing bead -16,5mm				
	0,302	Подстаканник -16,5мм				
	116	Držać stakla -20,5mm Glazing bead -20,5mm				
	0,320	Подстаканник -20,5мм				
	100	Držać stakla -24,5mm Glazing bead -24,5mm				
	0,330	Подстаканник -24,5мм				
	117	Držać stakla -28,5mm Glazing bead -28,5mm				
	0,348	Подстаканник -28,5мм				
	101	Držać stakla -32,5mm Glazing bead -32,5mm				
	0,359	Подстаканник -32,5мм				
	108	Držać stakla -38,5mm Glazing bead -38,5mm				
	0,380	Подстаканник -38,5мм				
	107	Držać stakla -46,5mm Glazing bead -46,5mm				
	0,409	Подстаканник -46,5мм				
	109	Mali slivnik Waterdrip				
	0,035	Капельник				

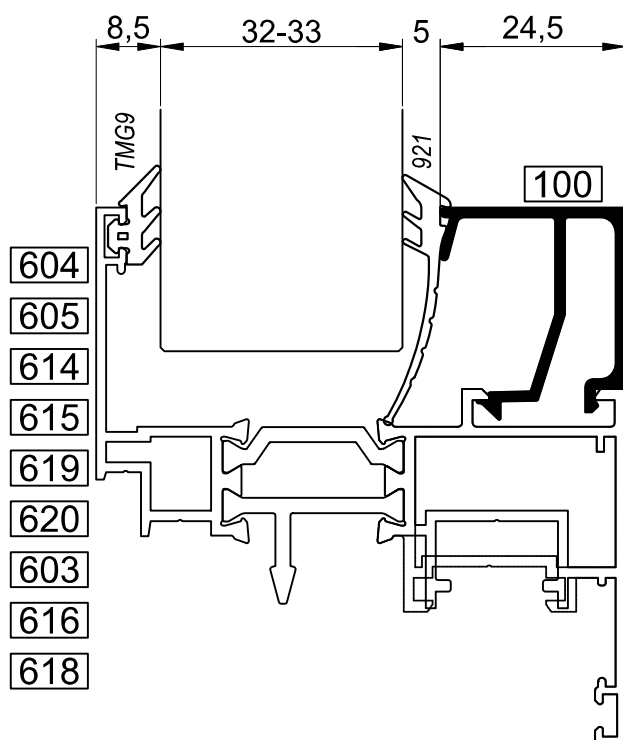
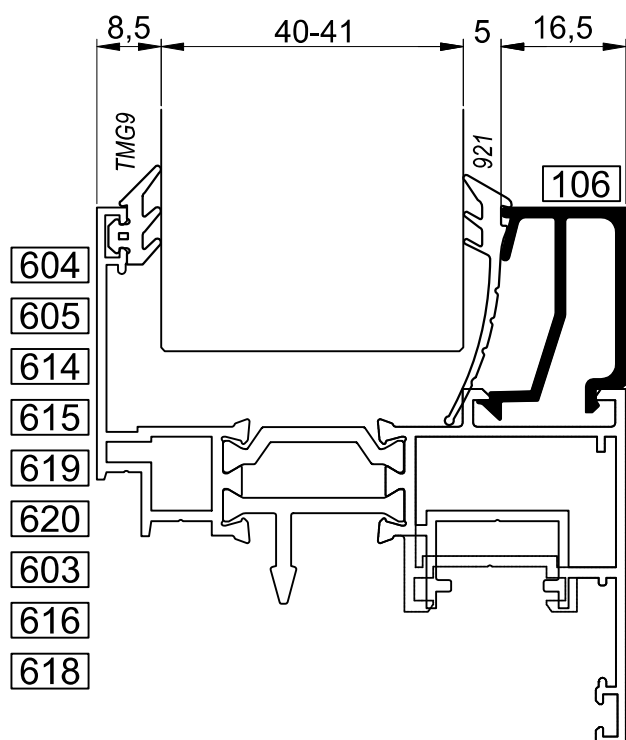
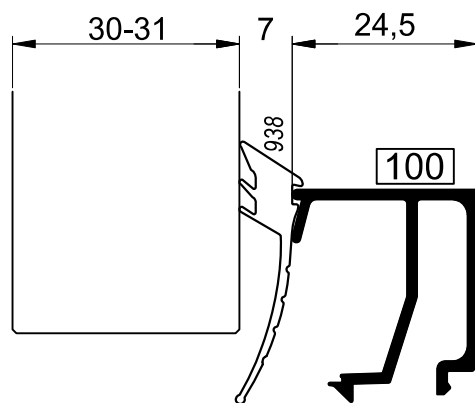
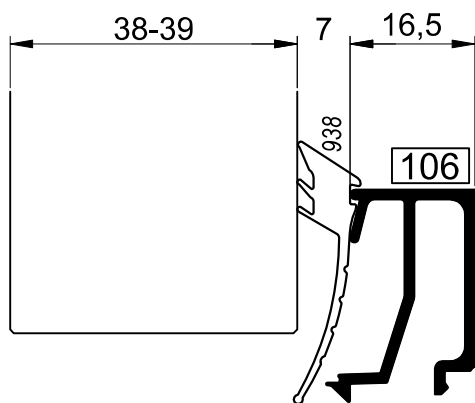
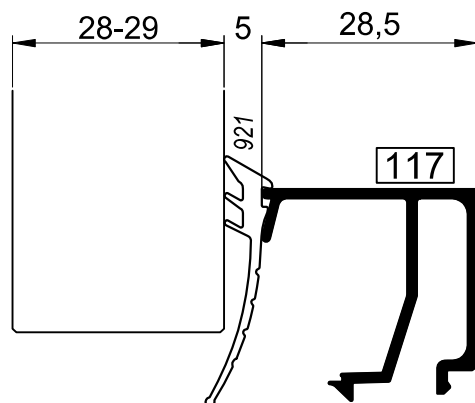
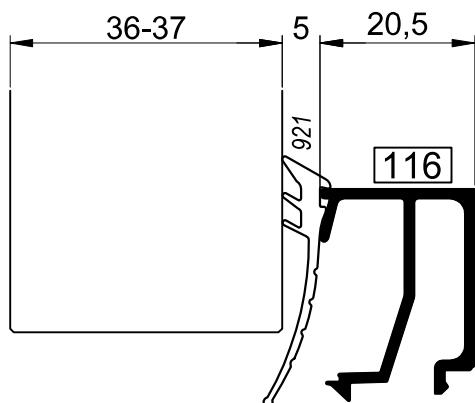
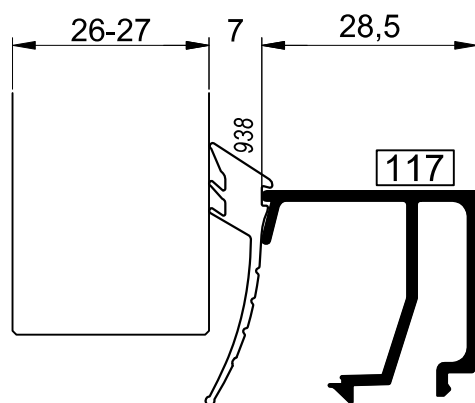
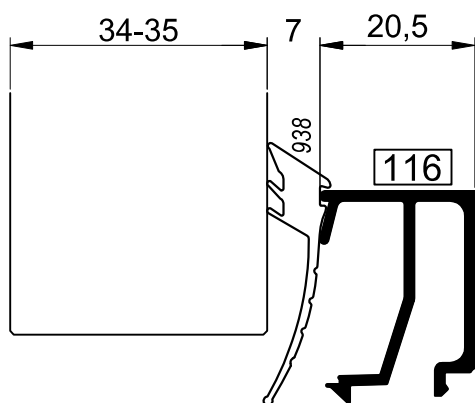
	Oznaka Mark Марк	Opis Description Описание				
	kg/m`		ly			b
	110	Opšivni profil Casing profile				
	0.119	Обшивка				
	TM33	Pogonska letva Rod for mechanism				
	0,152	Стержень для механизма				
	TM36	Slivnik Waterdrip				
	0,177	Капельник				
	TM42	Slivnik i nosač četkice Waterdrip				
	0,272	Капельник				
	TM43	Nosač četkice Brush holder				
	0,130	Держатель щетки				
	TM80	Modularni stub Modular mullion	19,853			
	0,946	Модульный колонка	5,102			
	TM81	Modularni stub Modular mullion				
	0,102	Модульный колонка				

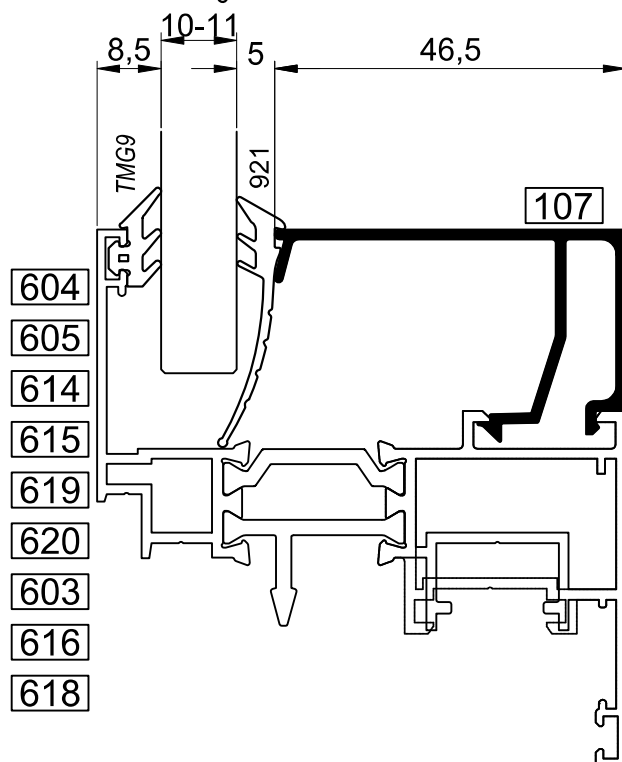
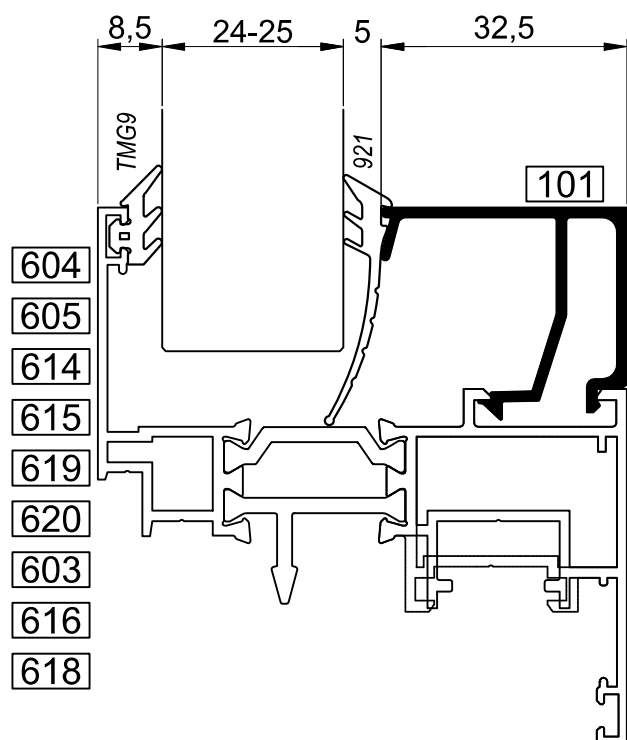
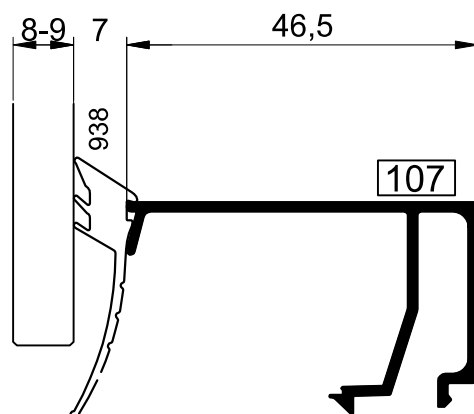
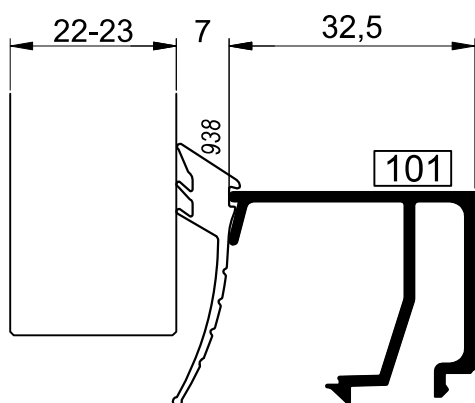
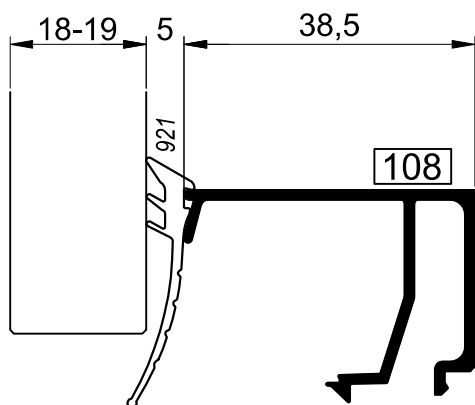
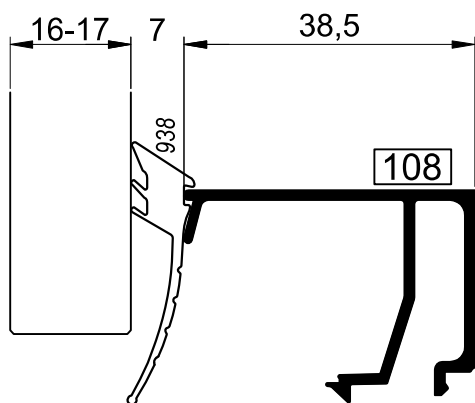


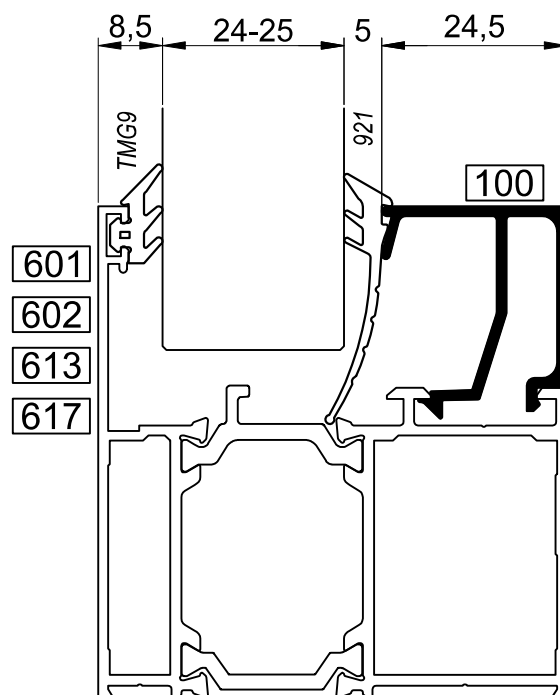
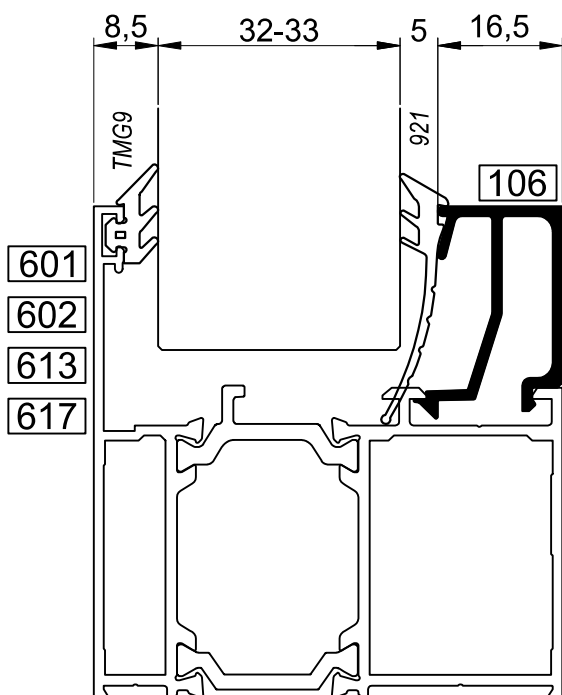
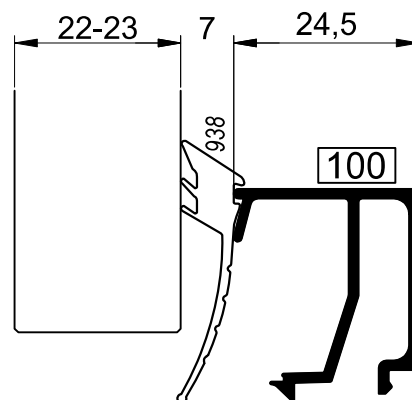
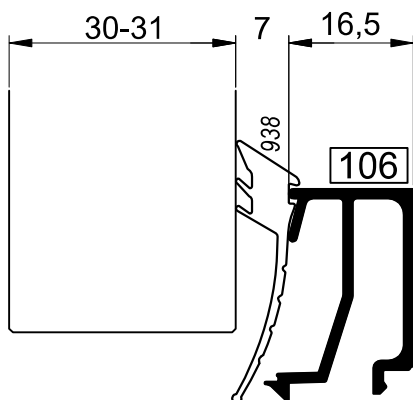
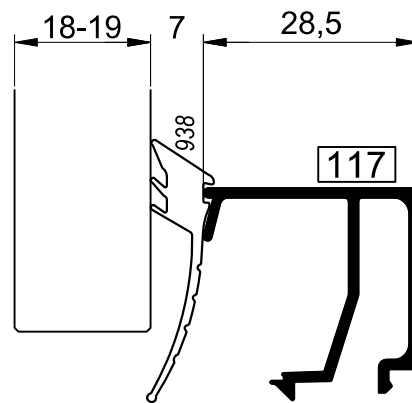
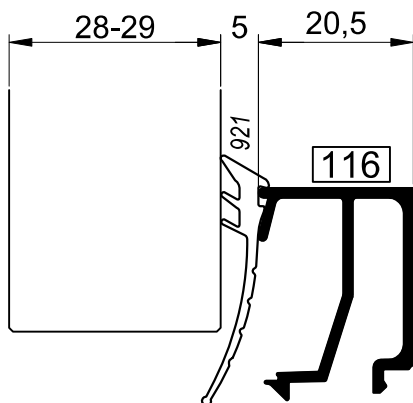
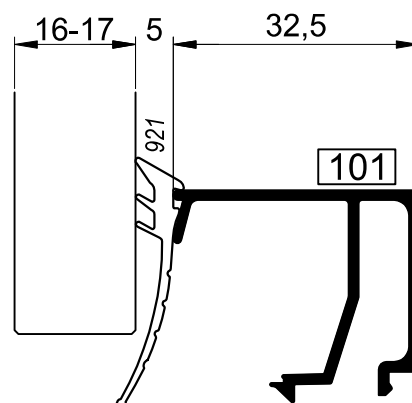
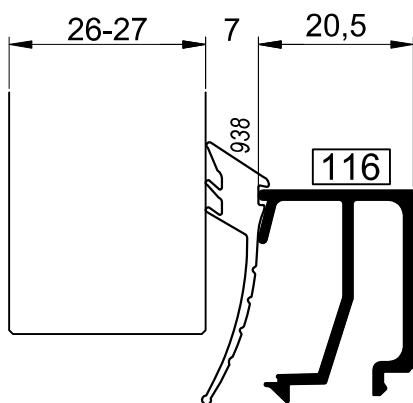


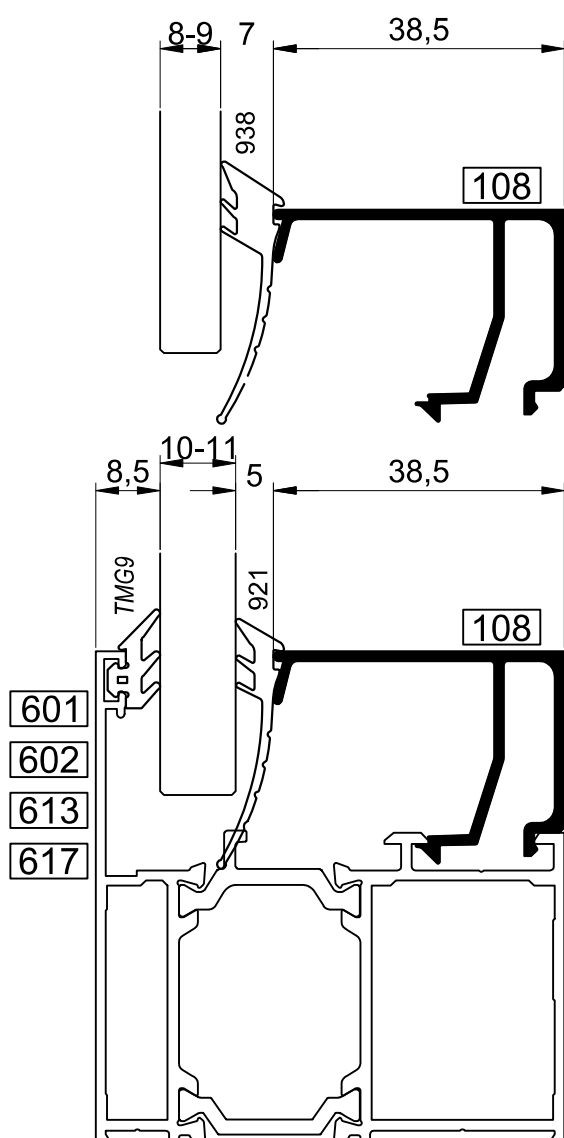


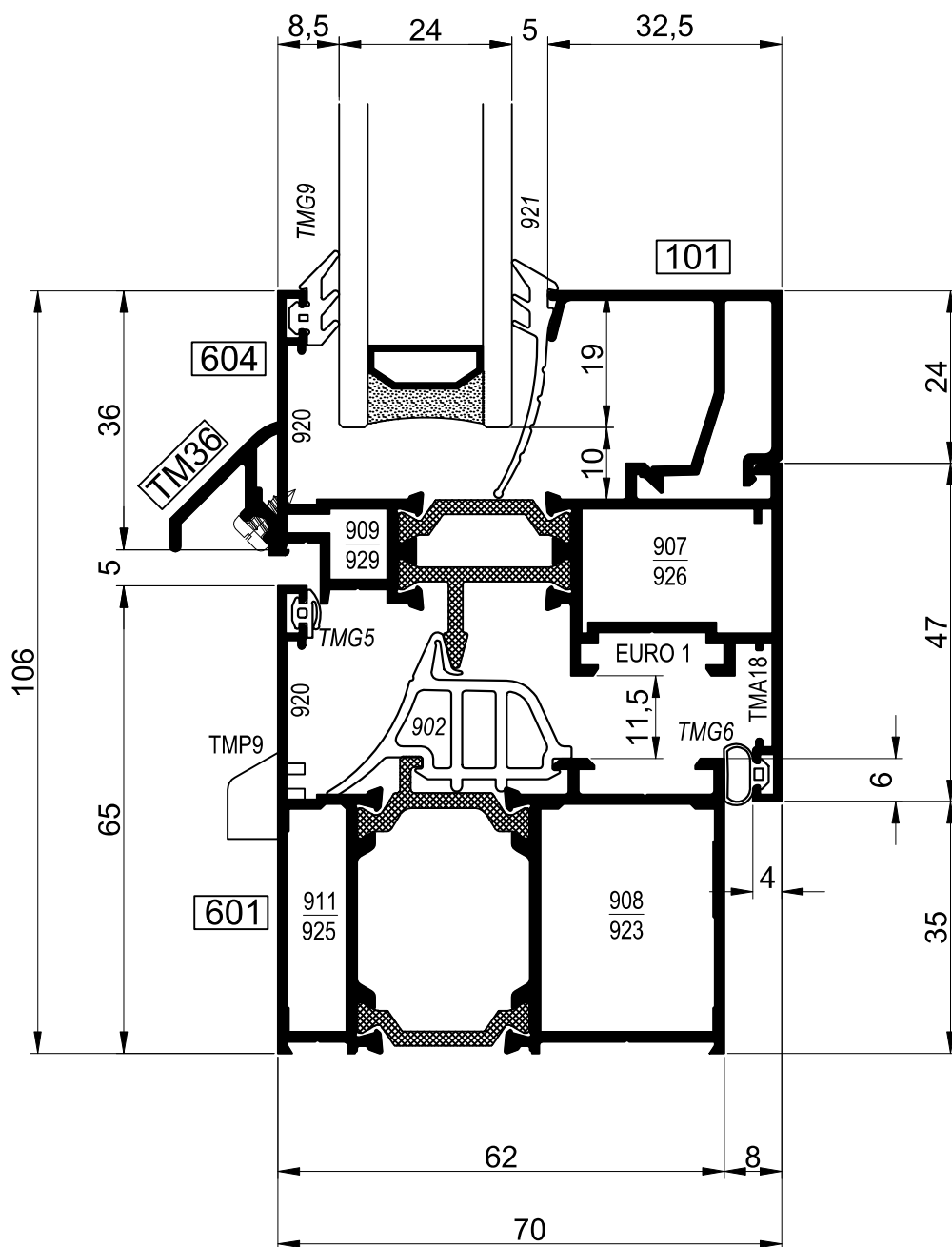
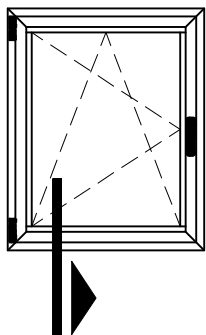


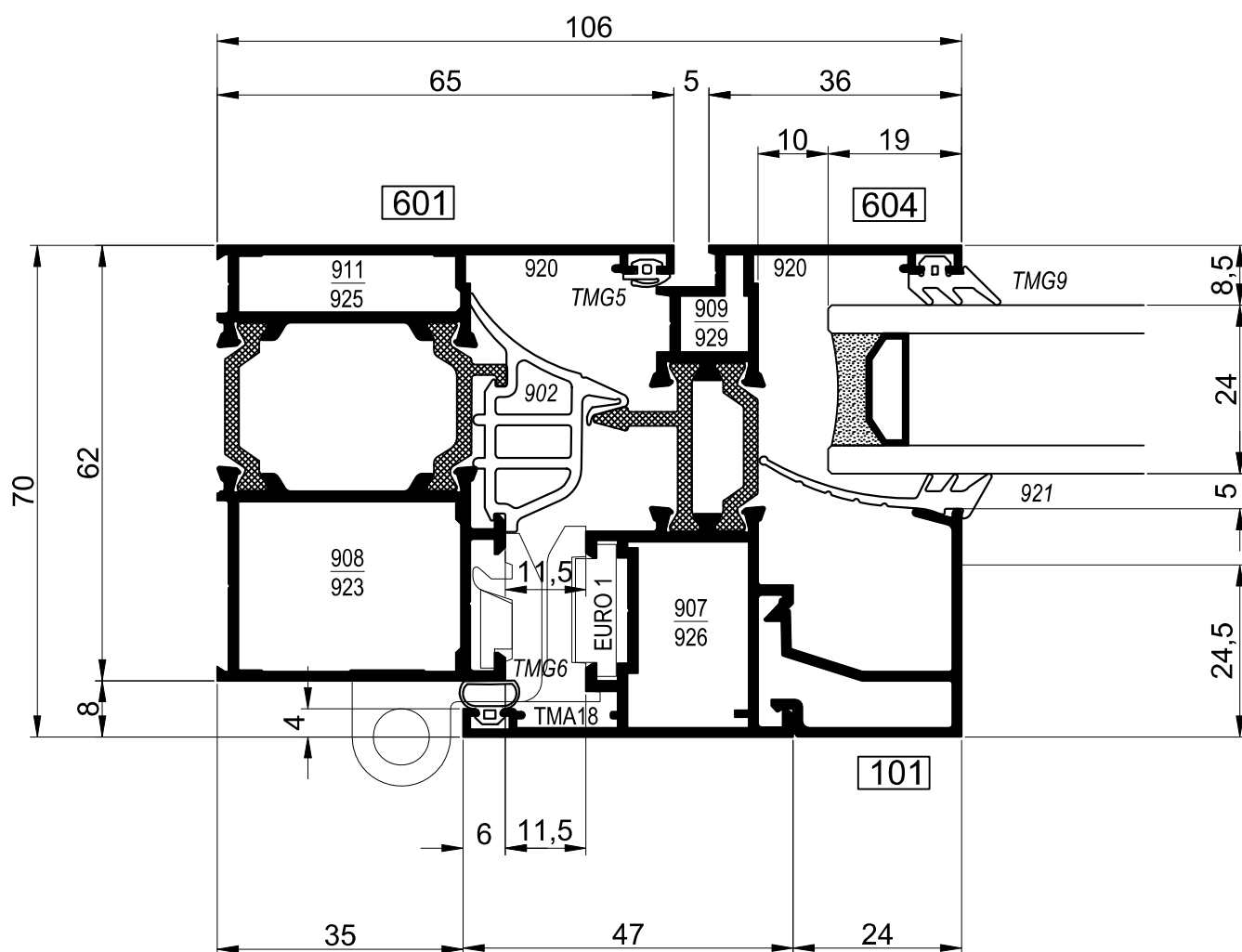
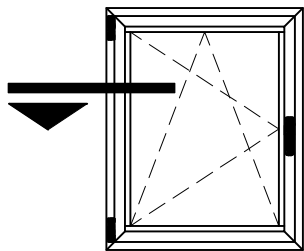


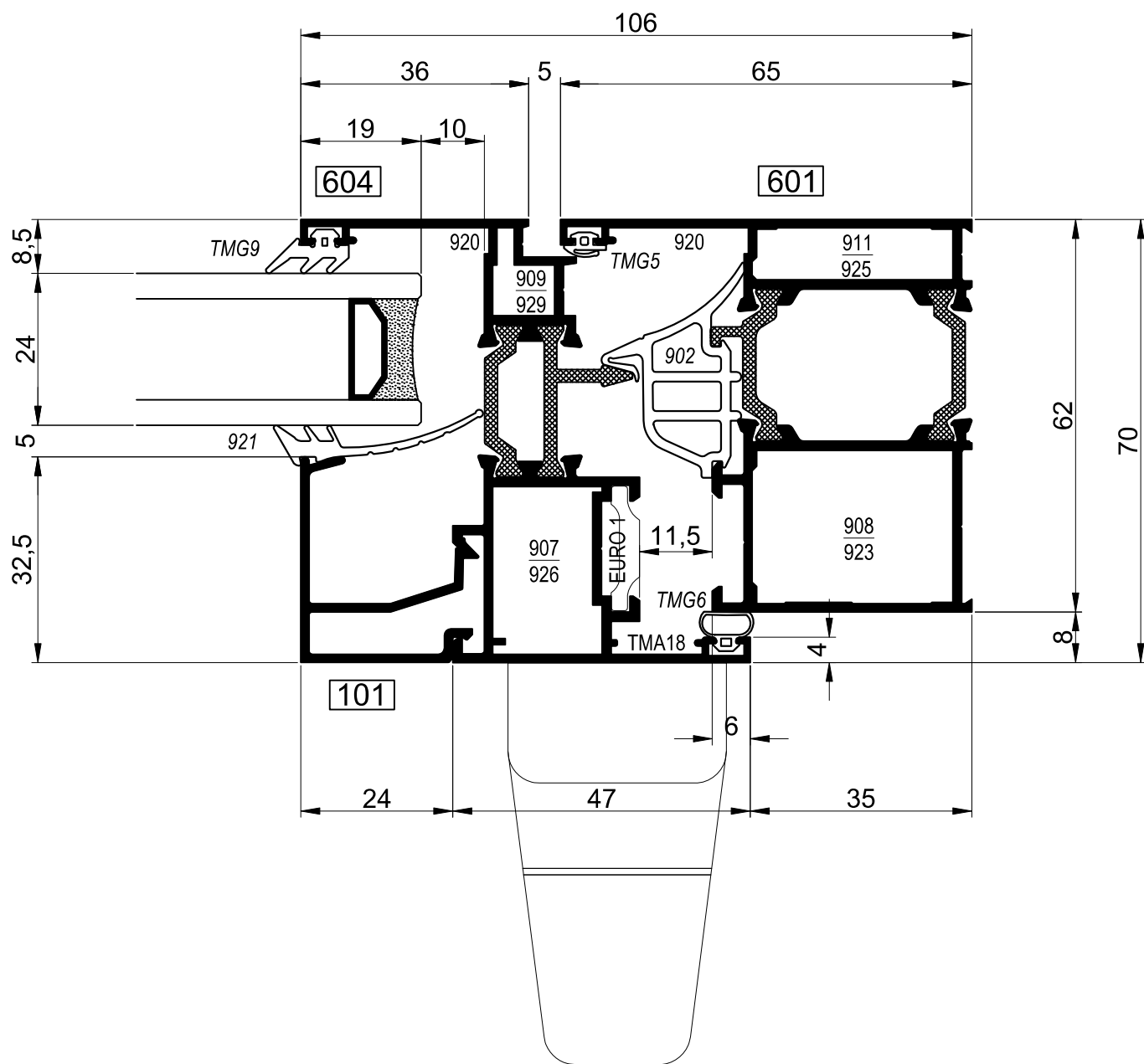
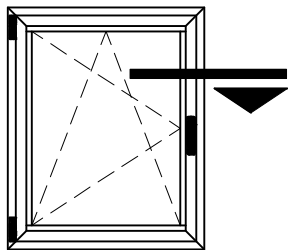


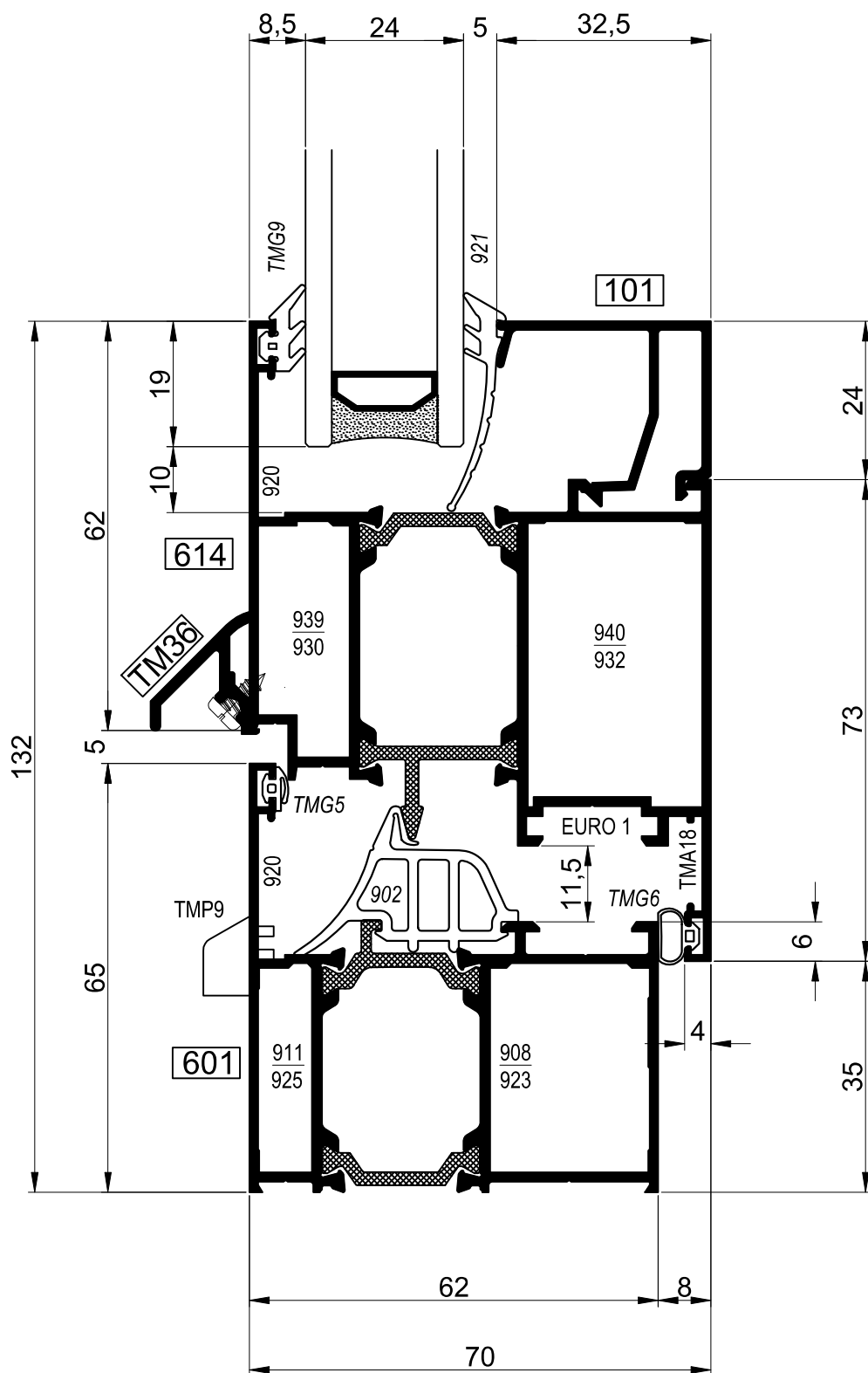
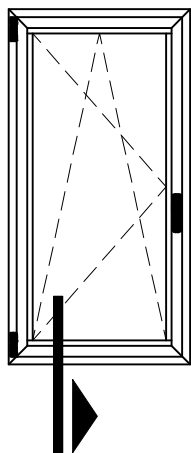


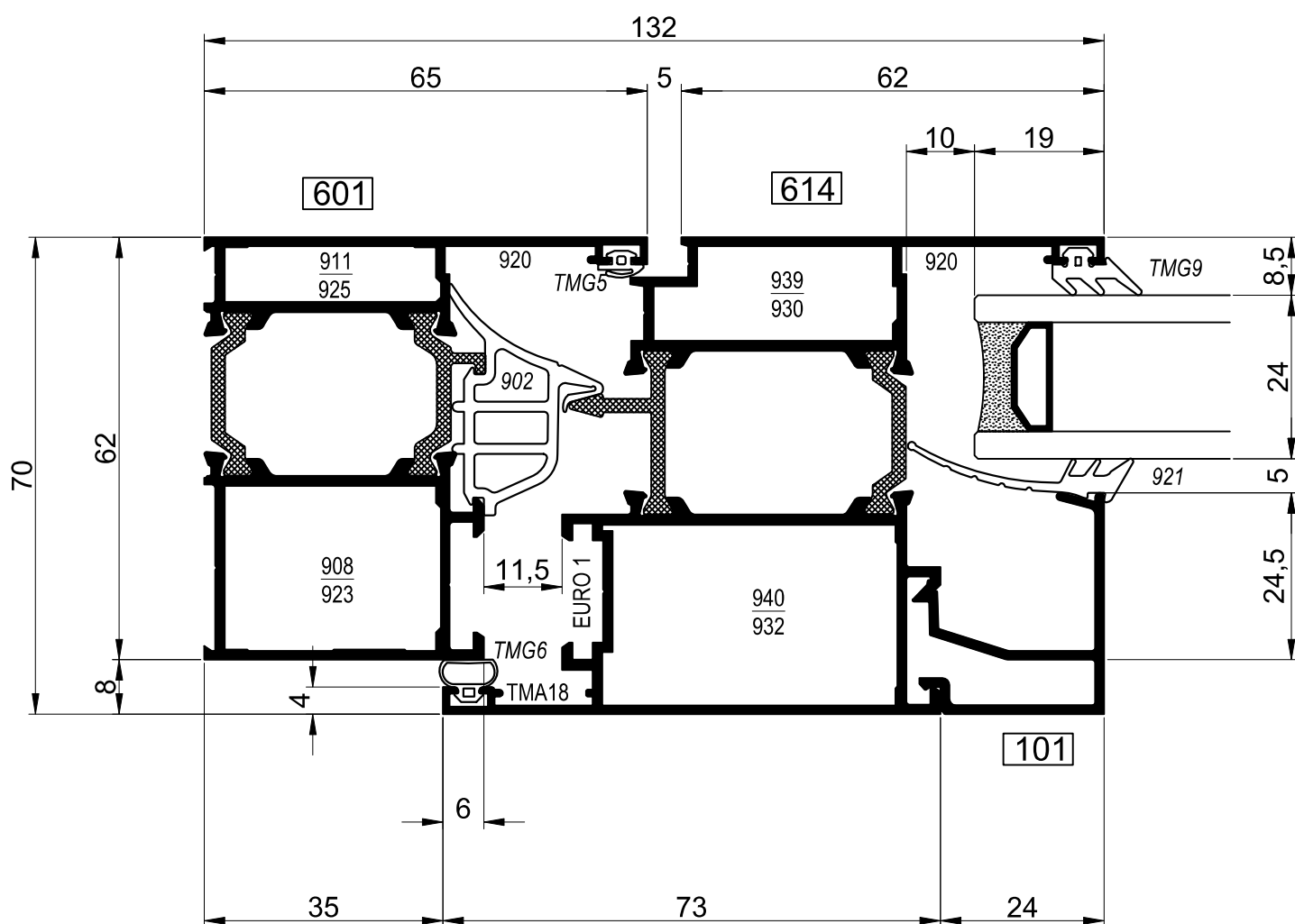
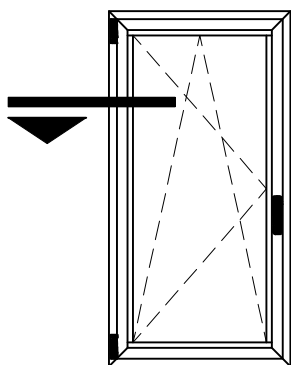


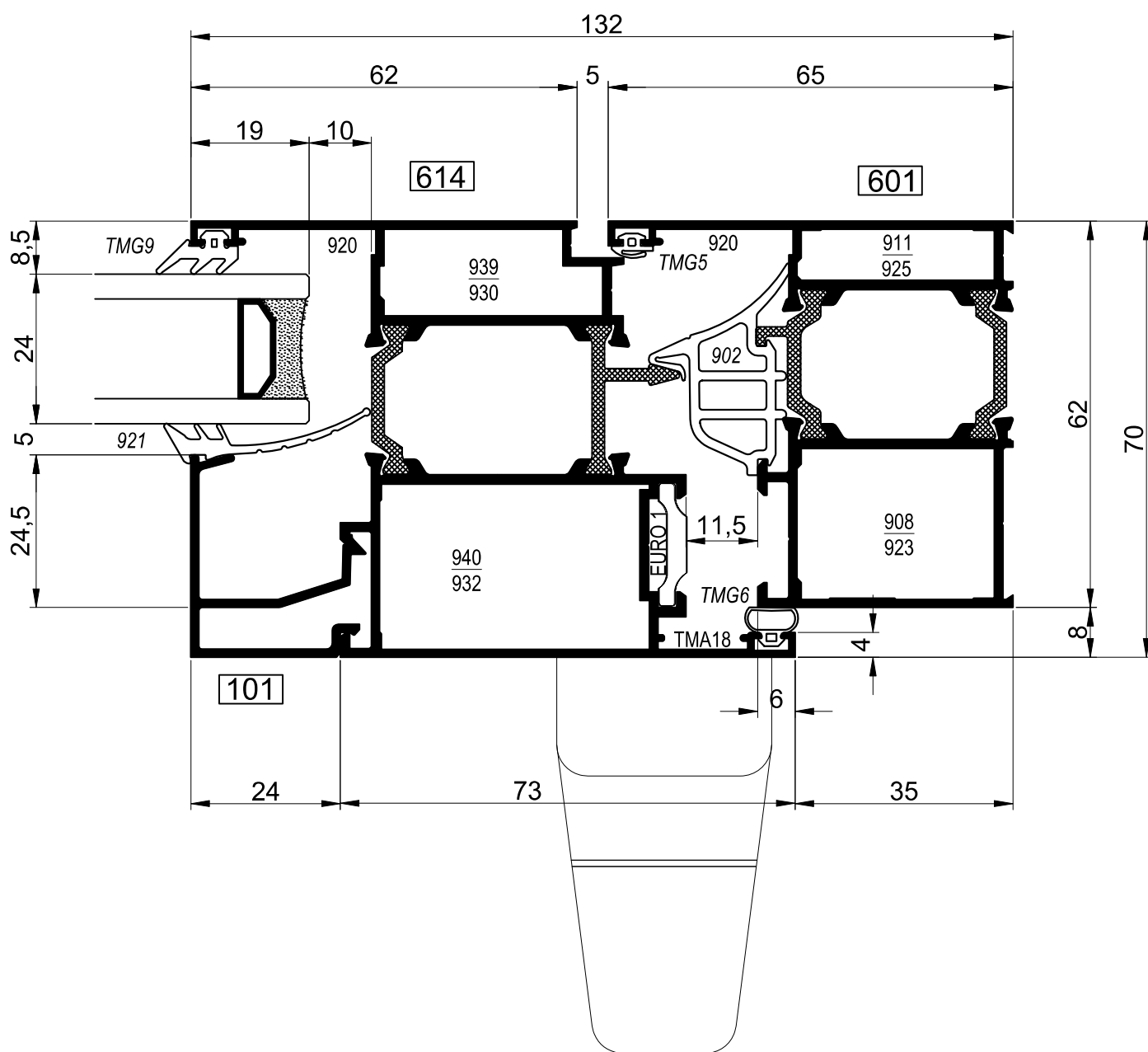
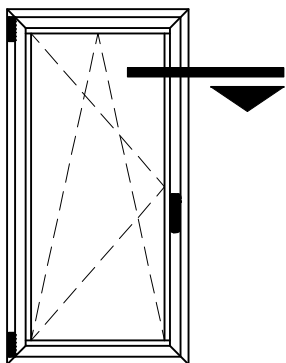


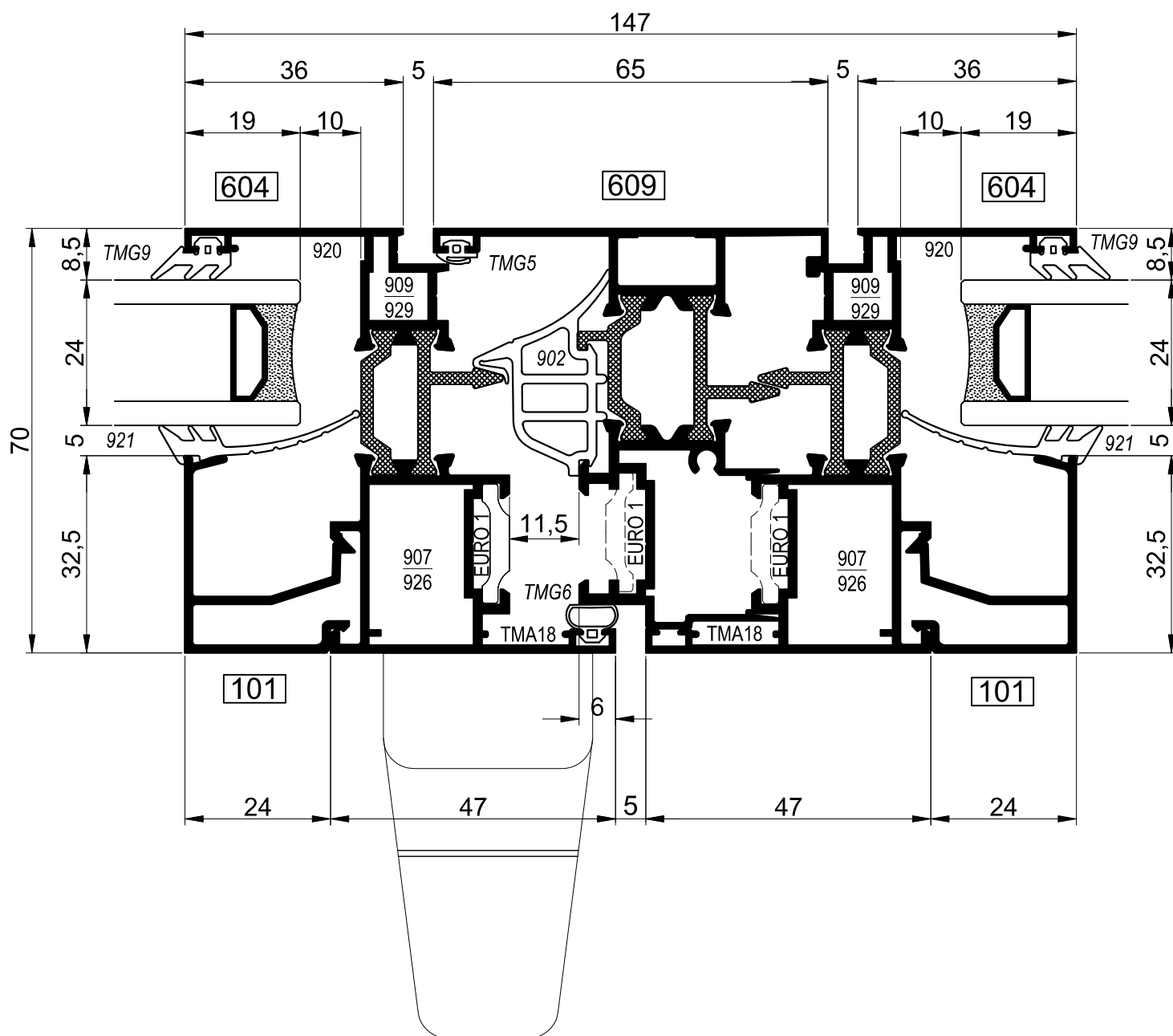
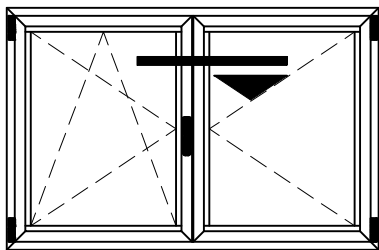


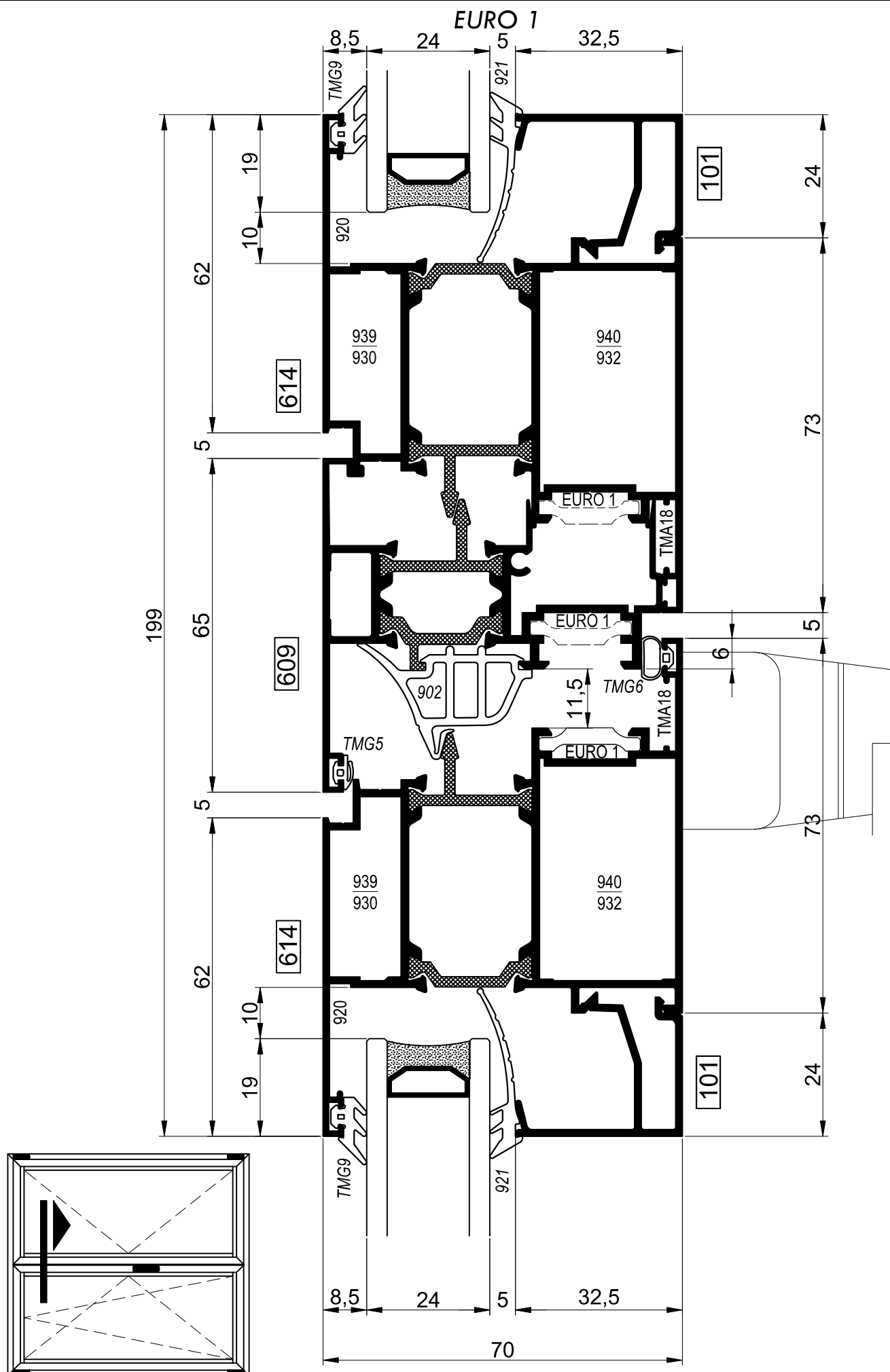


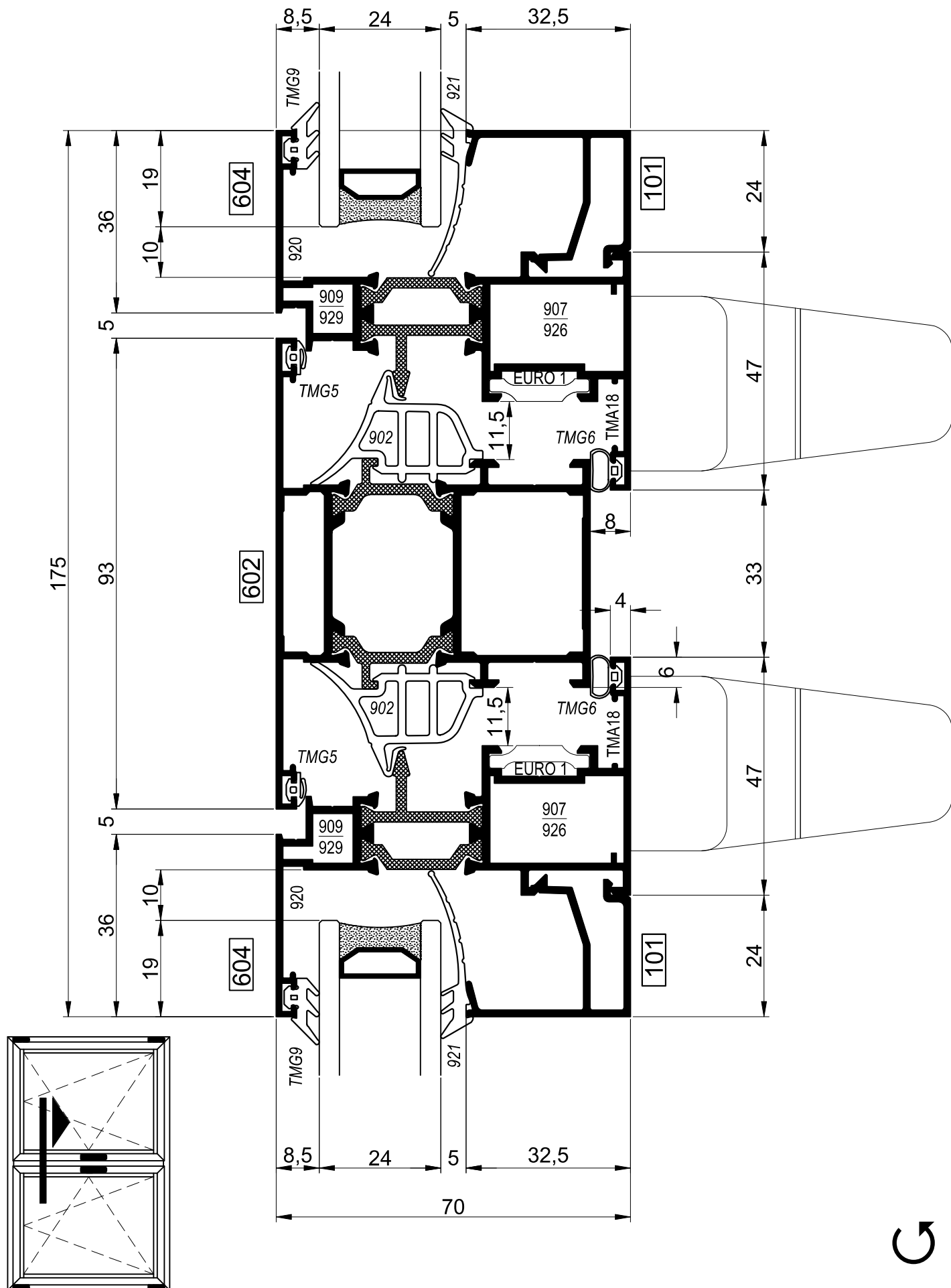


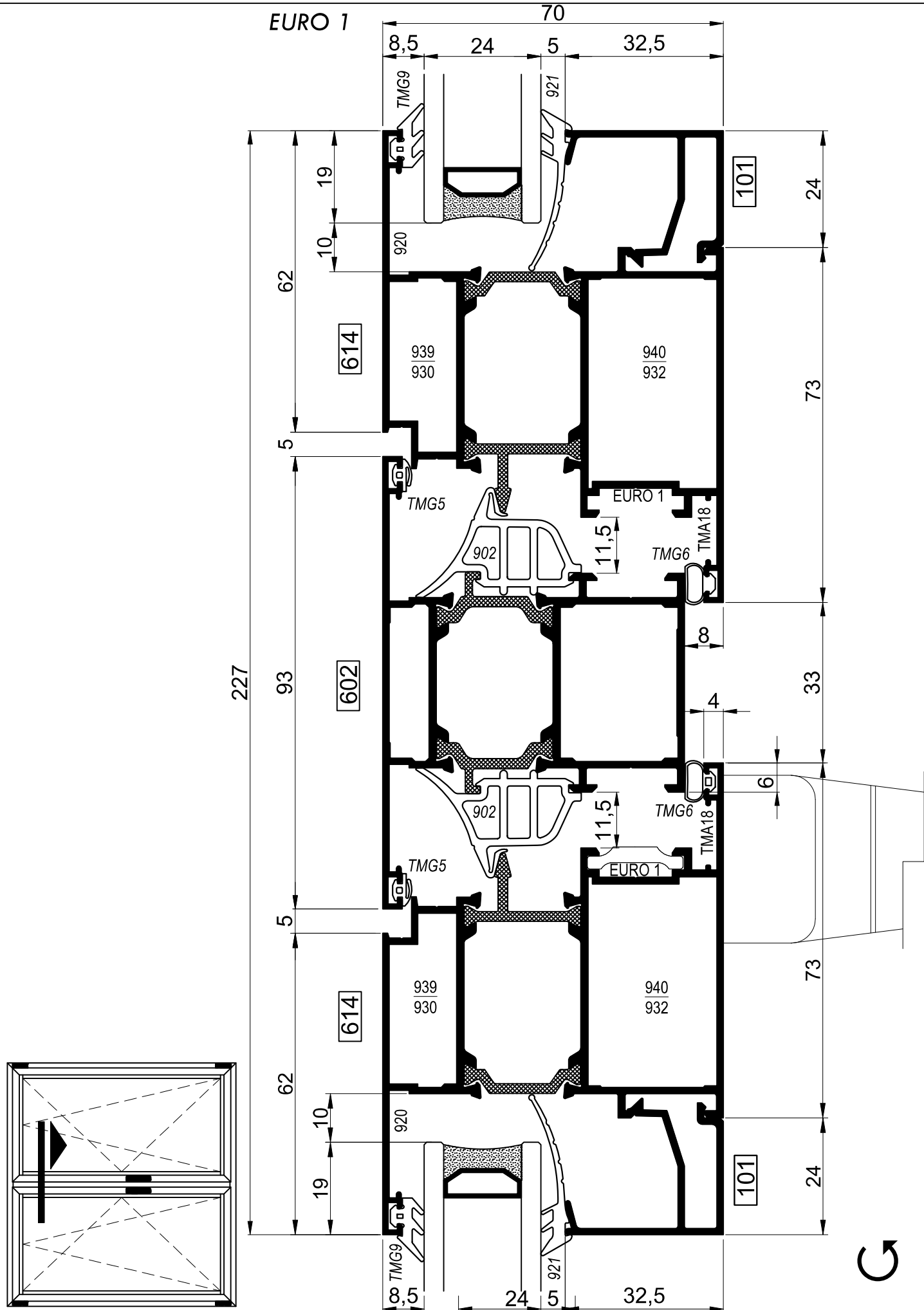


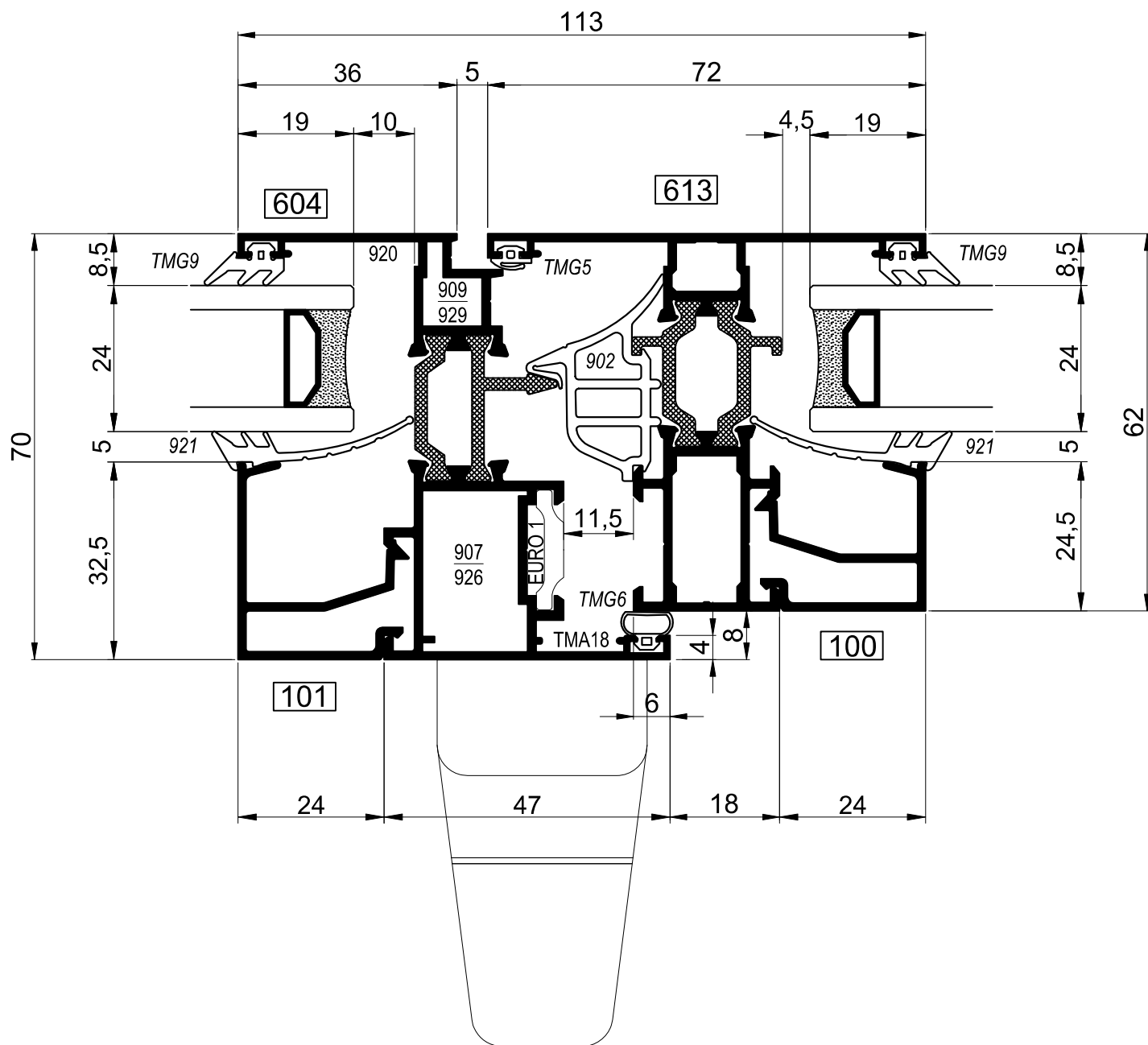
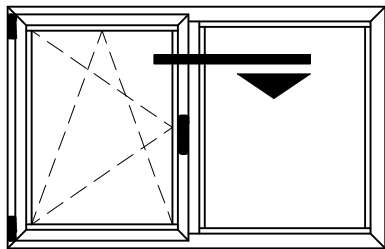




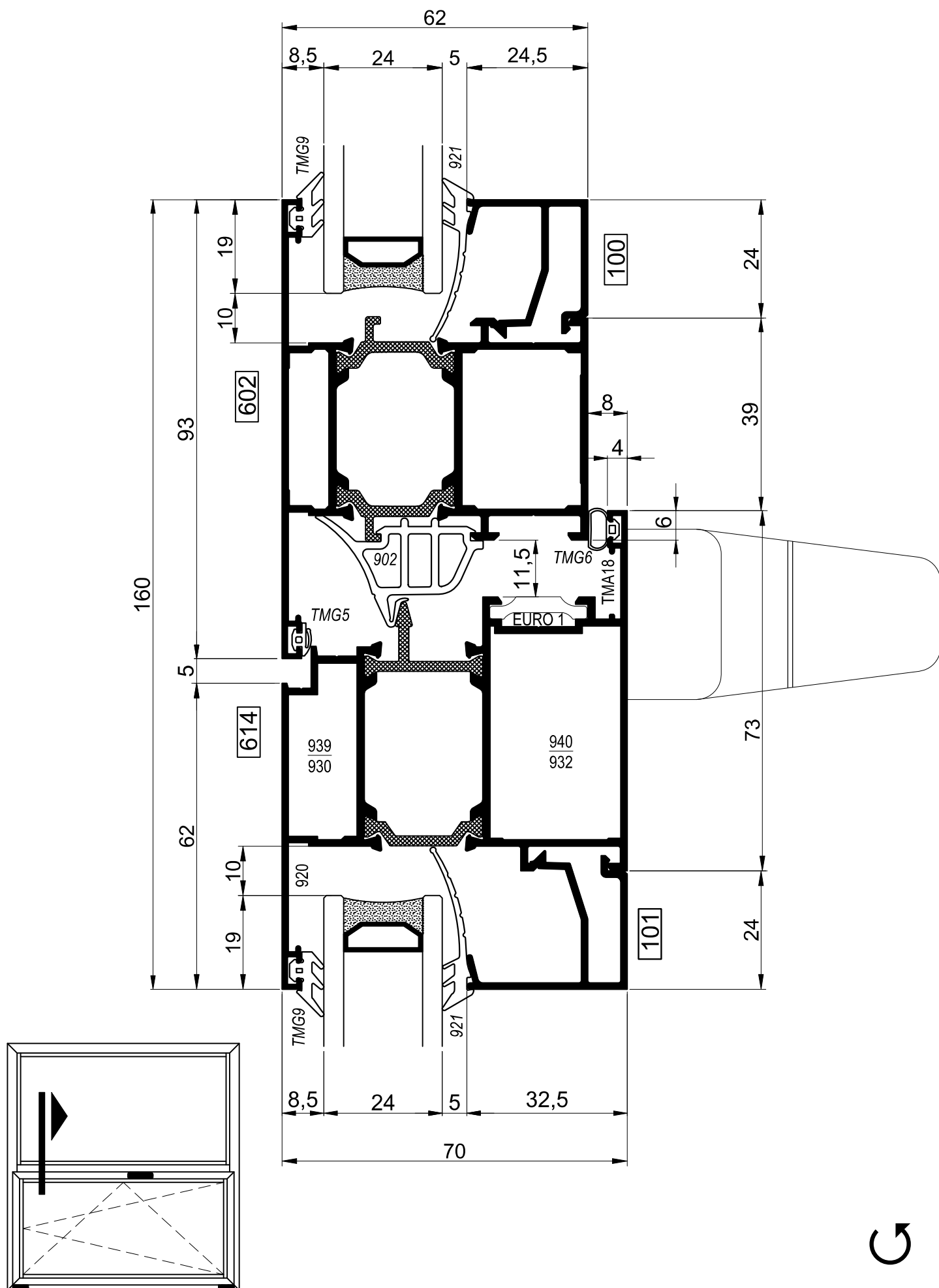


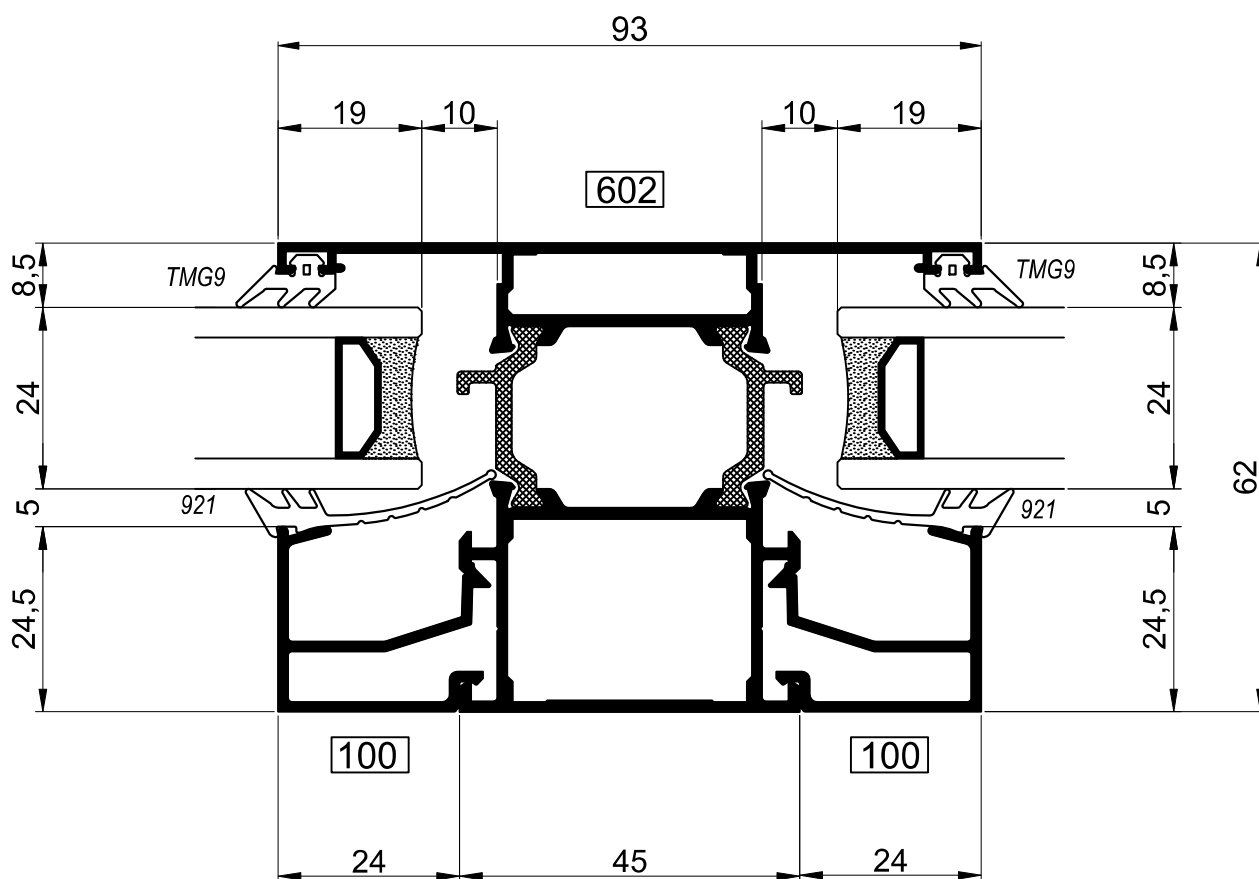
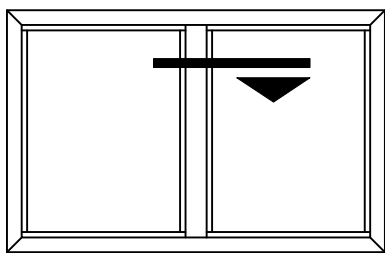


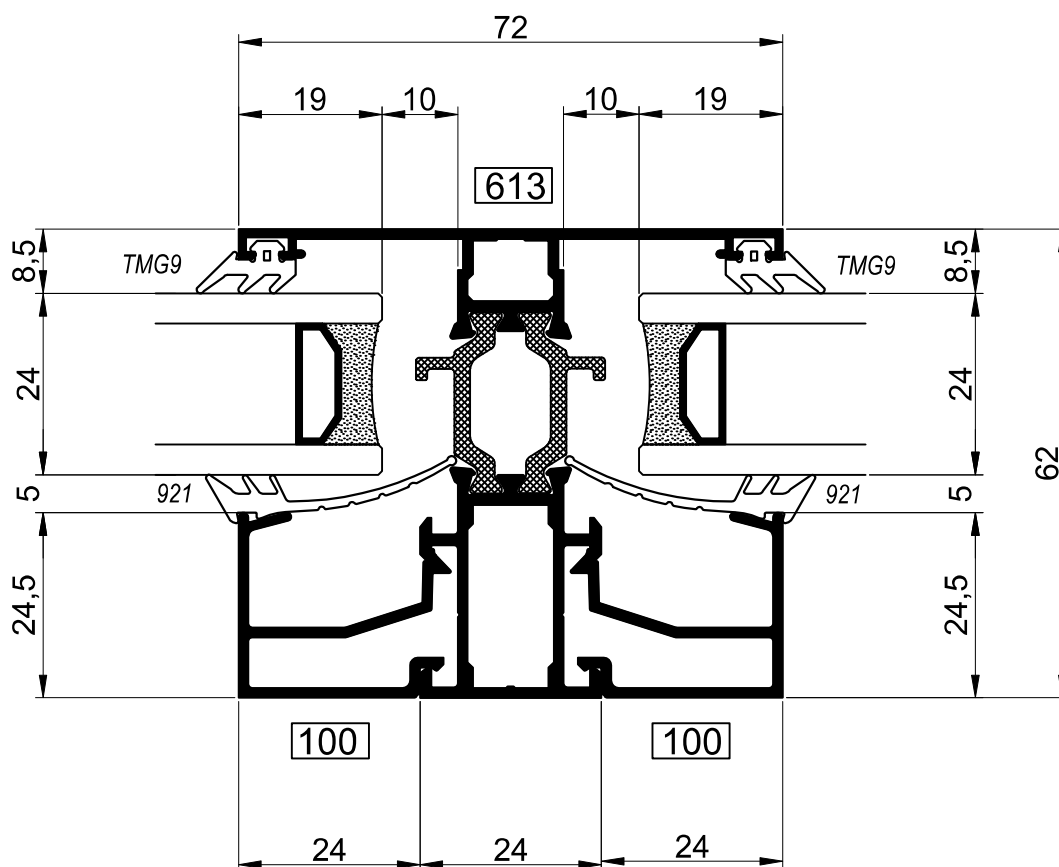
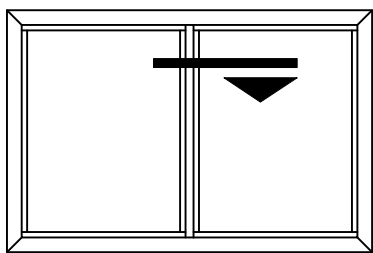


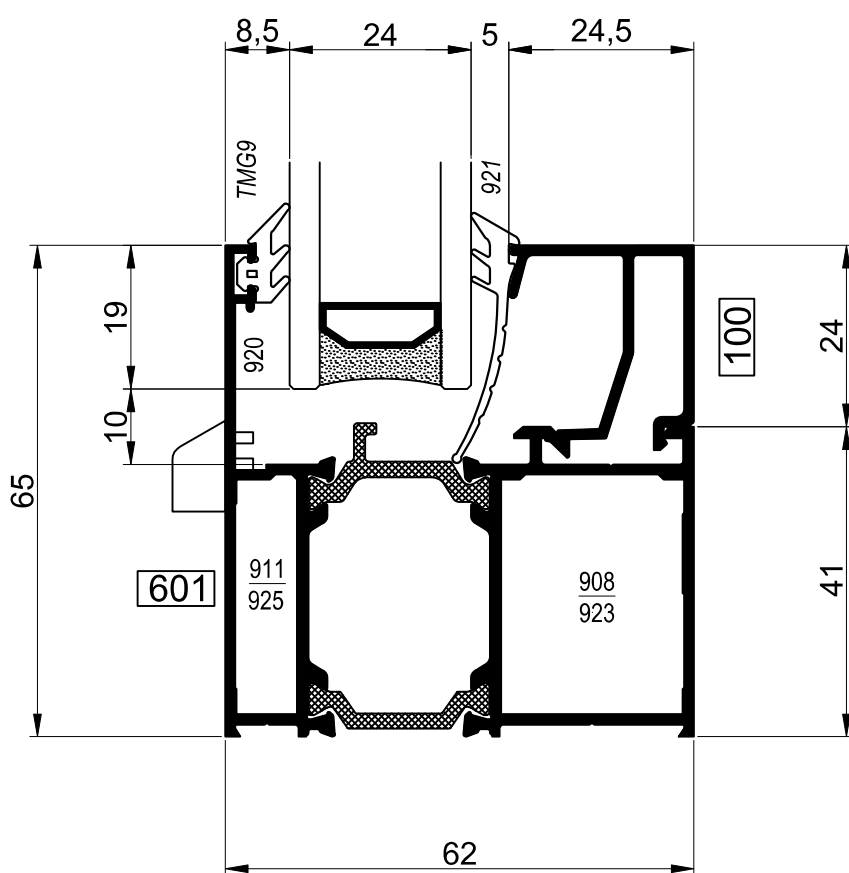
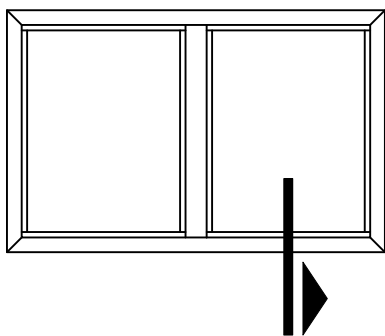


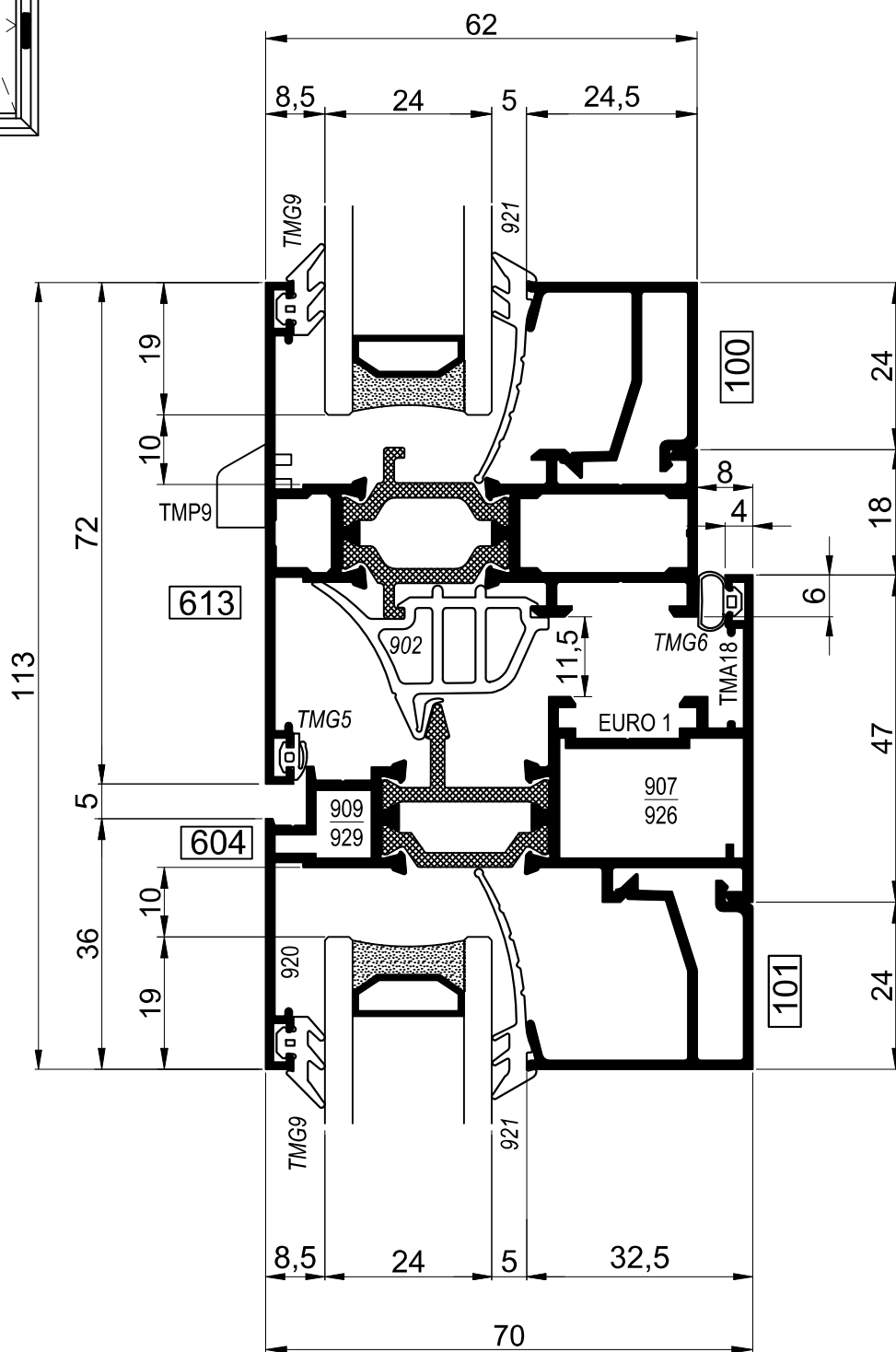
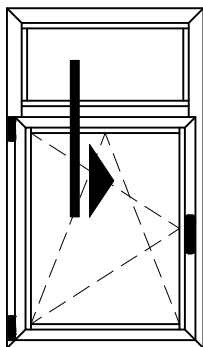
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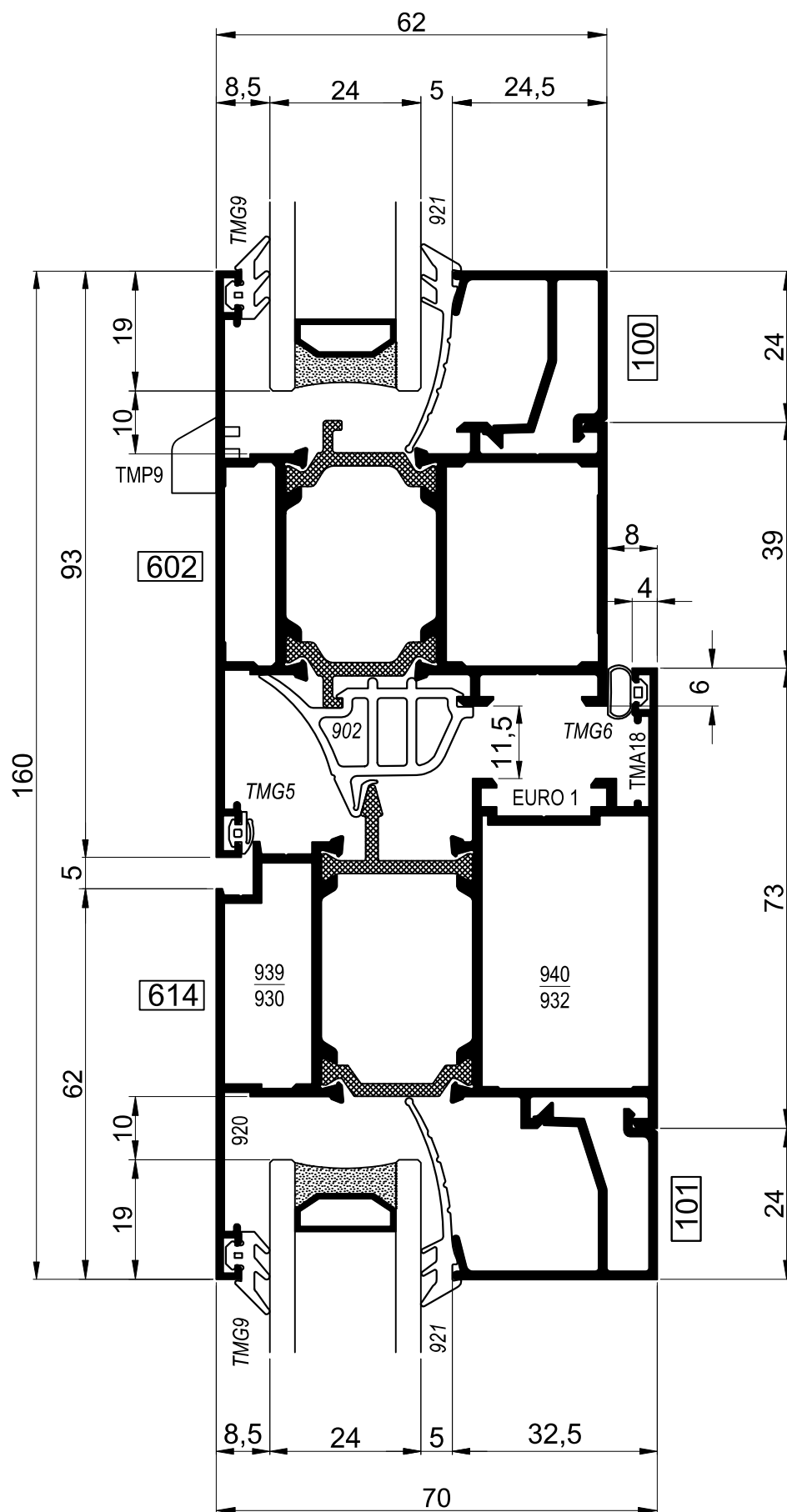
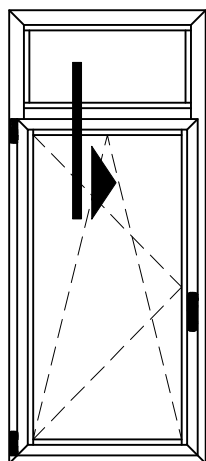


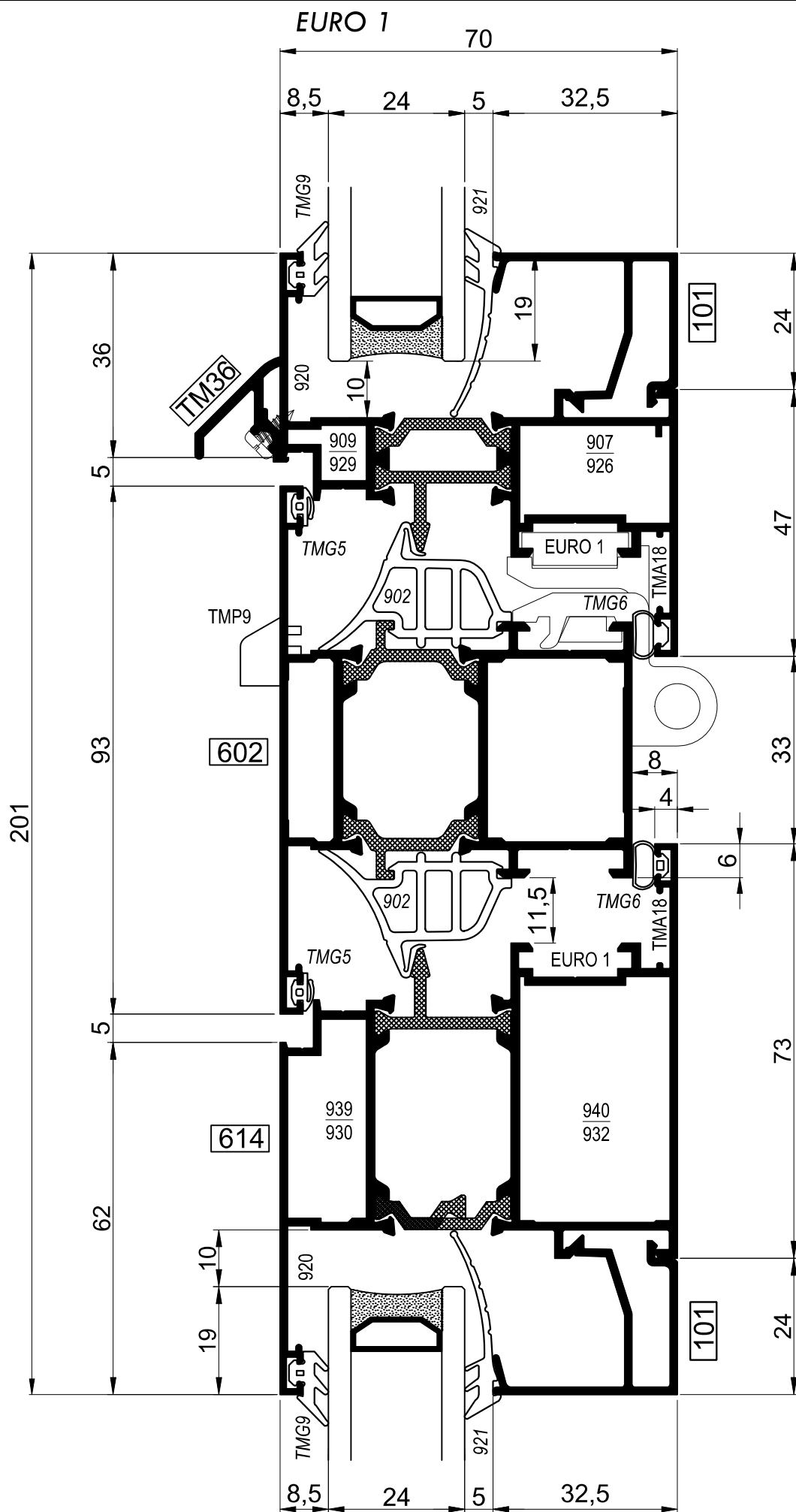
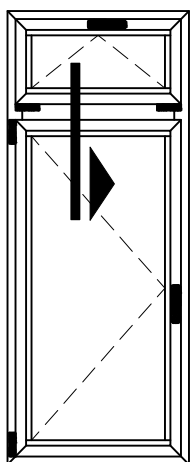


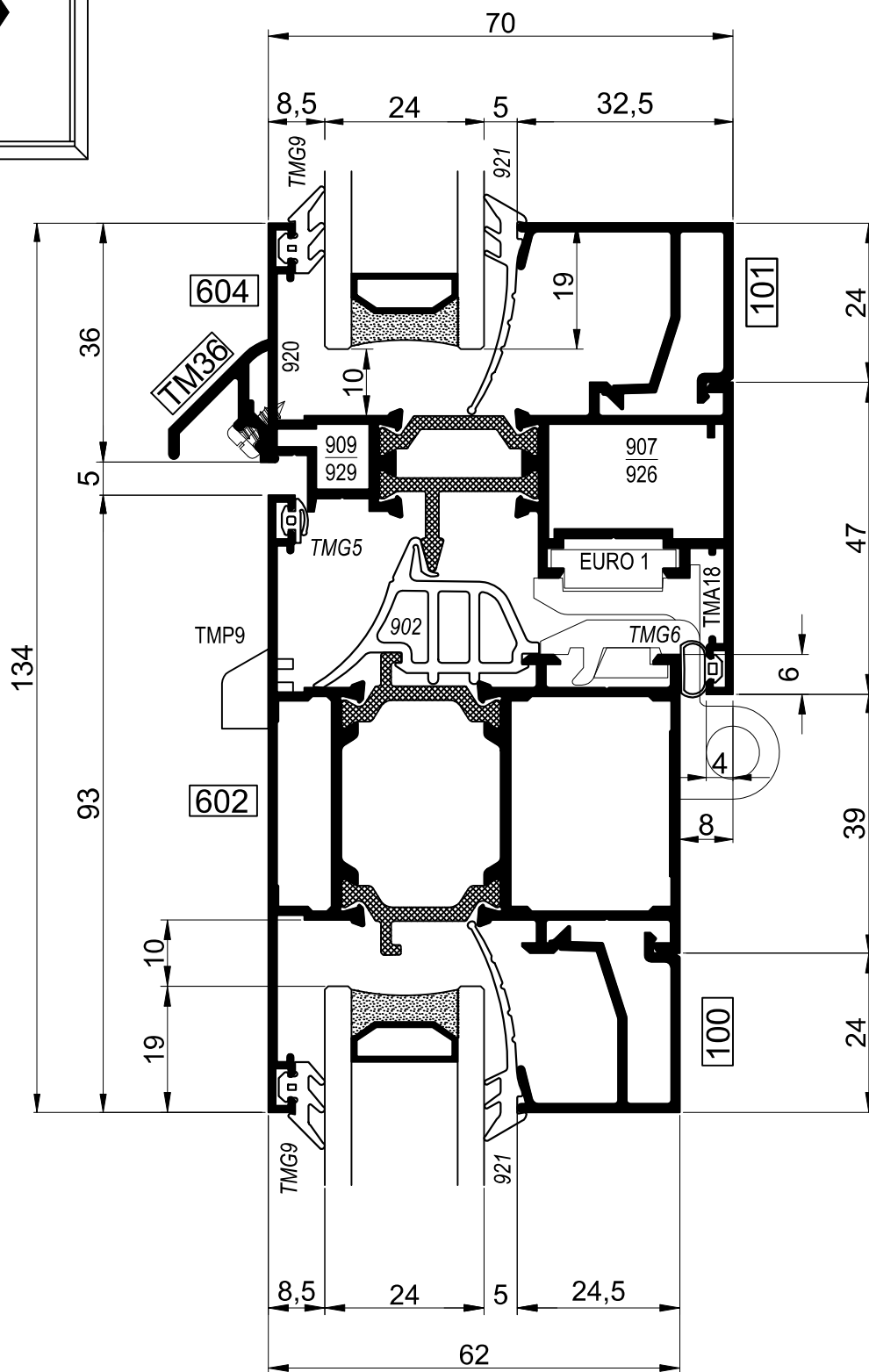
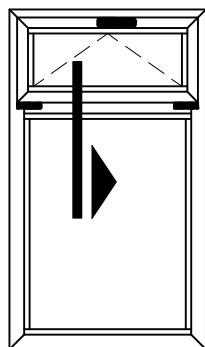




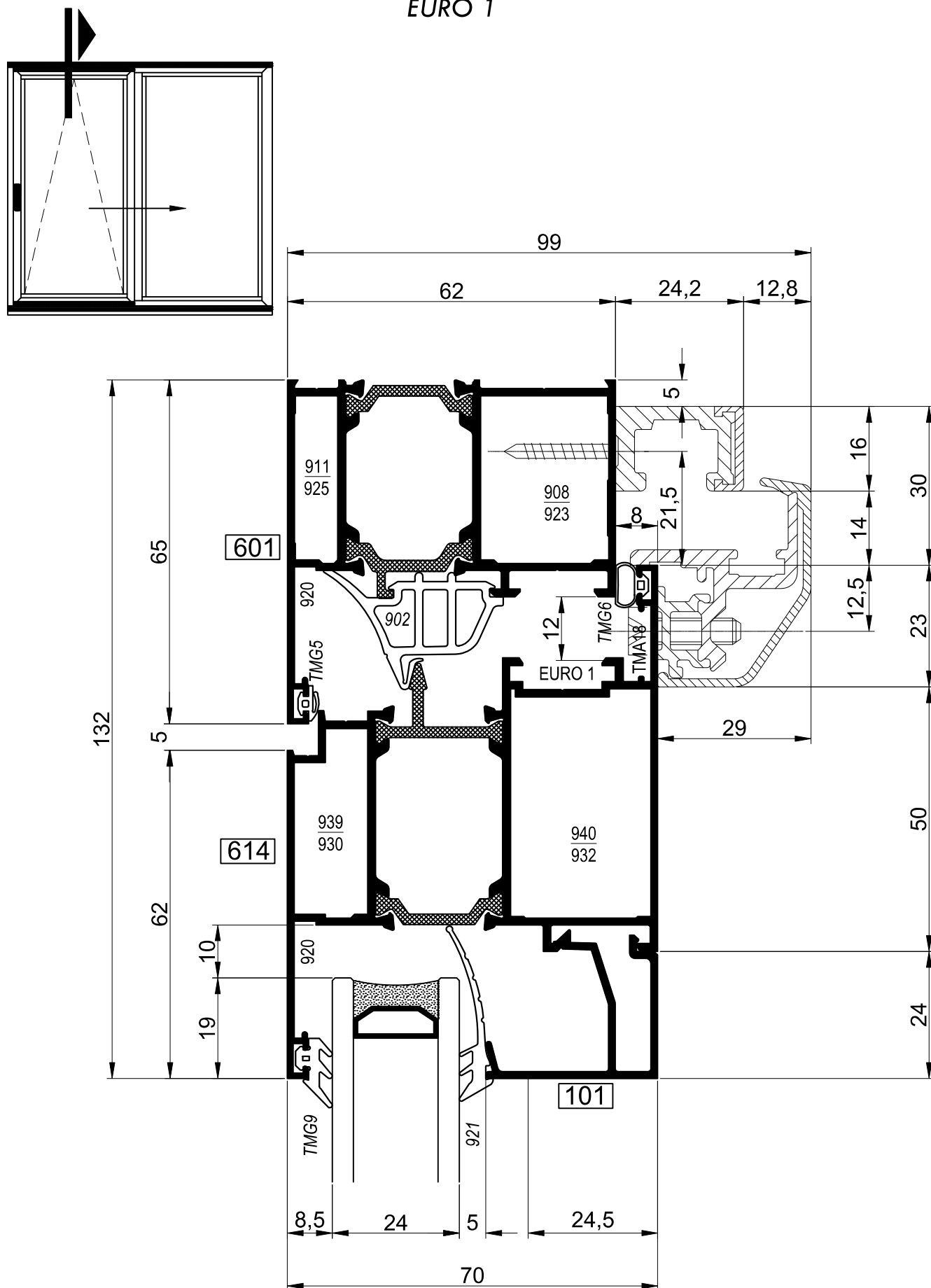




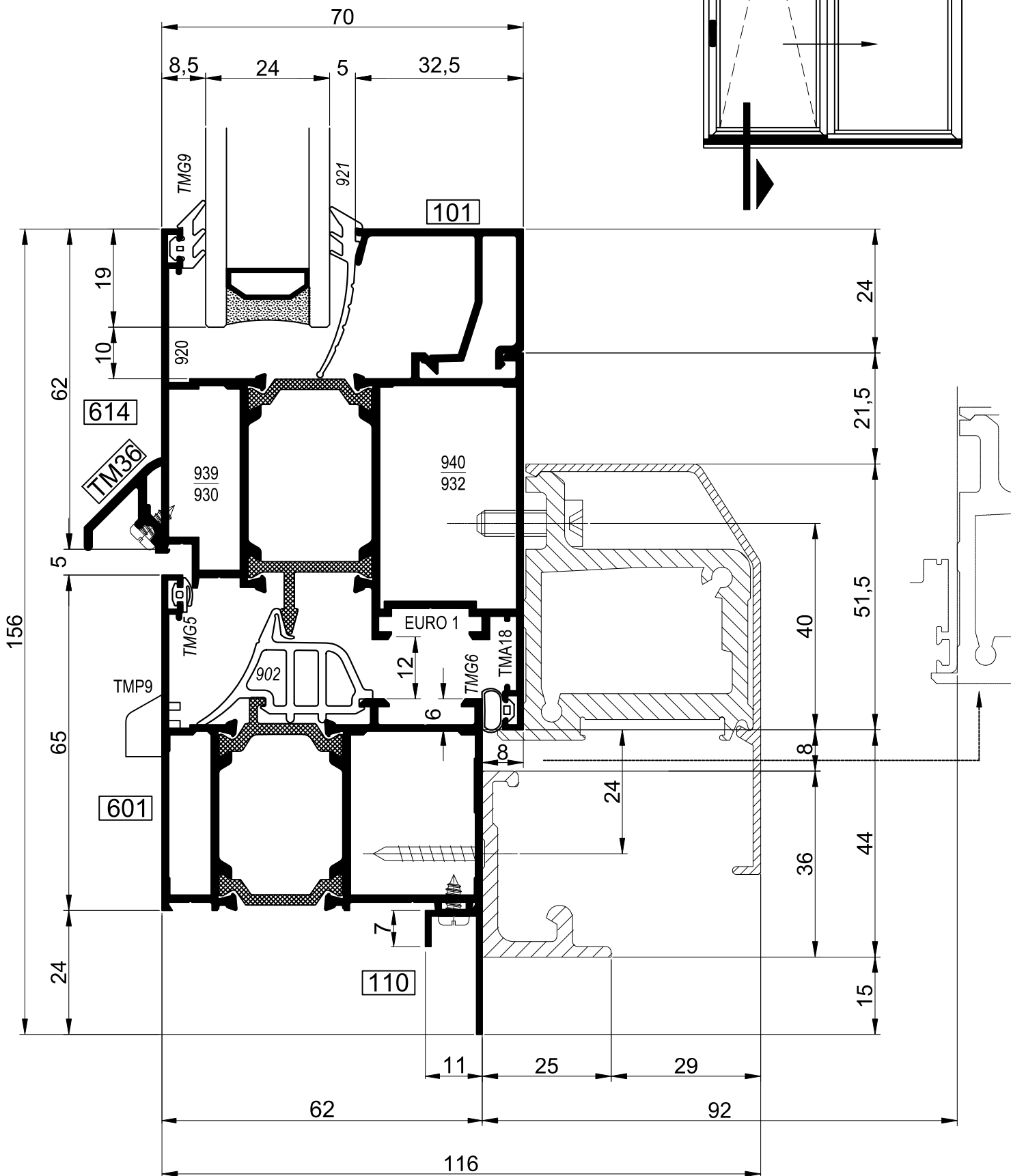


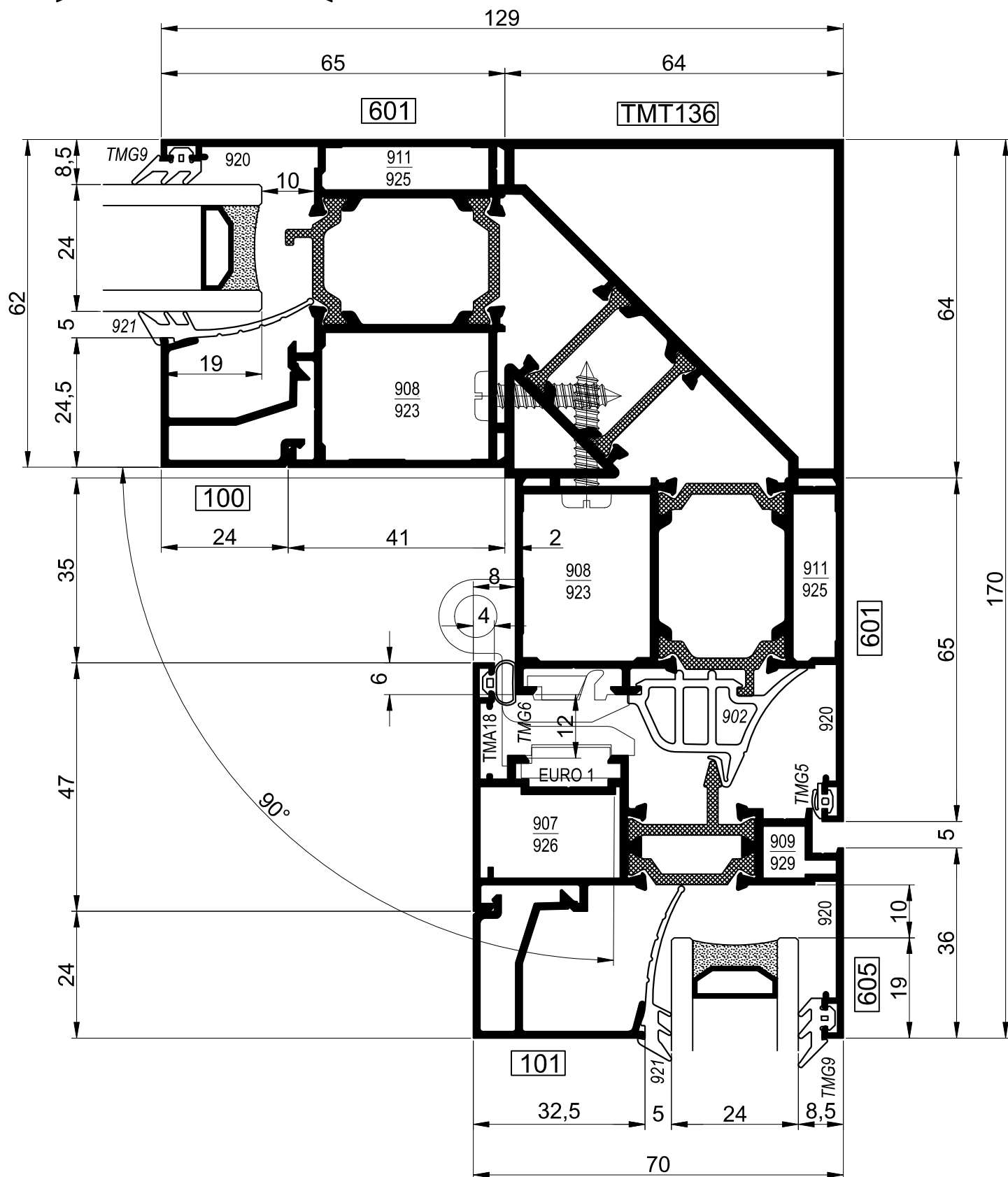
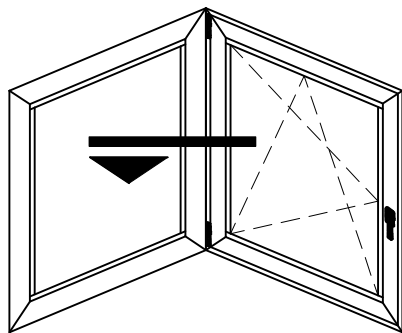


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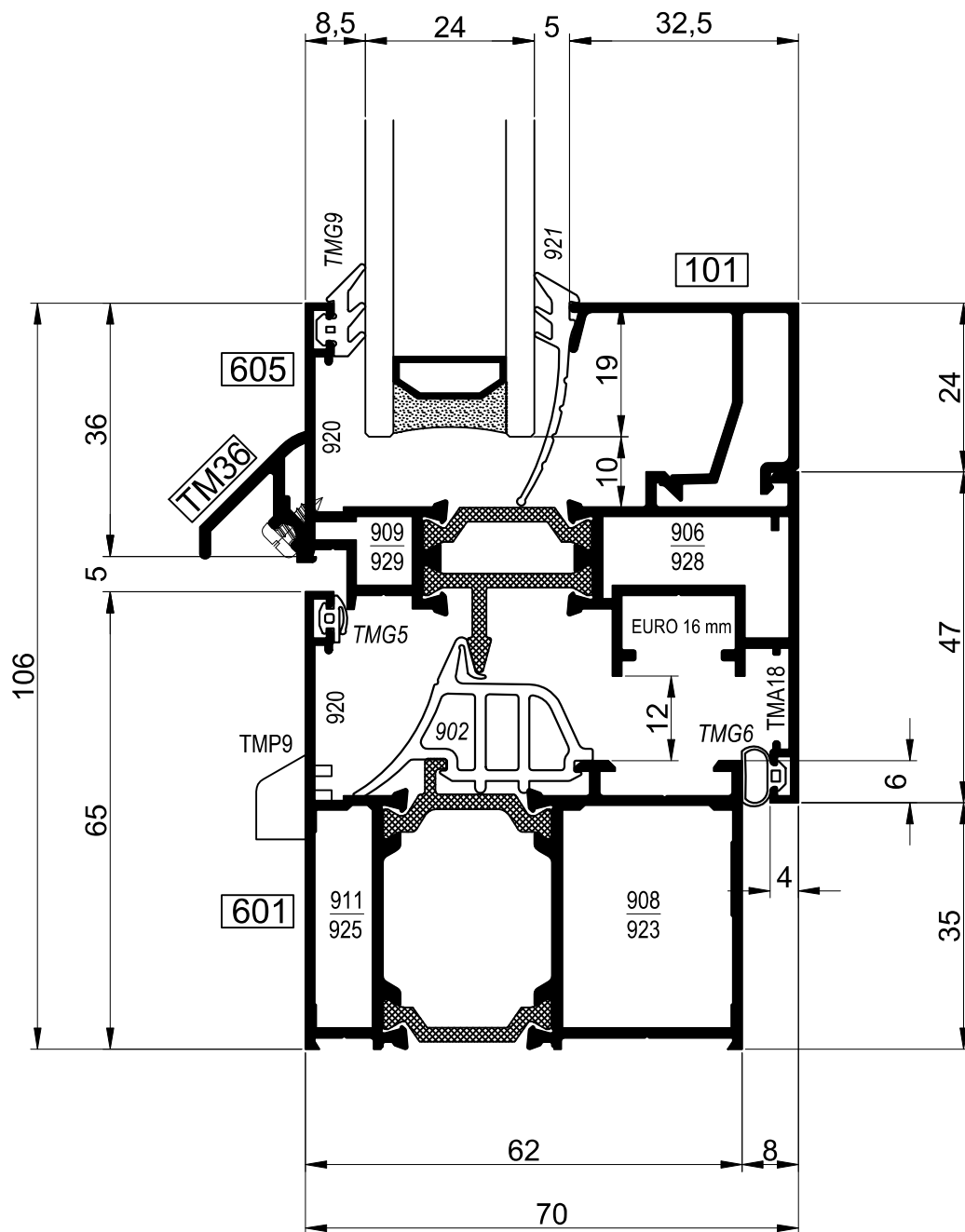
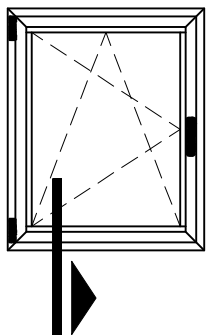
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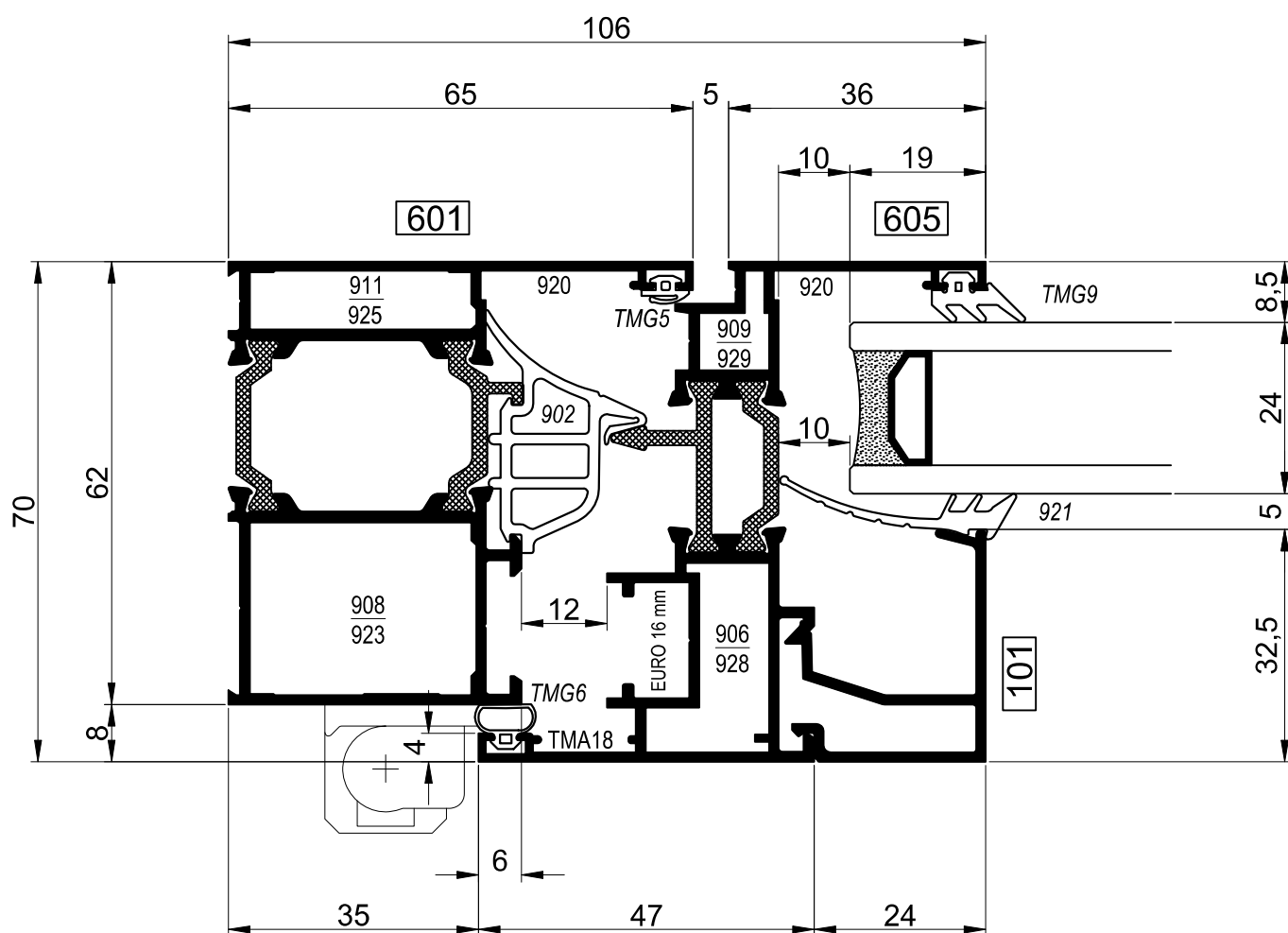
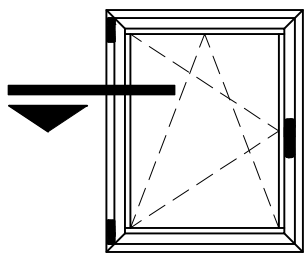




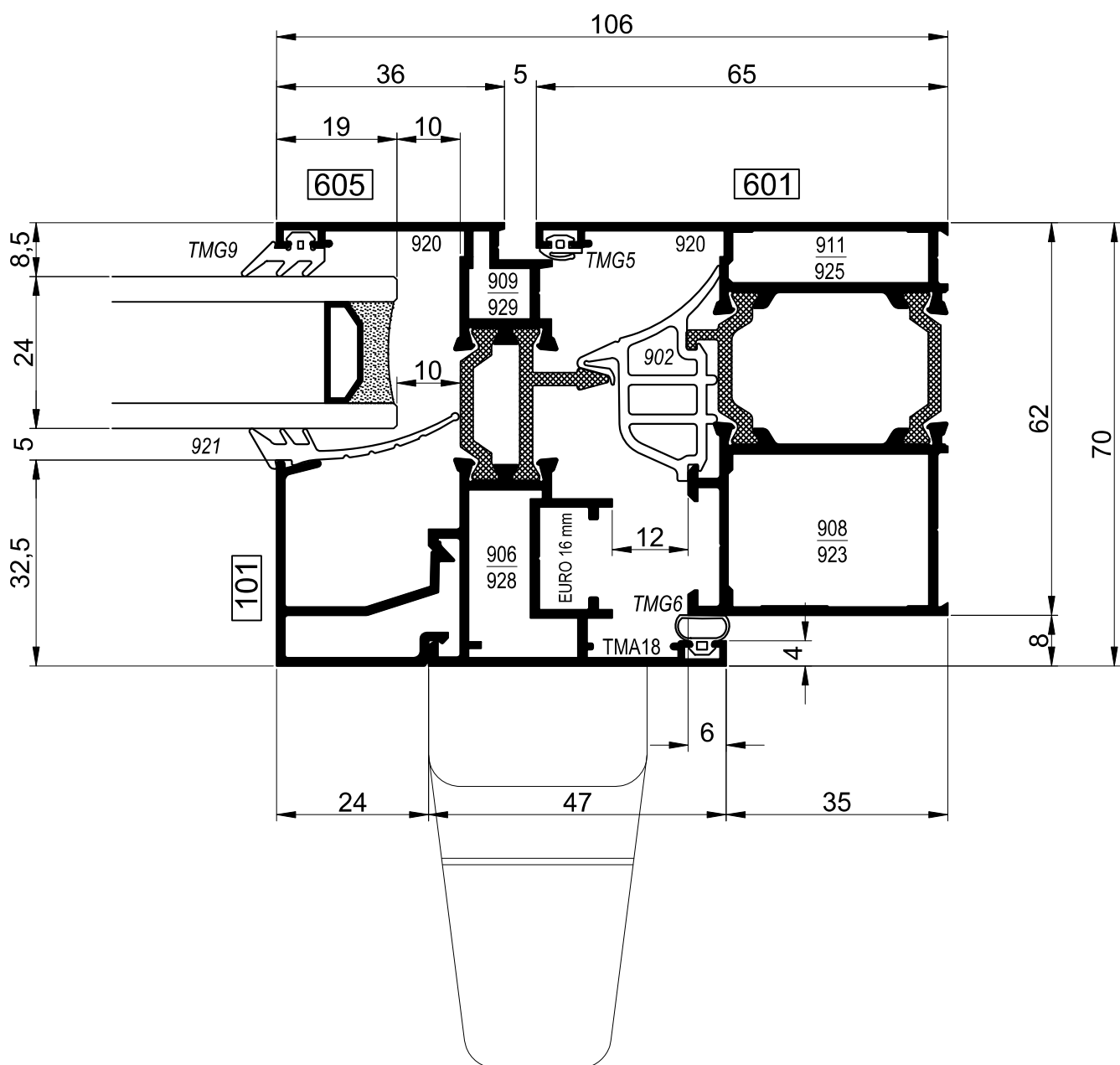
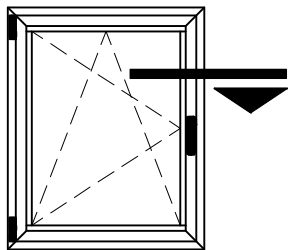
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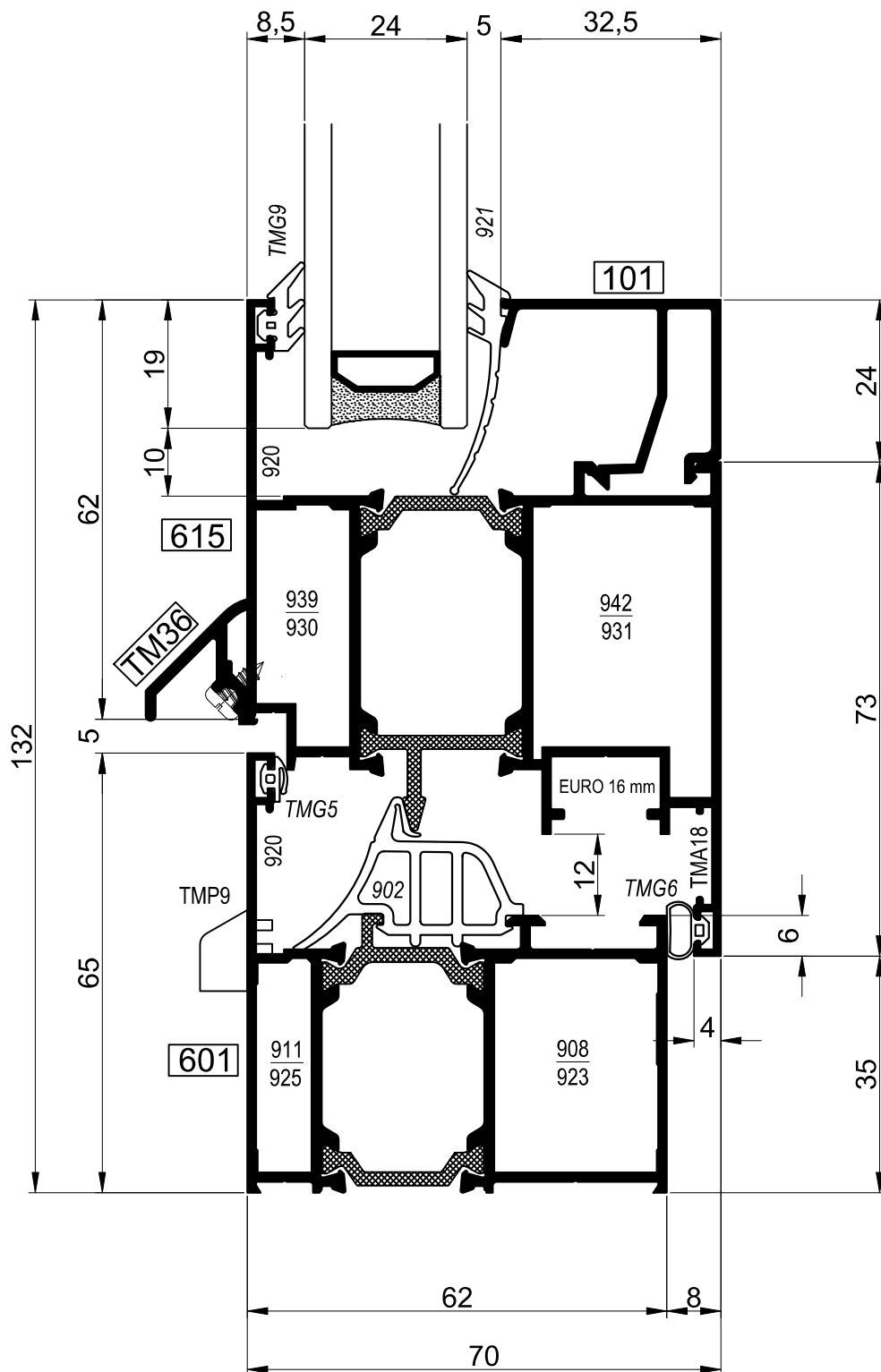
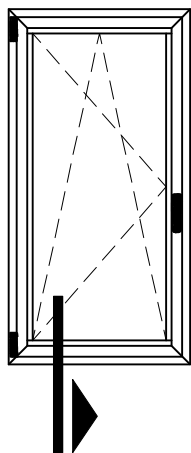
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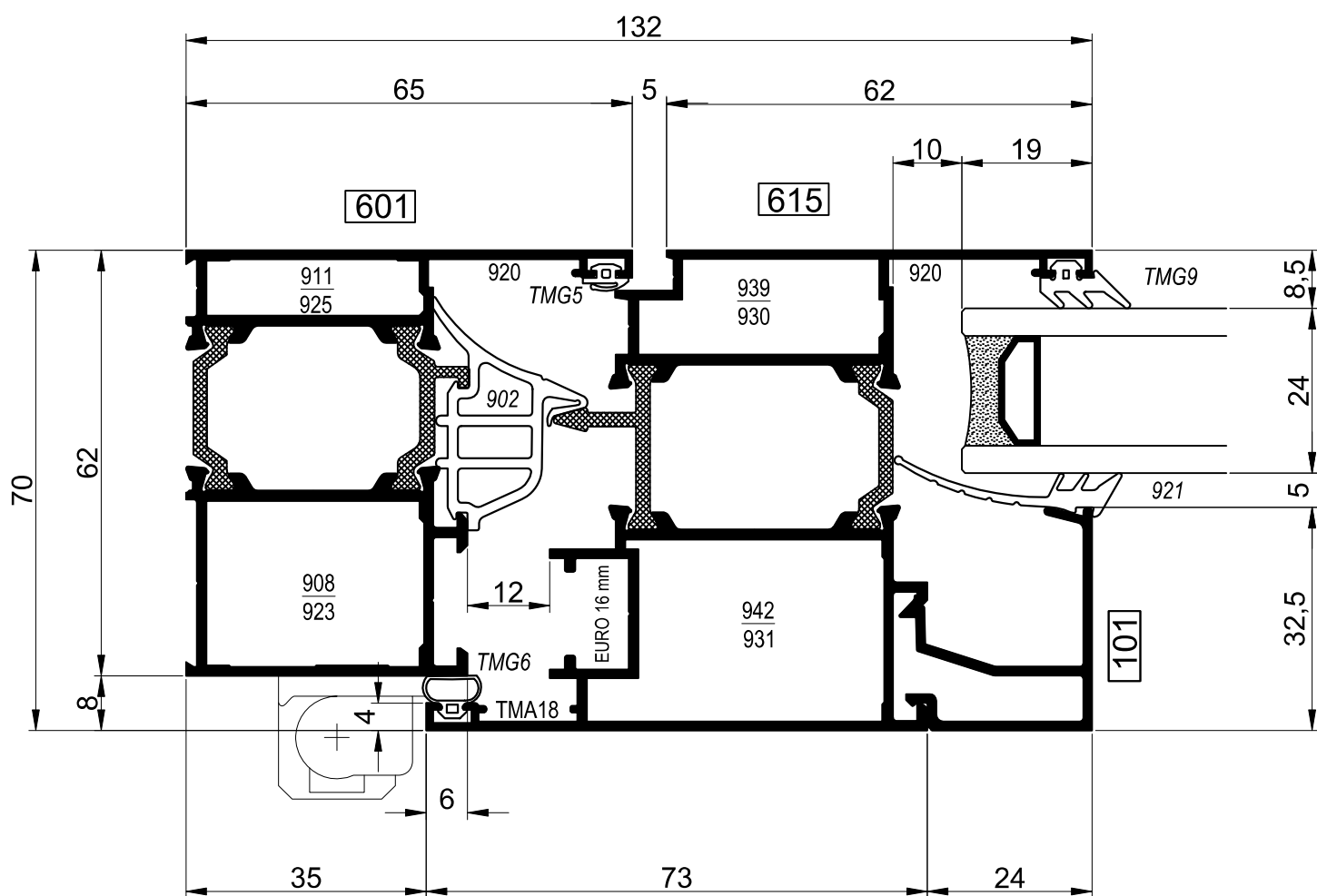
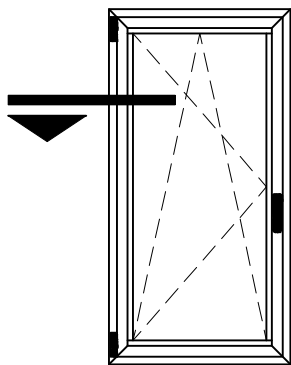
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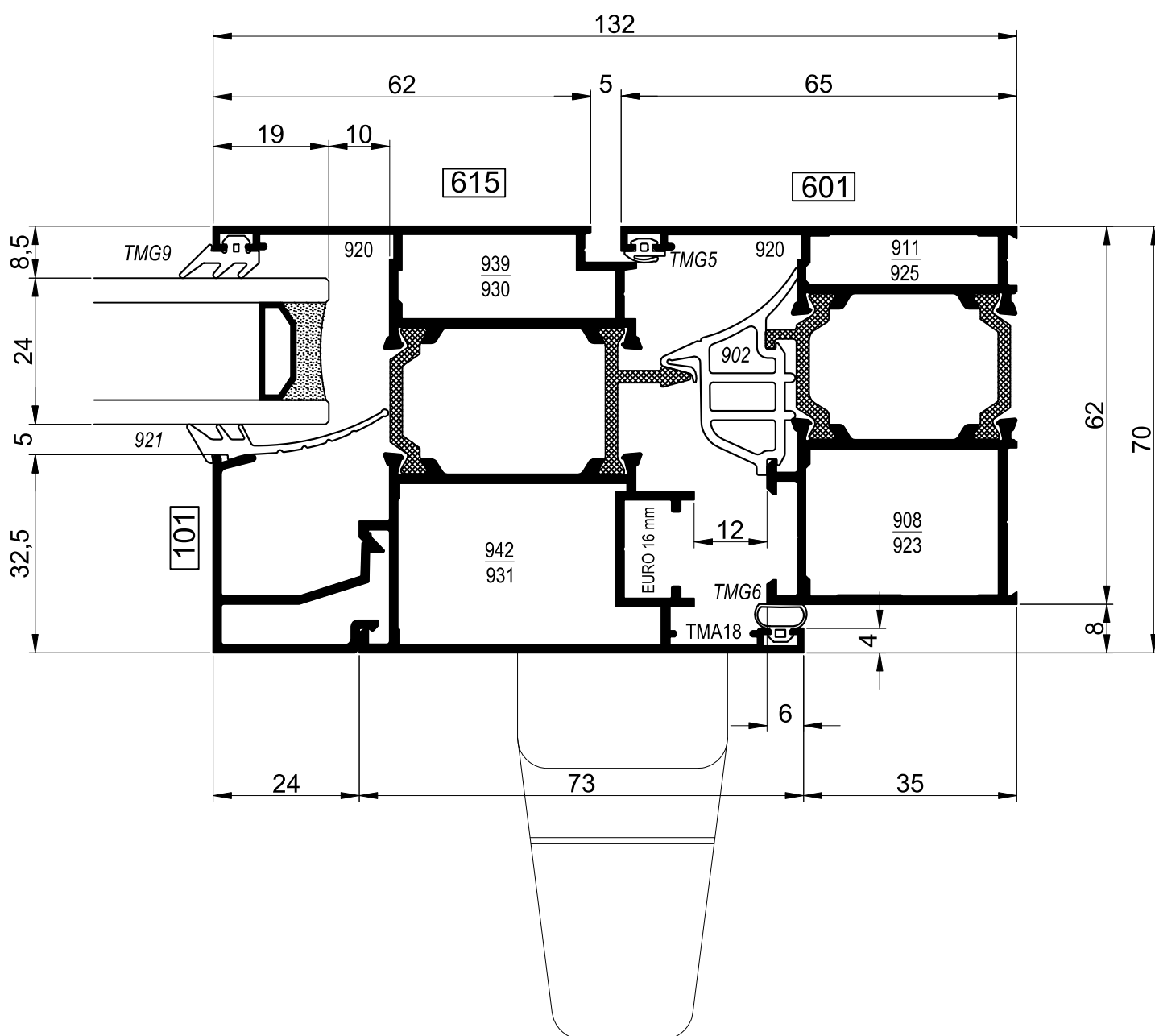
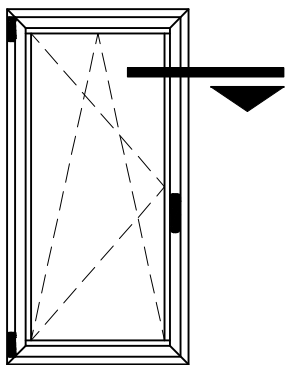
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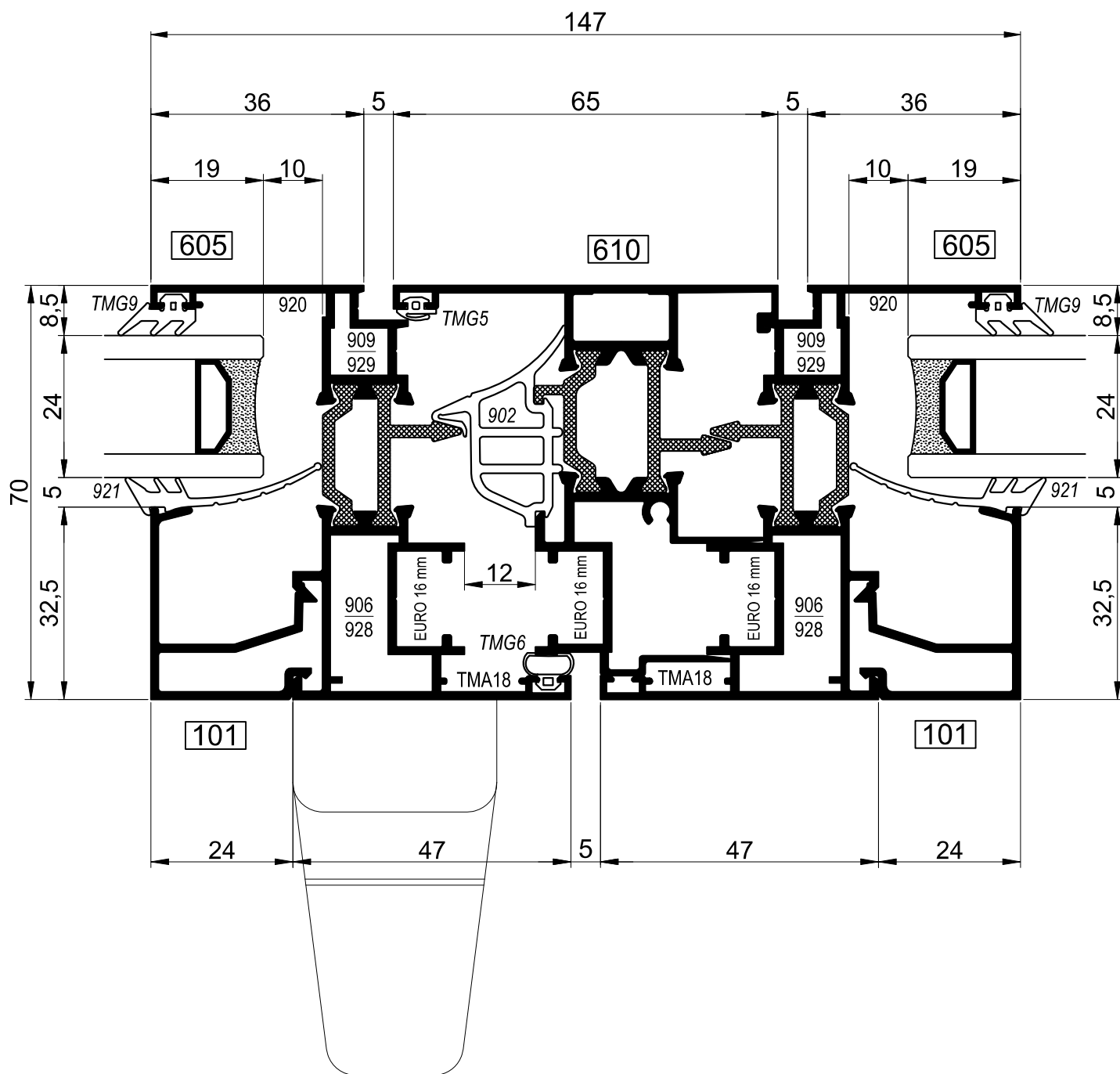
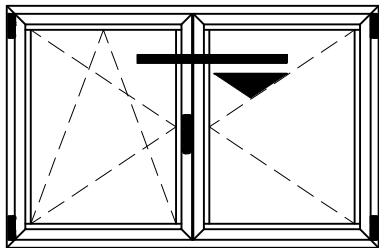
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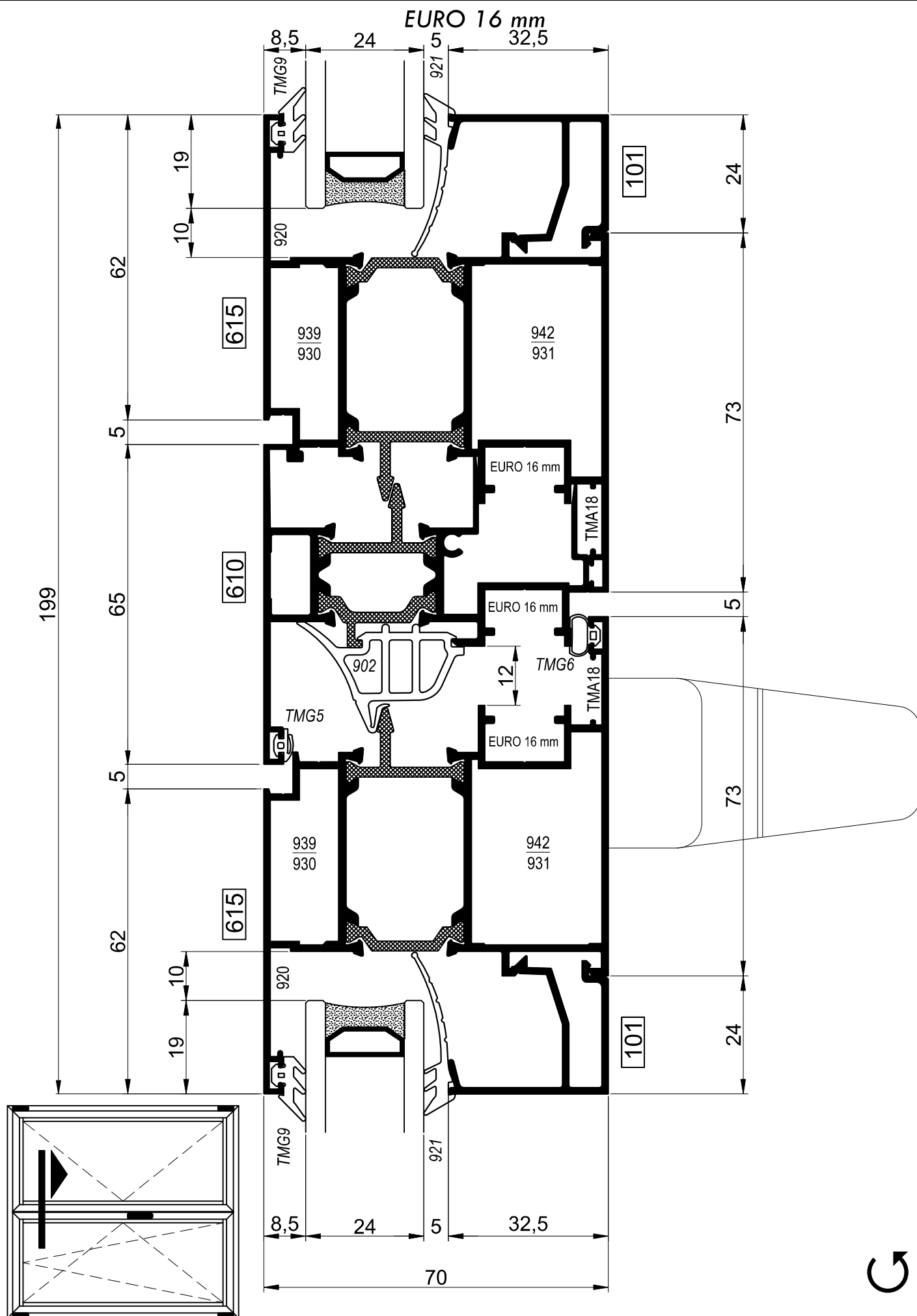


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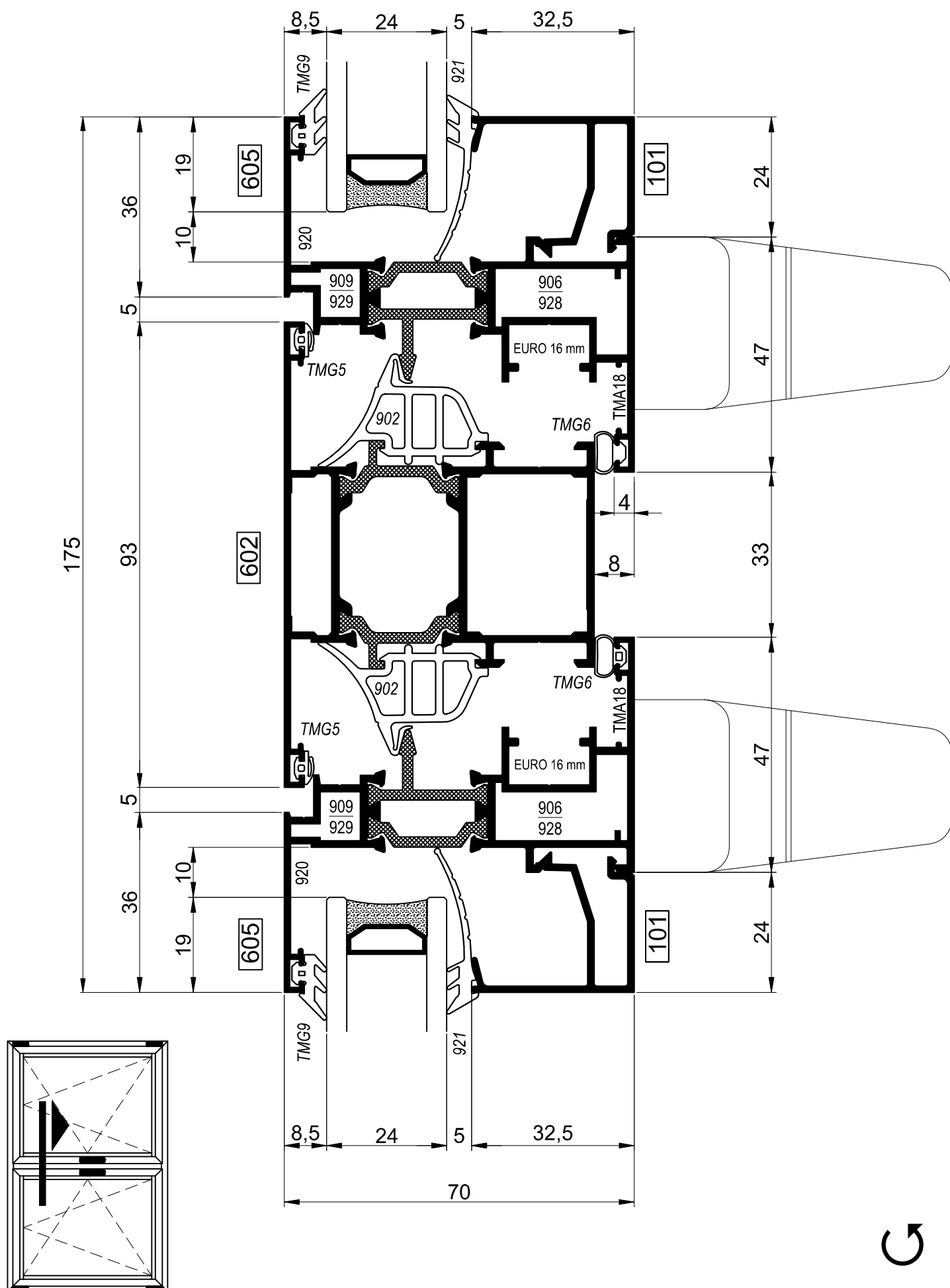


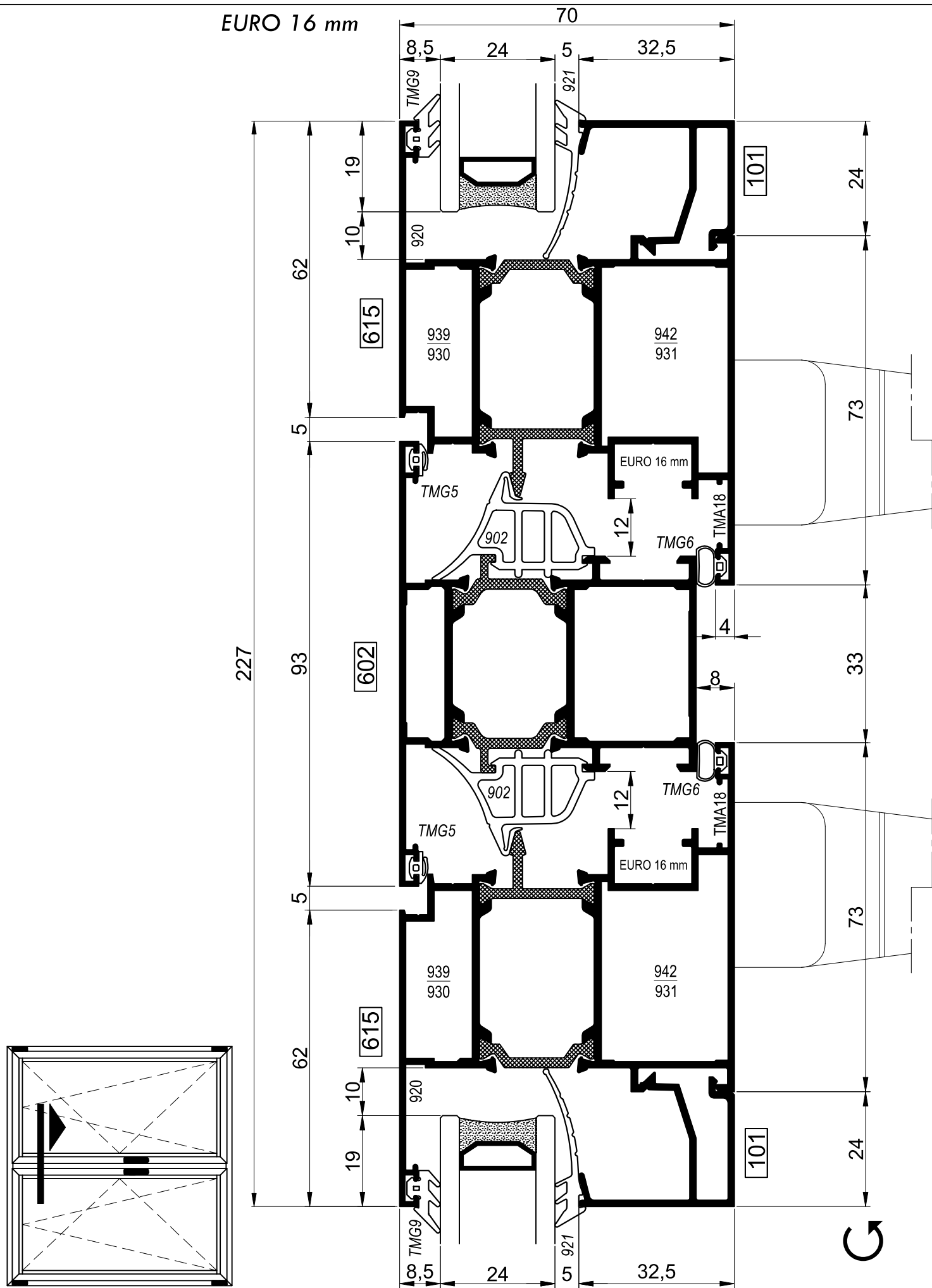
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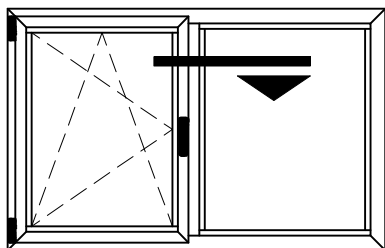




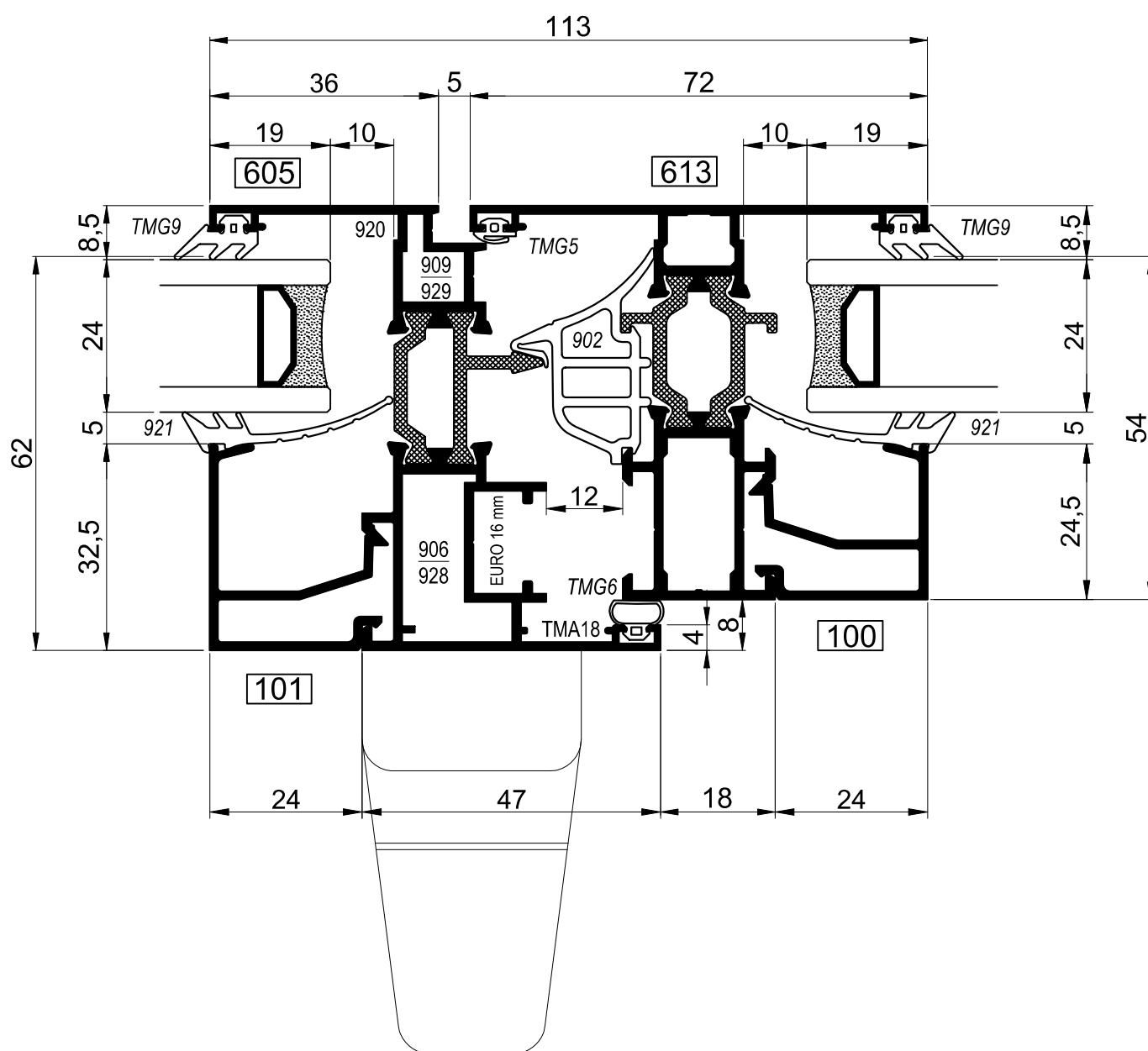
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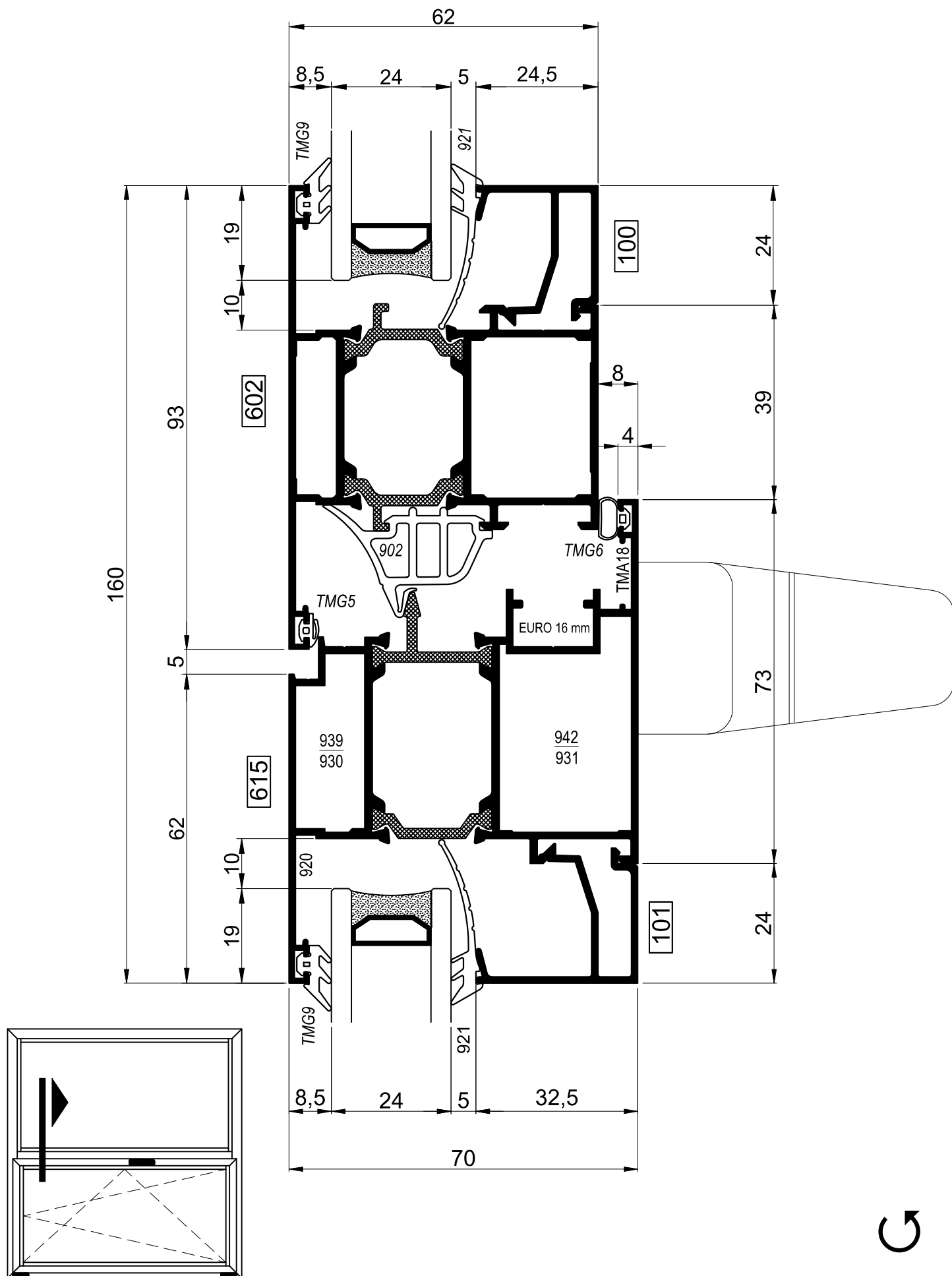


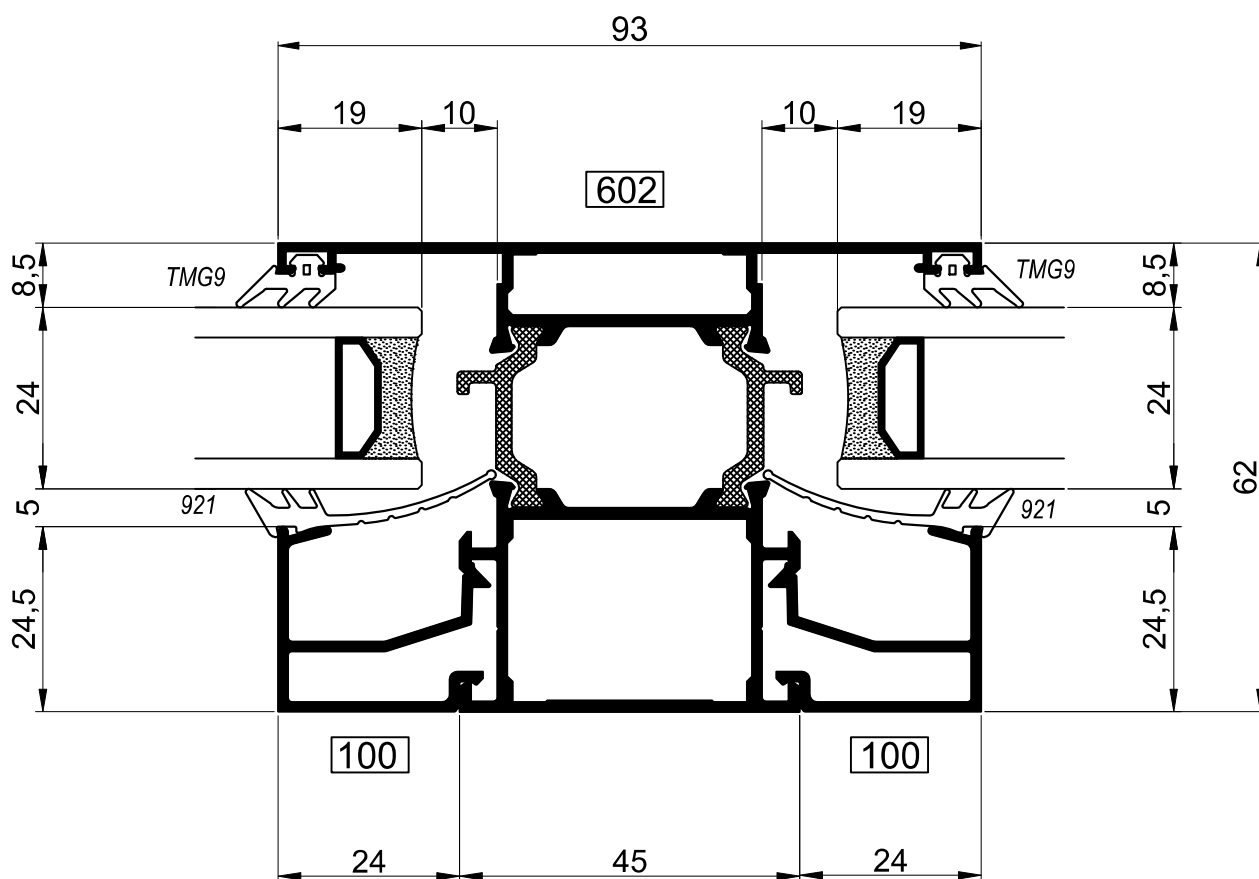
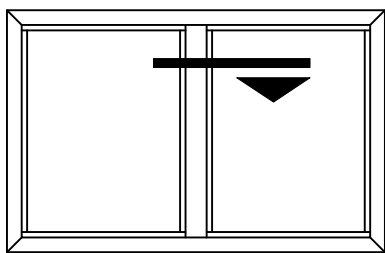


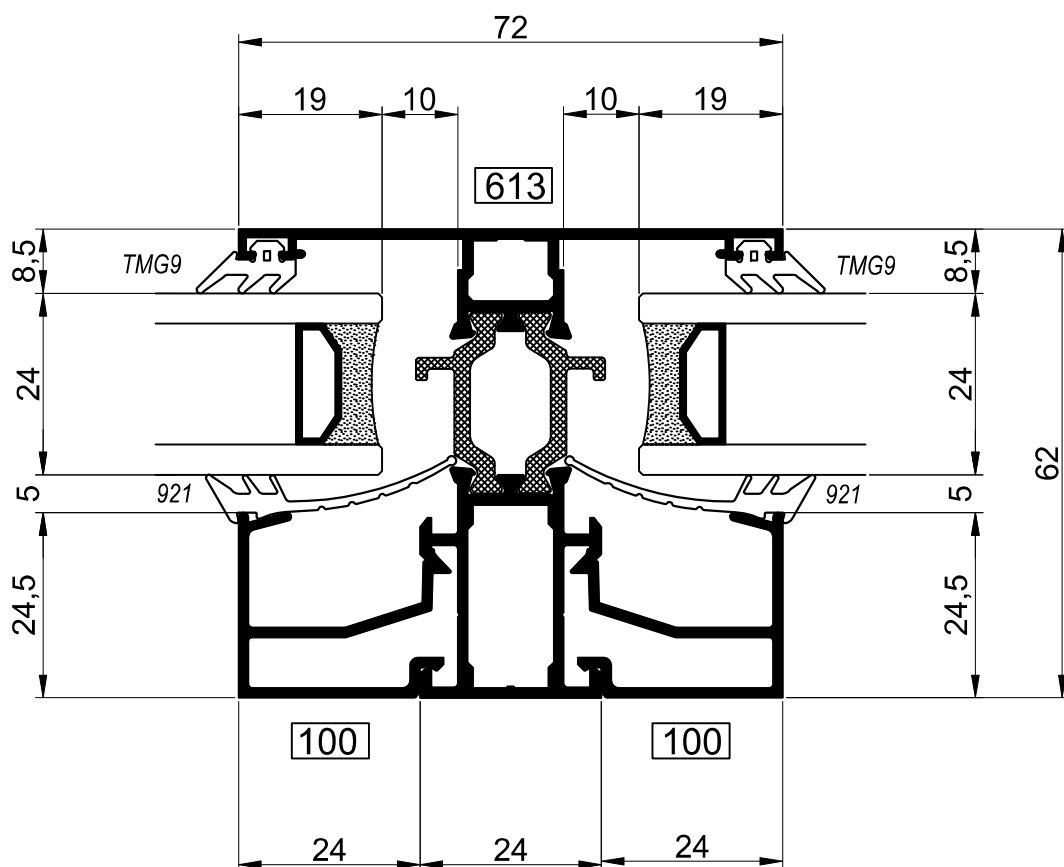
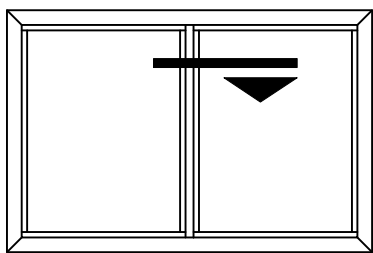


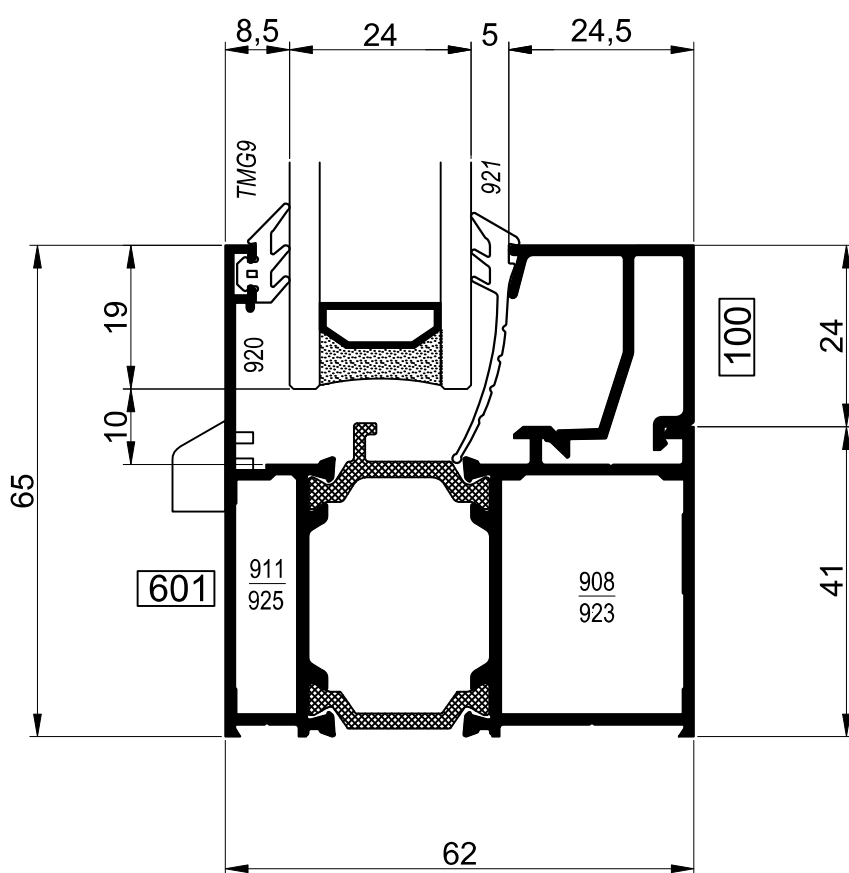
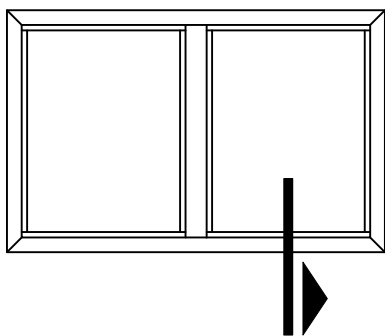
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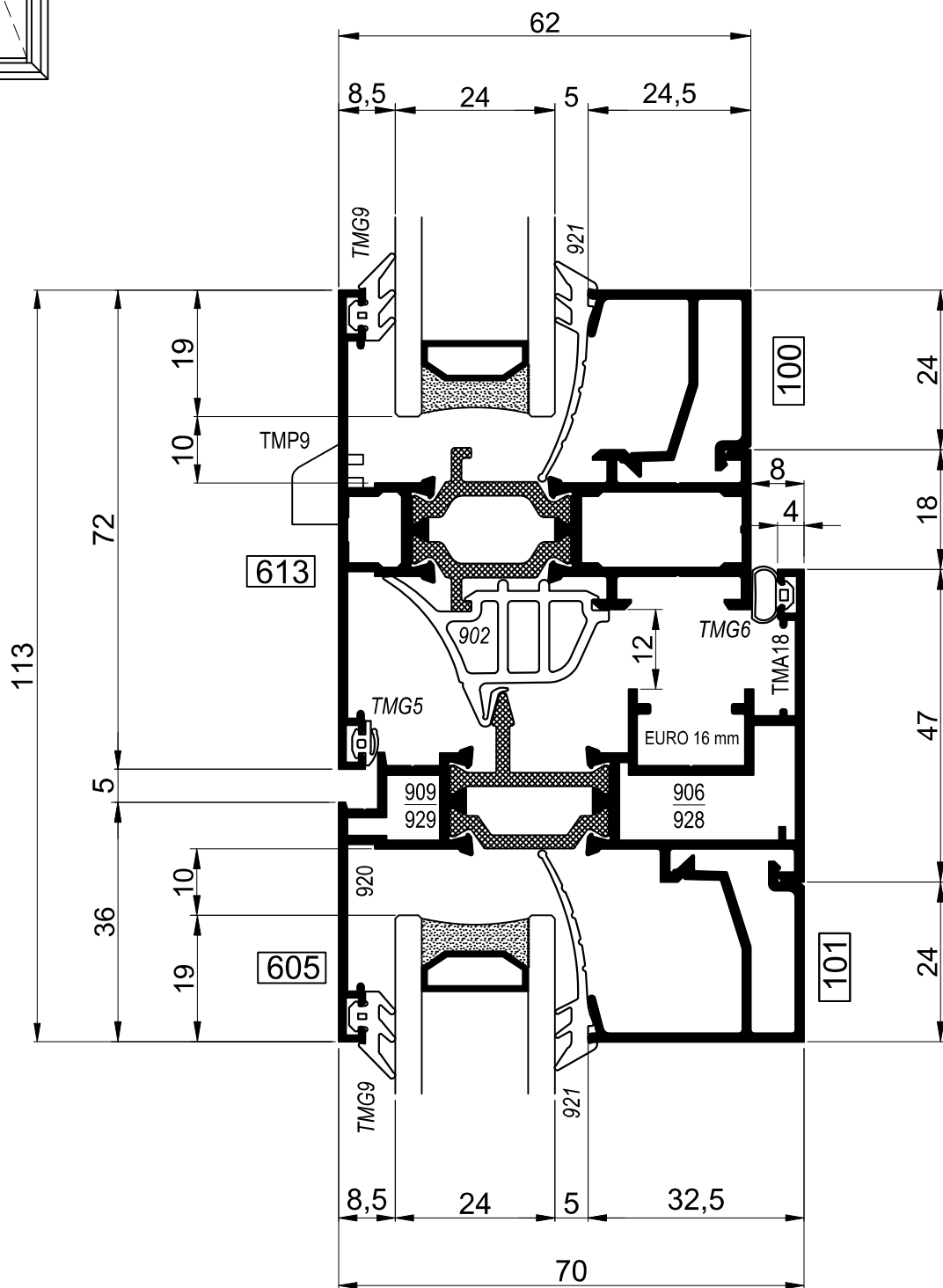
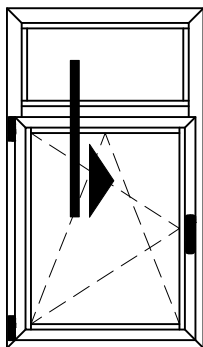




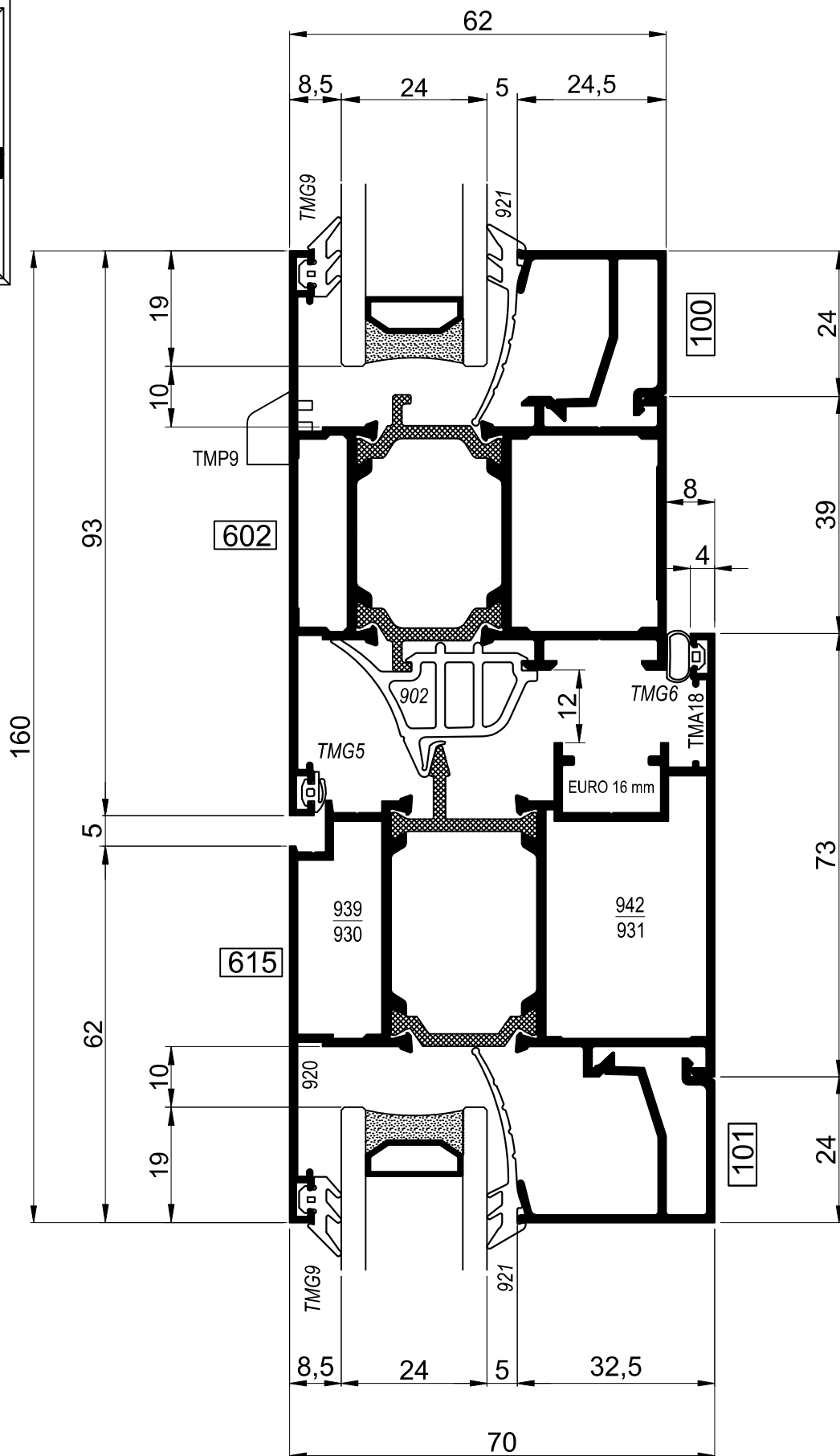
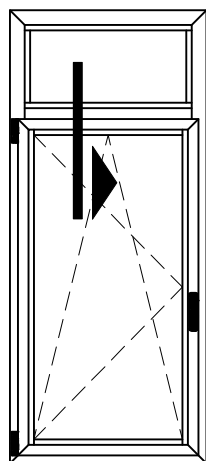




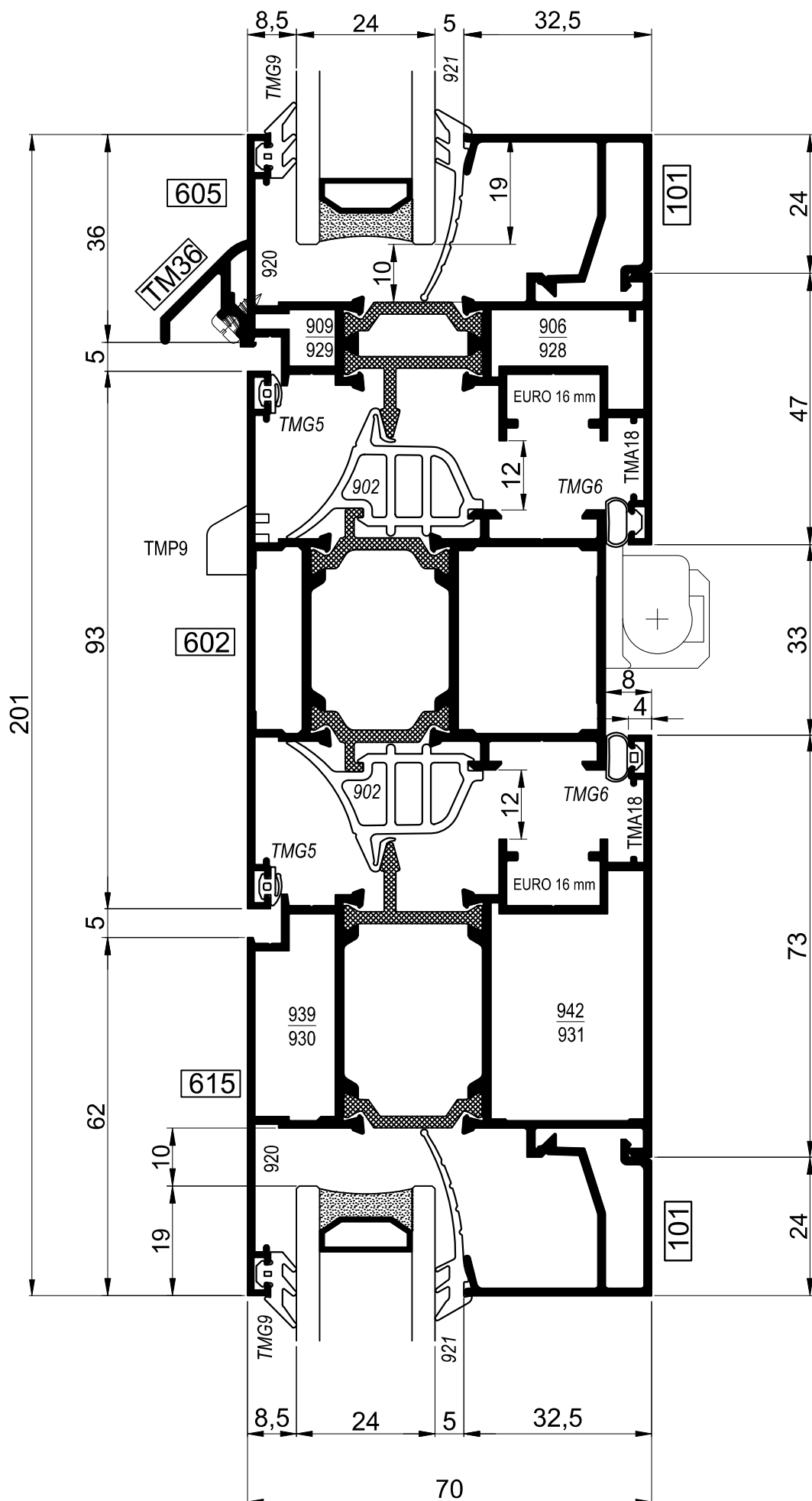
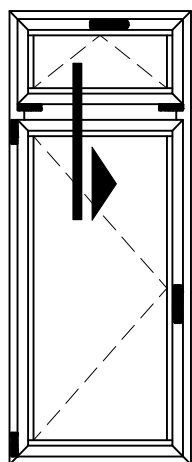
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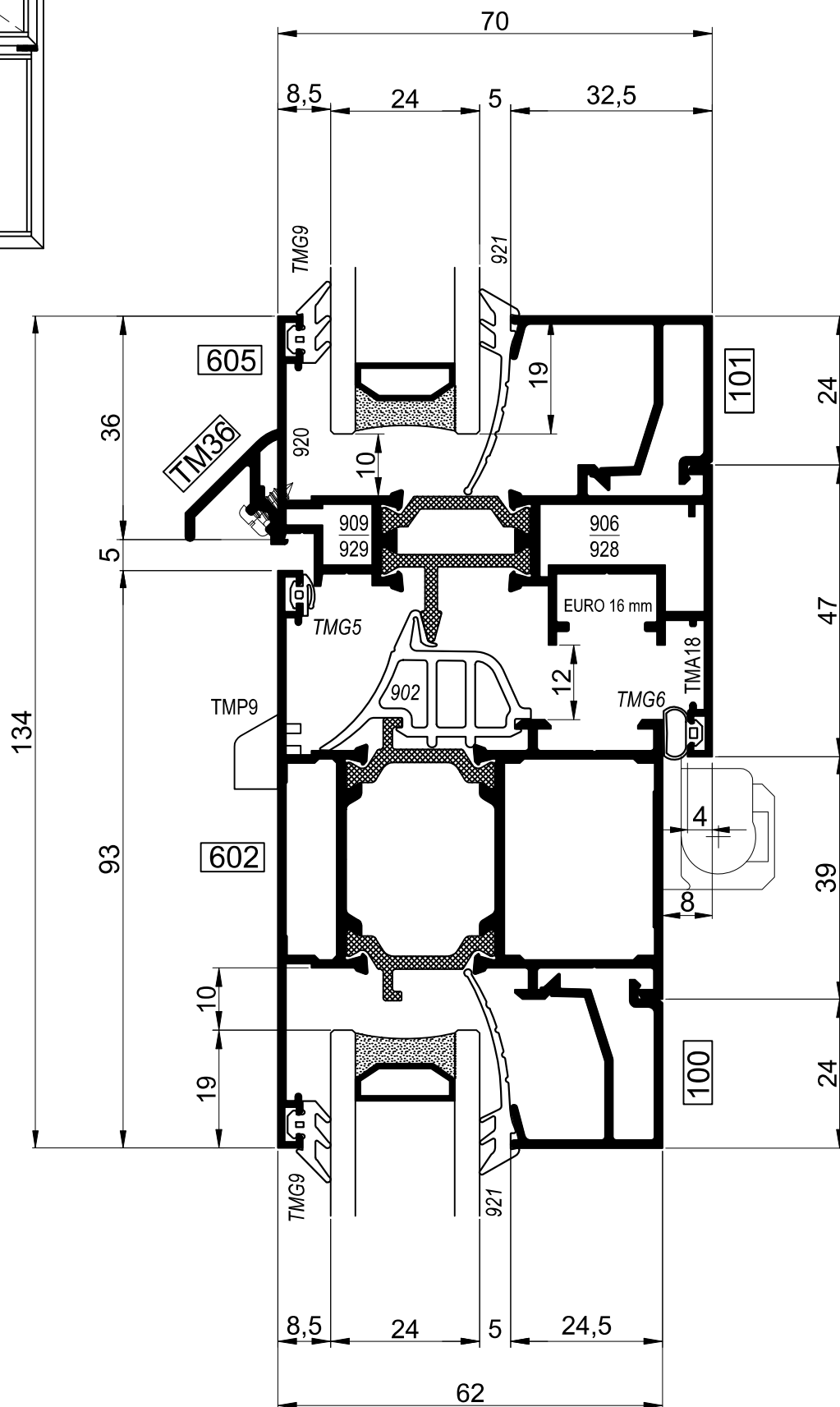
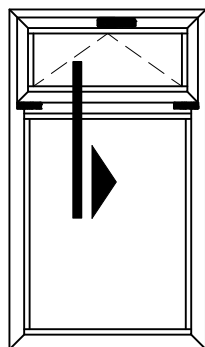


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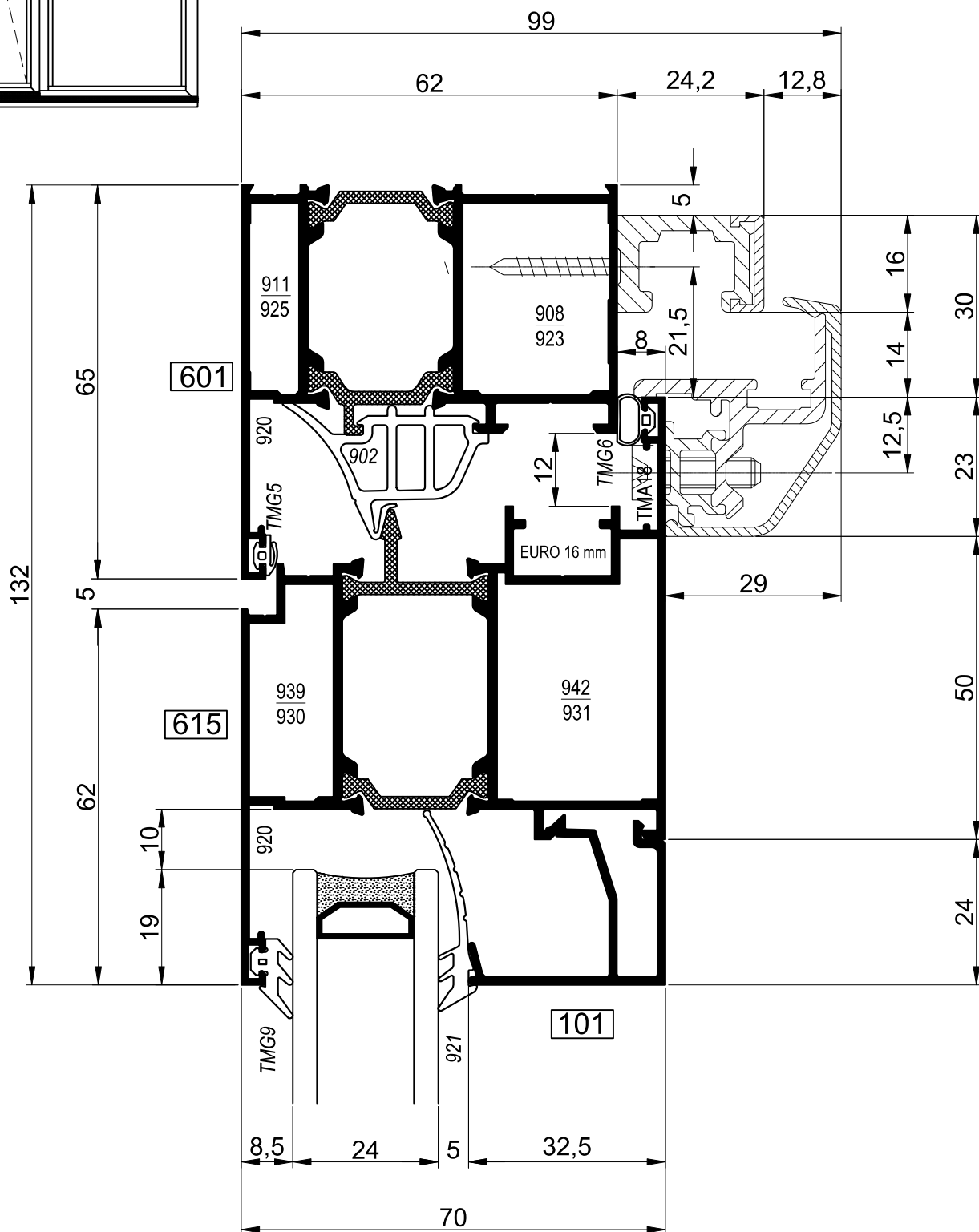
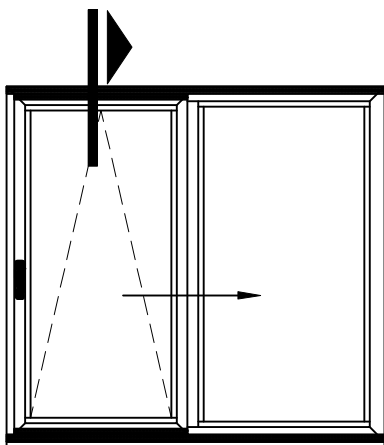


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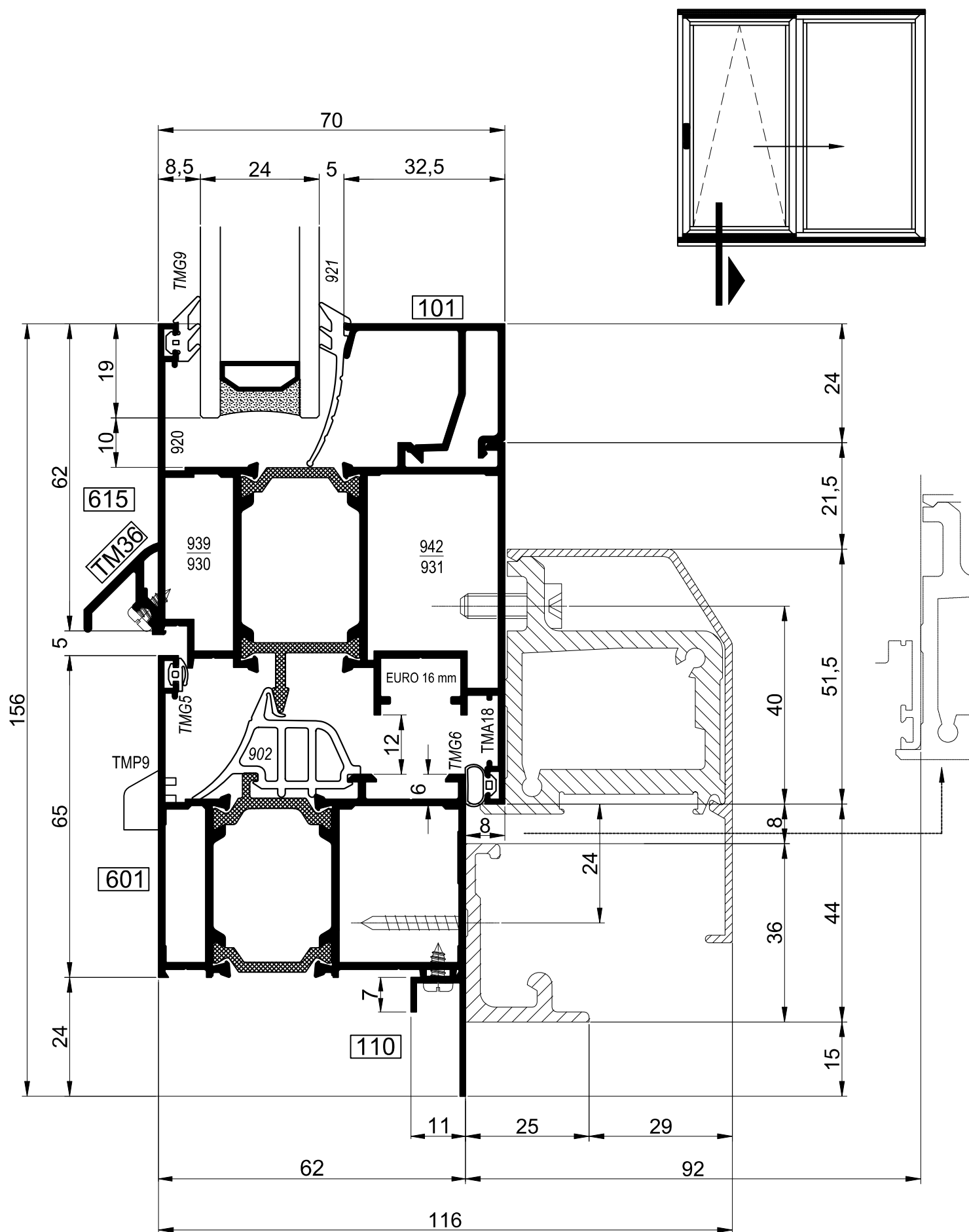




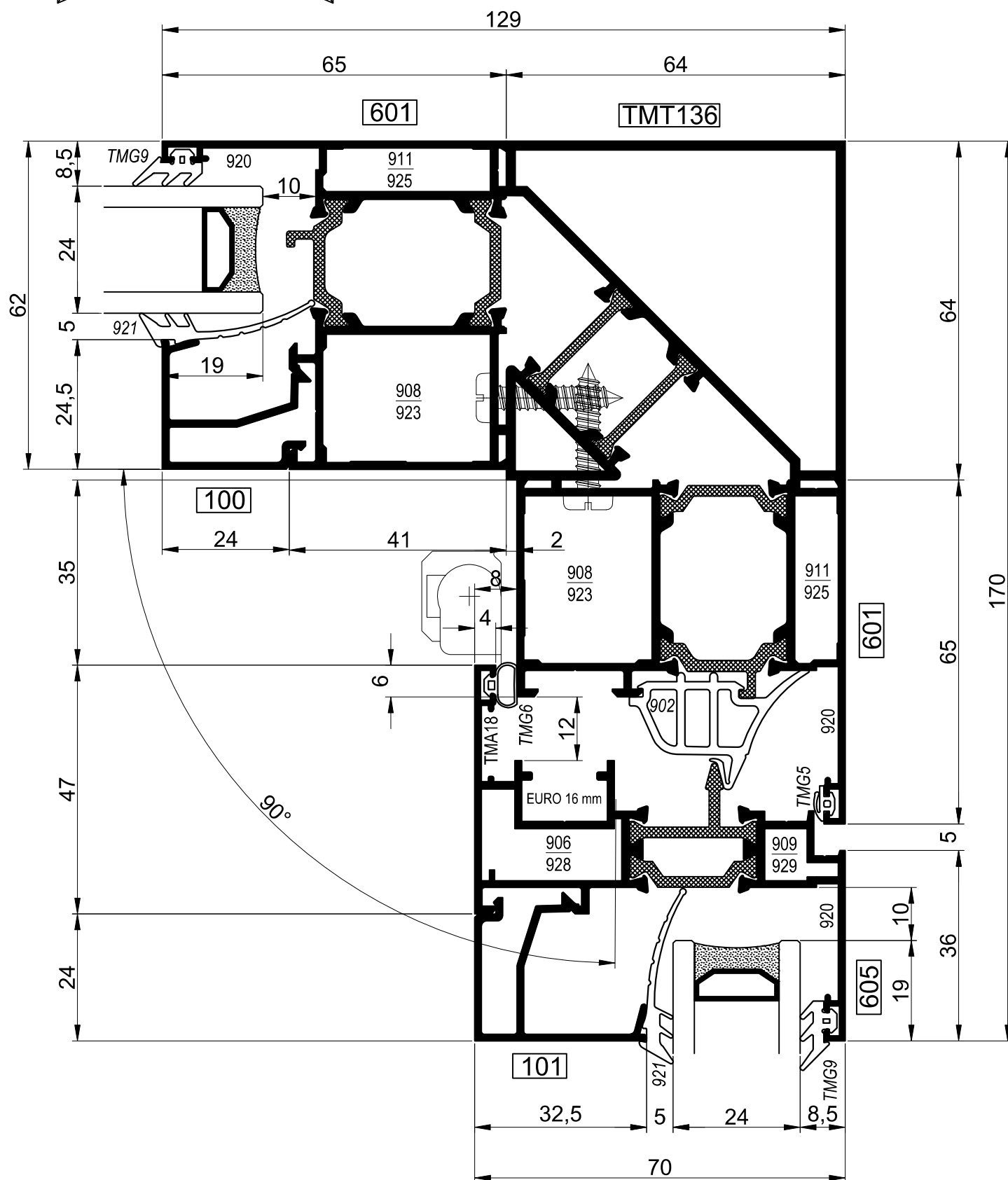
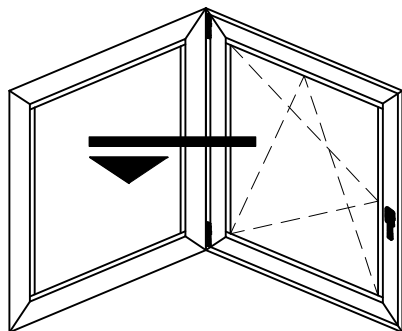
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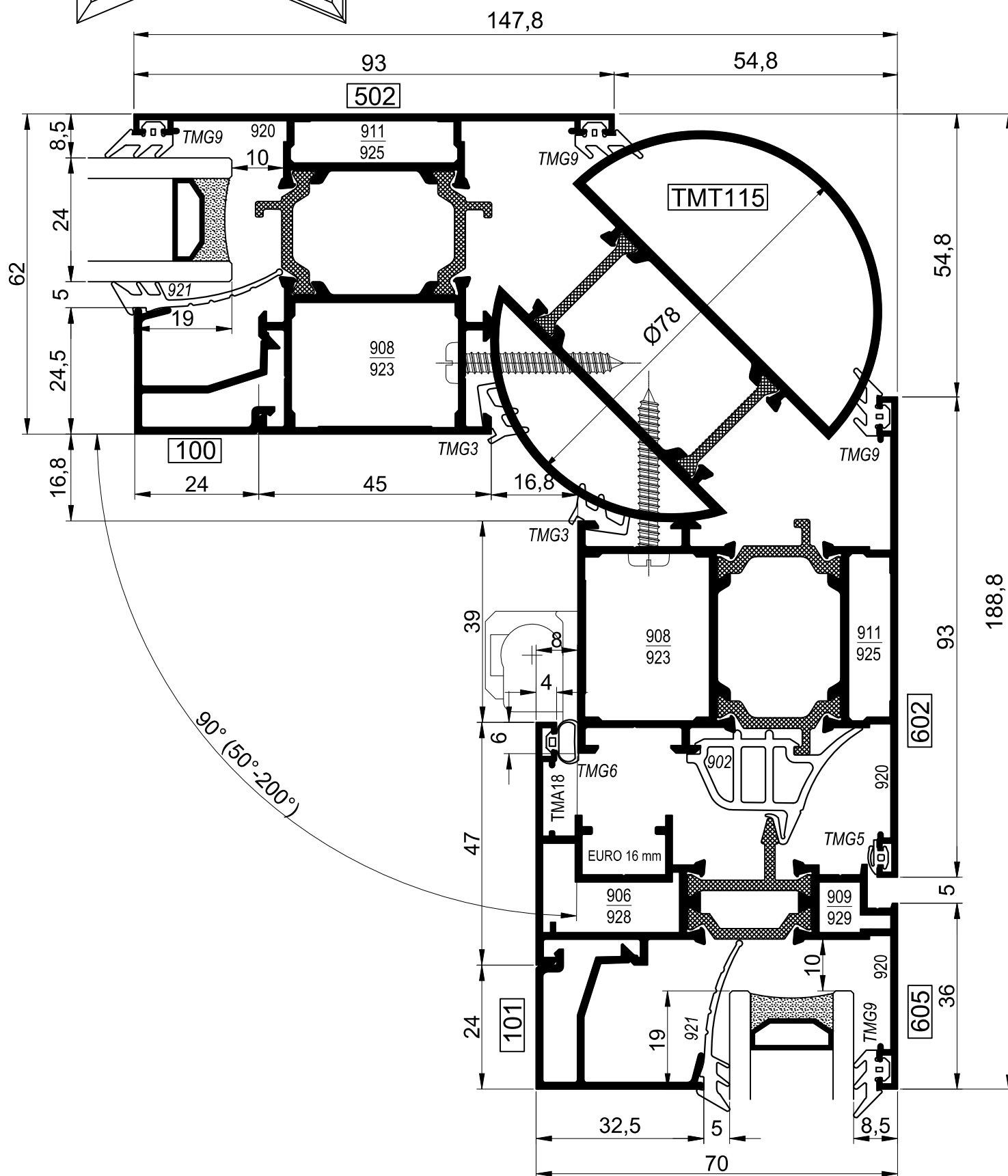
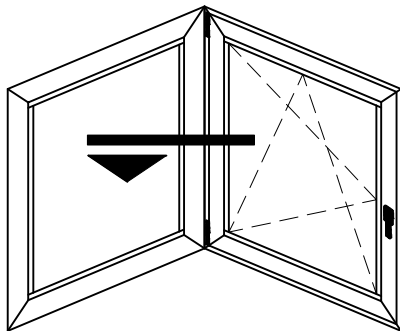


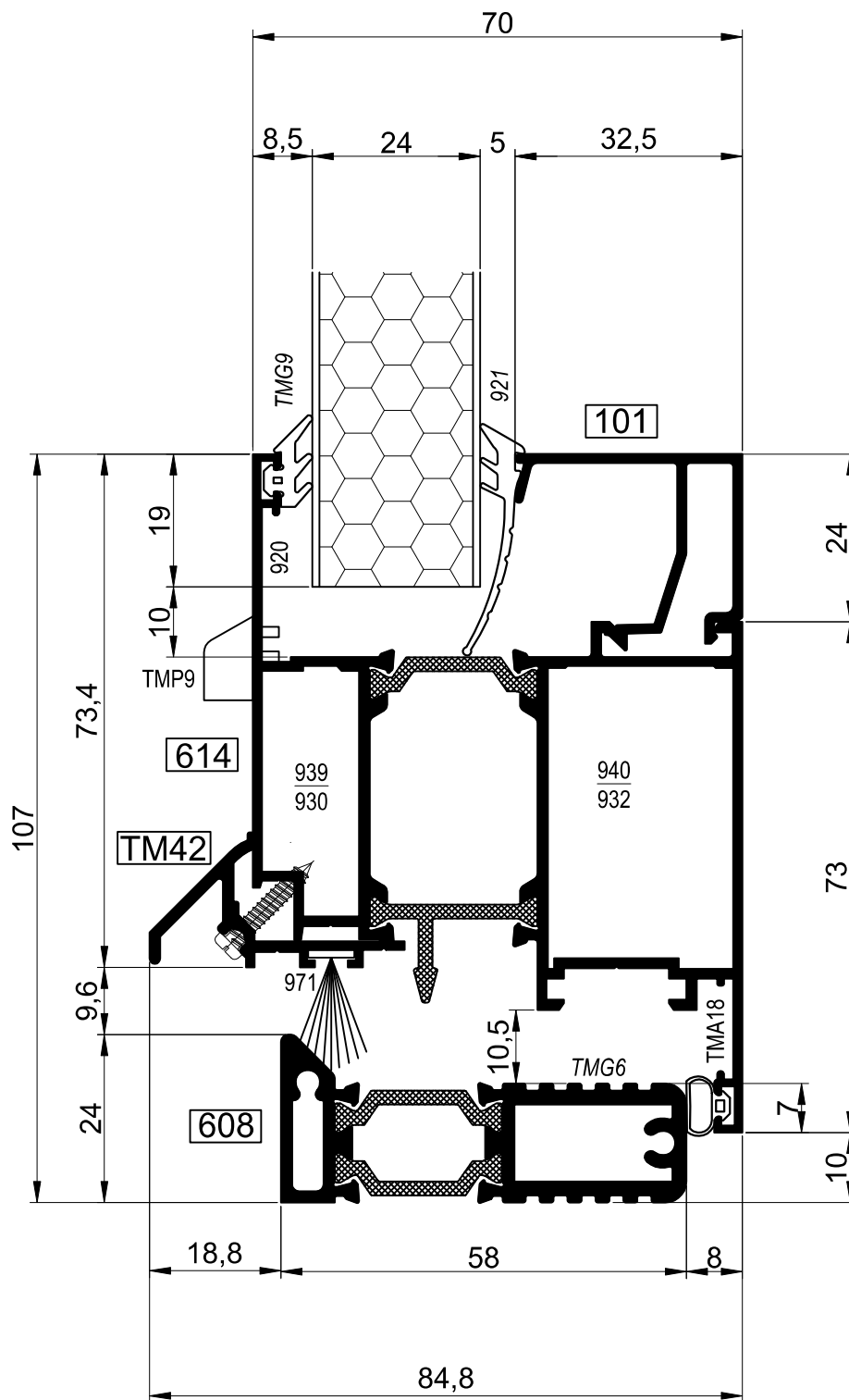
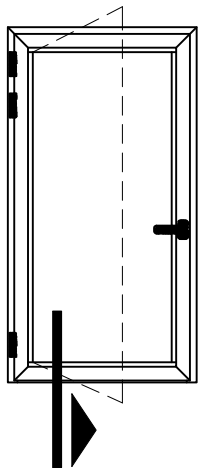
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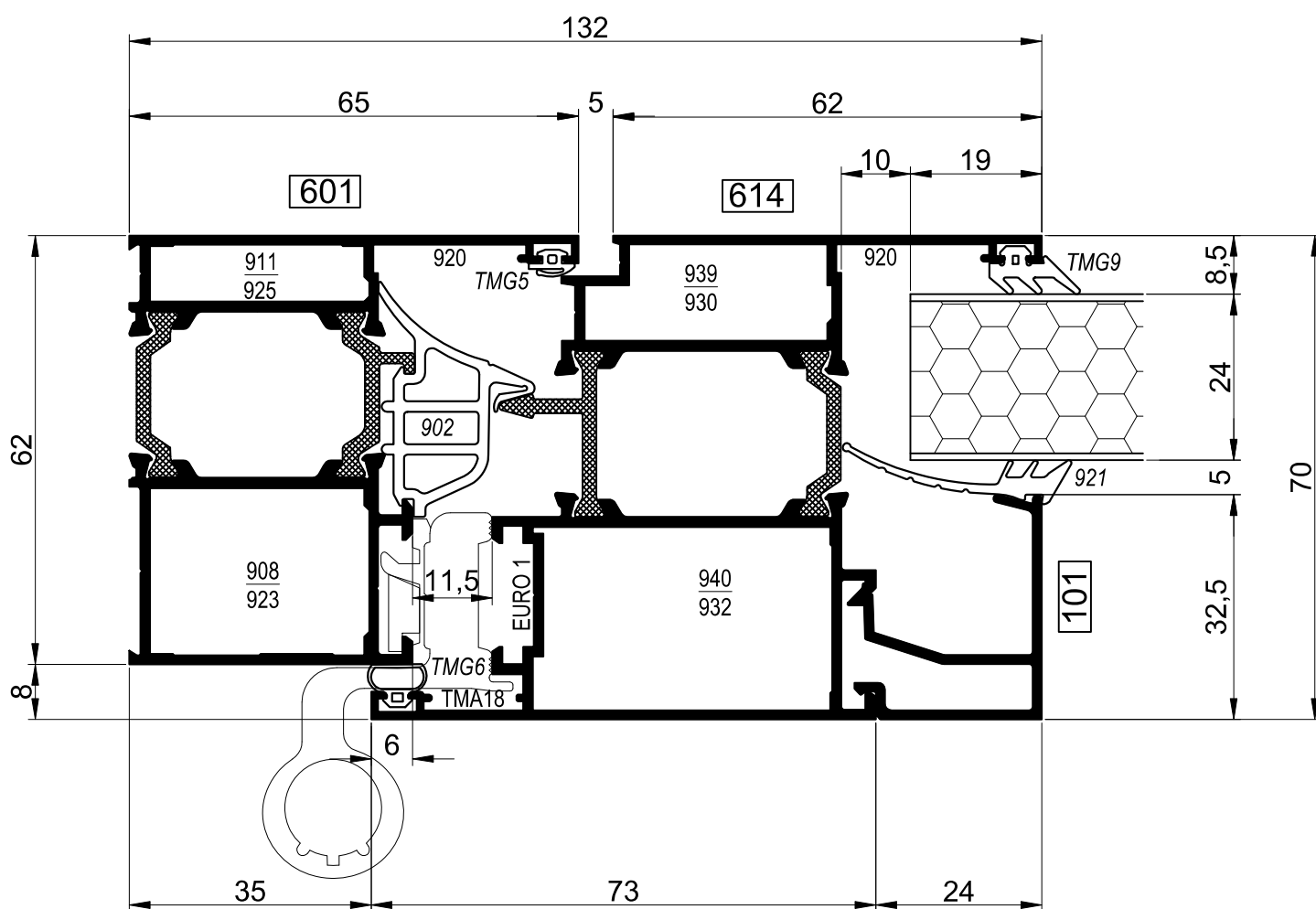
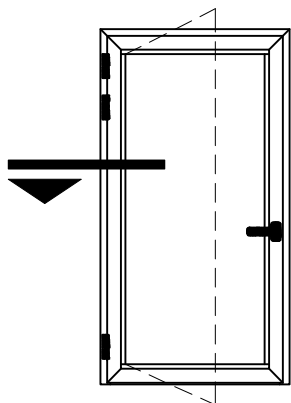


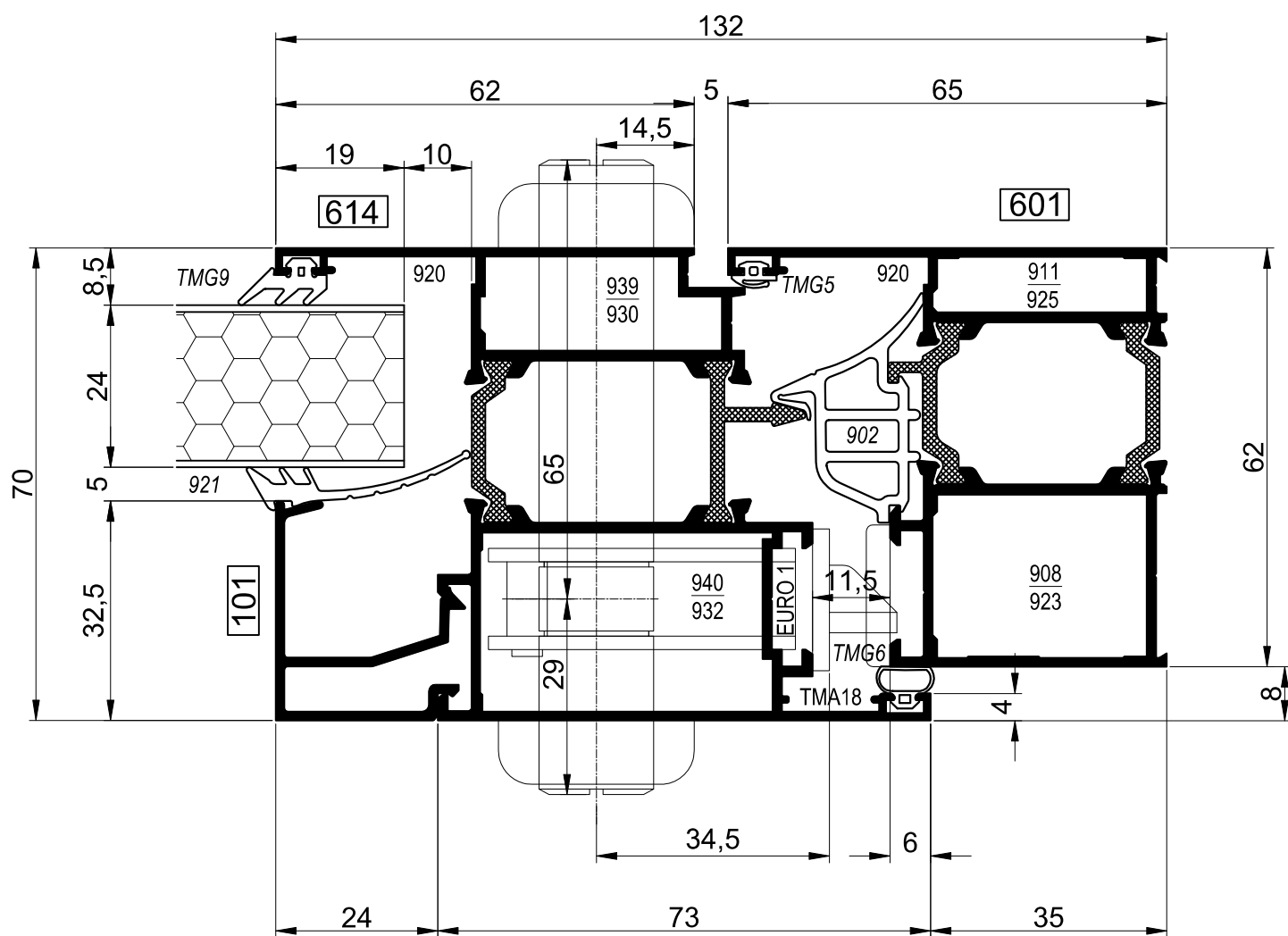
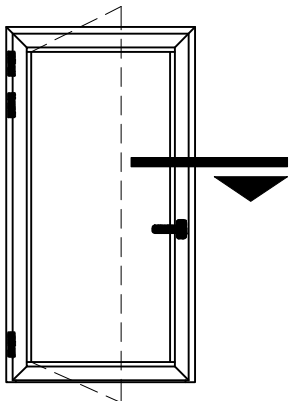
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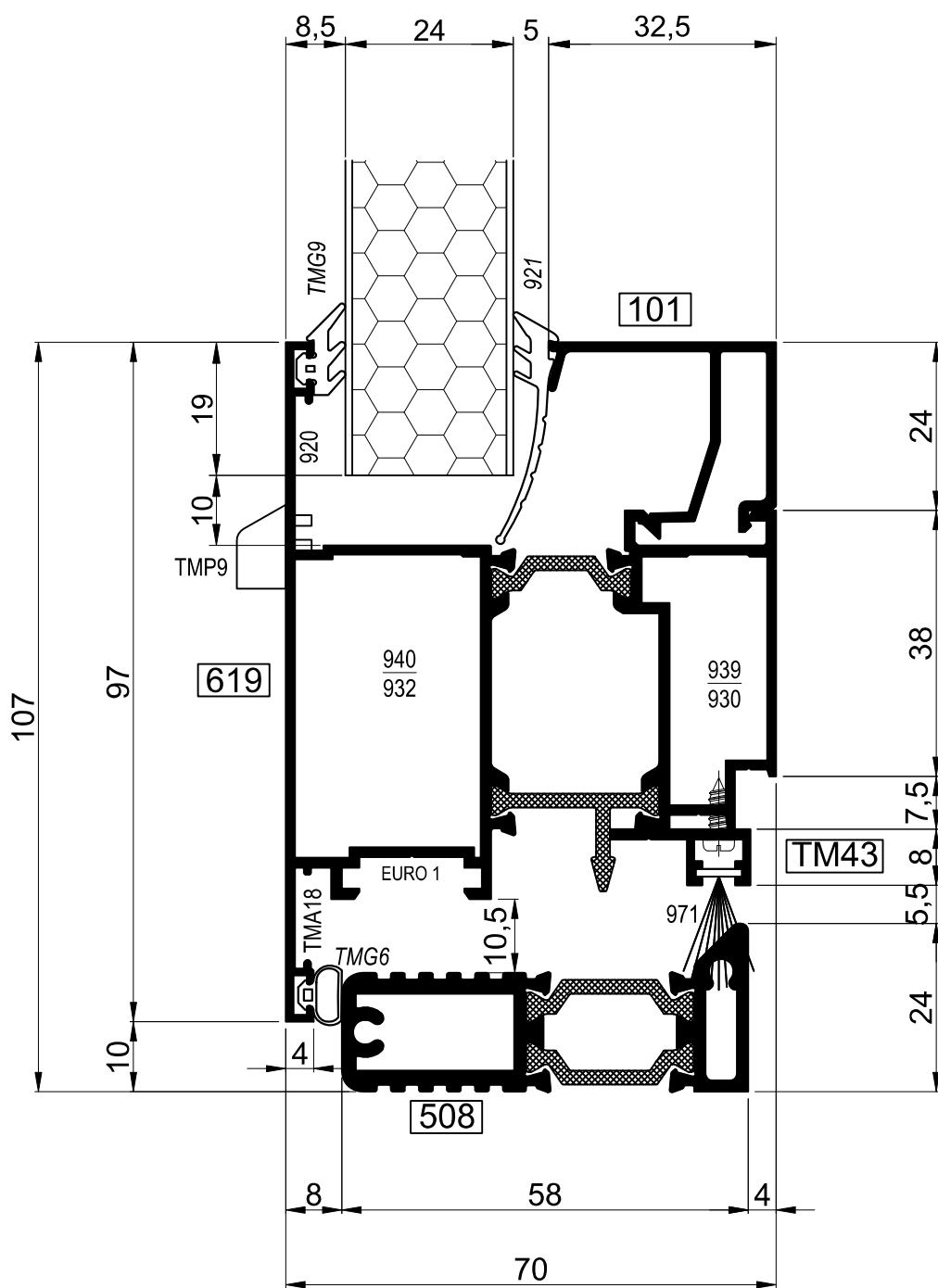
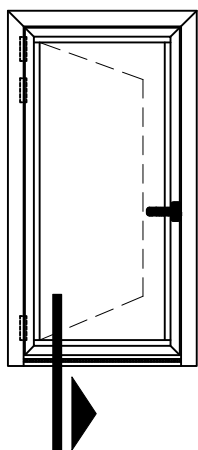


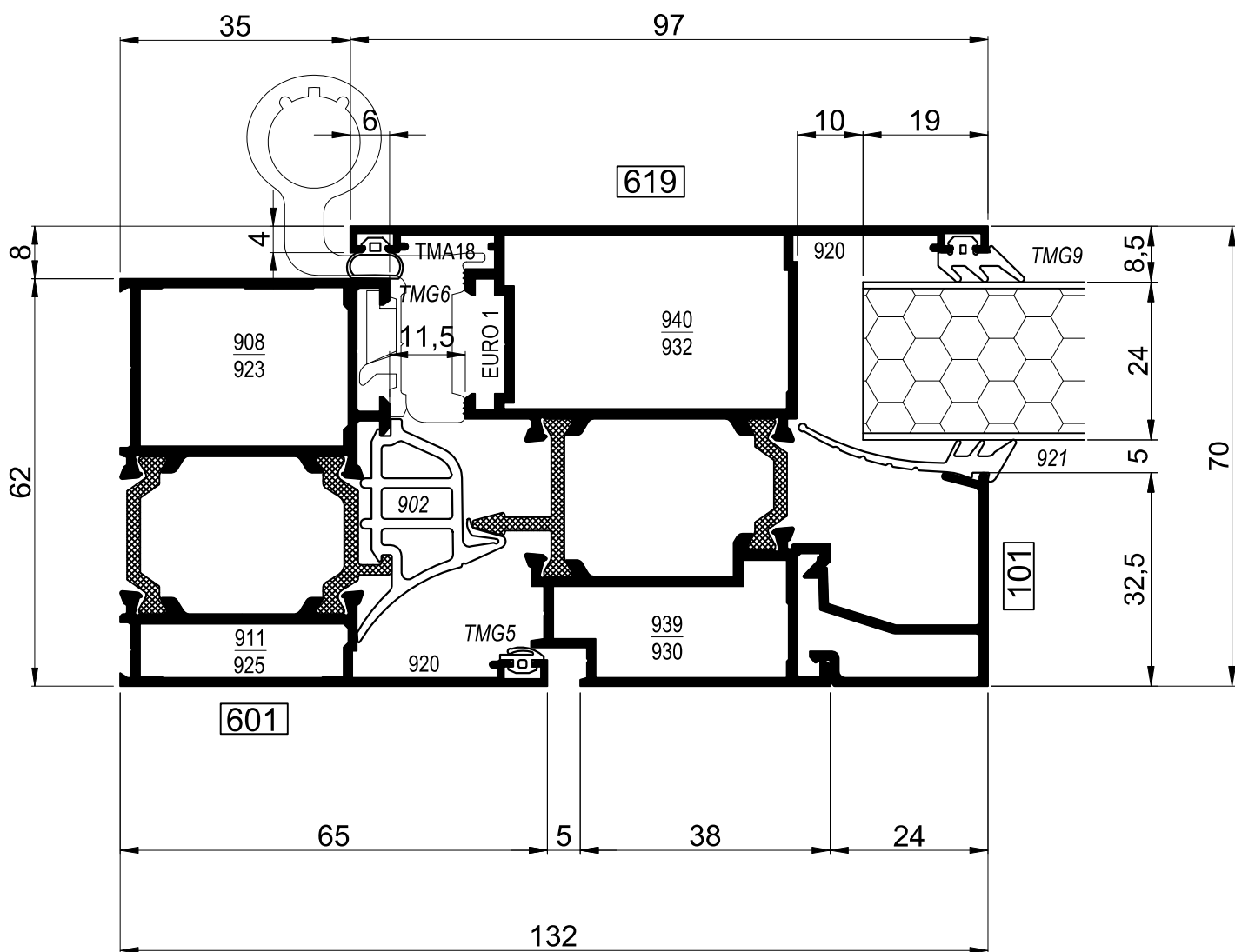
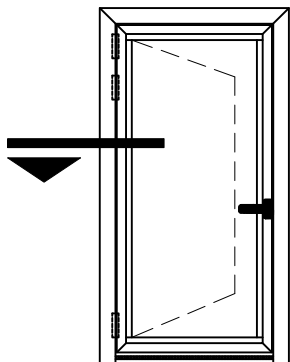


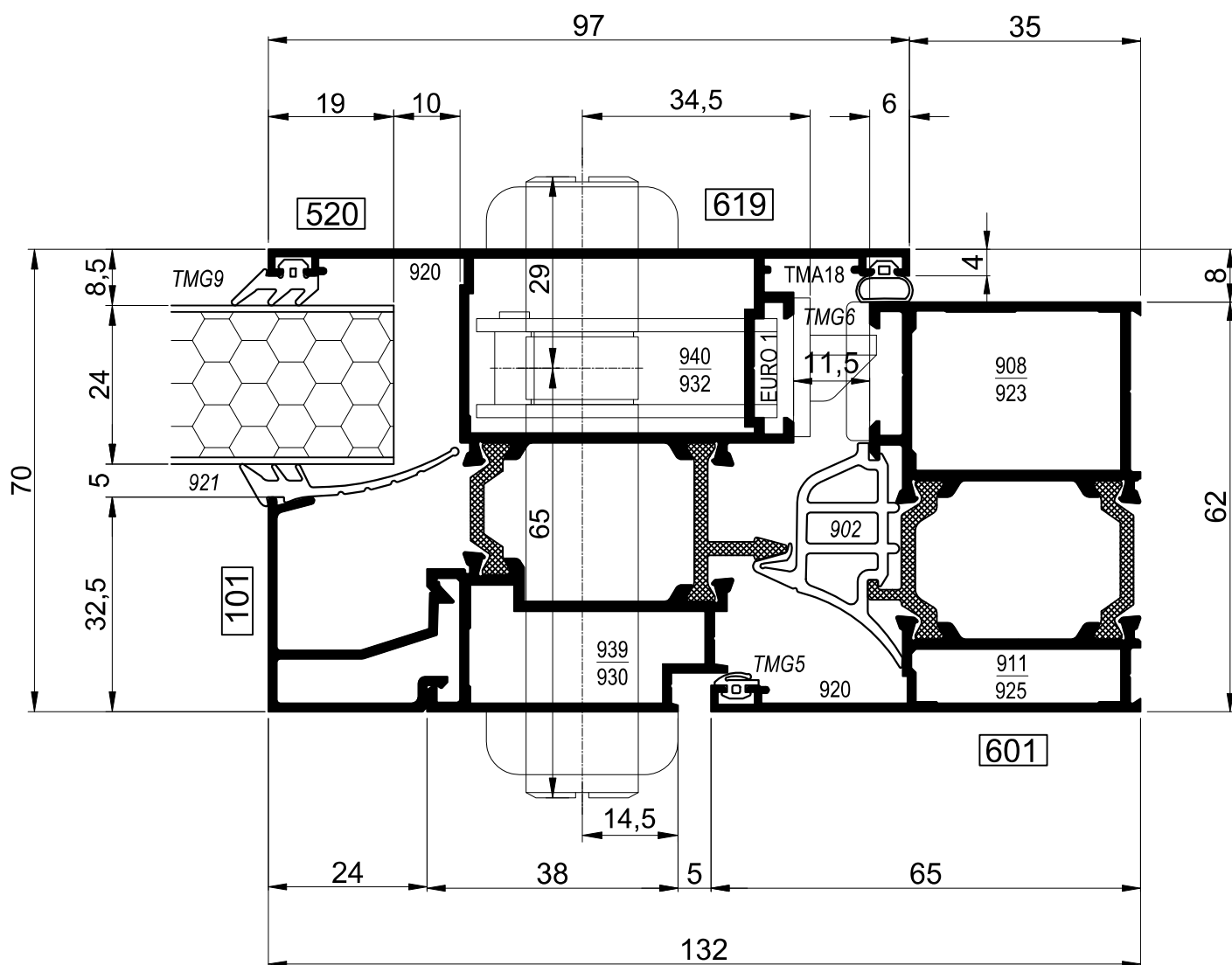
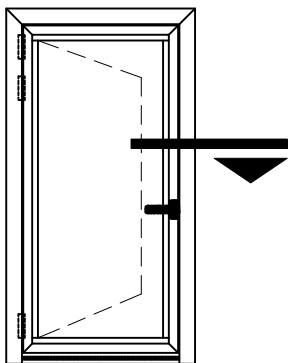


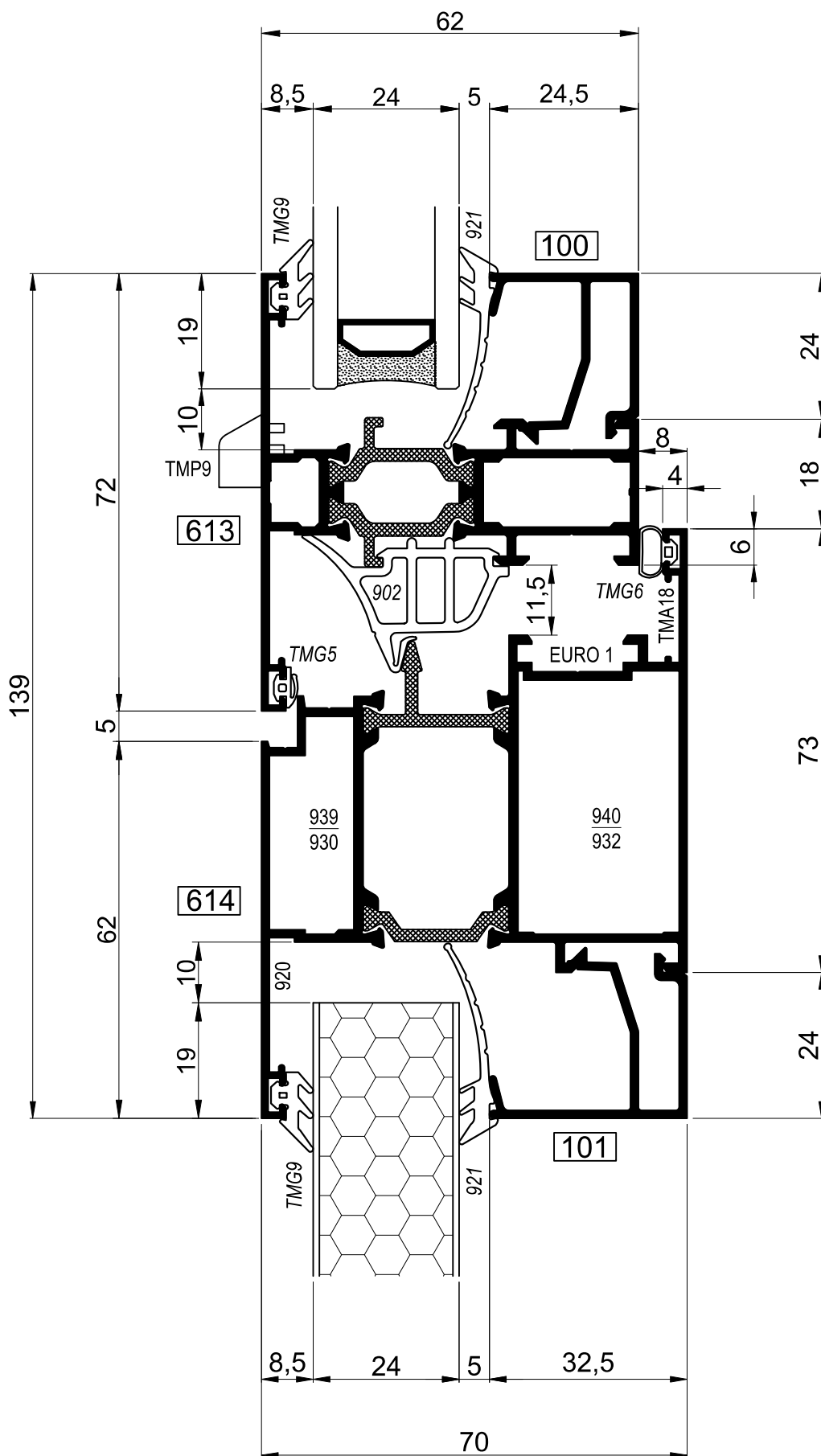
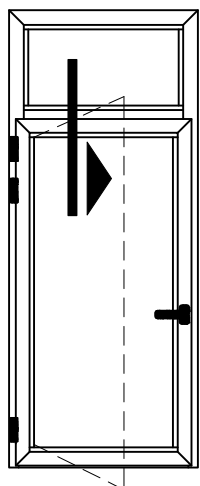


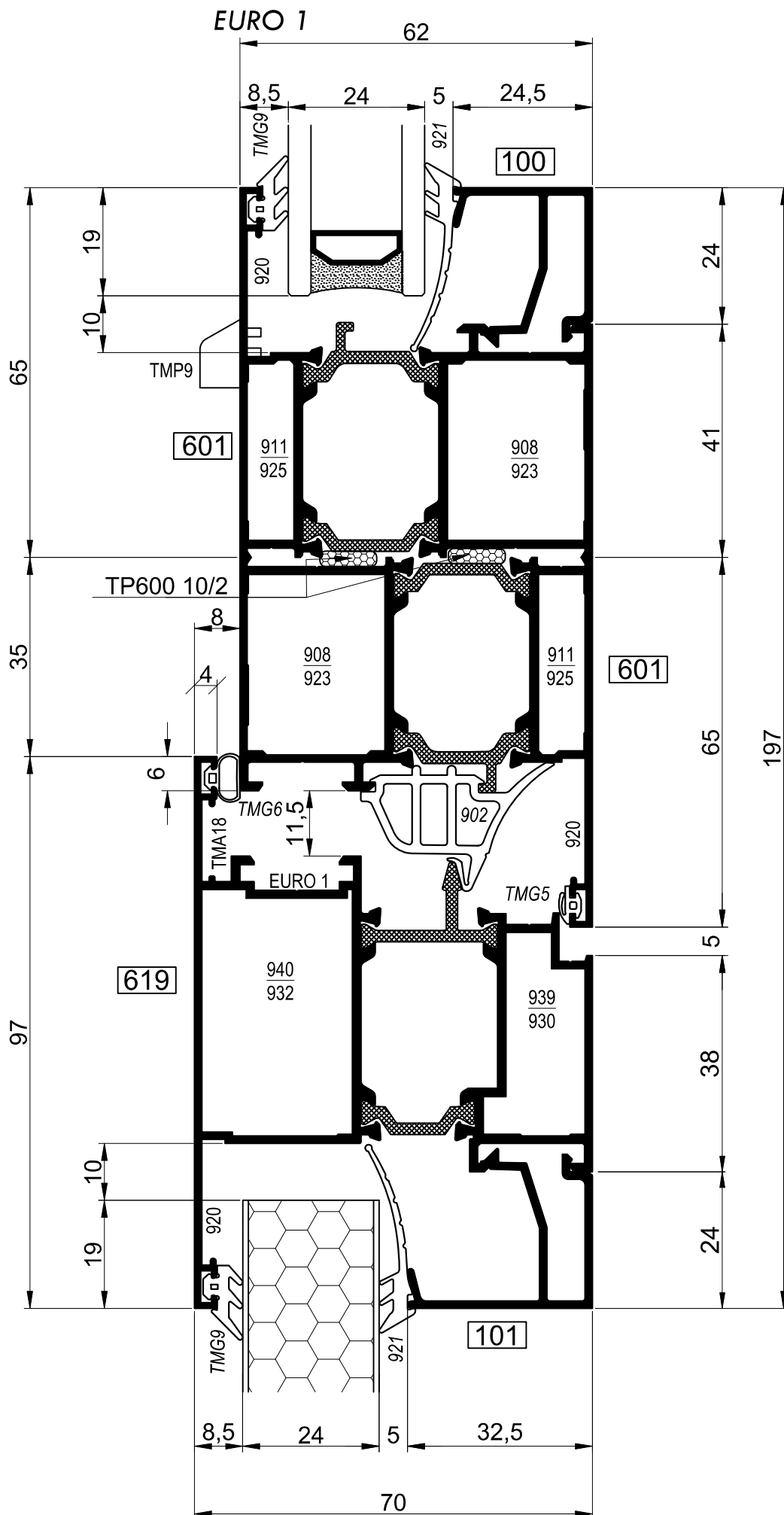




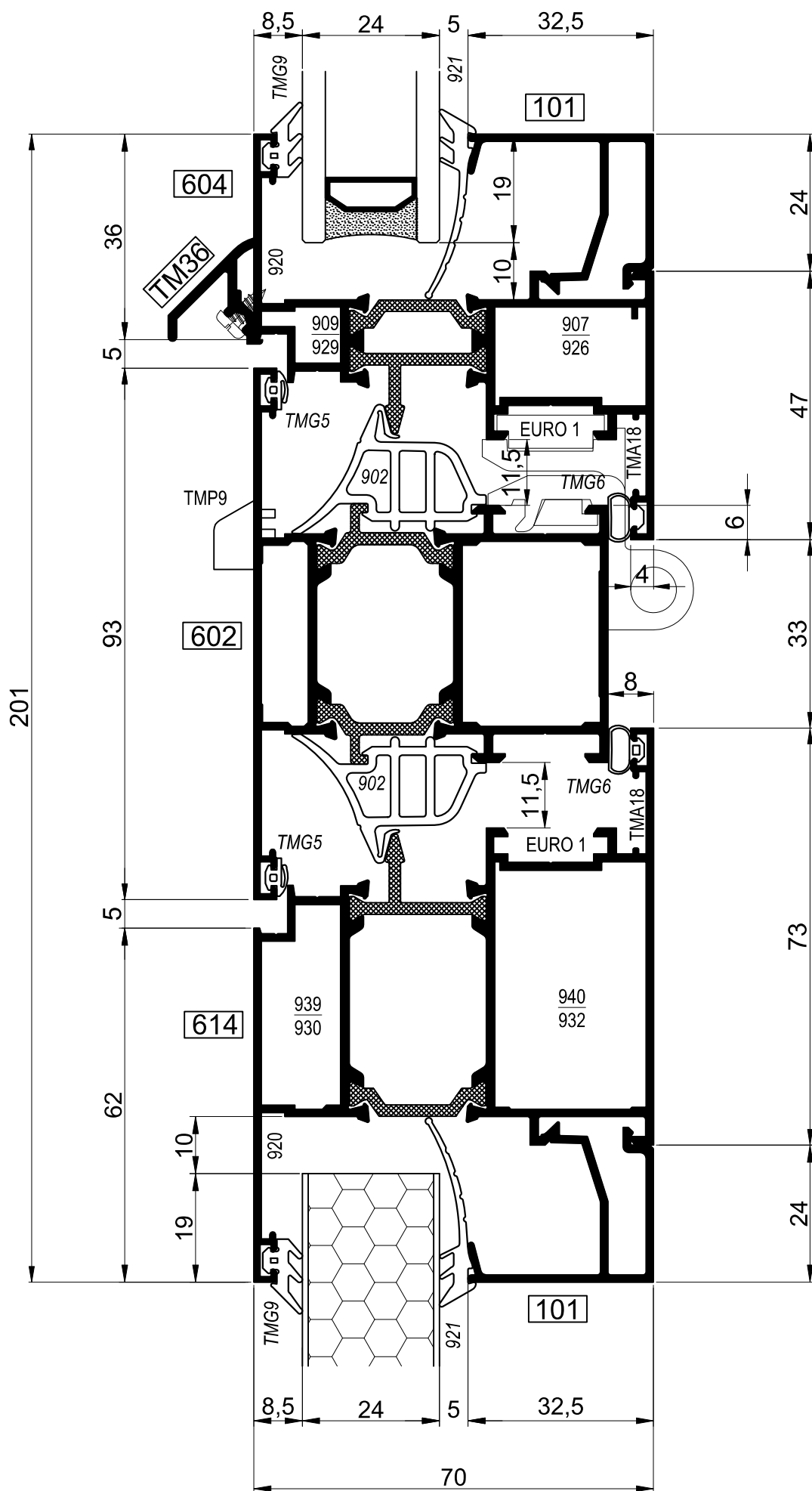
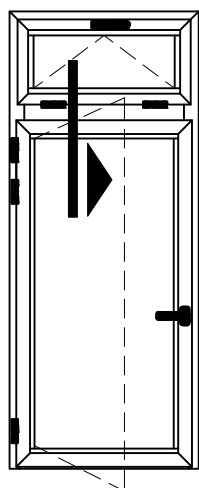


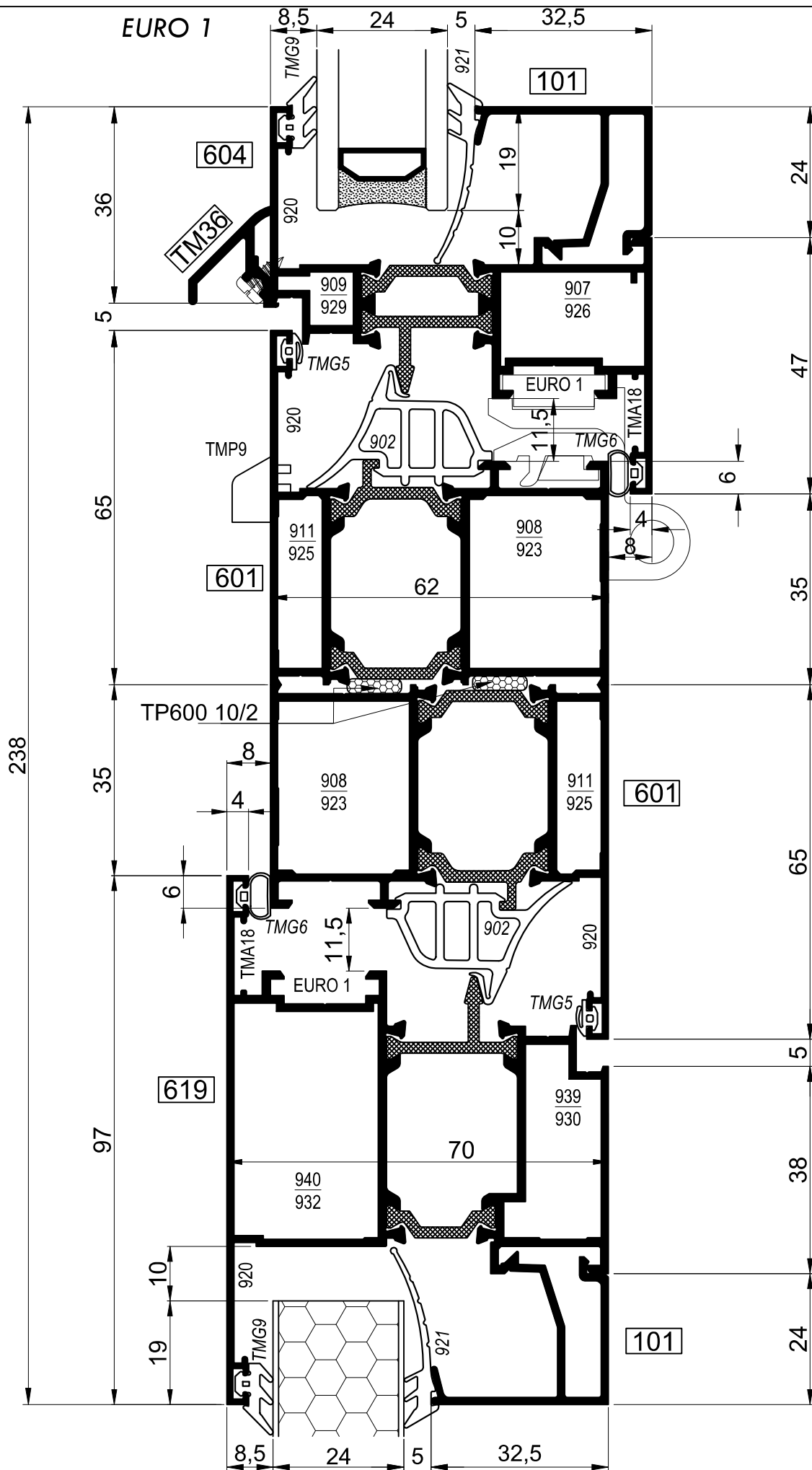
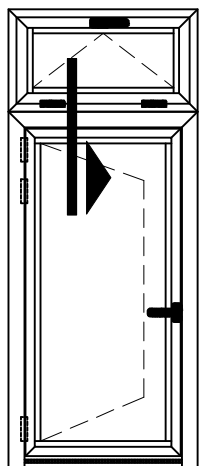


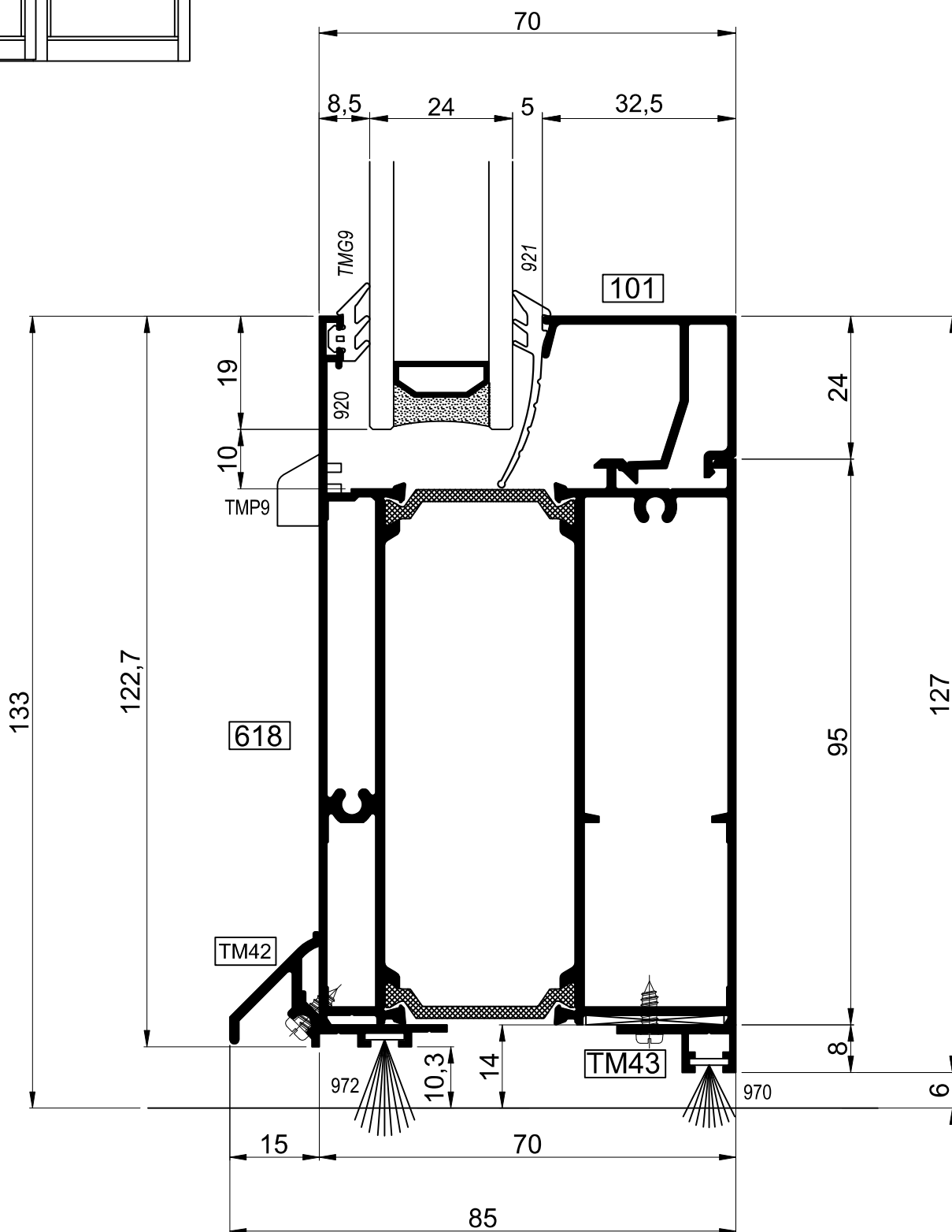
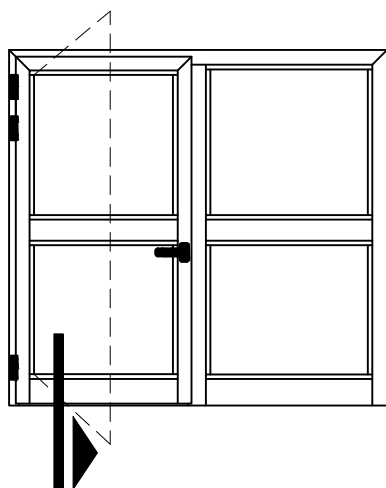


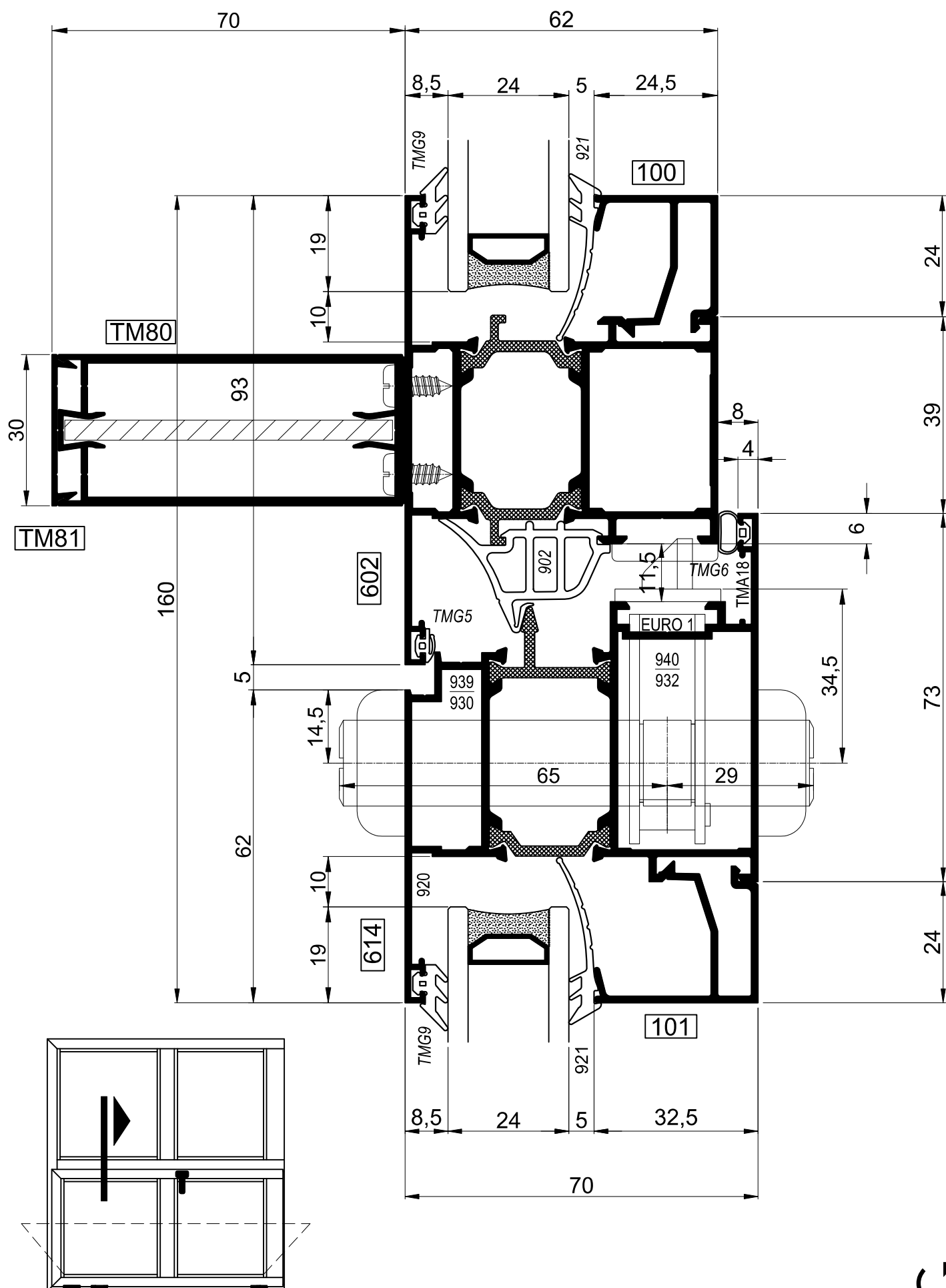


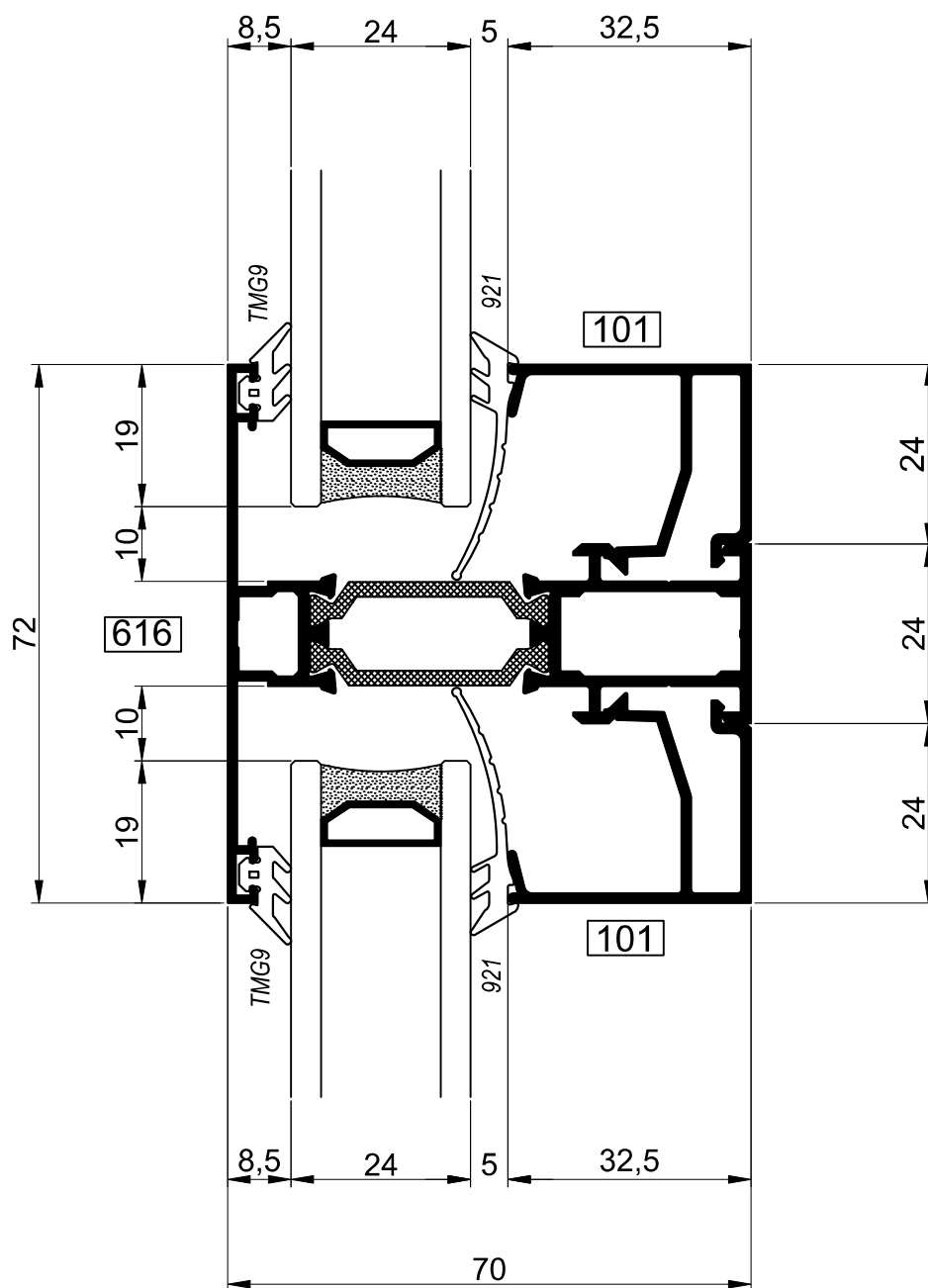
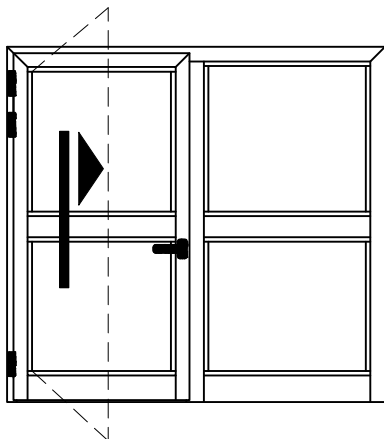
EURO 1

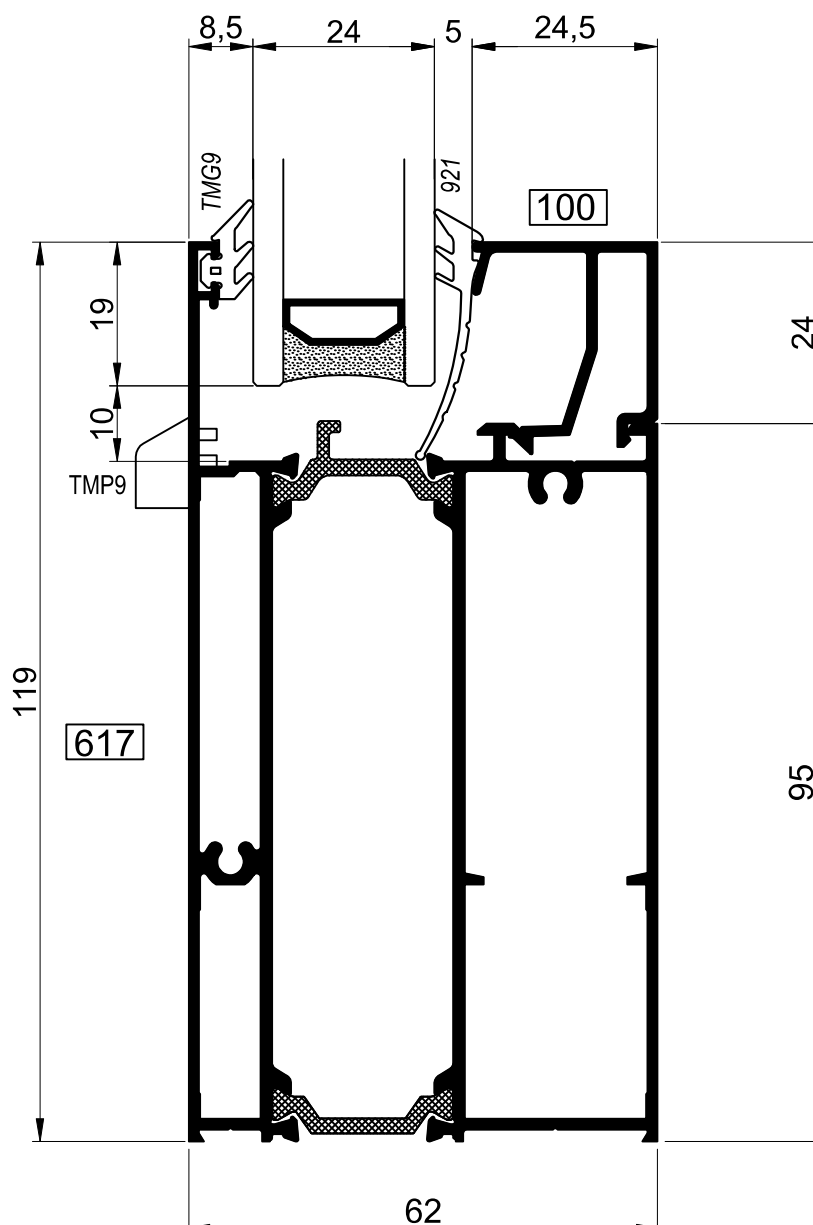
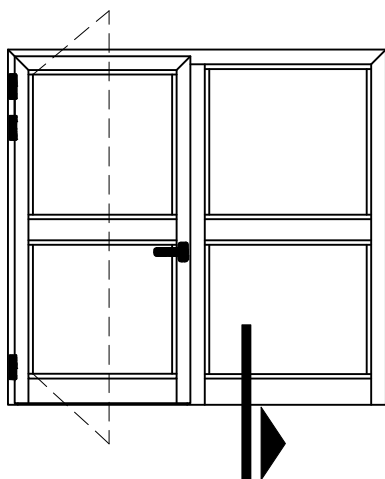


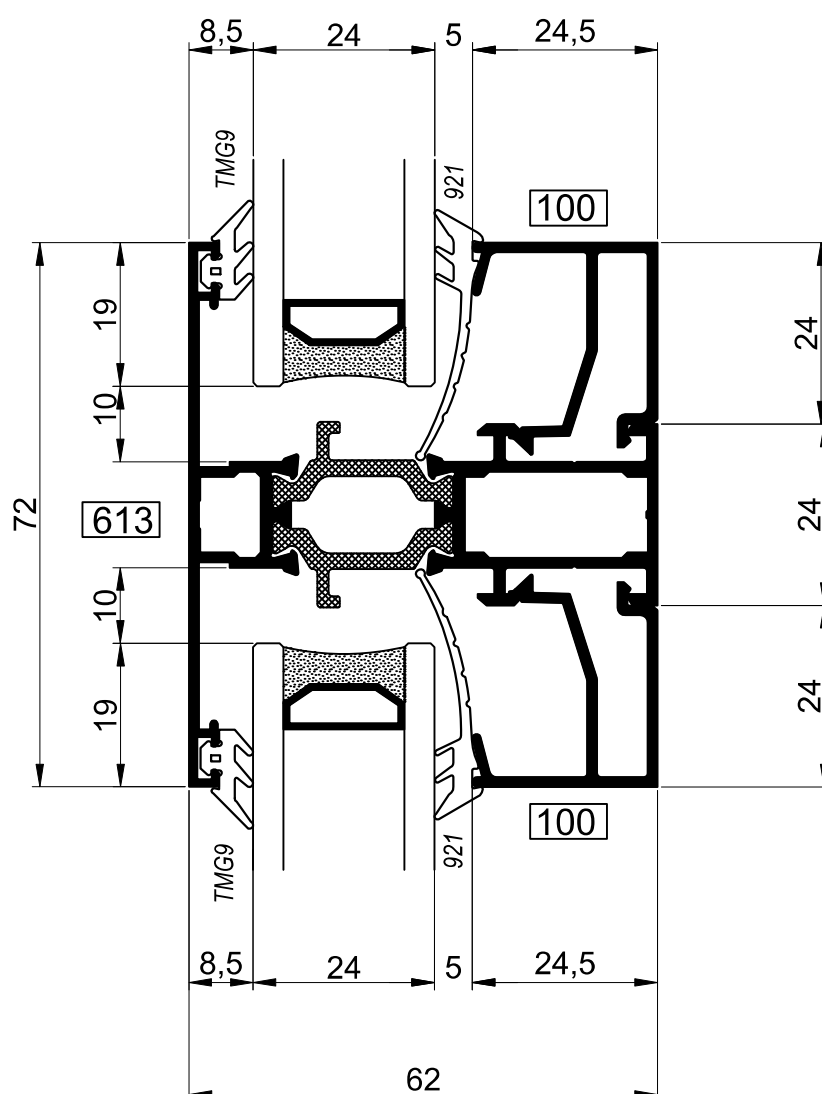
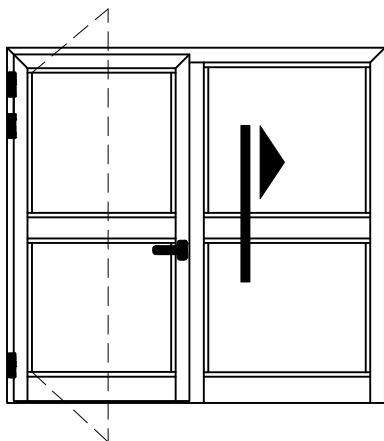


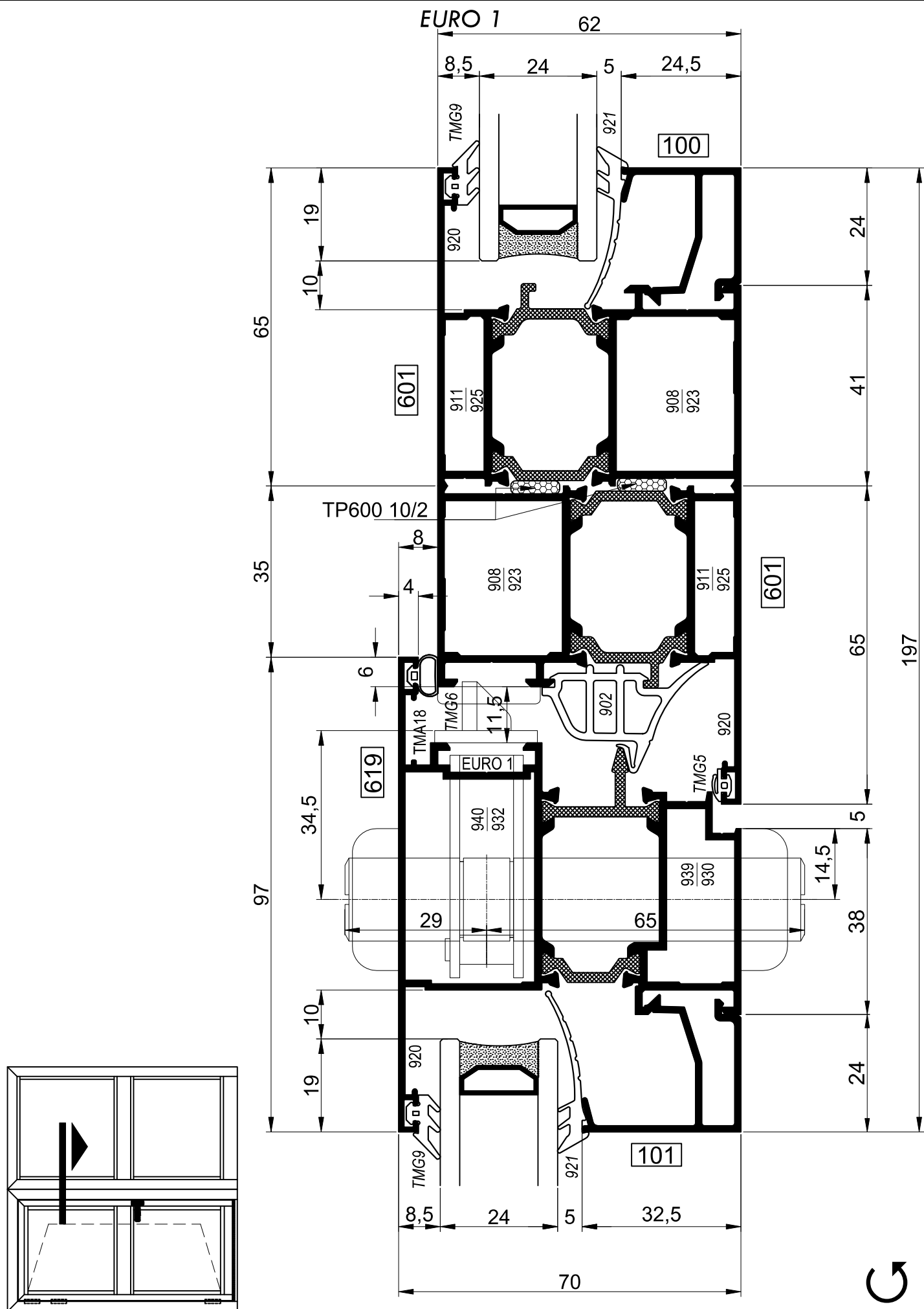


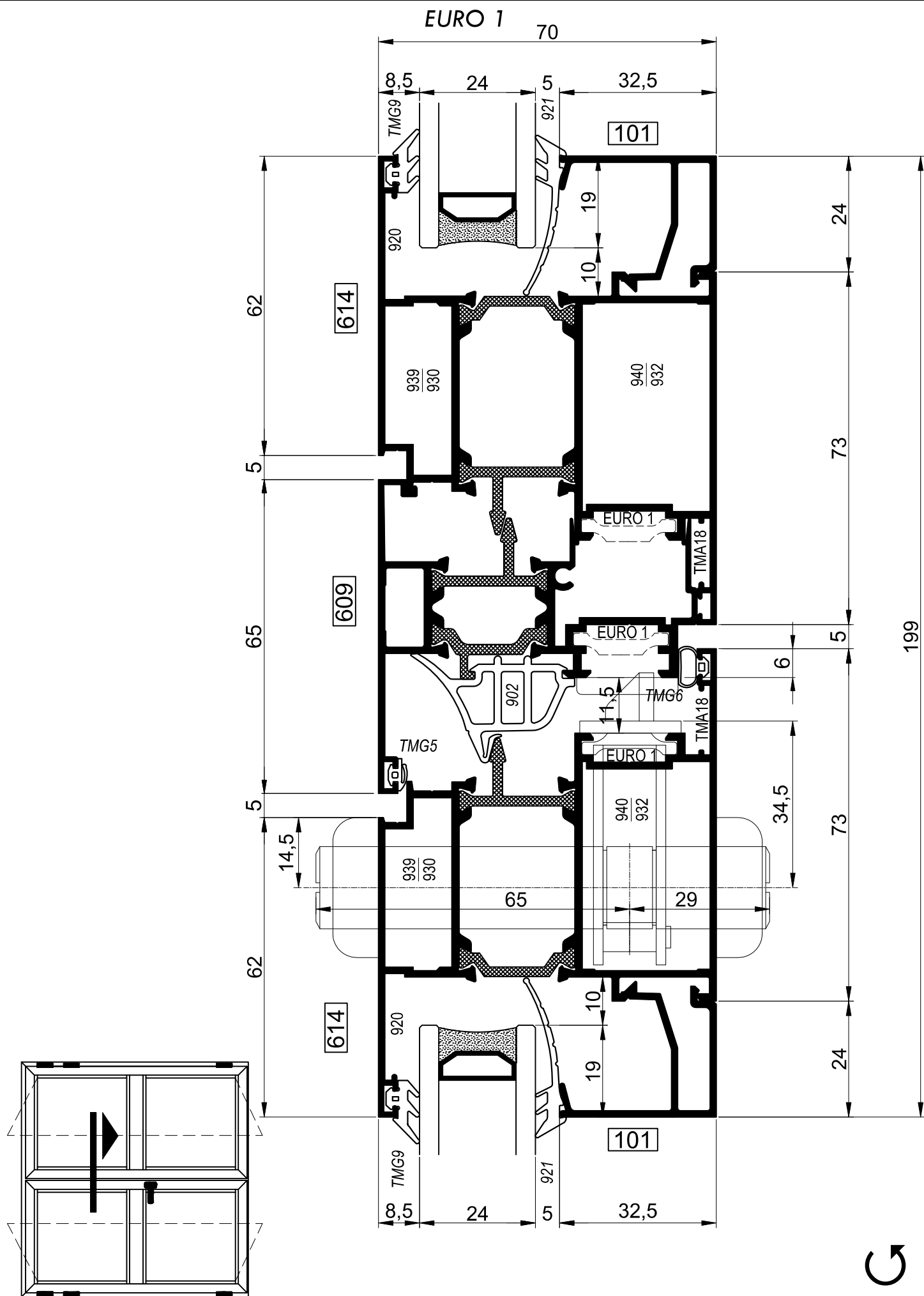


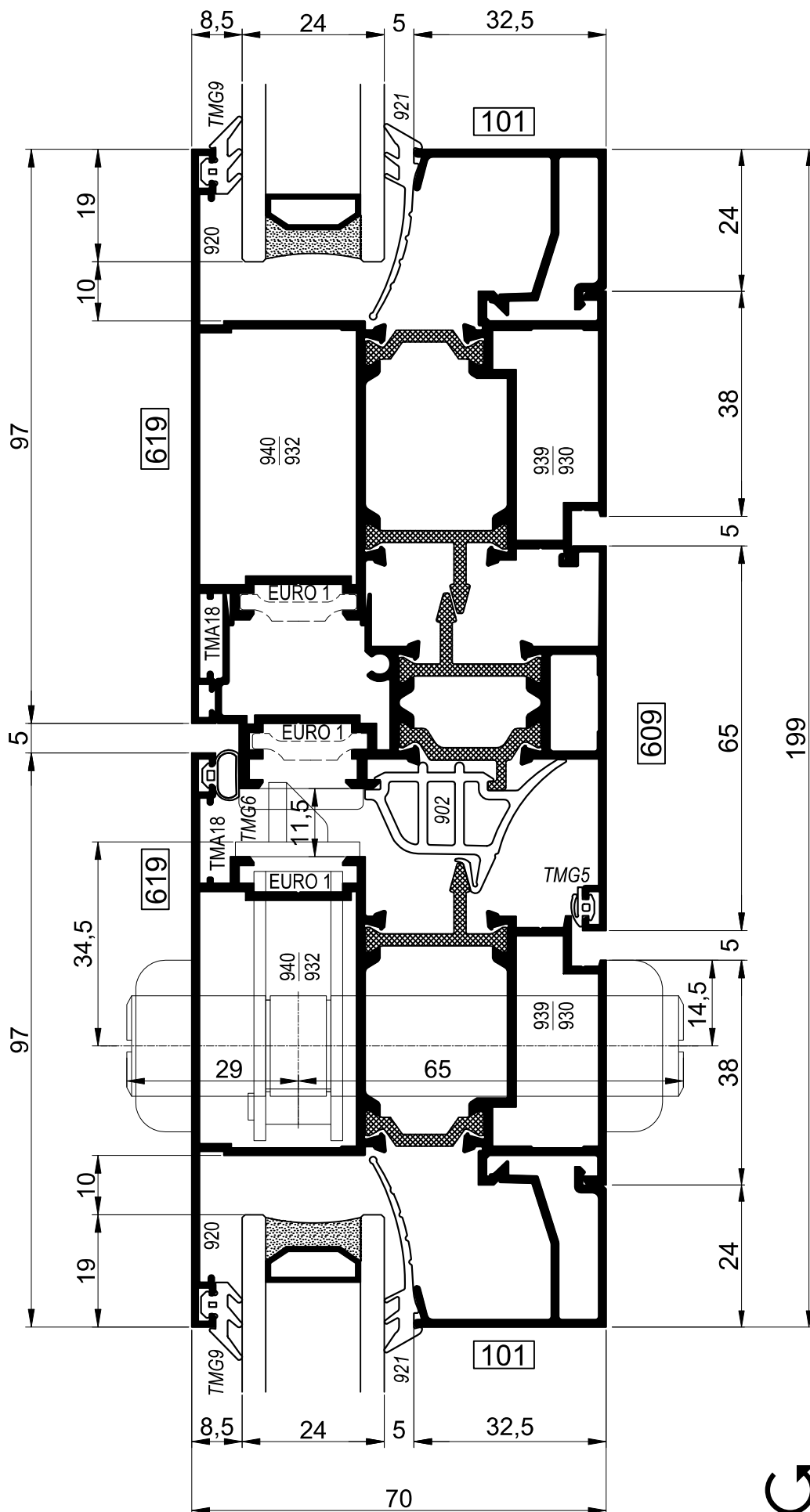
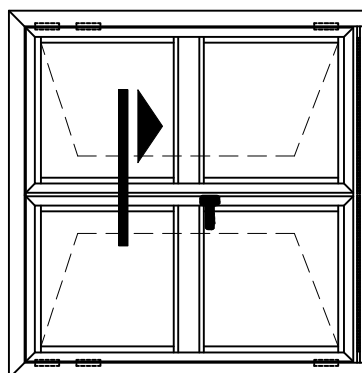




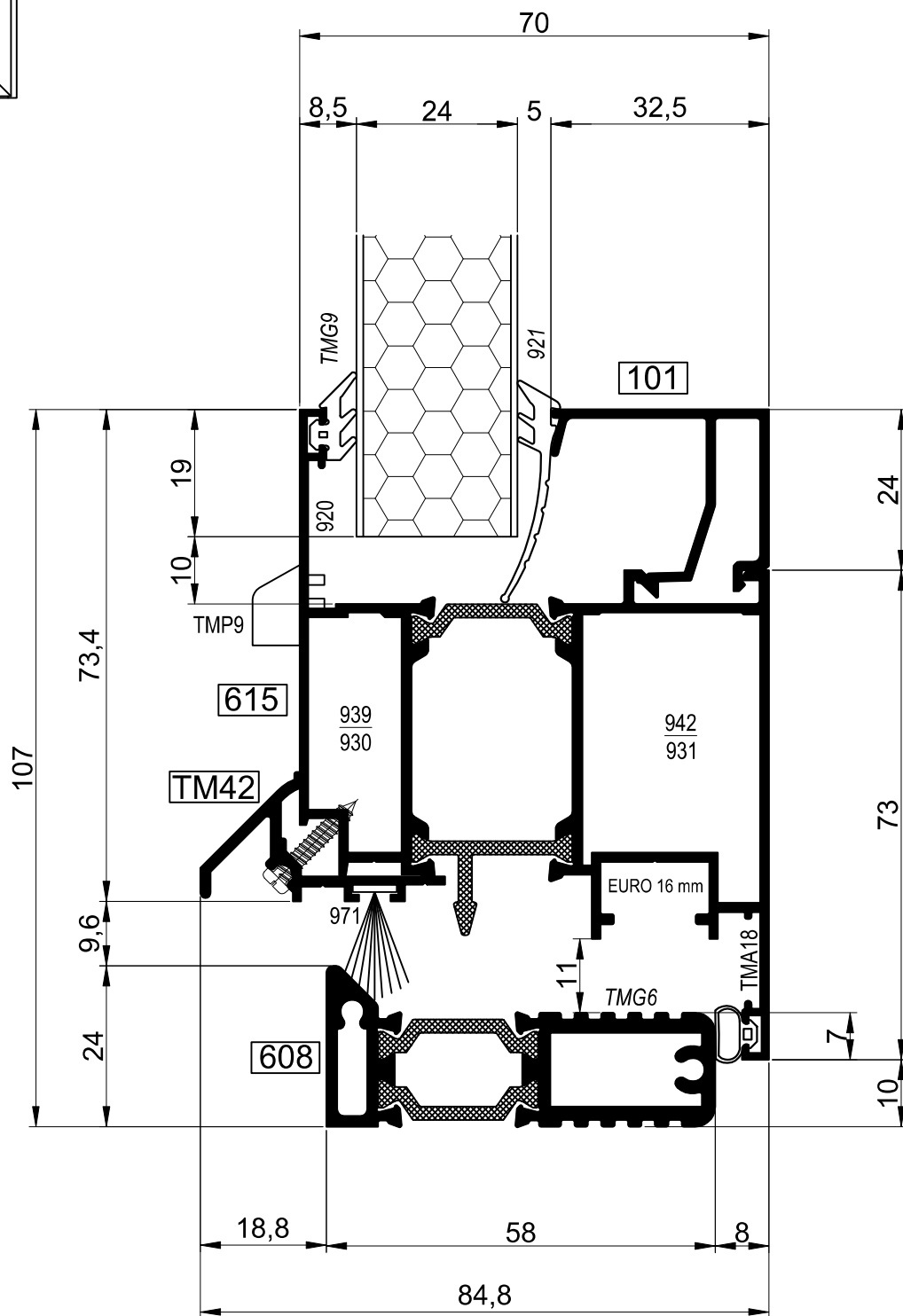
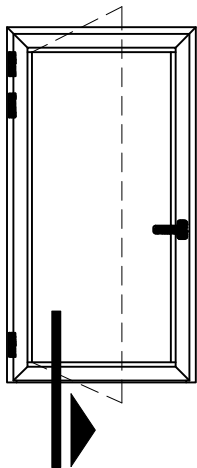


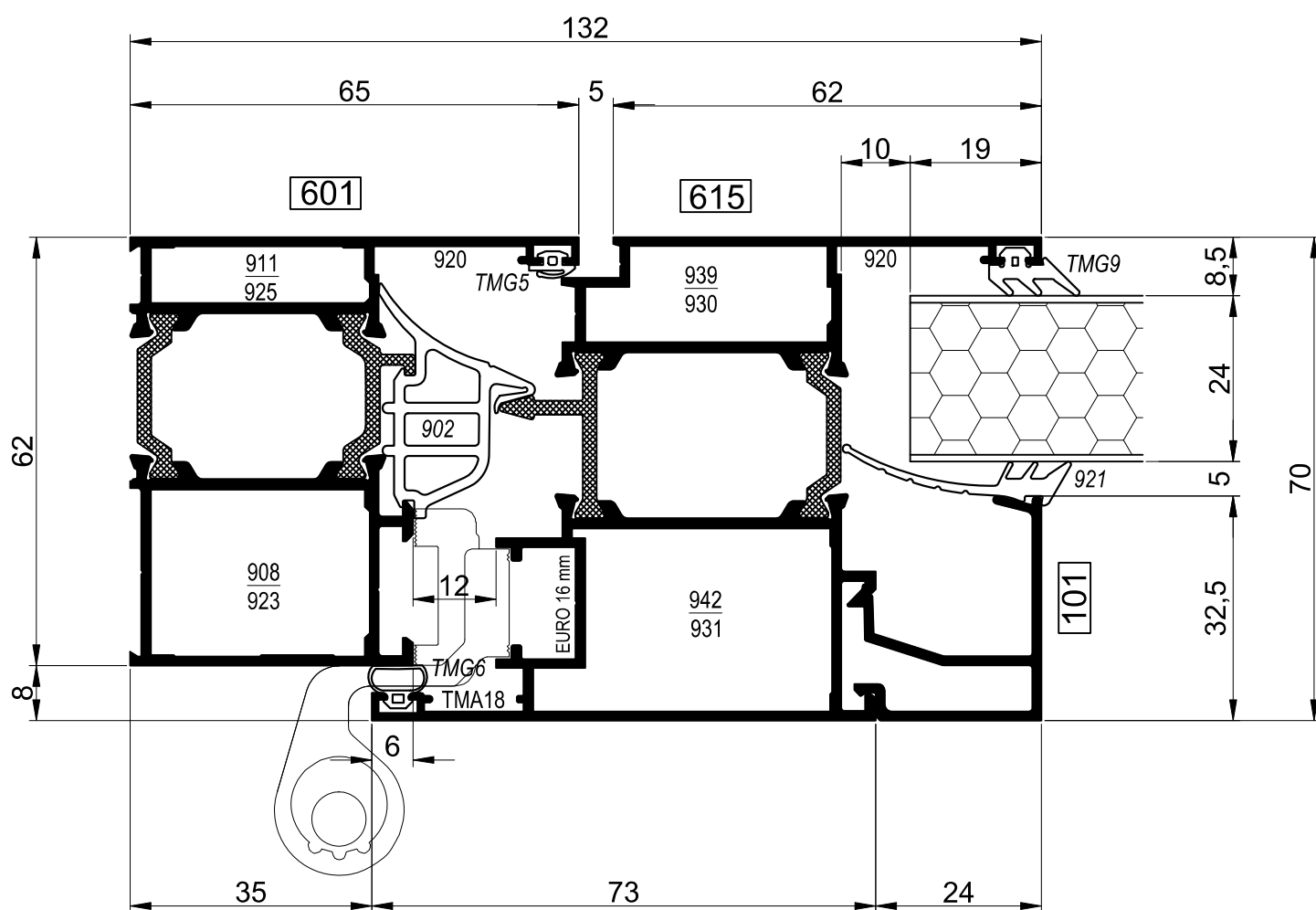
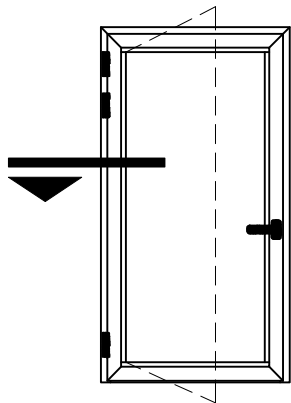


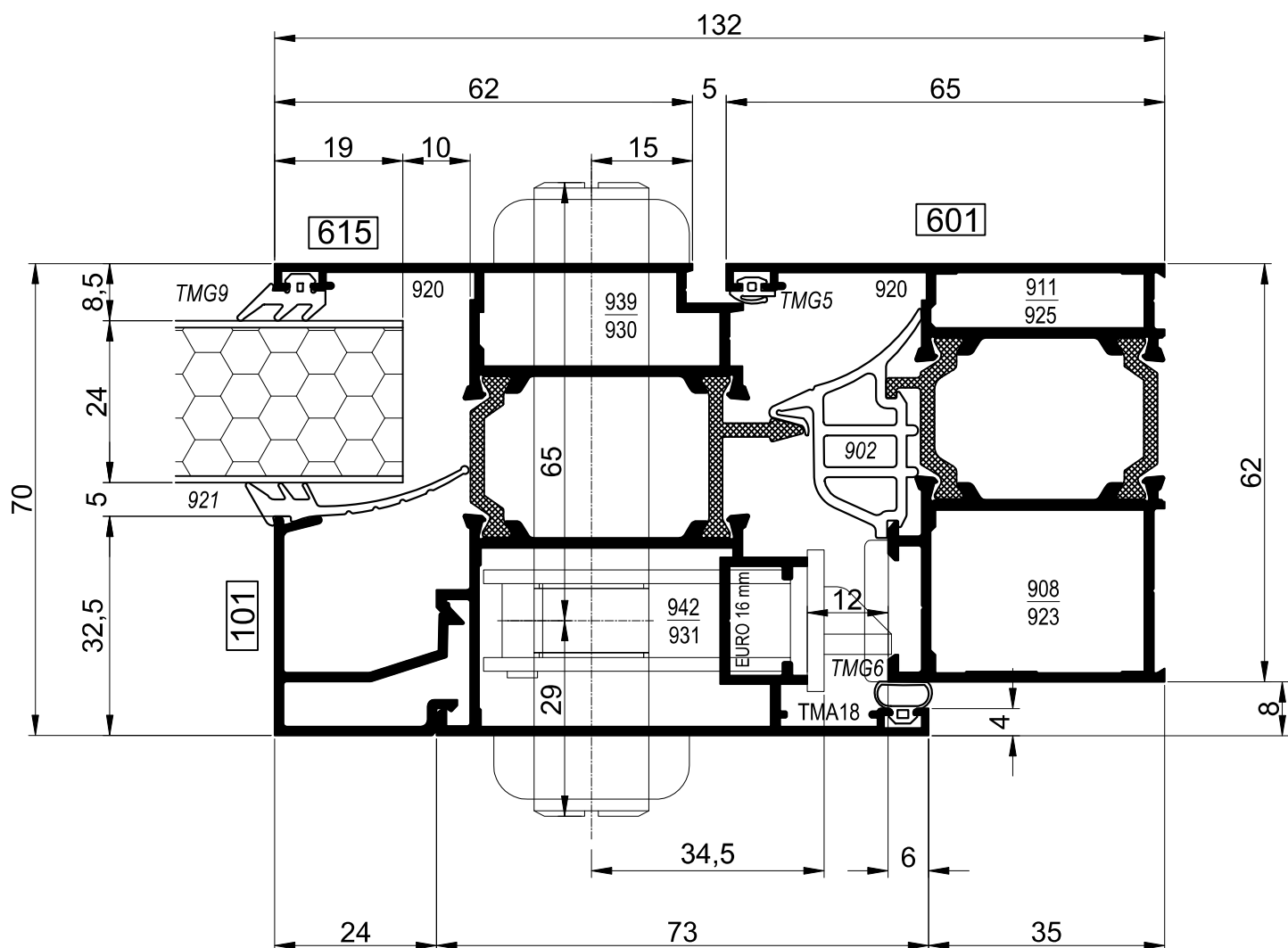
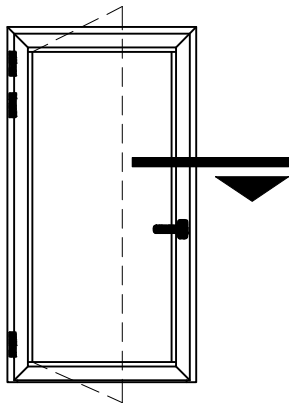




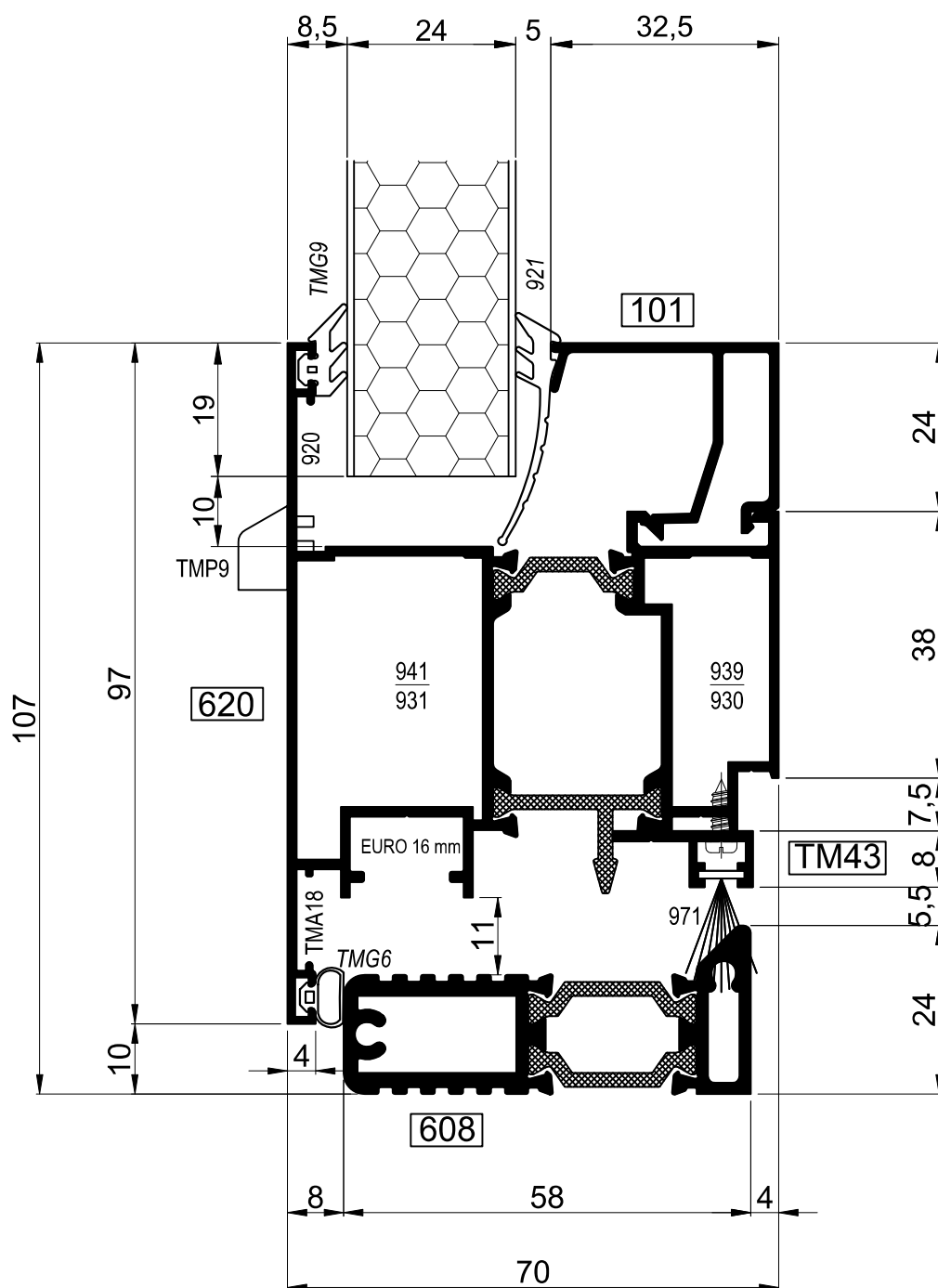
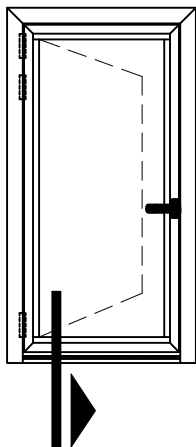
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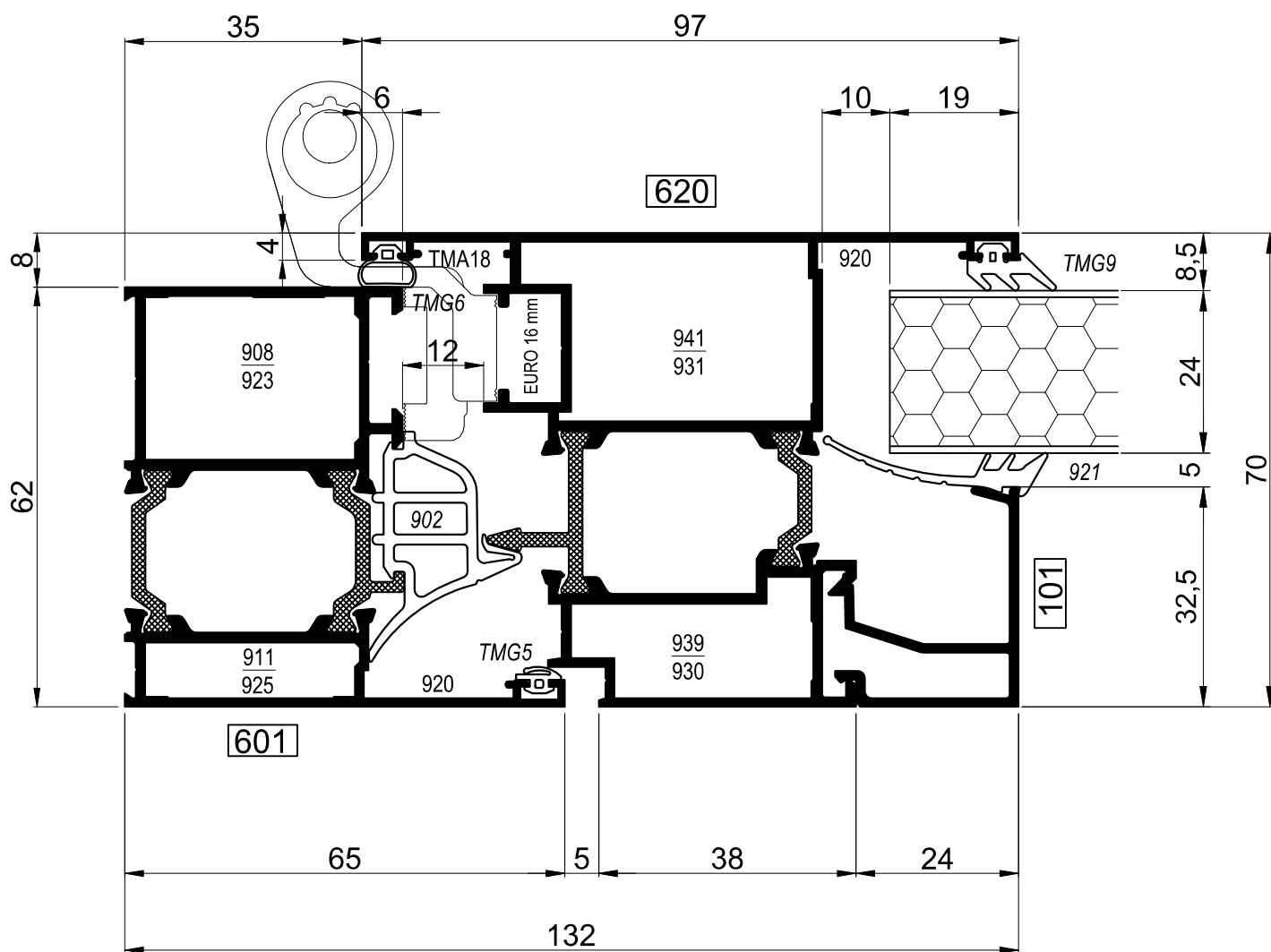
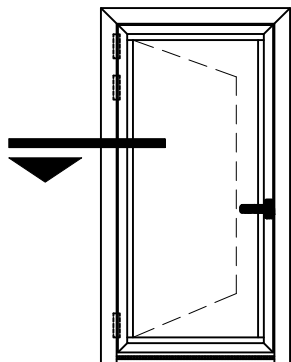




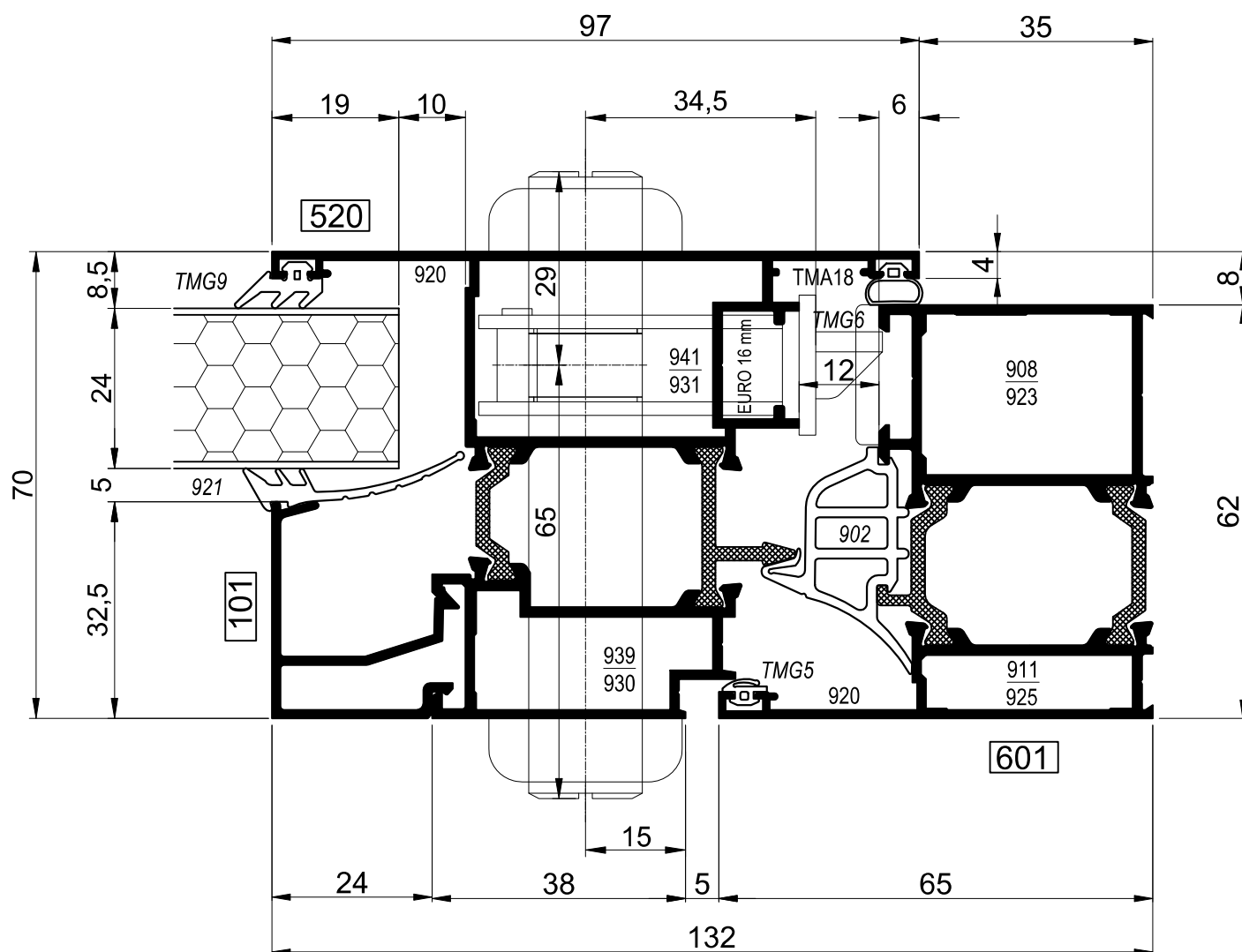
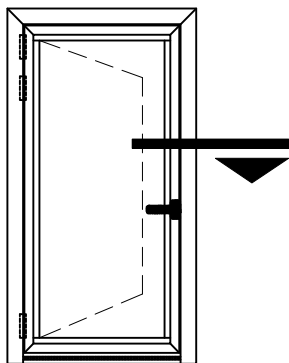


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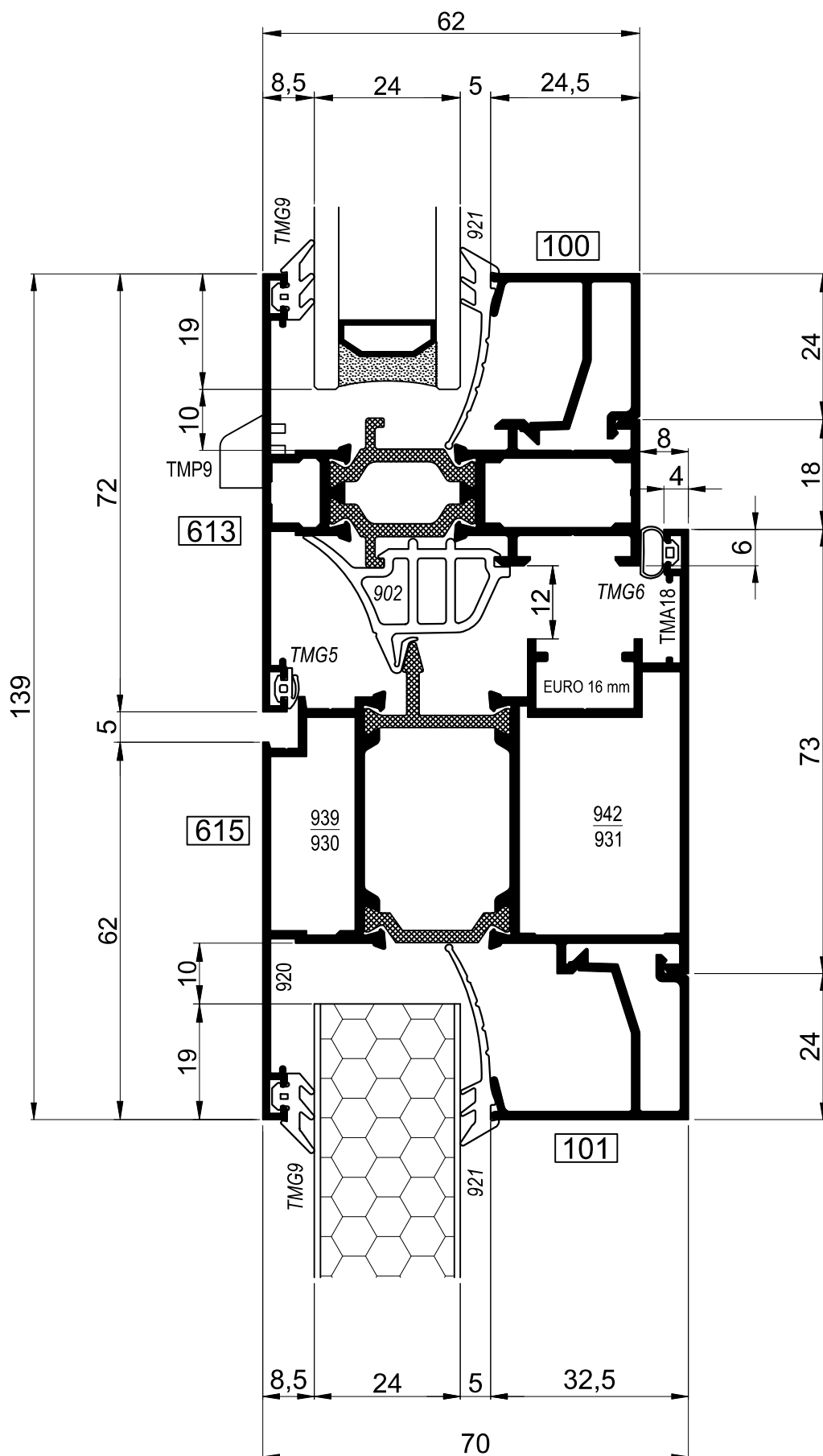
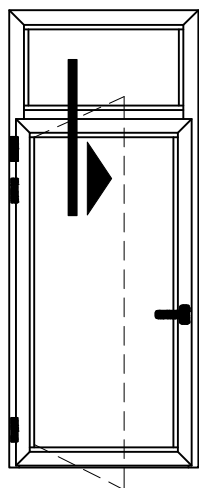


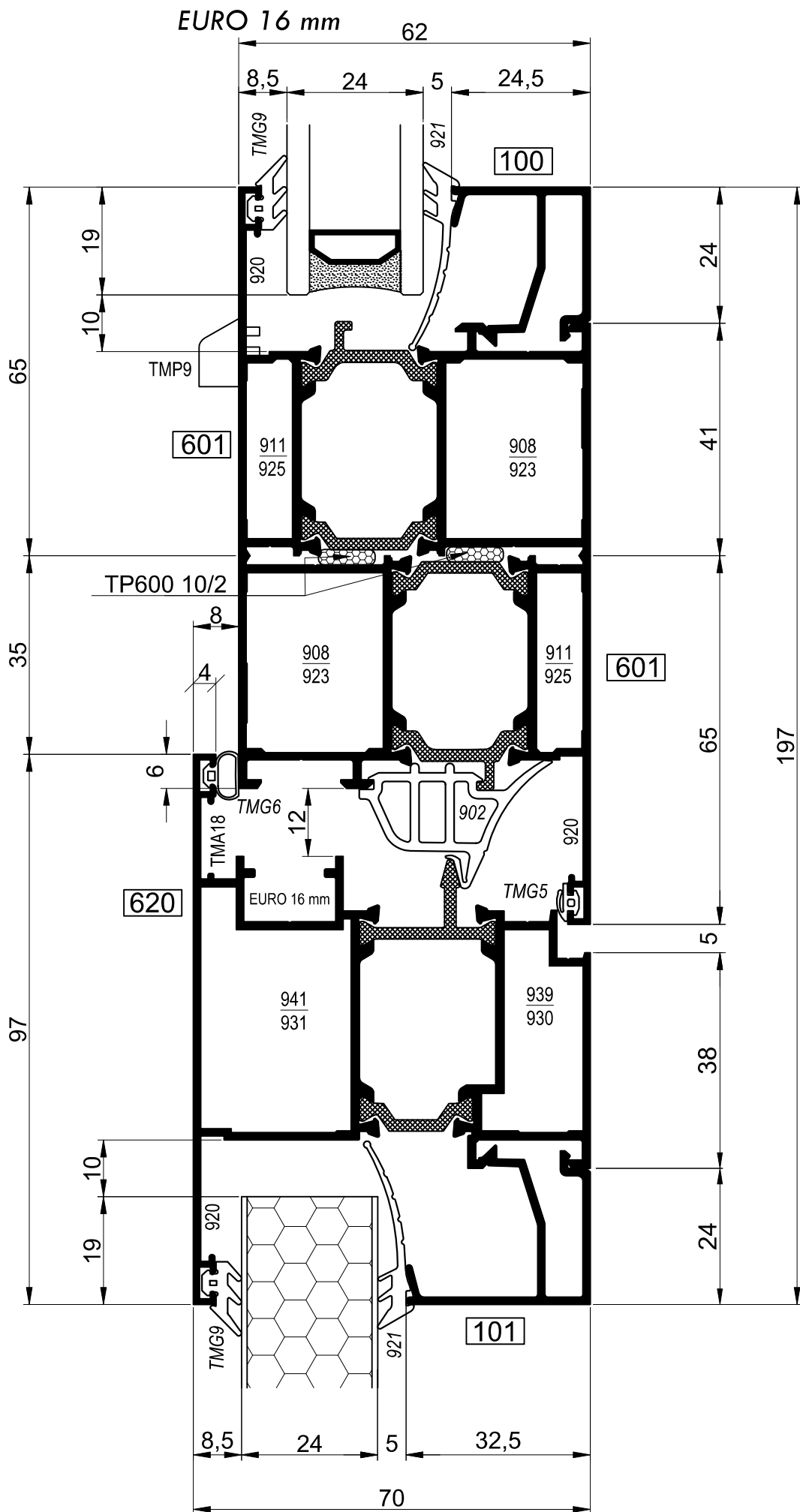
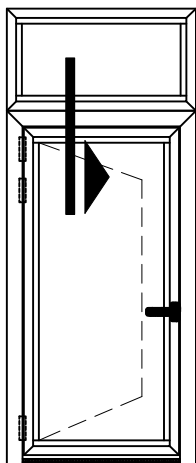


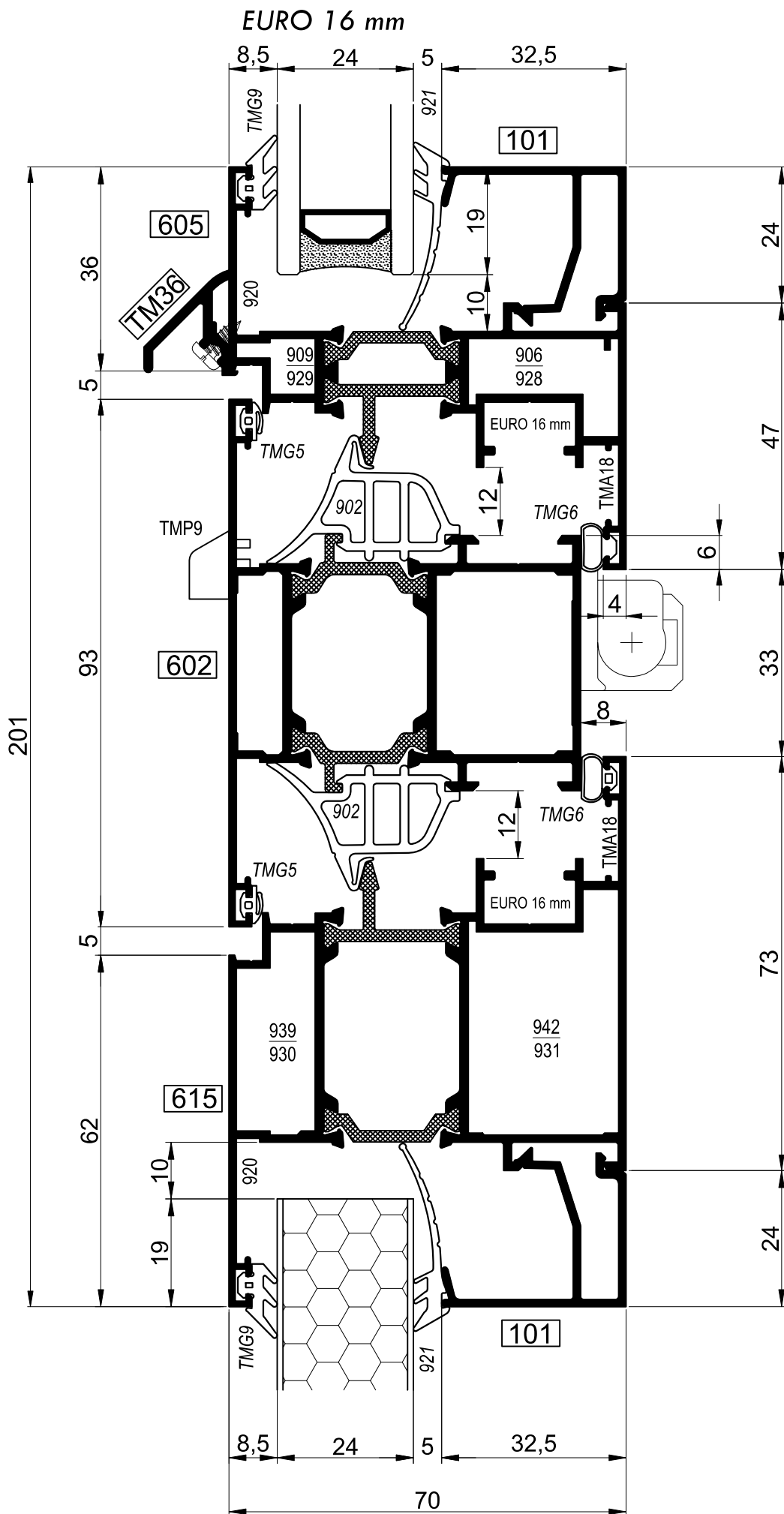
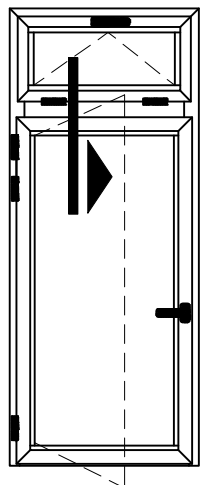
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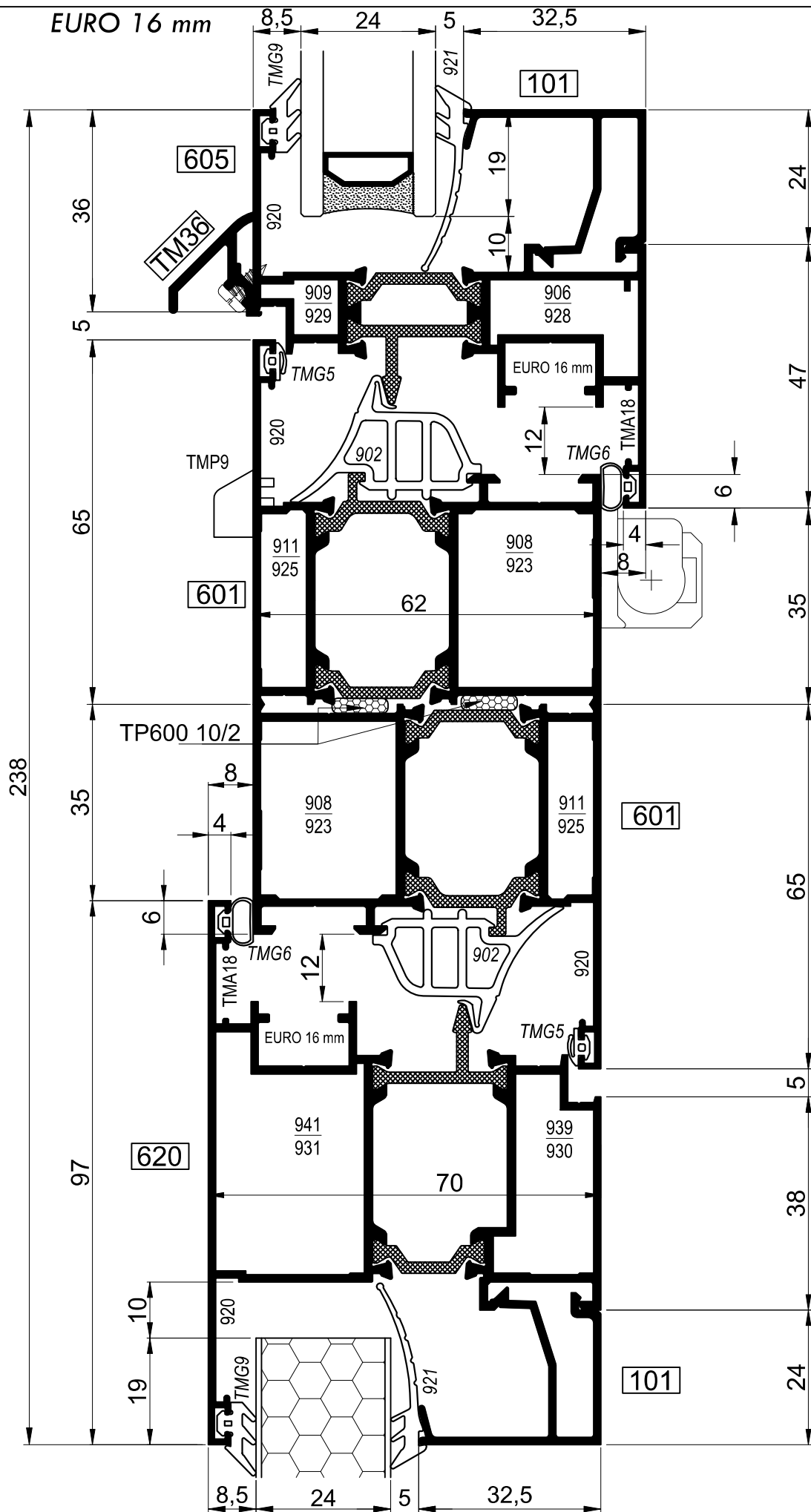
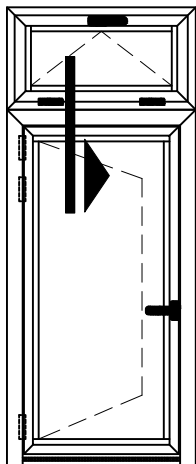


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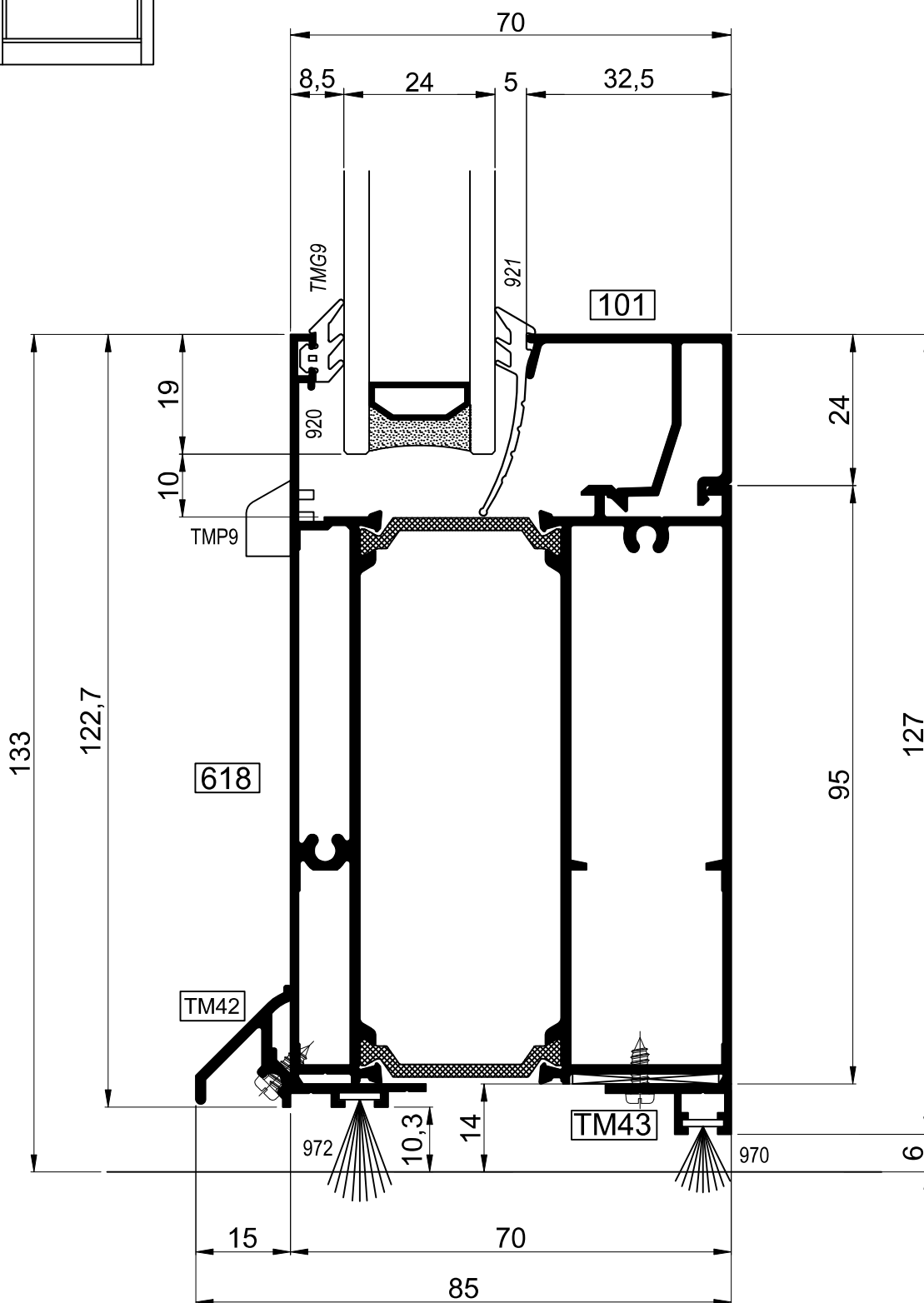
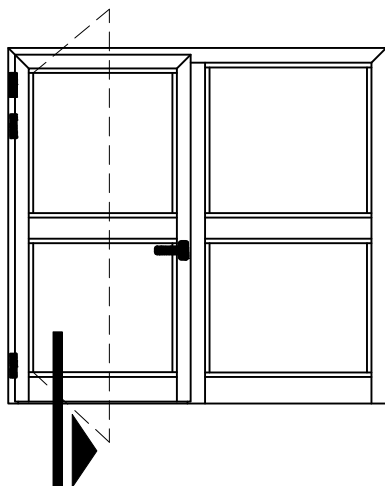




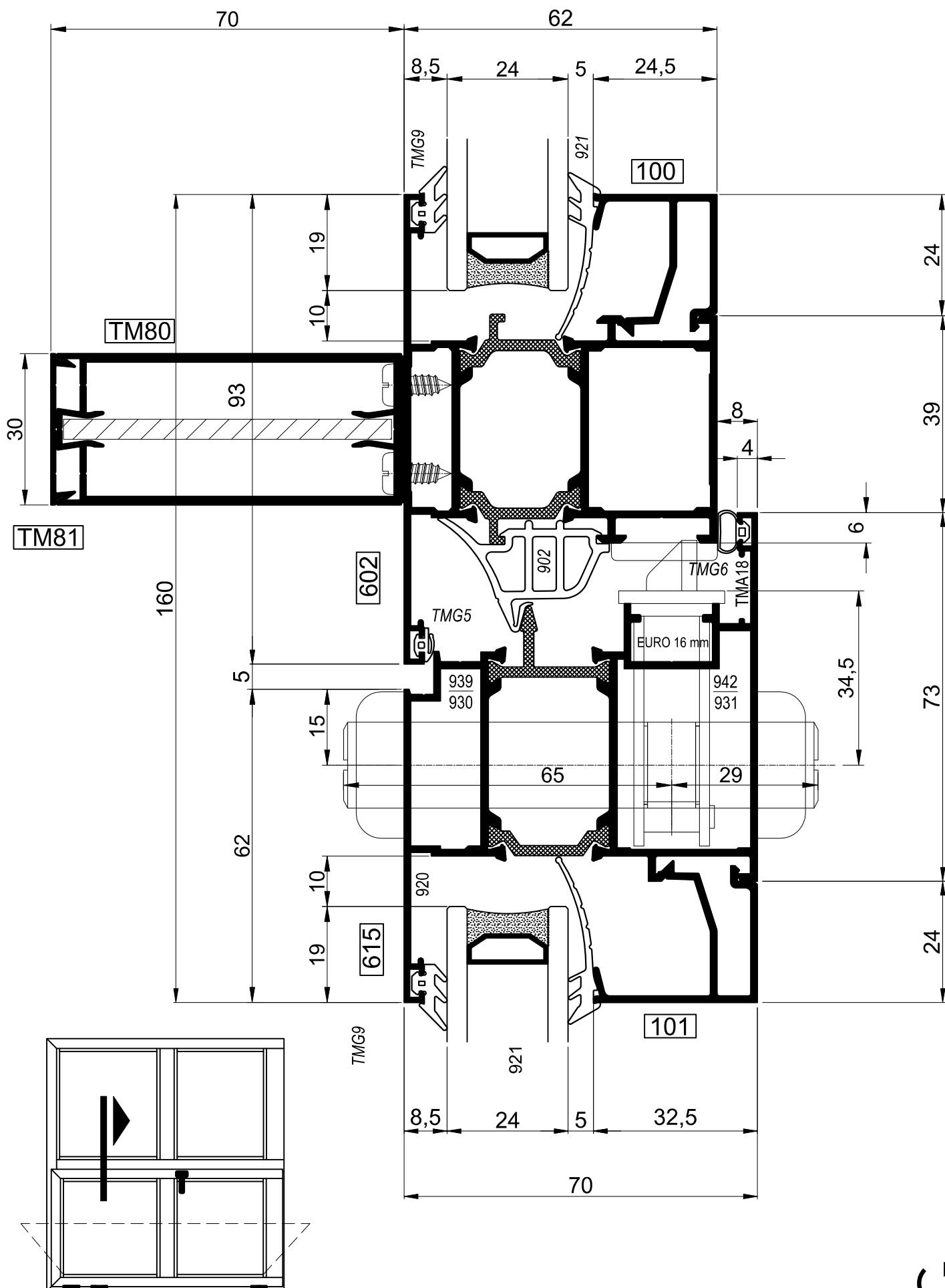




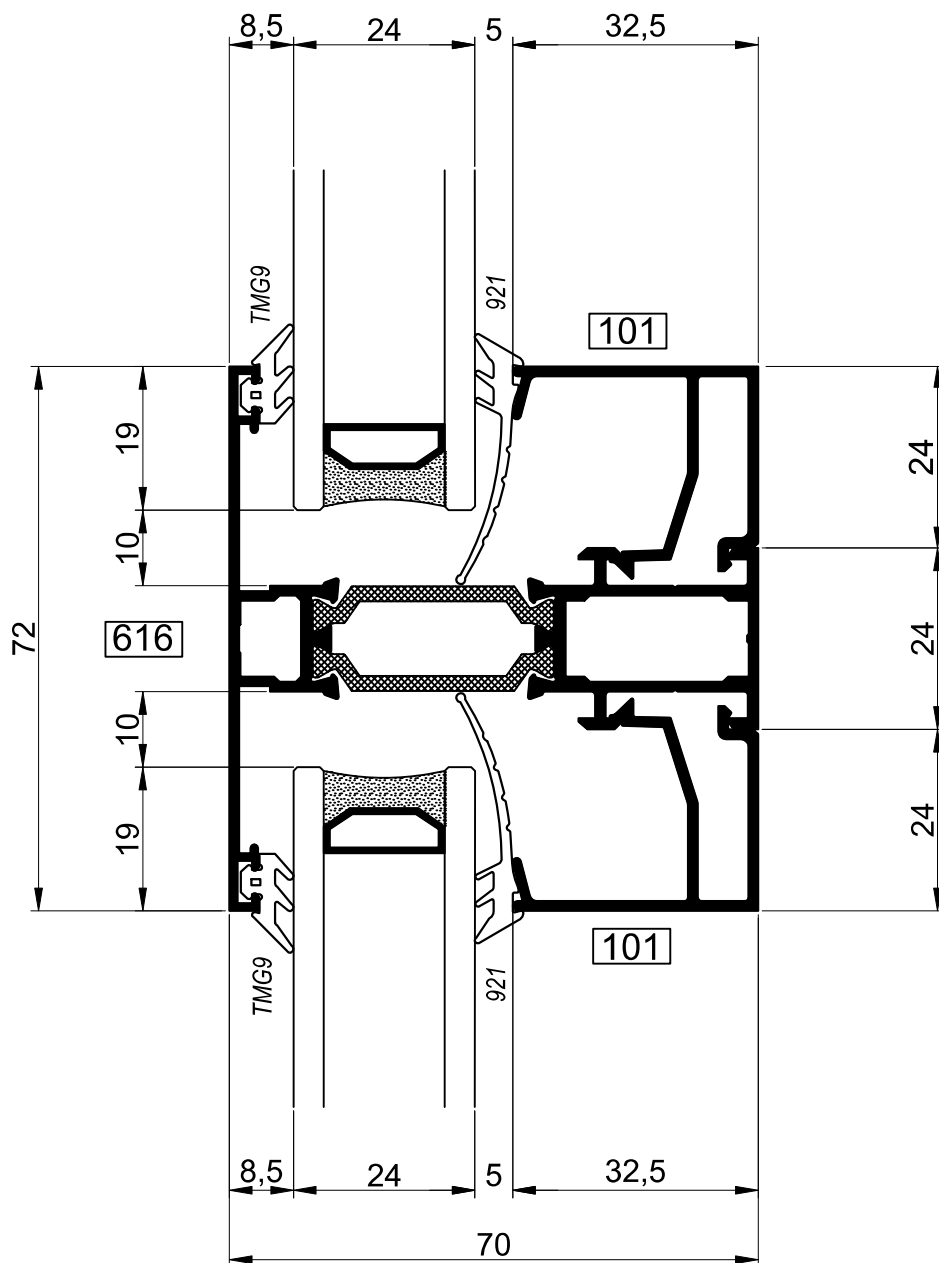
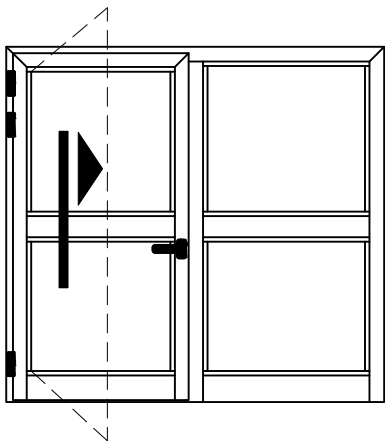
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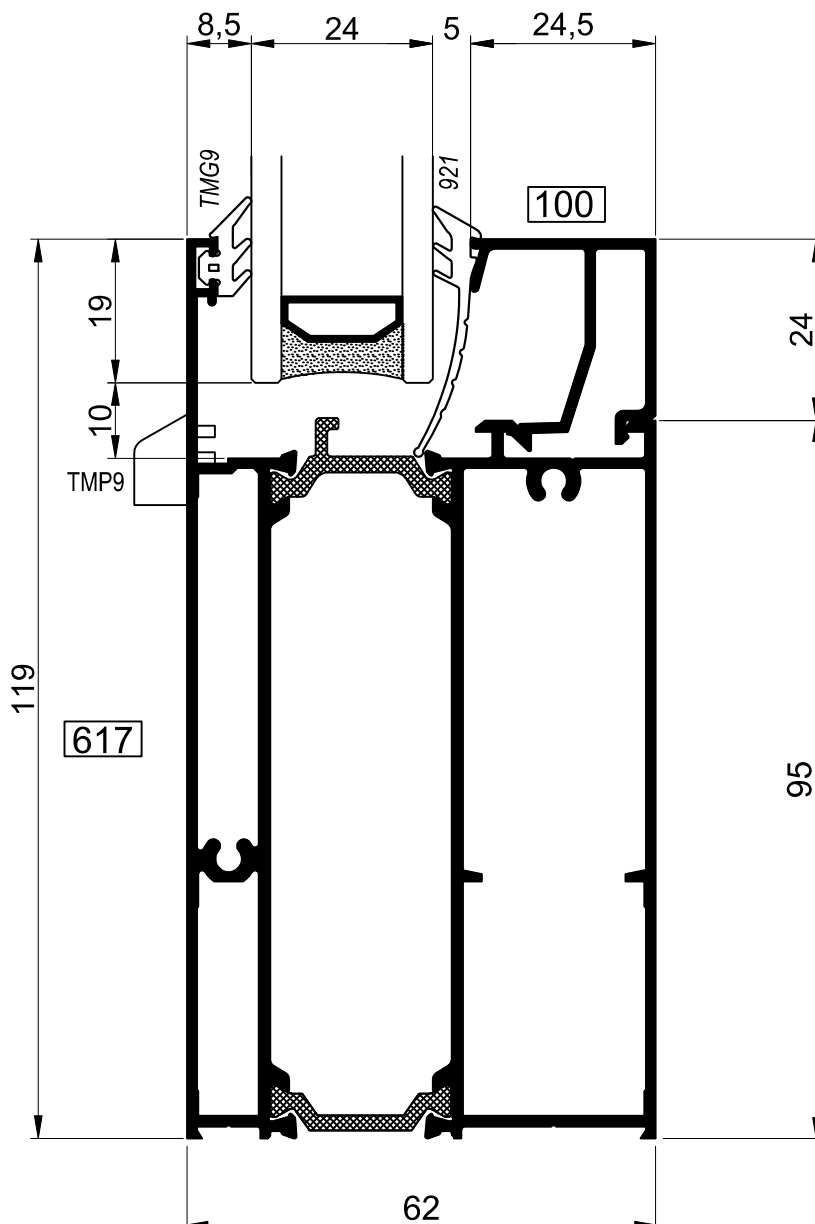
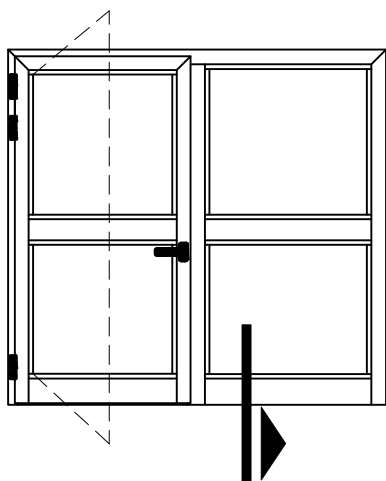


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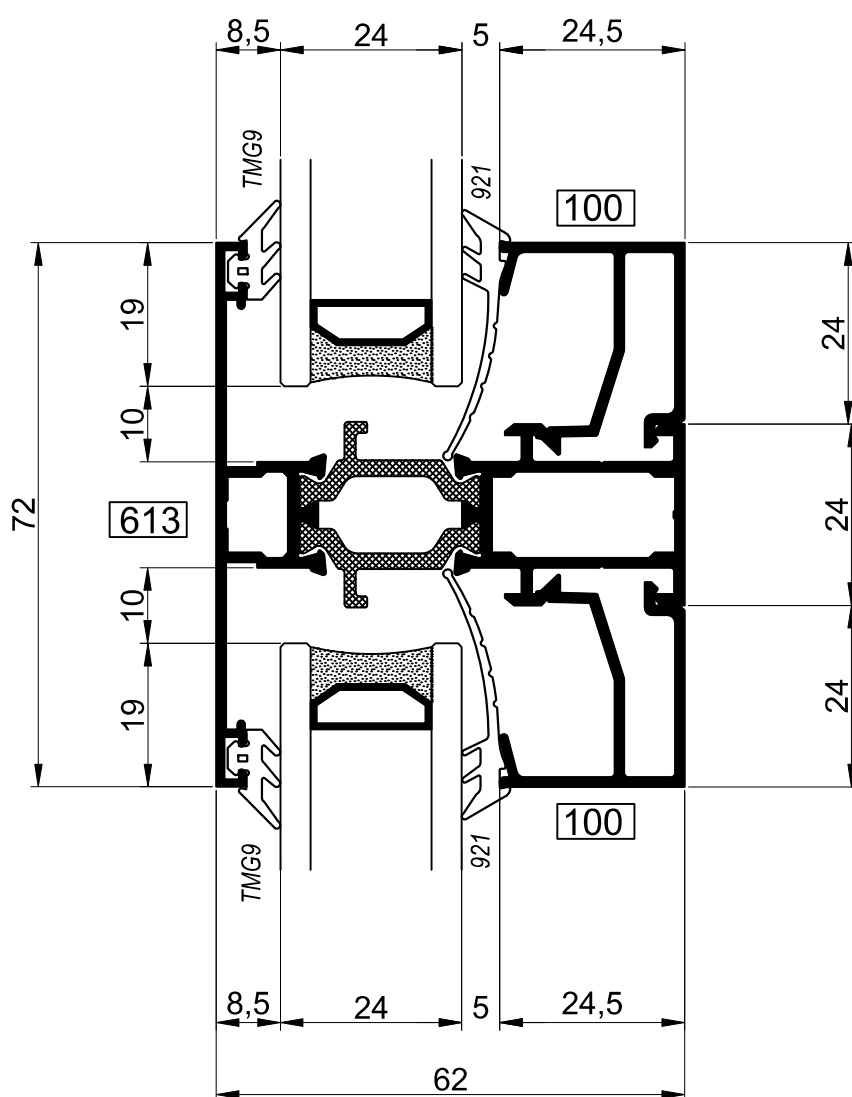
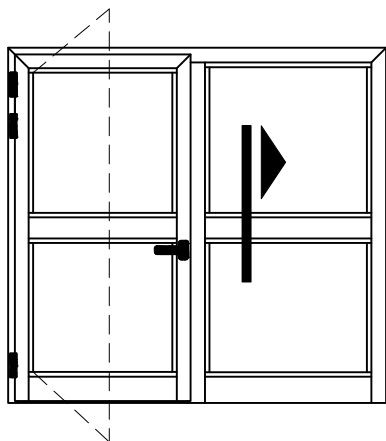


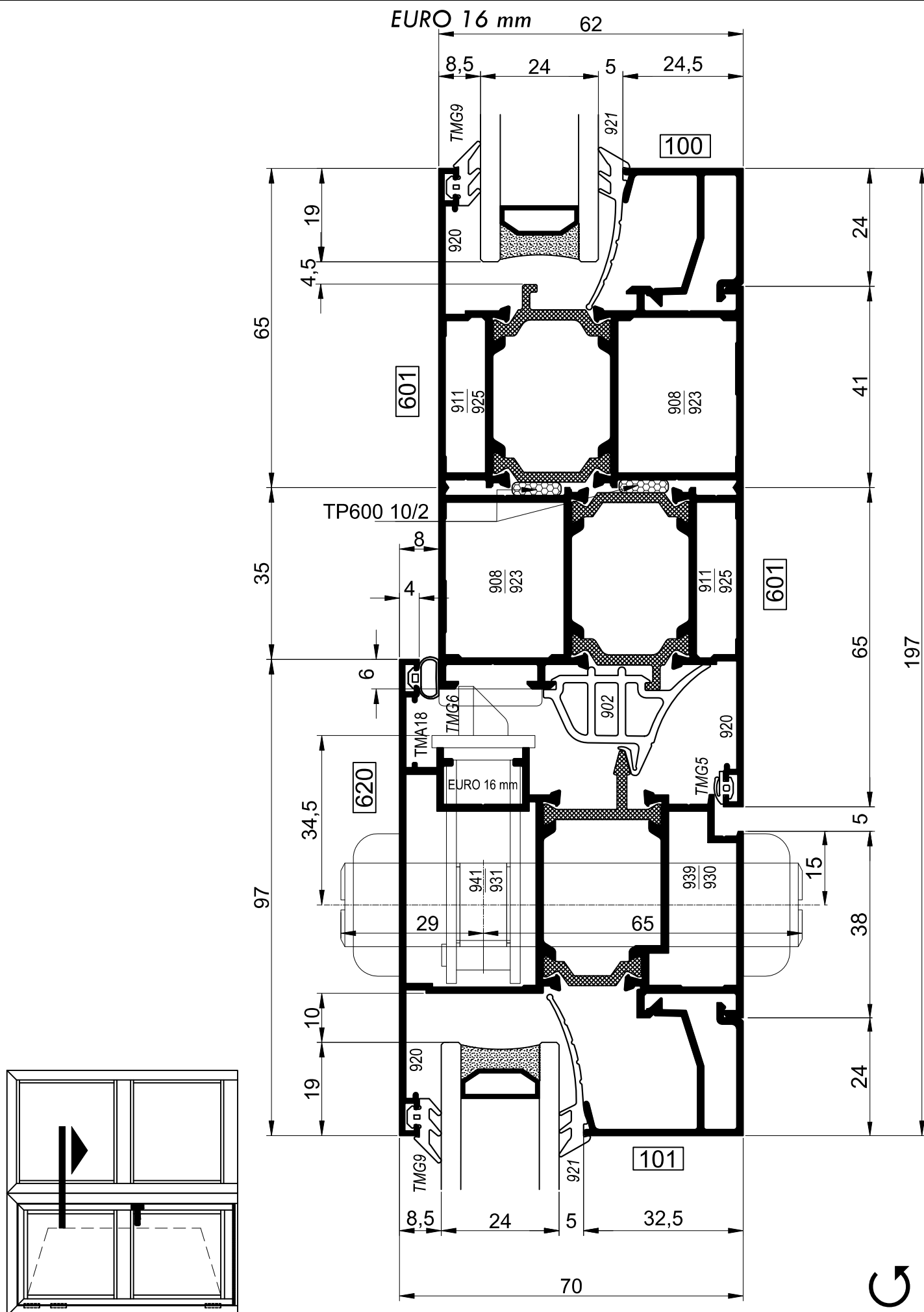
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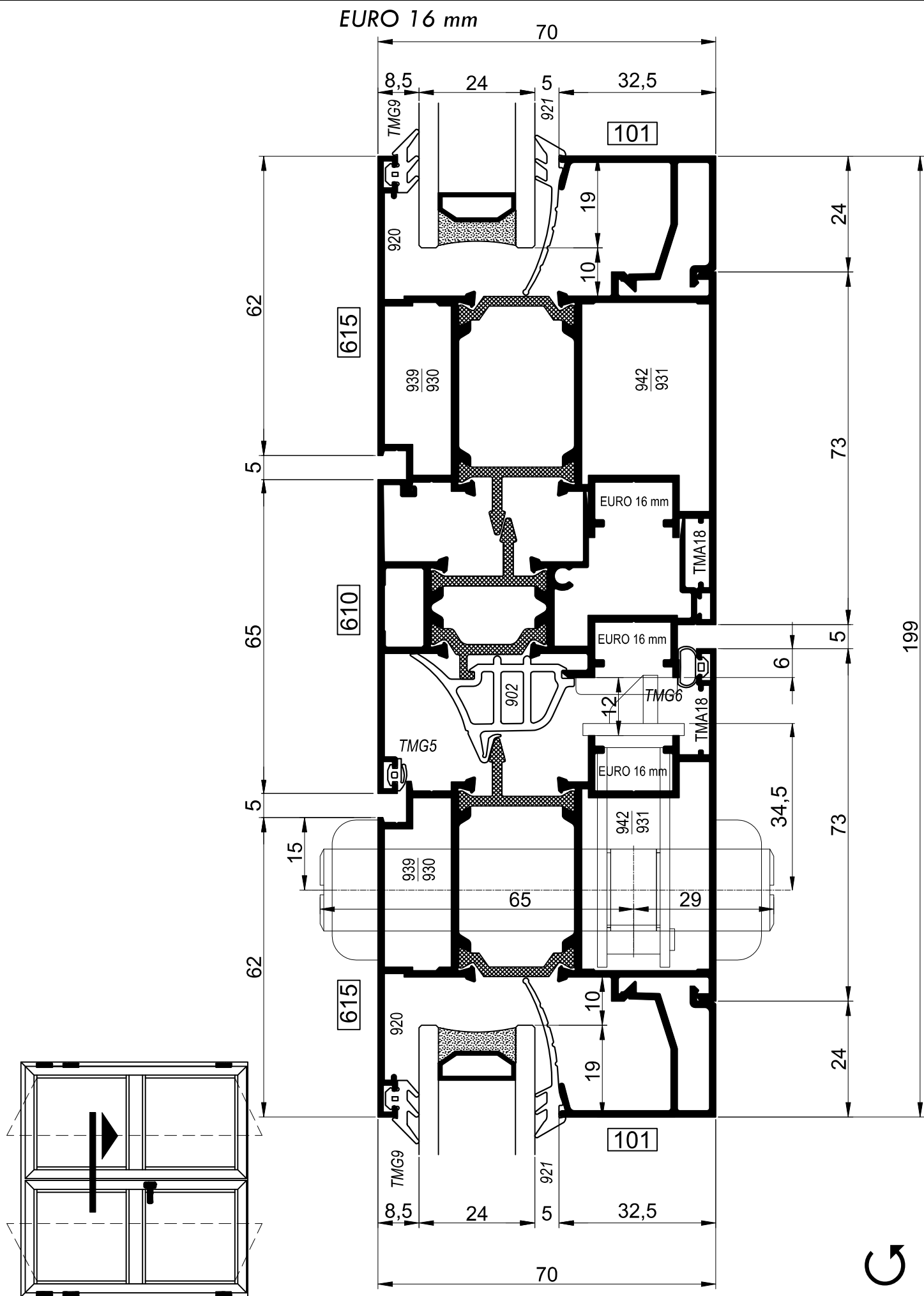


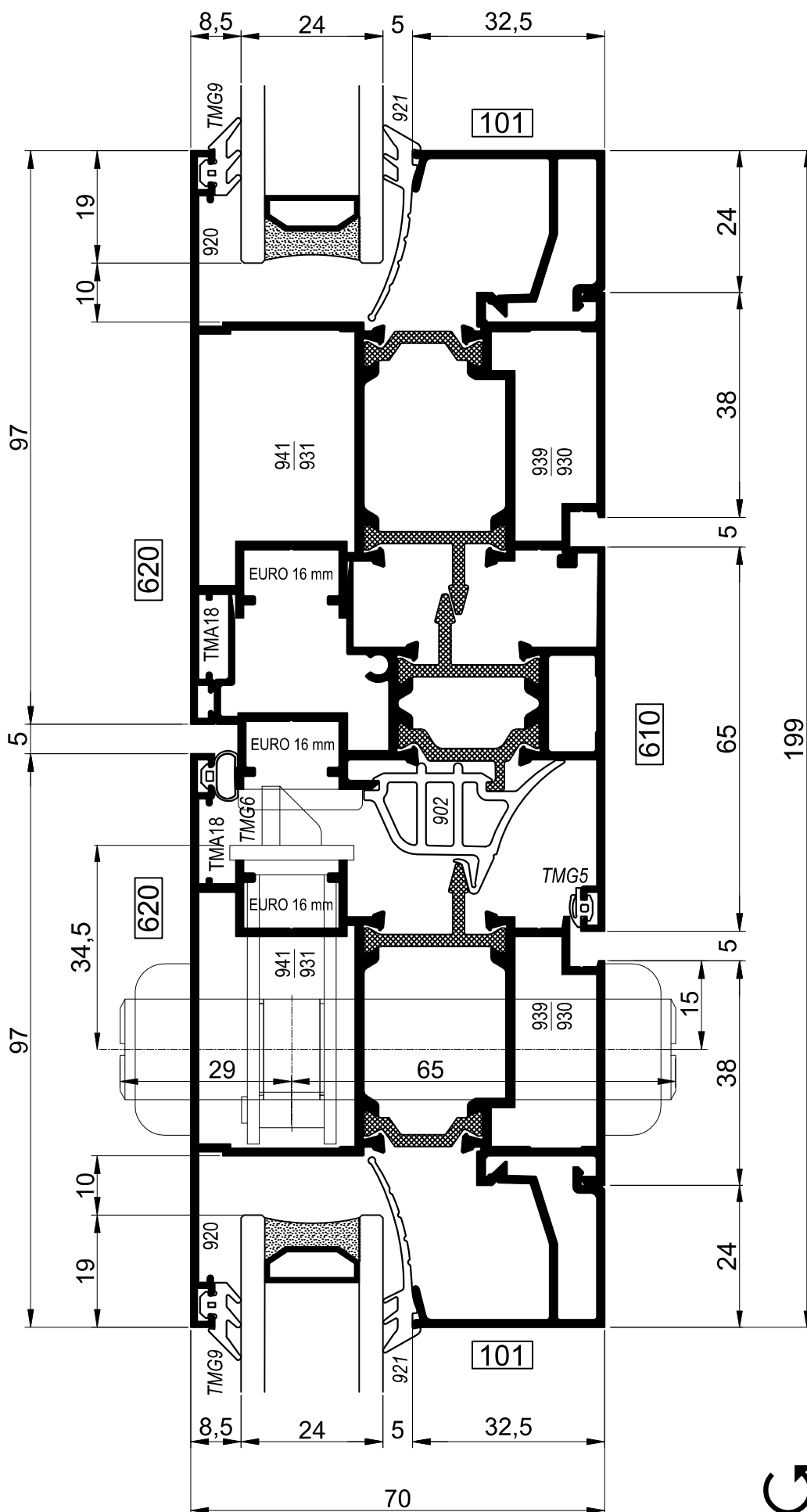
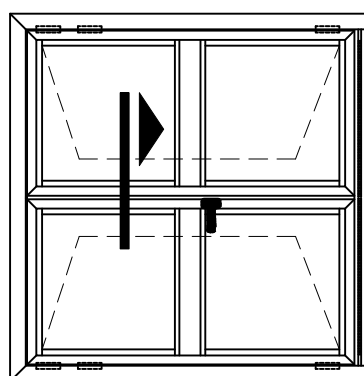


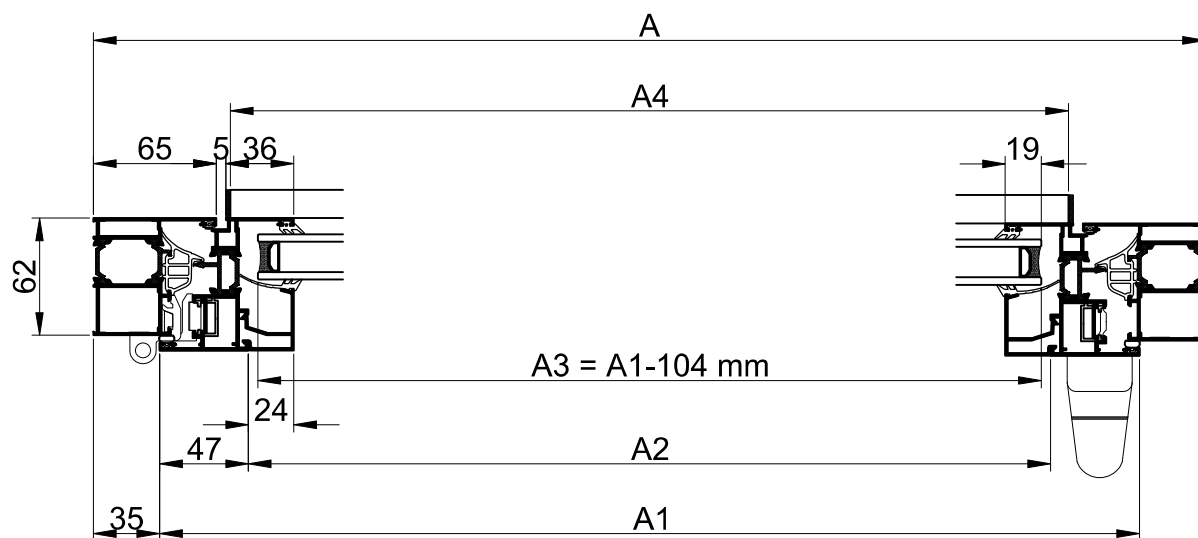
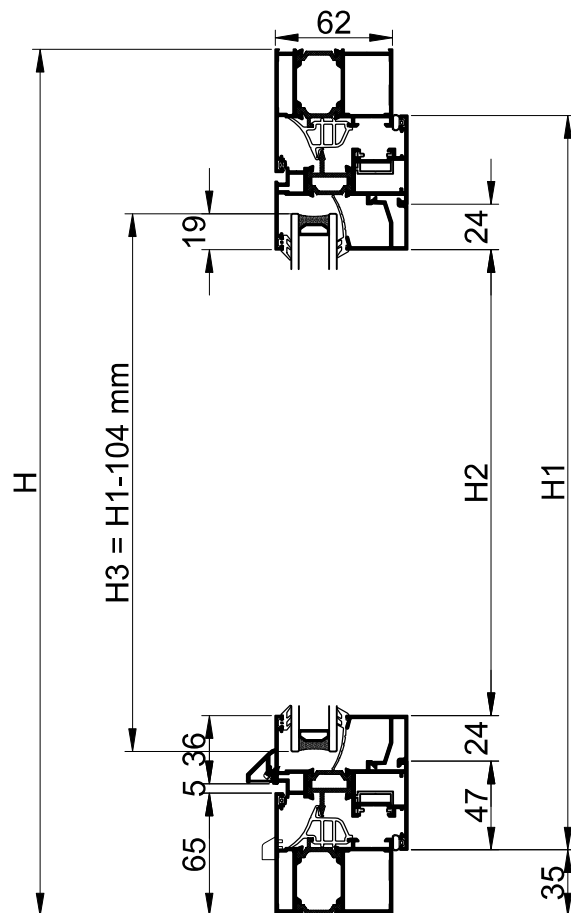
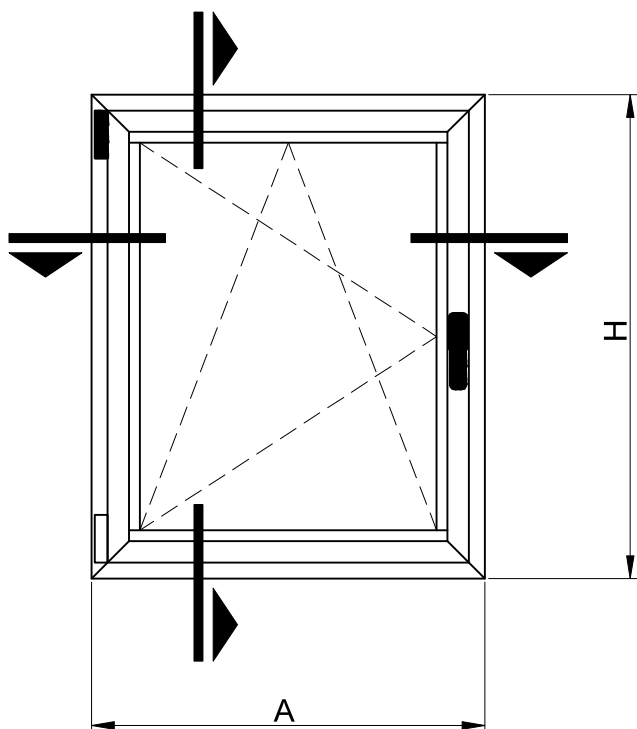
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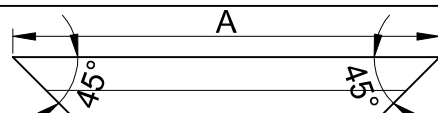
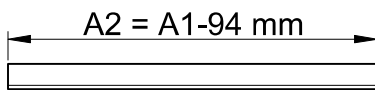
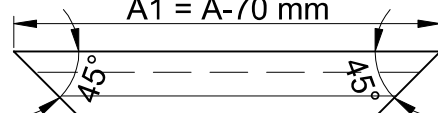
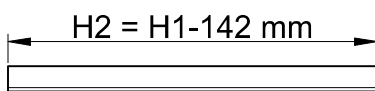
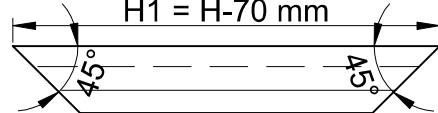
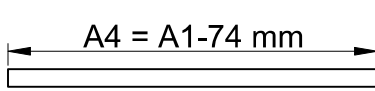


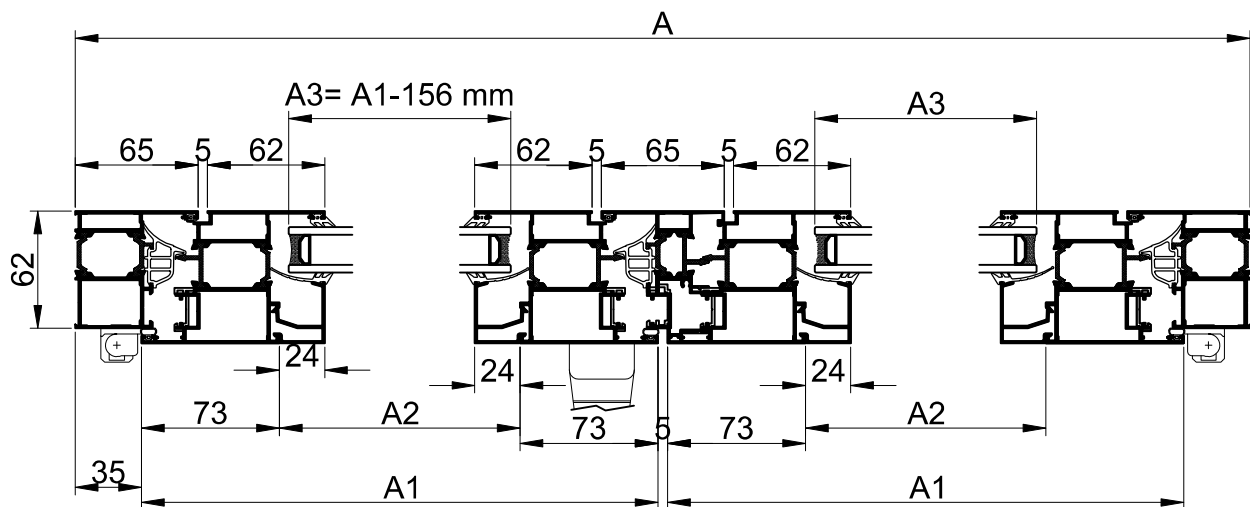
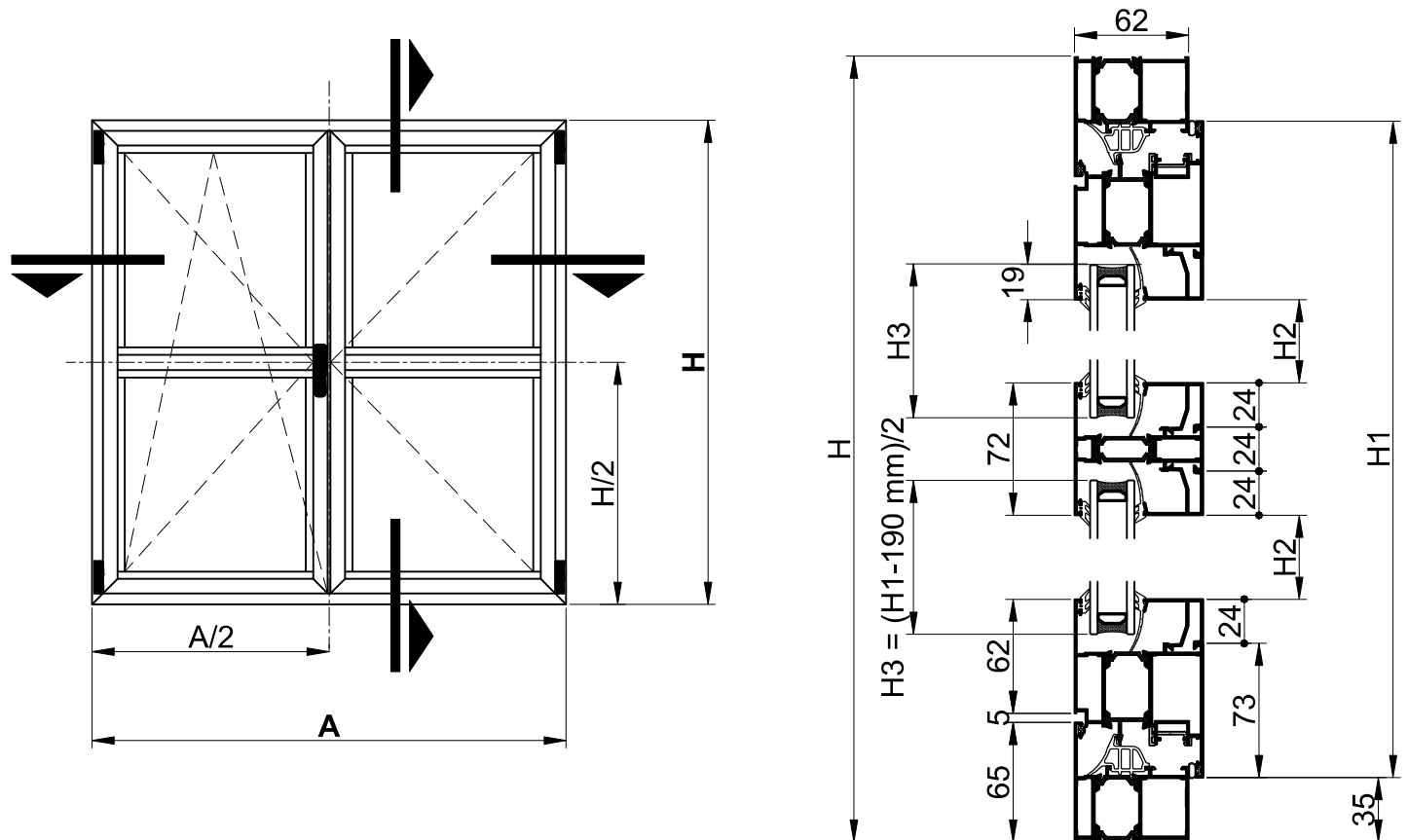




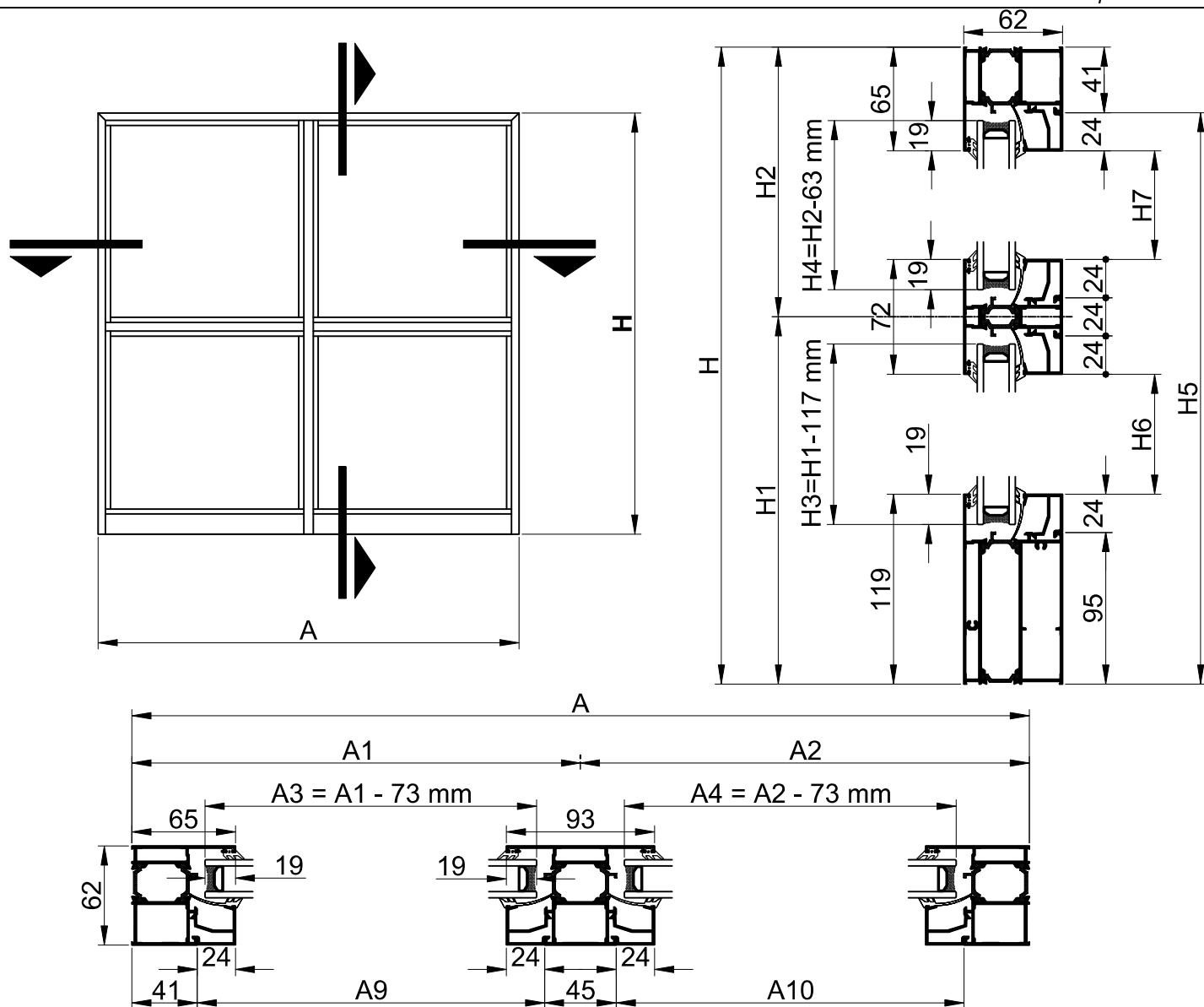




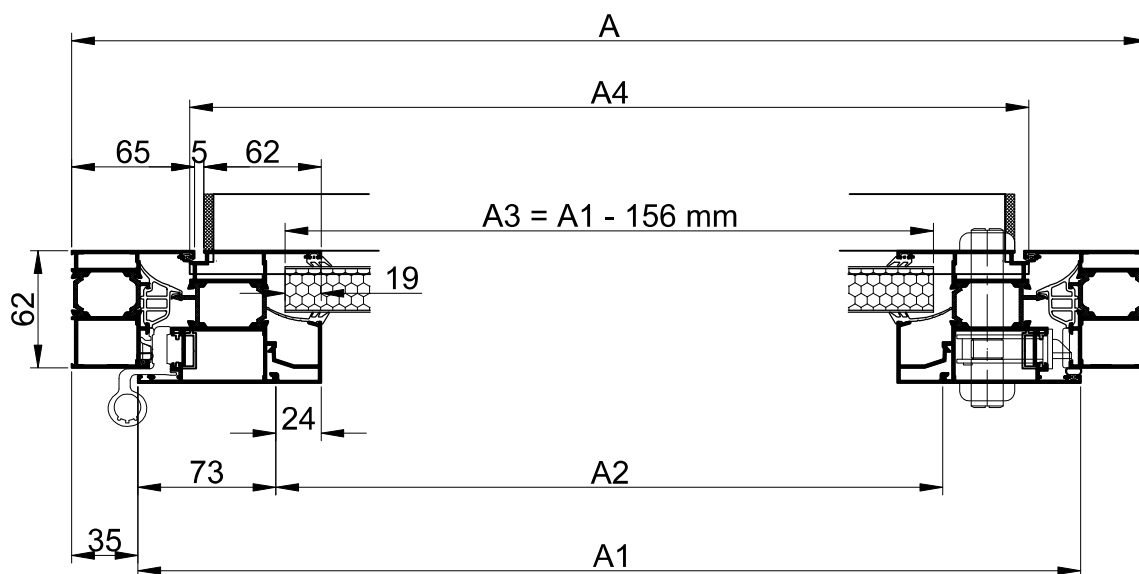
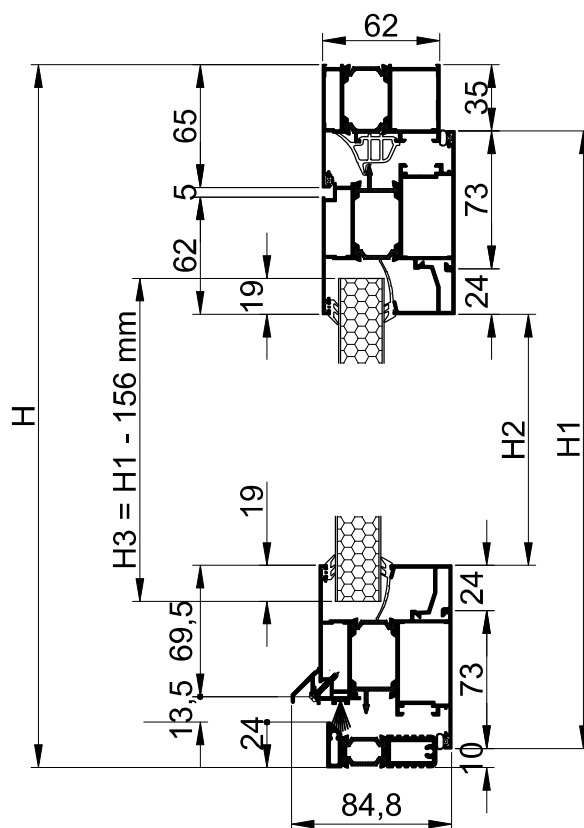
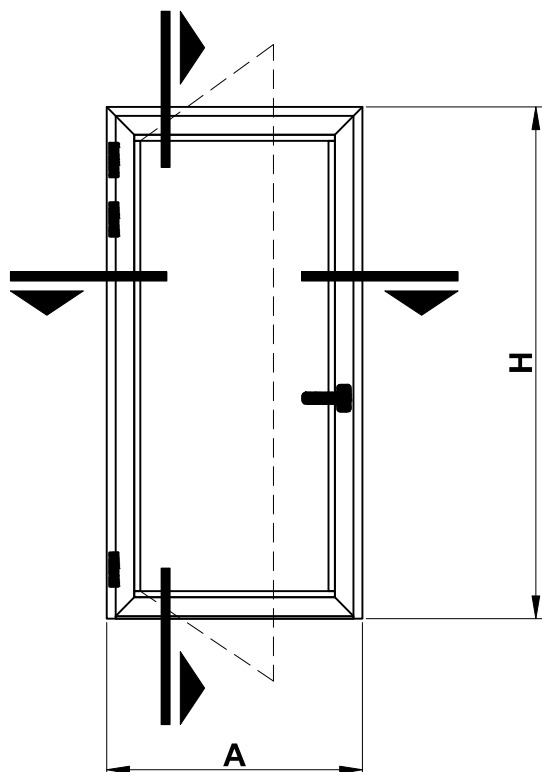
2 x			601			
2 x			601	2 x	 A2 = A1-94 mm 	101
2 x			605 604	2 x	 H2 = H1-142 mm 	101
2 x			605 604	1 x	 A4 = A1-74 mm 	TM36



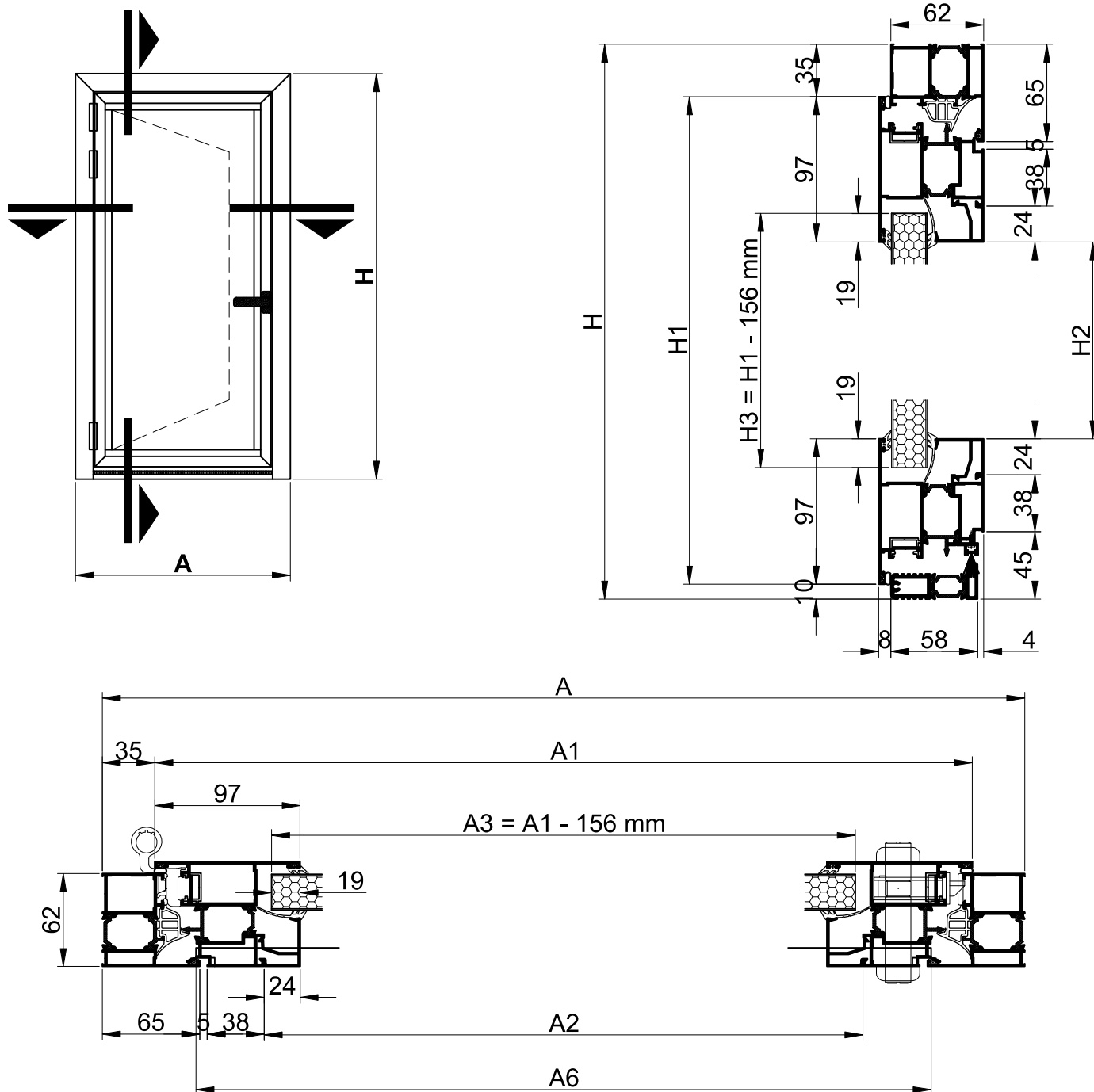
2 x	 A	 601	2 x	 $A_2 = A_1 - 146 \text{ mm}$	 616
2 x	 H	 601	1 x	 $H_4 = H_1 - 74 \text{ mm}$	 609 610
2 x	 $A_1 = (A - 75 \text{ mm})/2$	 614 615	8 x	 $A_2 = A_1 - 146 \text{ mm}$	 101
2 x	 $H_1 = H - 70 \text{ mm}$	 614 615	8 x	 $H_2 = (H_1 - 266 \text{ mm})/2$	 101

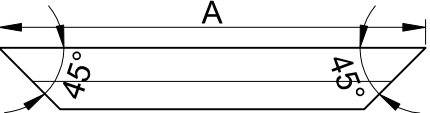
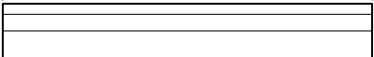
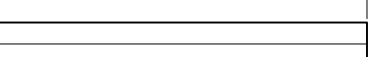
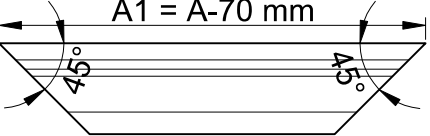
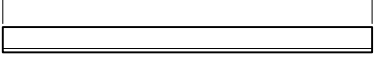
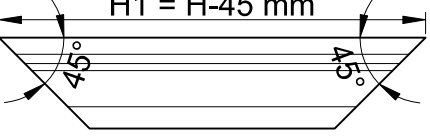
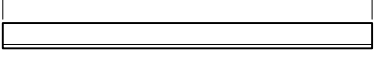


1 x	 $A = A_1 + A_2$	 601	1 x	 $H_5 = H - 41 \text{ mm}$	 602
1 + 1	 $H = H_1 + H_2$	 601	1 x	 $A_9 = A_1 - 63,5 \text{ mm}$	 613
1 x	 $A_9 = A_1 - 63,5 \text{ mm}$	 617	1 x	 $A_{10} = A_2 - 63,5 \text{ mm}$	 613
1 x	 $A_{10} = A_2 - 63,5 \text{ mm}$	 617	4 x	 $A_9 = A_1 - 63,5 \text{ mm}$	 100
			4 x	 $A_{10} = A_2 - 63,5 \text{ mm}$	 100
4 x	 $H_7 = H_2 - 101 \text{ mm}$	 100	4 x	 $H_6 = H_1 - 155 \text{ mm}$	 100



1 x A 45° 601	1 x A5 = A-82 608
1 x 1 H 601	1 x A4 = A1-55 mm TM42
2 x A1 = A-70 mm 45° 614 615	2 x A2 = A1-146 mm 101
2 x H1 = H-45 mm 45° 614 615	2 x H2 = H1-194 mm 101



1 x  A  601	1 x  $A5 = A - 82$  608
1 x 1  H  601	1 x  $A6 = A1 - 55$ mm  TM43
2 x  $A1 = A - 70$ mm  620 619	2 x  $A2 = A1 - 146$ mm  101
2 x  $H1 = H - 45$ mm  620 619	2 x  $H2 = H1 - 194$ mm  101

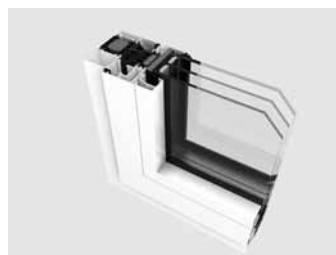
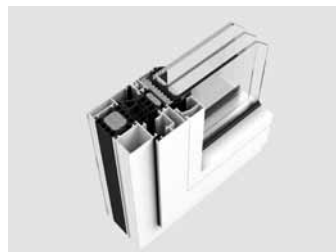
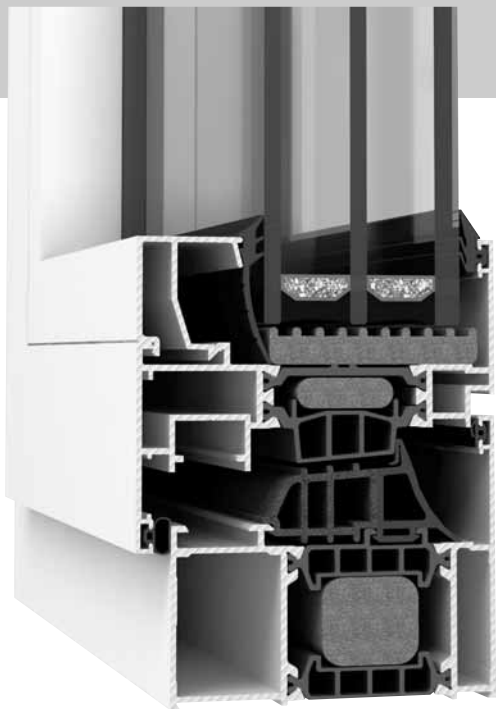
*Sistem
System
Система*

THERM 77

Sistem LINEAL THERM 77

System LINEAL THERM 77

Система LINEAL THERM 77



Tehnički opis sistema

Sistem LINEAL THERM 77 je jedan od šest iz serije LINEAL i predstavlja sistem aluminijumskih profila sa termičkim prekidom, specijalno projektovanih za izradu elemenata prozora i vrata sa ugradnom dubinom štoka od 77mm. Sistem je dizajniran tako da zadovoljava savremene zahteve na polju energetske efikasnosti, kao i ostale uslove nepohodne za bezbedan i udoban radni i životni prostor. Prilikom projektovanja elemenata sistema posebna pažnja je posvećena odabiru materijala koji vrše funkciju termičkog prekida u sklopu sistemskih profila. Na ovaj način su postignute maksimalne termoizolacione karakteristike $U_f \approx 1,34 \text{ W/m}^2\text{K}$, odnosno $U_w \approx 0,93 \text{ W/m}^2\text{K}$.

- Aluminijumski profili su proizvedeni postupkom ekstruzije u pogonima Tehnomarket-a. Sirovina za proizvodnju profila je primarna legura aluminijuma sa oznakom AlMgSi0,5 (AA6063 i 6060) i zateznom čvrstoćom profila od minimalno 210KN/mm².
- Poliamidne trake (PA 6,6 sa 25% staklenih vlakana) širine 39mm međusobno spajaju spoljašnje i unutrašnje aluminijumske delove u gotove profile, a pored funkcije mehaničkog spajanja, obezbeđuju i termički prekid. Garantovana sila smicanja spoljnog i unutrašnjeg aluminijumskog profila, povezanih poliamidnim trakama, se kontroliše u toku proizvodnje.
- Pojačana termička svojstva postignuta su dodatno putem suđerastih ispuna u slobodnim komorama u zoni poliamida, kao i primenom posebne koekstrudirane srednje zaptivke.
- Izolaciona svojstva sistema potvrđena su kroz rezultate ispitivanja toplotnih performansi. Takođe, ispitivanja su urađena i za otpornost na udare vetra, propuštanje vazduha i vode, kao i za zvučnu izolaciju.
- Sistem omogućava ugradnju standardnog okova u EURO 1 žljeb i okova za PVC u EURO 16mm žljeb.
- Sistem podržava ispune uključujući i staklo pakete od 23 do 55mm sa EPDM zaptivkama koje poseduju integrisanu barijeru protiv produvanja.
- Zaptivanje u zoni spoja štoka i krila je trostruko, preko tri trajno elastične EPDM zaptivke otporne na UV zračenje.
- Spajanje uglova pomoću ekstrudiranih patent spojnice ili spojnice za presovanje obezbeđeno je zatezanjem u svim komorama profila, što obezbeđuje siguran ugaoni spoj i preciznu geometriju gotovih elemenata.
- Kanalisanje kondenza i incidentne vode je regulisano preko slobodnih ravnih površina u komorama, dok je ventilisana spoljna komora duboka 20mm.
- Osnovna spoljašnja dimenzija štoka od 65mm omogućava idealan prihvatač vođica roletne i komarnika. Unutrašnja širina štoka obezbeđuje idealan prostor za sabirnik trake roletne.

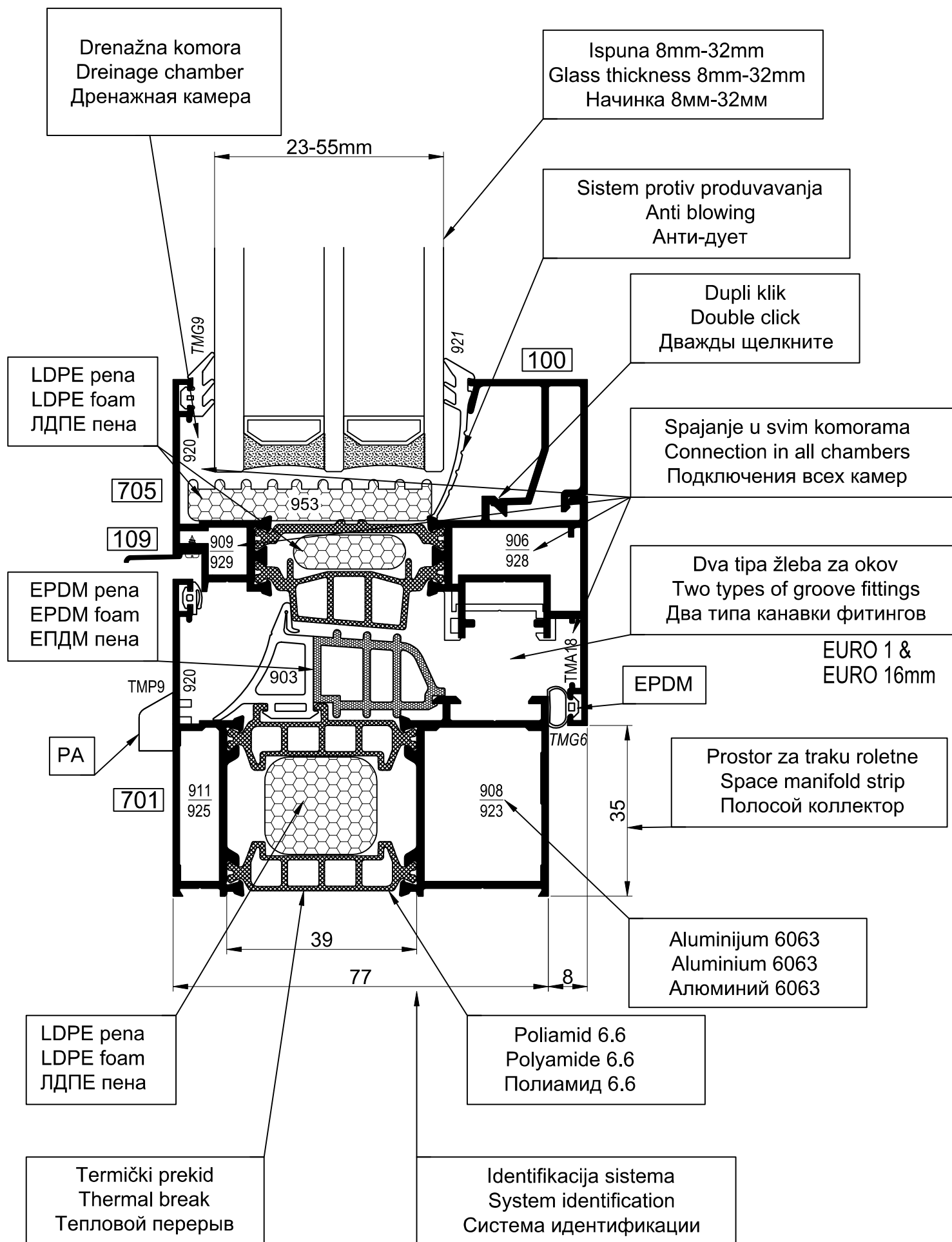
System LINEAL THERM 77 is one of six from LINEAL series and it represents aluminium profile system with thermal break, specially designed for manufacturing of windows and doors with frame depth of 77mm. System is designed to satisfy all contemporary demand for energy efficiency, as well as all other requirements for safe and comfortable living and working environment. Special attention was addressed to selection of materials that for the thermal break within the profile. This way, maximal isolation values of $U_f \approx 1,34 \text{ W/m}^2\text{K}$, or $U_w \approx 0,93 \text{ W/m}^2\text{K}$, were achieved.

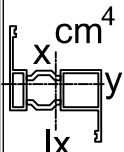
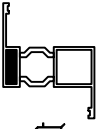
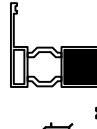
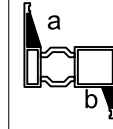
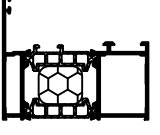
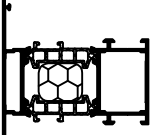
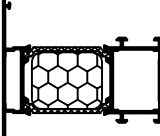
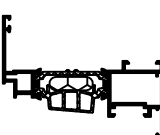
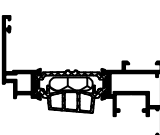
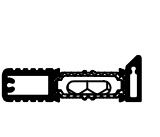
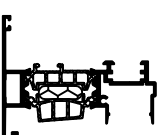
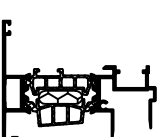
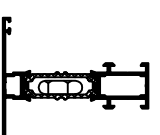
- Aluminium profiles were manufactured in Tehnomarket's own extrusion factory. The raw material used is primary aluminium alloy AlMgSi0.5 (AA6063 and AA6060) with minimum tensile strength of 210 KN/mm^2 .
- 39mm wide Polyamide stripes (PA 6,6 with 25% glass fibers) connect inner and outer aluminium parts into finished profiles, and beside functioning as a mechanical bond they also provide a thermal break. Guaranteed shearing force for profiles connected with polyamide stripes is strictly controlled during production.
- Exceptional thermic performance was achieved with foam - filled chambers in polyamide area, and with special, dual/material coextruded central gasket.
- Insulating performance of the complete system was confirmed through thermal performance testing. At the same time, wind load, air and water permeability and sound insulation were tested as well.
- System is compatible with both EURO 1 and EURO 16mm groove standards for hardware installation.
- System allows glass packages from 23 to 55mm with EPDM gaskets that feature integrated anti-blowing barrier.
- The triple sealing between frame and sash is achieved with three separate EPDM gaskets resistant to UV light.
- Corner joining with extruded patent or press clips is achieved through all profile chambers, thus guaranteeing secure and precise joints and finished element geometry.
- Drainage of condensed and incidental water is regulated via free flat surfaces in profile chambers, while ventilated outer chamber features optimal width of 20mm.
- Basic outer frame width of 65mm allows for an ideal mounting surface for optimal placement of mosquito net and roll-shutter's guides. Internal width of the frame provides an ideal space for tape coiler.

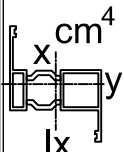
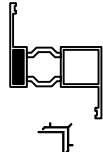
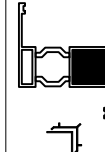
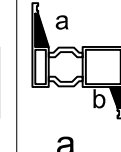
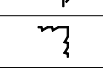
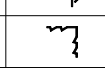
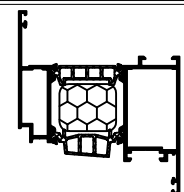
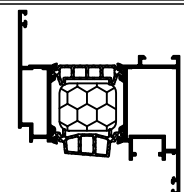
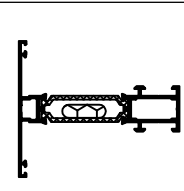
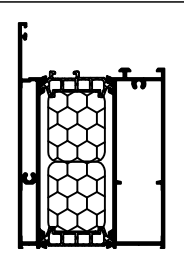
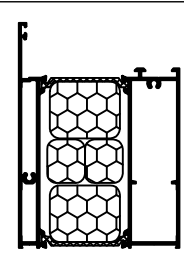
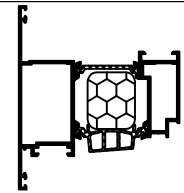
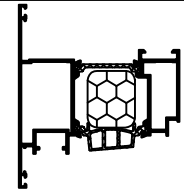
Техническое описание системы

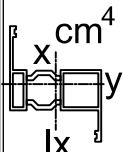
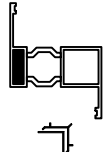
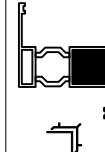
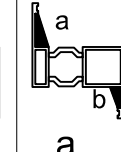
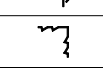
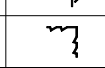
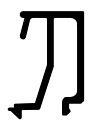
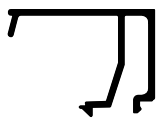
Система LINEAL THERM 77 - одна из шести систем серии LINEAL и представляет систему алюминиевых профилей с термическим разрывом, специально разработанная для производства элементов окон и дверей с монтажной глубиной косяка от 77mm. Система разработана для удовлетворения современных требований в области энергоэффективности, как и другие необходимые условия для безопасного и комфортного рабочего и жилого пространства. При проектировании элементов системы, особое внимание было уделено выбору материалов, которые выполняют функцию теплового разрыва внутри профиля. Таким образом, достигнуты максимальные теплоизоляционные свойства $U_f \approx 1,34 \text{ W/m}^2\text{K}$ и $U_w \approx 0,93 \text{ W/m}^2\text{K}$.

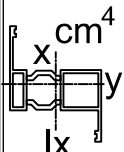
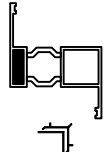
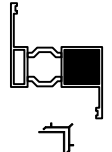
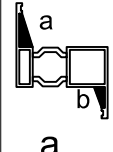
- Алюминиевые профили изготовлены способом экструзии в производственных цехах Техномаркета. Сырьем для производства профилей является первичный алюминиевый сплав с обозначением AlMgSi0,5 (AA6063 и 6060) и с минимальной прочностью на разрыв профиля 210 KN/mm^2 .
- Полиамидные полоски (PA 6,6 с 25% стекловолокна) шириной 39mm и сотовые мульти камерные структуры взаимосвязывают внешние и внутренние алюминиевые части в готовых профилях, а кроме функции механического соединения и обеспечивают и тепловой разрыв. Гарантированная сила сдвига внешнего и внутреннего алюминиевого профиля, которые связаны полиамидными полосками, контролируется в процессе производства. Усиление термических свойств, достигается дополнительно путем губчатых заполнений в свободных камерах в зоне полиамида, как и применением отдельной коэкструдированной средней прокладки.
- Изоляционные свойства системы подтверждены результатами испытания тепловых характеристик. Кроме того, были проведены испытания устойчивости на удары ветра, пропуск воздуха и воды, как и звукоизоляции.
- Система позволяет установку стандартных оков в EURO 1 желоб и оков для PVC в EURO 16mm желоб.
- Система поддерживает и заполнения, включая и стеклопакеты от 23 до 55mm, с EPDM прокладками, которые имеют интегрированный барьер против выдувания.
- Уплотнение в зонах соединений косяка и створки - трехрядное, с тремя постоянно упругими прокладками EPDM, которые устойчивы к UV-излучению.
- Сцепление углов, с помощью экструдированных сцепных устройств или сцепных устройств для прессовки, обеспеченное затяжкой во всех камерах профиля, что обеспечивает надежное соединение углов и точную геометрию готовых элементов.
- Направление конденсации и случайных вод регулируется через свободные ровные поверхности в камерах, в то время как вентилируемая внешняя камера имеет глубину 20mm.
- Основной внешний размер косяка от 65mm позволяет идеальный прием направляющей жалюзи и противомоскитных сеток. Внутренняя ширина косяка обеспечивает идеальное место для коллектора полосок жалюзи.

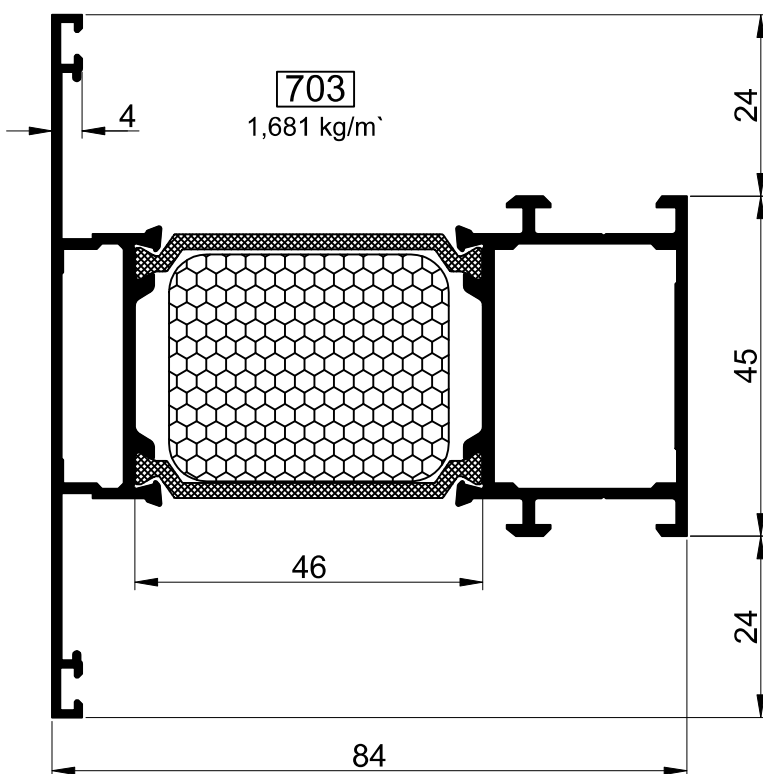
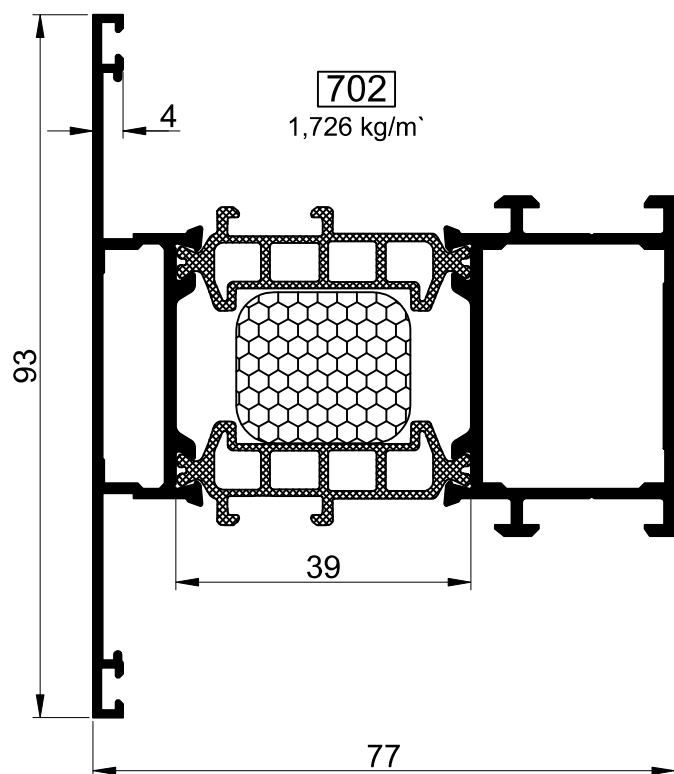
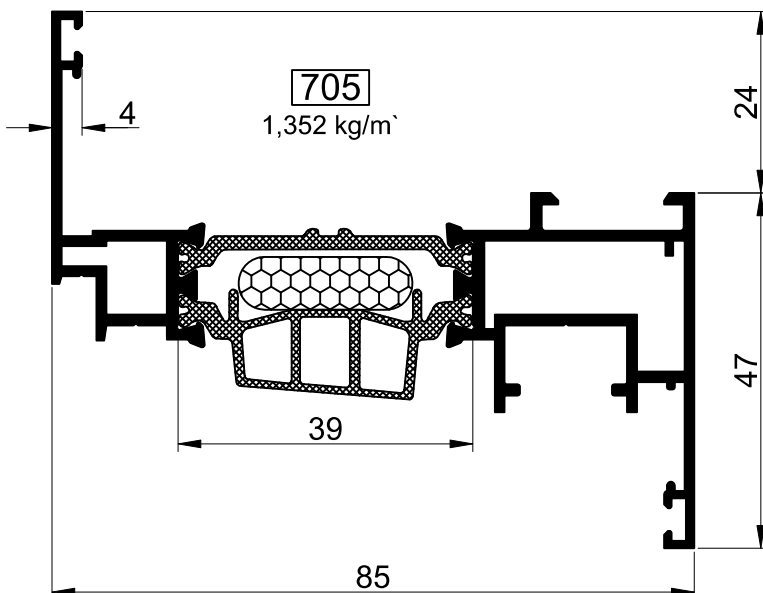
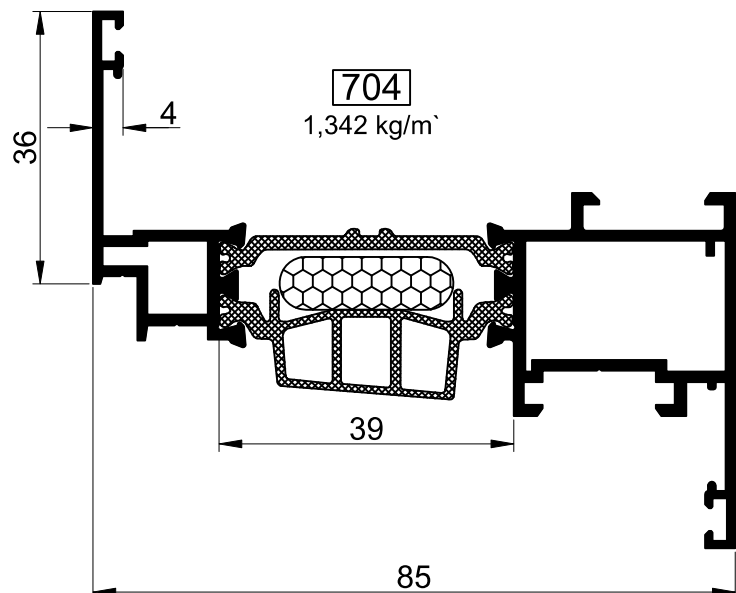
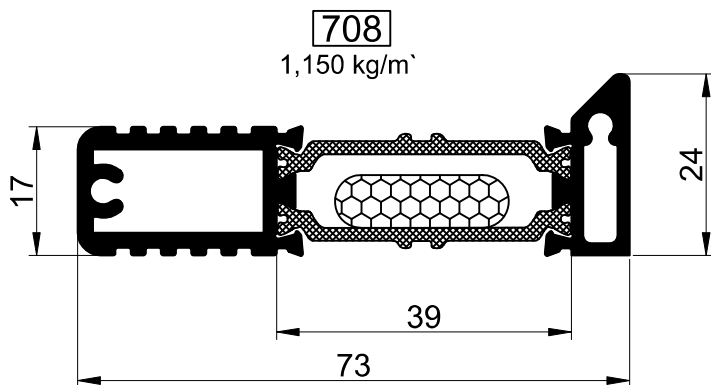
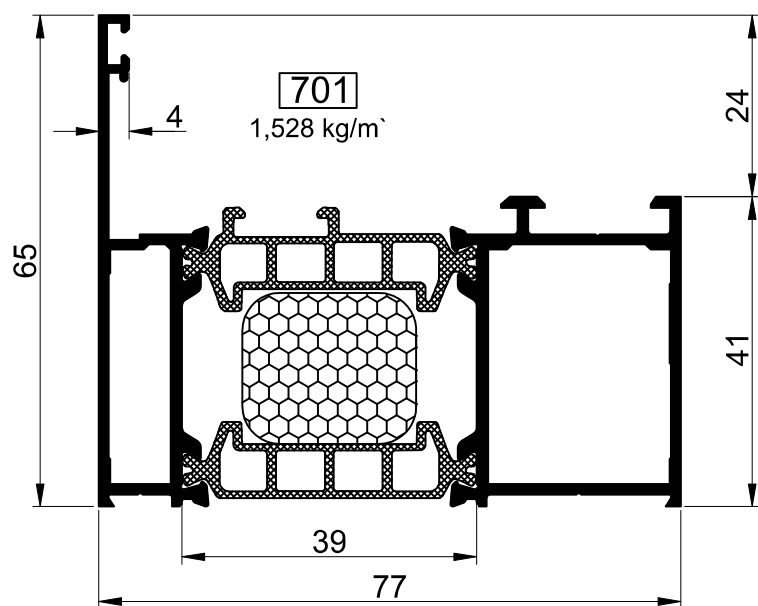


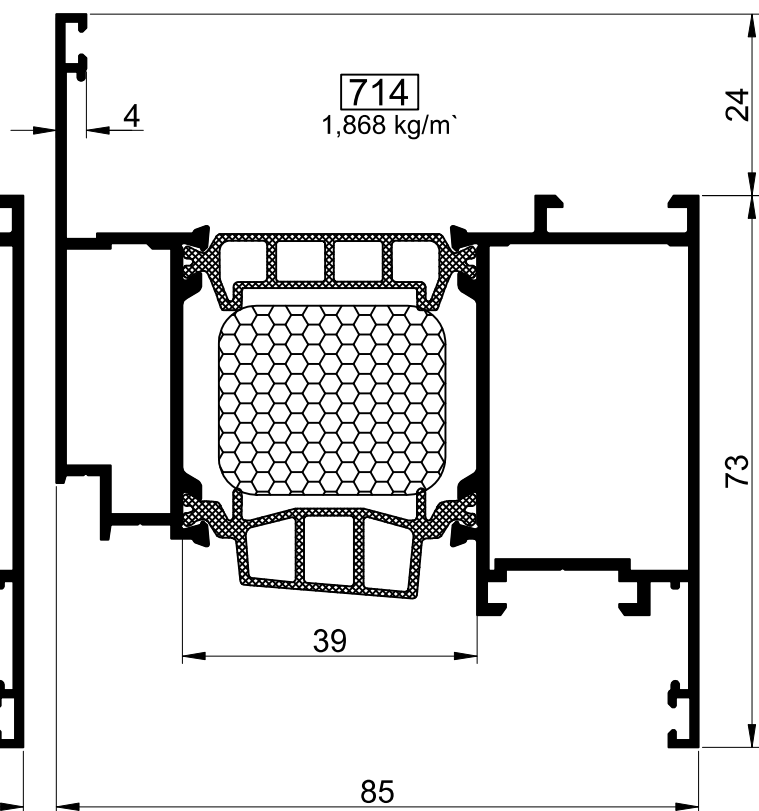
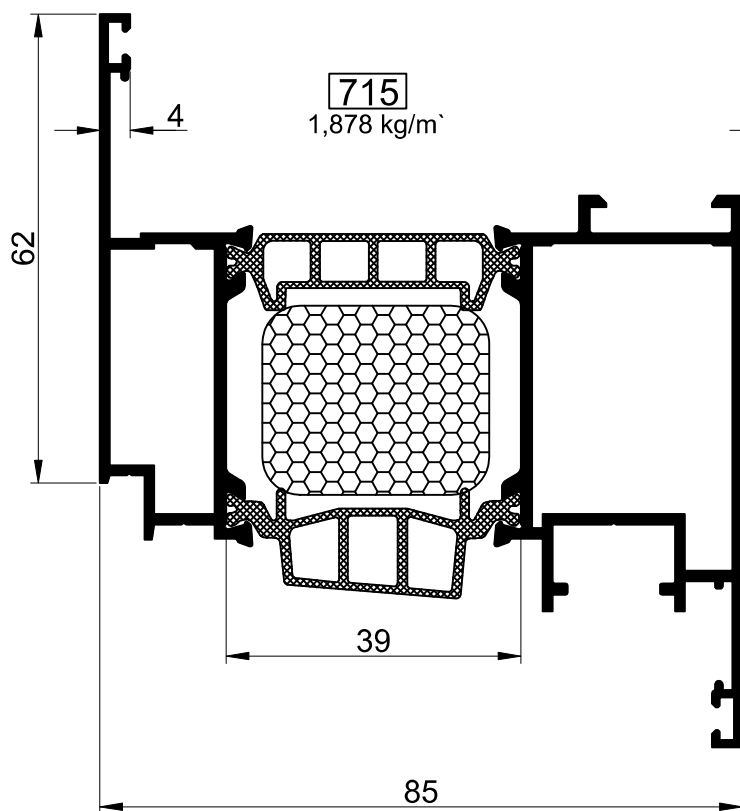
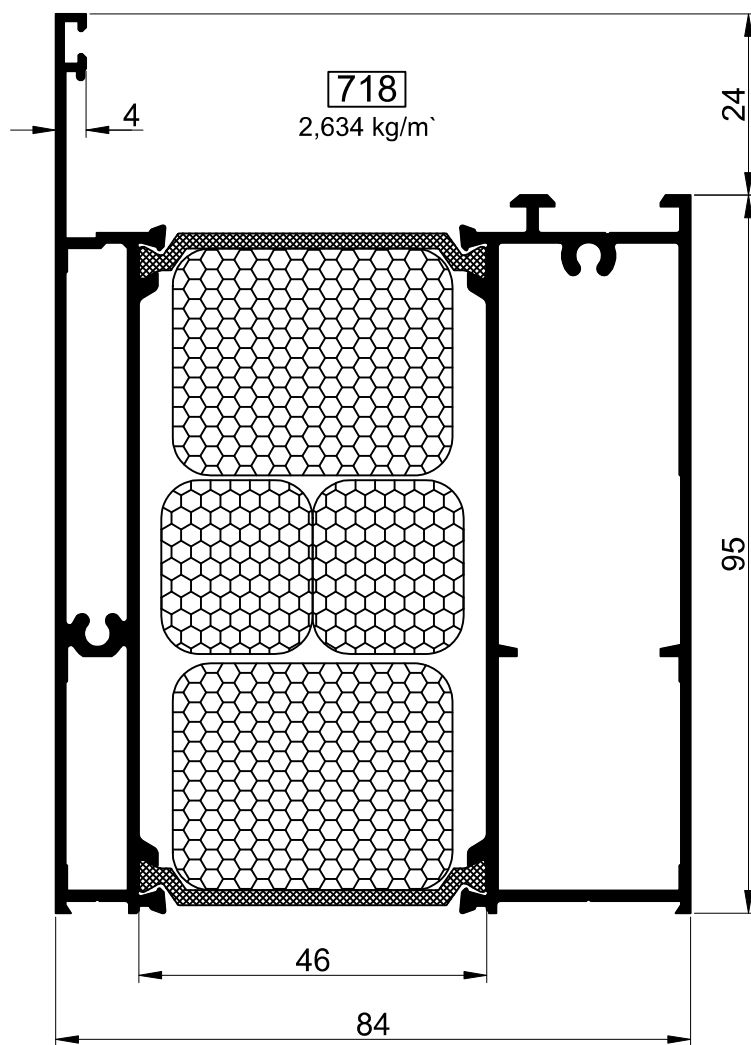
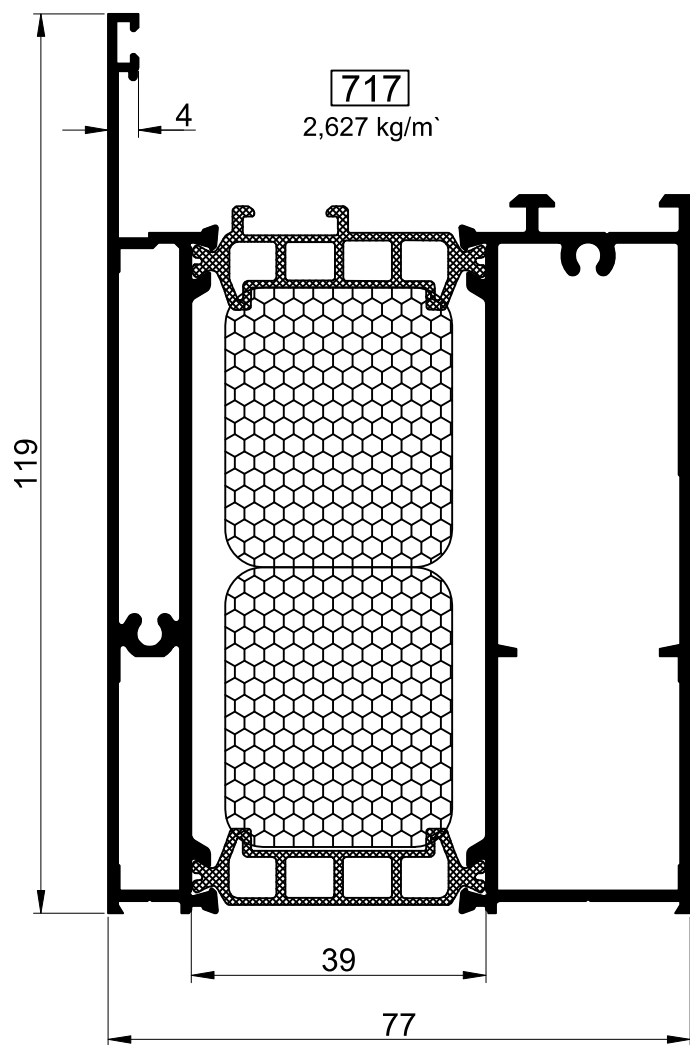
	Oznaka Mark Марк	Opis Description Описание	 cm ⁴			 a b
	kg/m`		ly			
	701	Štok Frame	36,761	911	908	920
	1,528	Рама	10,844	925	923	
	702	Prečka u štoku T profile in frame	43,569		915	
	1,726	T профил в раме	18,699		905	
	703	Prečka u krilu T profile in casement	53,905		915	
	1,681	T профил в створки	18,699		905	
	704	Prozorsko krilo - EURO 1 Casement -EURO 1	42,021	909	907	920
	1,222	Оконная створка -ЕУРО 1	4,549	929	926	TMA18
	705	Prozorsko krilo - EURO 16mm Casement -EURO 16mm	42,119	909	906	920
	1,342	Оконная створка -ЕУРО 16мм	4,350	929	928	TMA18
	708	Prag Threshold	24,746			
	1,152	Порог	1,353			
	709	Veza dvokrilnog prozora - EURO 1 French casement adaptor -EURO 1	32,481			
	1,375	Соединительный профиль двойного окна -ЕУРО 1	6,066			
	710	Veza dvokrilnog prozora - EURO 16mm French casement adaptor -EURO 16mm	32,007			
	1,377	Соединительный профиль двойного окна -ЕУРО 16мм	6,303			
	713	Prečka u štoku T profile in frame	31,819		922	
	1,203	T профил в рамке	6,652		905	

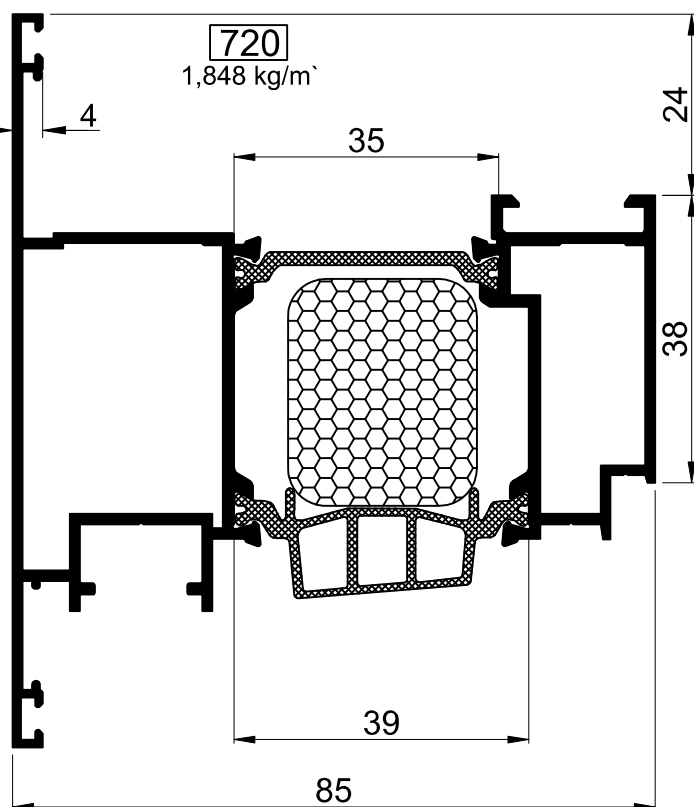
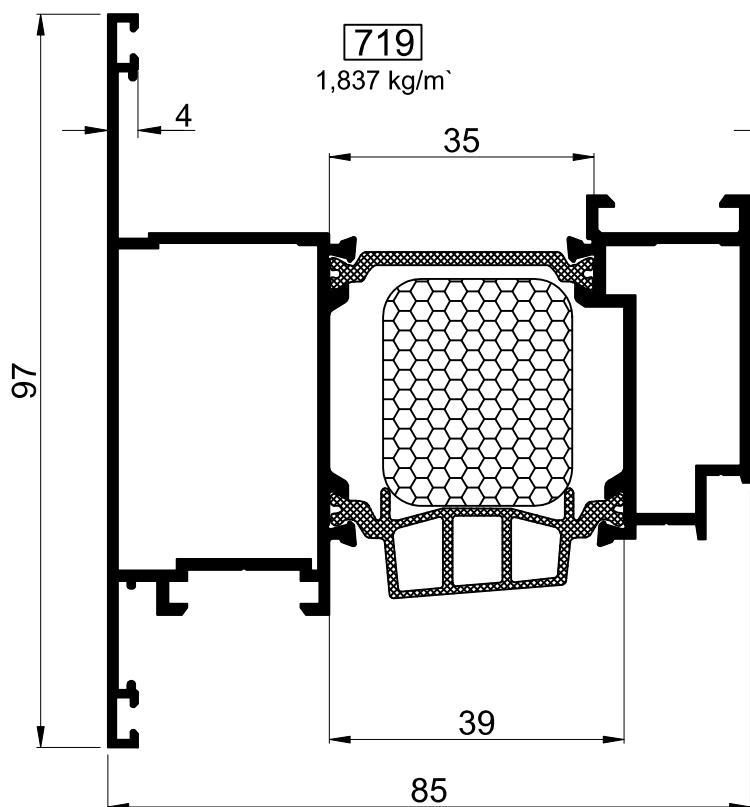
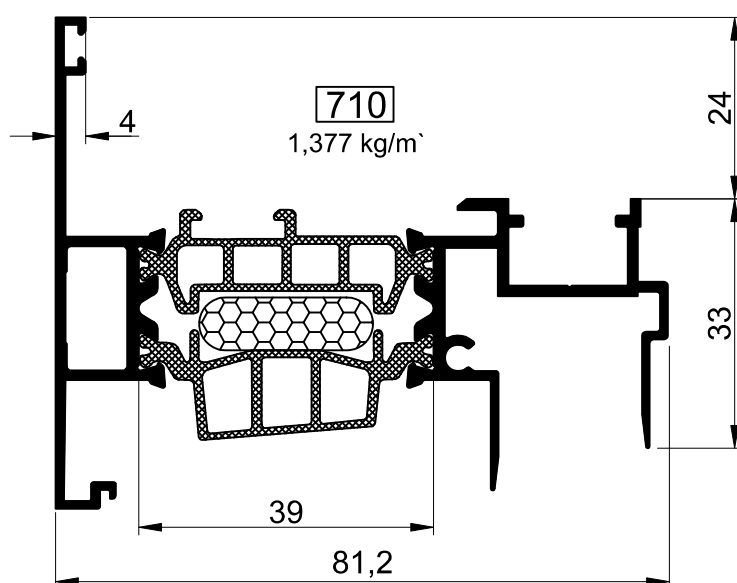
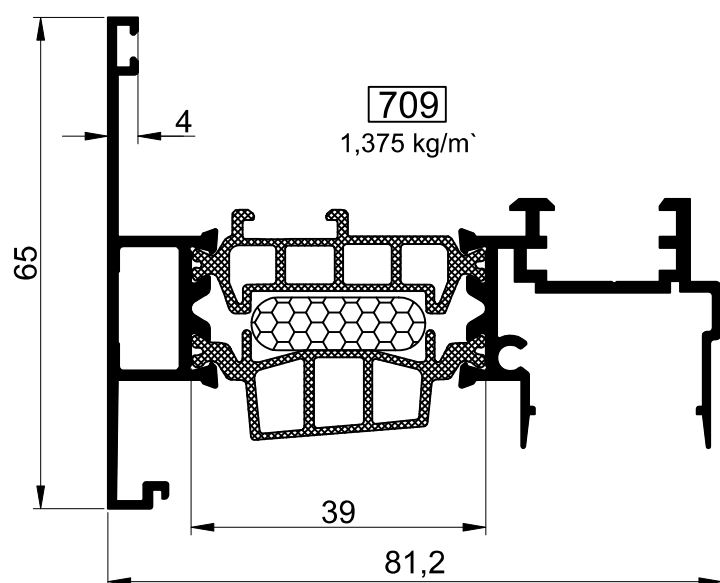
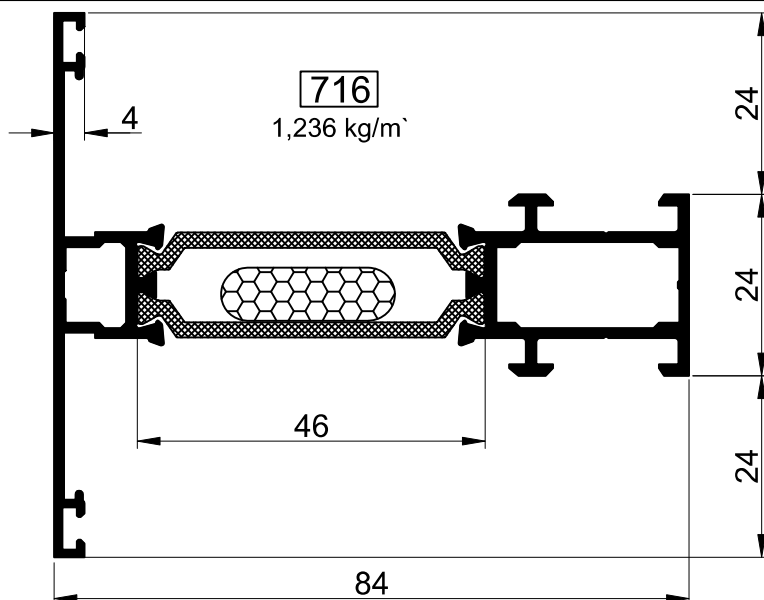
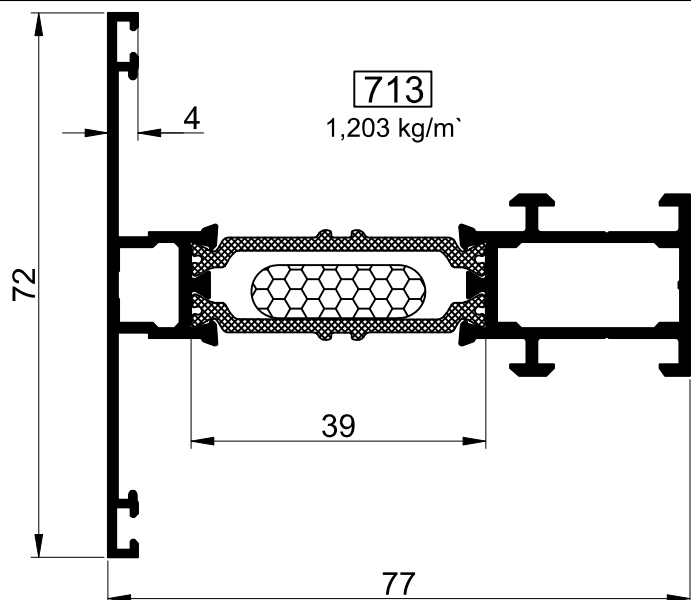
	Oznaka Mark Марк	Opis Description Описание				
	kg/m`		ly			a b
	714	Krilo vrata -otvaranjem unutra- EURO 1 Door leaf -open in -EURO 1	61,532	939	940	920
	1,868	Крыло двери, открывающиеся внутрь -ЕУРО1	19,056	930	932	TMA18
	715	Krilo vrata -otvaranjem unutra- EURO 16mm Door leaf -open in -EURO 16mm	61,934	939	941	920
	1,878	Крыло двери, открывающиеся внутрь -ЕУРО16мм	18,511	930	931	TMA18
	716	Prečka u krilu T profile in casement	39,382		922	
	1,236	Препятствие в створки	6,652		905	
	717	Parapetni profil u štoku / Veliki štok Parapet profile in frame / Large frame	67,677	911	908	920
	2,627	Парапет профиль в рамке большой рам	84,354	925	923	
	718	Parapetni profil u krilu Parapet profile in casement	87,638		915	
	2,634	Парапет профиль в створки	80,655		905	
	719	Krilo vrata -otvaranjem spolja- EURO 1 Door leaf -open out -EURO 1	54,668	939	940	920
	1,837	Крыло двери, открывающиеся наружу -ЕУРО1	24,527	930	932	TMA18
	720	Krilo vrata -otvaranjem spolja- EURO 16mm Door leaf -open out -EURO 16mm	55,132	939	942	920
	1,848	Крыло двери, открывающиеся наружу -ЕУРО16мм	23,753	930	933	TMA18

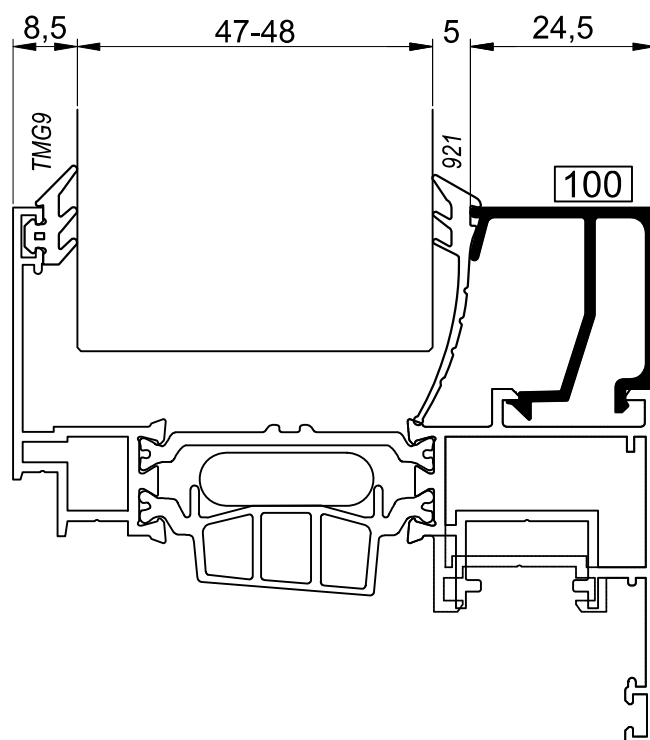
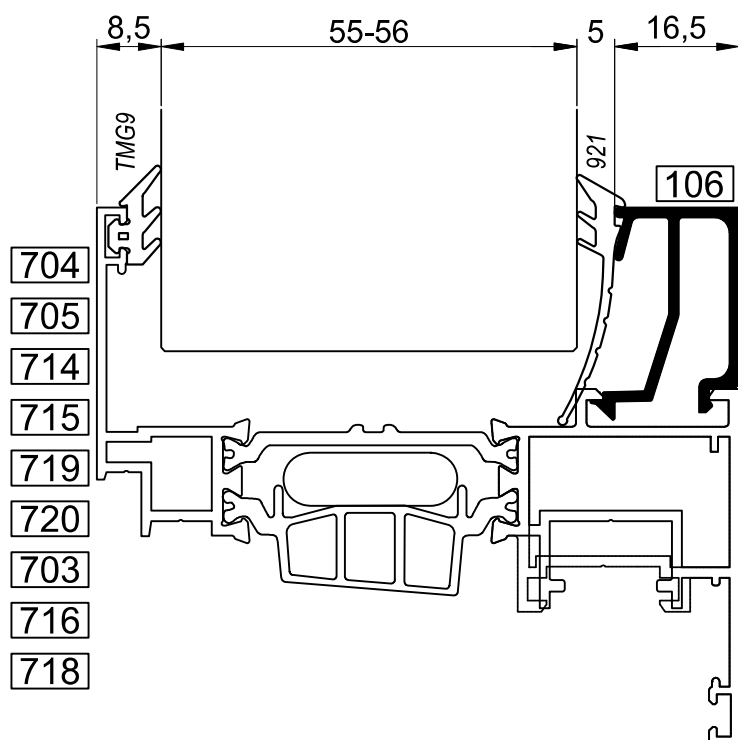
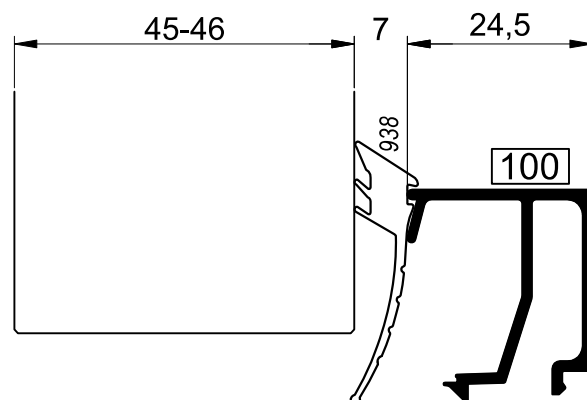
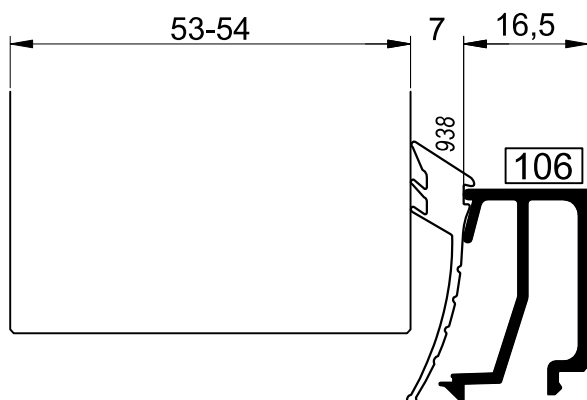
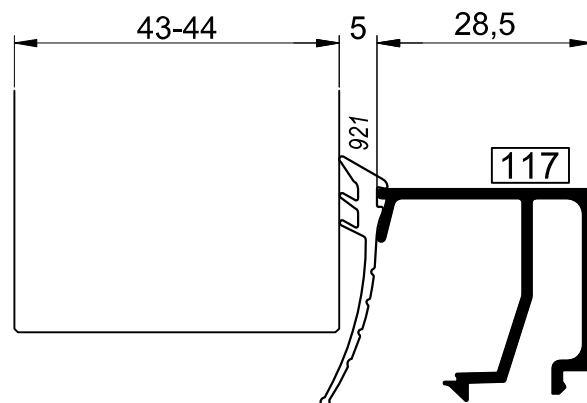
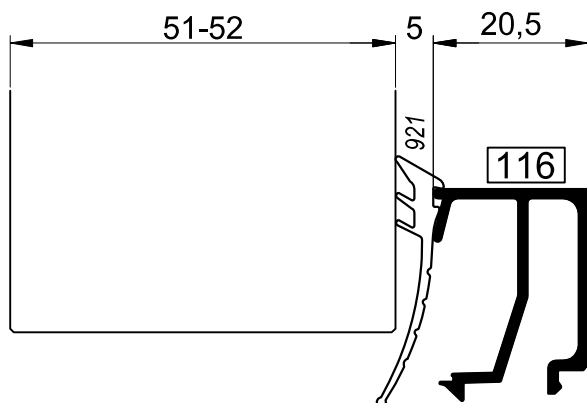
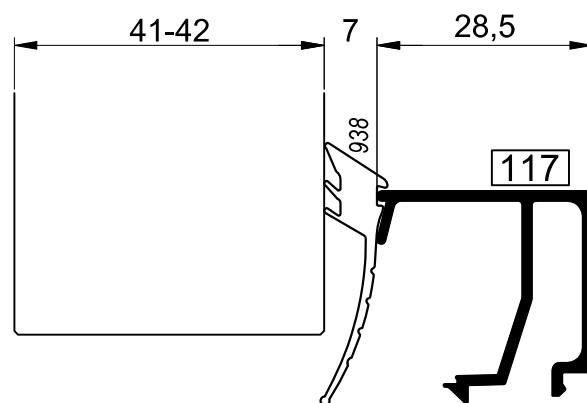
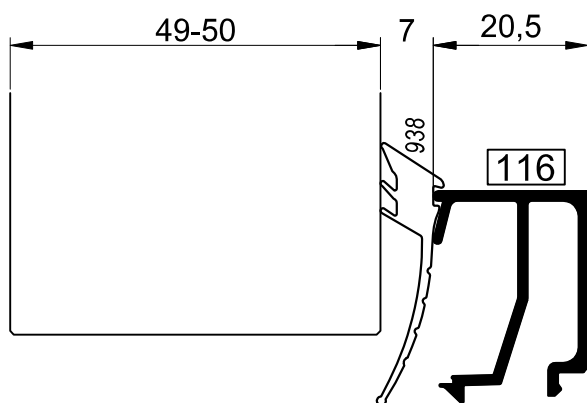
	Oznaka Mark Марк	Opis Description Описание				
	kg/m`		ly			a b
	106	Držač stakla -16,5mm Glazing bead -16,5mm				
	0,302	Подстаканник -16,5мм				
	116	Držač stakla -20,5mm Glazing bead -20,5mm				
	0,320	Подстаканник -20,5мм				
	100	Držač stakla -24,5mm Glazing bead -24,5mm				
	0,330	Подстаканник -24,5мм				
	117	Držač stakla -28,5mm Glazing bead -28,5mm				
	0,348	Подстаканник -28,5мм				
	101	Držač stakla -32,5mm Glazing bead -32,5mm				
	0,359	Подстаканник -32,5мм				
	108	Držač stakla -38,5mm Glazing bead -38,5mm				
	0,380	Подстаканник -38,5мм				
	107	Držač stakla -46,5mm Glazing bead -46,5mm				
	0,409	Подстаканник -46,5мм				
	109	Mali slivnik Waterdrip				
	0,035	Капельник				

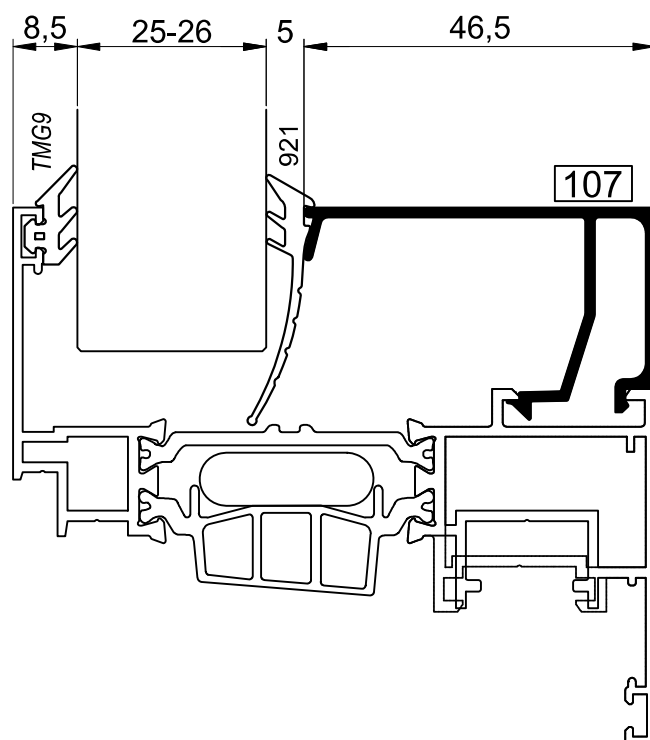
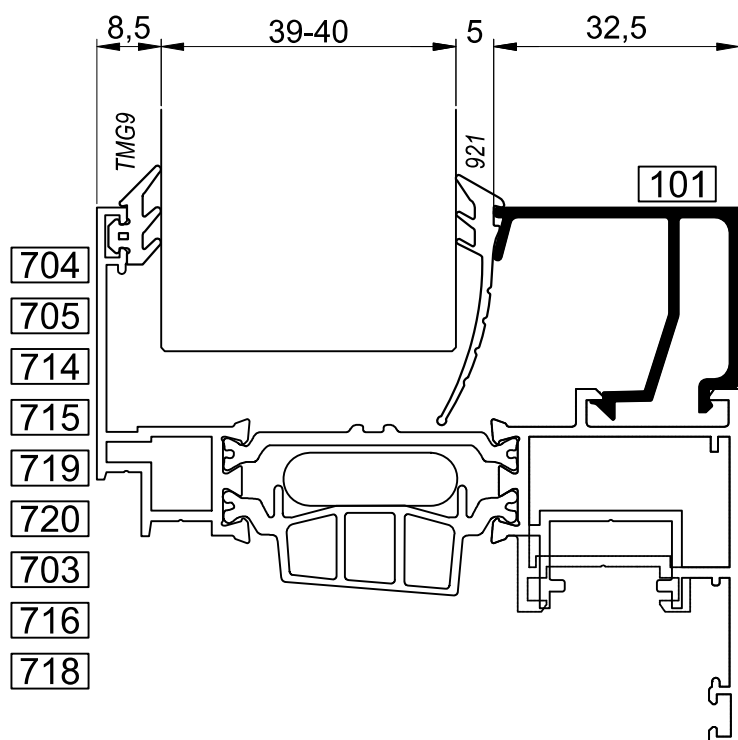
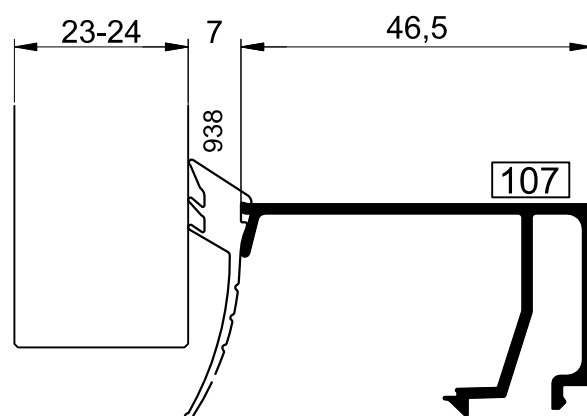
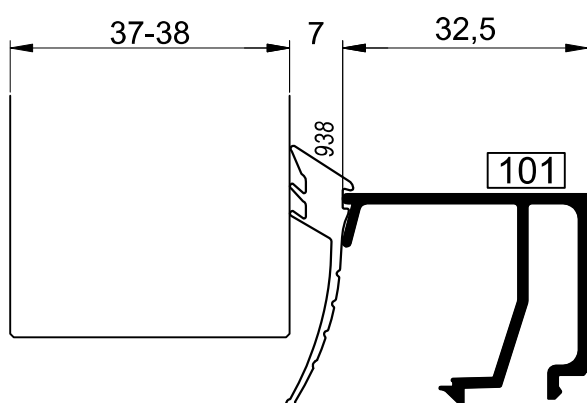
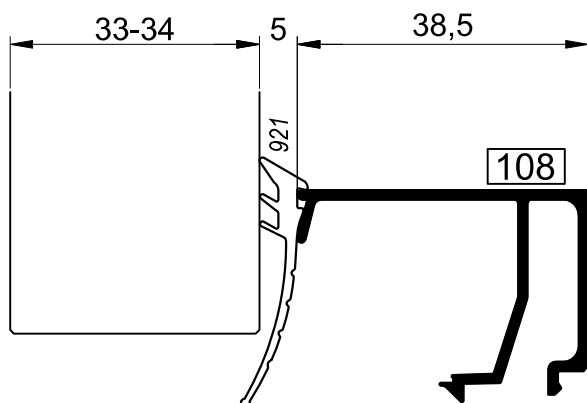
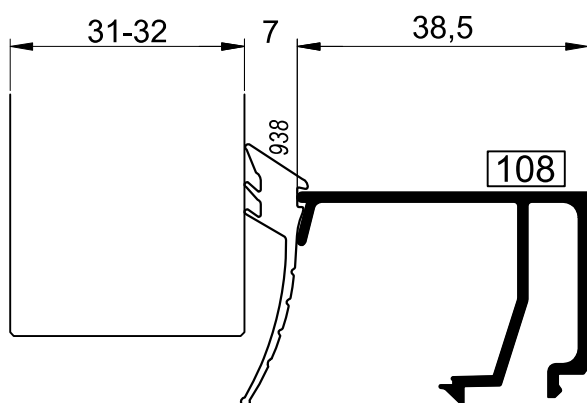
	Oznaka Mark Марк	Opis Description Описание				
	kg/m`		ly			b
	110	Opšivni profil Casing profile				
	0.119	Обшивка				
	TM33	Pogonska letva Rod for mechanism				
	0,152	Стержень для механизма				
	TM36	Slivnik Waterdrip				
	0,177	Капельник				
	TM42	Slivnik i nosač četkice Waterdrip				
	0,272	Капельник				
	TM43	Nosač četkice Brush holder				
	0,130	Держатель щетки				
	TM80	Modularni stub Modular mullion	19,853			
	0,946	Модульный колонка	5,102			
	TM81	Modularni stub Modular mullion				
	0,102	Модульный колонка				

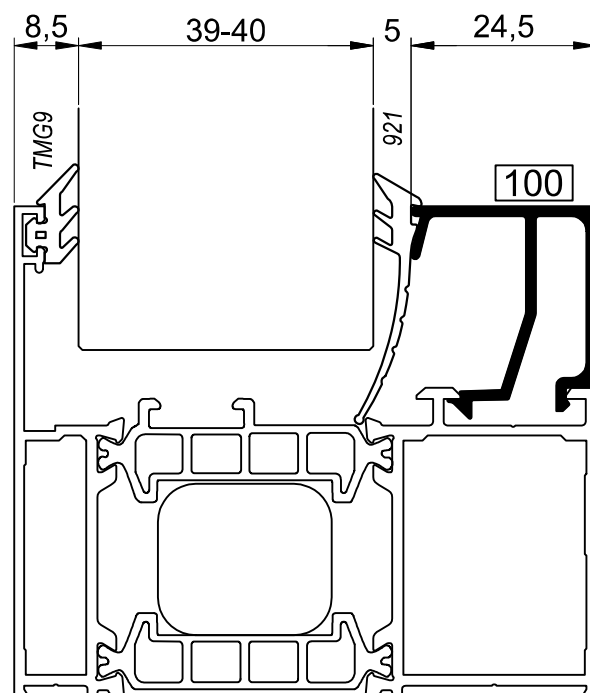
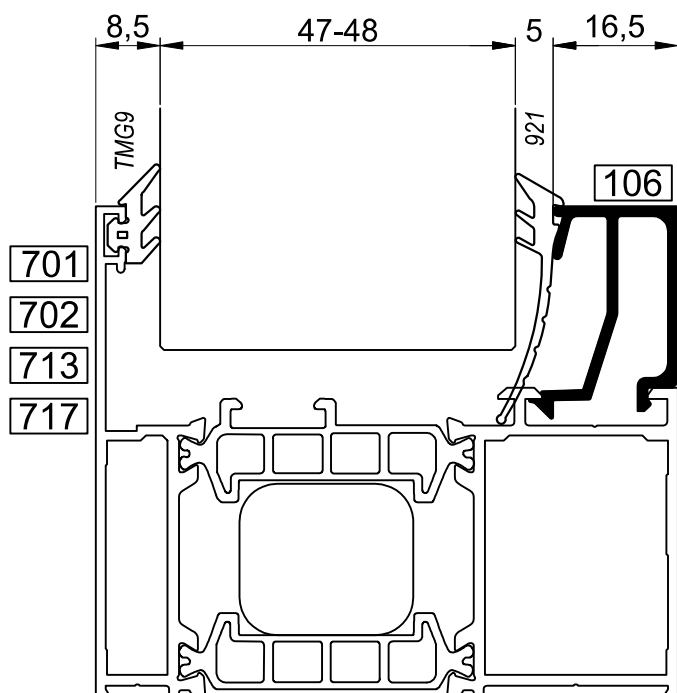
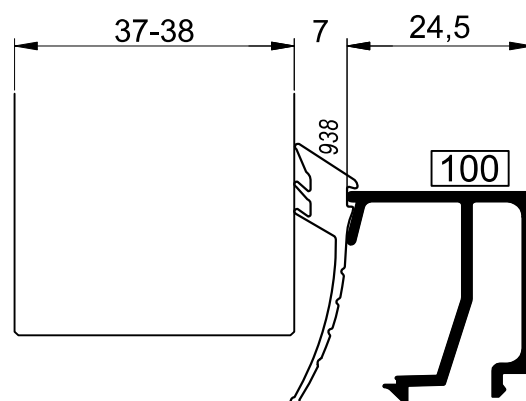
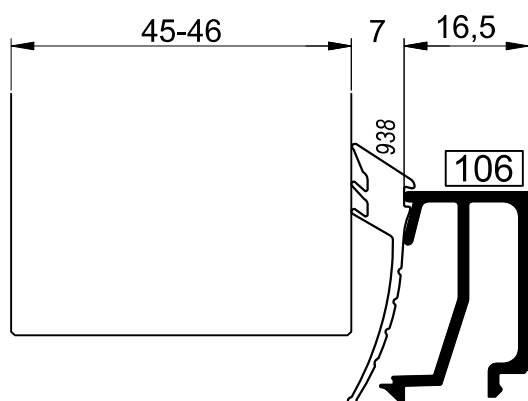
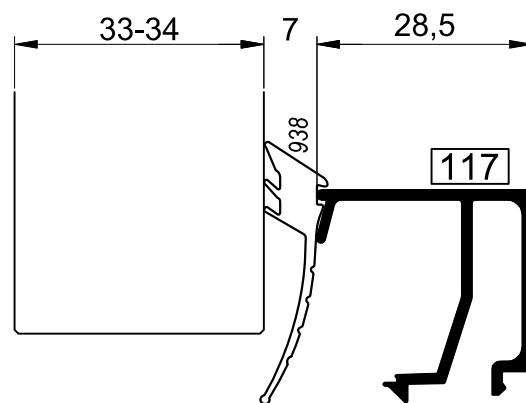
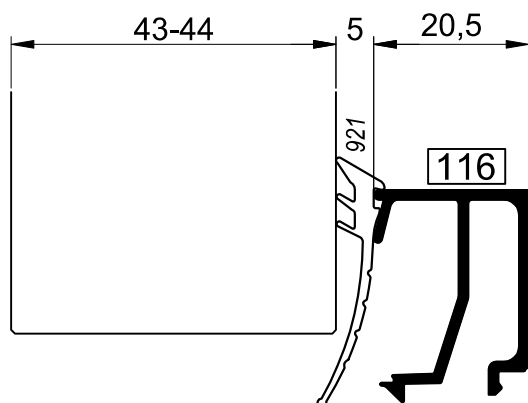
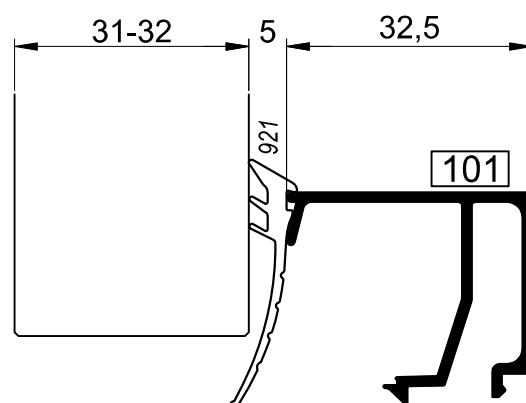
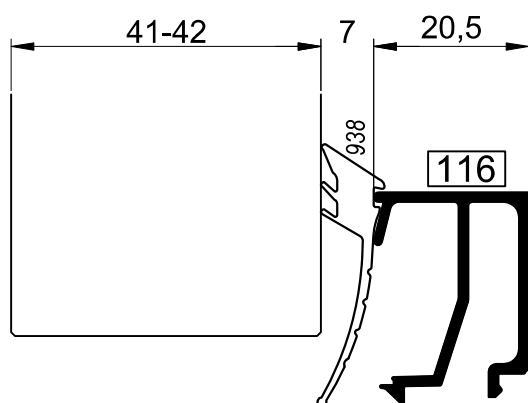


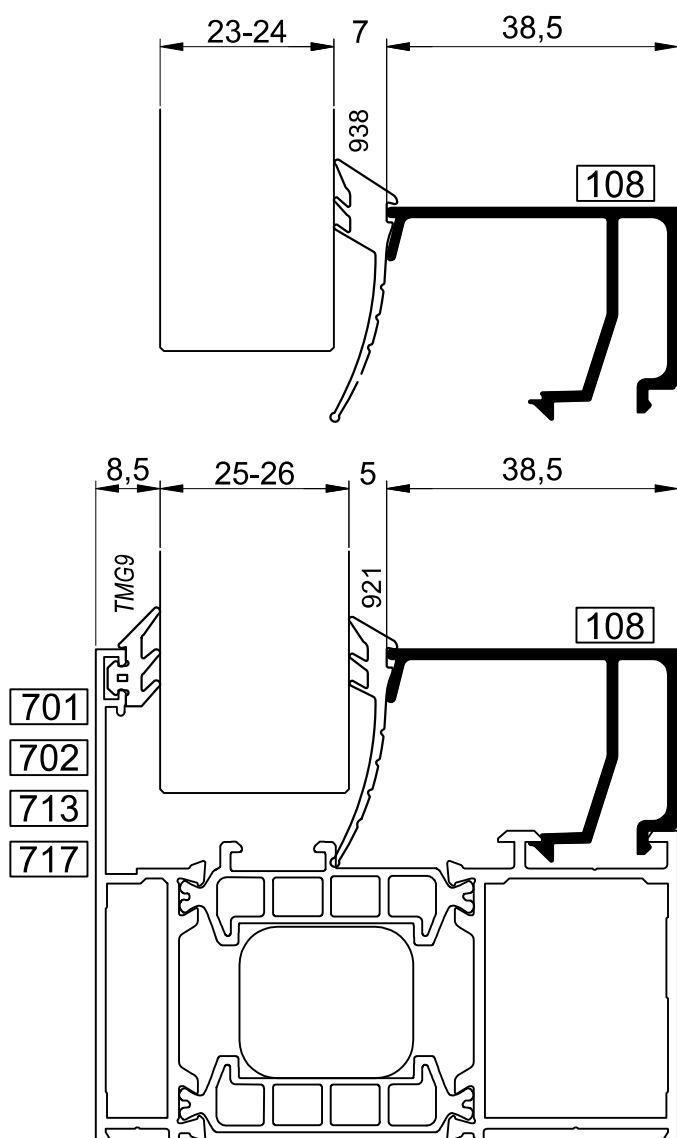


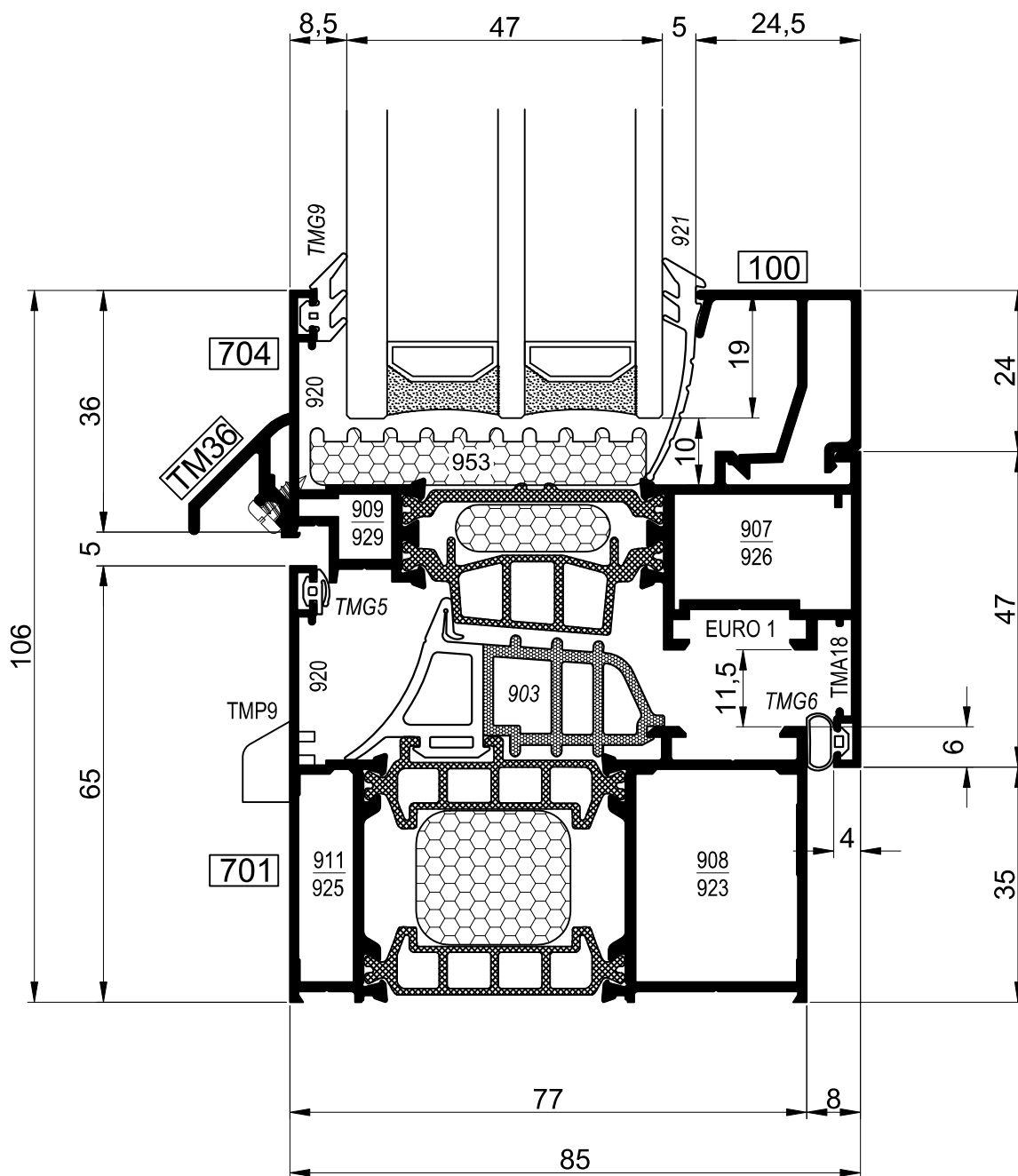
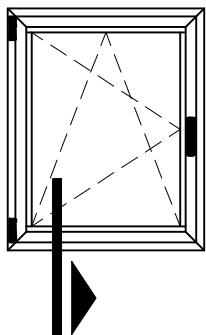


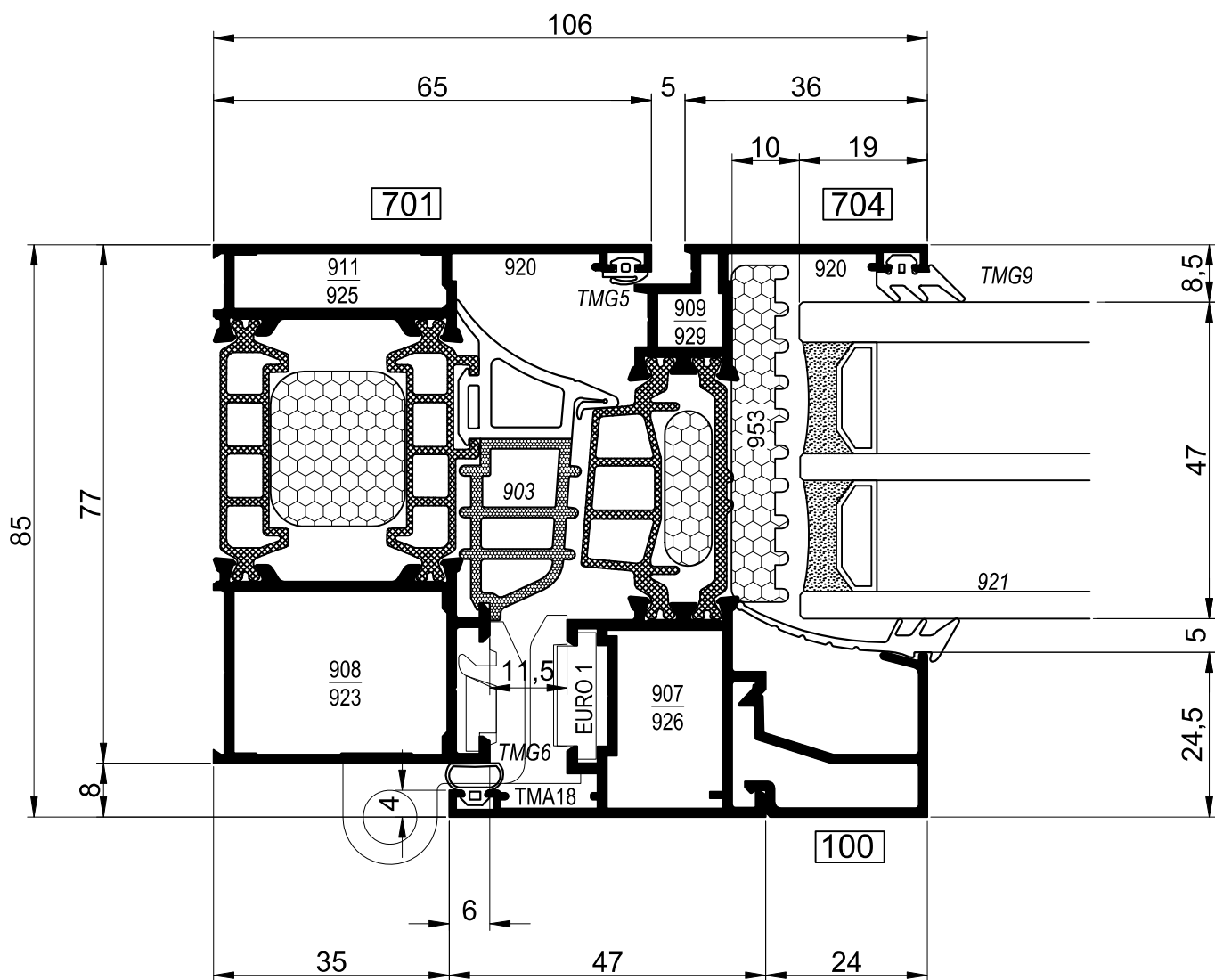
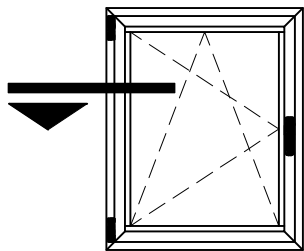


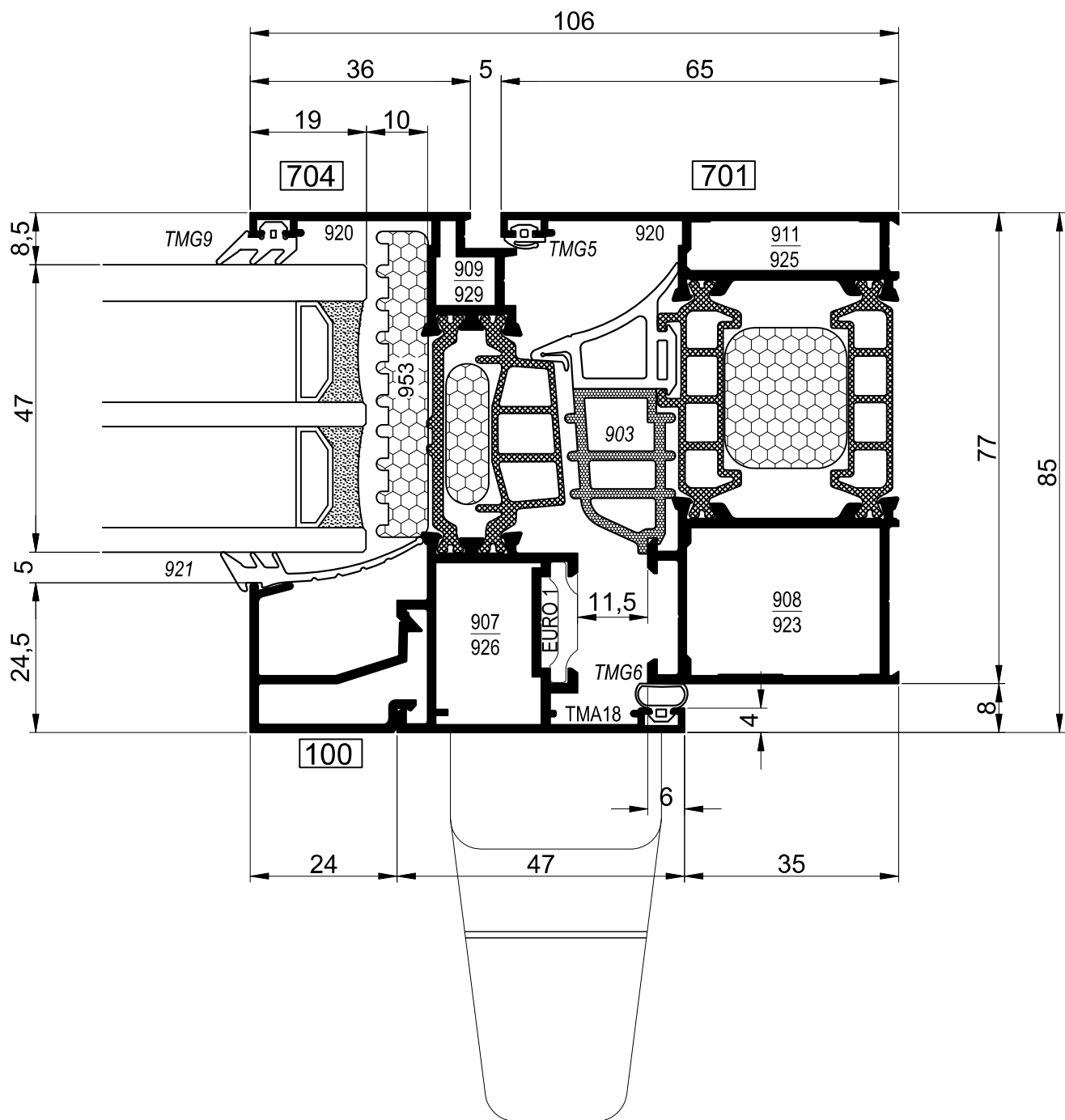
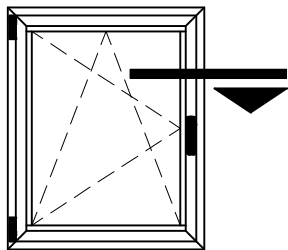


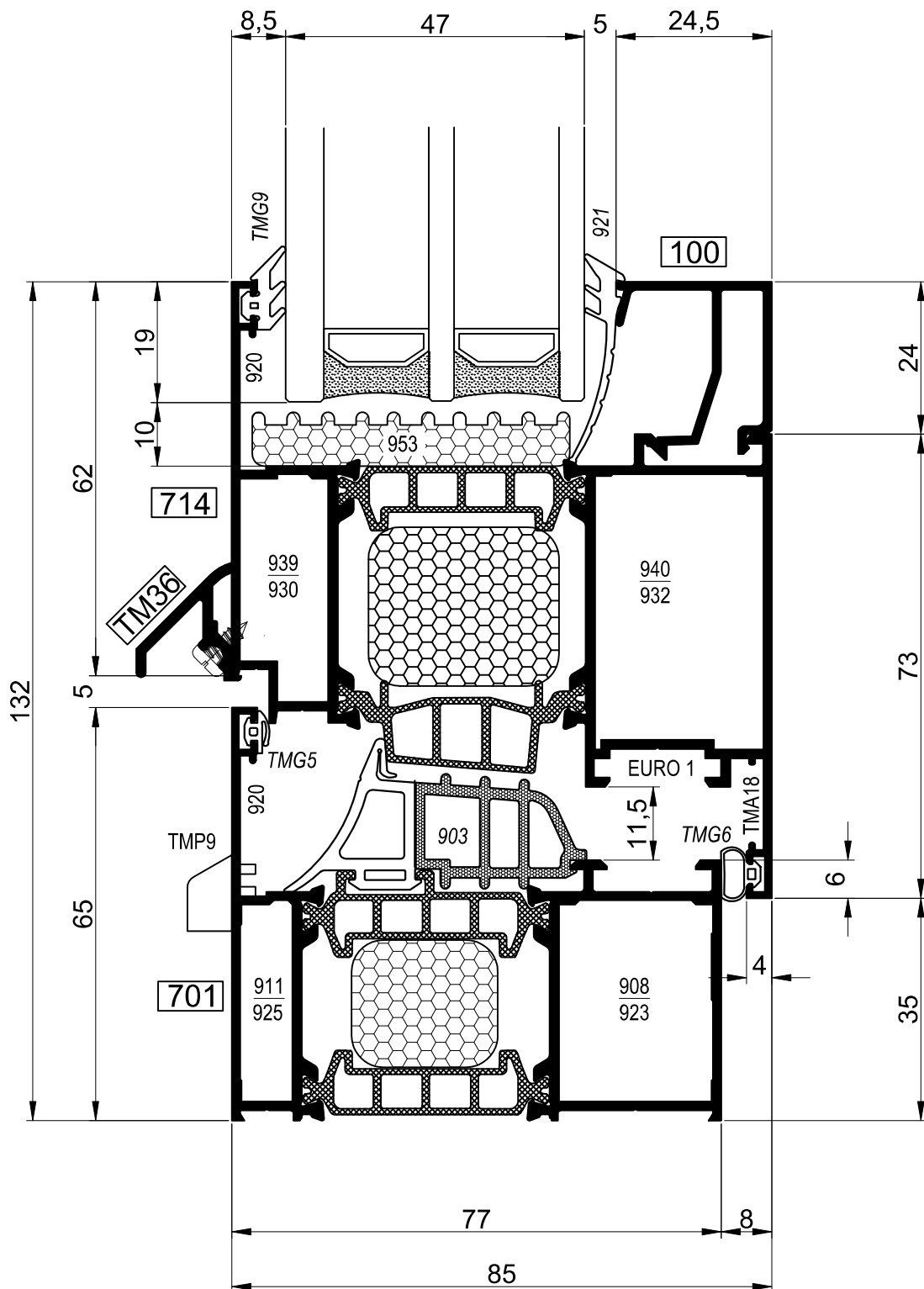
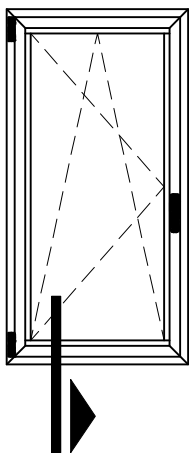


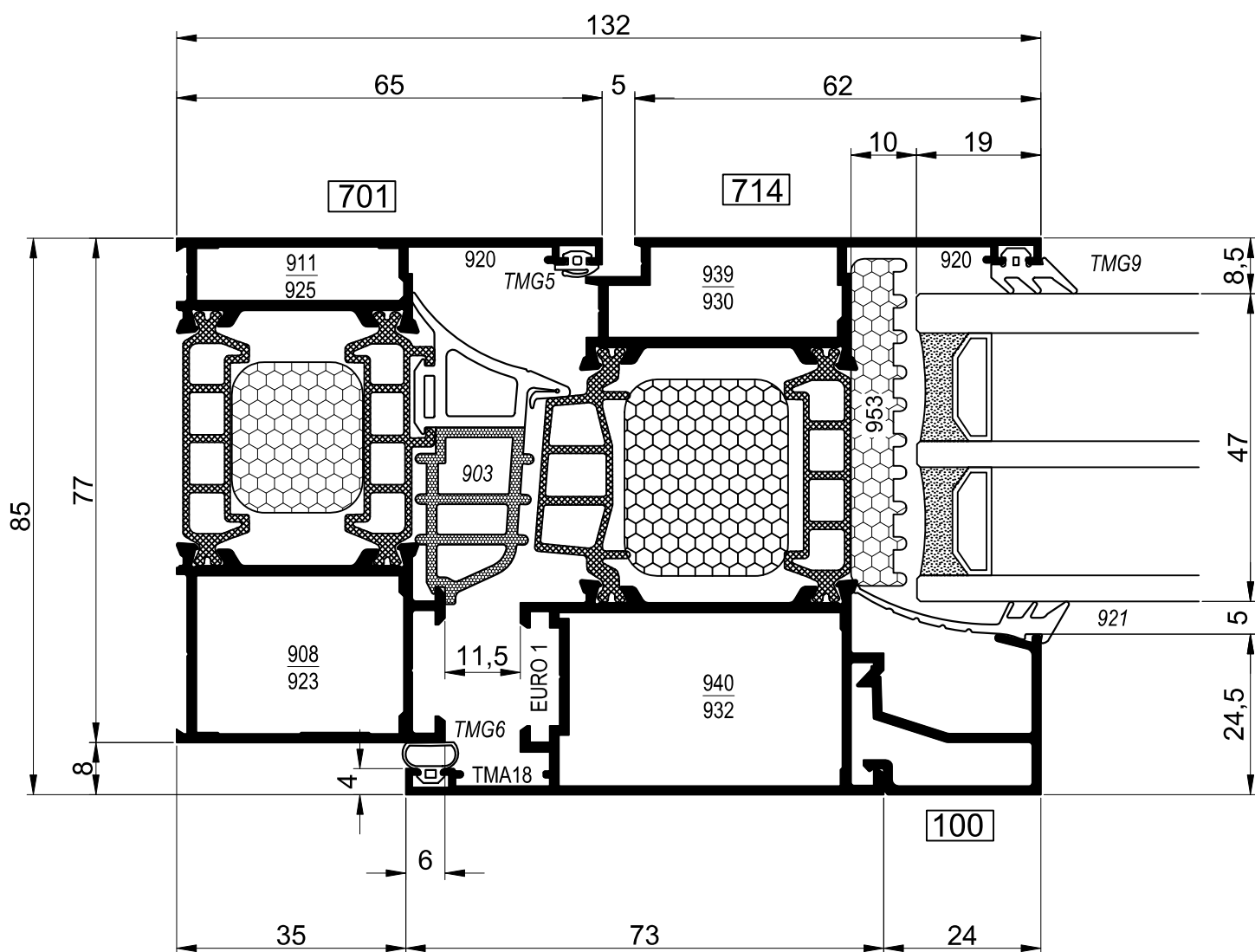
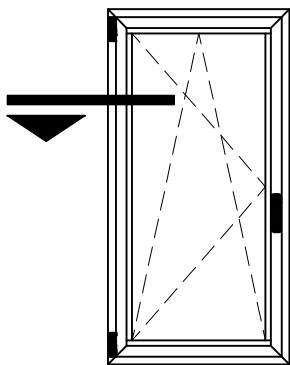


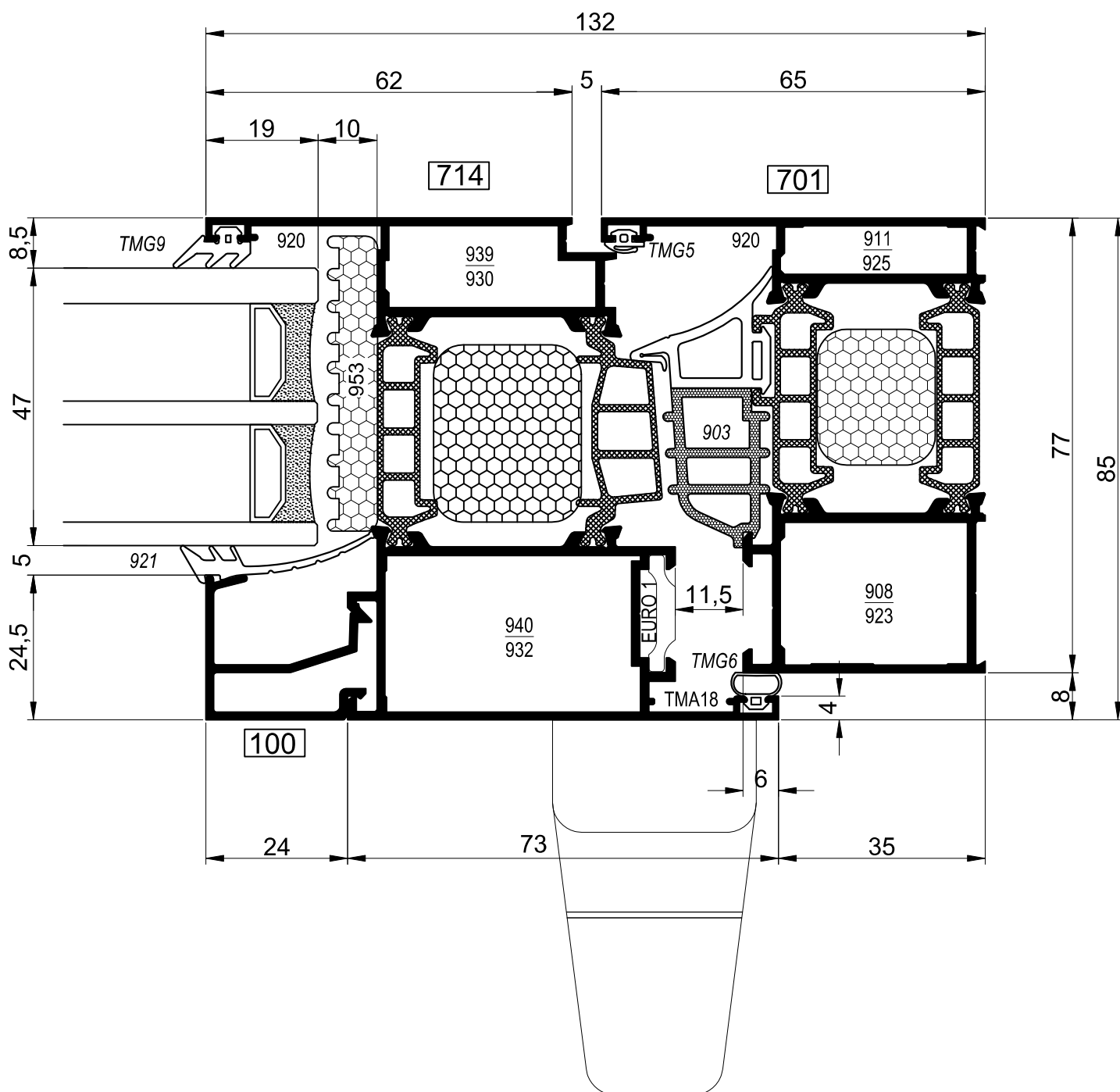
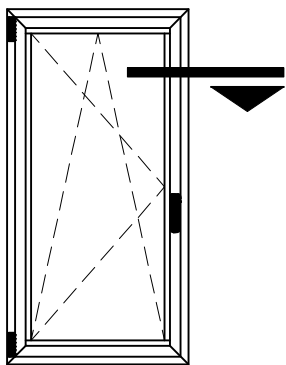


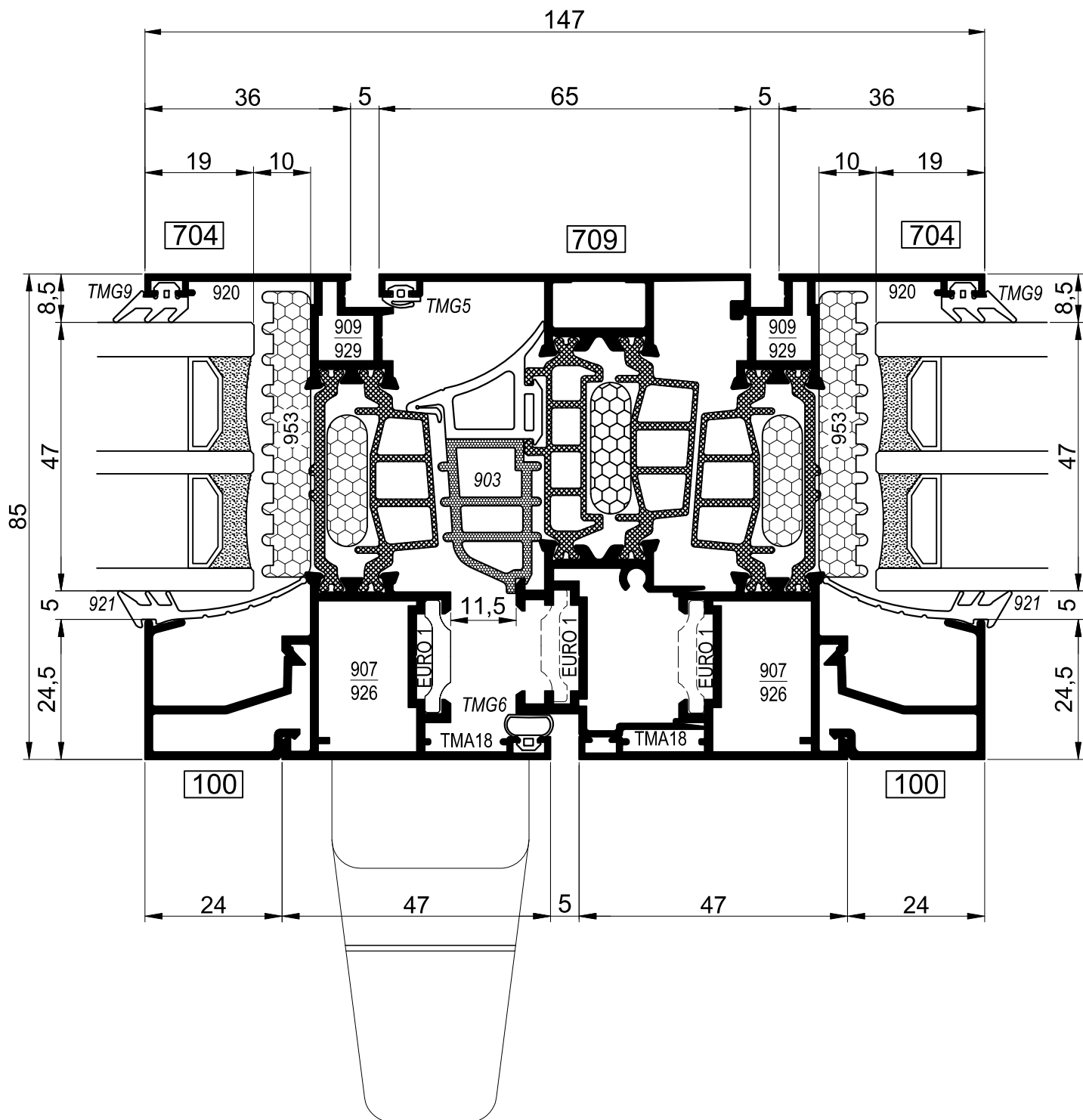
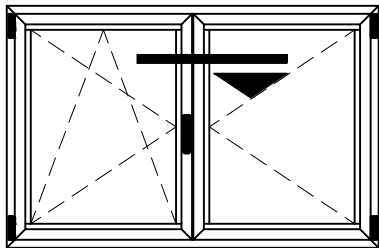


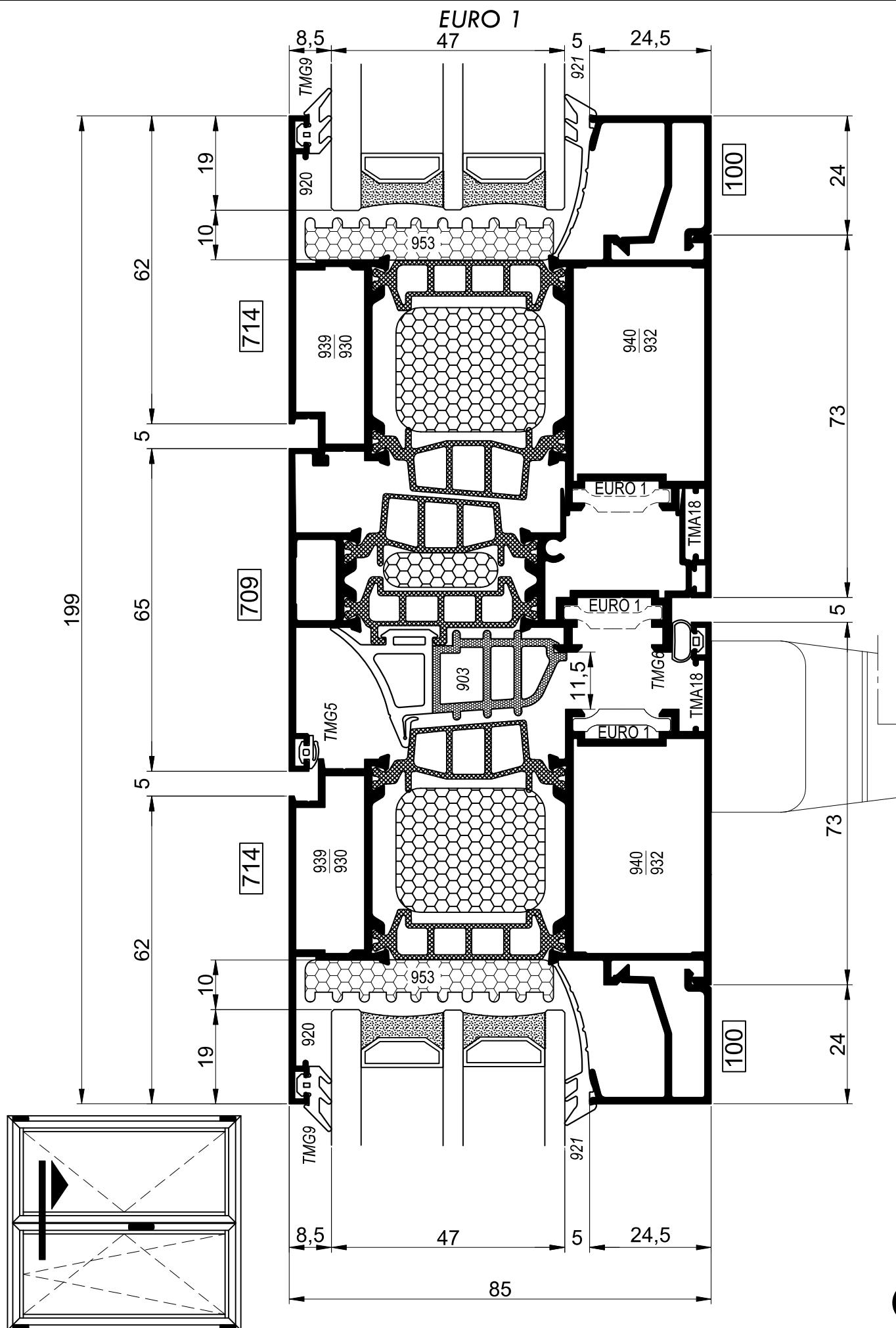


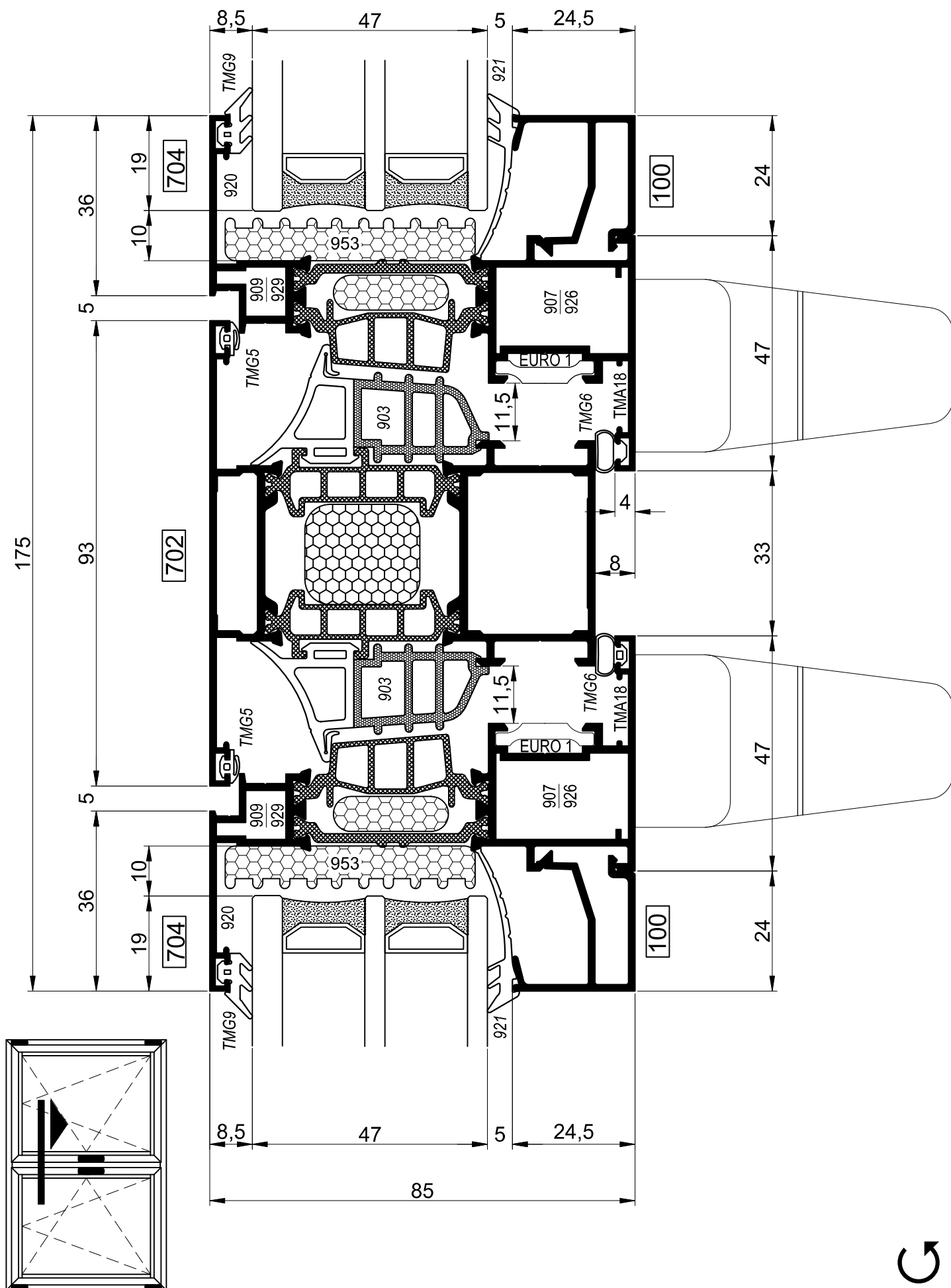


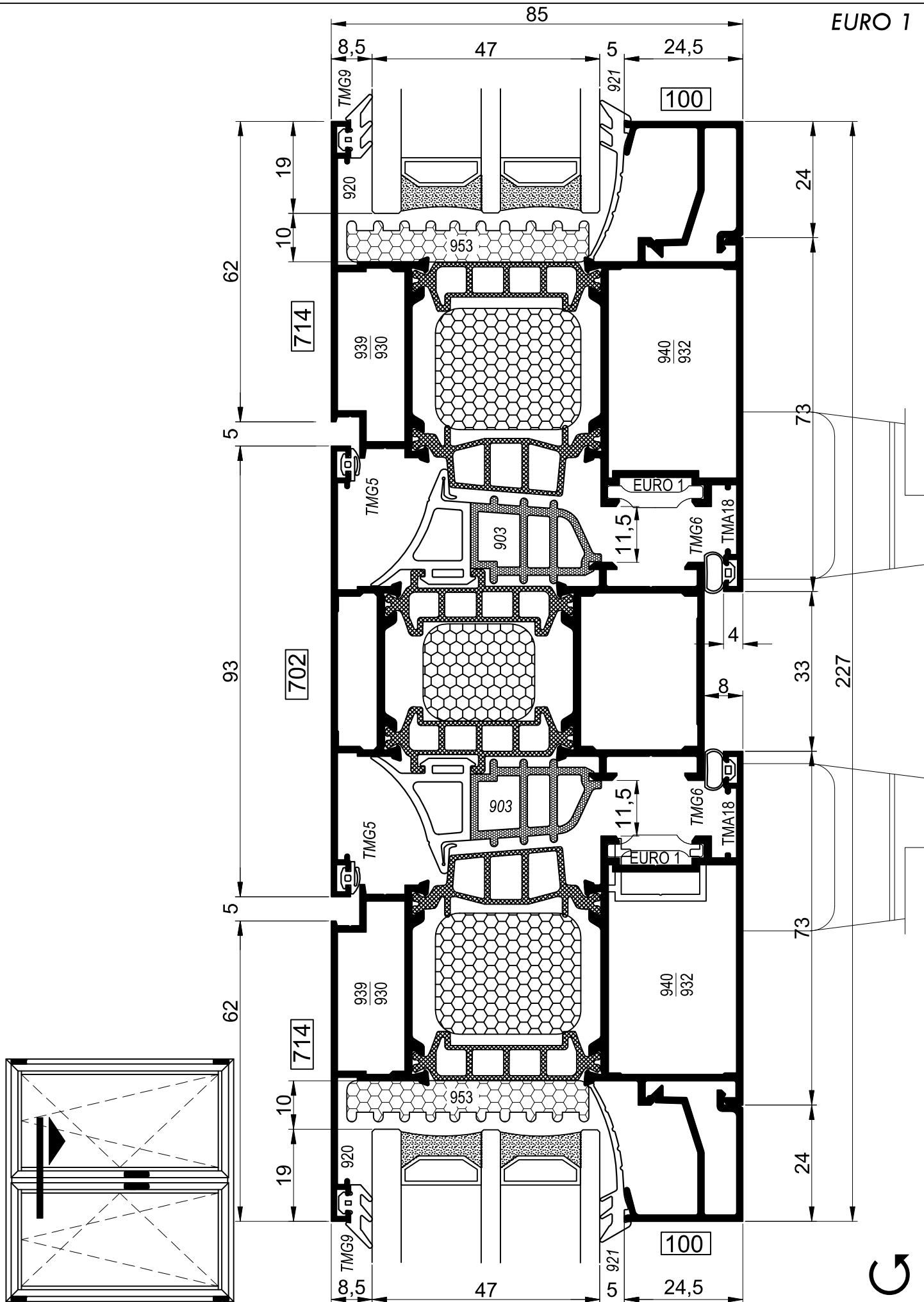


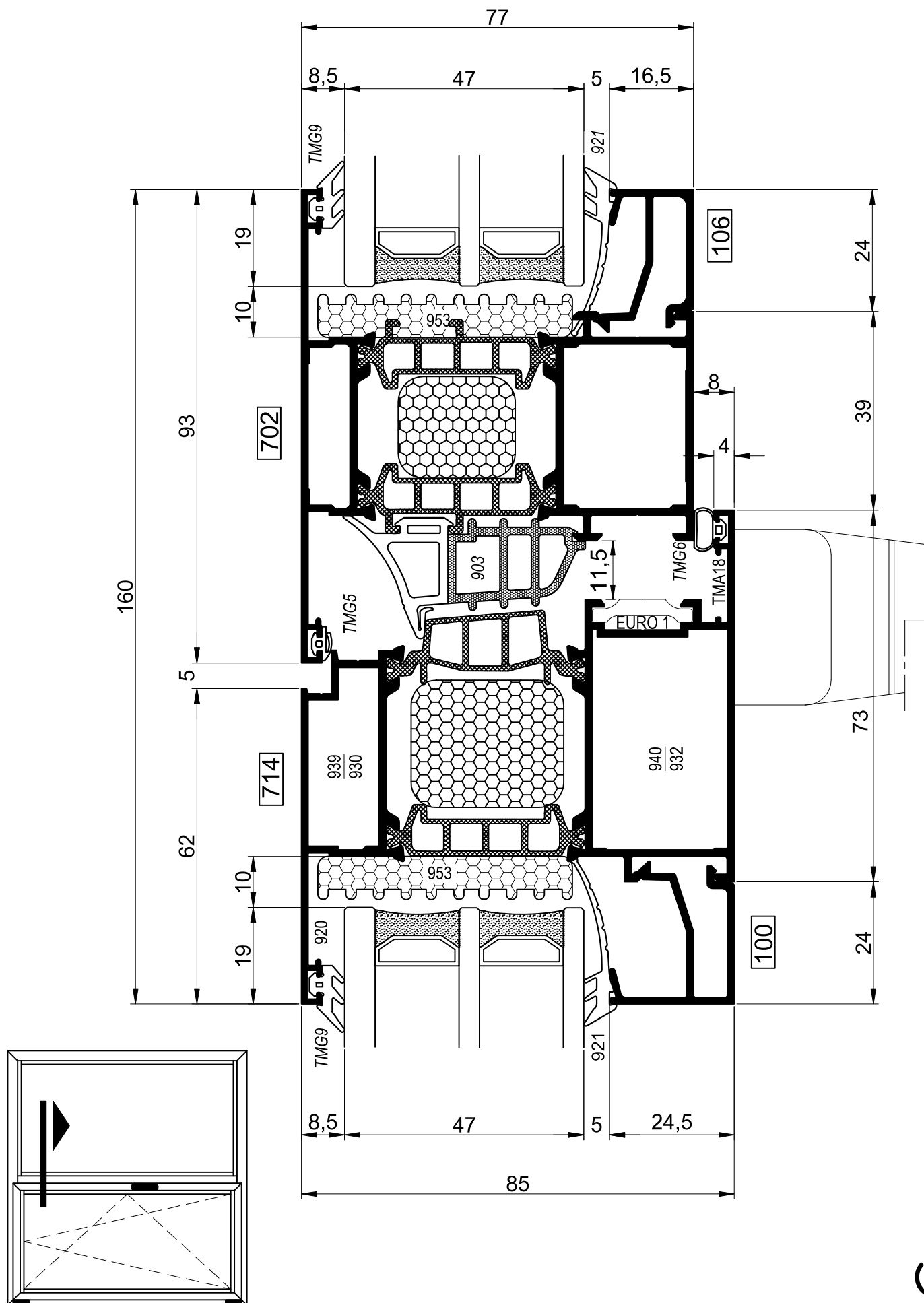


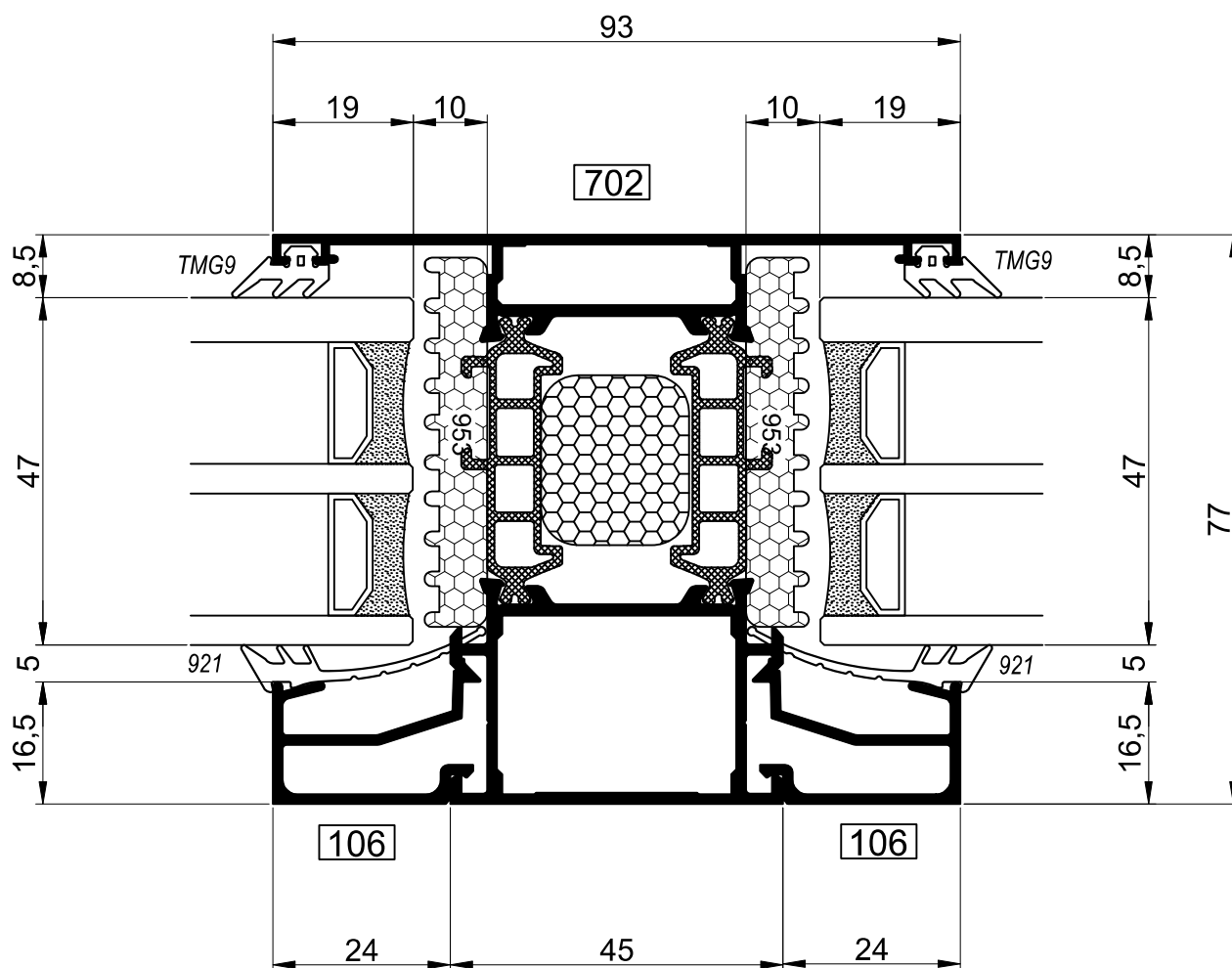
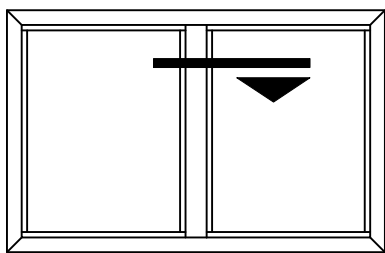


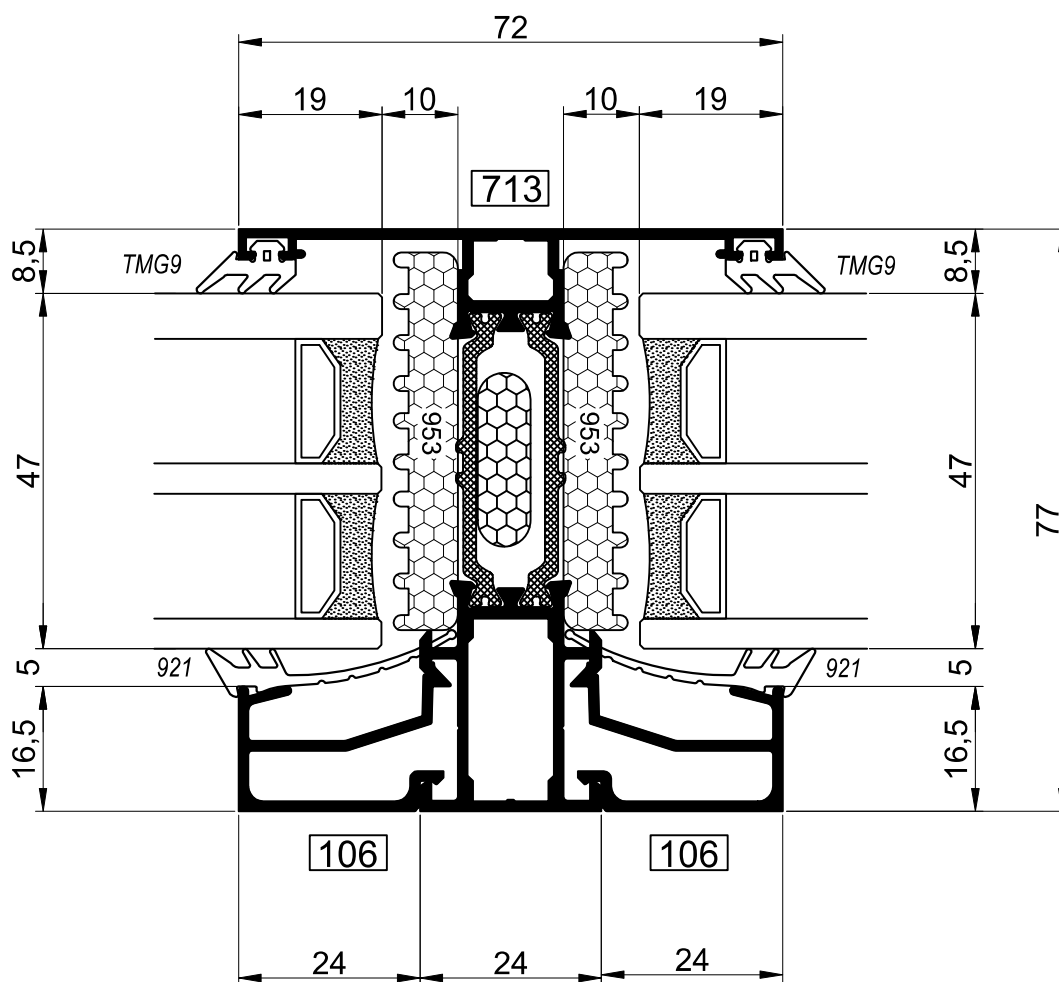
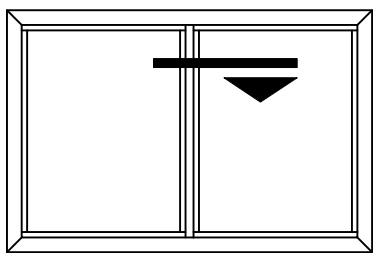


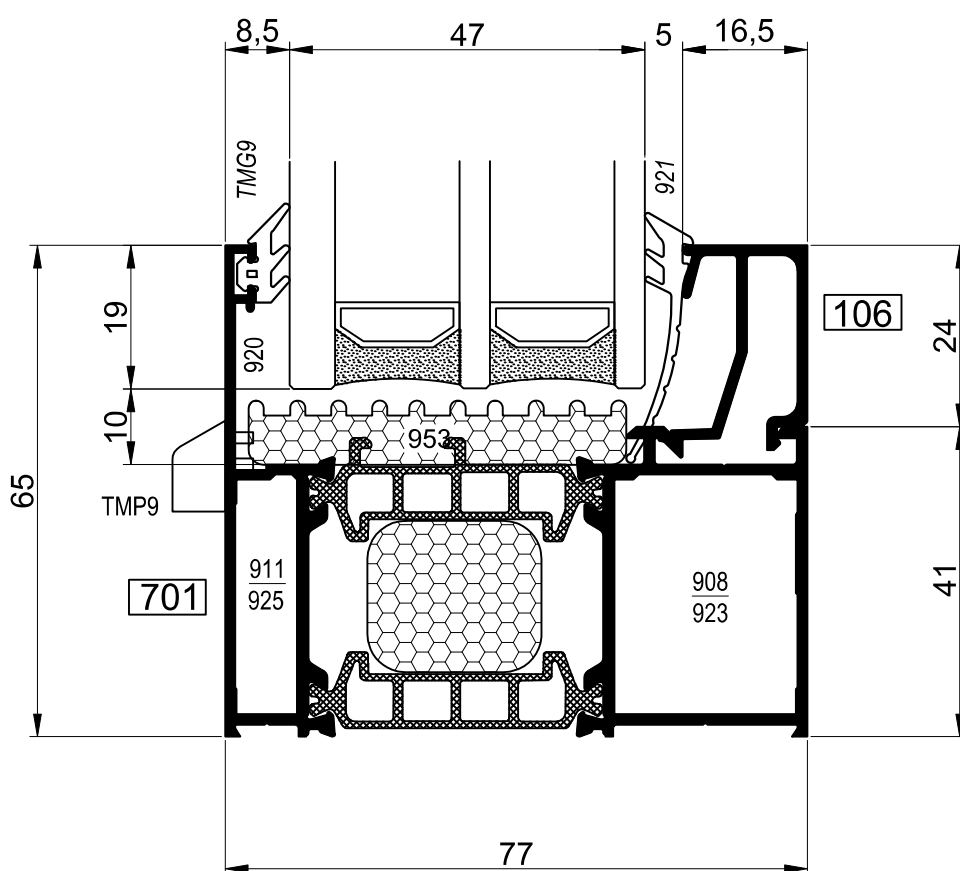
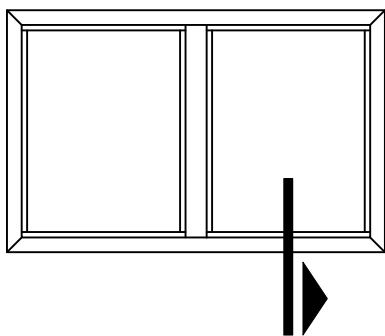


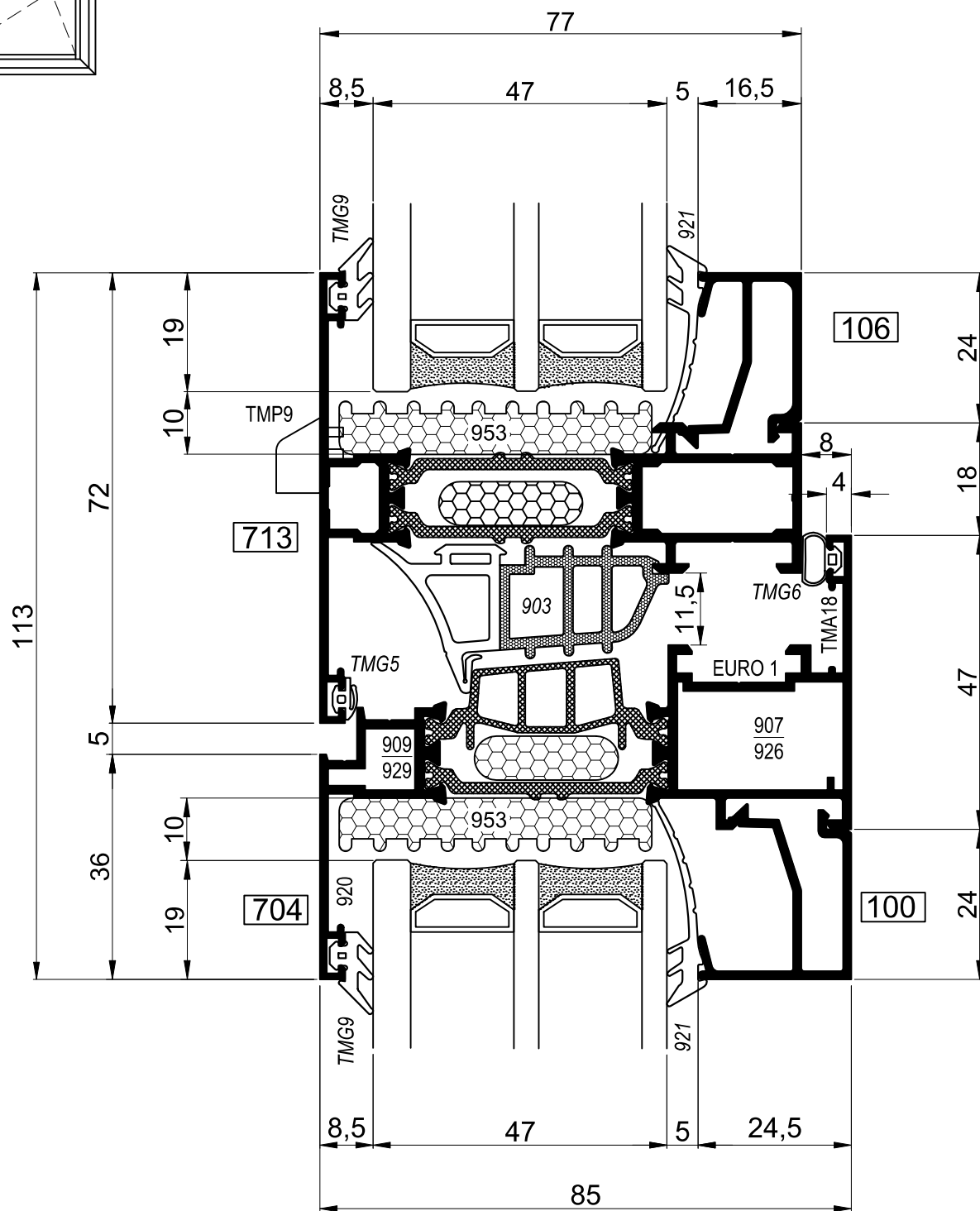
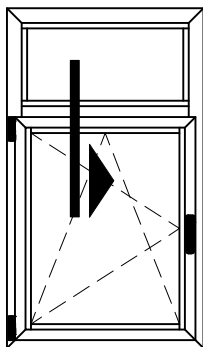


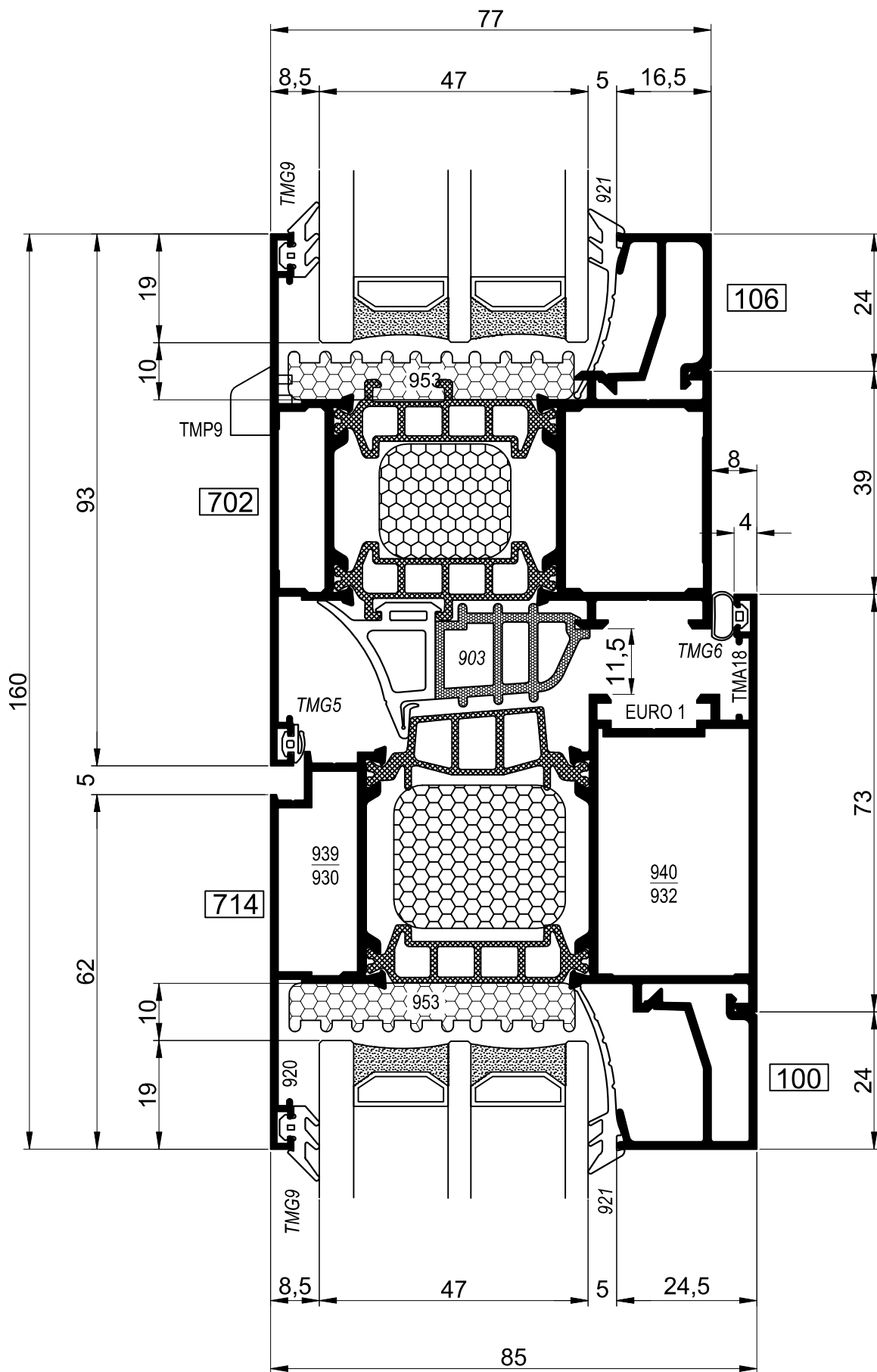
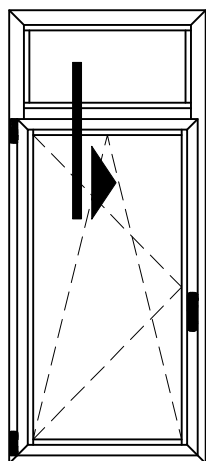


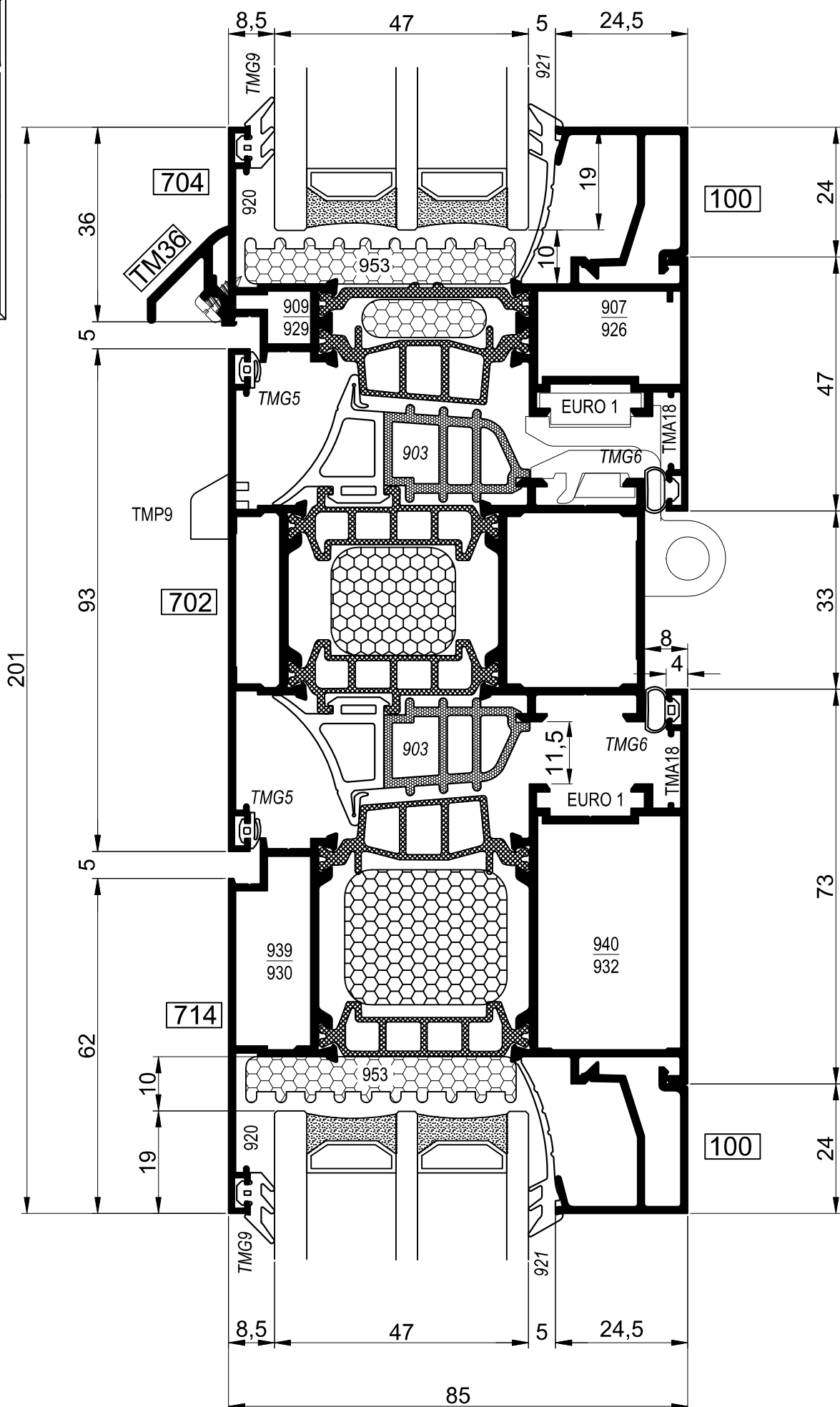
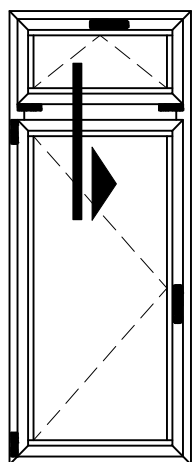


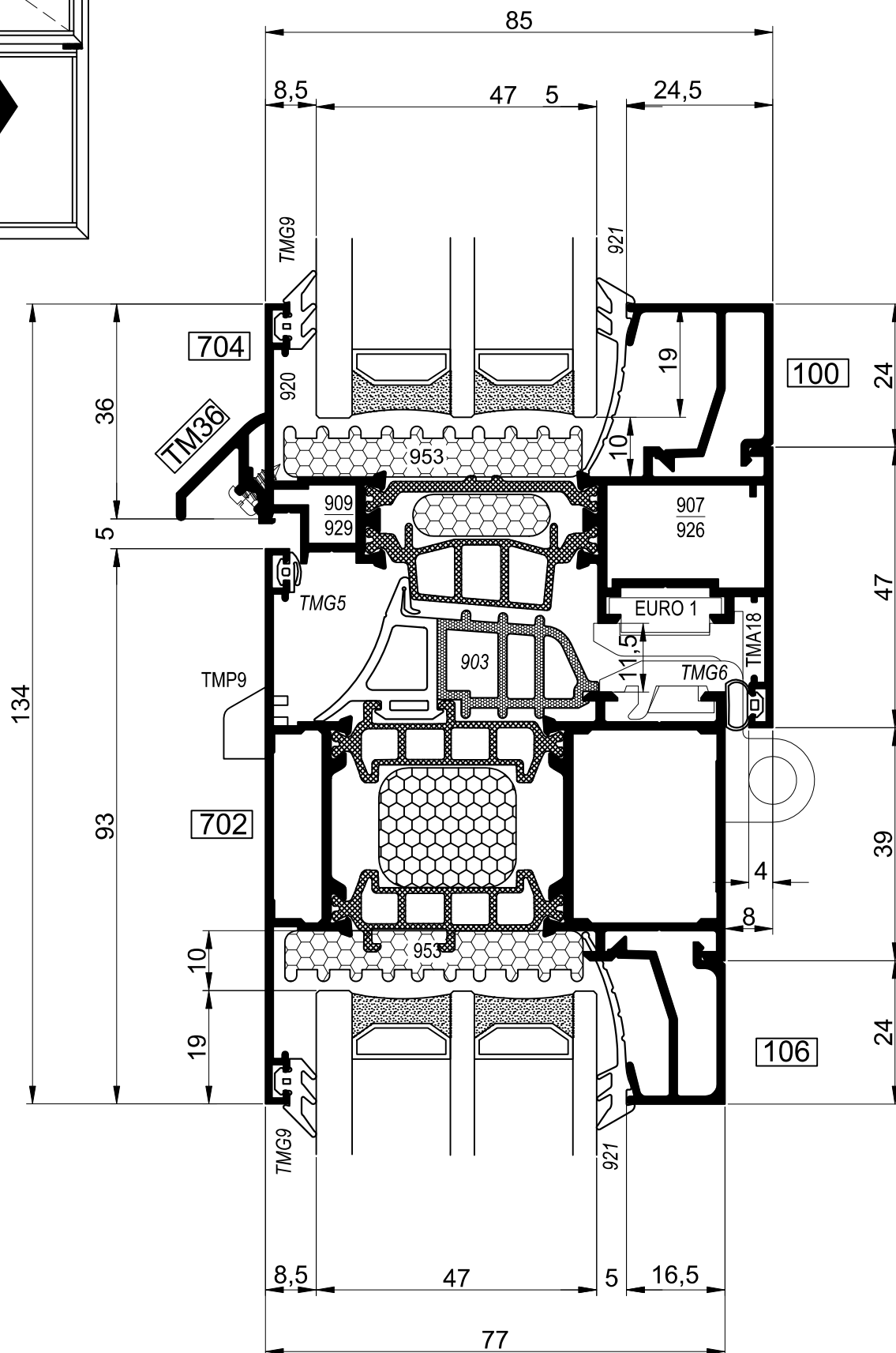
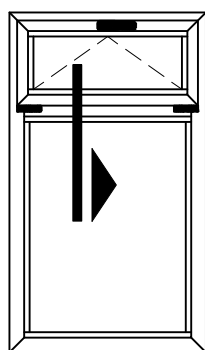


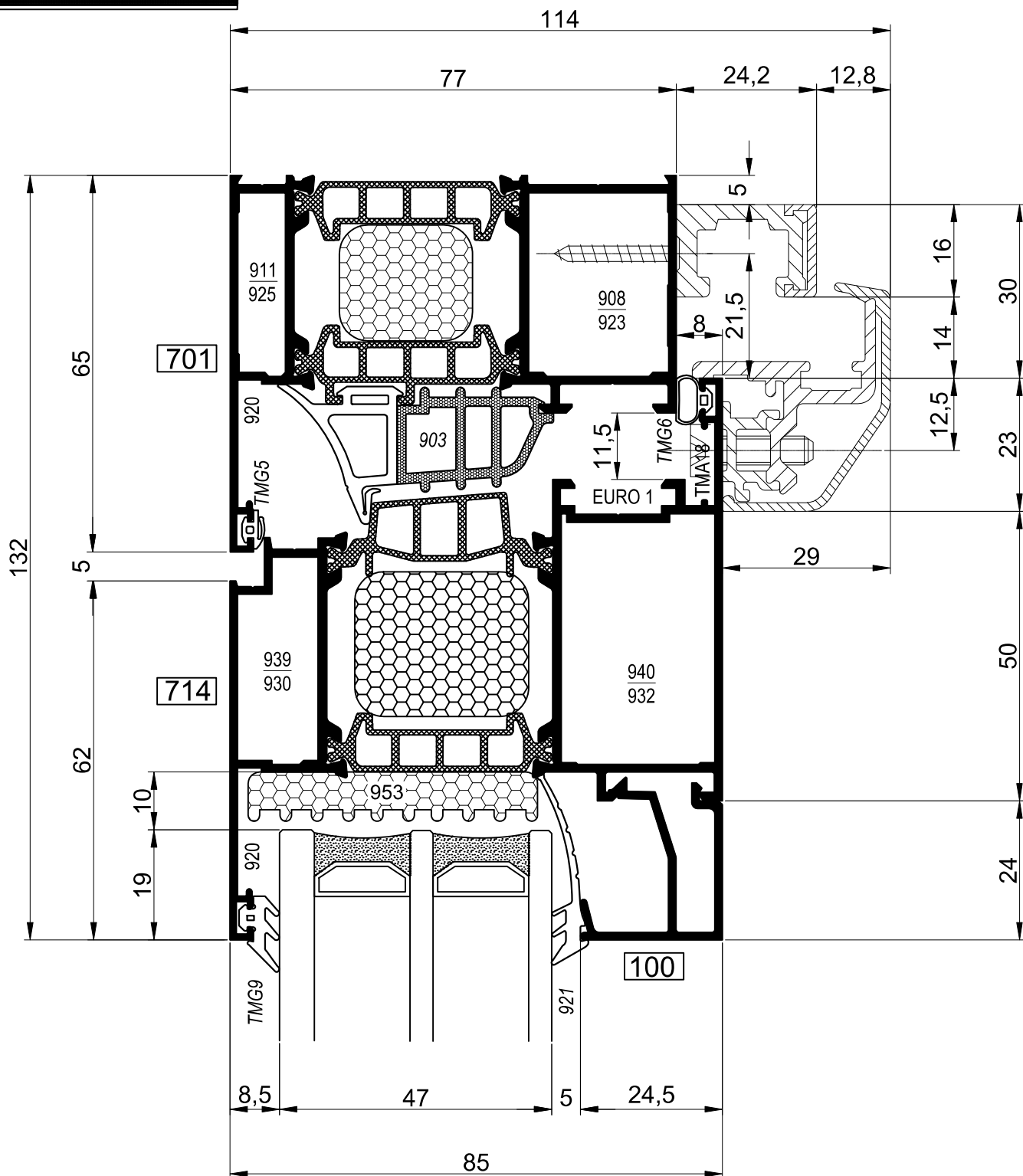
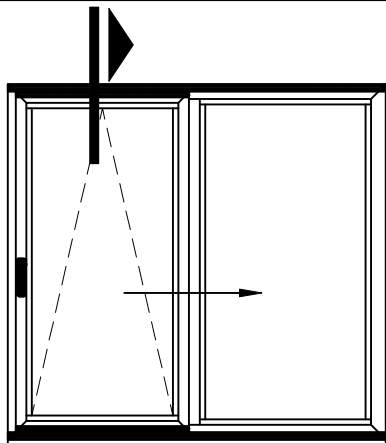


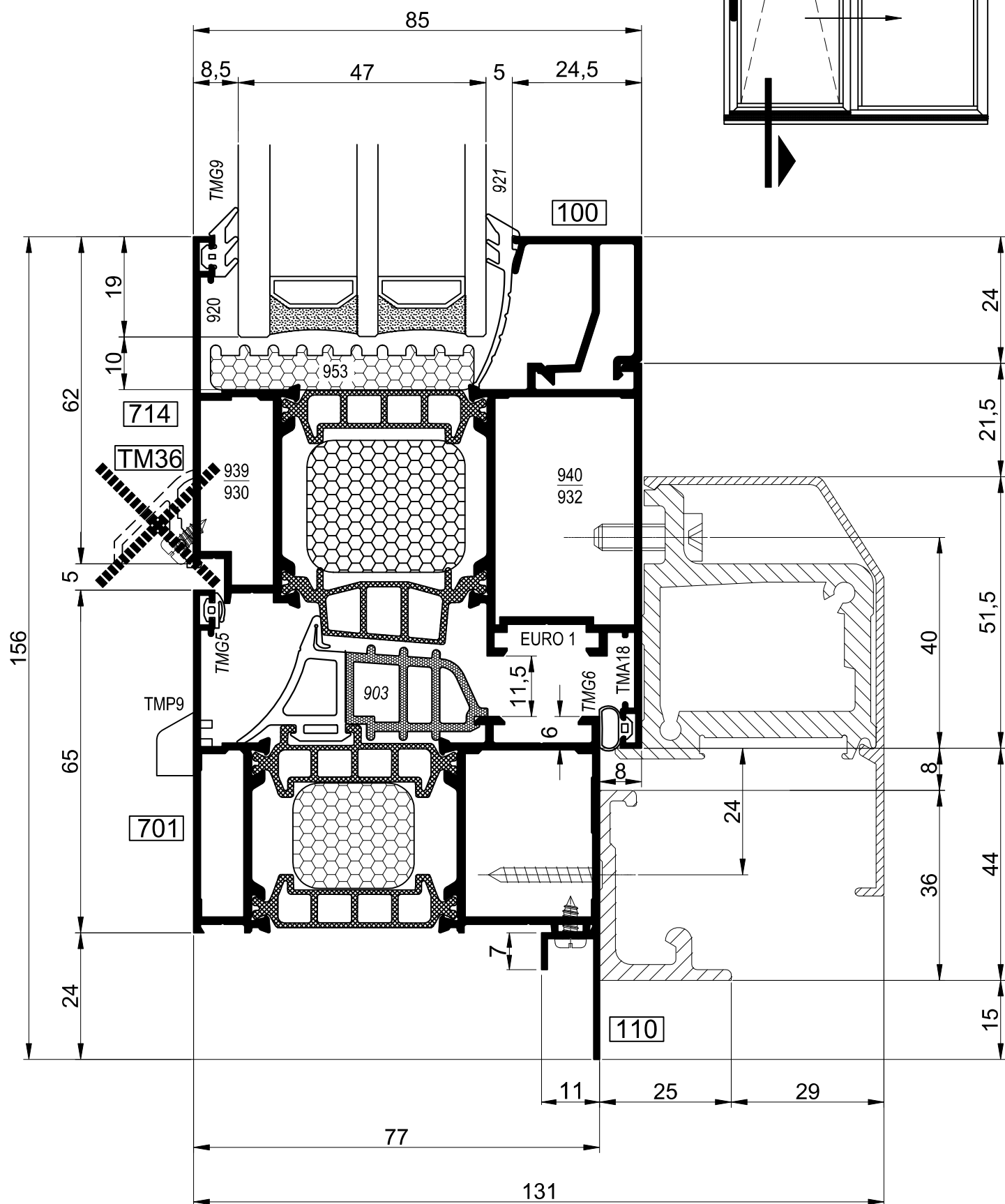


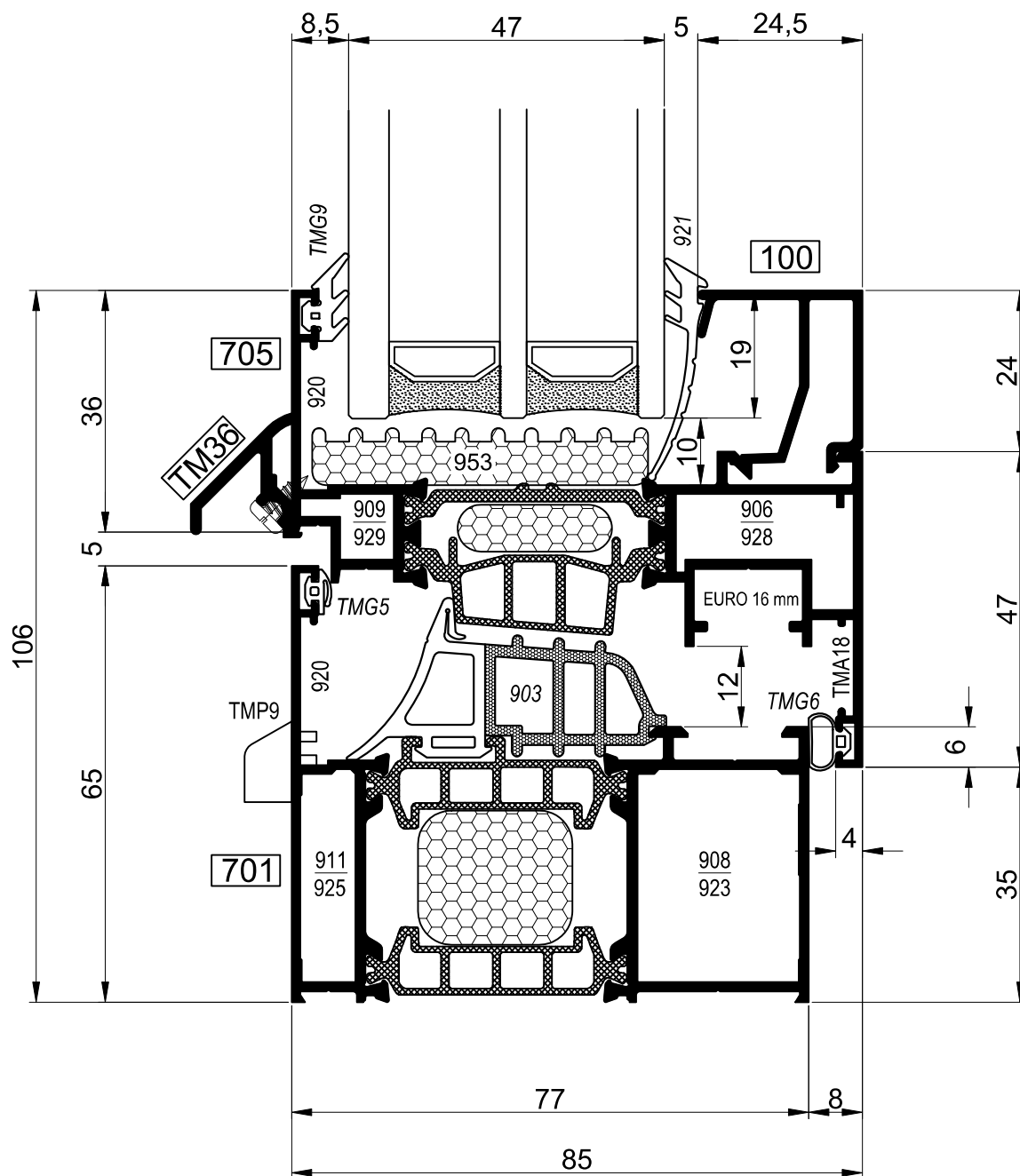
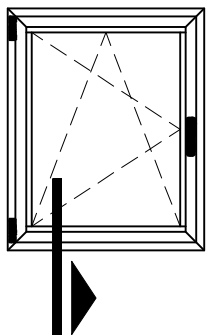


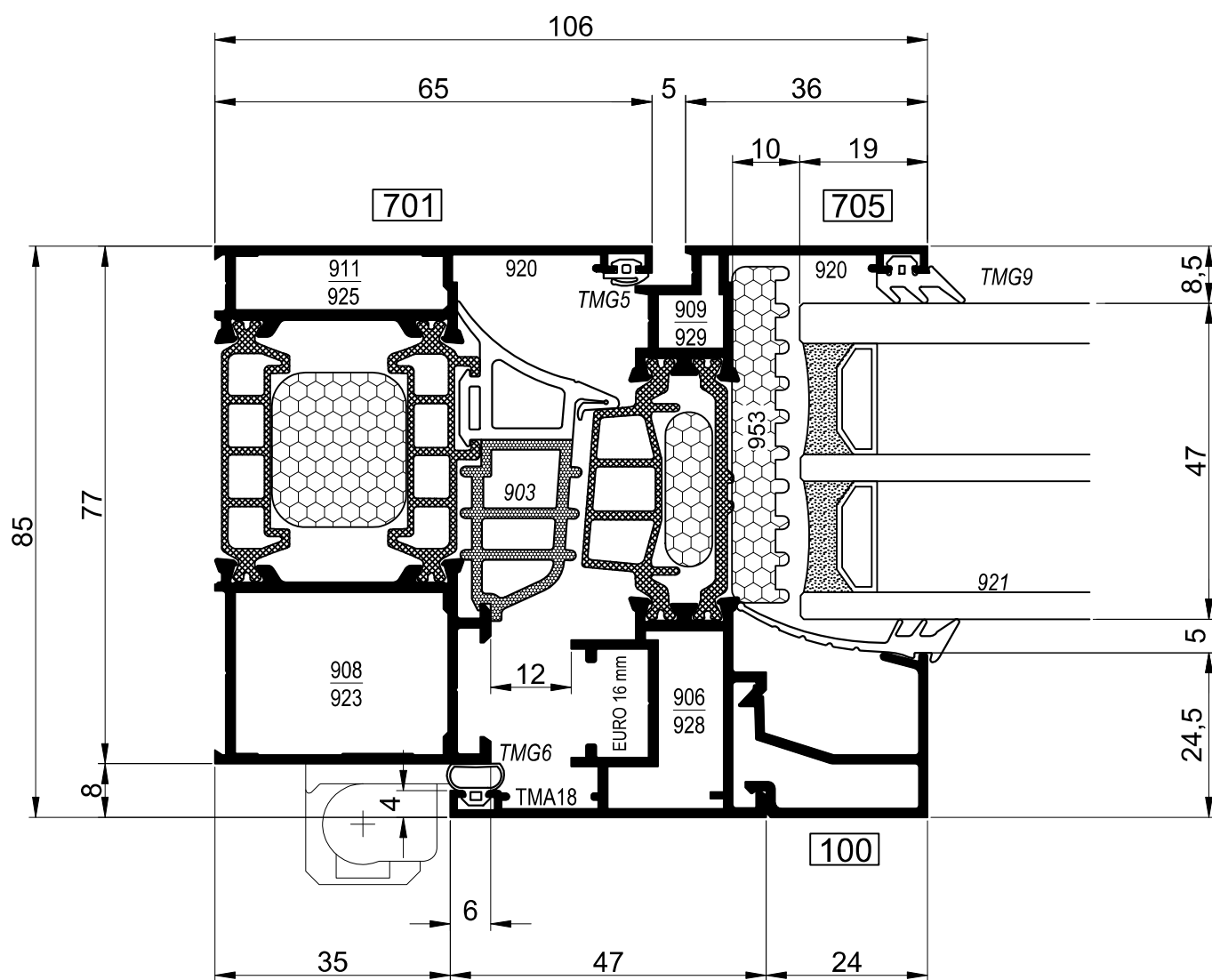
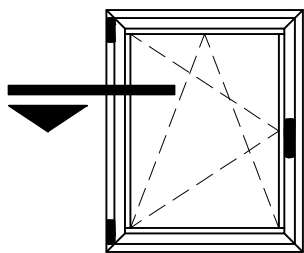


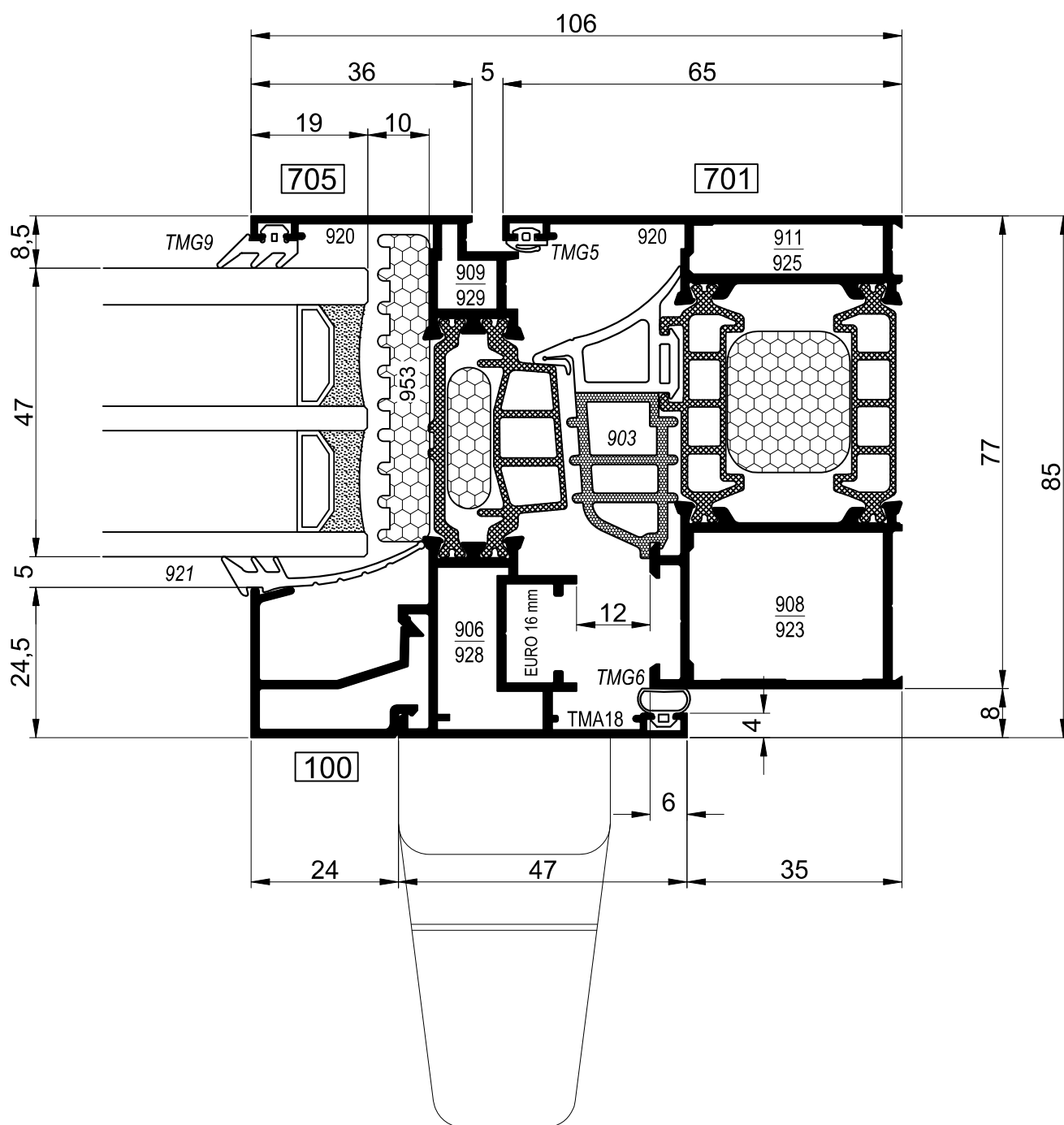
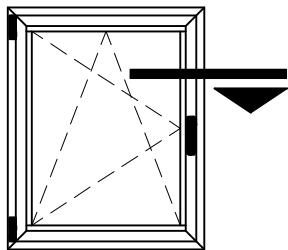


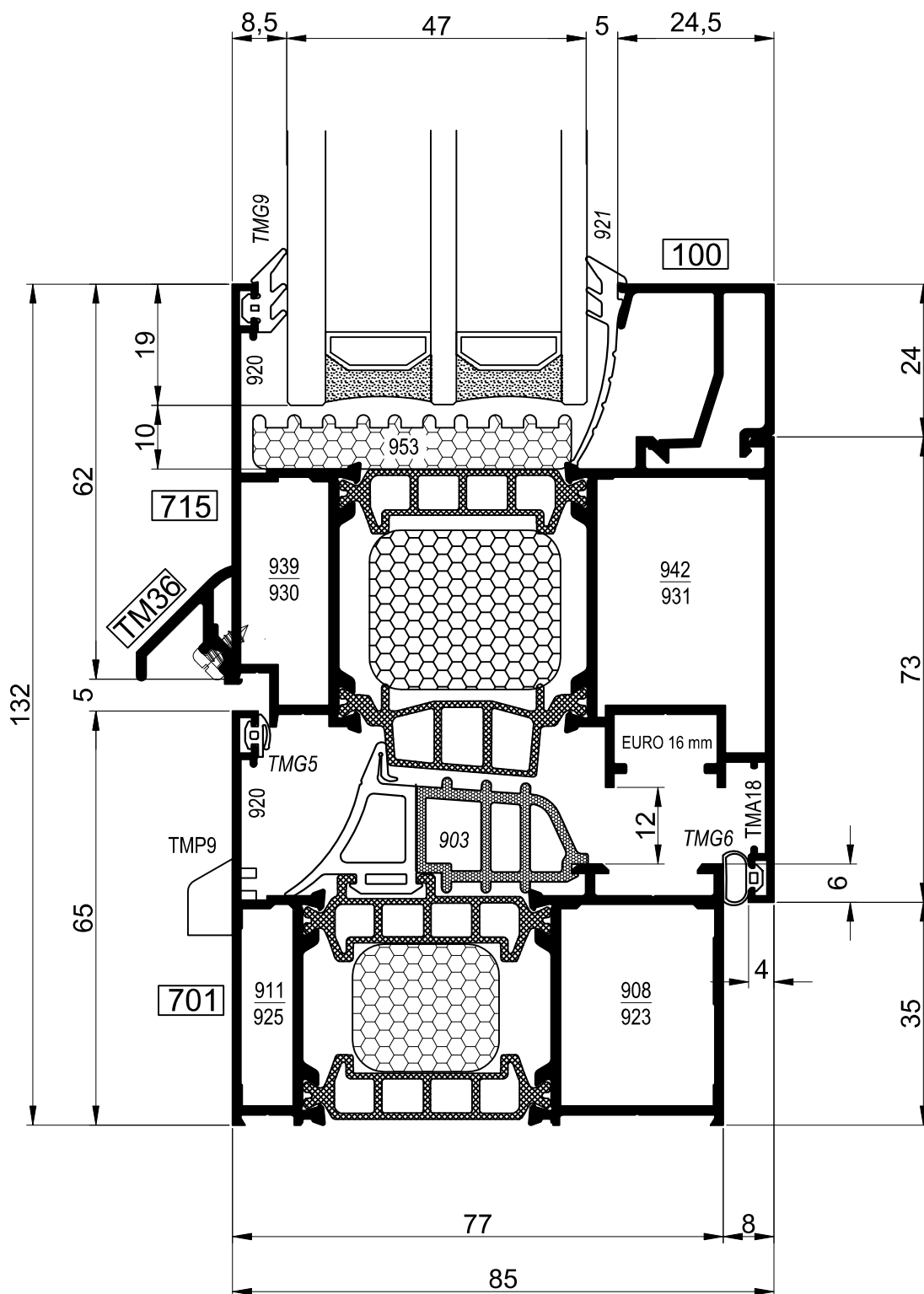
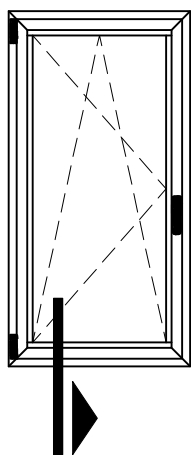


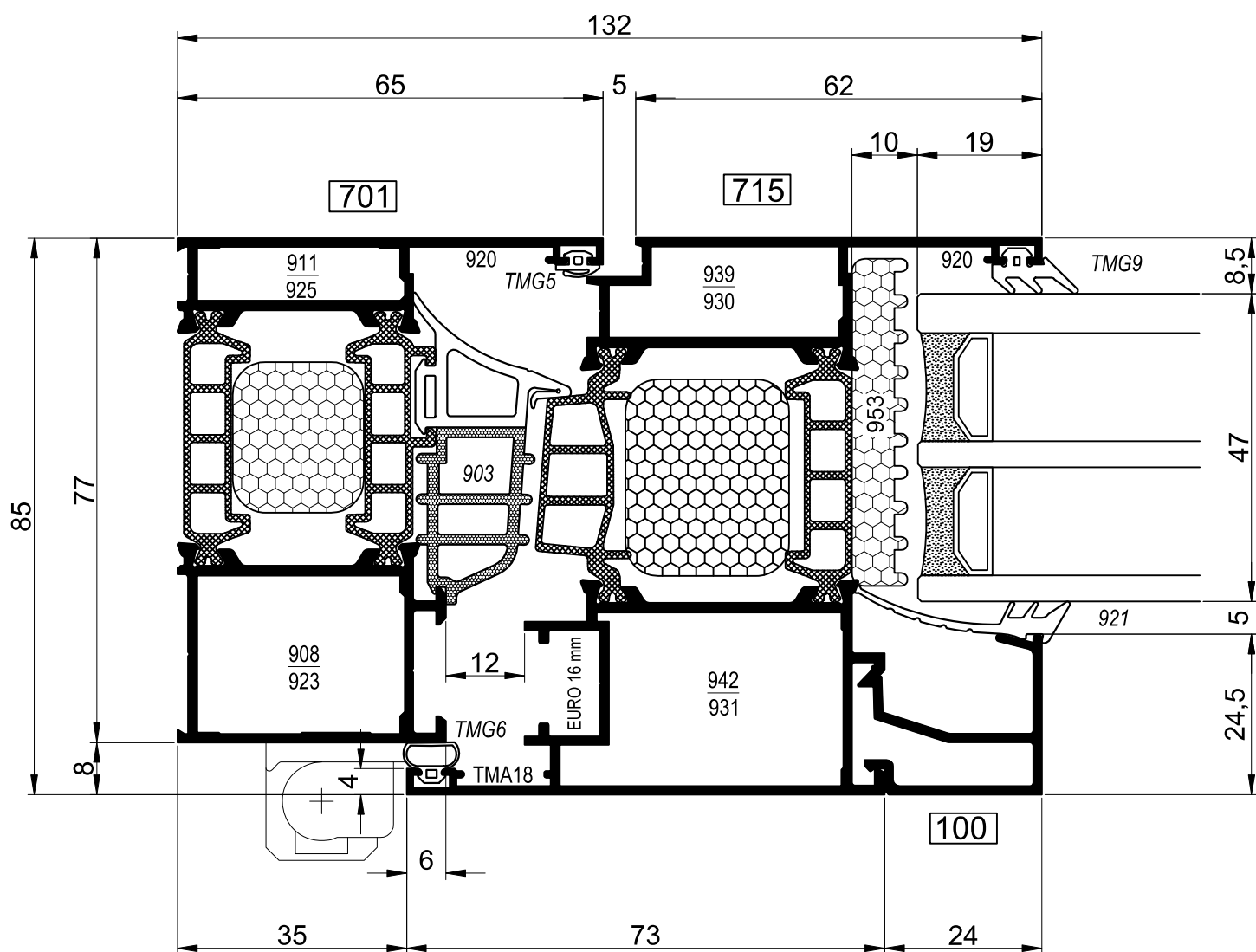
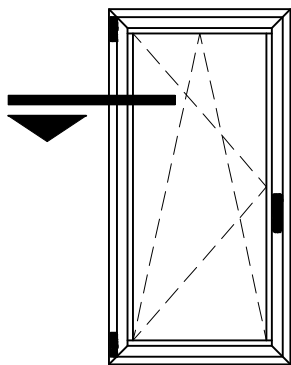


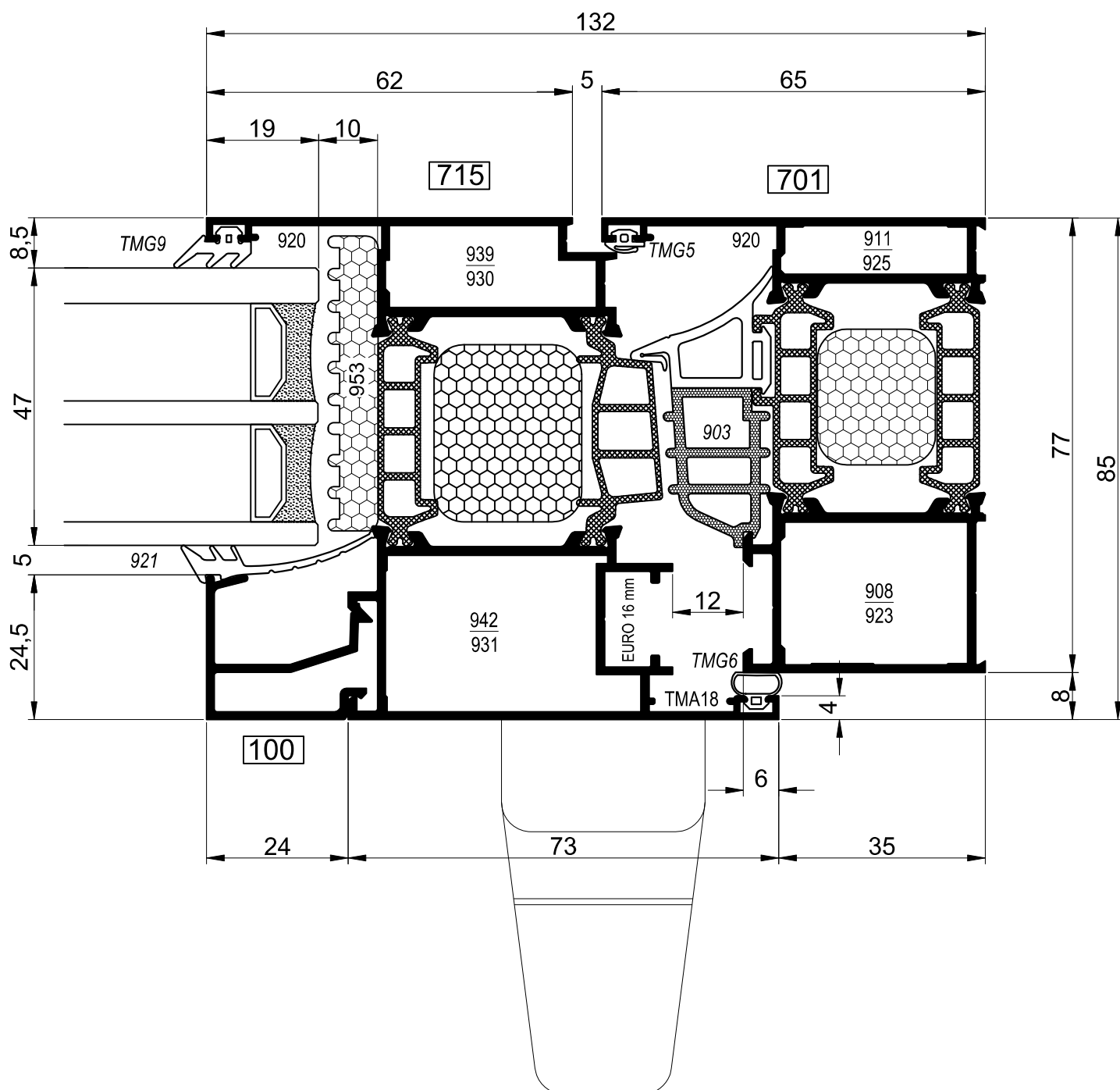
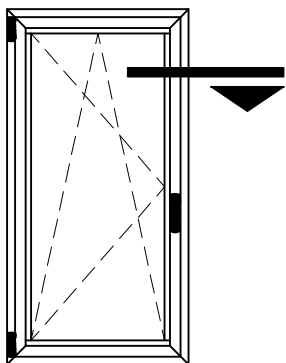




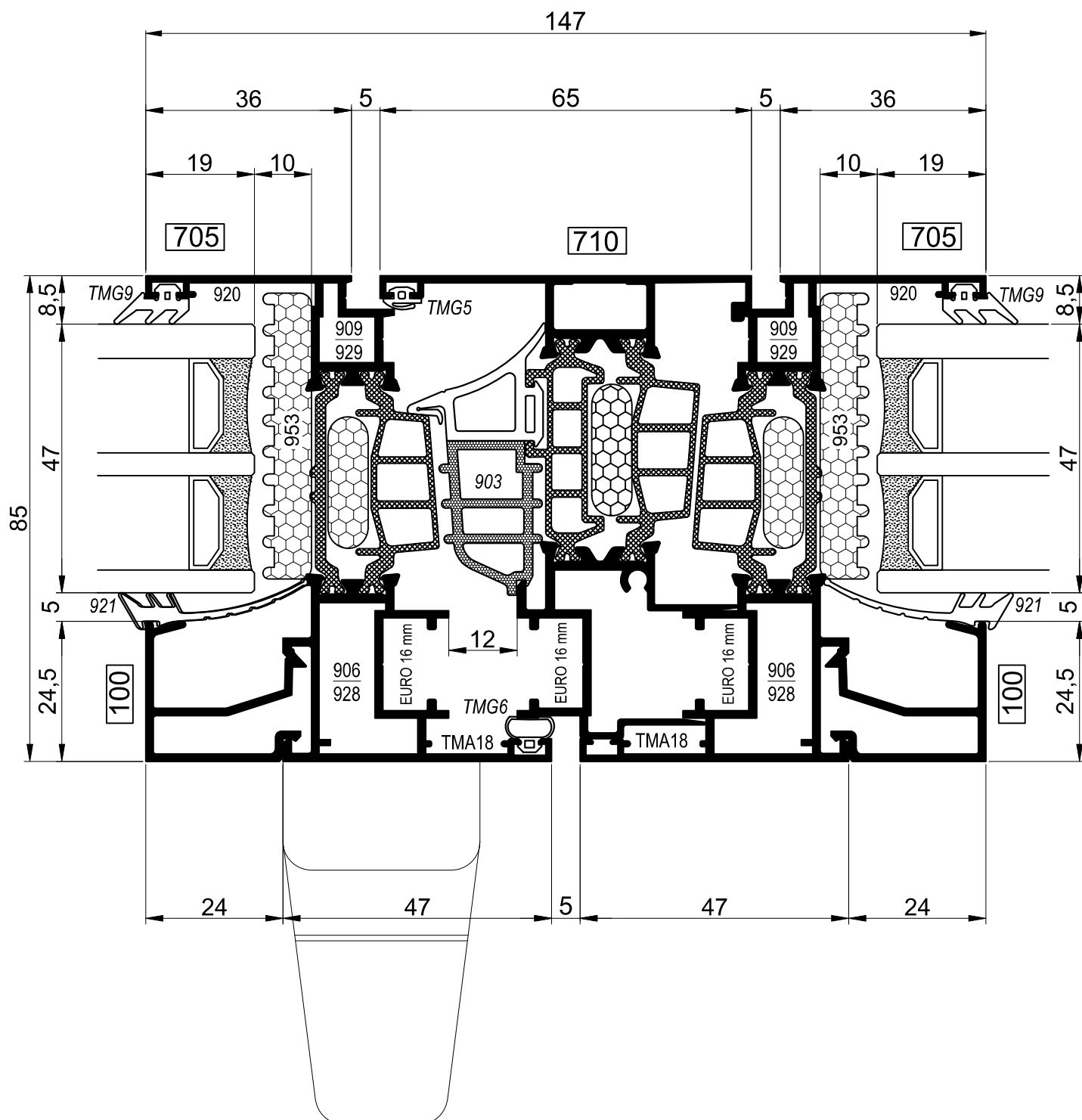
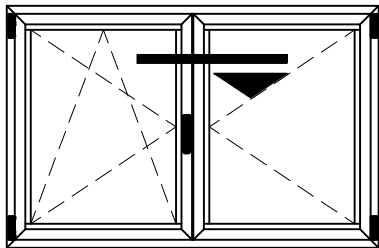


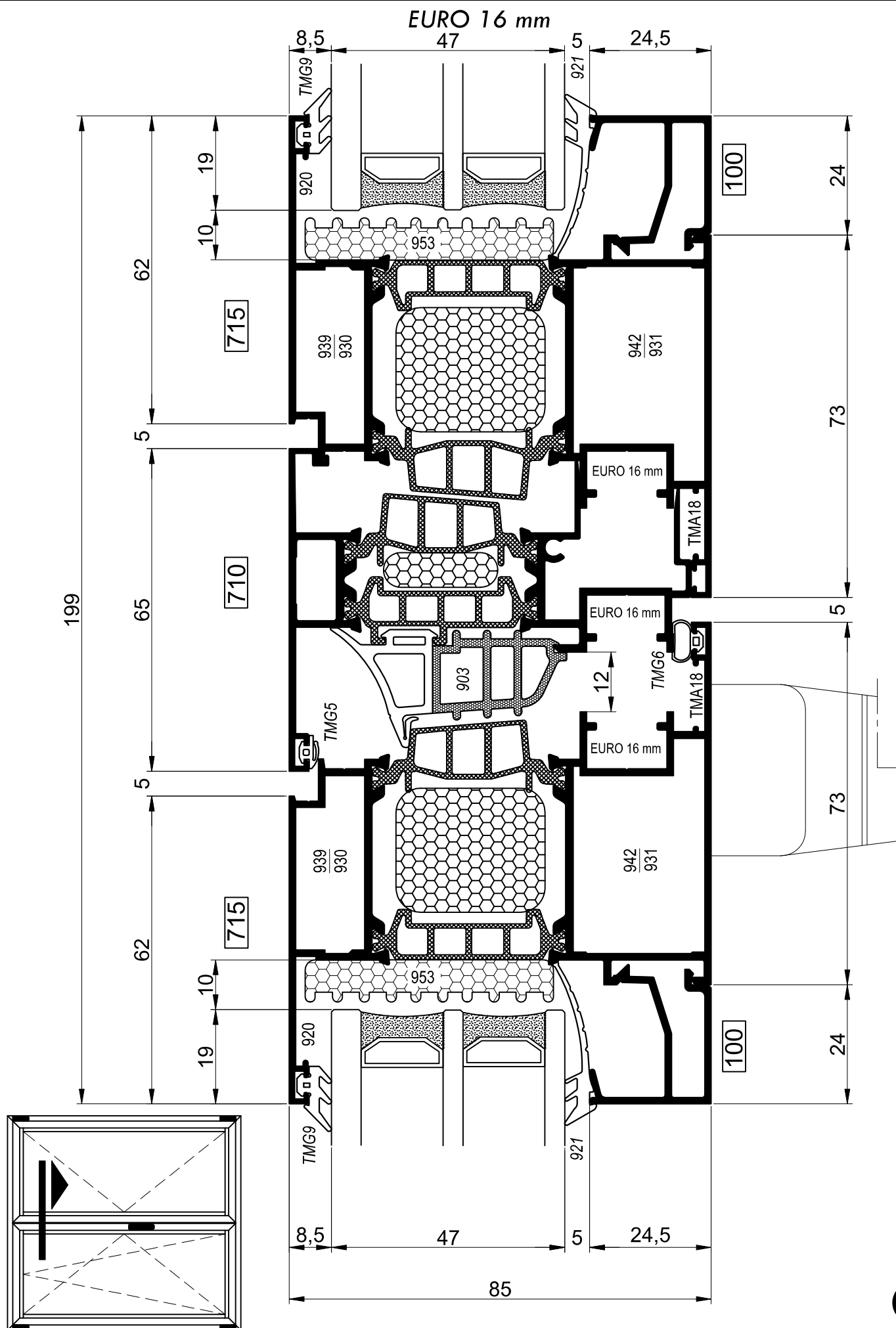


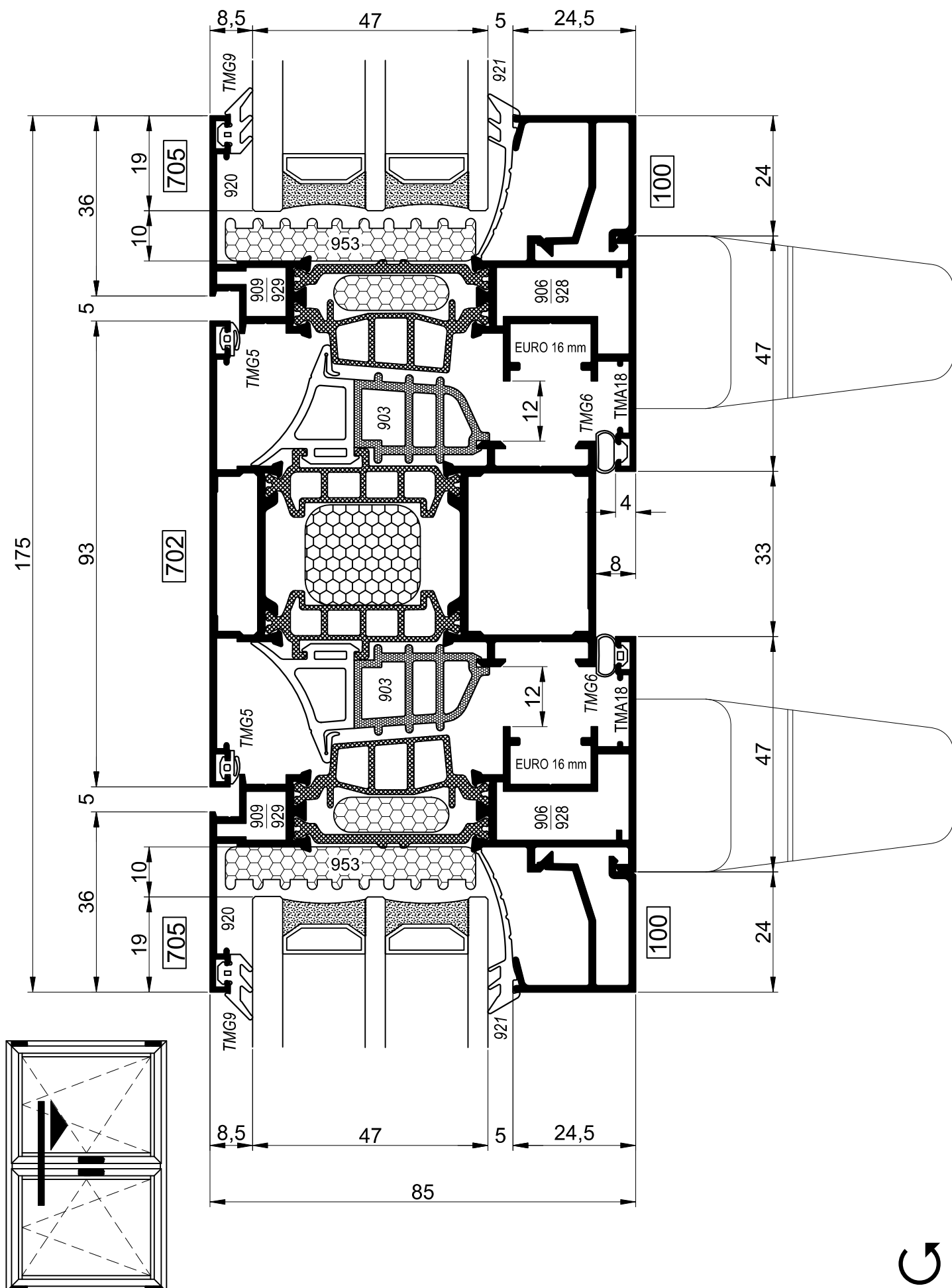


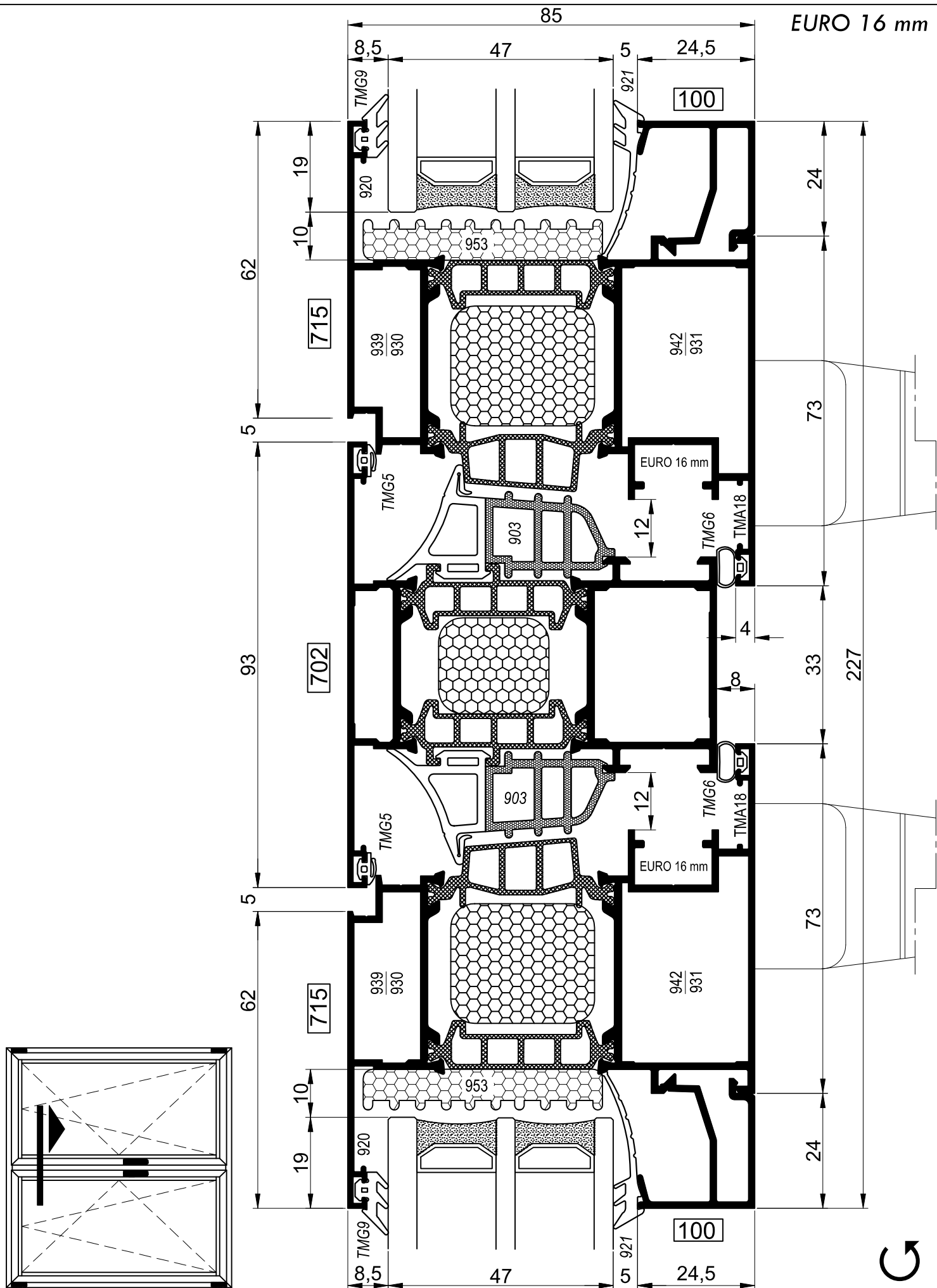


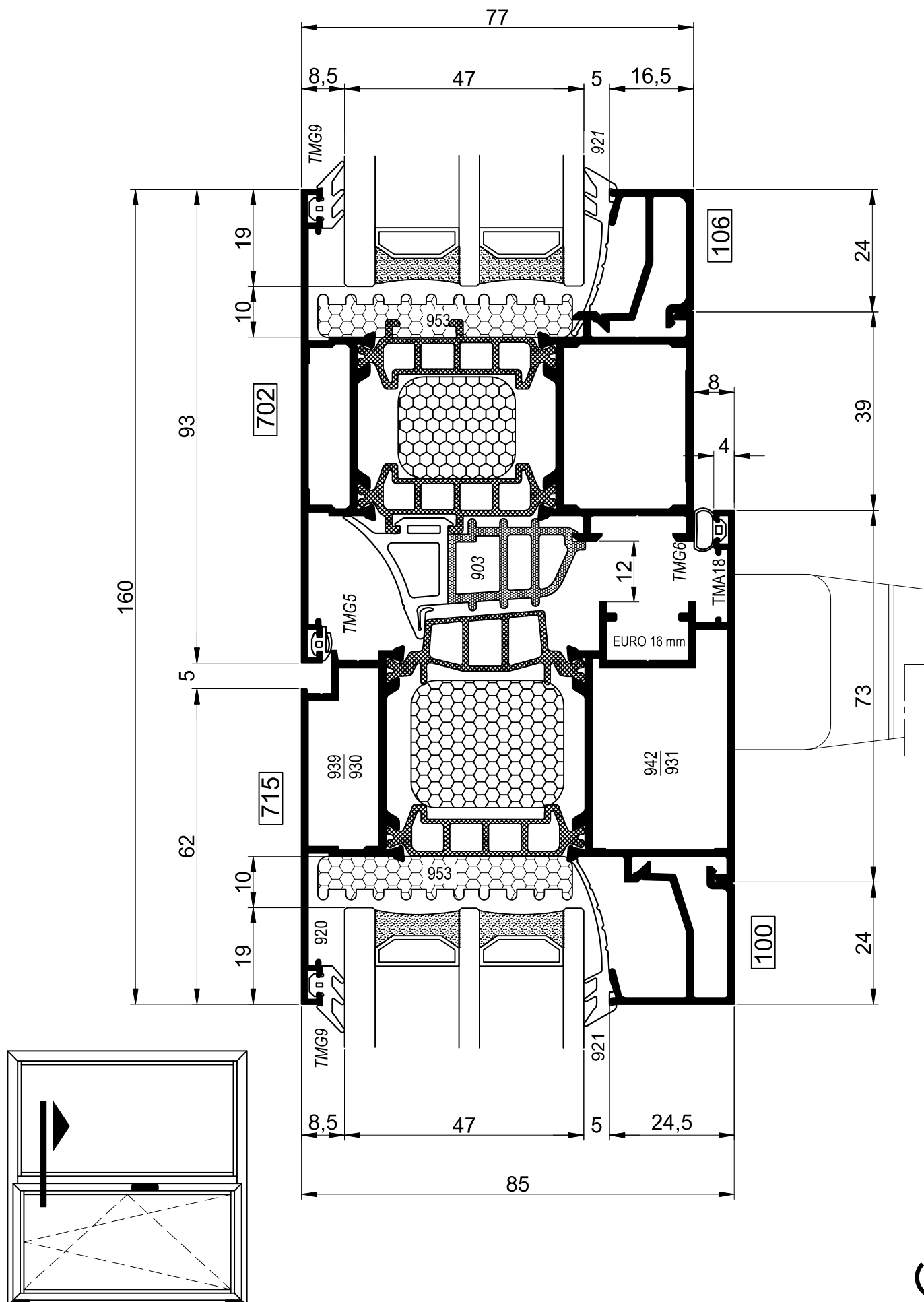
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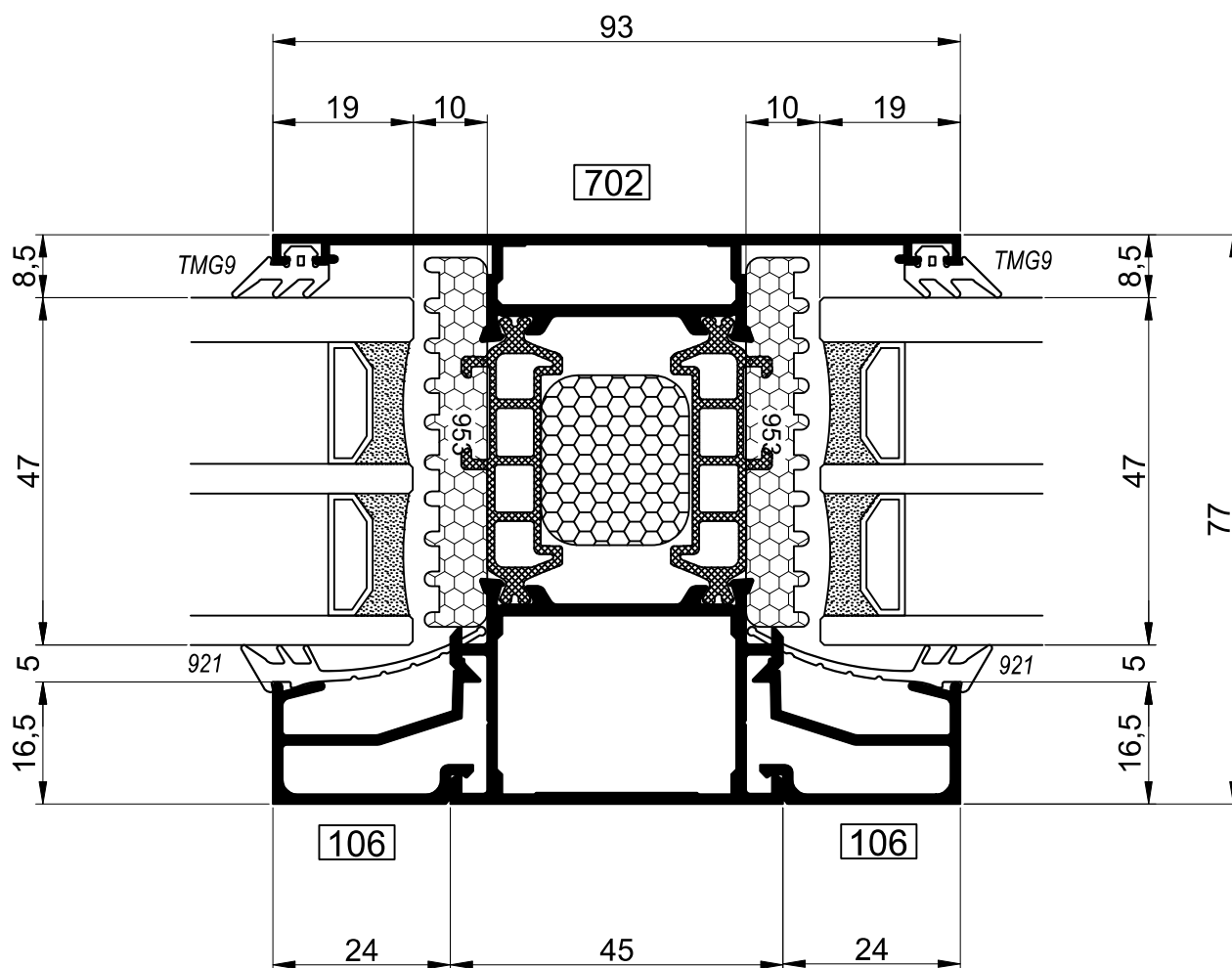
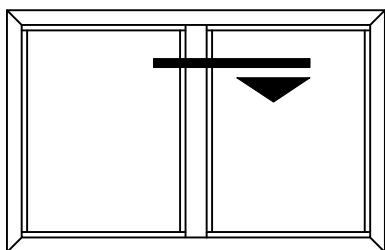


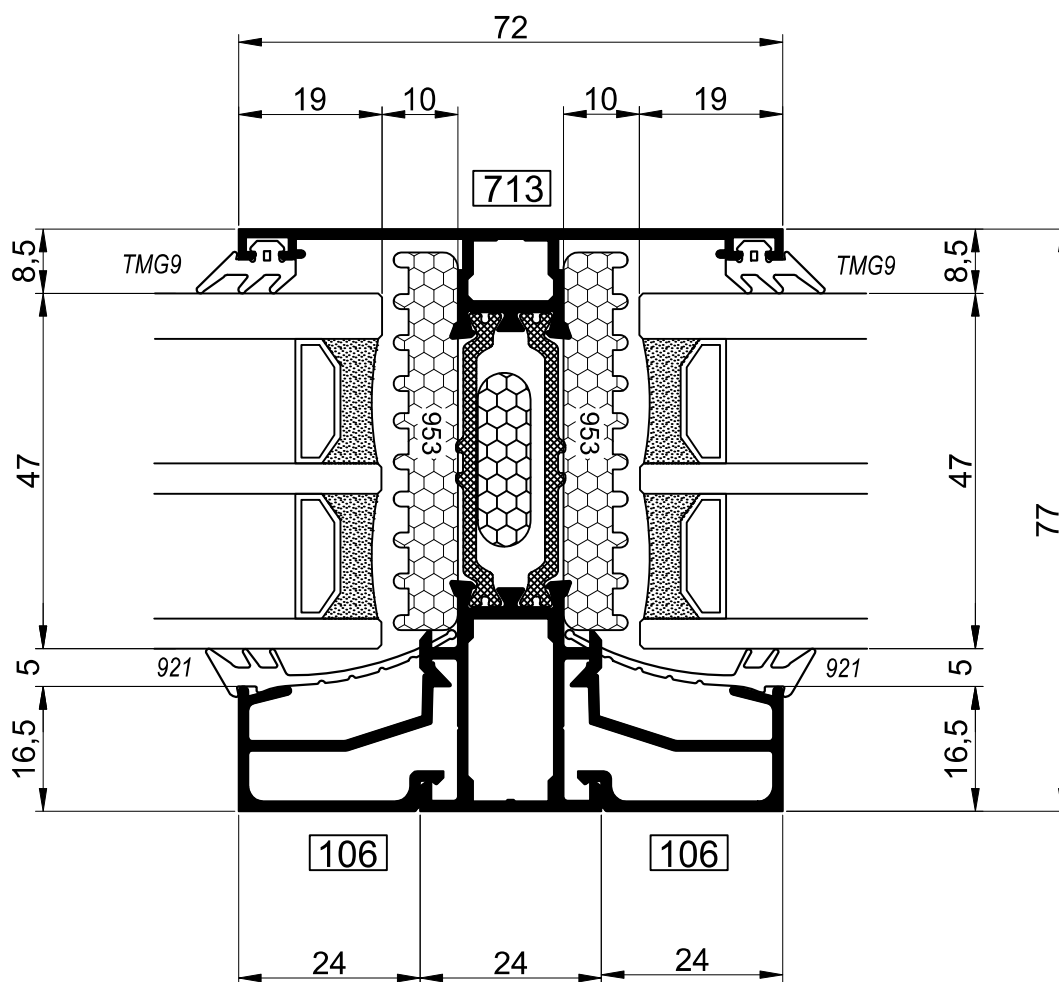
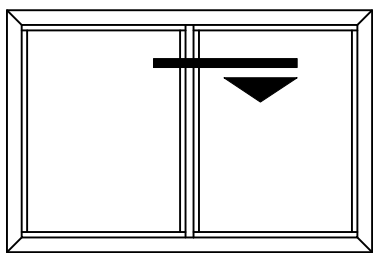


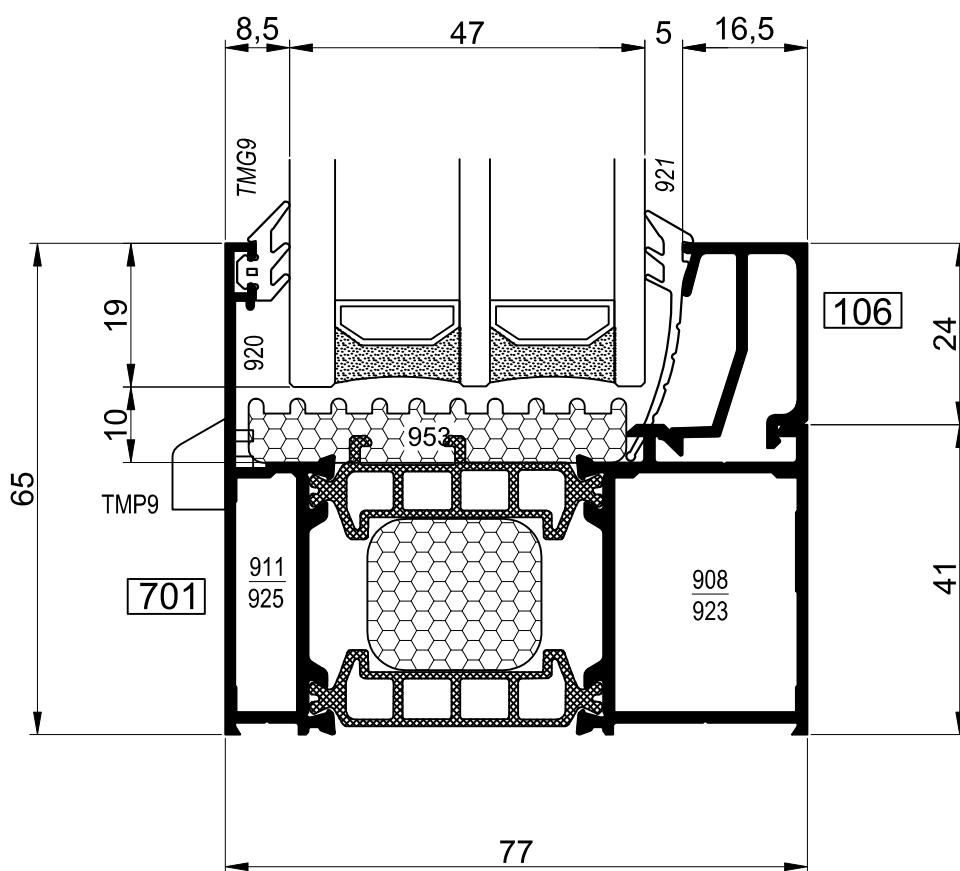
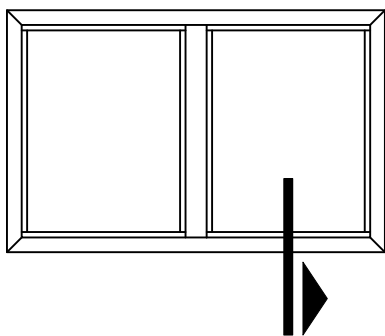


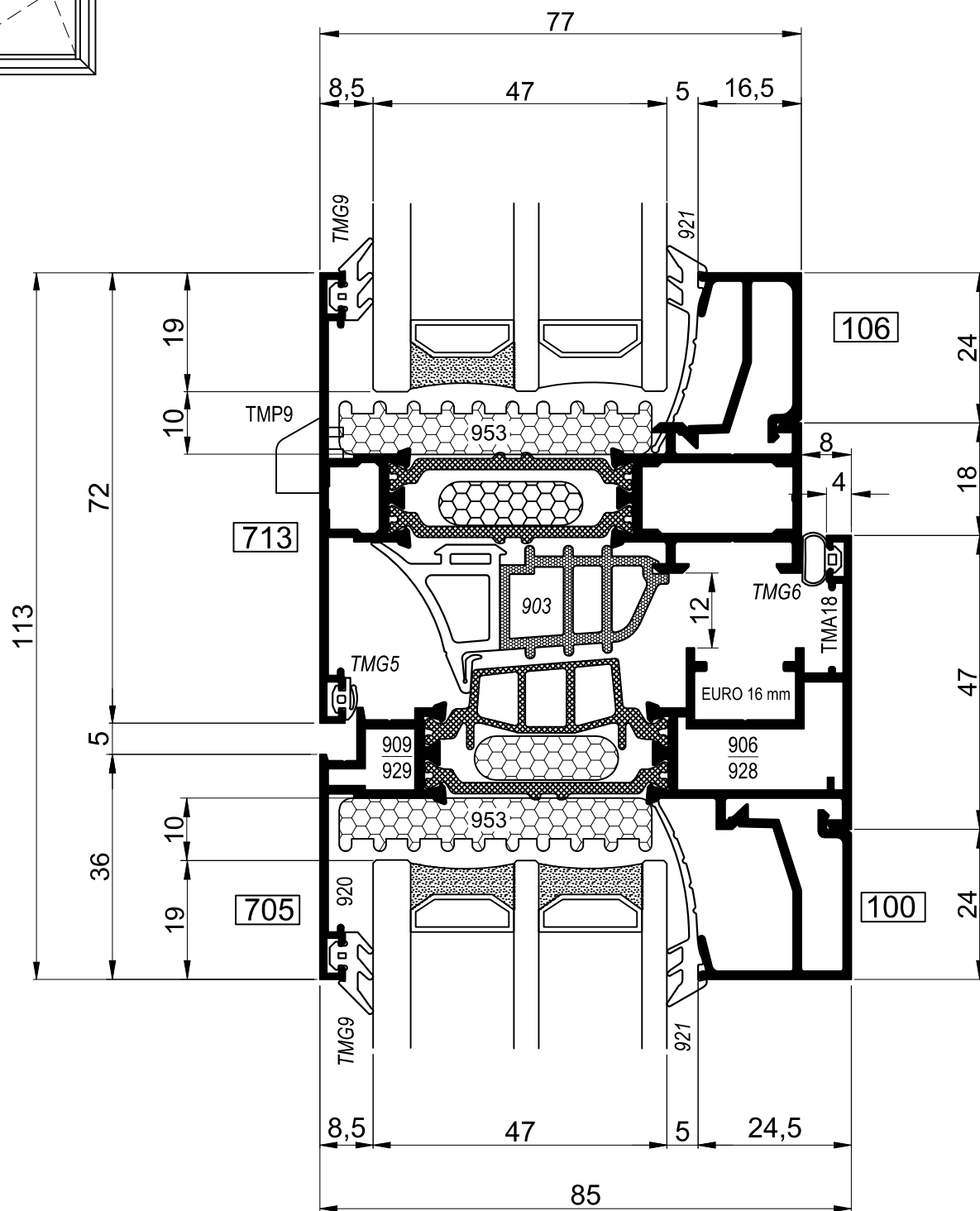
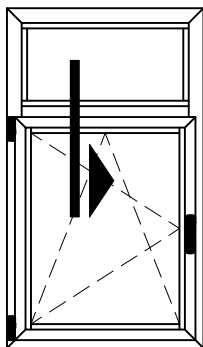




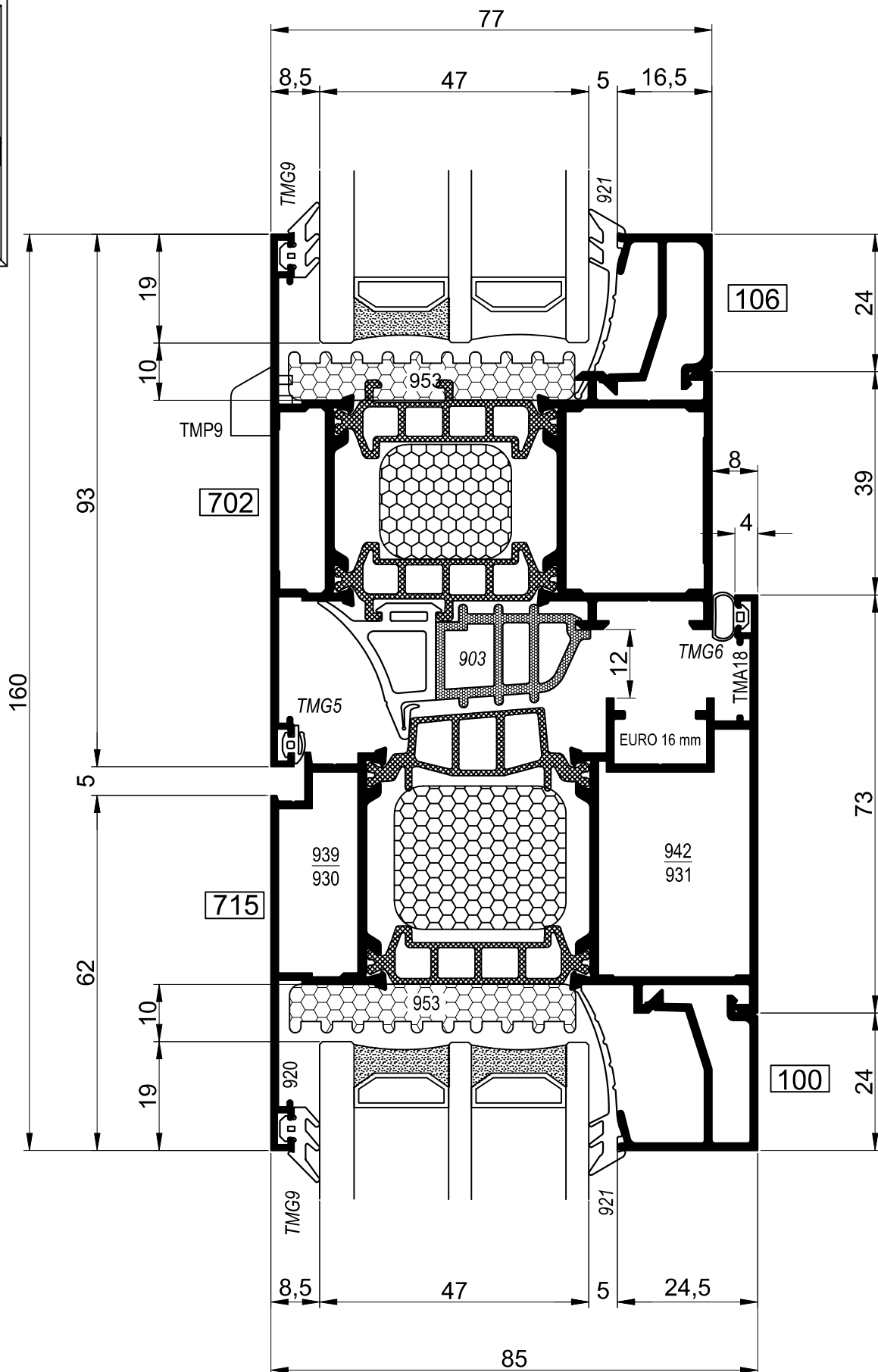
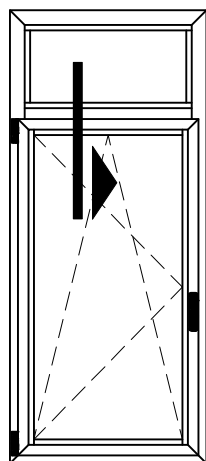




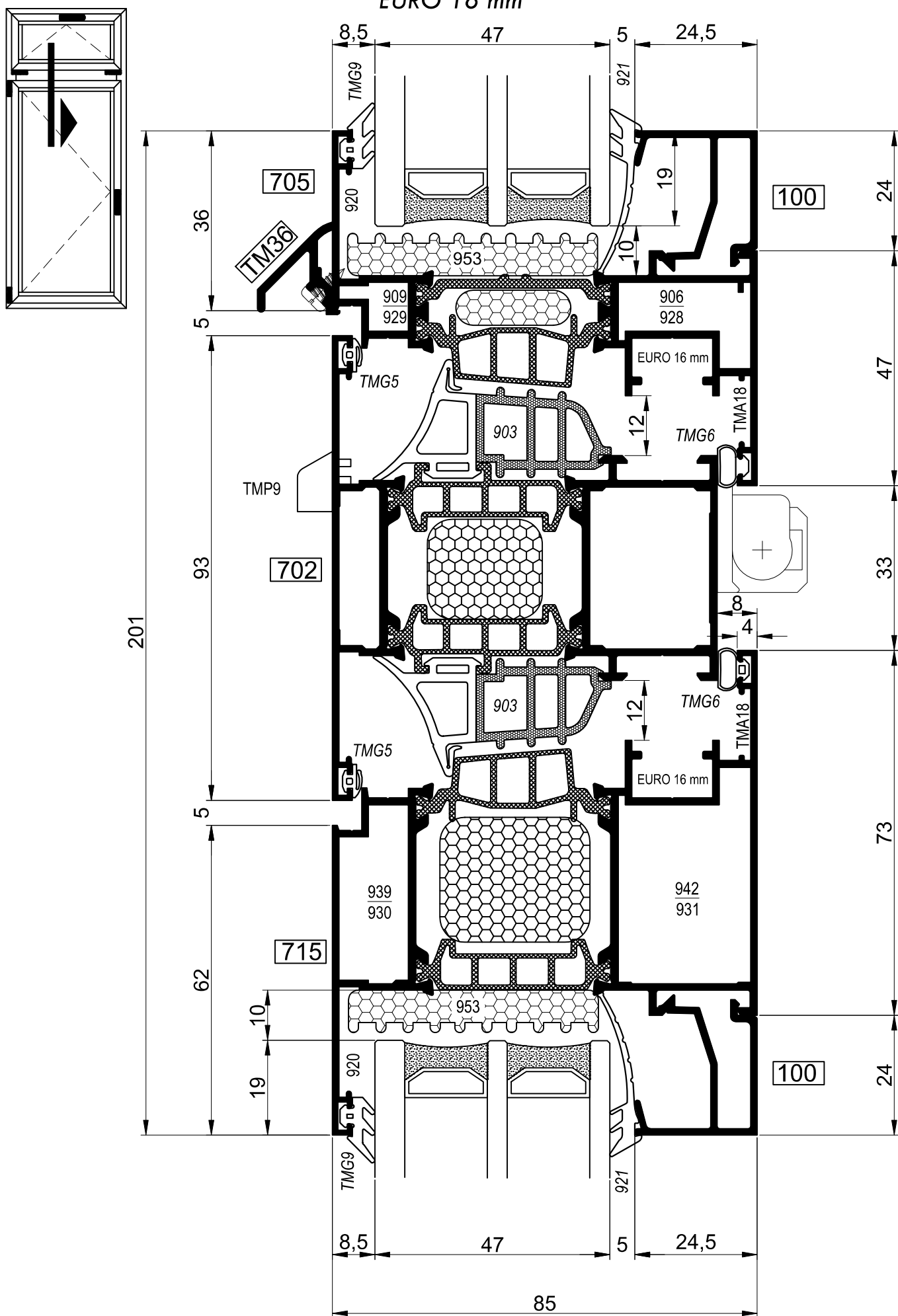


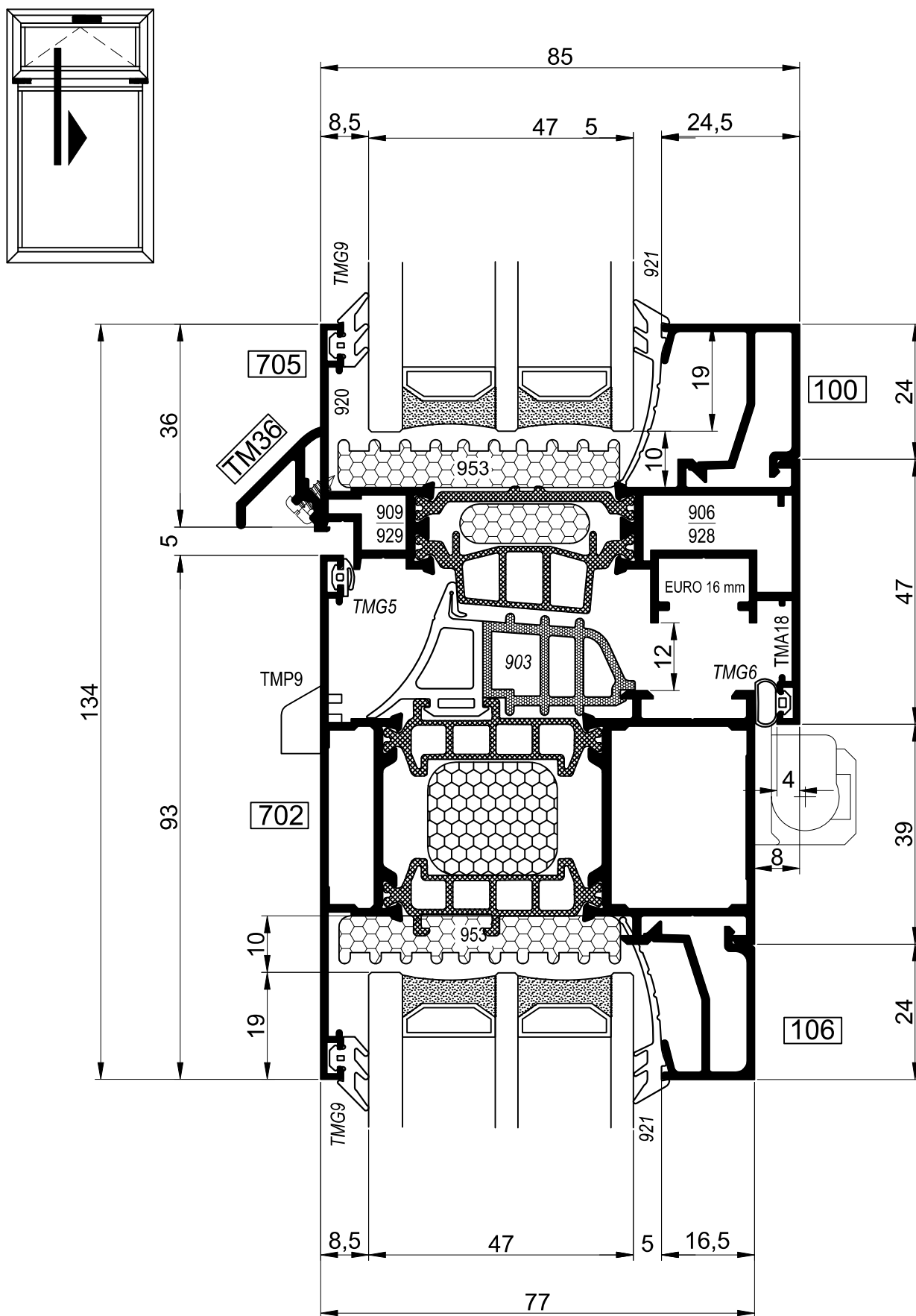


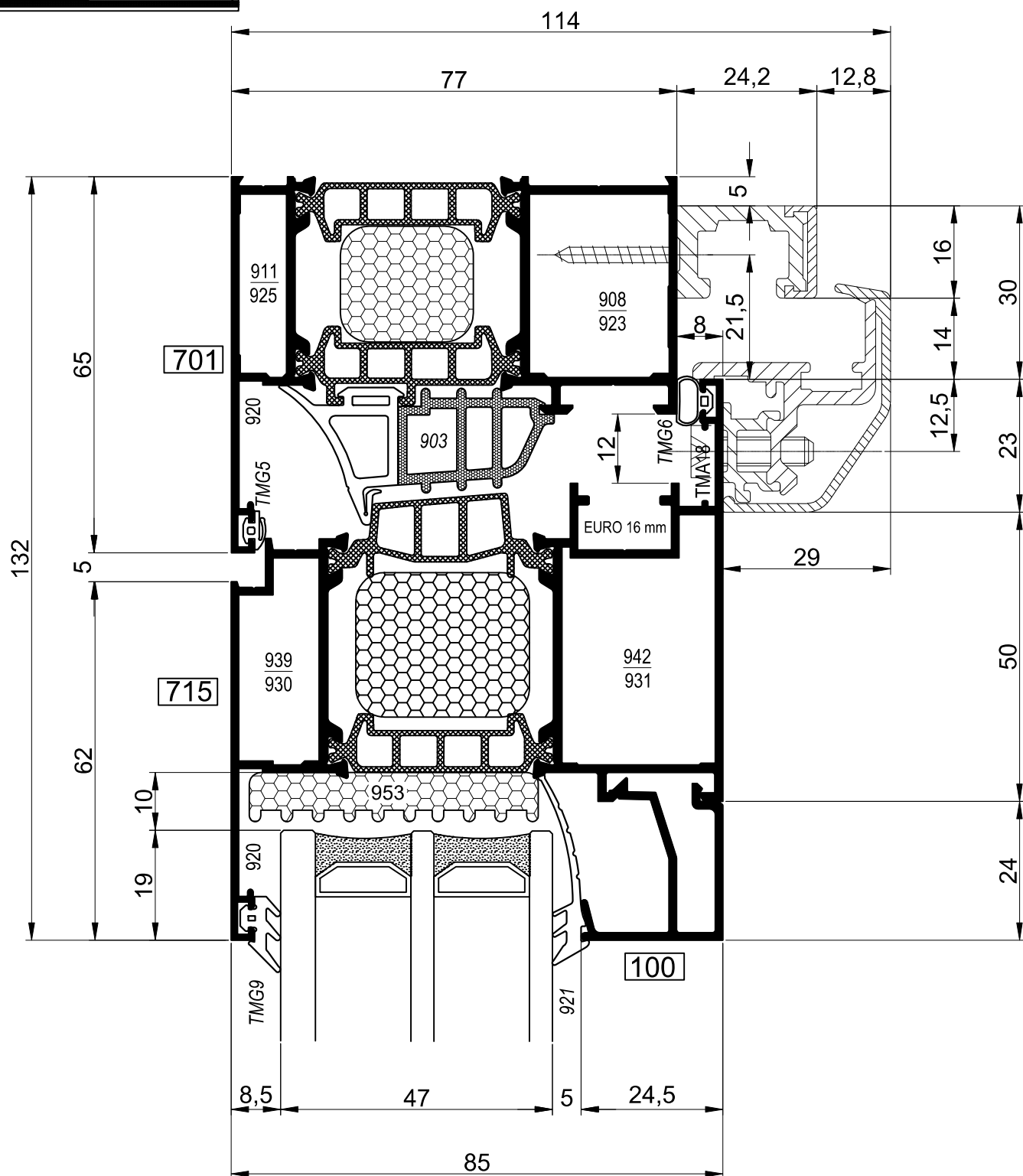
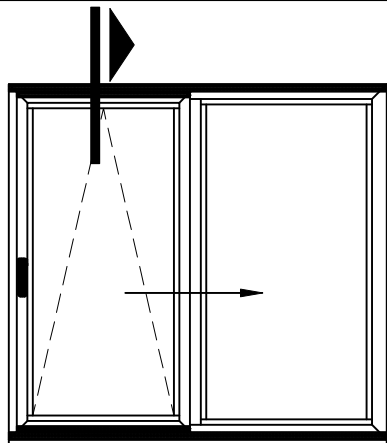
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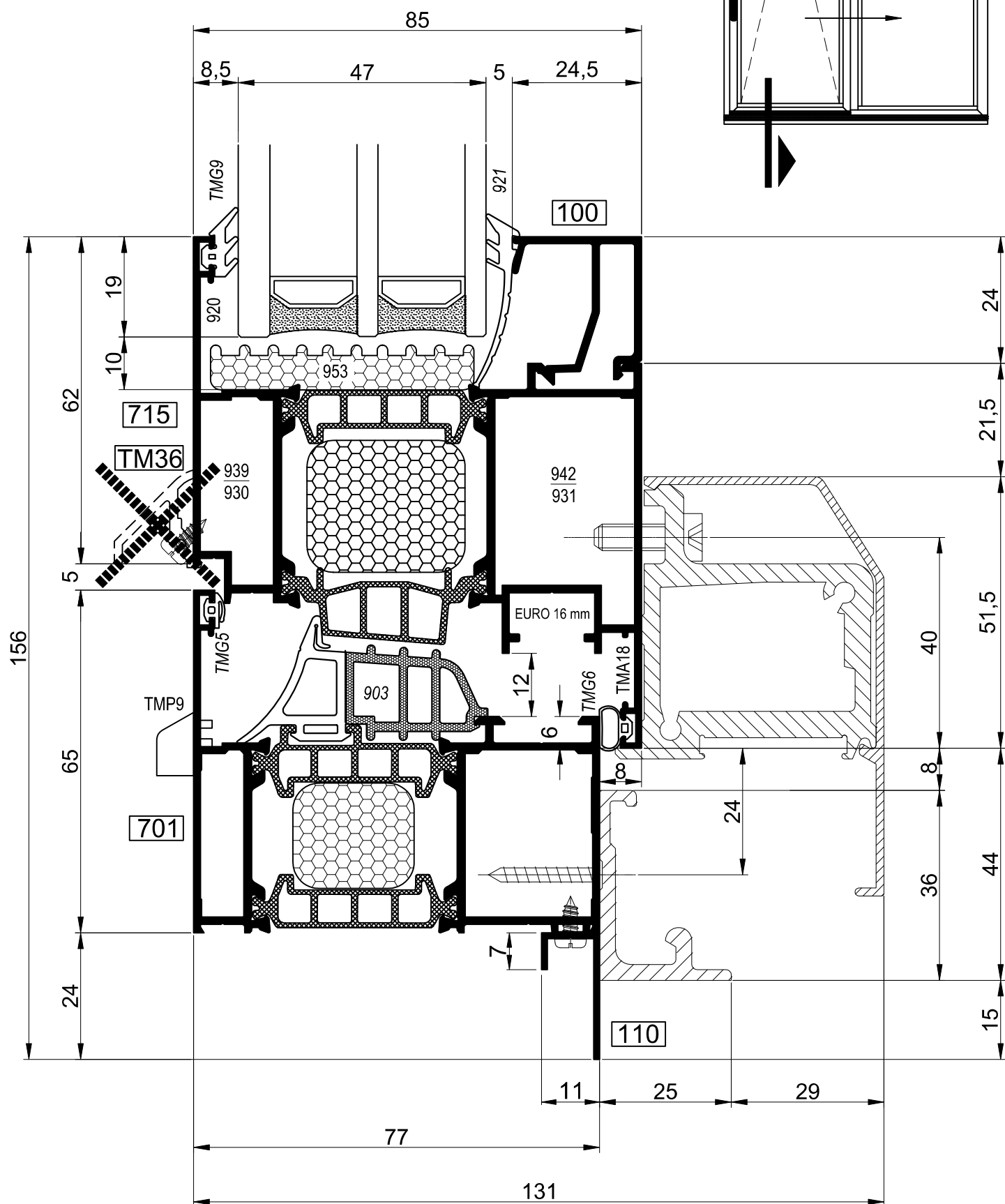


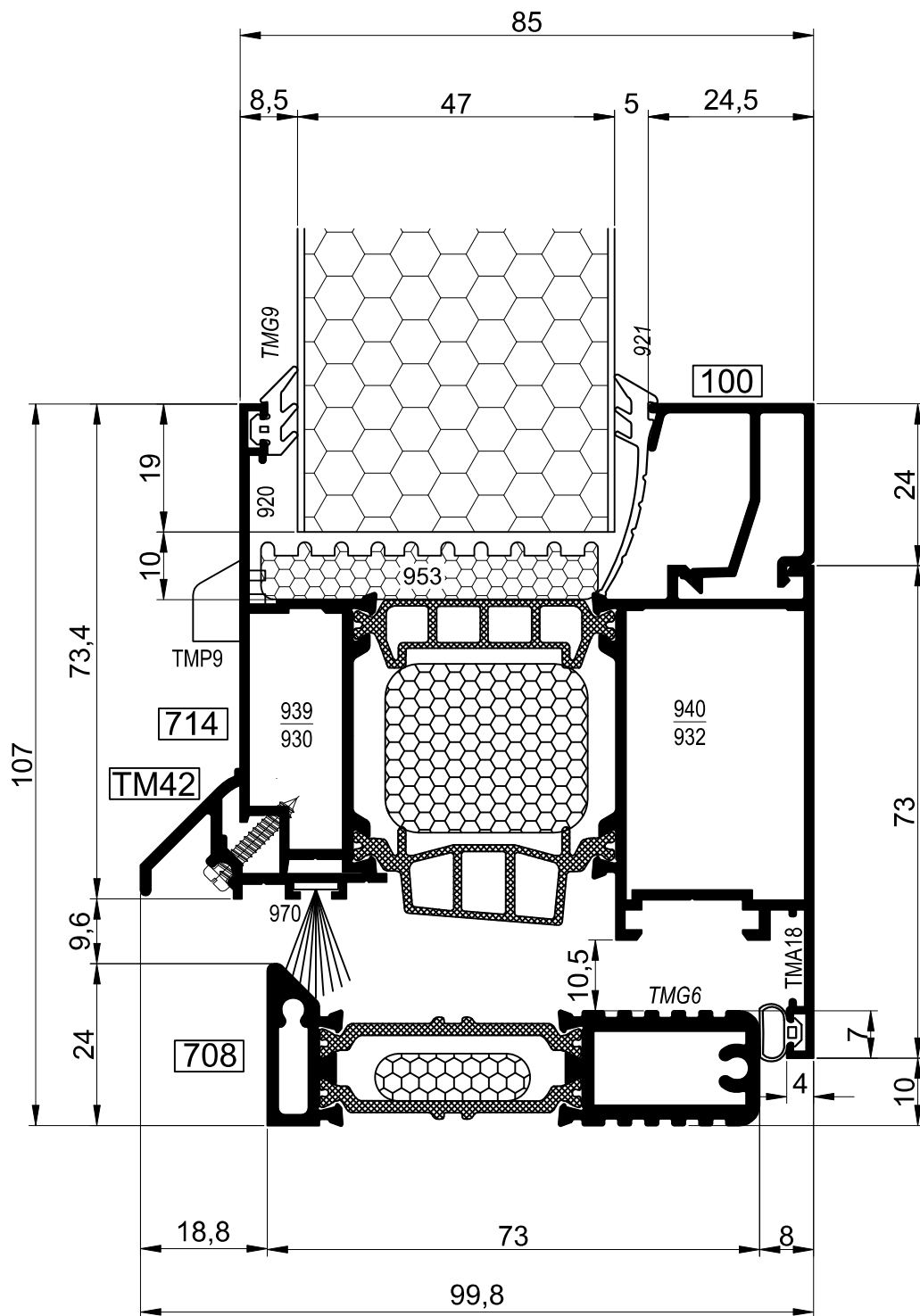
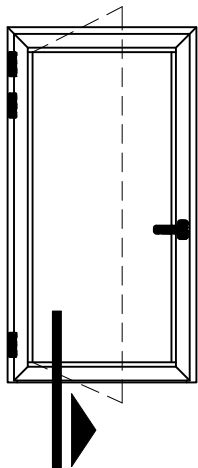
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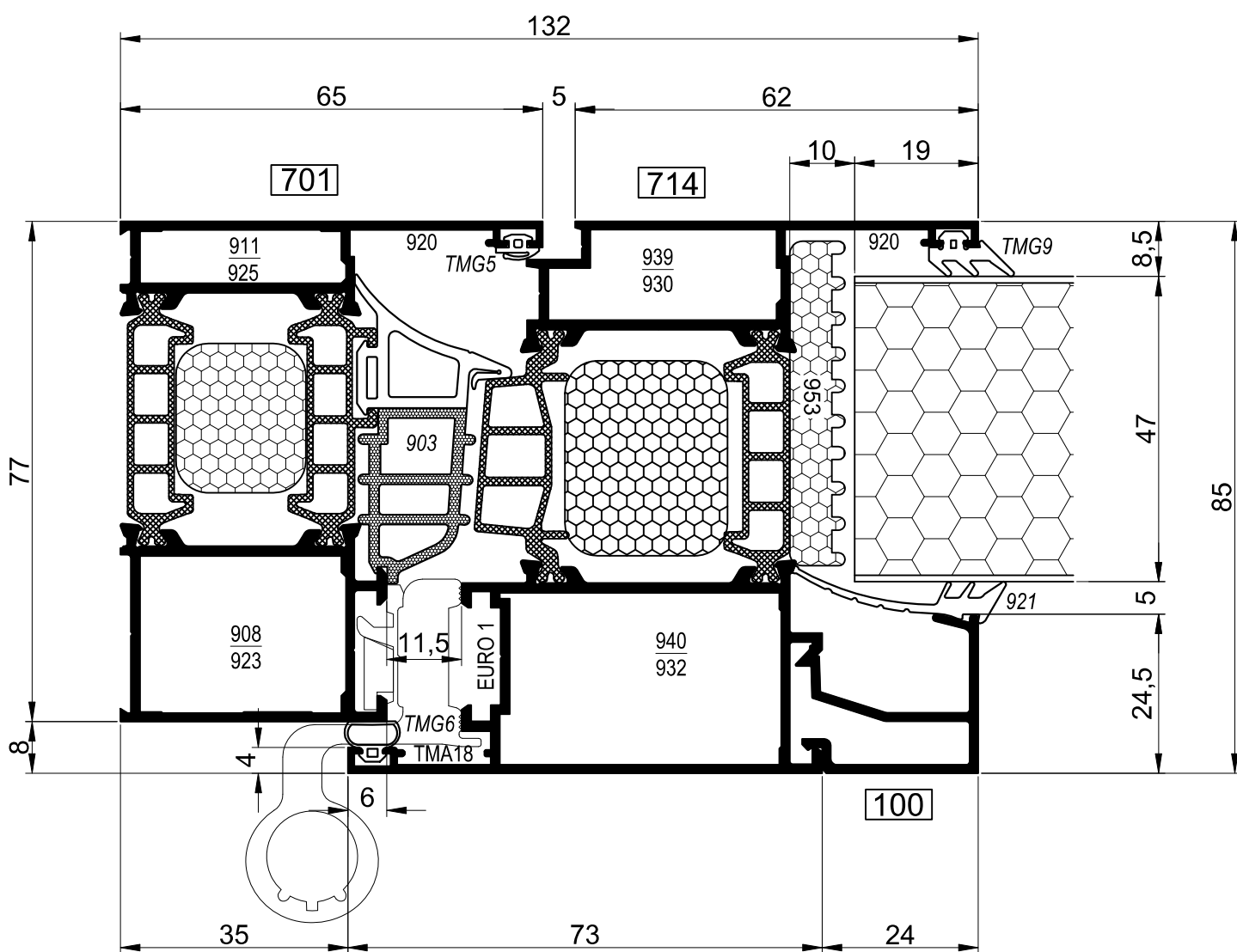
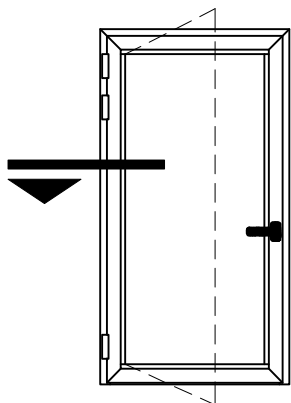


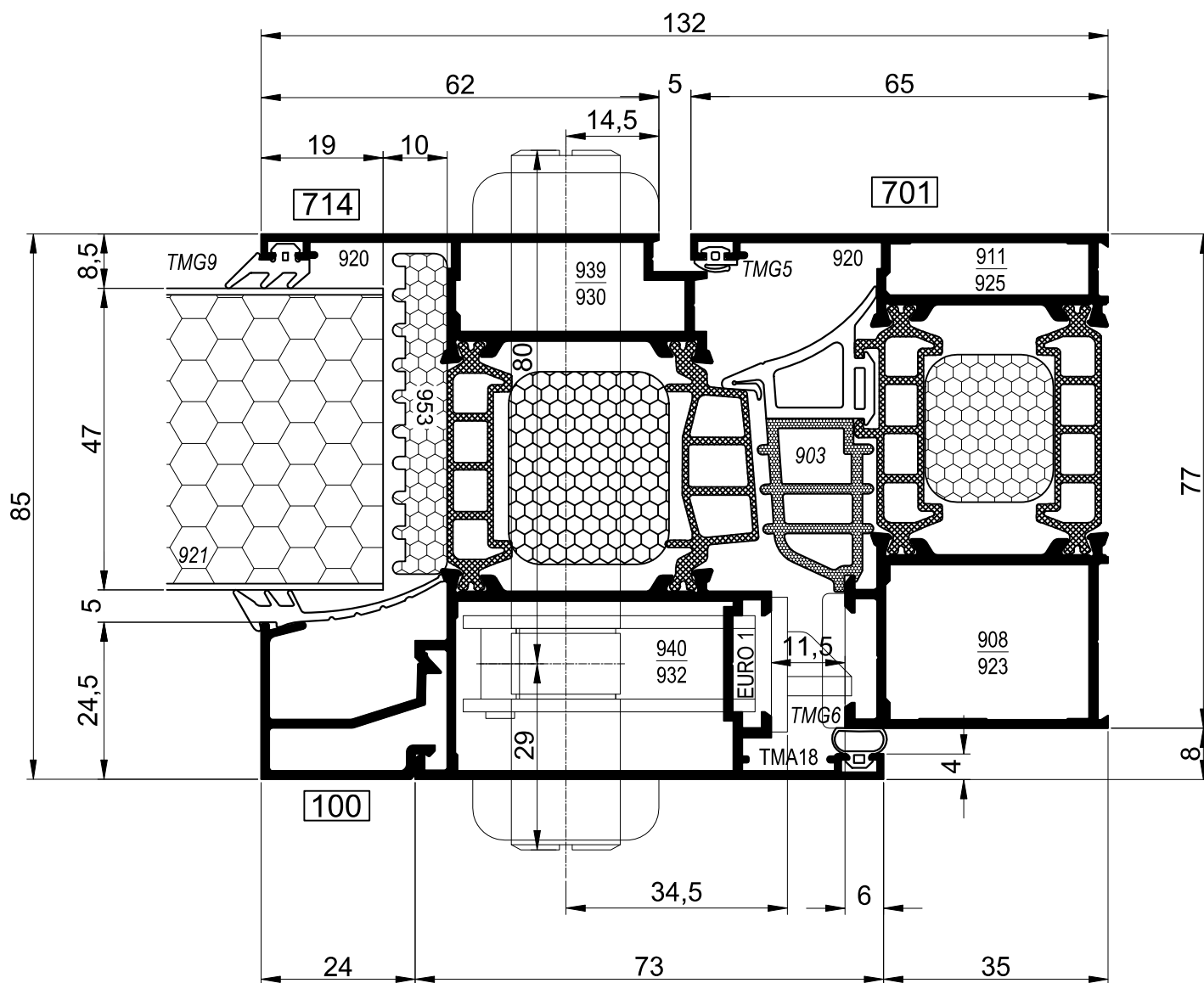
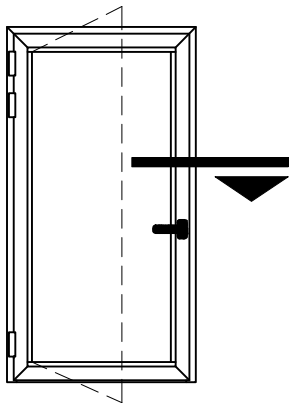


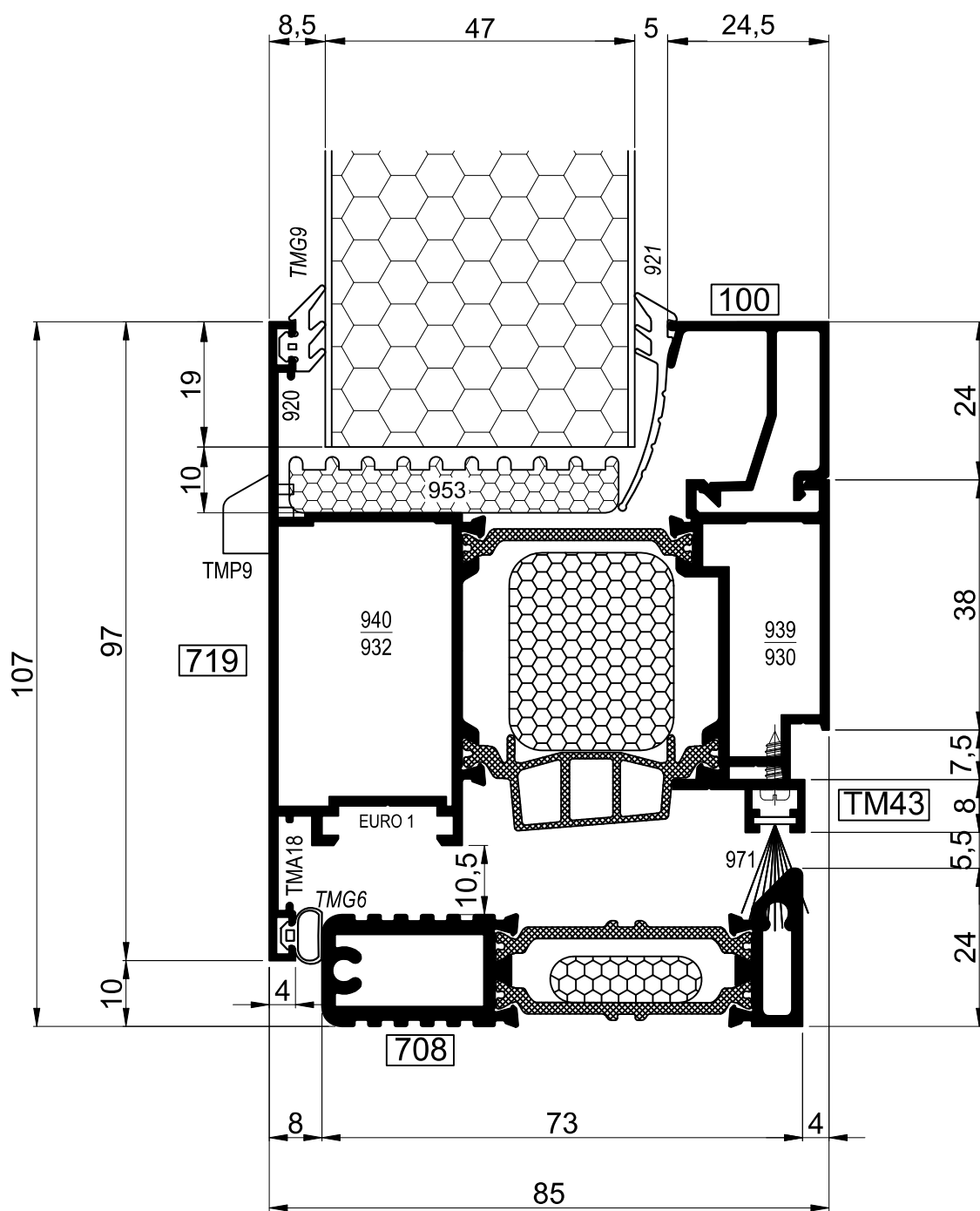
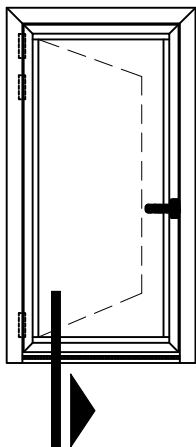


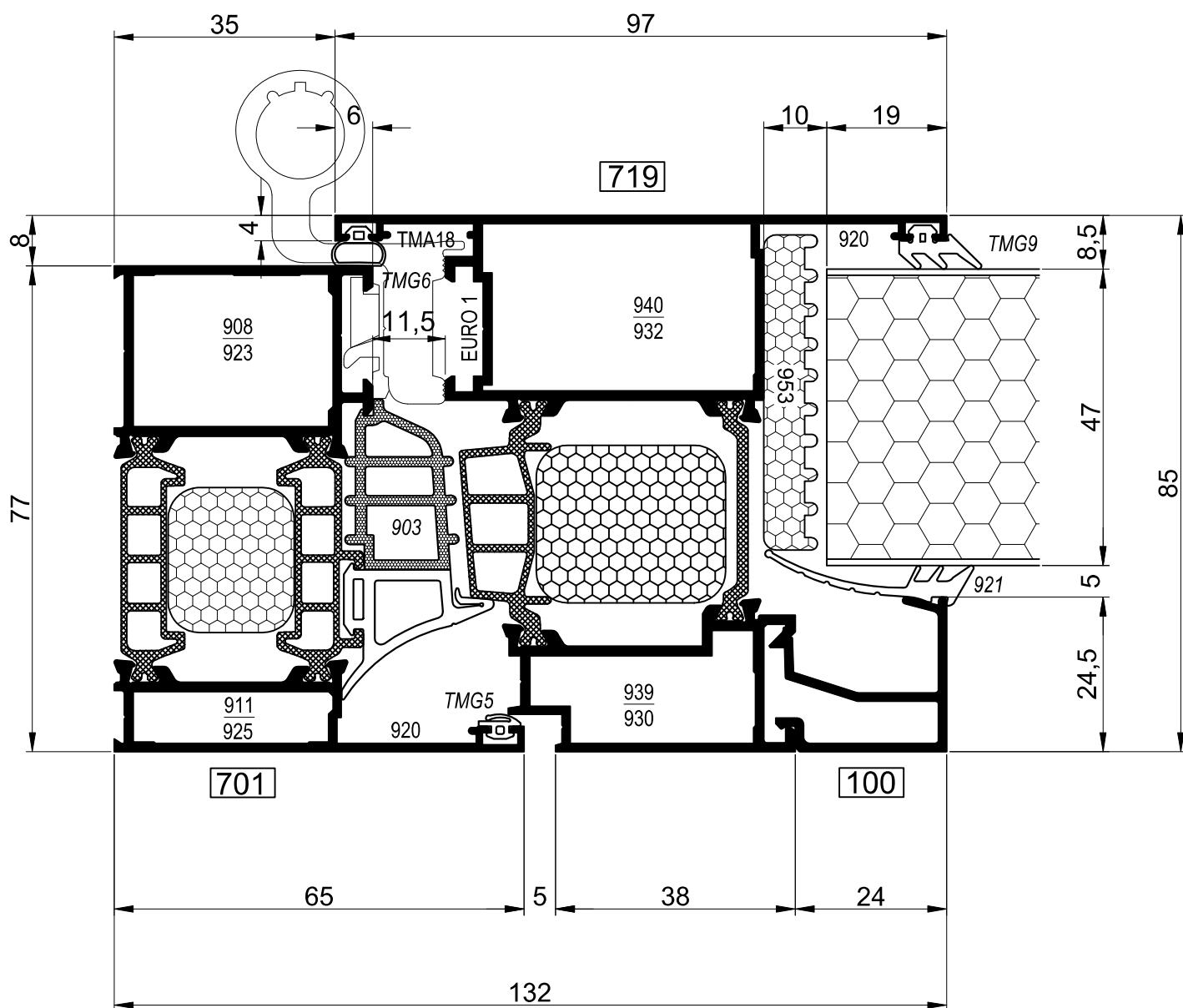
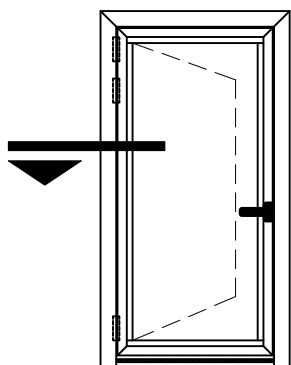


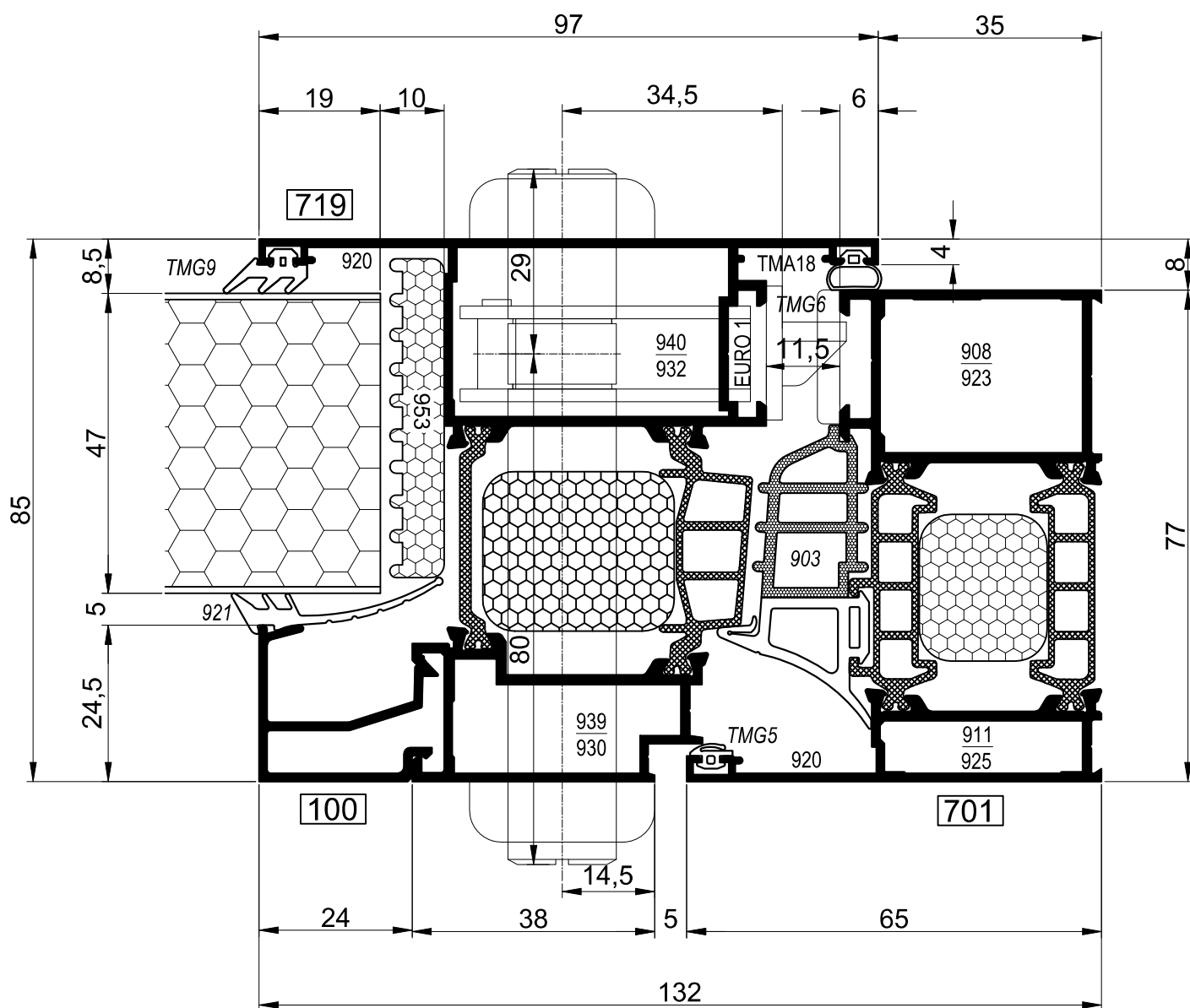
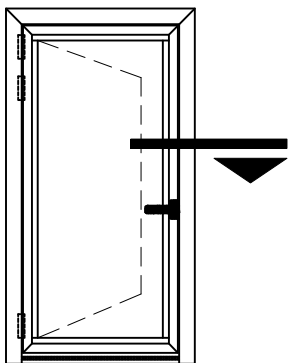


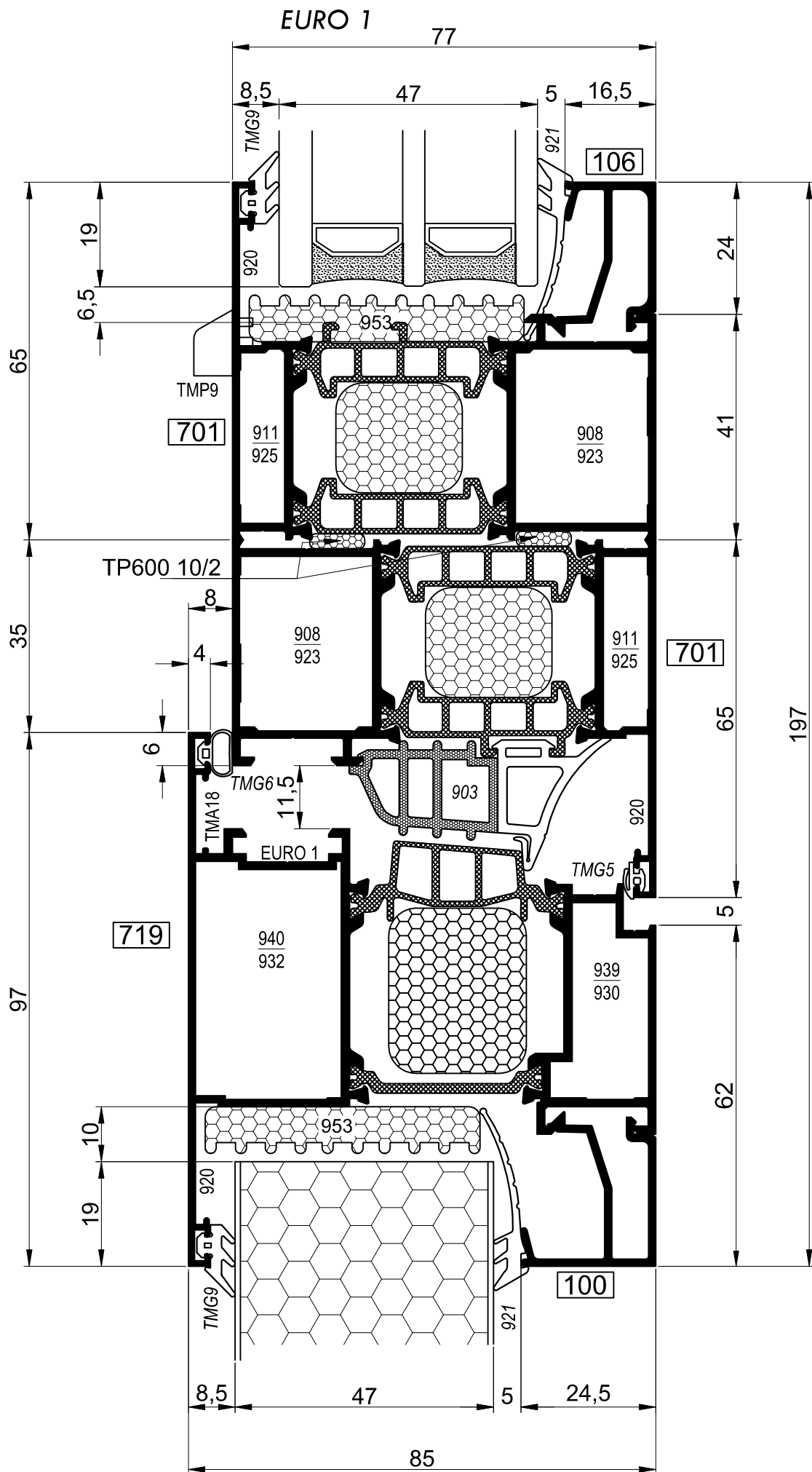
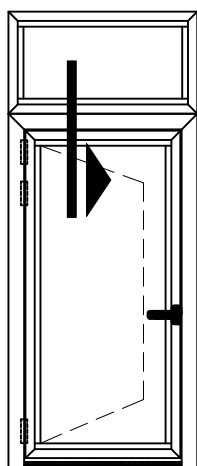


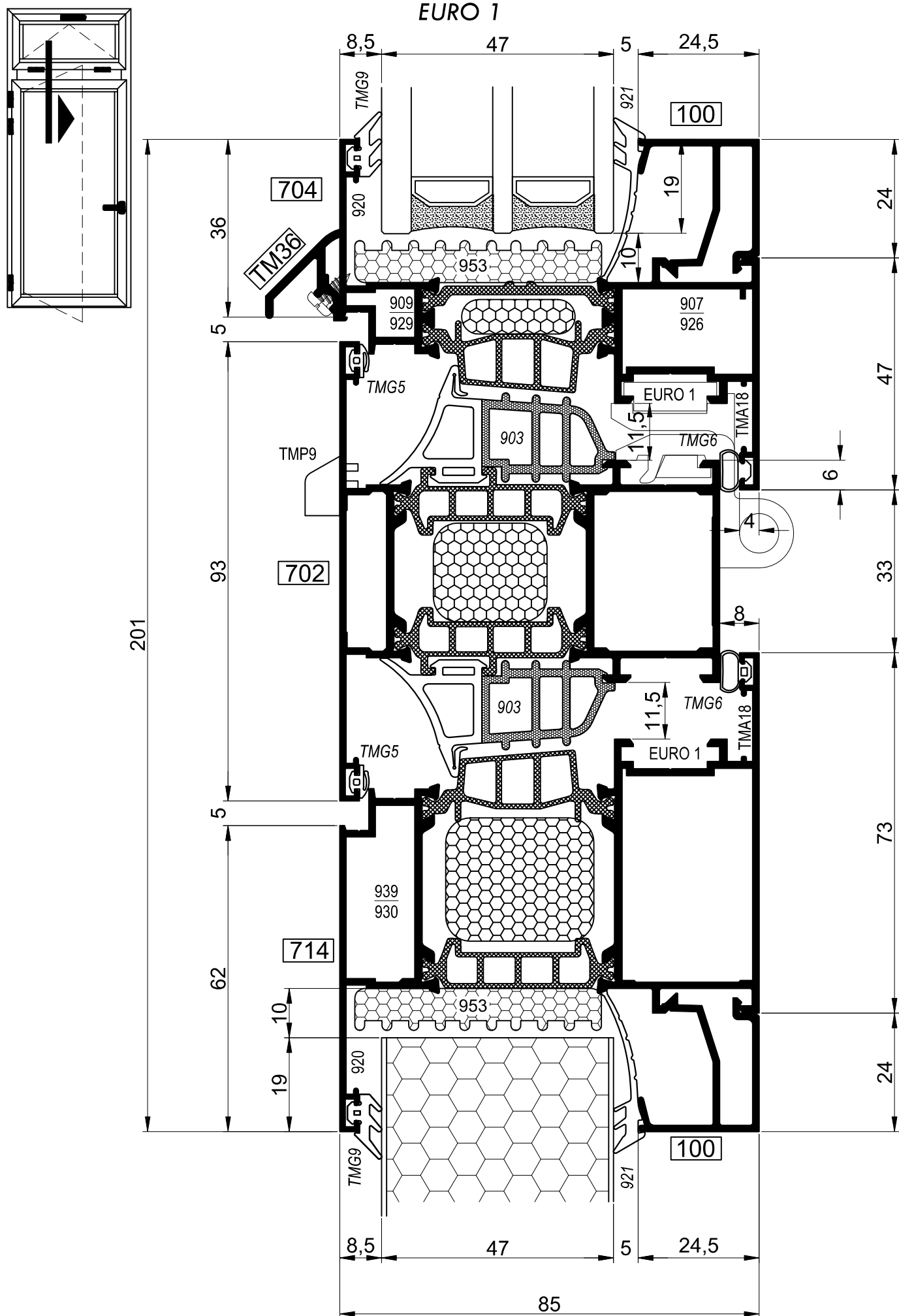




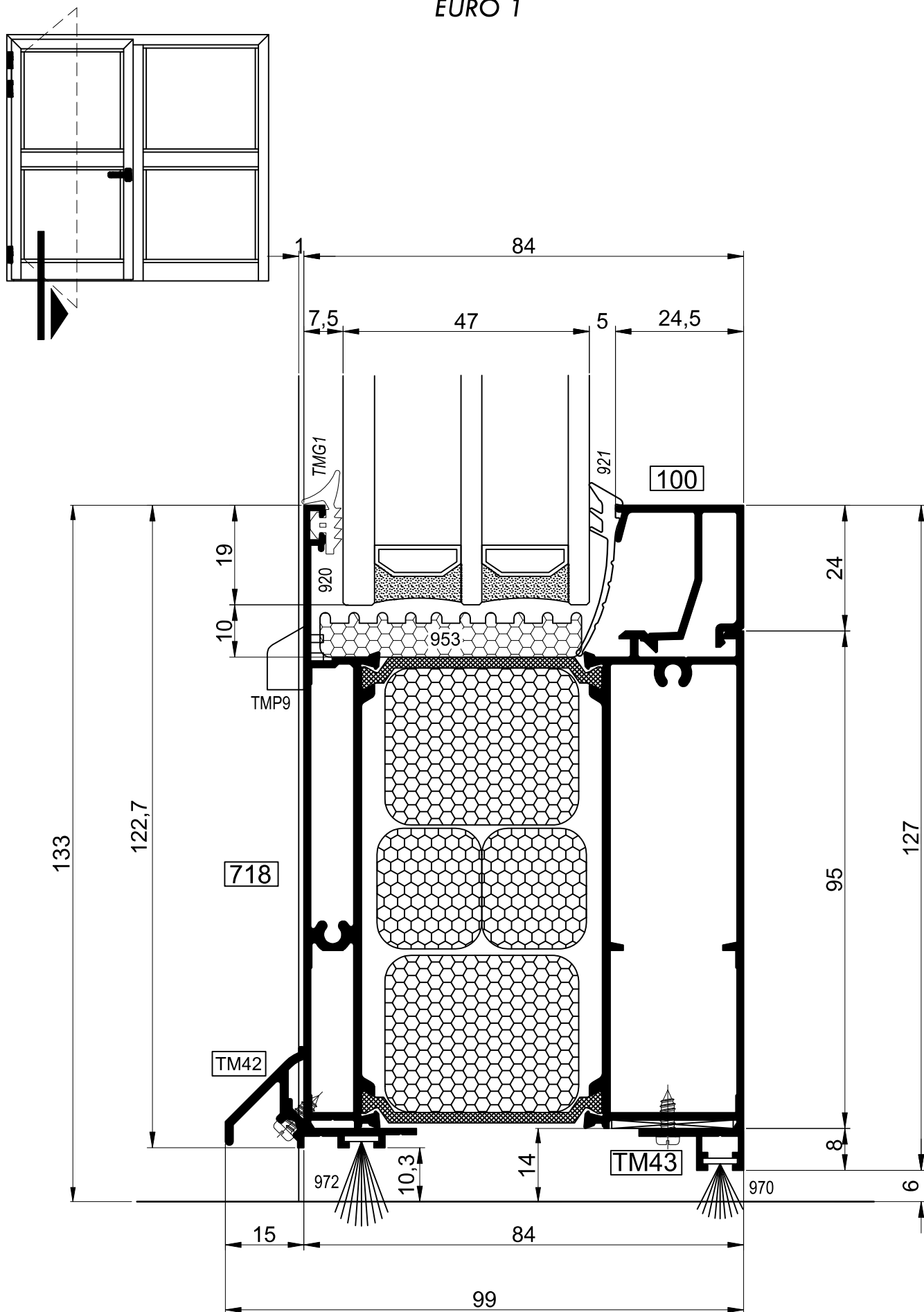


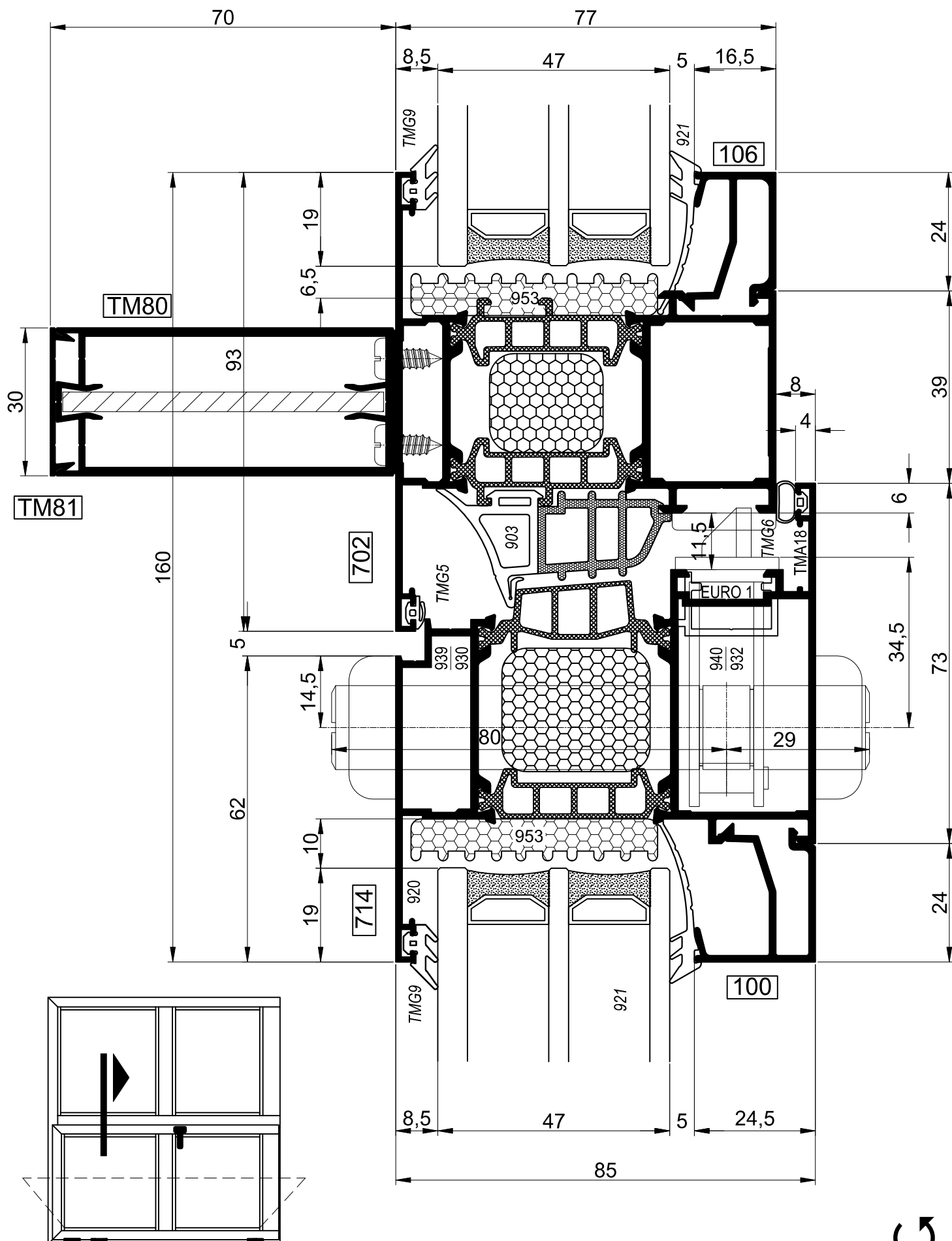


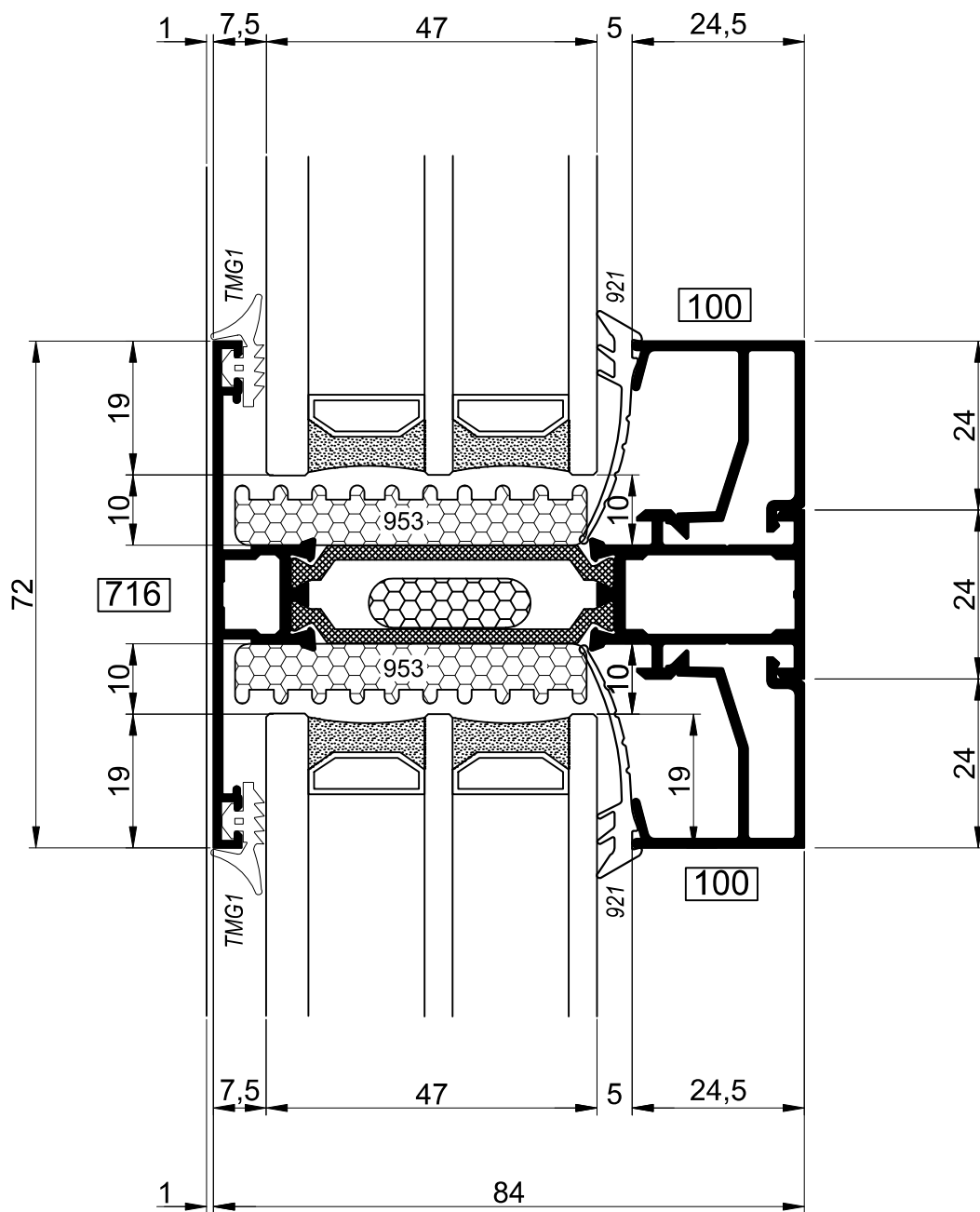
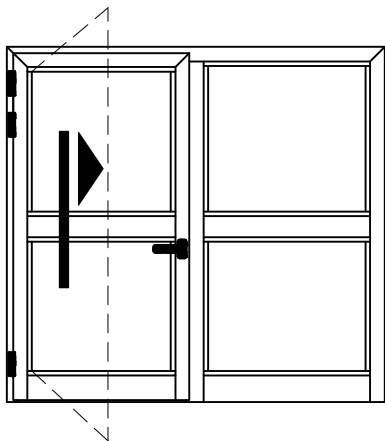


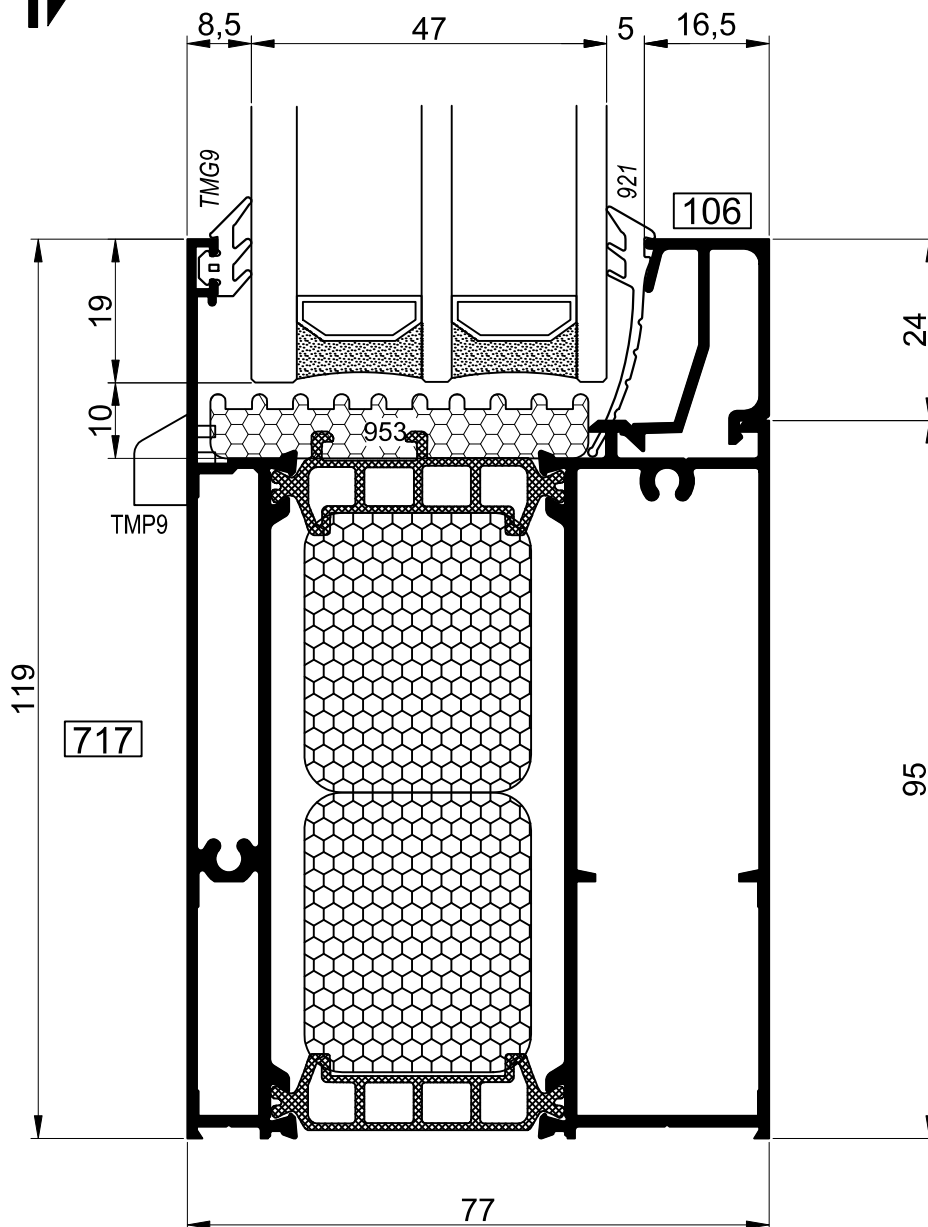
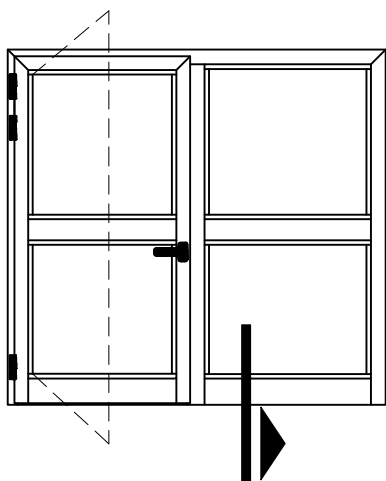


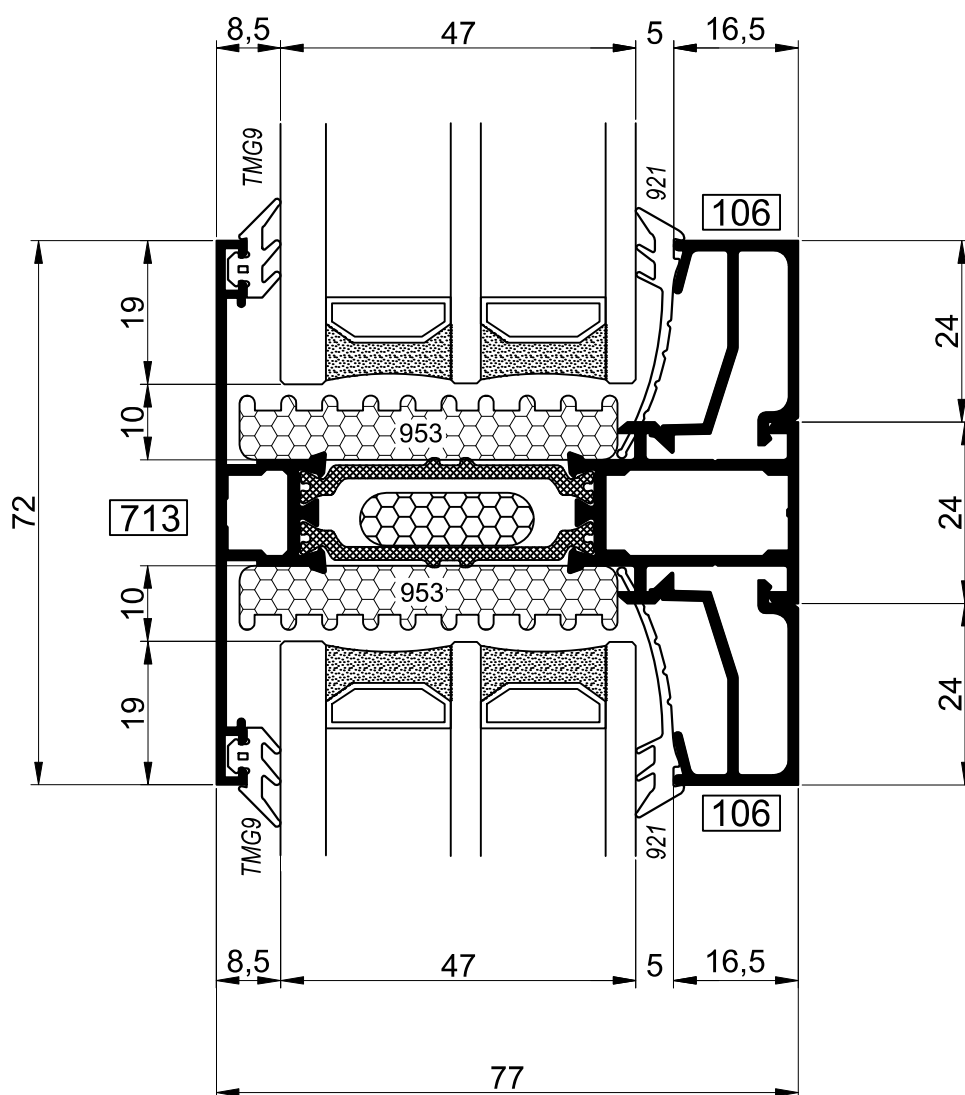
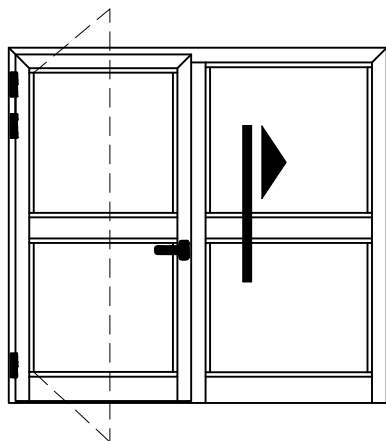


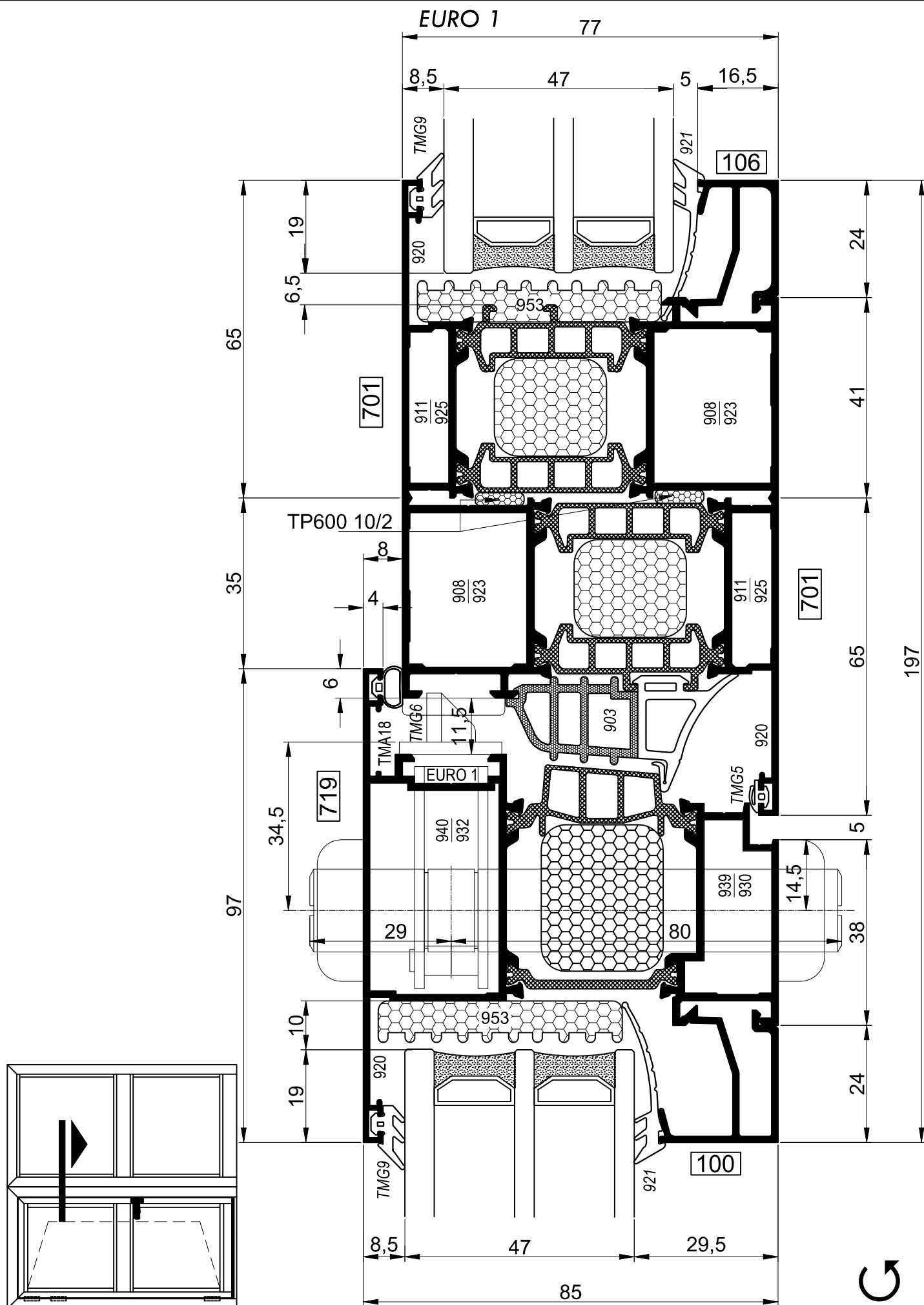


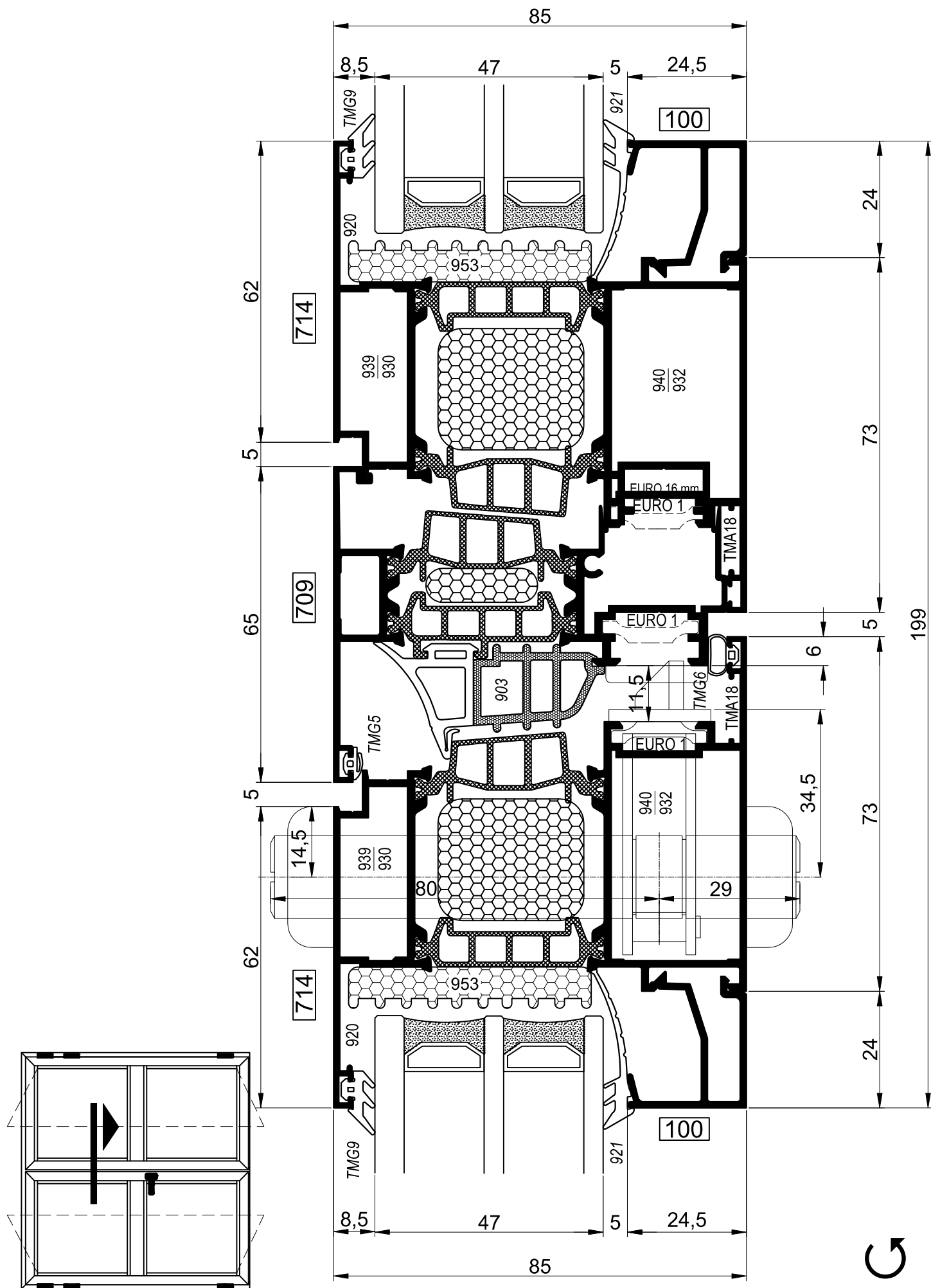




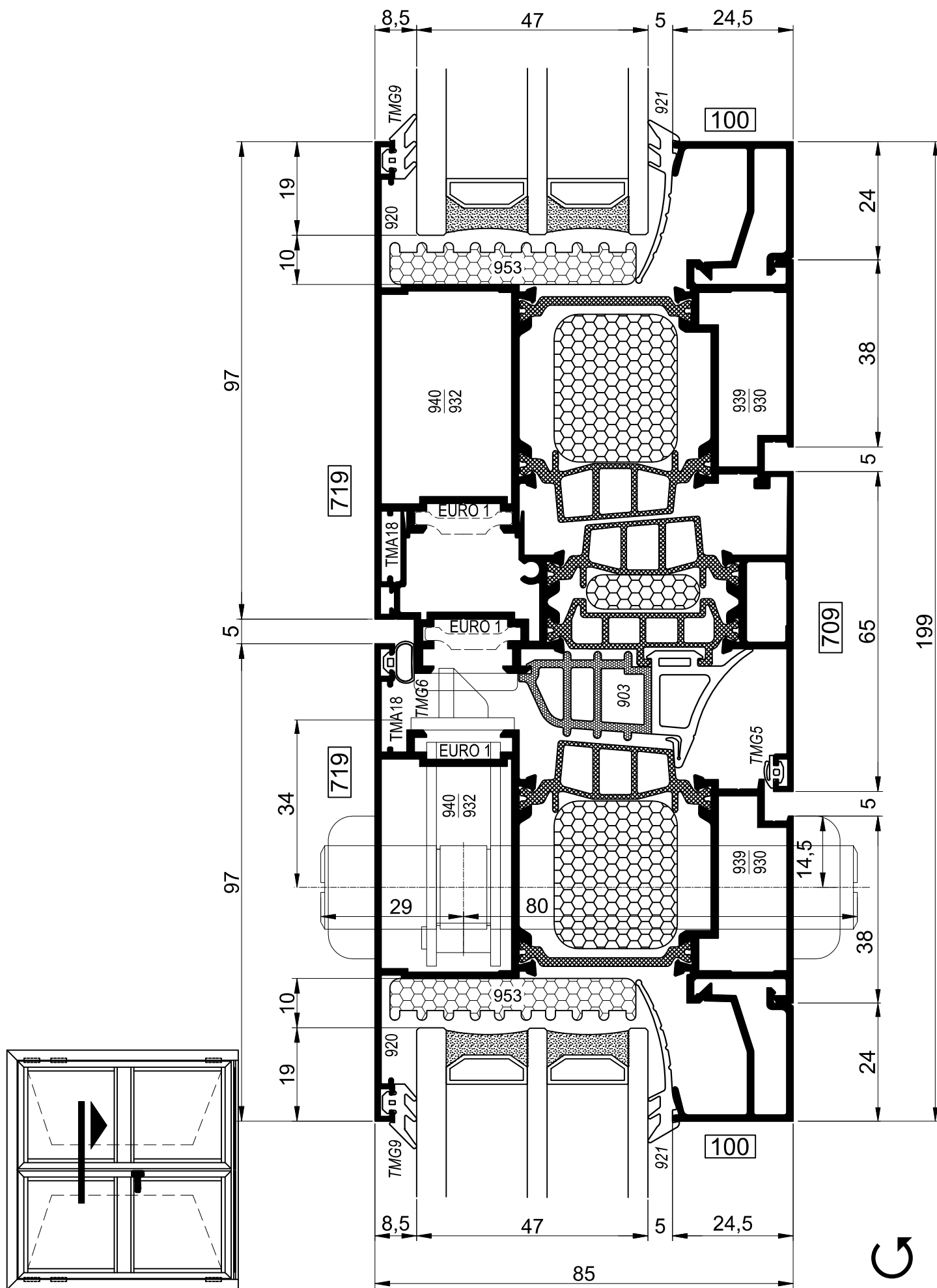


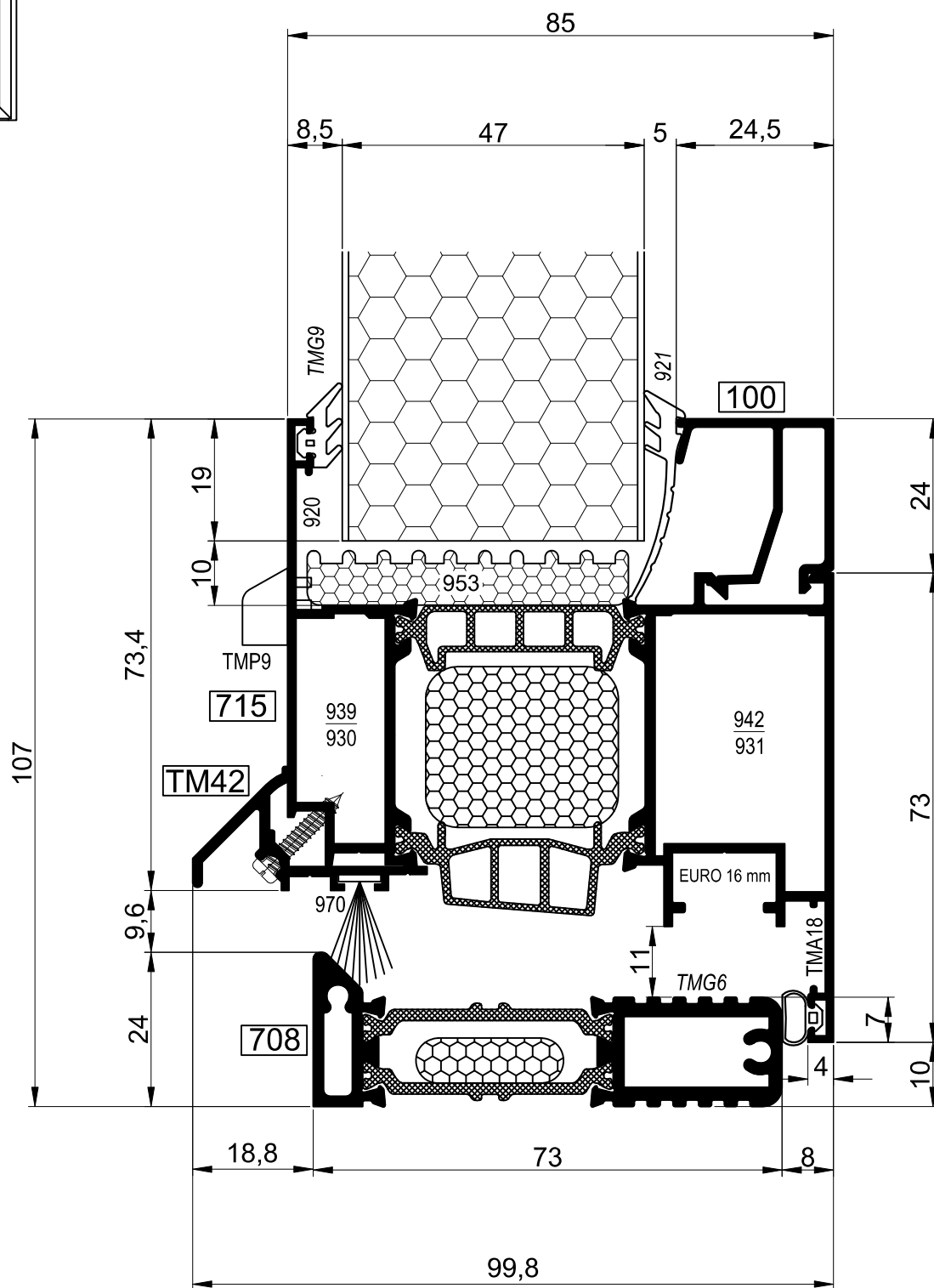
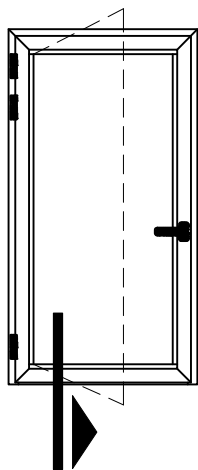


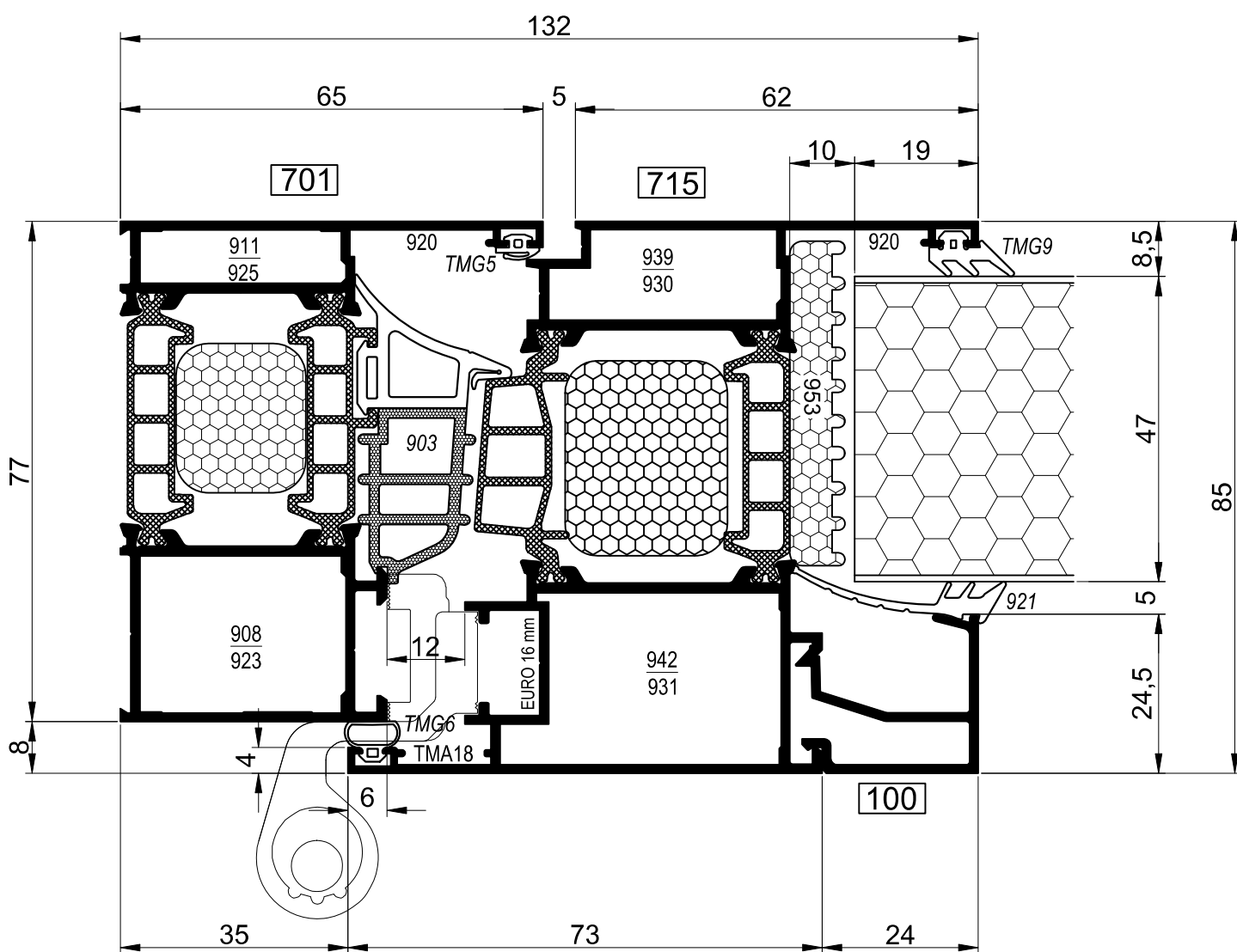
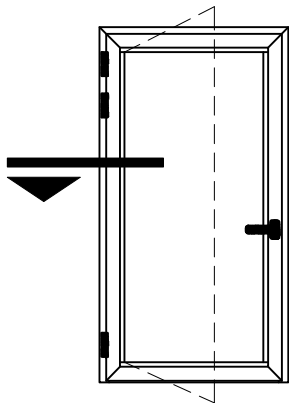


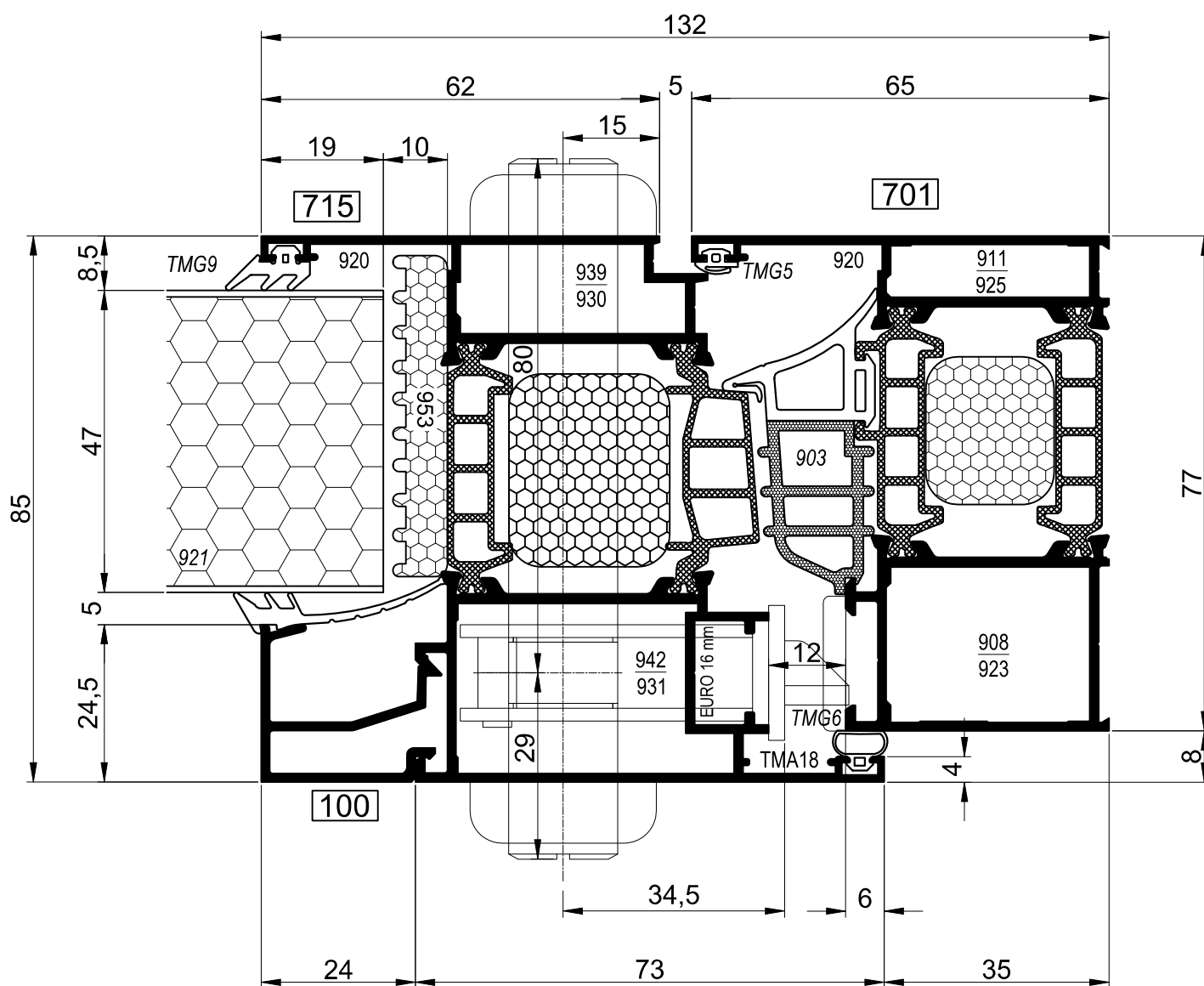
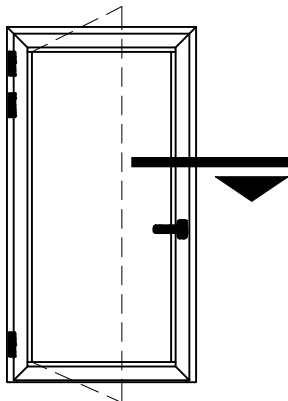


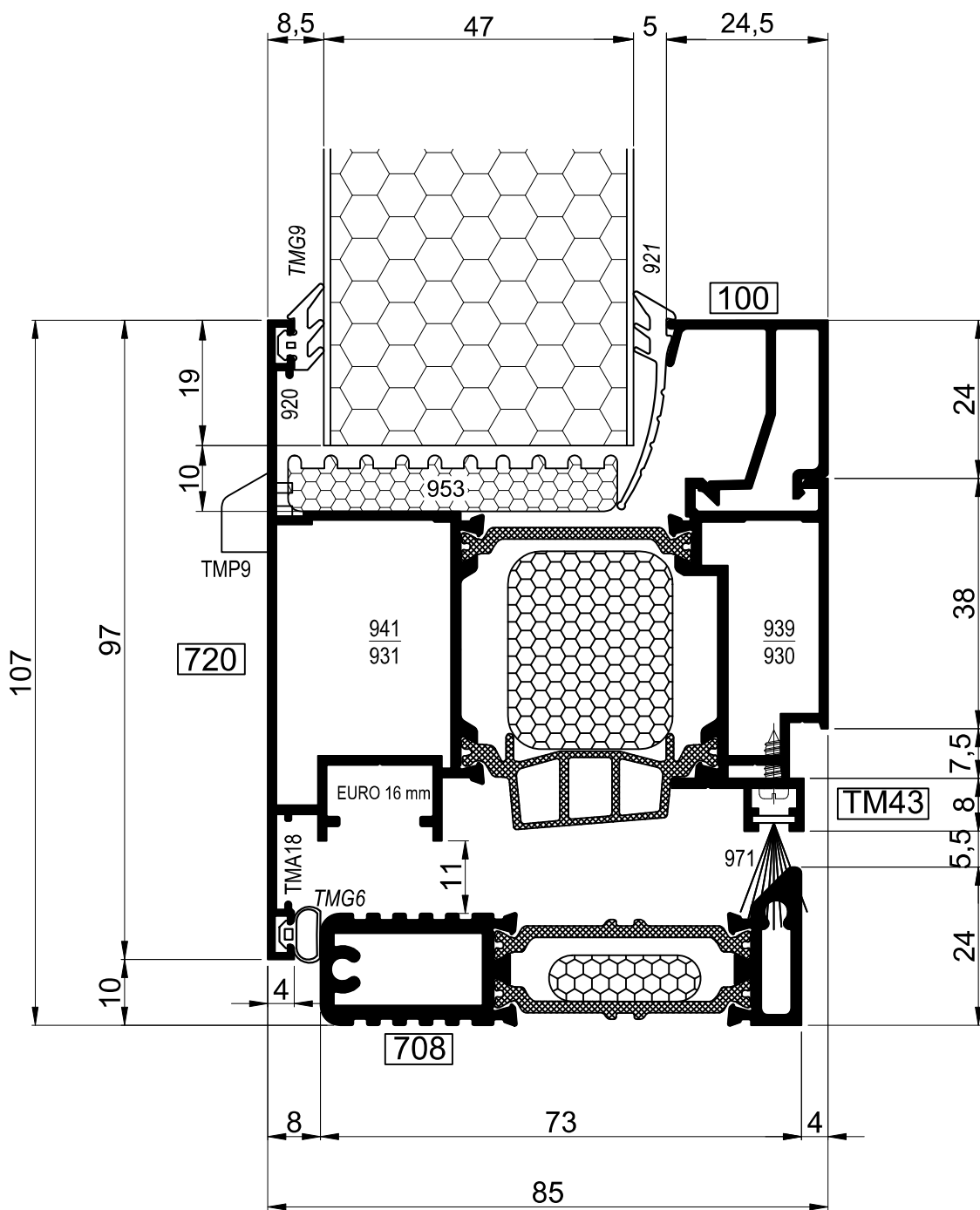
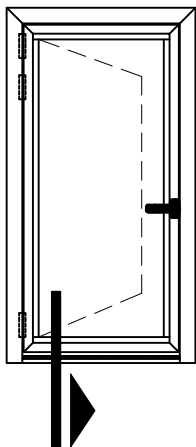
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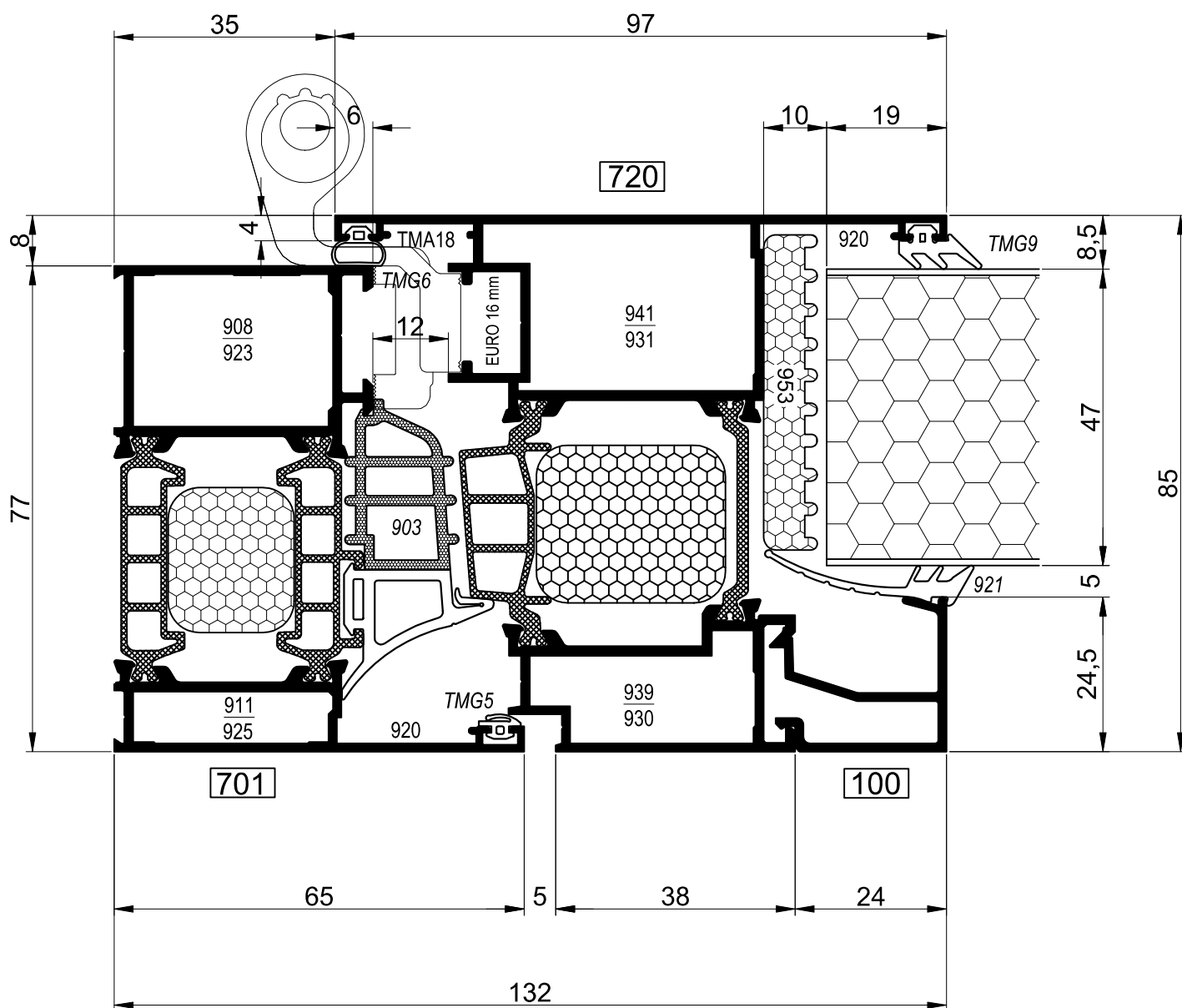
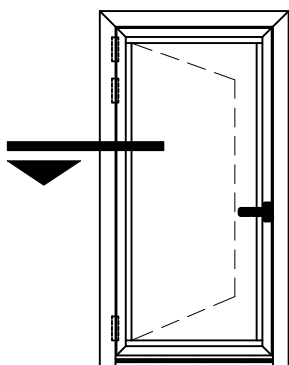


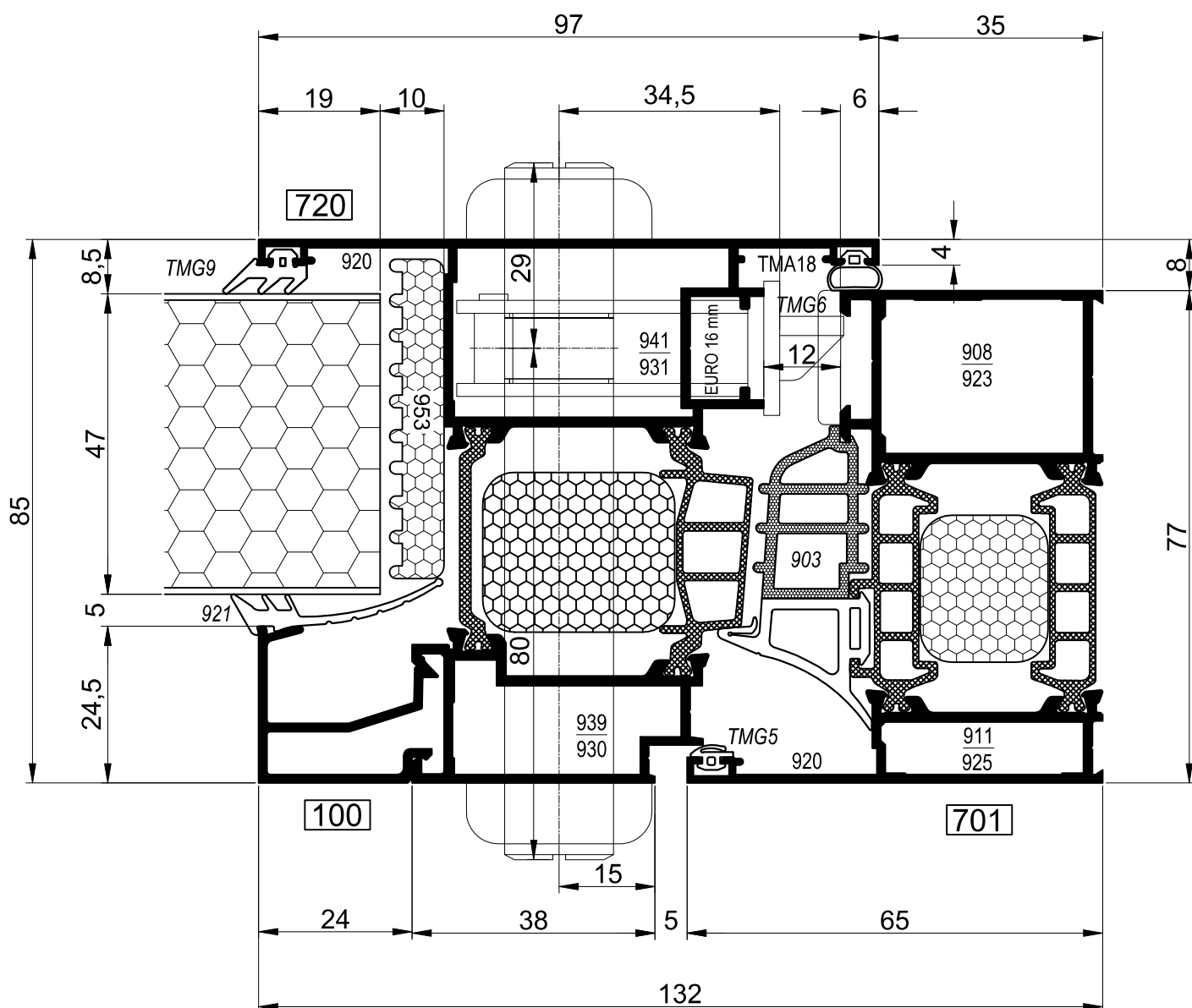
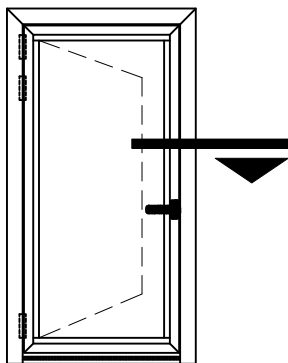




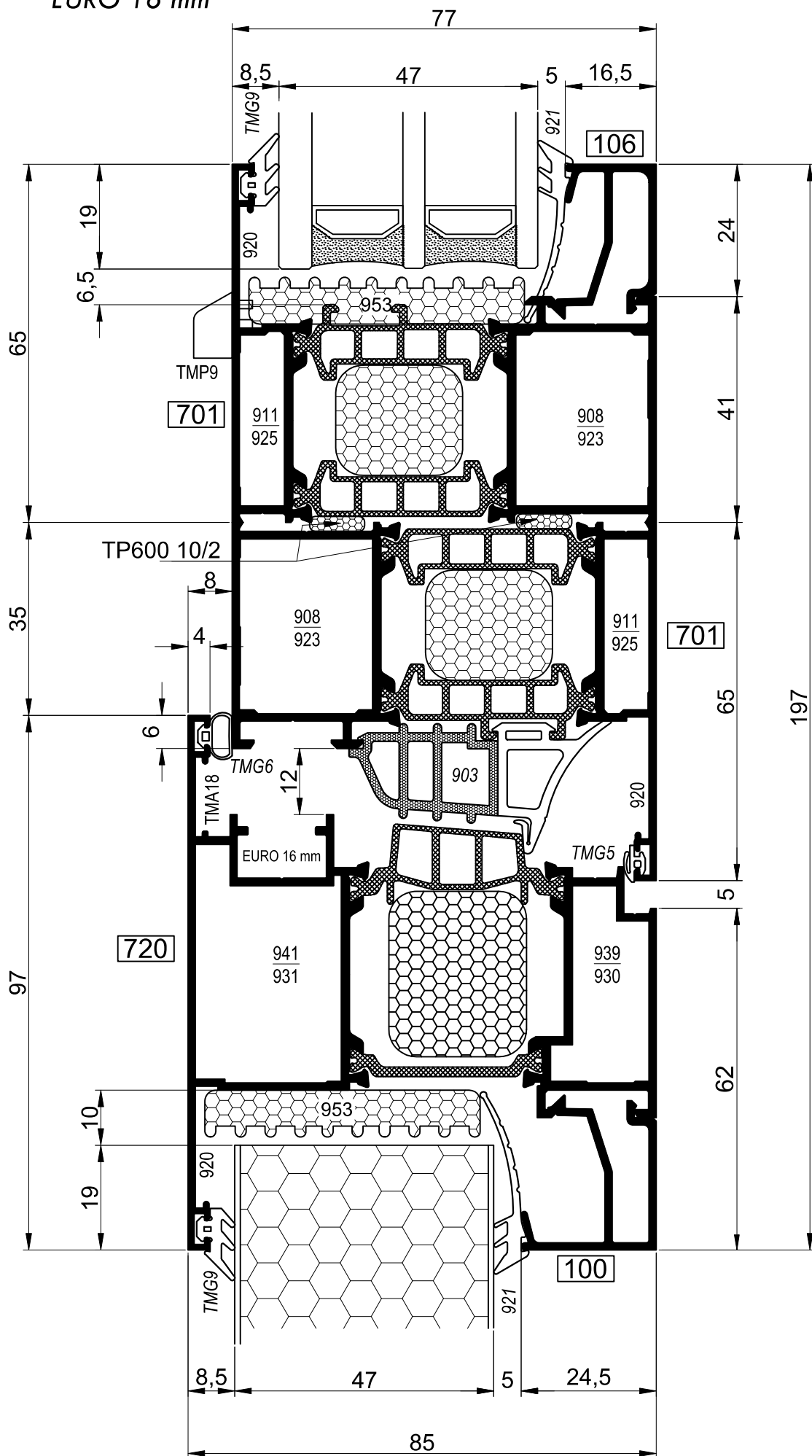
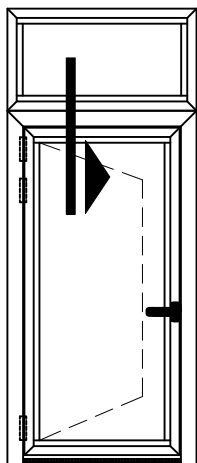




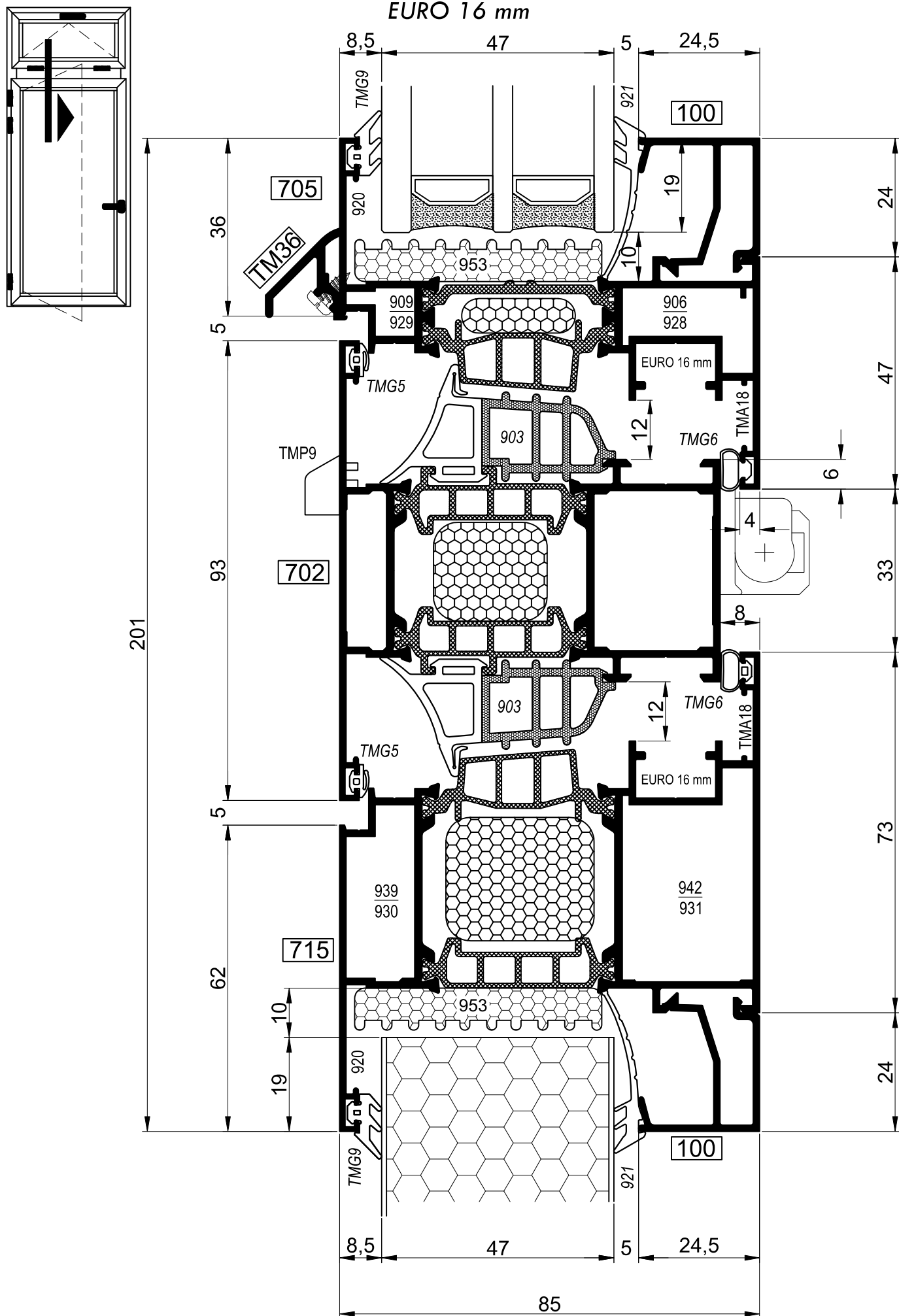


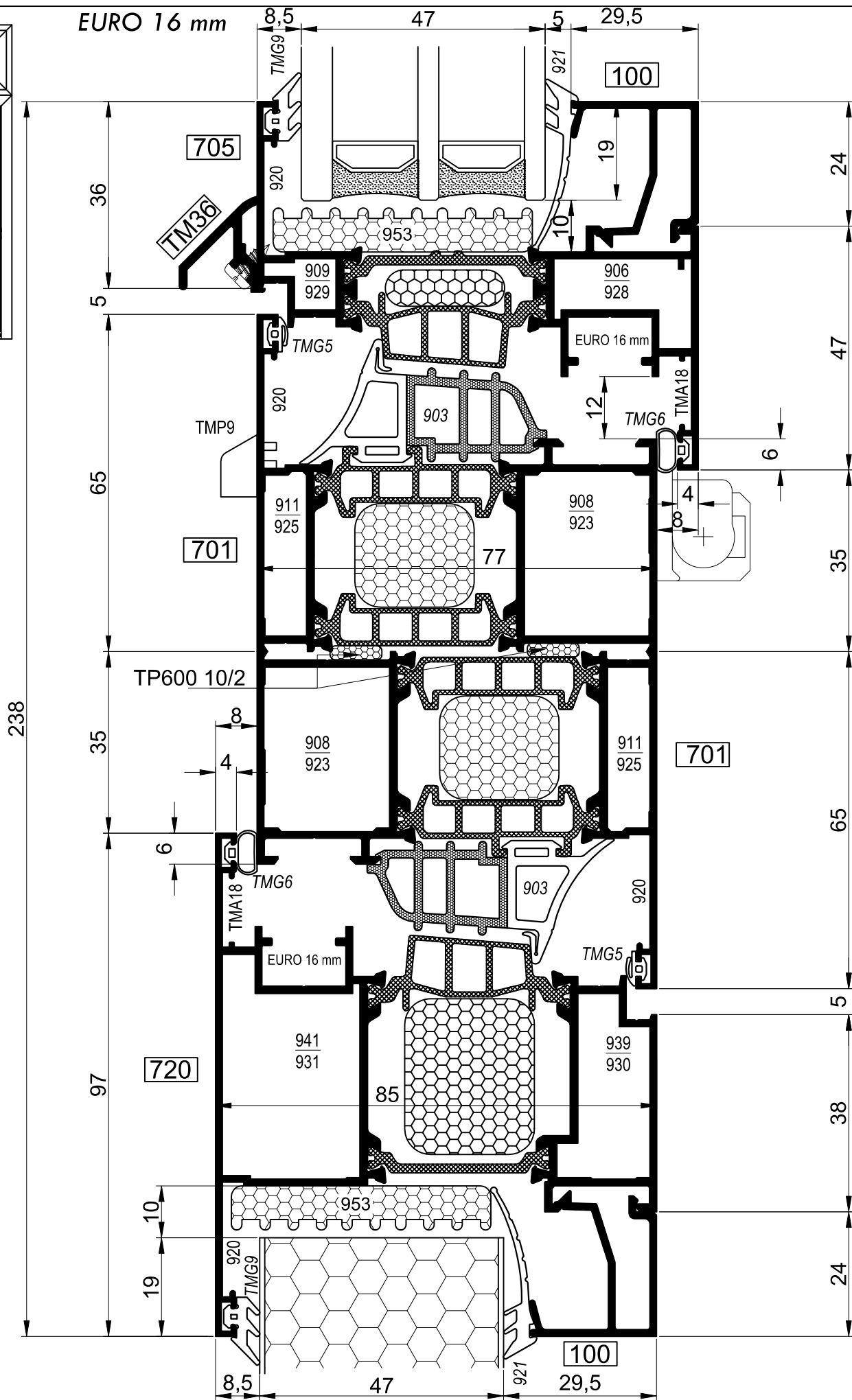
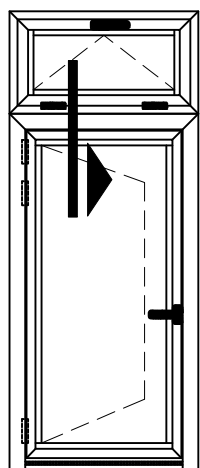


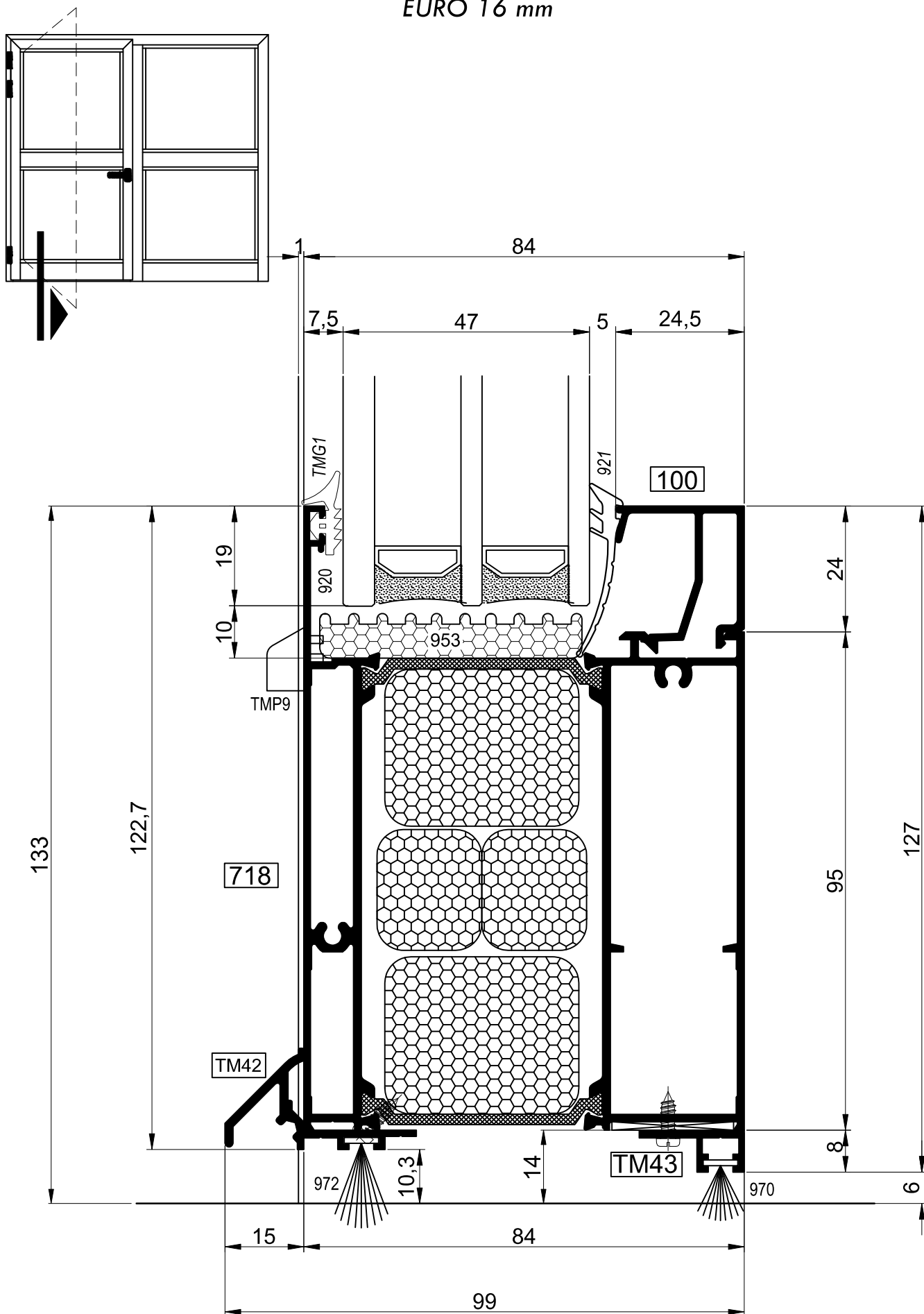
EURO 16 mm

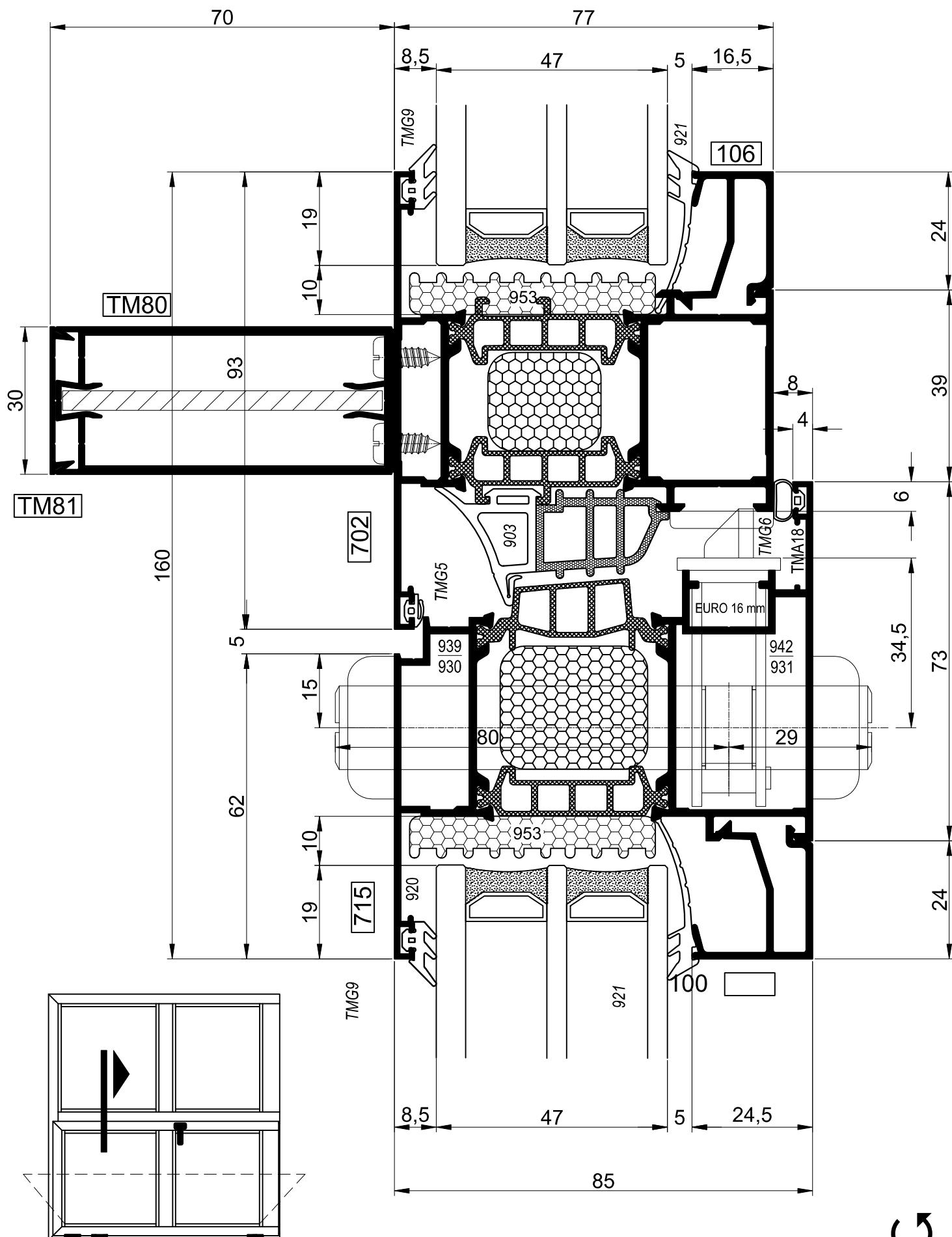


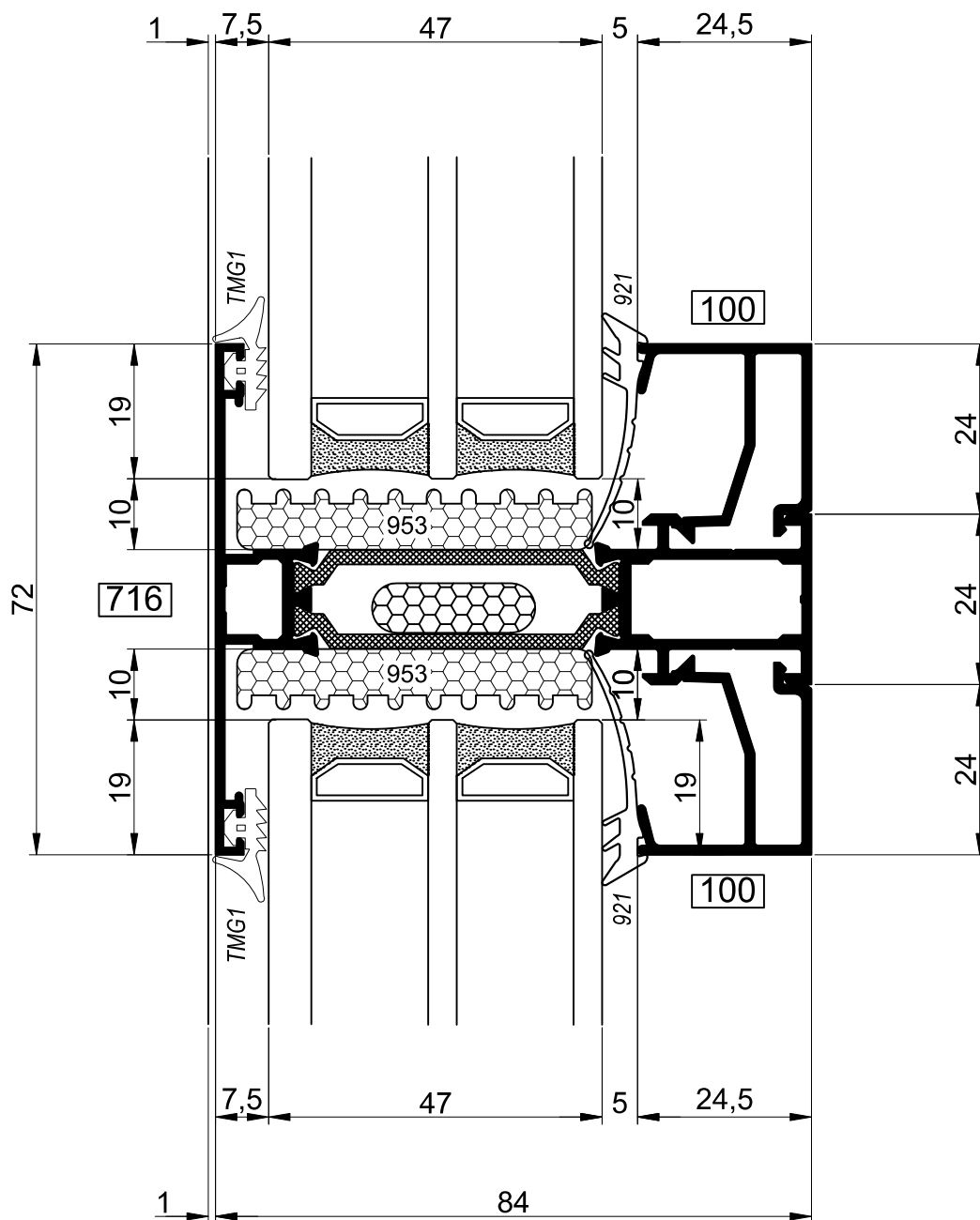
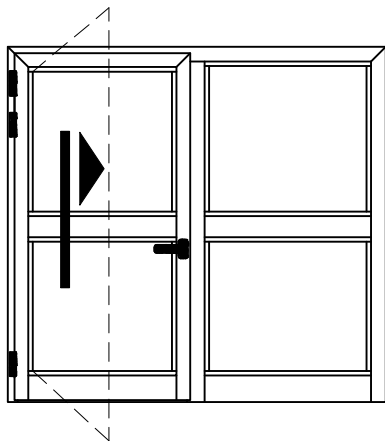
EURO 16 mm

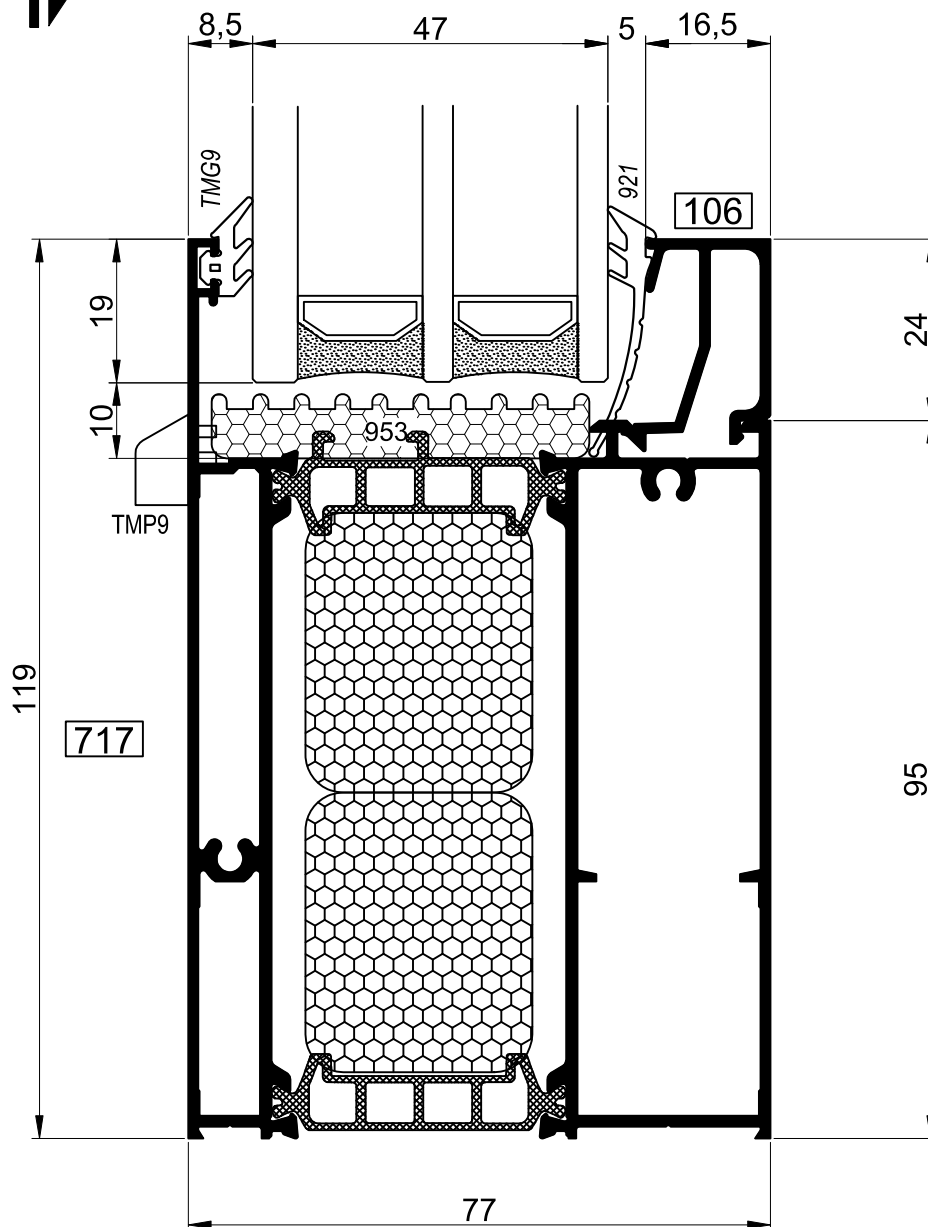
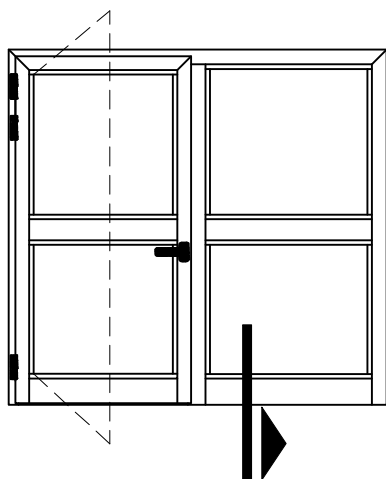




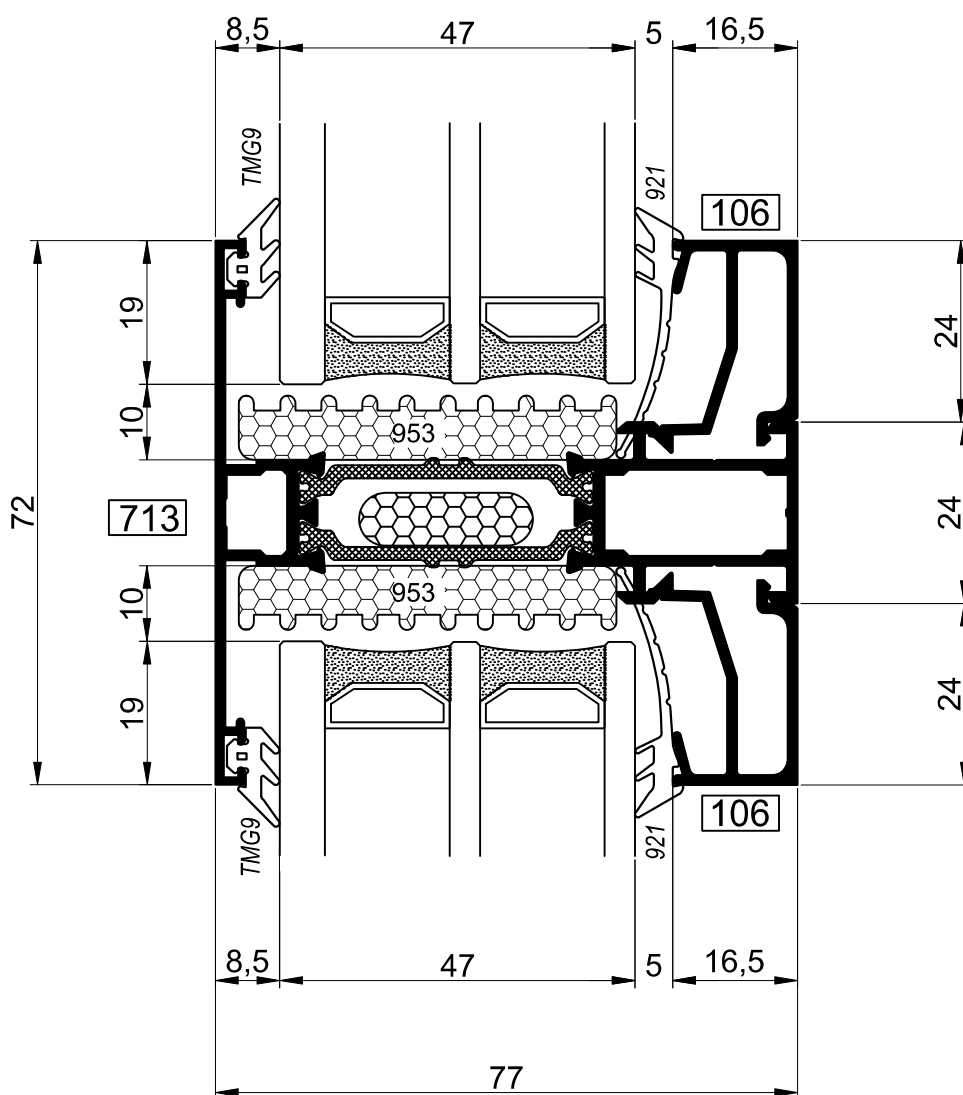
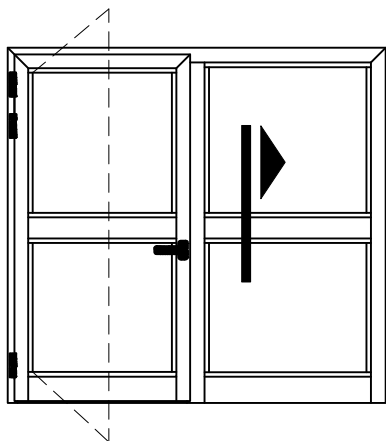


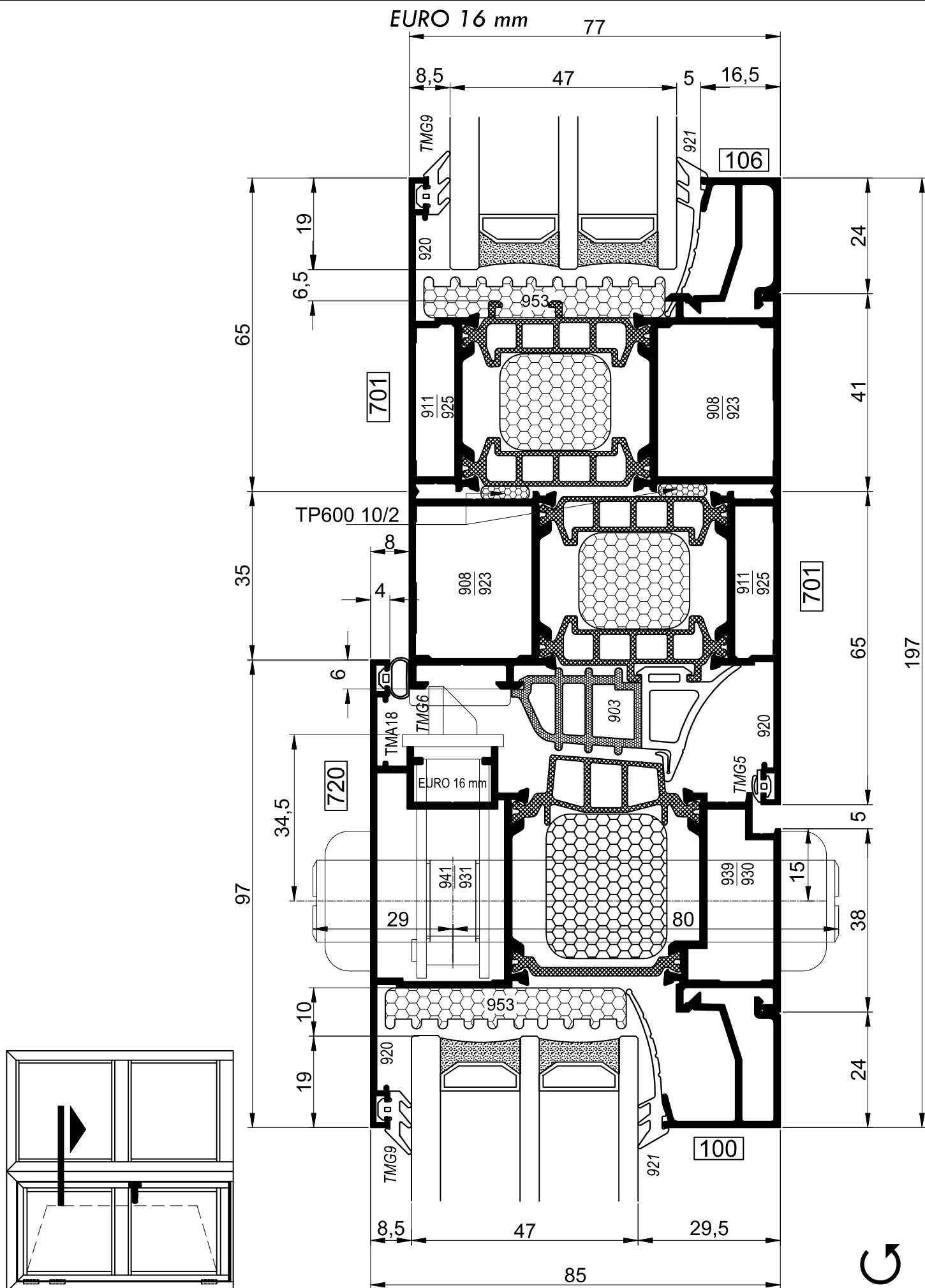




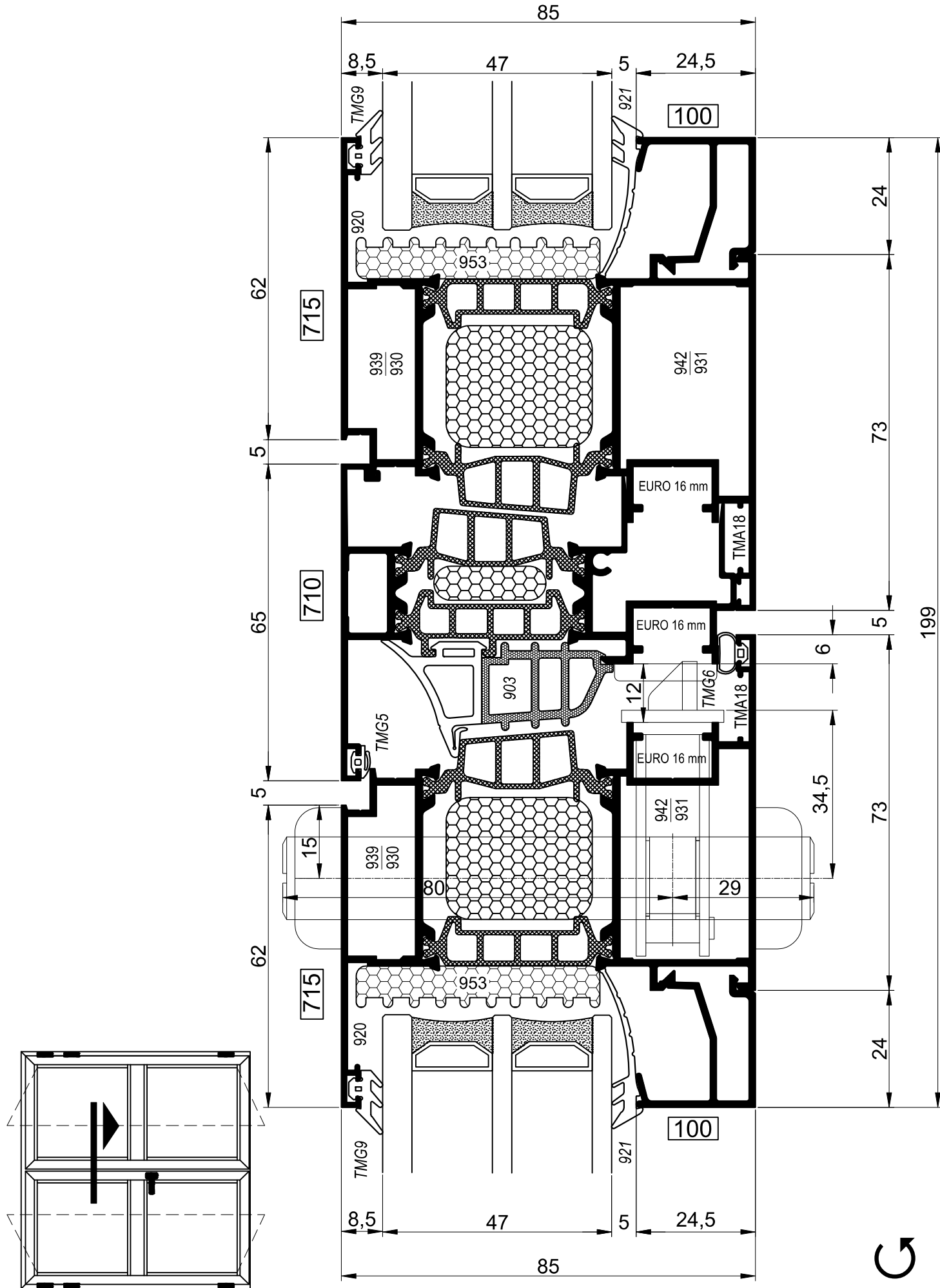


EURO 16 mm

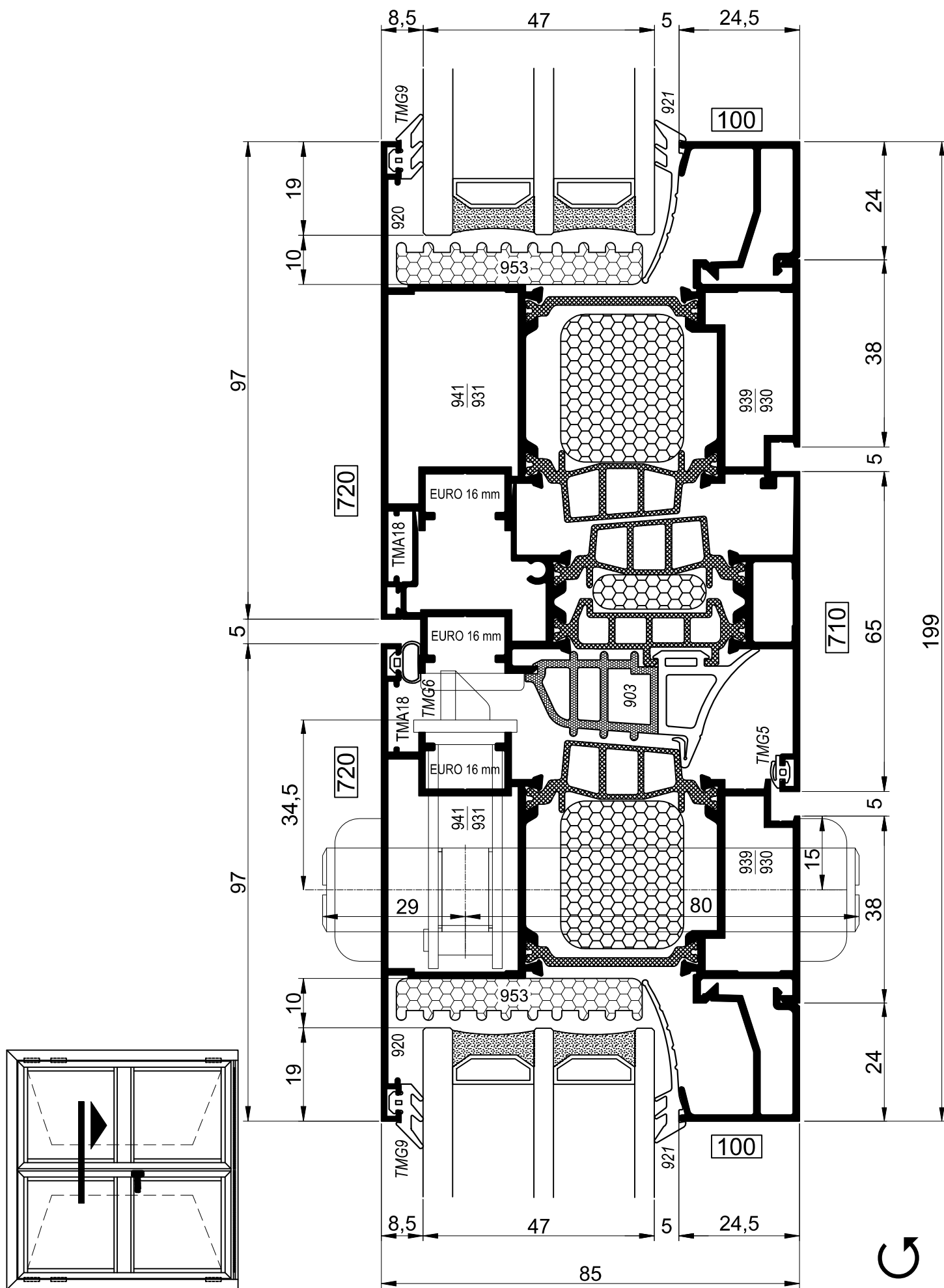


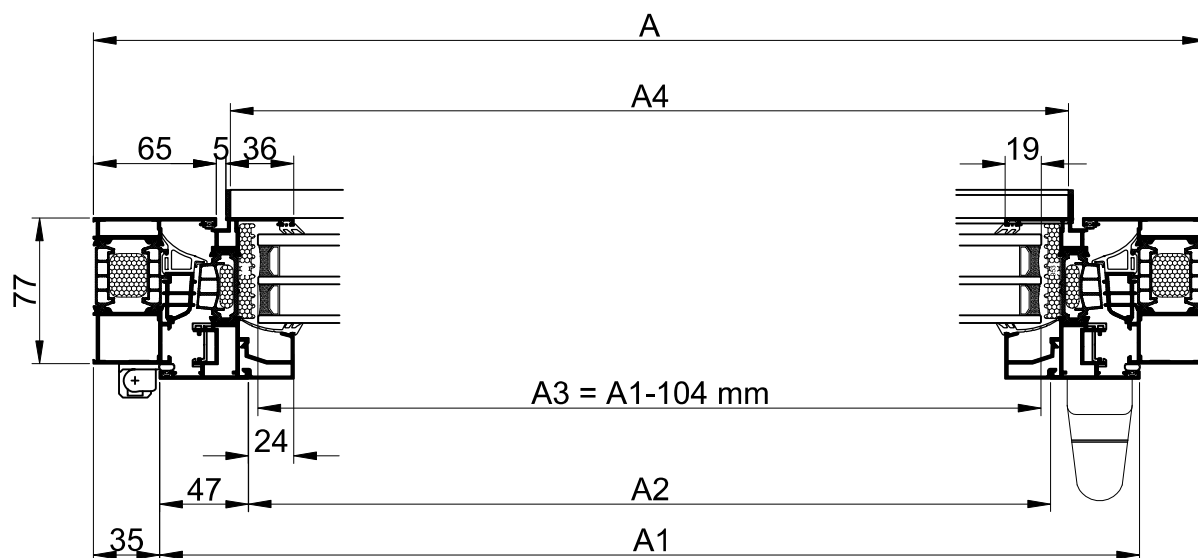
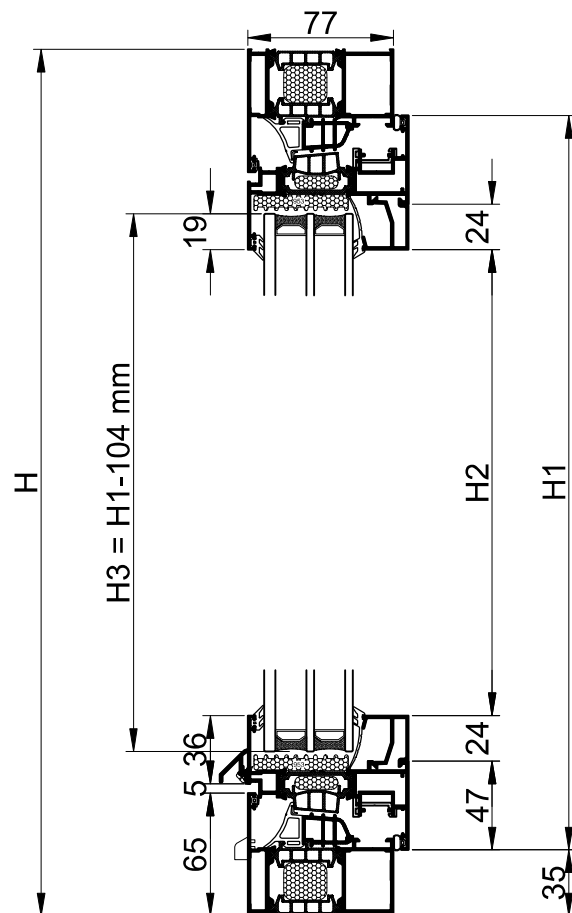
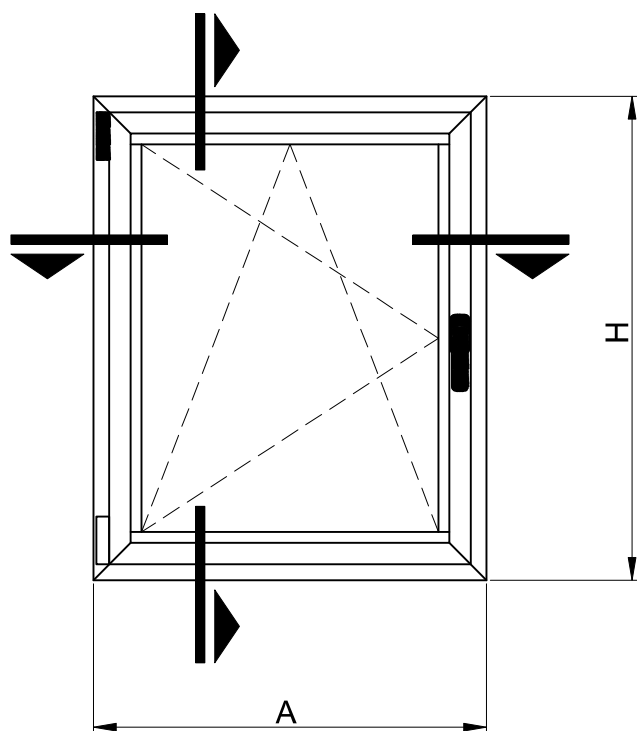


THERM 77
EURO 16 mm

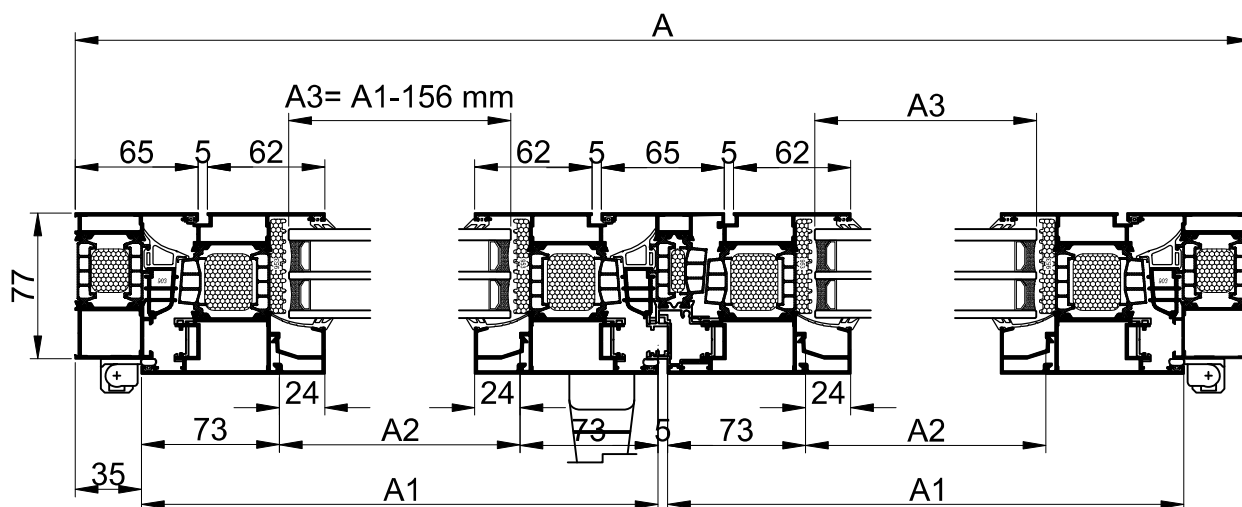
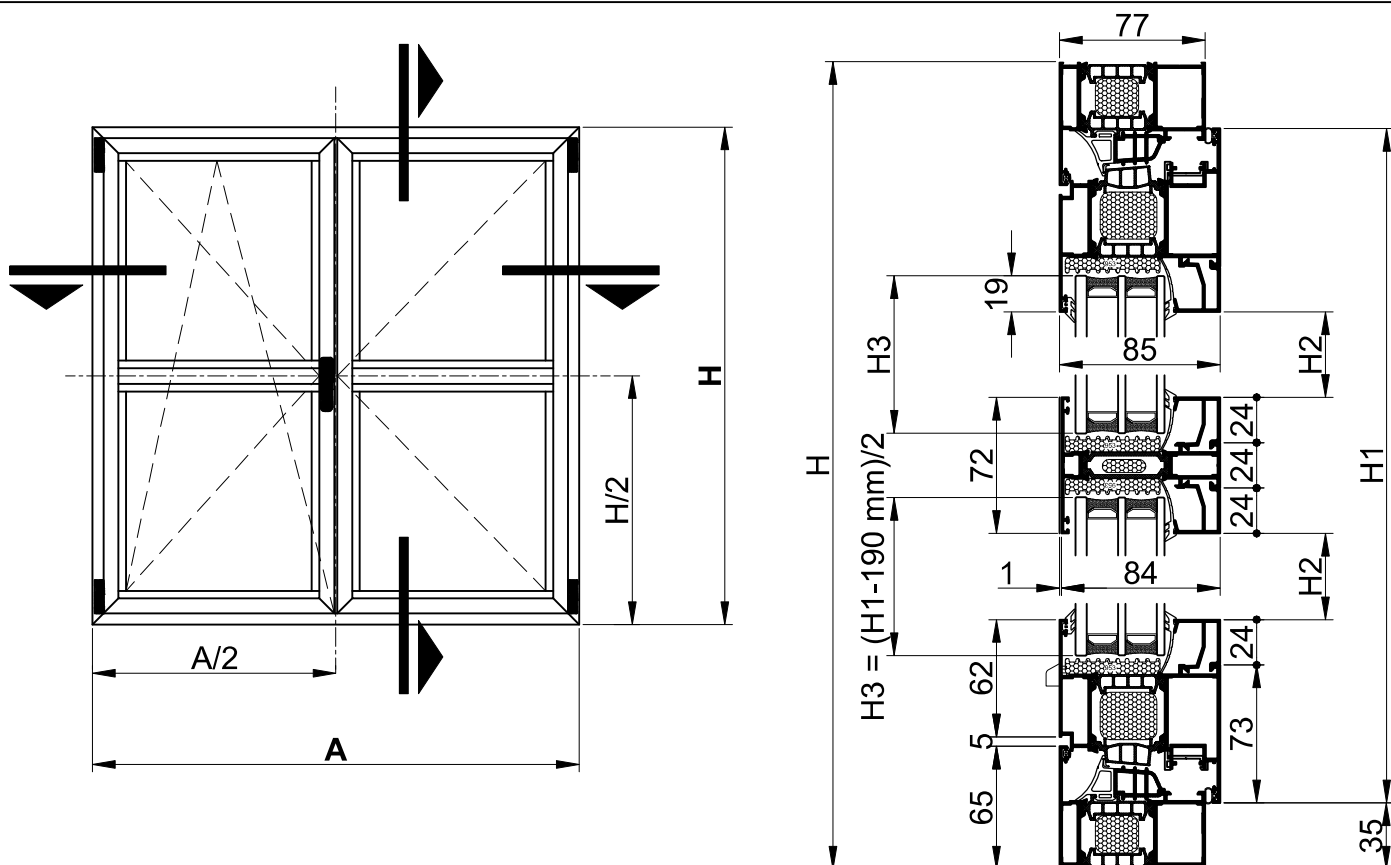


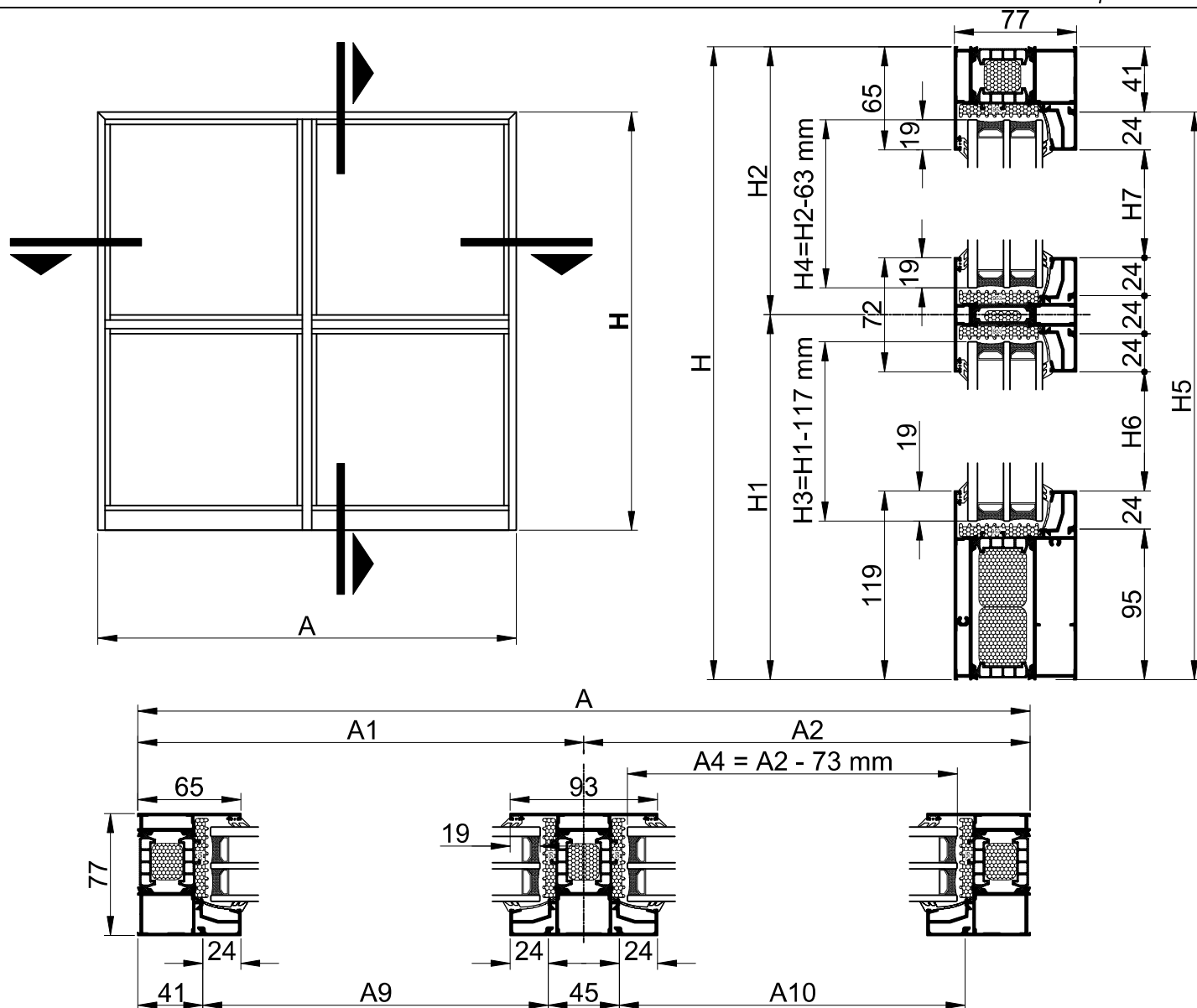
EURO 16 mm



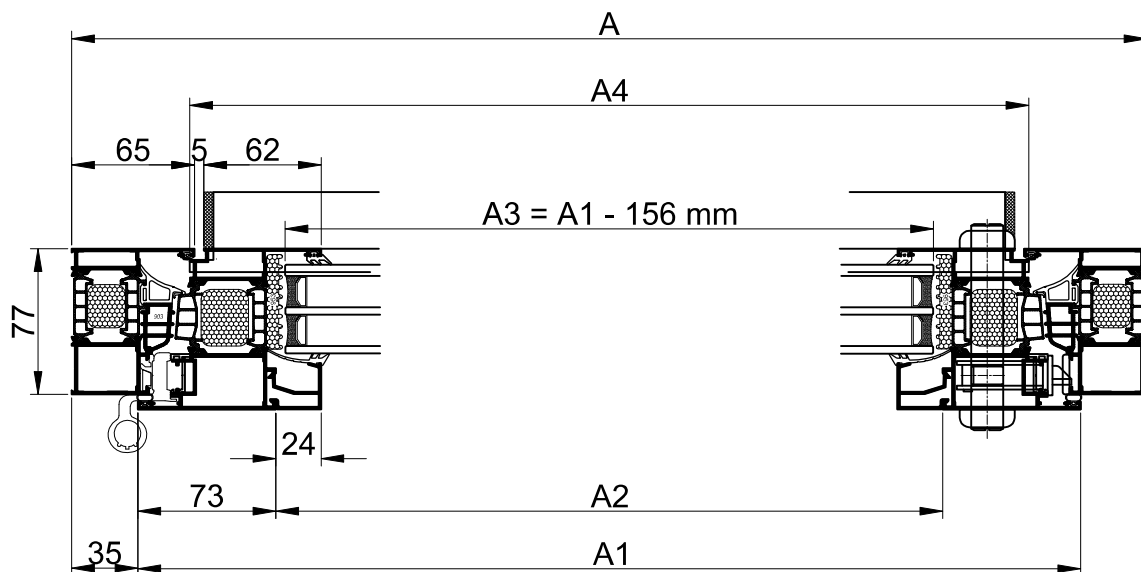
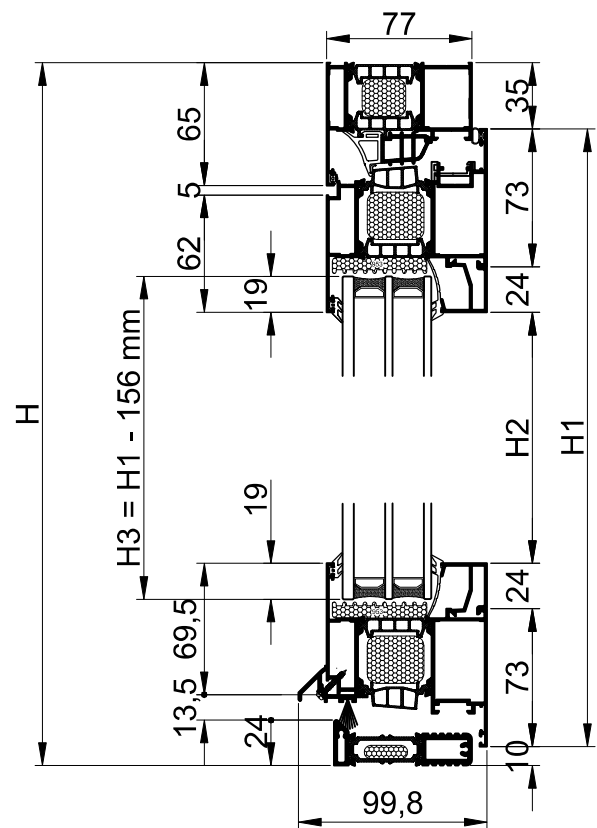
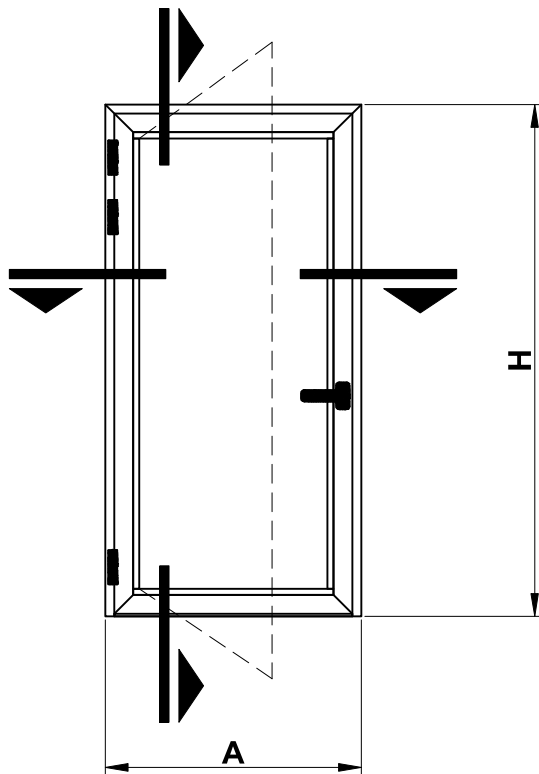


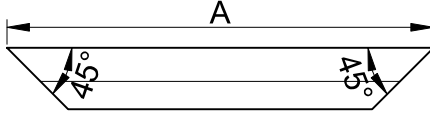
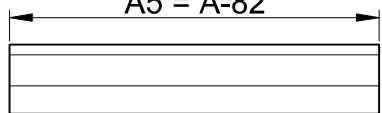
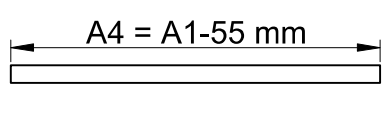
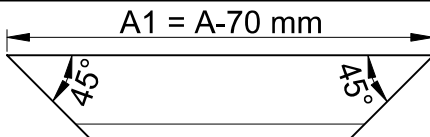
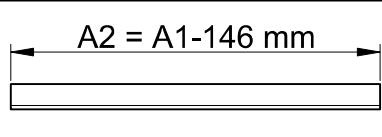
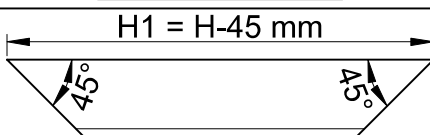
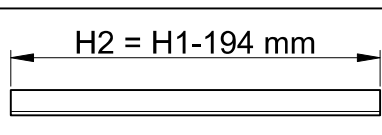
2 x			701		
2 x			701	2 x	A2 = A1-94 mm 100
2 x			705 704	2 x	H2 = H1-142 mm 100
2 x			705 704	1 x	A4 = A1-74 mm TM36

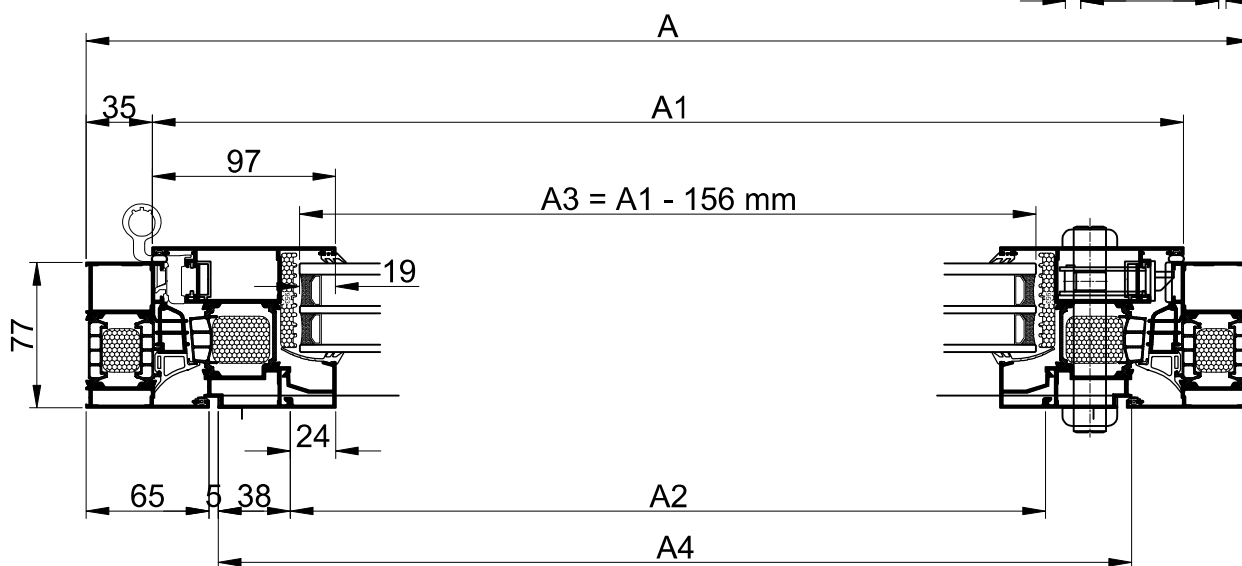
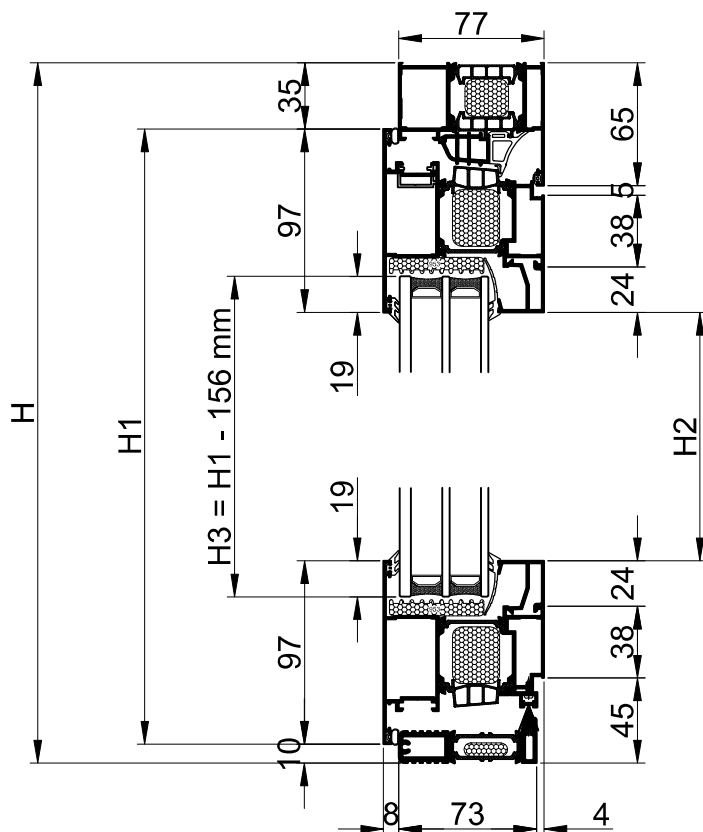
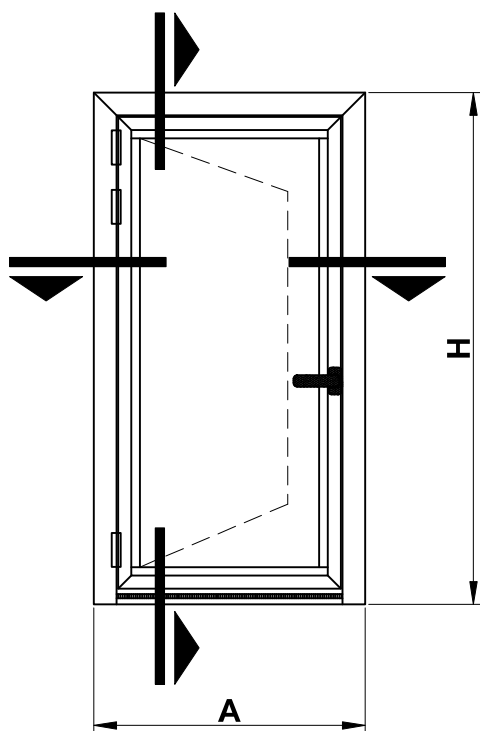




1 x $A = A1 + A2$ 45° 701	1 x $H5 = H - 41 \text{ mm}$ 702
1 + 1 $H = H1 + H2$ 45° 701	1 x $A9 = A1 - 63,5 \text{ mm}$ 713
1 x $A9 = A1 - 63,5 \text{ mm}$ 717	1 x $A10 = A2 - 63,5 \text{ mm}$ 713
1 x $A10 = A2 - 63,5 \text{ mm}$ 717	4 x $A9 = A1 - 63,5 \text{ mm}$ 106
	4 x $A10 = A2 - 63,5 \text{ mm}$ 106
4 x $H7 = H2 - 101 \text{ mm}$ 106	4 x $H6 = H1 - 155 \text{ mm}$ 106



1 x  701	1 x  708
1 x 1  701	1 x  TM42
2 x  714 715	2 x  100
2 x  714 715	2 x  100

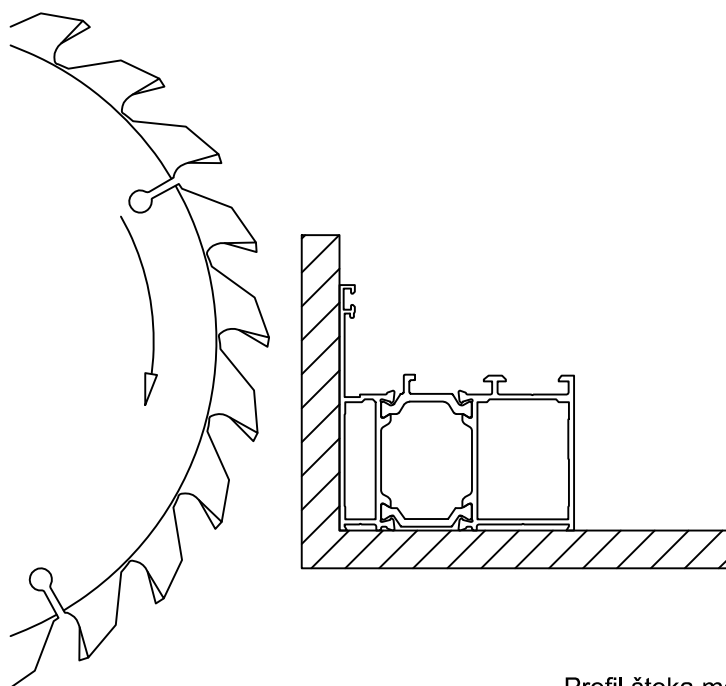


 1 x A 701	 1 x $A5 = A - 82$ 708
 1 x 1 H 701	 1 x $A6 = A1 - 55 \text{ mm}$ TM43
 2 x $A1 = A - 70 \text{ mm}$ 720 719	 2 x $A2 = A1 - 146 \text{ mm}$ 100
 2 x $H1 = H - 45 \text{ mm}$ 720 719	 2 x $H2 = H1 - 194 \text{ mm}$ 100

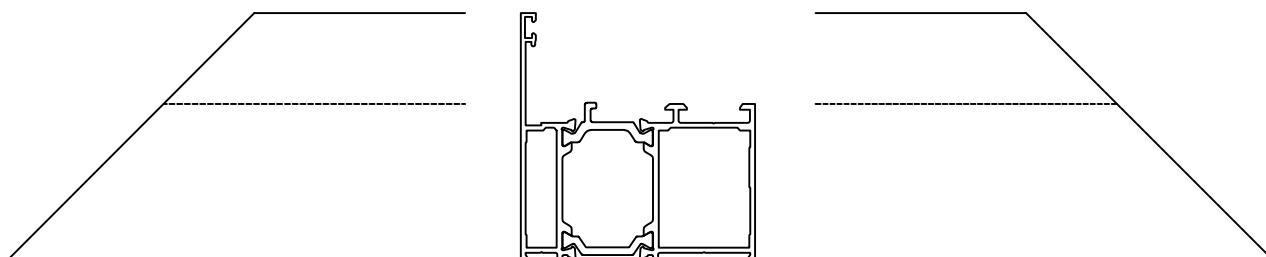
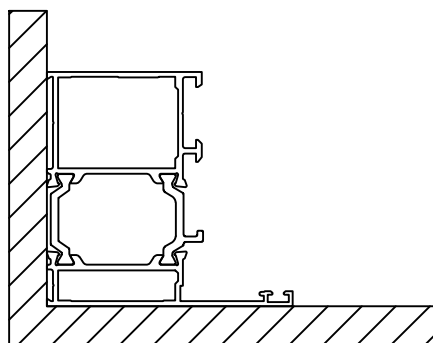
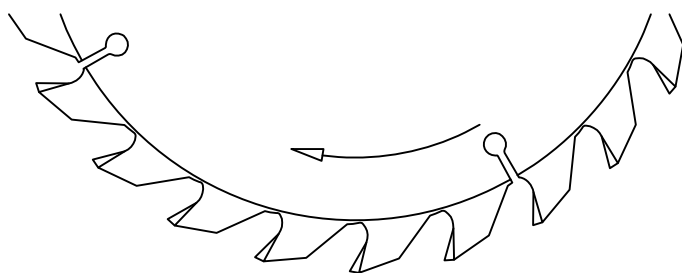
Mašinska obrada
Machining
Обработка



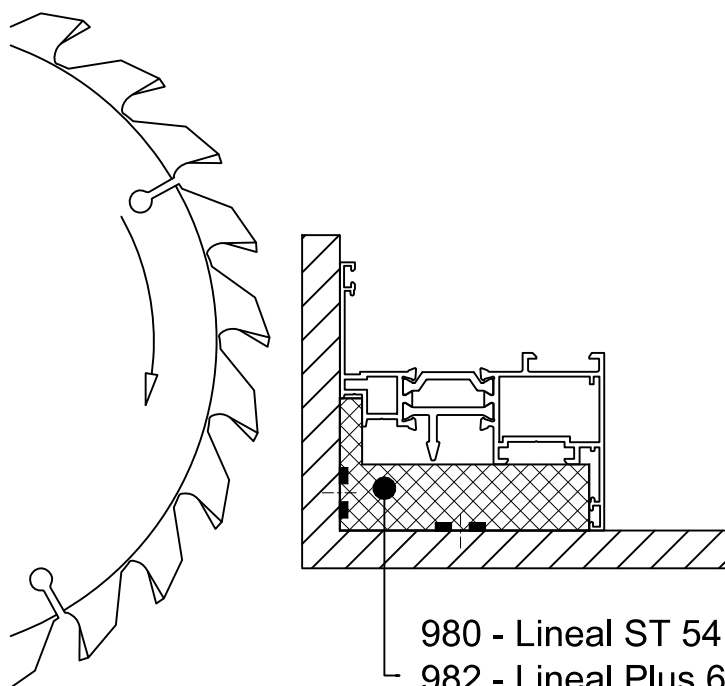
501	517
601	617
701	717



Profil štoka mora biti stabilno oslonjen
Frame profile must be stable rest
Профиль рамы должен быть стабильный

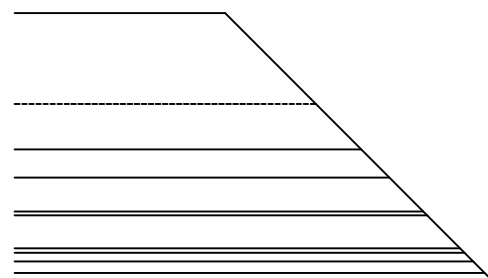
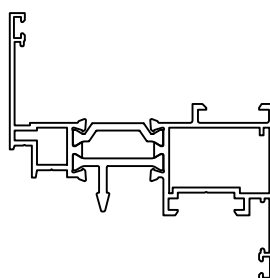
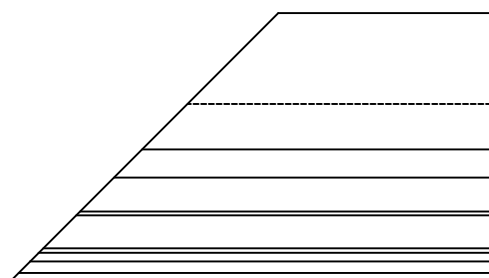
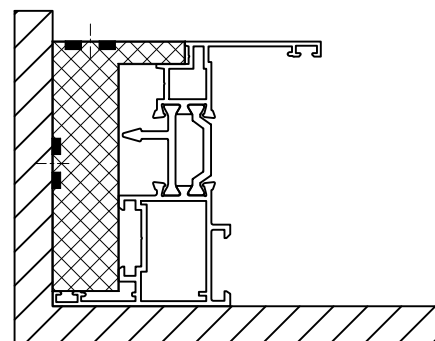
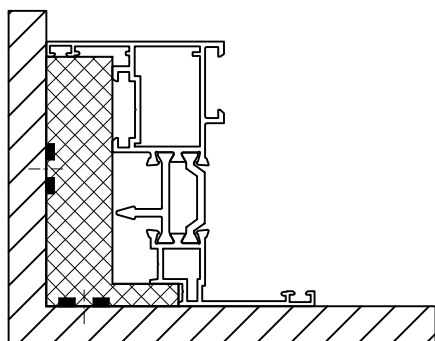
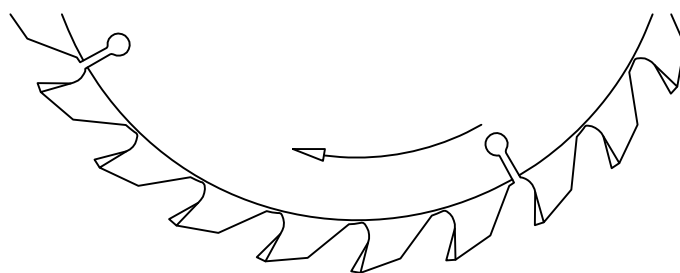
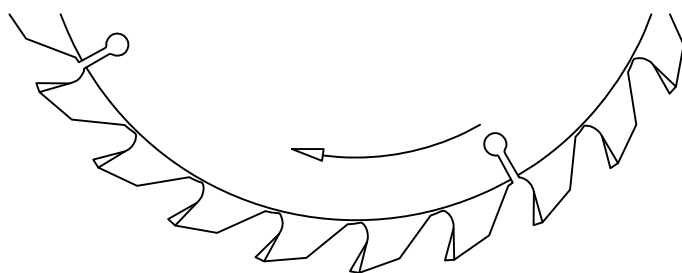


504	505	514	515	519	520
604	605	614	615	619	620
704	705	714	715	719	720



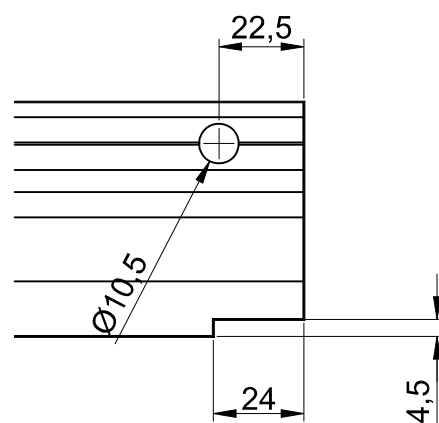
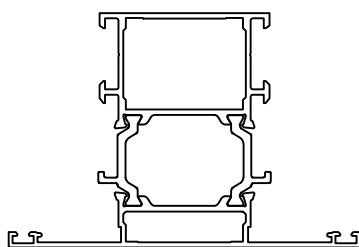
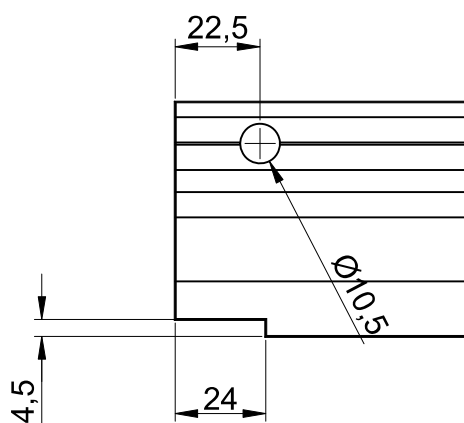
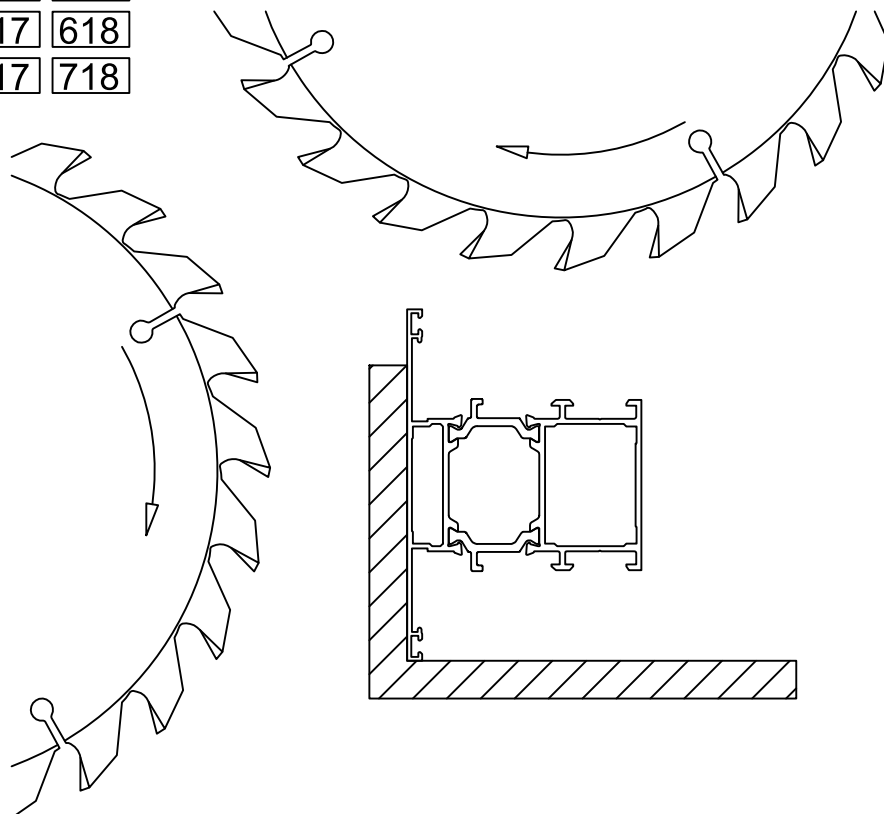
980 - Lineal ST 54
982 - Lineal Plus 62
984 - Lineal Therm 77

Profil krila mora biti stabilno oslonjen u alatu
Frame profile must be stable rest in tool
Профиль створки должен быть стабильный

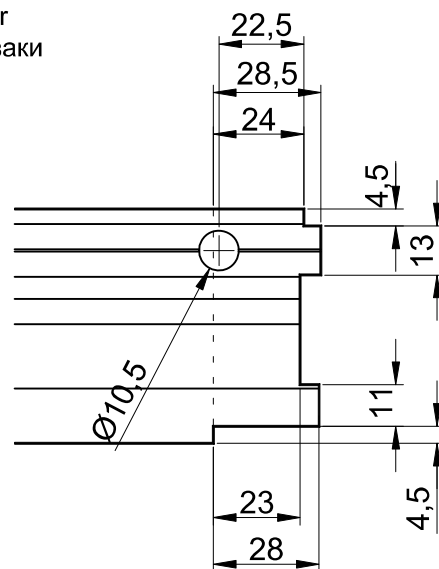
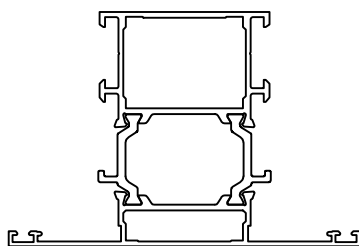
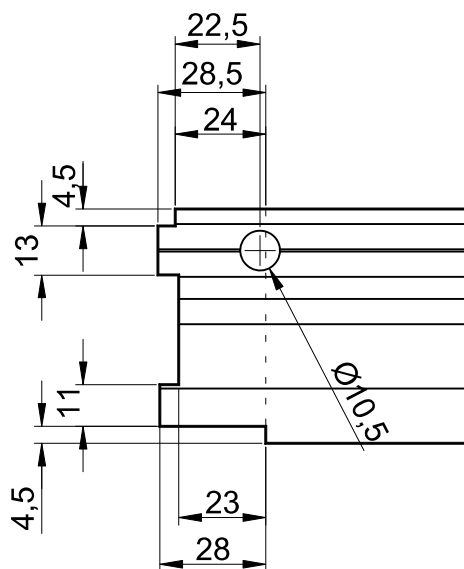


502	503	513	516	517	518
602	603	613	616	617	618
702	703	713	716	717	718

Profil prečke mora biti stabilno oslonjen
Crossbar profile must be stable rest
Профиль должен быть стабильный



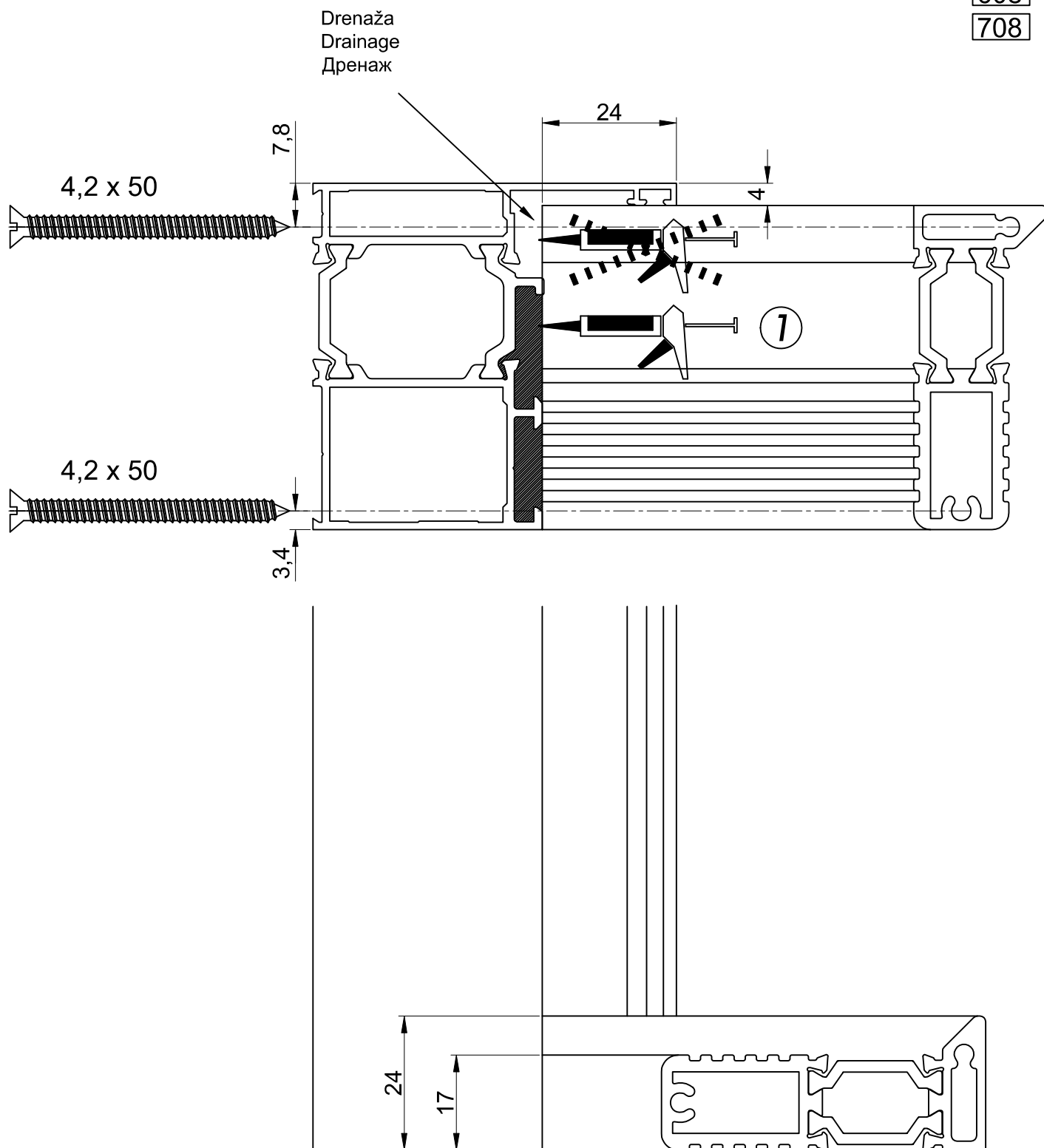
Koristiti LINEAL presu i glodala
Use LINEAL press and milling cutter
Использовать LINEAL пресс и резак



508

608

708

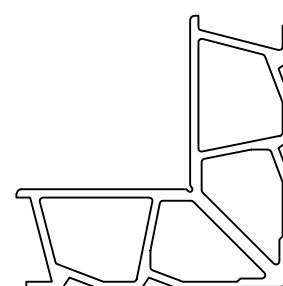
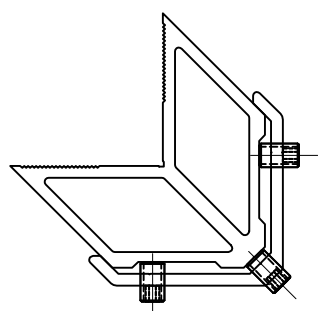
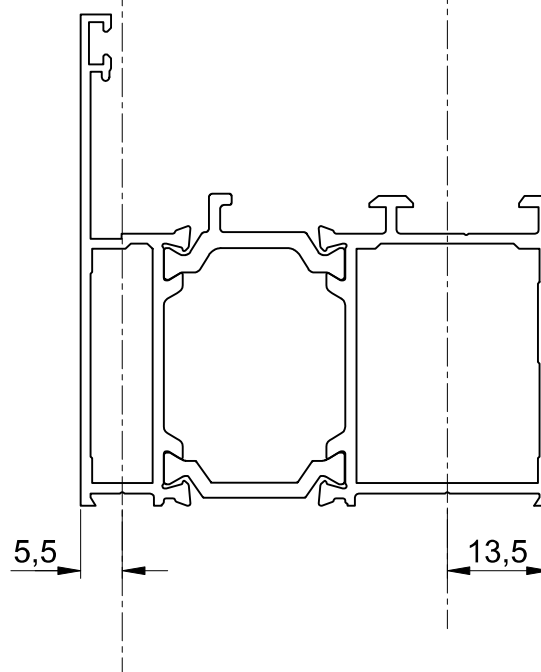
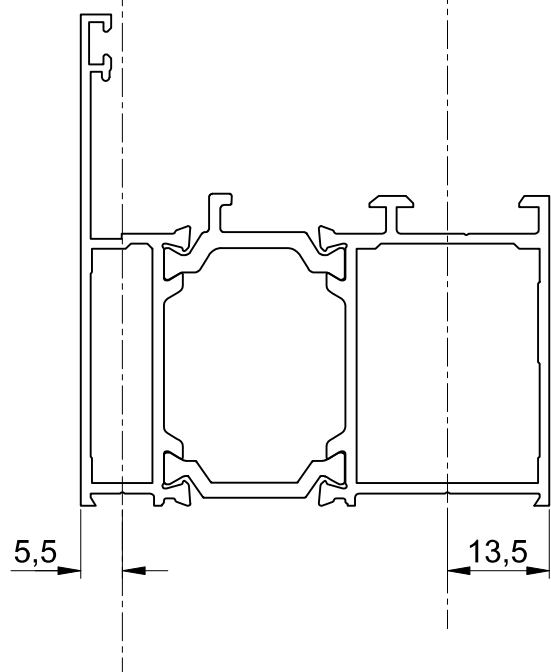
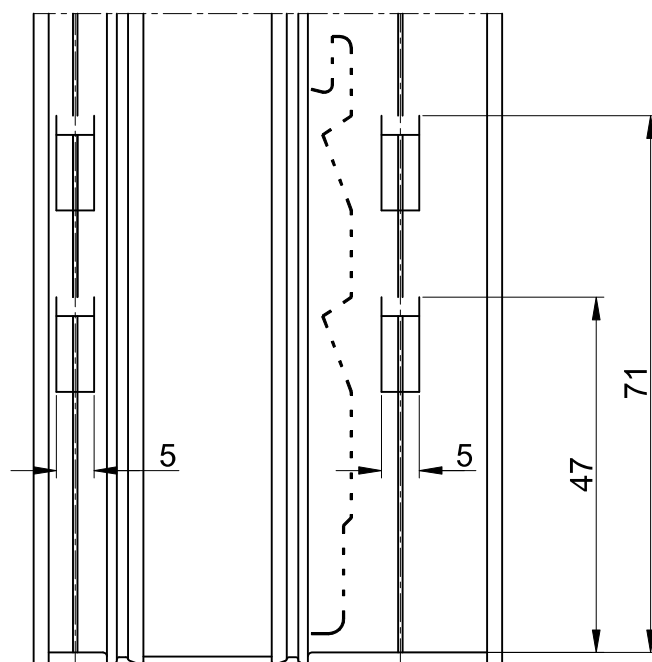
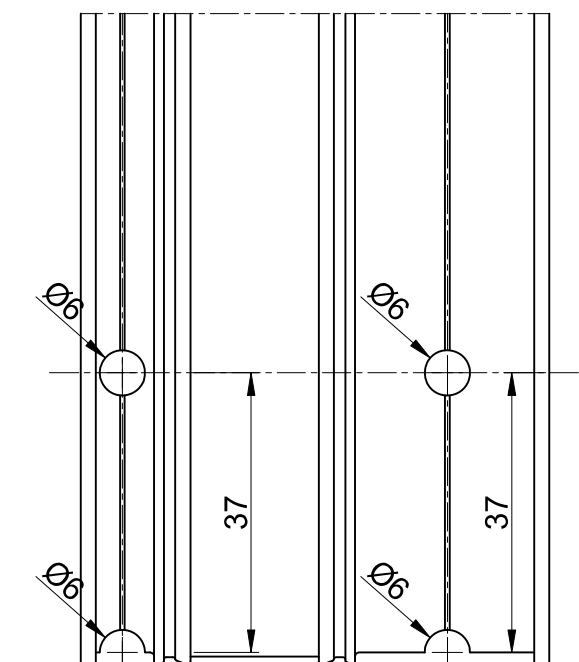


1

Lepak i zaptivna masa za alumijum
Glue and sealant for aluminium
Клей и герметик для алюминия

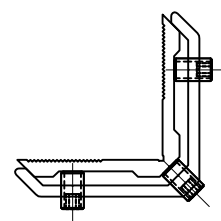
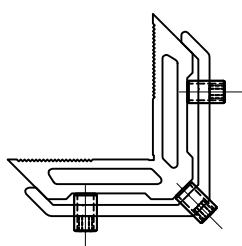
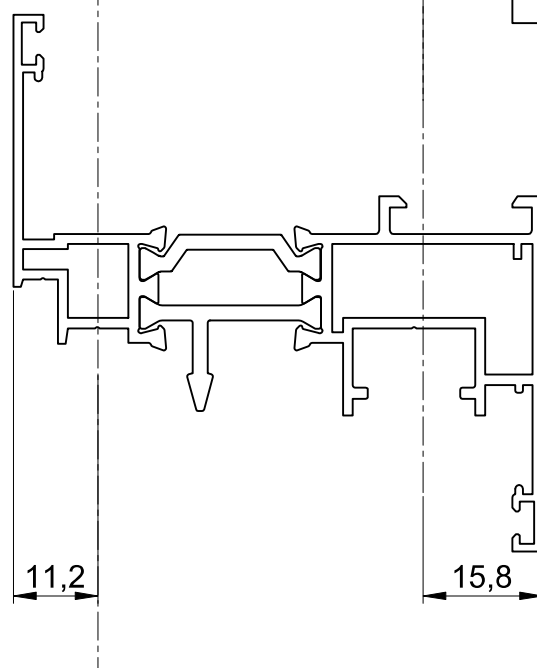
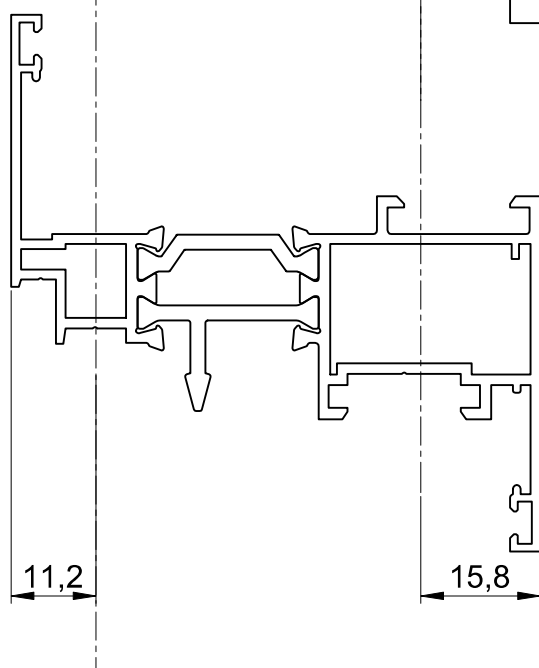
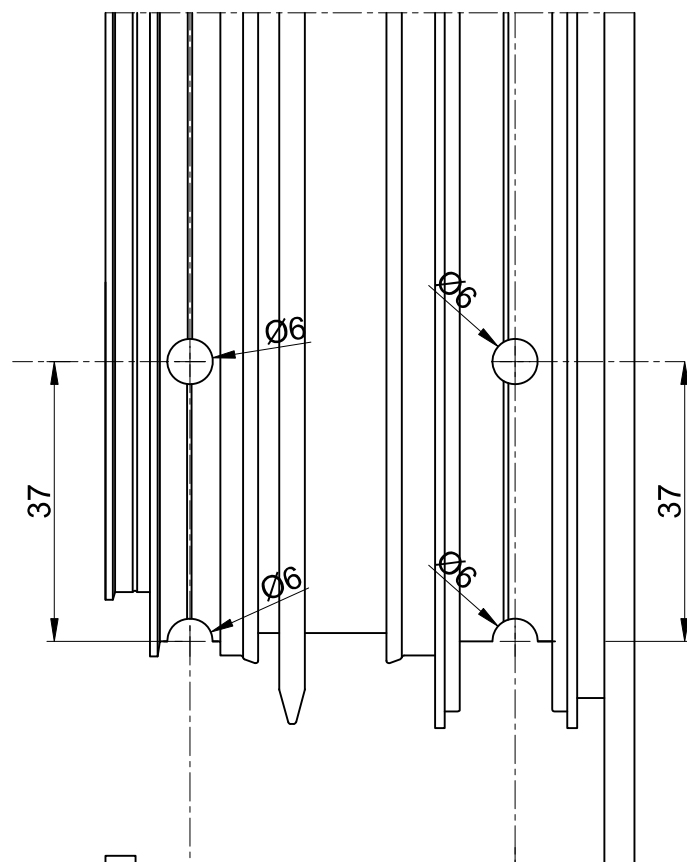
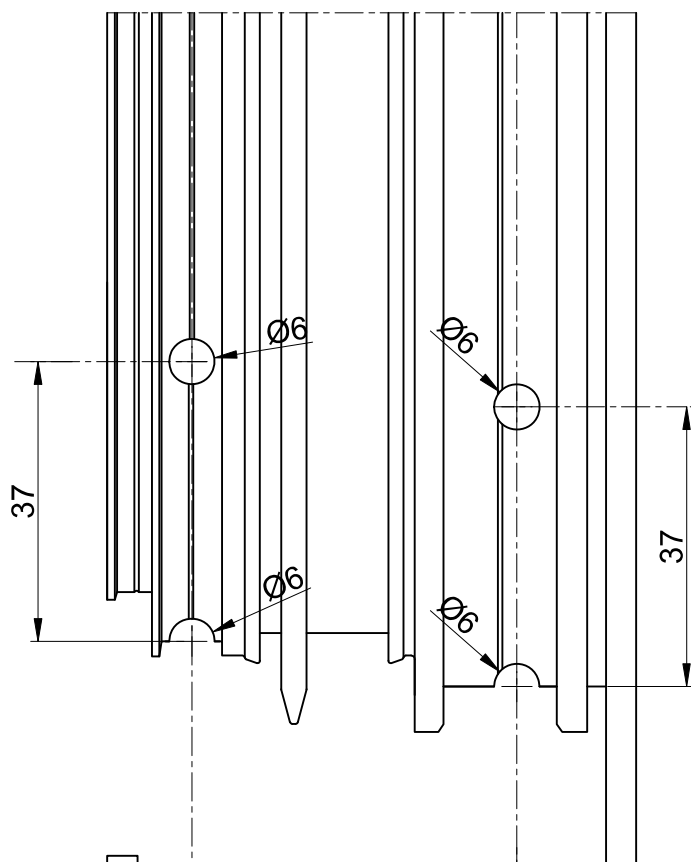
Koristiti LINEAL presu
Use LINEAL press
использовать LINEAL пресс

501	517
601	617
701	717



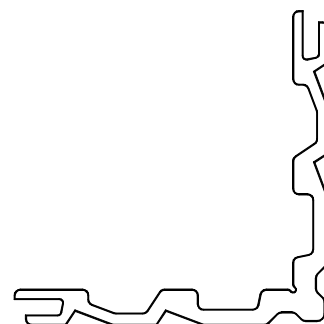
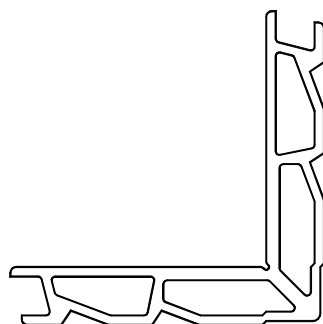
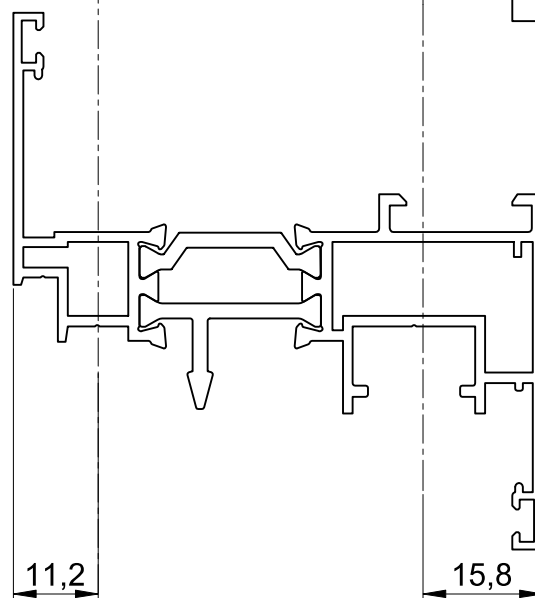
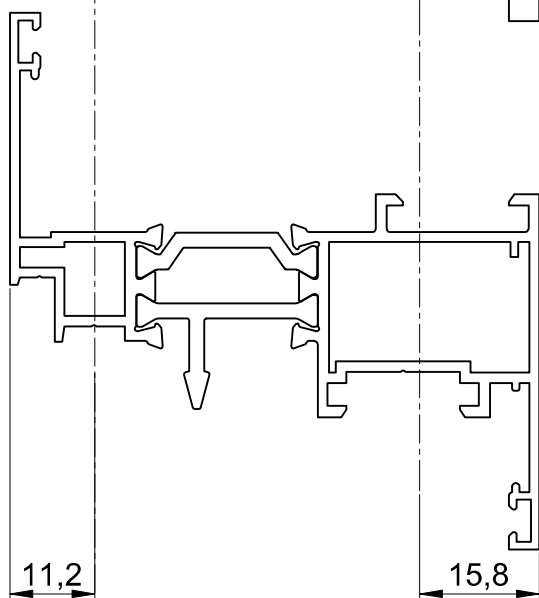
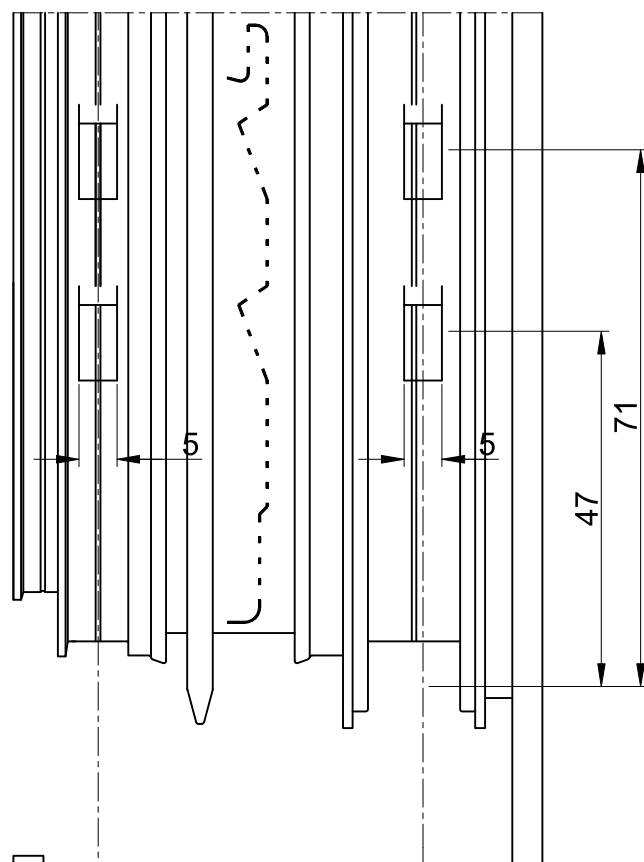
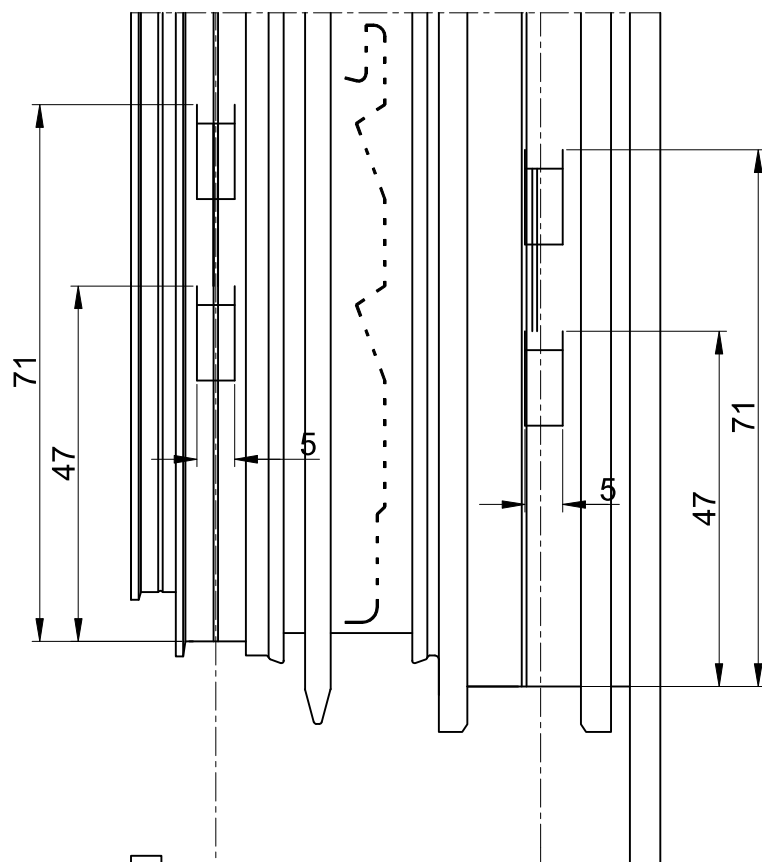
Koristiti LINEAL presu
Use LINEAL press
использовать LINEAL пресс

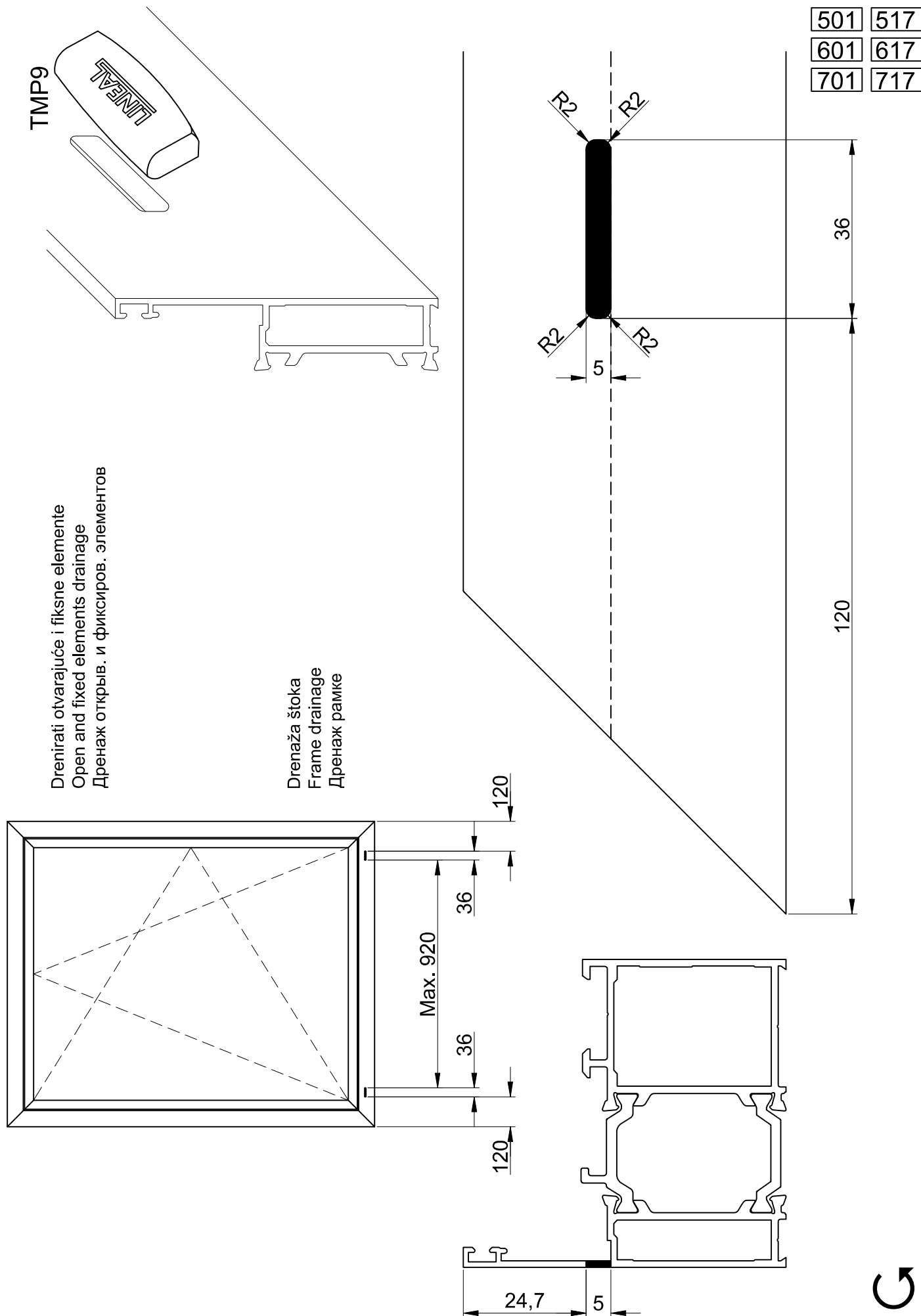
504	505	514	515	519	520
604	605	614	615	619	620
704	705	714	715	719	720

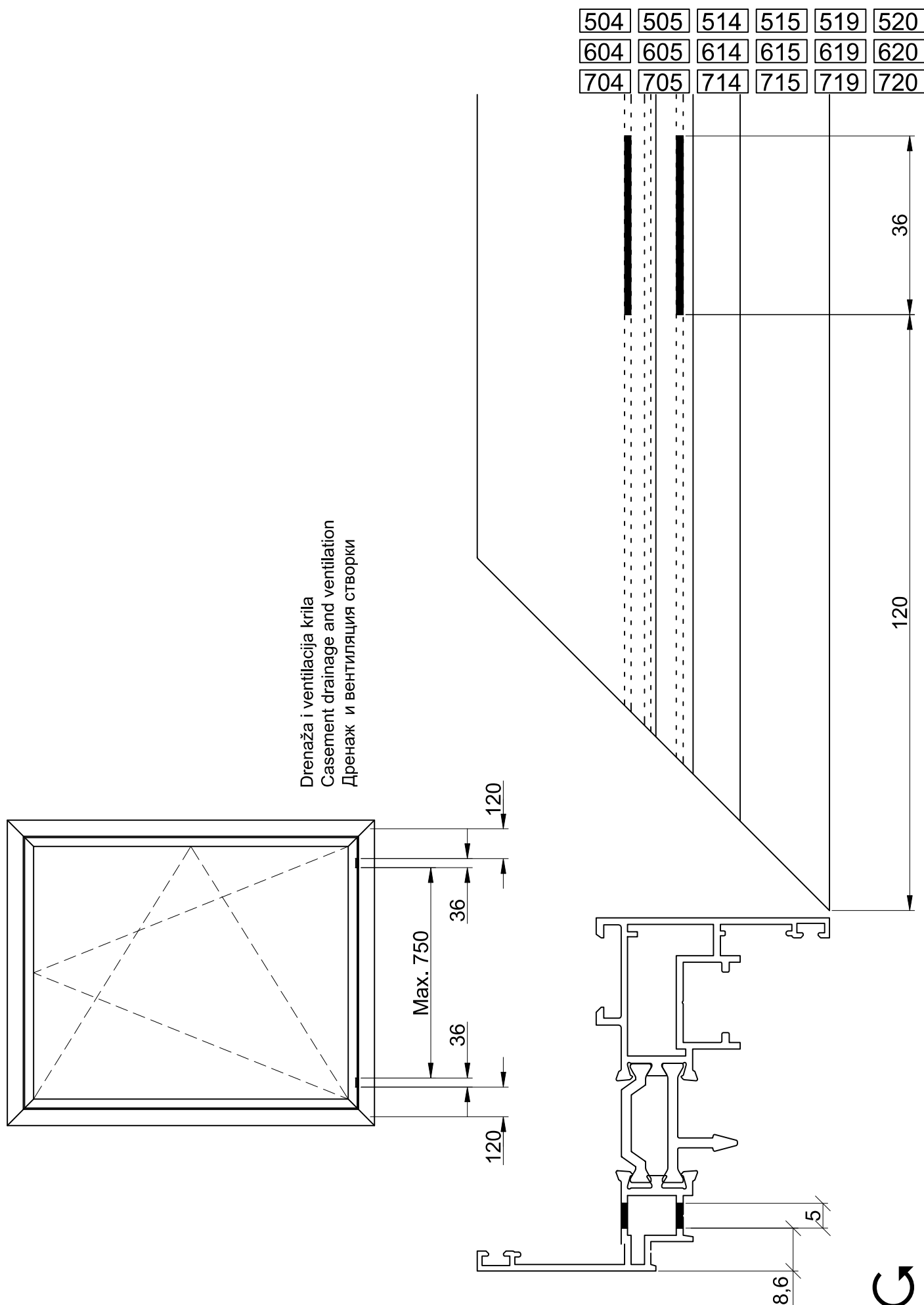


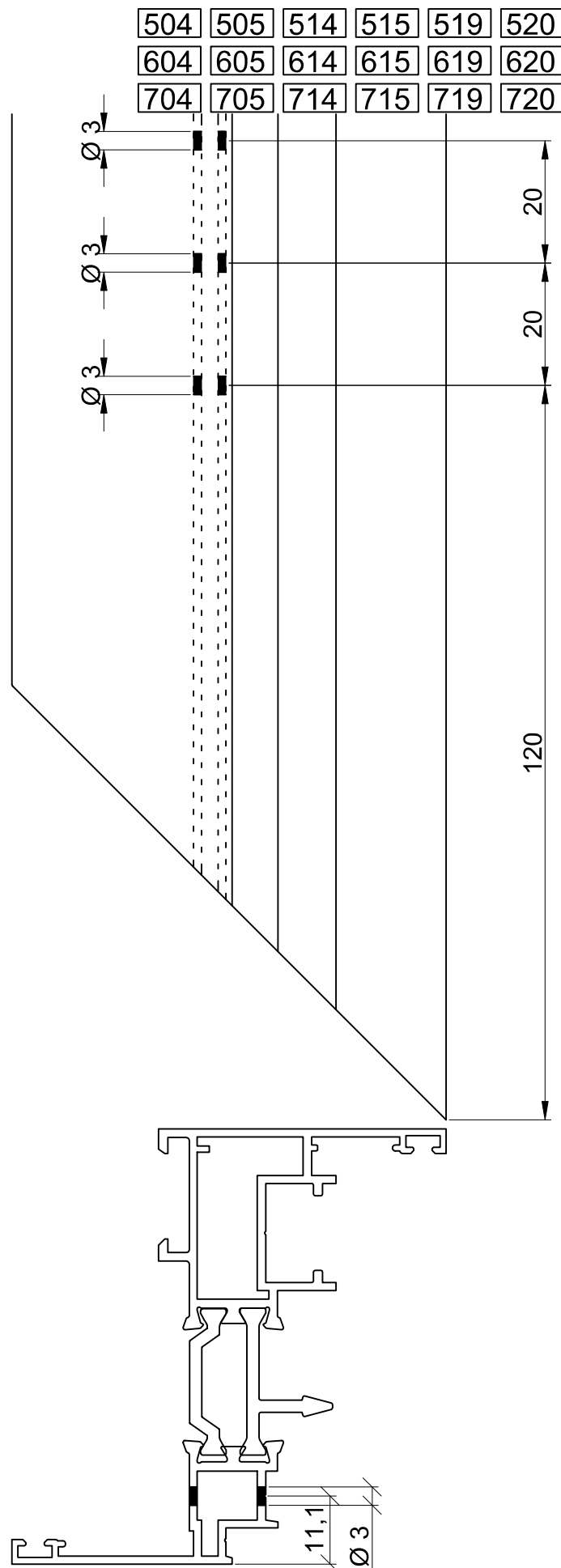
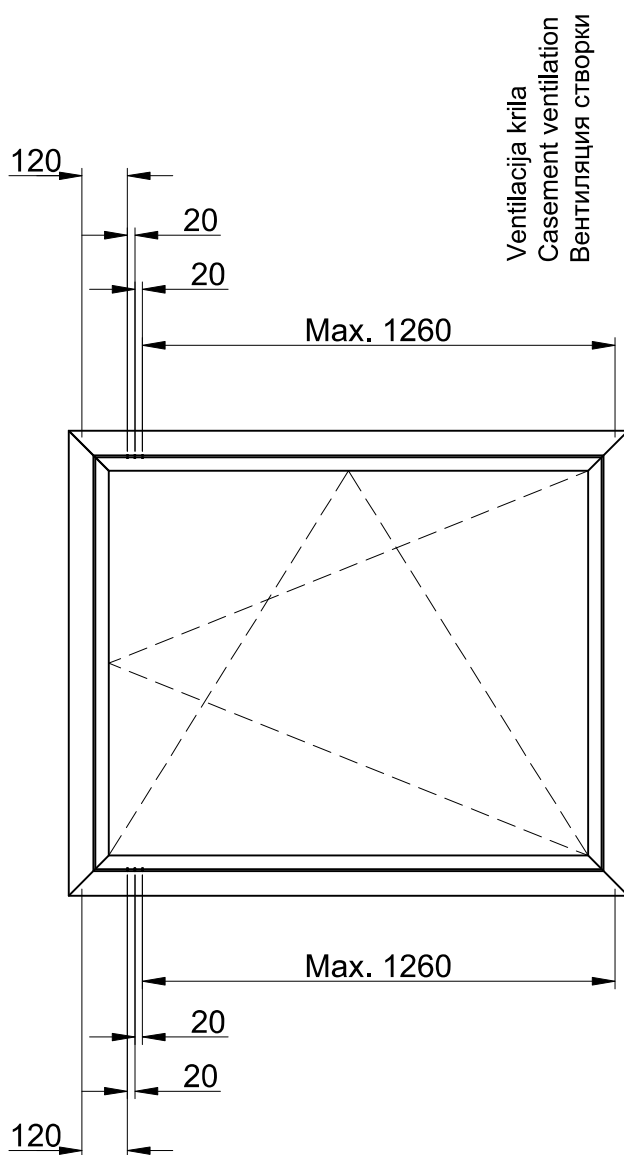
Koristiti standardne alate 5mm
Use standard tools 5mm
используйте стандартные инструменты

504	505	514	515	519	520
604	605	614	615	619	620
704	705	714	715	719	720



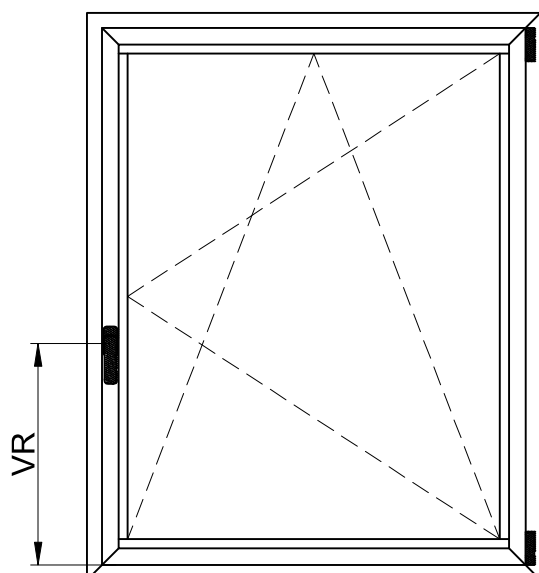




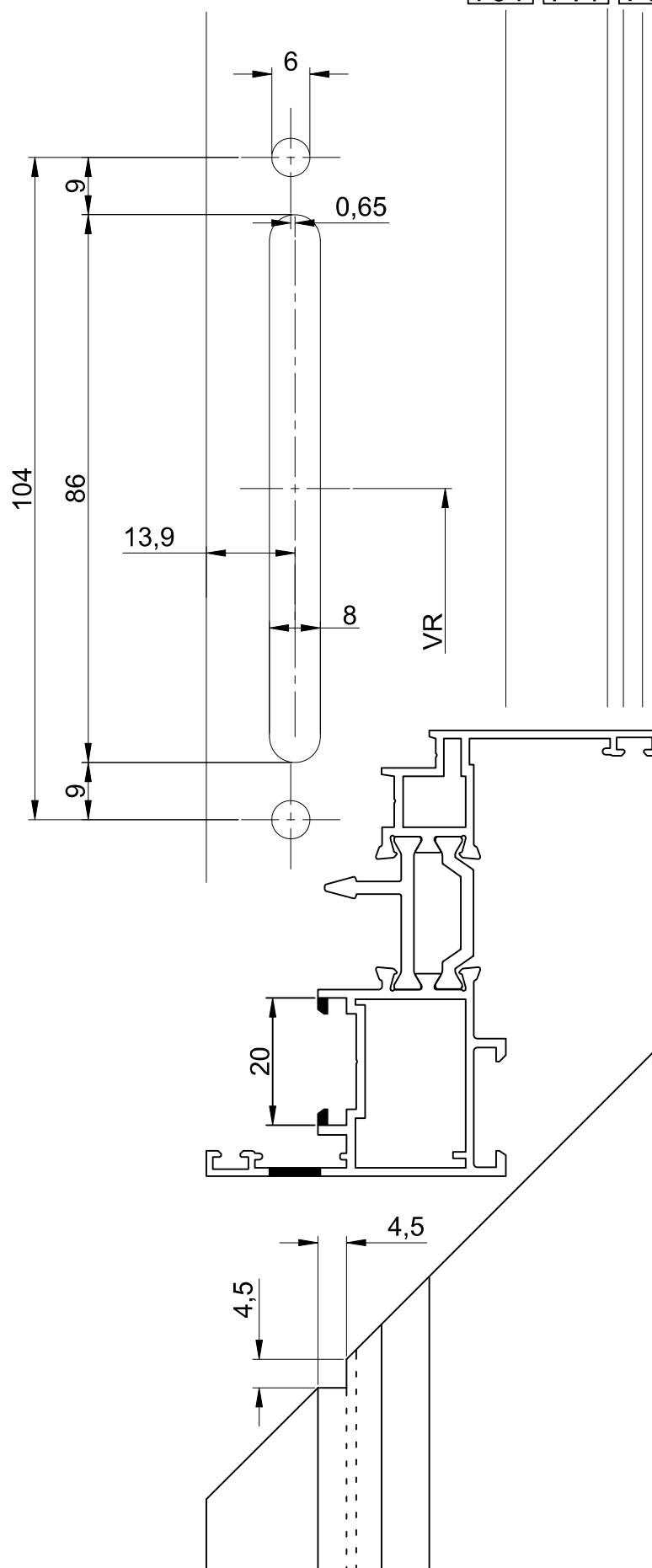


EURO 1

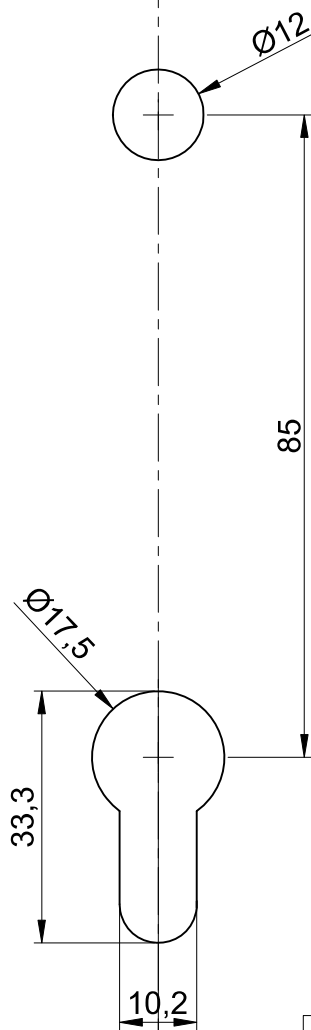
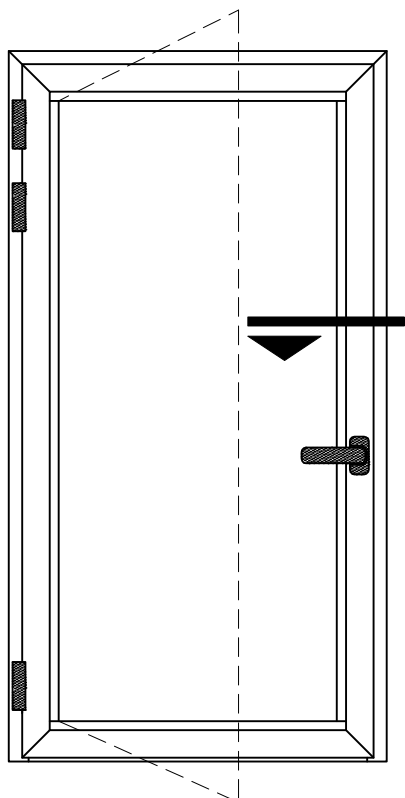
504	514	519
604	614	619
704	714	719



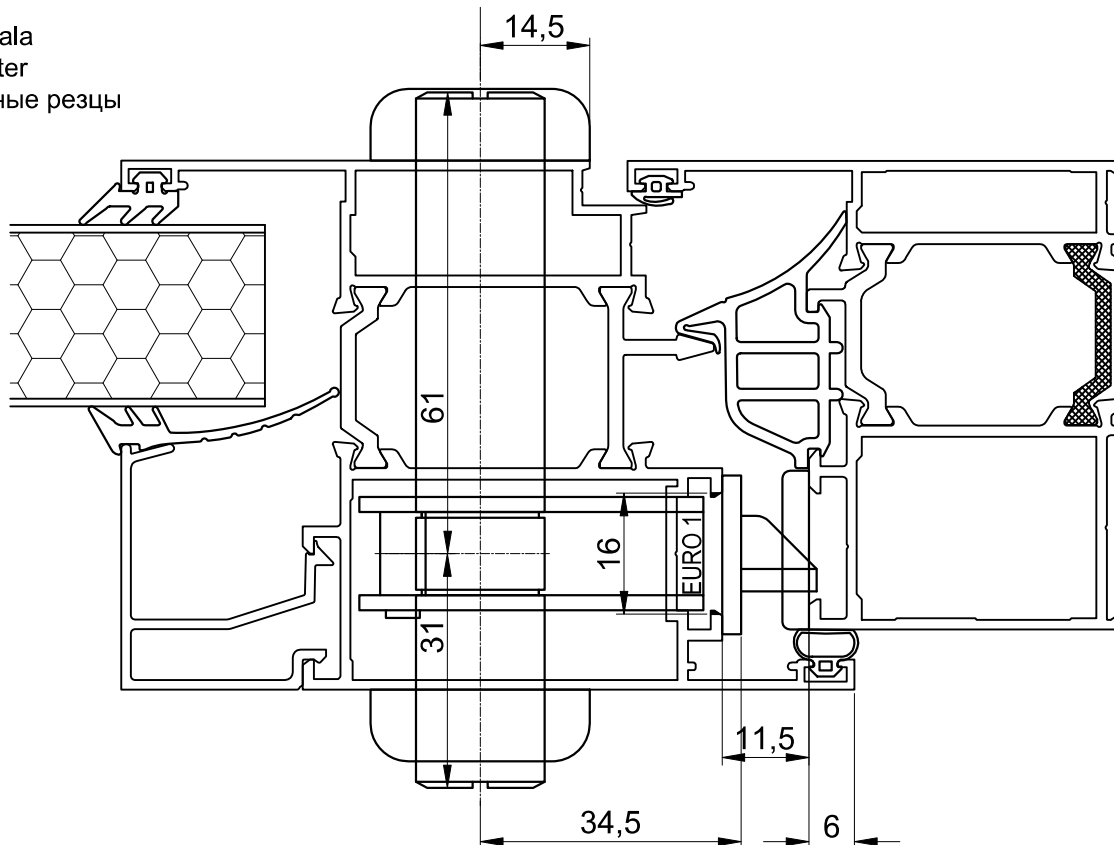
Koristiti LINEAL presu
Use LINEAL press
использовать LINEAL пресс

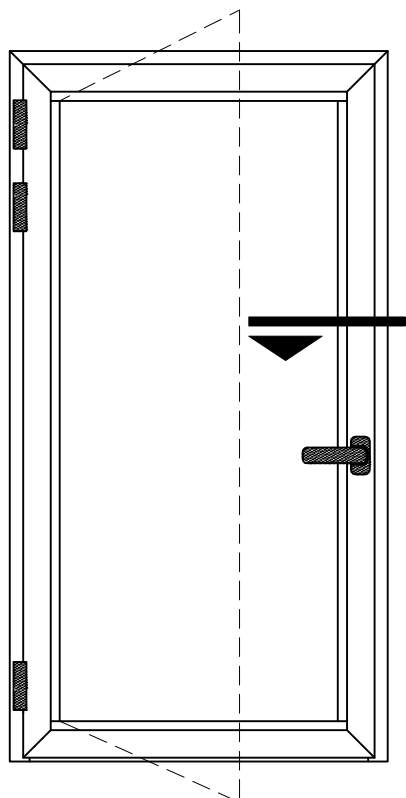


EURO 1

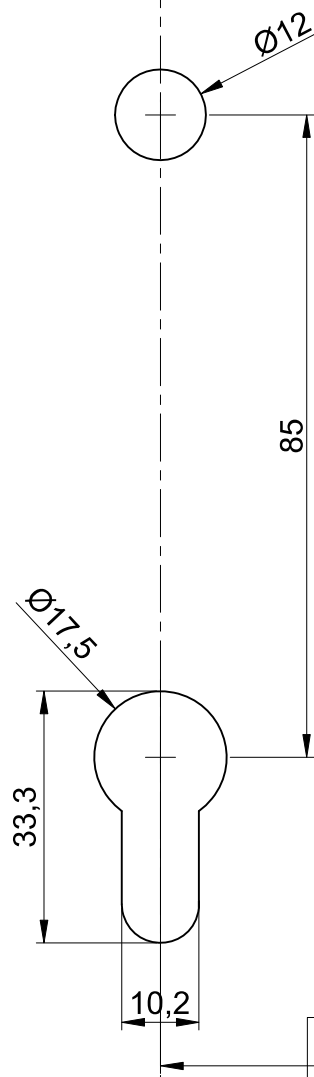


Koristiti standardna glodala
Use standard milling cutter
Используйте стандартные резцы

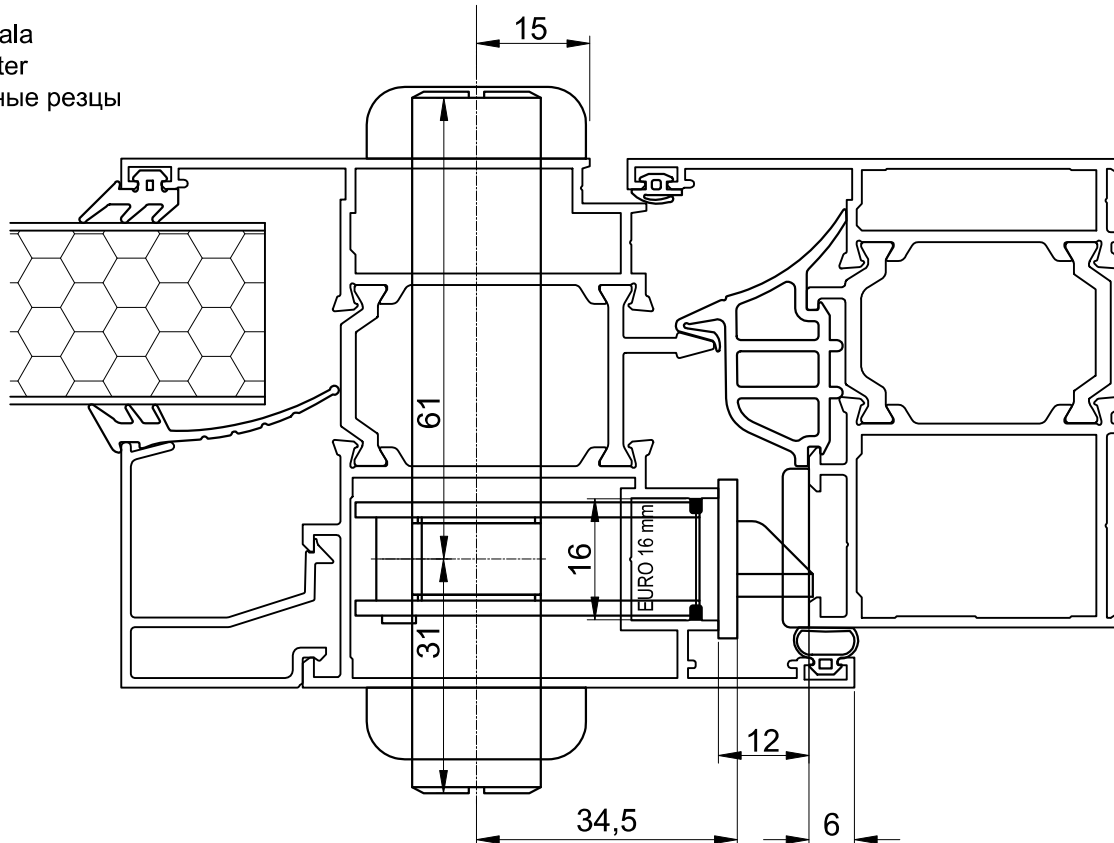


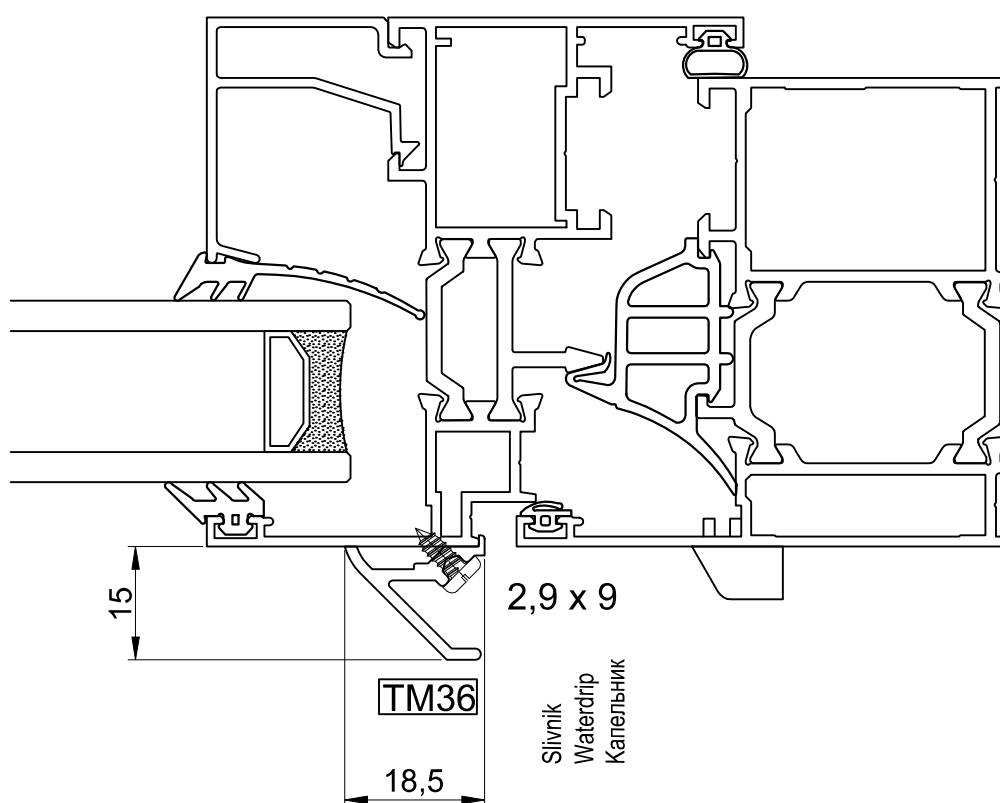
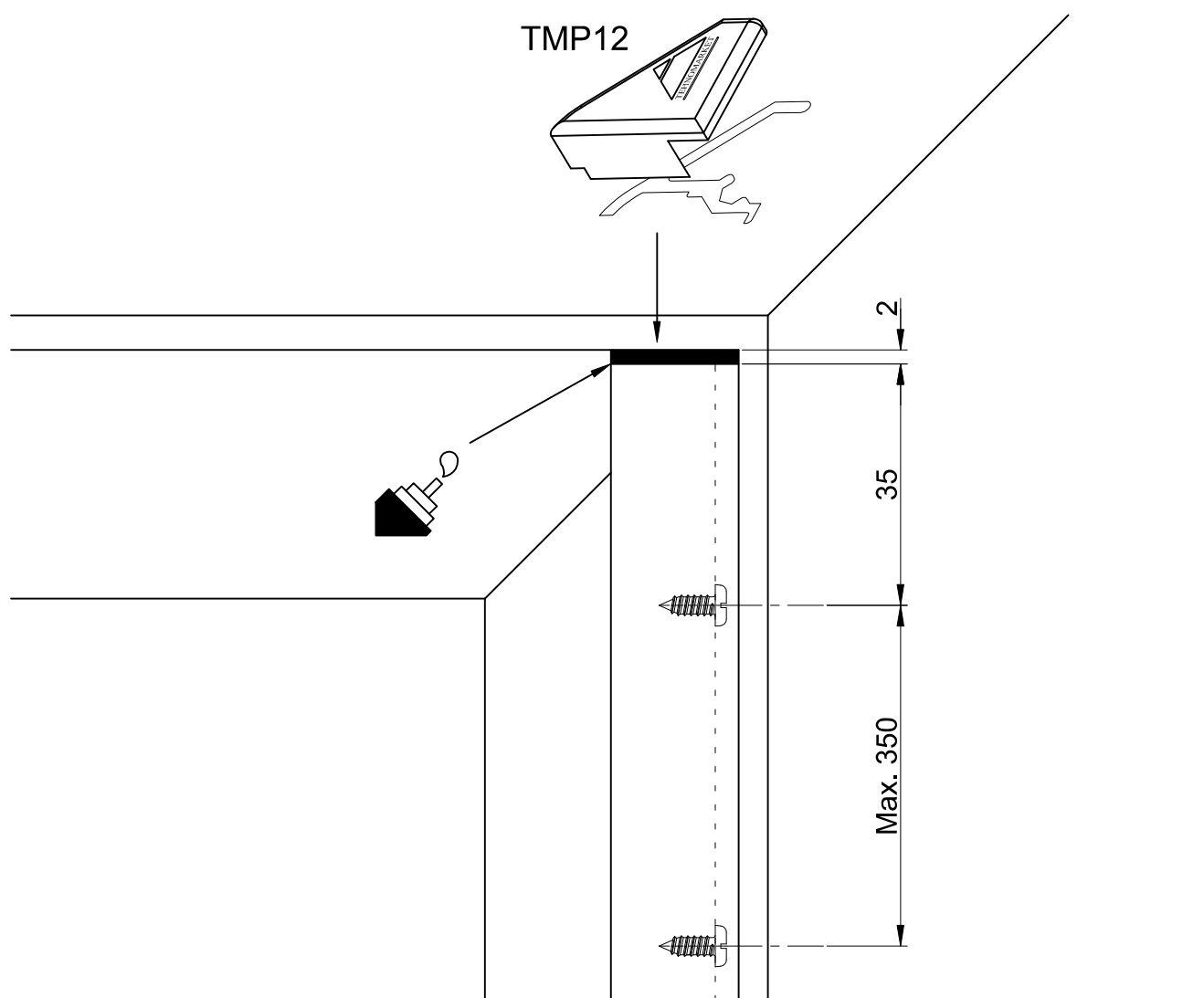


EURO 16mm



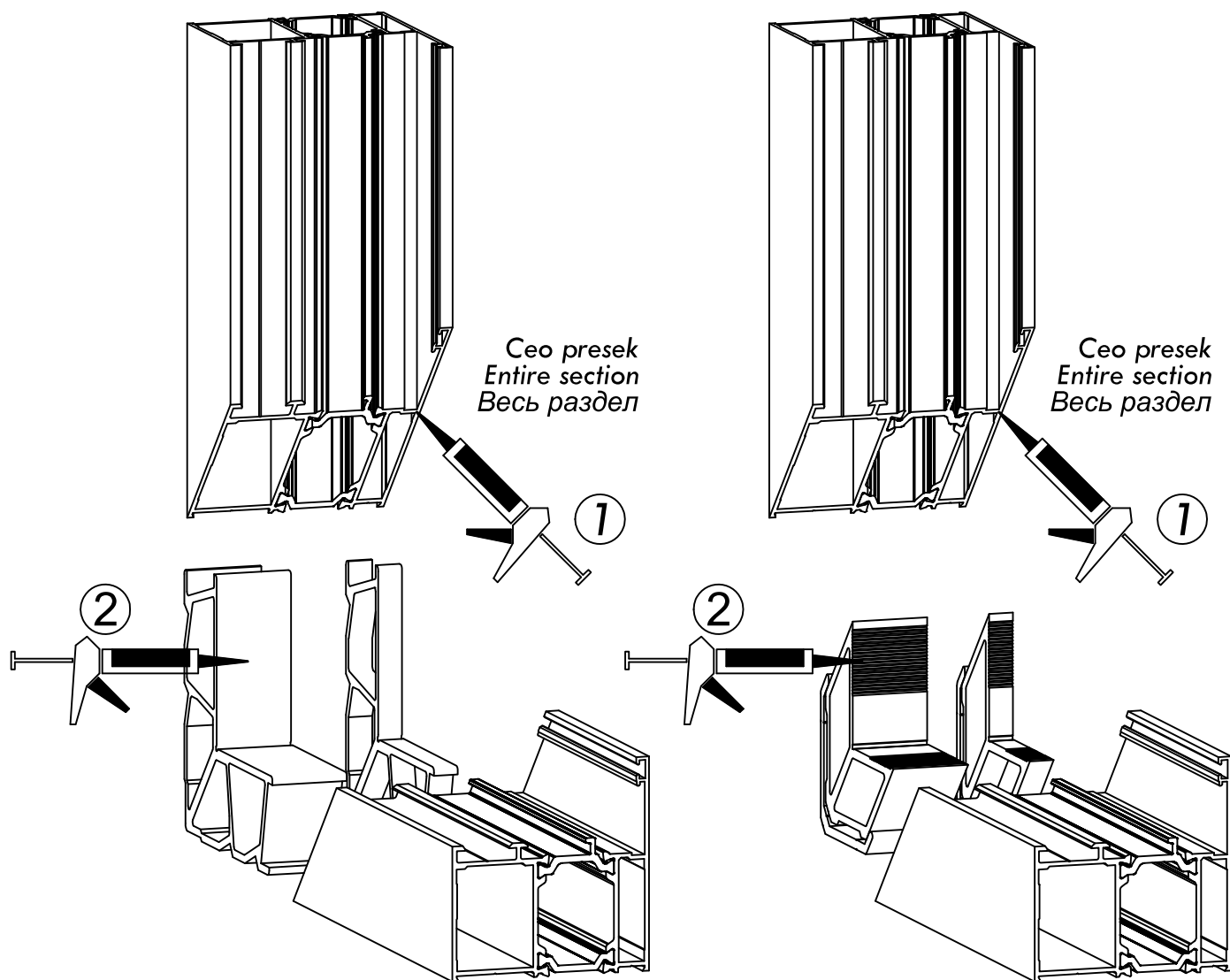
Koristiti standardna glodala
Use standard milling cutter
Используйте стандартные резцы





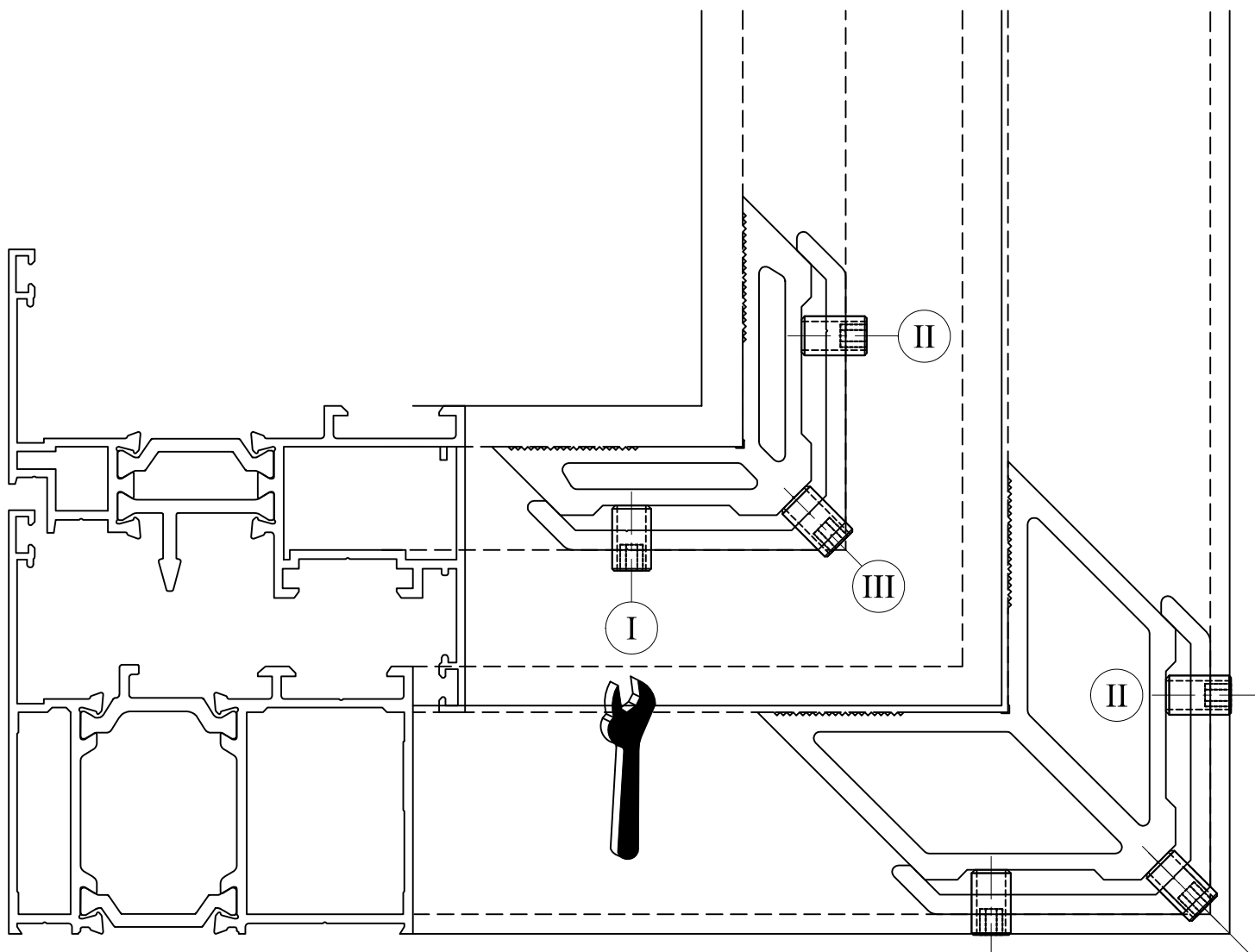
Sklapanje
Assembly
Ассамблея



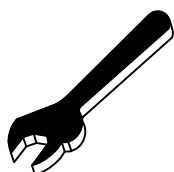


1 Lepak i zaptivna masa za alumijum
Glue and sealant for aluminium
Клей и герметик для алюминия

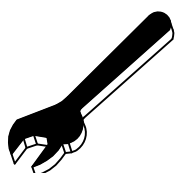
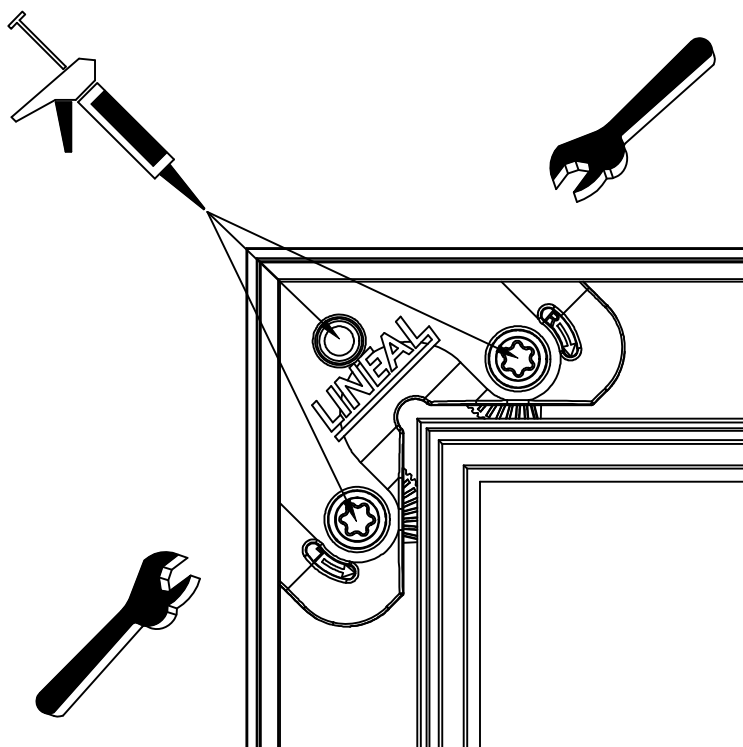
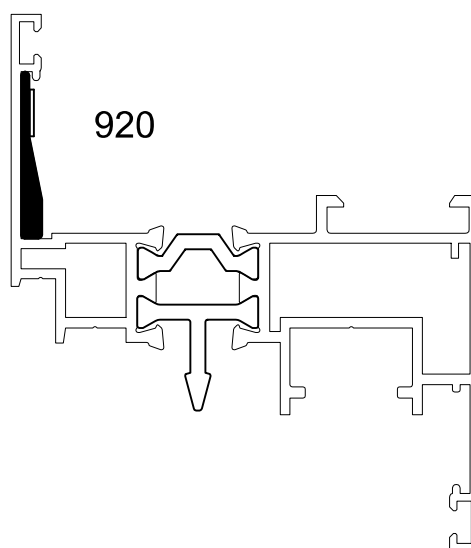
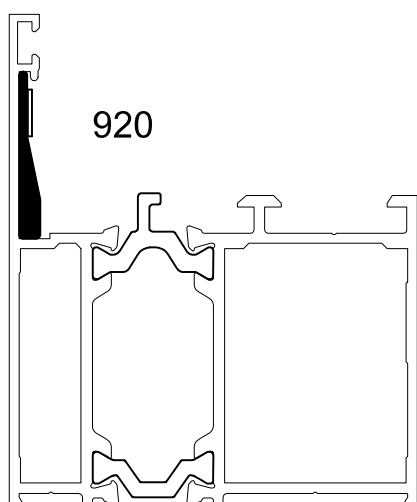
2 Lepak za spojnice
Corner joint glue
Клей для углового соединения



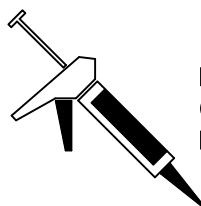
Prati raspored zatezanja
Follow the schedule for tightening
Следовать расписание для затяжки



Koristiti Imbus 2,5mm
Use Allen key 2,5mm
использовать имбус - шестигранный ключ 2,5мм

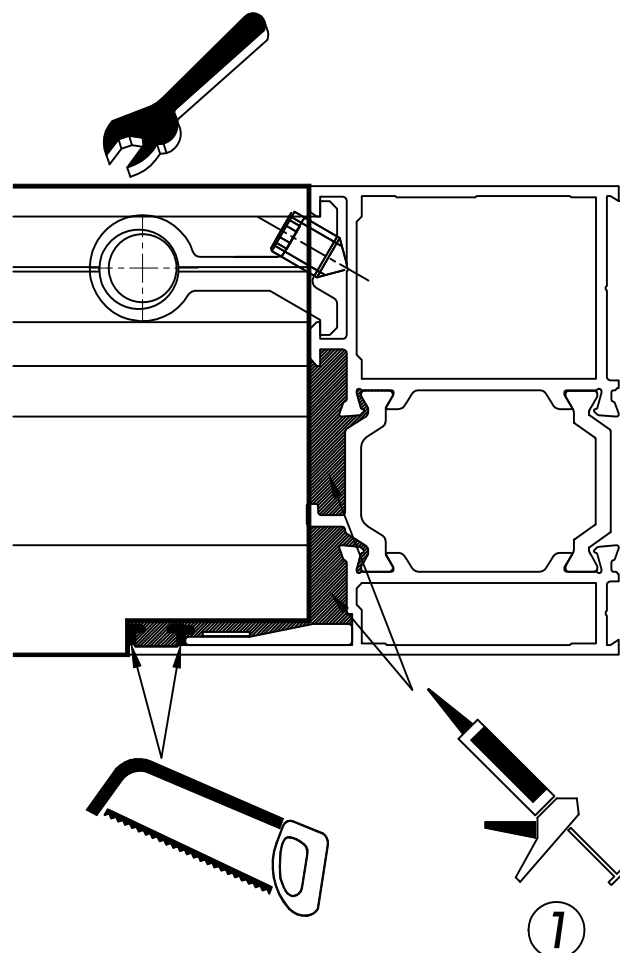
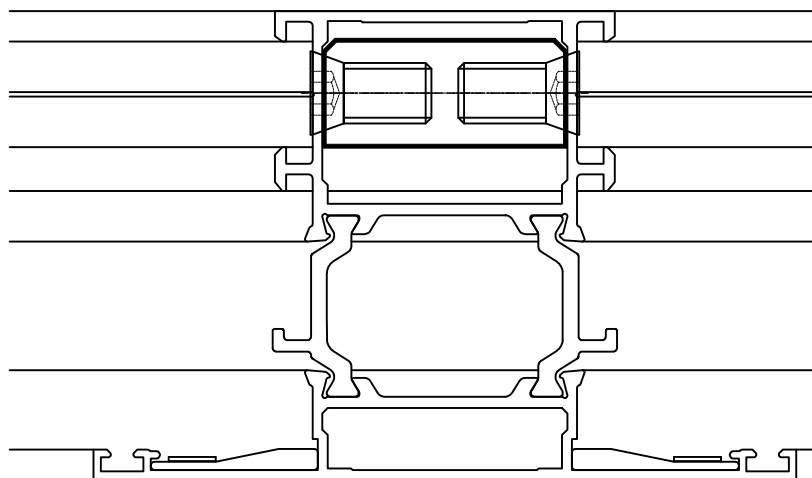


Koristiti Torx T25
Use Torx T25
использовать Torx T25

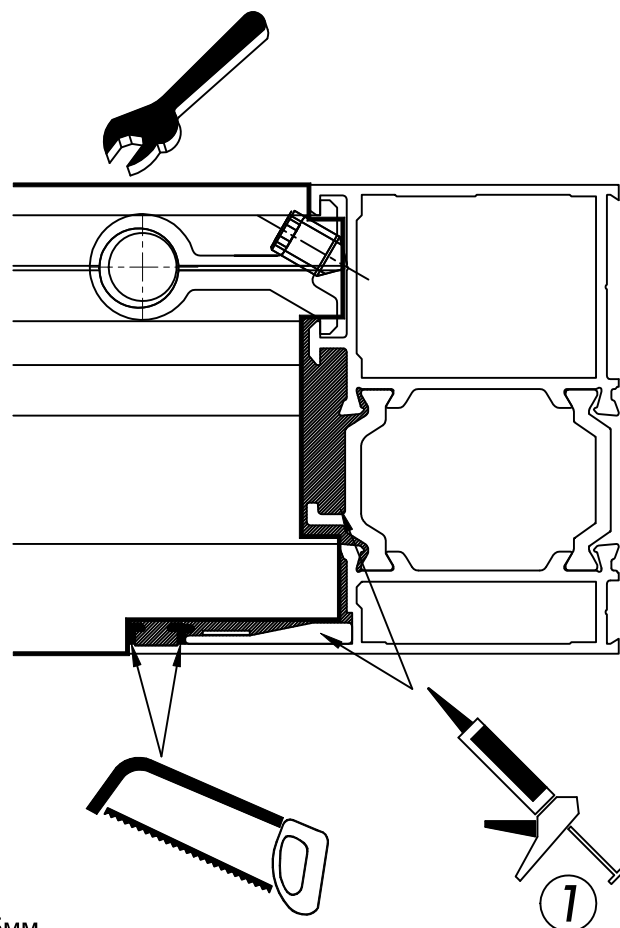
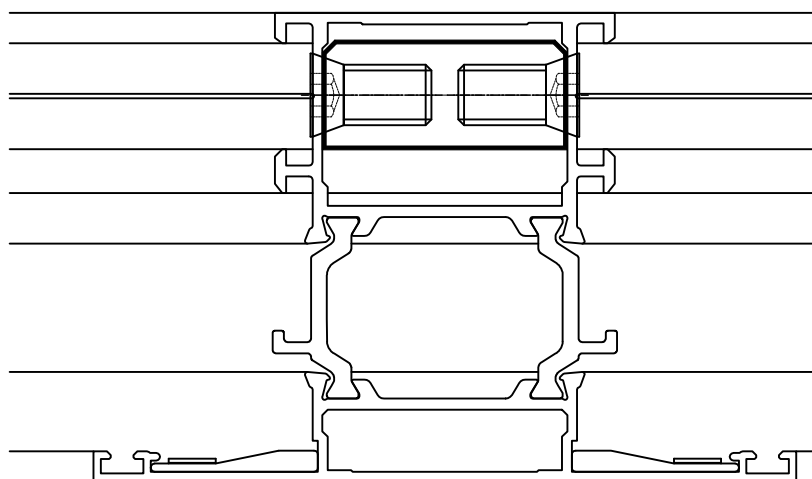


Lepak i zaptivna masa za alumijum
Glue and sealant for aluminium
Клей и герметик для алюминия

502	503	513	516	517	518
602	603	613	616	617	618

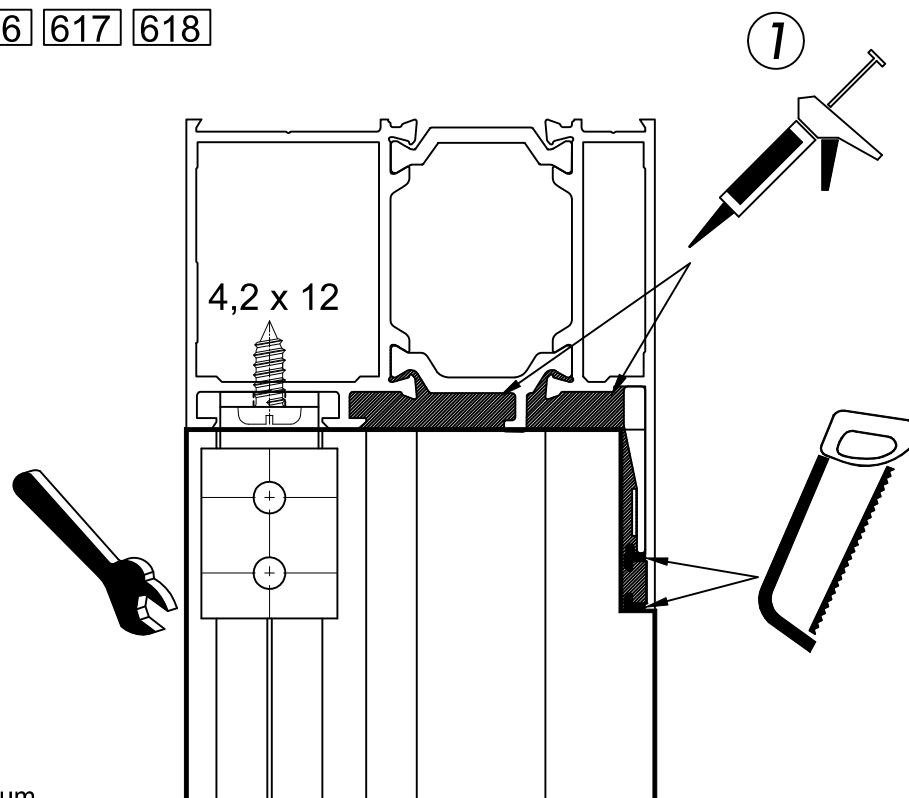


1 Lepak i zaptivna masa za aluminijum
Glue and sealant for aluminium
Клей и герметик для алюминия

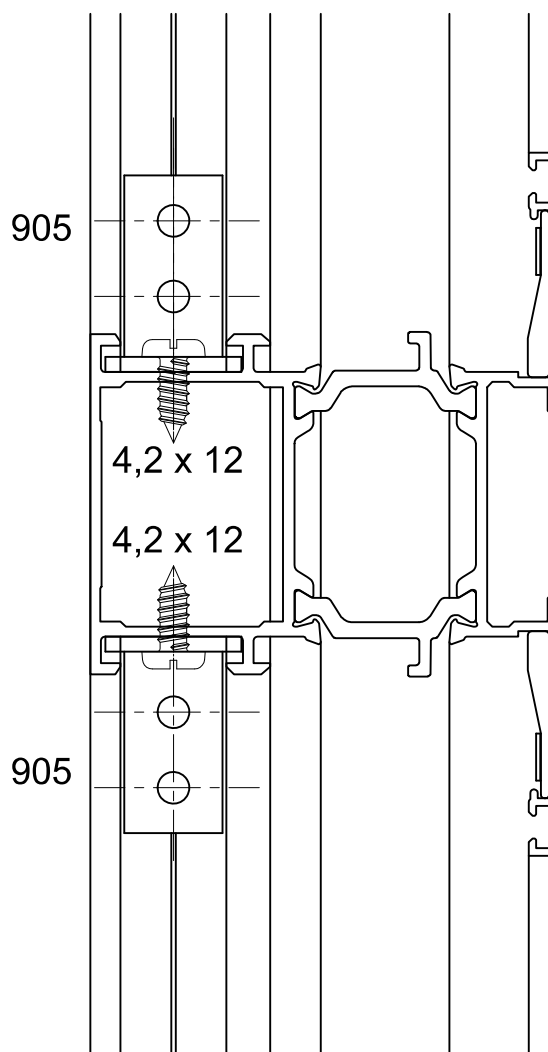


Koristiti Imbus 5mm
Use Allen key 5mm
использовать имбус - шестигранный ключ 5мм

502	503	513	516	517	518
602	603	613	616	617	618
702	713	717			

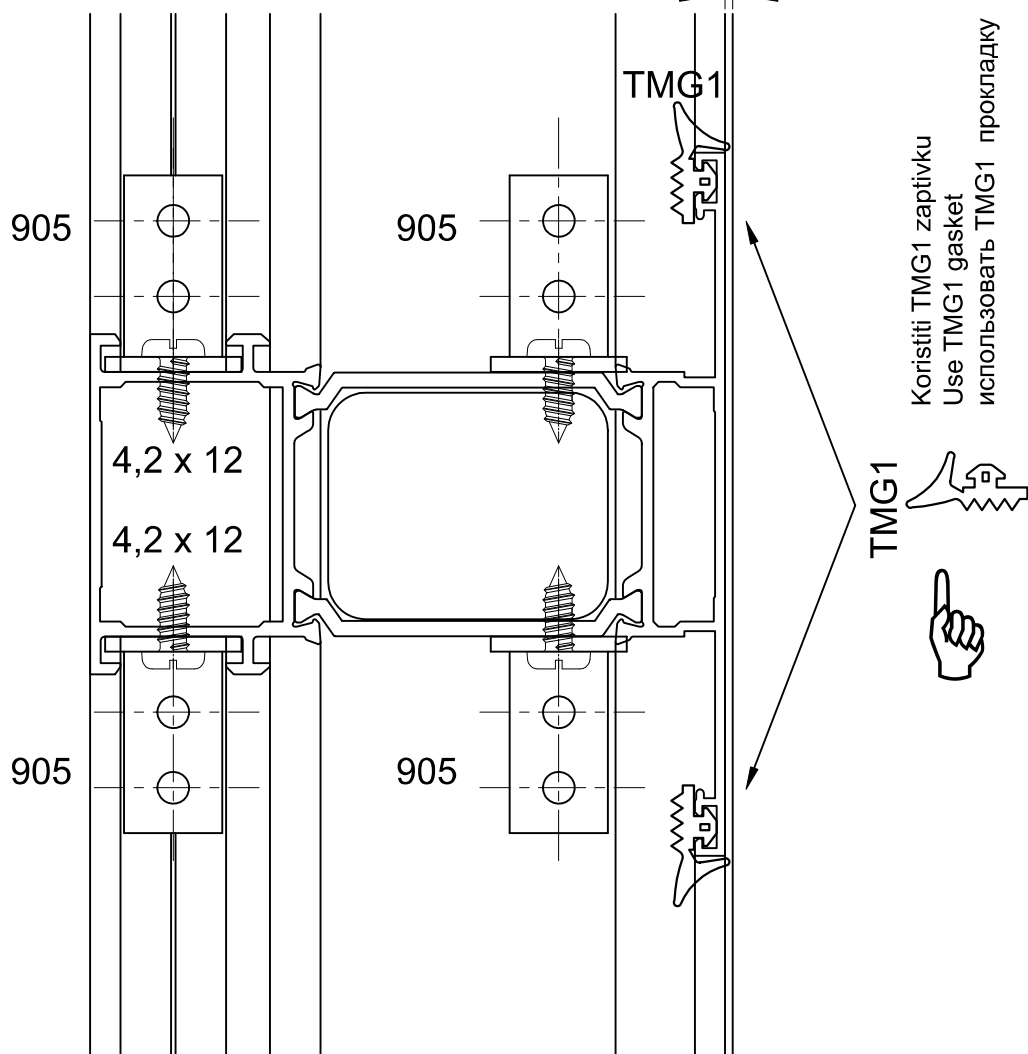
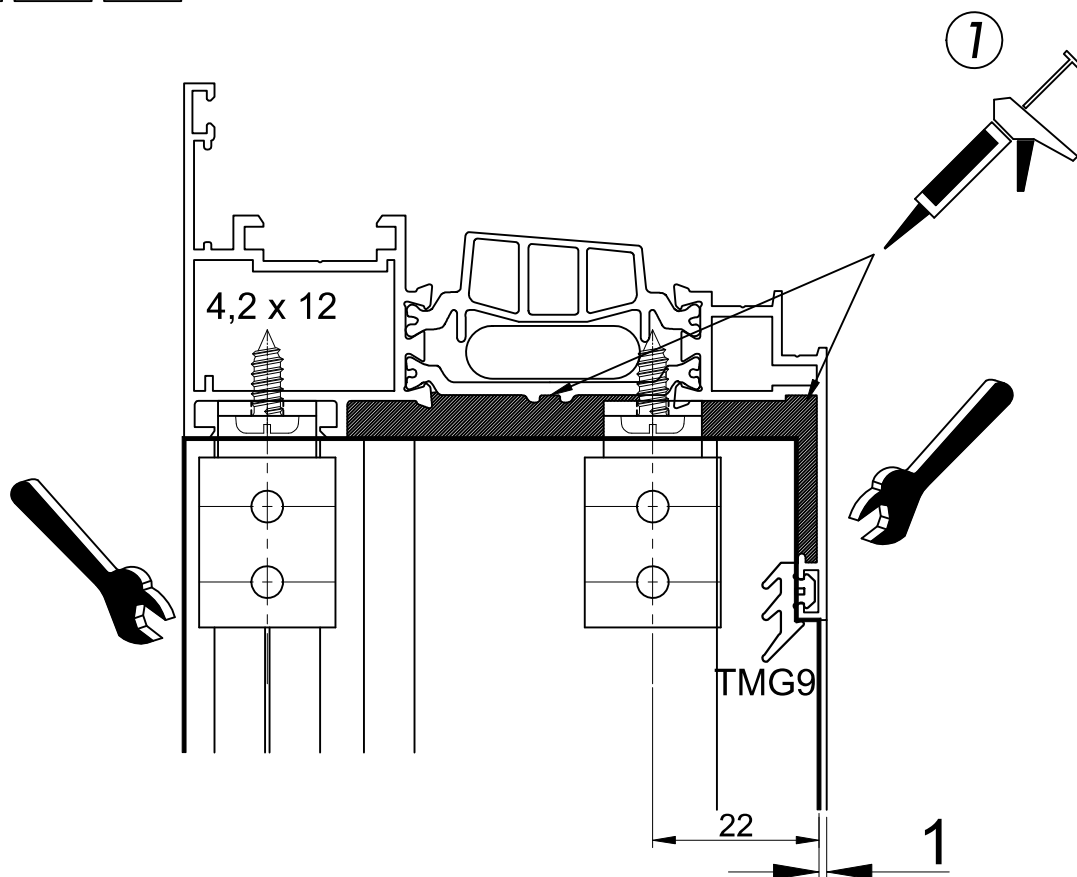


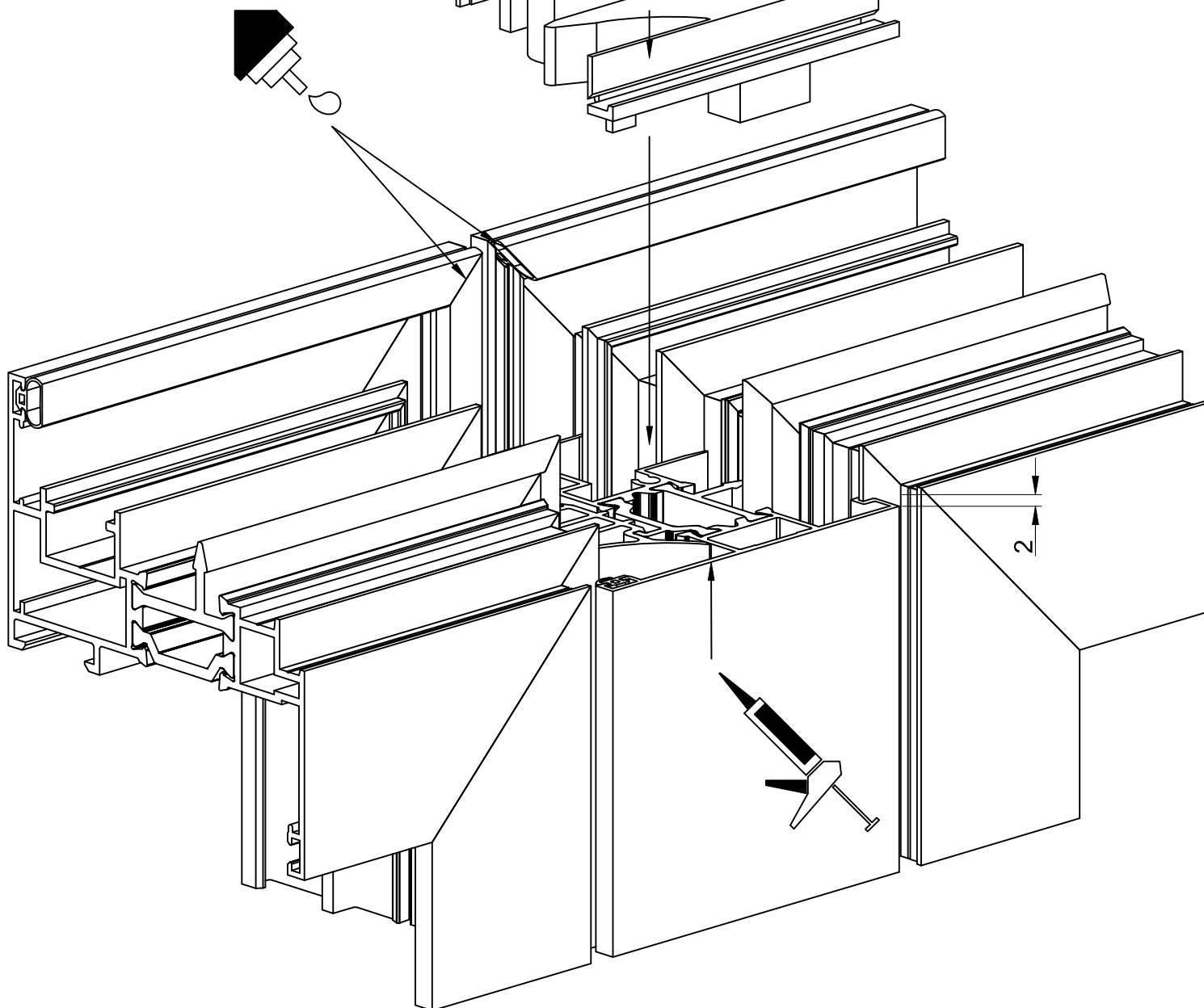
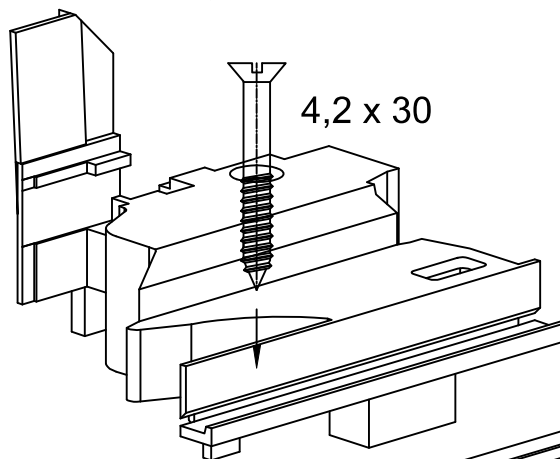
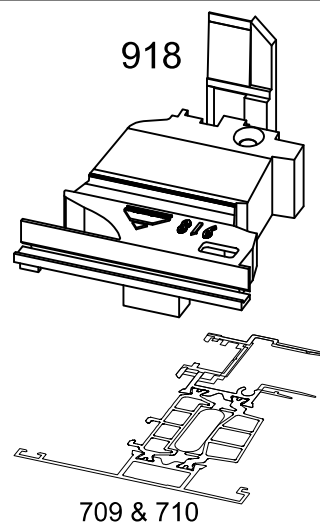
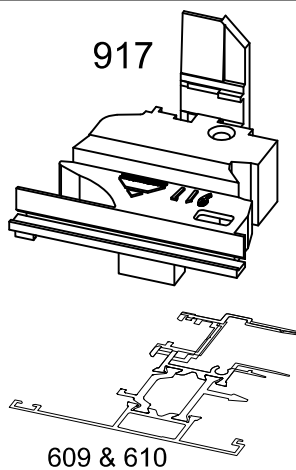
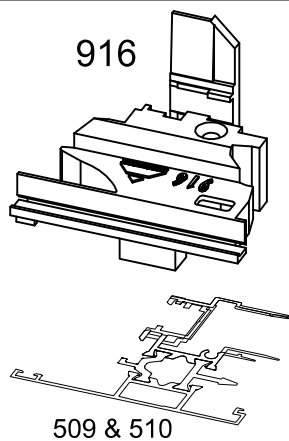
1 Lepak i zaptivna masa za alumijum
Glue and sealent for aluminium
Клей и герметик для алюминия



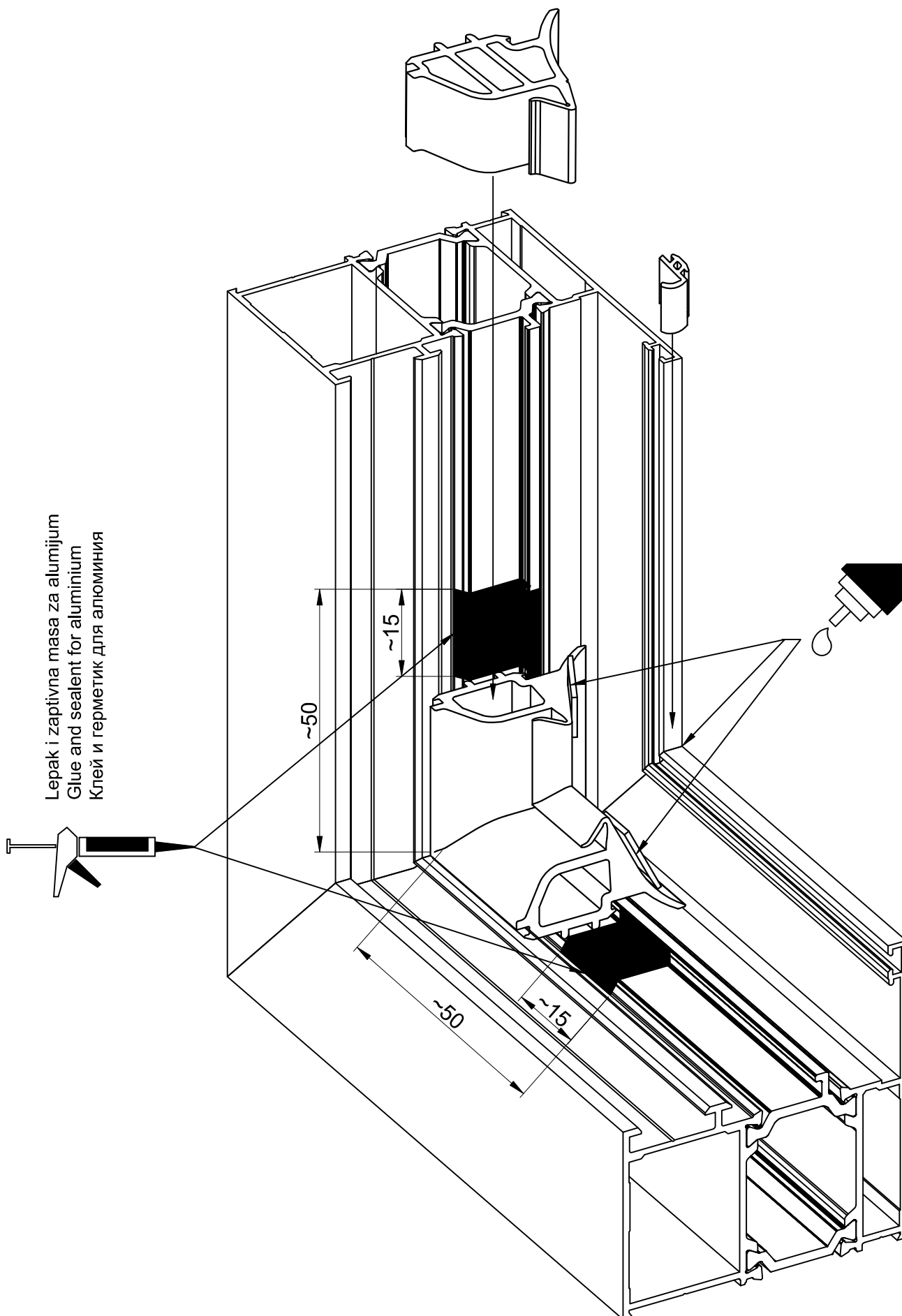
703 716 718

7
Lepak i zaptivna masa za aluminijum
Glue and sealent for aluminium
Клей и герметик для алюминия

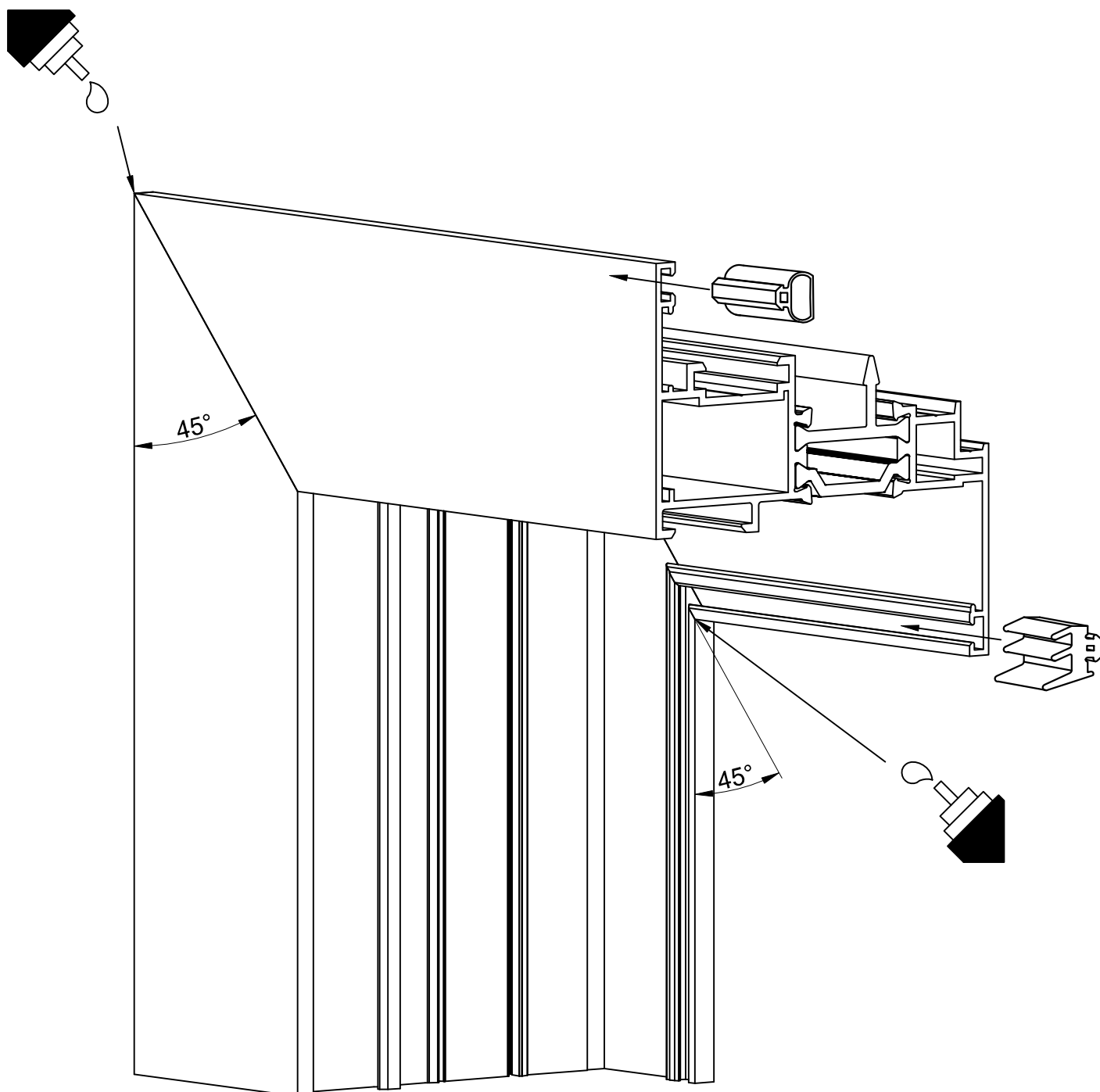




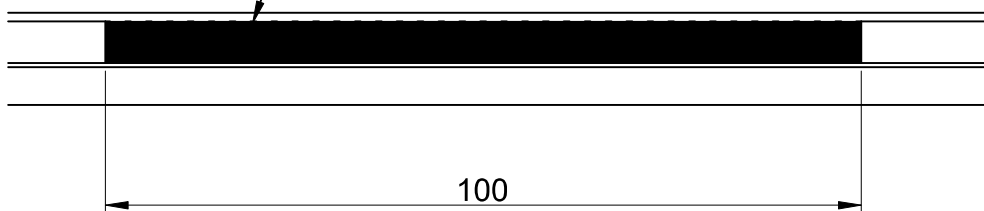
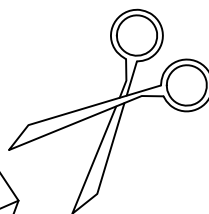
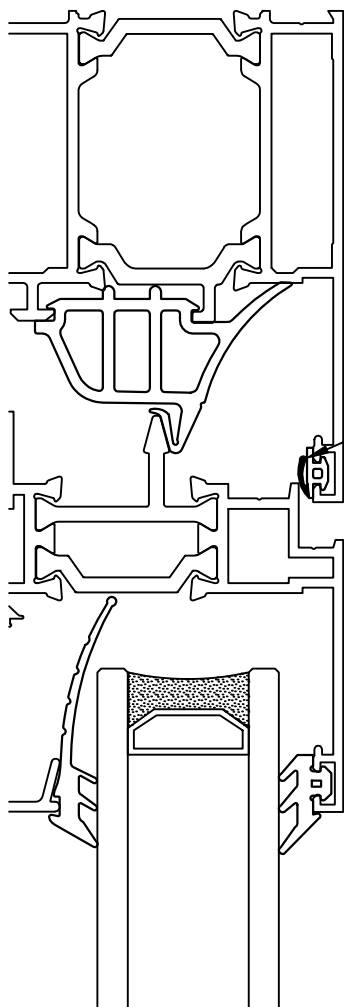
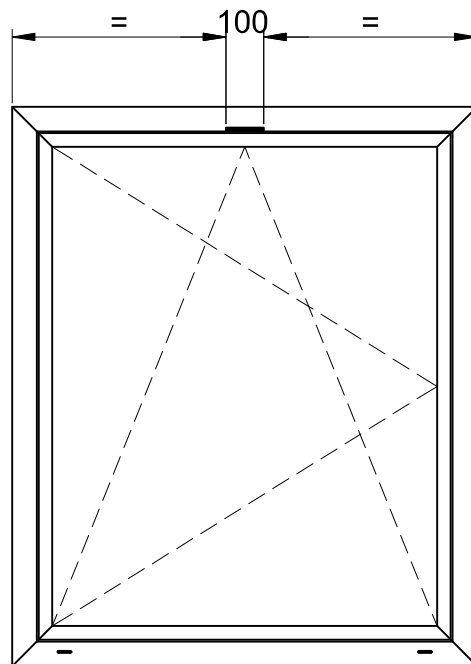
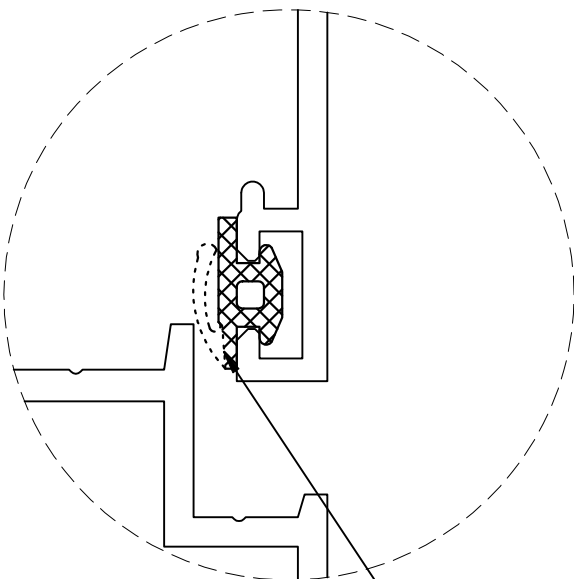
Sve zaptivke lepiti namenski lepkom za gumu
For all gaskets use gasket glue
Все прокладки приложить с эластичным клеем



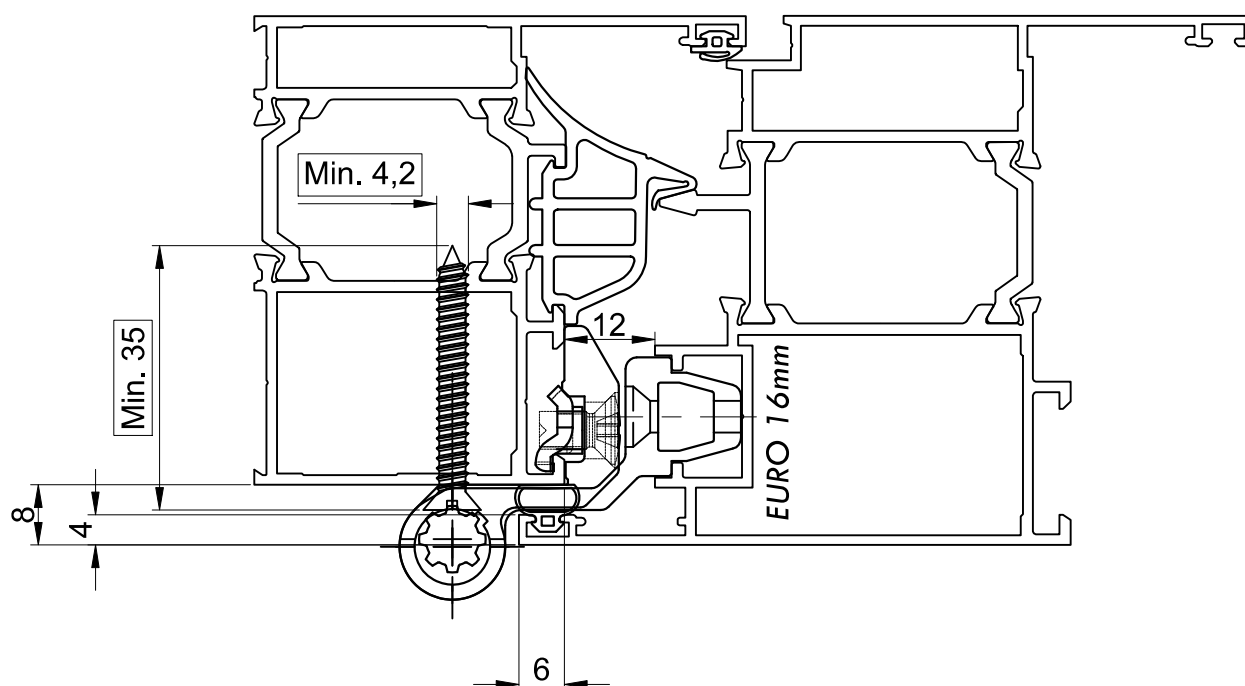
Sve zaptivke lepiti namenski lepkom za gumu
For all gaskets use gasket glue
Все прокладки приложить с эластичным клеем



Ventilacija štoka
Frame ventilation
Дренаж рамке

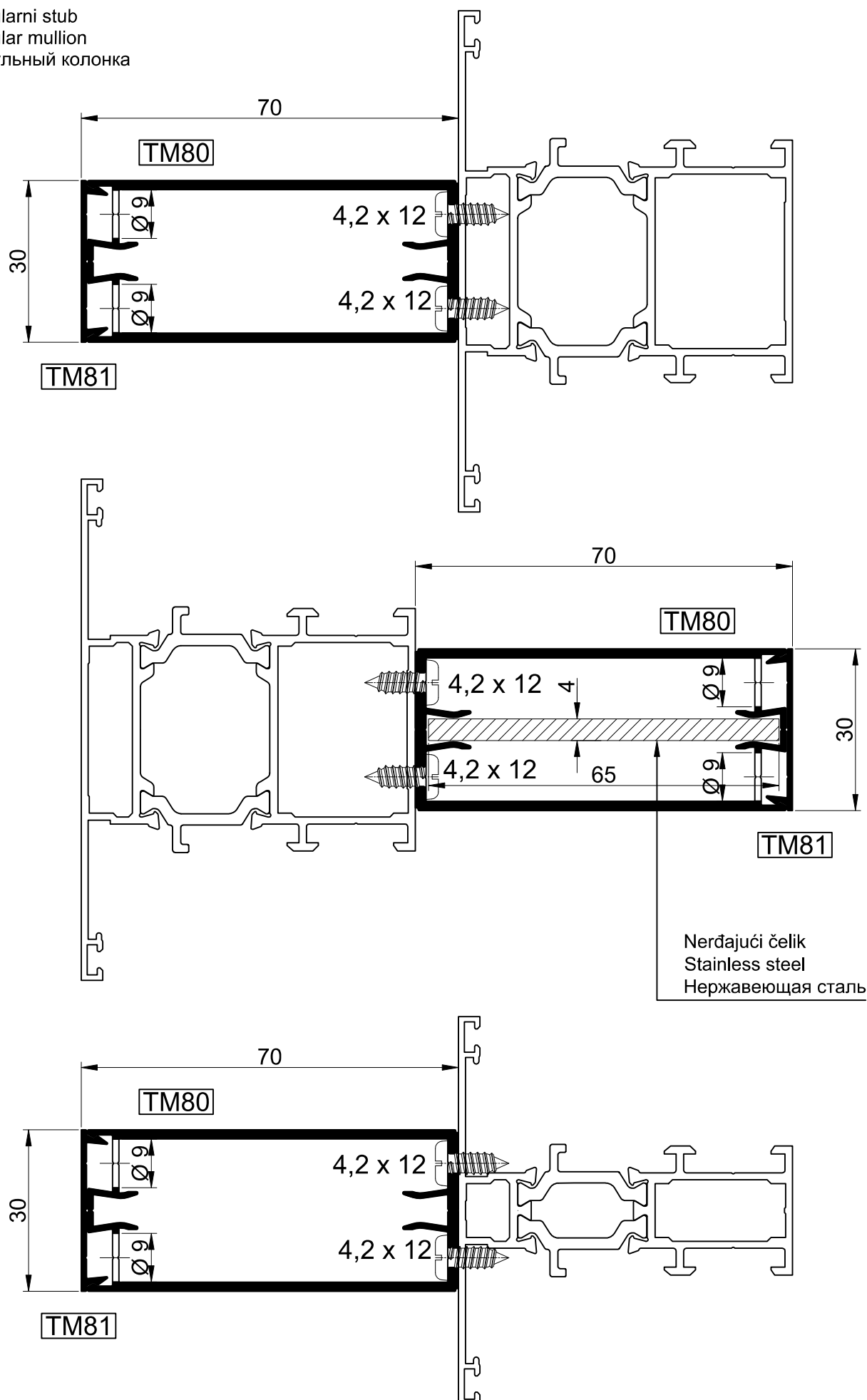


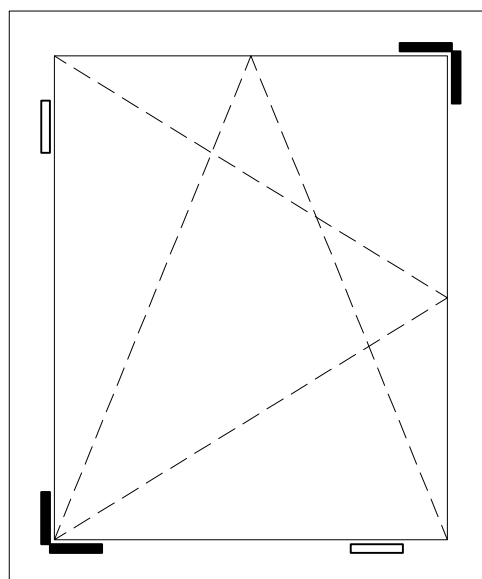
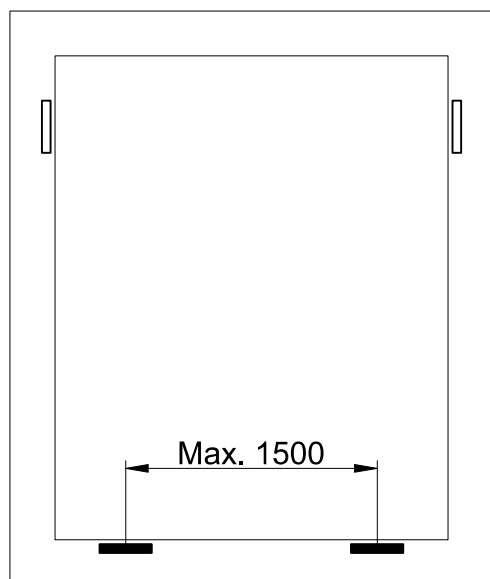
EURO 16mm



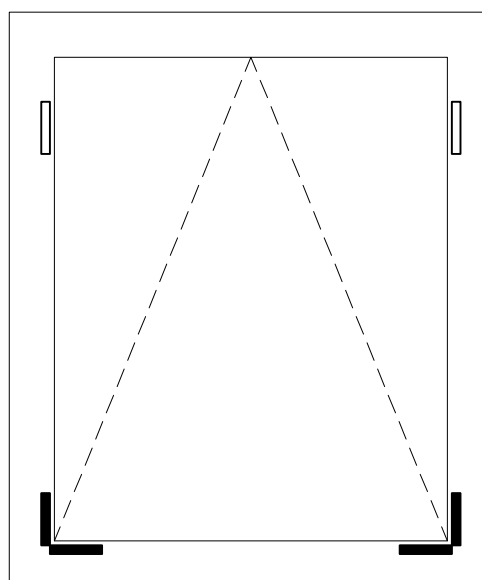
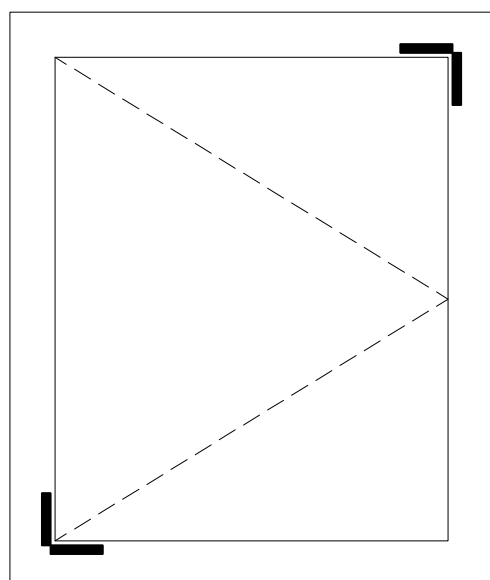
Šarku fiksirati kroz oba zida
 Tighten the hinge through the two walls
 Присоединять петлю через две стены

Modularni stub
Modular mullion
Модульный колонка

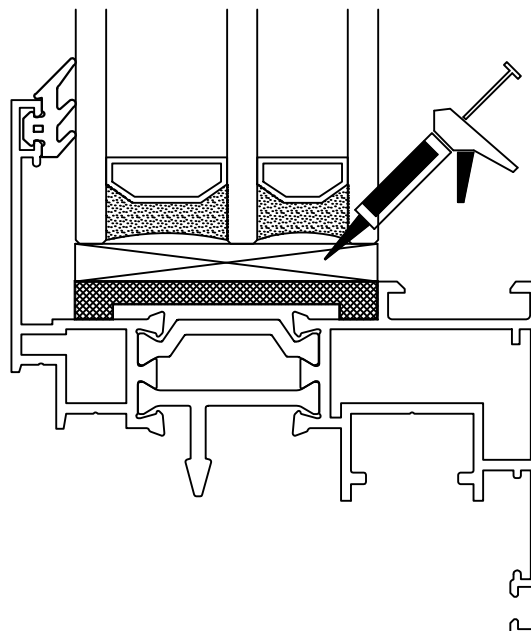
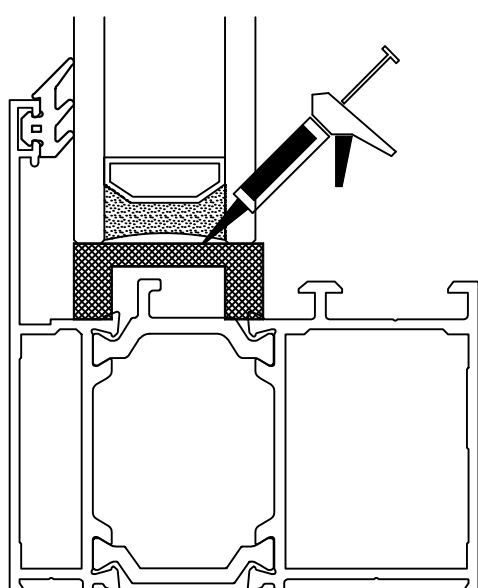




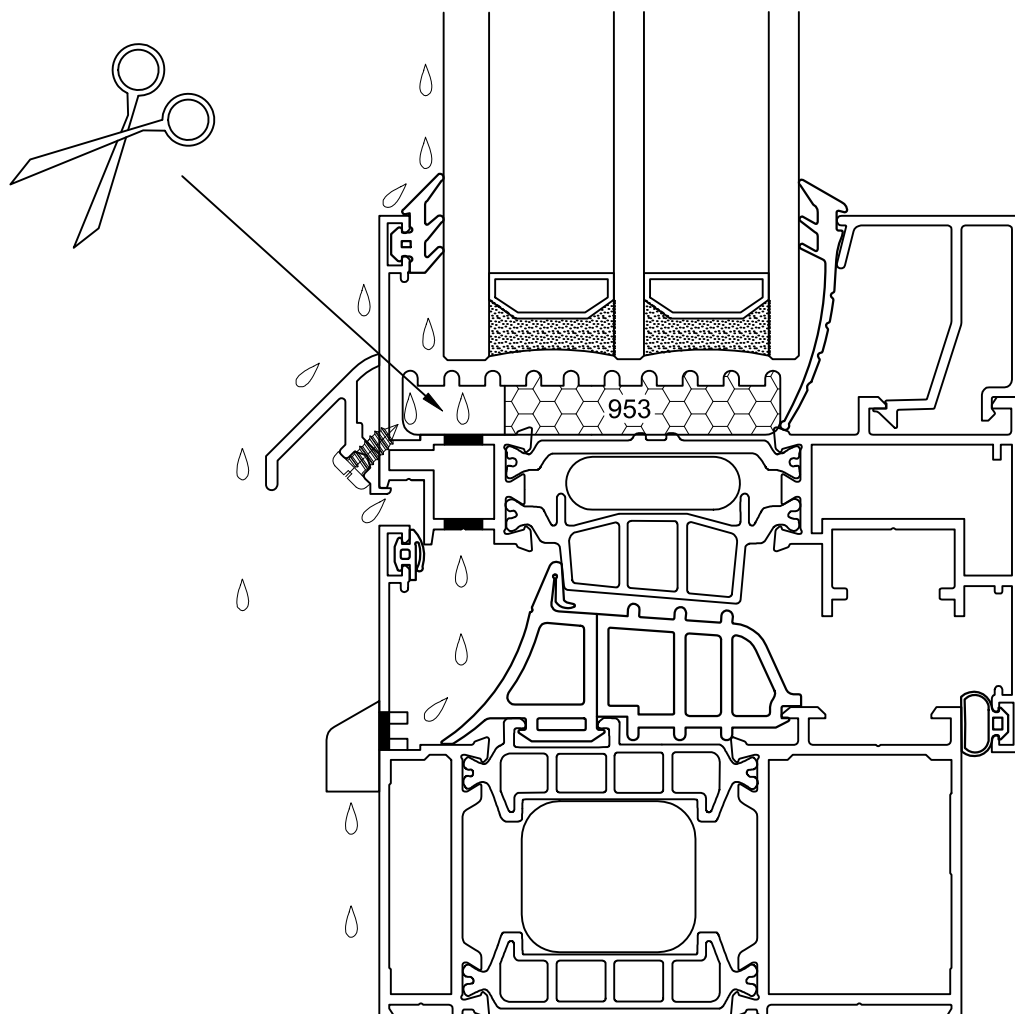
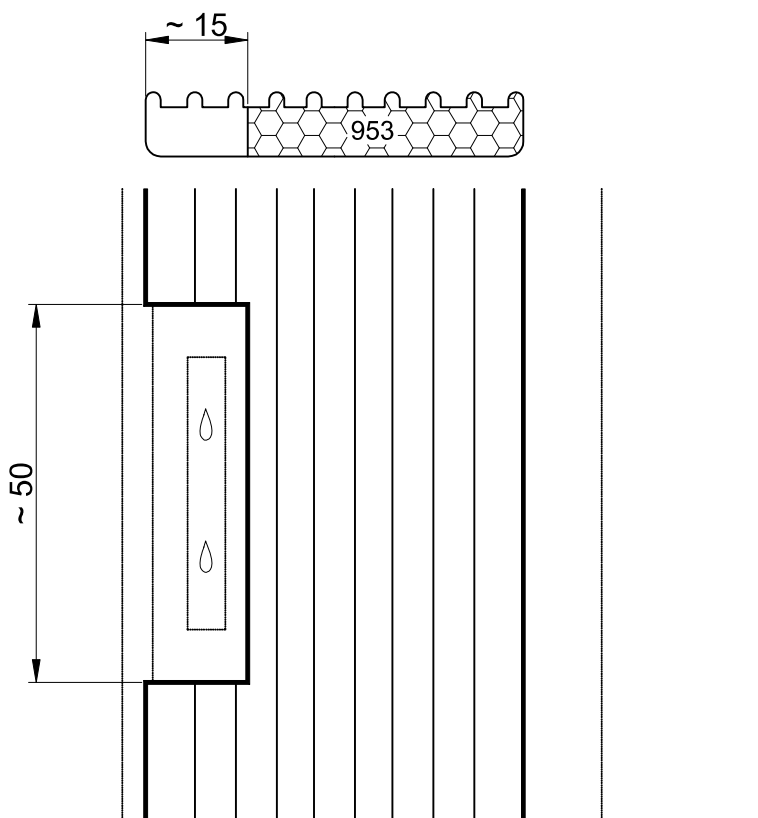
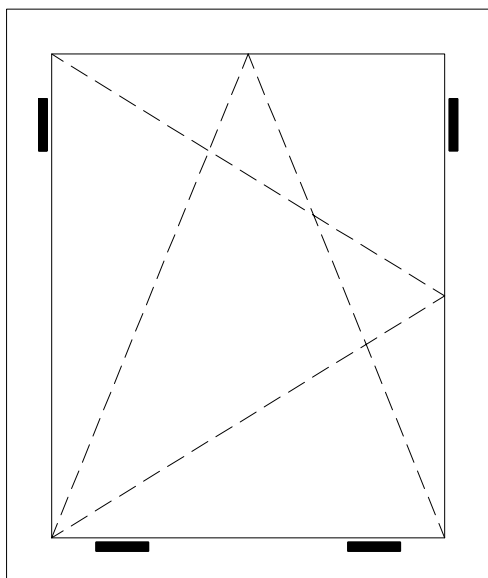
Ротосна радна
Additional rad
Остекление

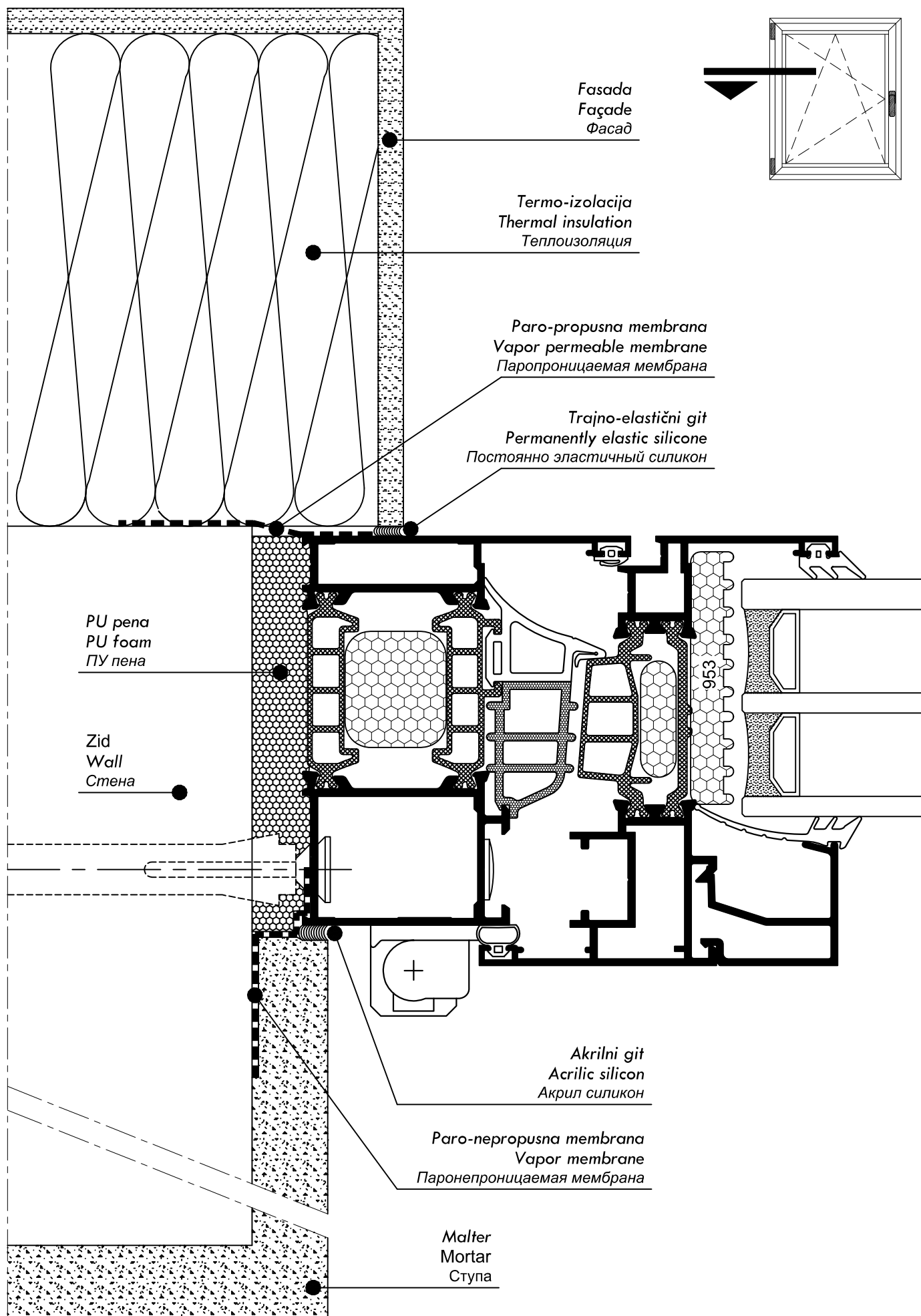


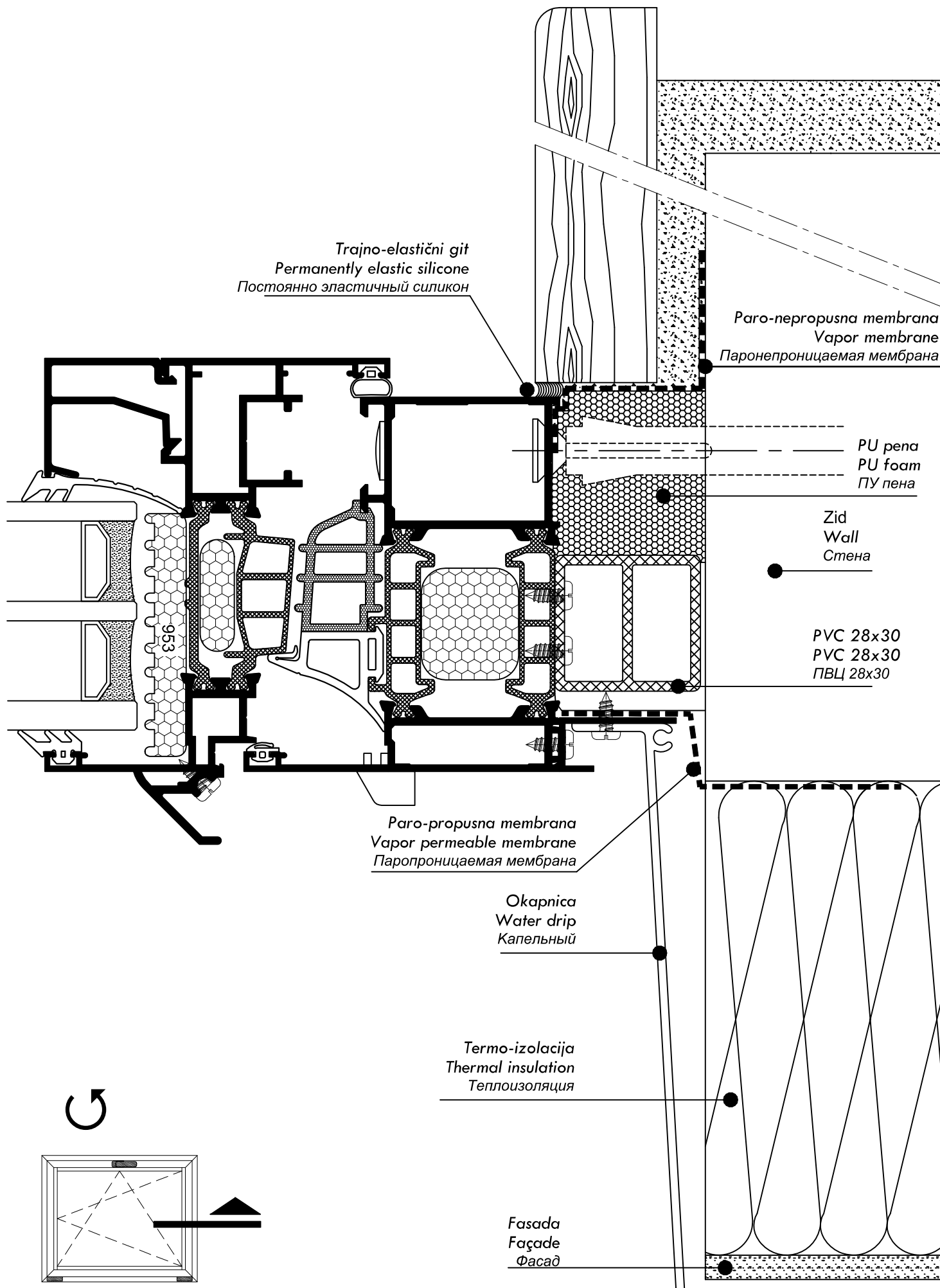
Основна радна
Main rad
Остекление



Drenaža i ventilacija krila
Casement drainage and ventilation
Дренаж и вентиляция оконной створки







Aluminijumski profili koji se proizvode u pogonu TEHNOMARKET-a dobijaju se postupkom ekstrudiranja, koji predstavlja jedan od postupaka obrade metala deformisanjem i podrazumeva kontinuirano istiskivanje termički pripremljene legure mehaničkom presom, kroz specijalno pripremljene matrice (alate) koje definišu geometriju preseka profila. Kao sirovina za izradu aluminijumskih profila koristi se legura na bazi primarnog aluminijuma AlMgSi0.5 (po DIN-u) koja odgovara oznakama AA6063 i AA6060 (po američkom standardu). Proces ekstrudiranja obavlja se na presi američke proizvodnje BLH kapaciteta 2000 tona sa kontrolisanim procesom rada.

VRSTE PROFILA

Imajući u vidu osnovnu namenu, aluminijumski profili su podeljeni u tri osnovne grupe:

- standardni (trgovački) - profili standardnog oblika kao što su „L“, „T“, „U“ i „U“ profili, kutijasti profili, cevi i ostali
- arhitektonski - profili koji se koriste za izradu aluminijumske bravarije, prozora, vrata, fasada, podkonstrukcije i slično
- industrijski (uslužni) - profili koji se koriste za specifične potrebe naručioca u različitim granama industrije i zanatstva.

MEHANIČKA SVOJSTVA PROFILA

Nakon ekstruzije profili se po pravilu, dodatno termički tretiraju u peći za homogenizaciju postupkom takozvanog starenja, koji obezbeđuju deklarirana mehanička svojstva. Veštačko starenje obezbeđuje površinsku tvrdoću od oko 80HB, kao i zateznu čvrstoću profila koja se kreće u opsegu od 220 do 250Mpa. Takođe, po zahtevu kupca, u u cilju dalje mehaničke obrade, profili mogu biti isporučeni bez prethodnog postupka homogenizacije u vidu nestarenih profila.

POVRŠINSKA ZAŠTITA

Profili dobijeni postupkom ekstrudiranja, a bez dalje površinske zaštite spadaju u kategoriju sirovih. Profili sa naknadno obavljenom površinskom zaštitom nude se u dve osnovne kategorije završne obrade:

- eloksirani - profili sa zaštitom putem elektrolitičke anodne oksidacije ili takozvane eloksaže
 - plastificirani - profili sa površinskom zaštitom putem postupka elektrostatske pulverizacije ili takozvane plastifikacije, u bojama prema RAL ton karti
- TEHNOMARKET obezbeđuje kvalitet profila sa površinskom zaštitom u skladu sa važećim standardima SRPS EN ISO 7599 (za postupak anodne oksidacije aluminijuma i legura aluminijuma) i SRPS EN 12206 (za postupak plastifikacije).

Tehnomarket's aluminium profiles are manufactured using extrusion, a mechanical deformation process that uses mechanical force to push thermally treated aluminium alloy through specially prepared dies that define profile geometry. Only primary aluminium derived alloy AlMgSi0.5 (according to DIN standard) or AA6063 and AA6060 (according to american standards) is used in production of our profiles. Extrusion is done with american-made press BHL with 2000 ton capacity and numerically controlled processes.

PROFILE CATEGORIES

Based on their use, aluminium profiles can be classified in three basic groups:

- standard (commercial) general use profiles like „L“, „T“, „U“ and various square, round and other shapes
- architectural profiles used for manufacturing of aluminium doors, windows, facades and light substructures
- industrial (custom) profiles manufactured according to client supplied drawings for use in various industrial and commercial branches

MECHANICAL PROPERTIES

After extrusion, profiles are generally heat treated in aging oven, in order to obtain desired mechanical properties defined by alloy used in extrusion process.

Artificial aging provides surface hardness of around 80HB, and tensile strength in range from 220 to 250Mpa.

Profiles can also be supplied without heat treatment as unaged and raw for various uses that commend this type of profiles.

SURFACE TREATMENT

Extruded profiles without surface coating are considered raw. There are two types of additional surface coating:

- anodisation profiles are protected by means of electrolytic anode oxidation (or simply anodisation)
- powder coated profiles are painted by electrostatic pulverization (powder coating) in any of RAL colors

Tehnomarket provides quality coated aluminium profiles in all according to current standards as SRPS EN ISO 7599 for anodisation and SRPS EN 12206 for powder coating.

Алюминиевые профили, которые производятся в цехе ТЕХНОМАРКЕТ-а получают способом экструзии, который является одним из методов обработки металлов давлением и подразумевает непрерывное выдавливание термически подготовленных сплавов механическим прессом, через специально подготовленные матрицы (инструменты), которые определяют геометрию поперечного сечения профиля. В качестве сырья, для производства алюминиевых профилей, используются сплавы алюминия AlMgSi0.5 (согласно DIN-у), который отвечает обозначениям AA6063 и AA6060 (по американскому стандарту). Процесс экструзии осуществляется на прессе американского производства BLH, мощностью в 2000 тонн с возможным контролем процесса работы.

ВИДЫ ПРОФИЛЯ

Принимая во внимание основную цель, алюминиевые профили разделены на три основные группы:

- стандартные (коммерческие) профили стандартных форм, таких как „L“, „T“ и „U“ профили, коробчатые профили, трубы и другие
- архитектурные - профили, которые используются для производства алюминиевых аксессуаров, дверей, окон, фасад, субконструкции и т. д.
- промышленные (специальные) - профили, которые используются для конкретных потребностей клиентов в различных отраслях промышленности и ремесел.

МЕХАНИЧЕСКИЕ СВОЙСТВА ПРОФИЛЕЙ

После экструзии, профили, как правило, дополнительно подвергаются термообработке в печи для гомогенизации, способом так называемого процесса старения, которым обеспечиваются декларируемые механические свойства. Искусственное старение обеспечивает поверхностную твердость от приблизительно 80HB, а также прочность на разрыв профиля, который находится в диапазоне от 220 до 250Mpa. Также, по просьбе заказчика, в целях дальнейшей механической обработки, профили могут быть доставлены без предварительного процесса гомогенизации, в форме профилей которые не были подвергнуты процессу старения.

GEOMETRIJA PROFILA

Геометрија профила дефинише се техничким цртежима који служе за израду матрица. Тачност израде матрица и профила, односно дозвољене толеранције, дефинисане су серијом стандарда SRPS EN 755, према коме се и врши унутрашња контрола квалитета екструдираних профила.

NARUČIVANJE PROFILA

Наручивање и куповина профила врши се преко Службе задужене за продају профила у оквиру фирме TEHNOMARKET. Ваžno је да Порудбенице купца садрже следеће податке како би што прецизније дефинисали тип и категорију потребних профила:

- каталошка ознака, тачан назив или детаљан опис профила који би требало да послужи да се идентификује потребни профил
- дужина шипки у којој је потребно испоручити профиле
- стандардна дужина шипки је 6м, на специјалан захтев, уз посебне услове и поједина ограничења, могу се испоручити и профили других дужина
- врста и ознака боје површинске заштите неопходно за оба типа: елоксажу и пластификацију профила уколико површинска заштита није потребна, Порудбина дефинише потребне профиле као сирове
- количину профила, било у броју шипки дефинисане дужине, укупној дужини или тежини профила

PROFILE GEOMETRY

Profile geometry is determined through technical drawings for extrusion matrix/die. Matrix precision is defined with series of standards SRPS EN 755. The same set of standards is also used as benchmark for internal Quality Control.

PROFILE ORDERING

Placing orders and purchasing is handled through corresponding Sales department within company. It is important that Purchase orders contain all relevant information in order to appropriately define following:

- catalogue designation, exact name or detailed description of profile
- bar length required (please note that standard bar length is 6m)
- type and color code for surface coating mandatory for both types of surface coating
- quantity, whether in bar number, total required length or total weight

Please take notice that the technical documentation quotes theoretical profile weight and that the real weights are often different. This is standard and completely normal due to die wear during its life span and extrusion process. Allowed tolerances are up to +10% over theoretical weight. The minimum order quantity for standard commercial and architectural profiles from TEHNOMARKET's product range is one standard bar of 6m.

ЗАЩИТА ПОВЕРХНОСТИ

Профили, полученные процессом экструзии, а без дополнительной защиты поверхности, входят в категорию сырых. Профили с последующей сделанной защитой поверхности, предлагаются в двух основных категориях окончательной обработки:

- анодированные-профили защищенные способом электролитического анодного окисления или так называемого анодирования.
- пластифицированные - профили с защитой поверхности способом электростатического распыления или так называемой пластификации, в гамме цветов системы RAL. TEHNOMARKET обеспечивает качество профилей с защищенной поверхностью в соответствии с действующими стандартами SRPS EN ISO 7599 (для процедуры анодного окисления алюминия и алюминиевых сплавов) и SRPS EN 12206 (для процесса пластификации).

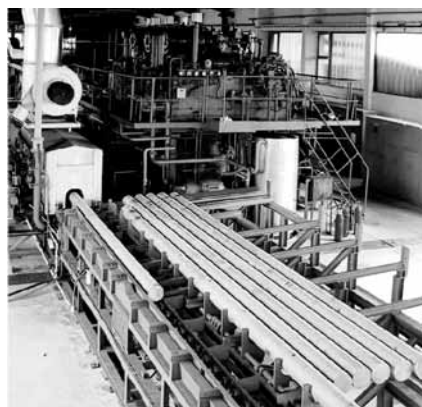
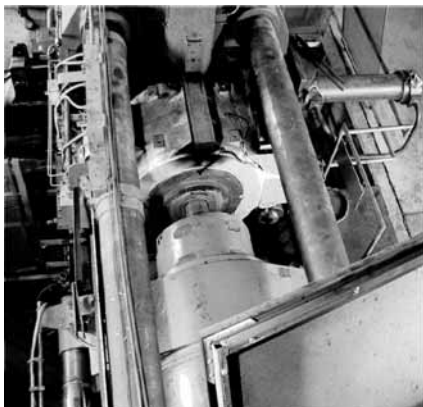
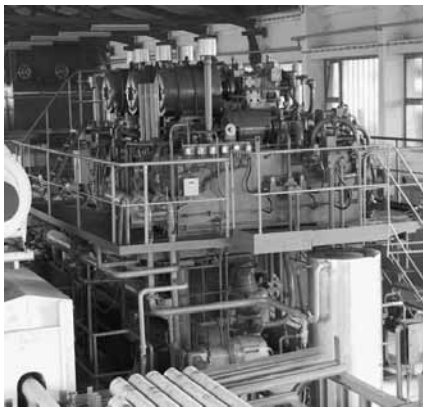
ГЕОМЕТРИЯ ПРОФИЛЯ

Геометрия профиля определяется в соответствии с техническими чертежами, которые используются для выработки матриц. Точность выработки матриц и профилей, т.е. разрешенные допуски, определены в серии стандартов SRPS EN 755, в соответствии с которыми и выполняется внутренний контроль качества экструдированных профилей.

ЗАКАЗЫВАНИЕ ПРОФИЛЯ

Заказывание и покупка профилей, производится через Службу по продажам профилей в компании TEHNOMARKET. Важно, чтобы заказ клиентов включал следующие данные, для того, чтобы более точно определить тип и категорию требуемого профиля:

- знак в каталоге, точное название или подробное описание профиля, который должен быть использован для идентификации требуемого профиля
- длина стержня, в которой необходимо поставить профили - стандартная длина стержней - 6м, по специальному запросу, со специальными требованиями и некоторыми ограничениями могут поставляться и профили другой длины
- тип и цветовой код защиты поверхности - необходимо для обоих типов: анодированных и пластифицированных профилей, если защита поверхности не нужна, заказ определяет нужный профиль как сырой
- количество профилей - количество стержней определенной длины, или совместной длины, или весу профилей.



Prilikom naručivanja profila potrebno je imati na umu da su u katalogima dati podaci o teorijskim težinama profila i da specifične težine po jednom metru, često ne odgovaraju stvarnim težinama profila. Ovo je posledica standardnog procesa ekstrudiranja i uobičajenog habanja matrica. Dozvoljene tolerancije su + 10% u odnosu na teorijske težine. Za standardne trgovačke profile kao i arhitektonske profile iz programa TEHNOMARKET-a, minimalna količina za narudžbu je jedna šipka standardne dužine od 6.0m. Minimalna količina za porudžbinu industrijskih - uslužnih profila je 500kg po matrici, a na poseban zahtev kupca i uz posebne komercijalne uslove, mogu se prihvatiti i manje narudžbe (ne manje od 200kg po matrici).

Prilikom isporuke profili se isporučuju sečeni na šipke, u dve kategorije sečenja profila:

- grubo sečenje - sečenje profila na liniji za ekstrudiranje koje se vrši pre postupka starenja profila sa tačnošću od +/-15mm. Minimalna dužina profila koja se postiže grubim sečenjem profila je 2m.
- sečenje na preciznu meru - ukoliko naručilac zahteva isporuku profila kraćih od 2m kao i u situacijama kada se traži precizno sečenje tačnosti +/- 1 mm vrši se naknadno sečenje tj. nakon postupka starenja.

Maksimalna dužina profila je ograničena dužinom peći za starenje i ona iznosi 7,5m što je ujedno maksimalna dužina za sirove i eloksirane profile. Za plastificirane profile maksimalna dužina je ograničena uobičajenim dužinama komora za plastifikaciju i ona iznosi 6,5m.

Minimal order quantity for custom extruded profiles is 500kgs per die, and for some specific circumstances and sales terms, smaller quantities may be ordered (but never less than 200kgs per die)

Finished profiles are delivered cut to size, in two distinct categories:

- rough cutting the profile is cut directly on the extrusion line, prior to artificial aging, with precision of +15mm. Minimal length of profiles in this category is 2m.
- precise cutting if the client requires profiles shorter than 2m, and in situations where precision of +1mm is needed, additional precision cutting is done after heat treatment of profiles.

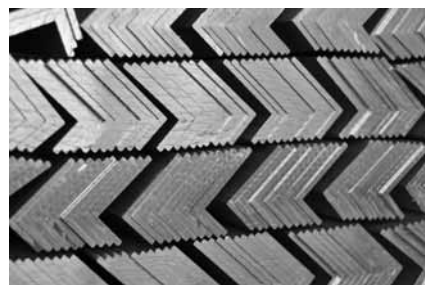
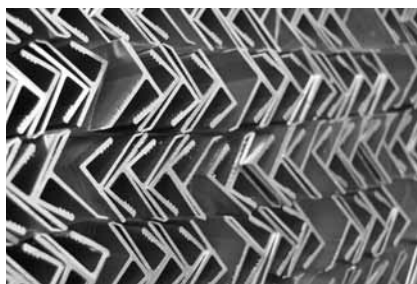
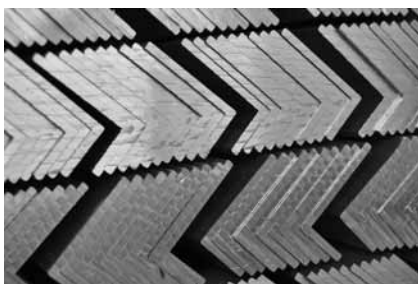
The maximal profile length available for purchase is limited by aging oven dimensions and it is 7,5m, which is also maximal bar length for raw and anodized profiles. The bar length for powder coated profiles is limited by powder coating chamber dimensions and it is usually 6,5m.

При заказе профиля, следует иметь в виду, что в каталогах представлены данные о теоретическом весе профилей, и что удельный вес на один метр часто не соответствуют фактическому весу профиля. Это является следствием стандартного процесса экструзии и нормального износа матриц. Допустимые допуски +10% по сравнению с теоретическим весом. Для стандартного коммерческого профиля как и архитектурные профили из продукции ТЕХНОМАРКЕТ, минимальное количество заказа - один стержень стандартной длины от 6.0м. Минимальное количество заказа для промышленных - специальных профилей - составляет 500кг по матрицы, а по специальному запросу покупателя и на специальных коммерческих условиях, могут быть приняты и более мелкие заказы (не меньше чем 200кг по матрицы).

При поставке, профили поставляются резанные на стержни, в двух категориях резки профилей:

- грубая резка - резка профиля на линии для экструзии, которая делается до поступка старения профиля с точностью от ± 15 мм. Минимальная длина профиля, которая достигается грубой резкой профиля - 2м.
- резка в размер - если заказчик требует доставку профиля короче чем 2м, как и в ситуациях когда требуется прецизионная точность реза ± 1 мм, делается дополнительная резка, т.е. резка после процесса старения.

Максимальная длина профиля ограничивается длиной печи для старения, а это 7,5м, в тоже время и максимальная длина для сырого и анодированного профиля. Для пластифицированных профилей максимальная длина ограничена длиной камеры для пластифицирования, и составляет 6,5м.



Nakon završenog procesa ekstrudiranja, starenja profila i kontrole kvaliteta gotovih proizvoda, aluminijumski profili se sladište u namenski pripremljenim policama na način koji obezbeđuje međusobno razlikovanje grupe i tipa profila. Od daljeg postupka obrade i površinske zaštite zavisi dalja priprema i skladištenje, kao i pakovanje i transport.

SIROVI profili smatraju se najmanje zaštićenim, jer poseduju samo sloj prirodne oksidacije, tako da su osetljivi na koroziju, atmosferske uticaje, pa čak i na manju mehaničku silu. Preporuka je da se kod ovog tipa profila izbegava dug period skladištenja. Skladišteni prostor mora biti suv i ventiliran, bez direktne izloženosti suncu, kako bi se sprečila pojava kondenza po površini profila.

Pakovanje za isporuku isključivo mora biti u neutralnu perforiranu foliju ili u odgovarajući PH neutralni papir bez boje. Važno je međusobne dodirne površine svesti na najmanju moguću meru, da bi se izbeglo trenje kao i zarobljavanje kondenza. Profili bez površinske zaštite nipošto se ne smeju ovlaženi zamotavati u folije, jer takav način pakovanja prouzrokuje koroziju površine, koja potpomognuta sunčevim zracima može nastati u veoma kratkom roku.

ELOKSIRANI profili usled hemijskog tretmana površine imaju na sebi veći sloj zaštite, ali način pakovanja i skladištenja se bitno ne razlikuje od sirovih profila. Kod ovako tretirane površine, profili se moraju čuvati na suvom, zasenčenom i provetrenom mestu, upakovani u posebne folije ili papir. Eloksova je posebno osetljiva na hemijske uticaje i mikro oštećenja. Iz ovog razloga važno je dobro zaštititi profile u agresivnim sredinama i obezbediti da ne budu izloženi manjim mehaničkim udarima, pomeranjima i međusobnom trenju.

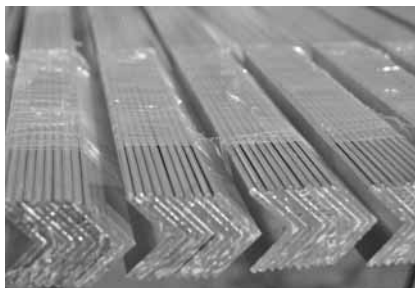


After extrusion, ageing and final quality control, aluminium profiles are stored on a special, custom made shelves that allow separation between different groups and profile types in the warehouse. Further preparation, storage, packaging and transport are different for each of available surface treatments.

RAW profiles are considered least protected, because they carry only a natural oxidative layer on the surface, making them susceptible to corrosion, atmospheric influences, even to a lesser mechanical force. It is recommended to avoid long storage periods with raw aluminium profiles. The storage space must be dry and ventilated, without direct sunlight exposure, in order to prevent surface condensation on the profiles.

Packaging for delivery is done exclusive with neutral, perforated foil or appropriate PH neutral, non-colored paper. It is important to minimize contact surfaces between profiles in order to avoid friction and capture of condensation. Profiles without any surface treatment should never be foil-wrapped while wet, because wrapping speeds up the corrosion process, that can occur in a very short time, especially when exposed to direct sun.

ANODIZED profiles are already better protected than the raw ones, but storage and packaging are not very different than previous group. This type of surface treatment requires dry, ventilated storage without direct sunlight, and profiles have to be wrapped in protective foil. Anodization is especially sensitive to chemical and mechanical influences and susceptible to micro-damage. Therefore, it is recommended to thoroughly protect profiles in aggressive environments and exclude any possibility of mechanical damage due to impact, movement or friction.



После завершения процесса экструзии, старение (окончательная термообработка) профиля и контроля качества готовой продукции, алюминиевые профили хранятся на специально подготовленных стеллажах, по методу, который обеспечивает междусобное разделение групп и тип профилей. От дальнейшей процедуры обработки и поверхностной защиты, зависит и дальнейшая подготовка и хранение, а также упаковка и транспортировка.

СЫРЫЕ профили считаются меньше всего защищенными, потому что они имеют слой естественного окисления, чувствительны к коррозии, к воздействию окружающей среды, и даже на маленькую механическую силу. Рекомендуется, чтобы для этого типа профилей должен избегаться длительный срок хранения. Складское помещение должно быть сухим и проветриваемым без прямых солнечных лучей, чтобы предотвратить возникновение конденсата на поверхности профиля.

Упаковка для поставки, исключительно должна быть только в нейтральной перфорированной пленке или в соответствующей pH безцветной нейтральной бумаги. Важно, чтобы взаимные контактные поверхности были сведены к минимуму, во избежание трения и захвата конденсации. Профили без обработанной поверхности, ни в коем случае не должны быть завернуты в фольгу влажными, потому что такая упаковка вызывает коррозию поверхности, которая поддерживаемая солнечным светом может настать в очень короткий срок.

АНОДИРОВАННЫЕ профили, ввиду химической обработки поверхности, имеют на себе больший слой защиты, но метод упаковки и хранения существенно не отличается от метода для сырых профилей. Профили, поверхности которых обработаны этим методом, должны храниться в сухом, без прямых солнечных лучей и проветриваемом месте, упакованы в специальную фольгу или бумагу. Анодирование особенно чувствительно к химическим воздействиям и микроповреждениям. По этим причинам, необходимо хорошо защитить профили в агрессивных окружениях и предохранить их, чтобы они не подвергались механическому воздействию, движению и взаимному трению.

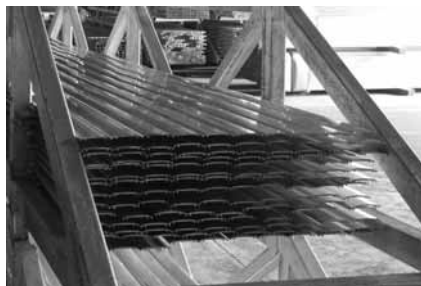
PLASTIFICIRANI profili su svojom površinom koja ima nanet zaštitni sloj boje, otporniji od sirovih i eloksiranih profila. Njihova osjetljivost je daleko manja po pitanju zahtevanih uslova skladištenja zbog pojačane otpornosti površine profila na vodu, vlagu i kondenz. Kod ove grupe bitno je da folija i papir kojim se pakuju ovi profili, budu neutralni i otporni na UV zrake, kako ne bi došlo do promene završne boje i pojave fleka. Plastifikacija bolje podnosi i mikro mehanička oštećenja, ali je i dalje osjetljiva na jače udare, tako da je bitno pravilno odlaganje u magacinske police i pakovanje profila u buntove.

Ono što je zajedničko za sva tri tipa profila je to da je obavezno skladištenje na suvom mestu, pri temperaturama koje ne variraju drastično i koje ne idu iznad 35°C, dok vlažnost vazduha ne bi trebalo da prelazi 65%. Preporučuje se da prostor ima visok nivo ventilacije i stalno prisutno kretanja vazduha.

Najpovoljnije odlaganje i čuvanje sva tri tipa profila je u zatvorenom magacinskom prostoru, dobro provetrenom, na posebno dizajniranim policama za slaganje šipki aluminijumskih profila.

Kako bi se izbegle deformacije potrebno je da svi profili budu u horizontalnom položaju, postavljeni na ravnu i stabilnu površinu, koja može biti puna ili u vidu rebara dovoljno gusto postavljenih kako bi se izbegla krivljenja po dužini. Težina, veličina i savitljivost profila diktiraju tip oslonca magacinskih policama i veličine krajnjih pakovanja.

Zbog sigurnosti i bolje zaštite, preporučuje se da transport profila bude zatvorenog tipa, sa čvrsto upakovanim profilima u buntove. Neophodno je da svi buntovi budu fiksirani za palete, kako bi se izbeglo pomeranje u toku transporta, a tim i ugrožavanje geometrije i krajnjeg kvaliteta površine.



POWDER COATED profiles are more resistant than raw and anodized ones. They are far less demanding in regard of storage conditions due to their good surface resistance toward water, humidity and condensation. It is important that wrapping foil or paper are neutral and UV resistant, in order to prevent change of surface color and appearance of stains. Powder coating is also more resistant to micro-damage, but they should still be protected from impact damage and properly packaged and stored on shelves.

What all three profile types have in common is need for dry, well ventilated and covered storage space, with relatively stable temperature not higher than 35°C and humidity below 65%.

Closed, specially designed and equipped warehouse is recommended for appropriate storage of all types of aluminium profiles.

To avoid profile deformation, it is recommended that they are placed horizontally, on flat, rigid surface that can be either a solid plate or a ribbed construction with small enough distance between individual ribs in order to keep profiles from deformation. Weight, size and flexibility of profiles dictates the type of storage shelves and final packaging size.

In order to insure safety and optimal protection, it is recommended that profiles are transported in an enclosed vehicle, securely wrapped in bundles. It is necessary that all bundles are safely attached to pallets to avoid possible damage of paint coat and profile geometry during transport due to unwanted movement.



ПЛАСТИФИЦИРОВАННЫЕ профили, на поверхность которых нанесен защитный слой краски, более устойчивые от сырых и анодированных профилей. Их чувствительность значительно меньше, с точки зрения требуемых условий хранения, в связи с увеличением сопротивления профиля к воде, влаге и конденсации. В этой группе важно, чтобы пленка и бумага, в которые упакованы эти профили, были нейтральными и устойчивы к воздействию ультрафиолетовых лучей, чтобы не произошли изменения в конечной окраски цвета и появления пятен. После пластификации, профили лучше переносят и микромеханические повреждения, но по-прежнему уязвимы на сильные удары, поэтому важное значение имеет правильное хранение на складских полках и упаковка профилей в пучки.

То, что является общим для всех трех типов профилей, обязательное складирование на сухом месте при температурах, которые резко не меняются, и не поднимается выше 35°C, а влажность воздуха не должна превышать 65%. Рекомендуется, чтобы в помещении был высокий уровень вентиляции и присутствие постоянного воздушного движения.

Самое лучшее складирование и хранение всех трех типов профилей в закрытом складском помещении, хорошо проветриваемом, на специальных разработанных полках для укладки стержней алюминиевых профилей.

Во избежании деформации профилей, необходимо чтобы все профили были в горизонтальном положении, положенные на плоскую и устойчивую поверхность, которая может быть целая или в виде достаточно плотных ребер, во избежаний искажений по длине профиля. Вес, размер и гибкость профилей определяться по типу складских полок и размеру готовой упаковки.

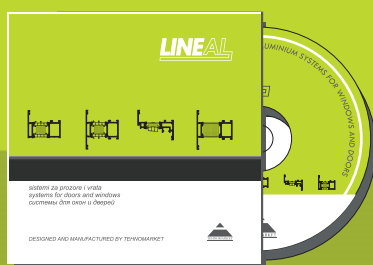
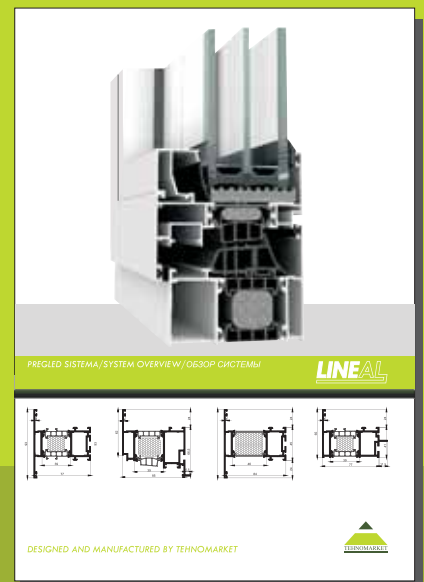
Для обеспечения безопасности и лучшей защиты, рекомендуется закрытый транспорт профилей, с плотно упакованными пучками профилей. Очень важно, чтобы все пучки были притянуты к поддону, с тем чтобы избежать смещения во время транспортировки, чтобы не поставить под угрозу геометрию и конечное качество поверхности.

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