

TECHNICAL DESCRIPTION

PRESS-LOCKED GRATINGS

Description:

Press-locked gratings are made according to DIN 24537-1.

Raw material (steel strips) is S235JR according to EN 10025.

Bearing bar $a \times b$ mm (with or without serration):

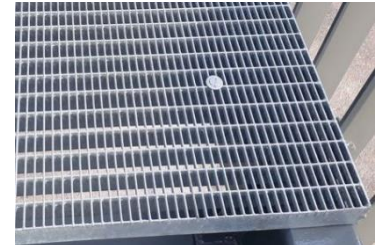
b (height) from 25 to 50mm;

a (thickness) from 2 to 5mm.

Secondary bar variable: 8x2, 10x2 or 10x3, 12x3mm.

Banding bar (closing strip) $a \times b$ mm or "T" profile for closing all around

Pitch (inter-ax dimensions) $c \times d$ mm



Press-locked gratings in raw material are produced with automated equipment at maximum dimension 2000x2000mm. From these panels we cut at required dimensions respecting the client's projects and weld the banding bars.

Usual pitch dimension is 33x33mm and gratings can be done in multiple of 11.11mm (ex: 33x11, 50x11, 22x22 etc.).

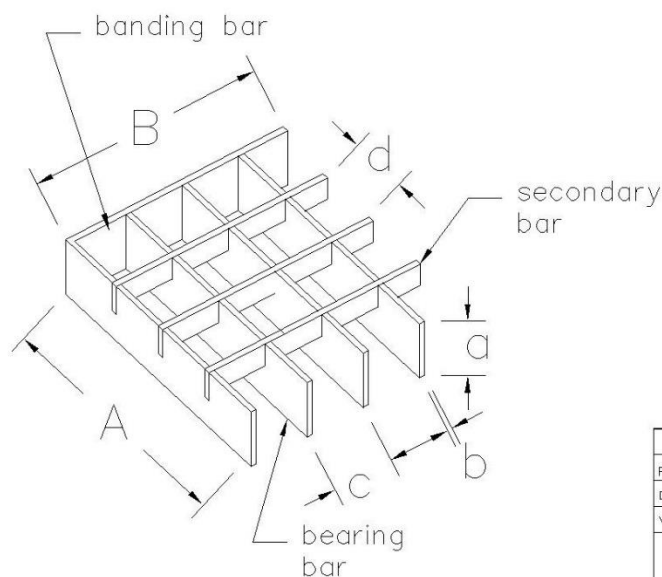
Tolerances for press-locked gratings are according to RAL GZ 638.

After gratings have reached his final form, they will be hot-dip galvanized according to ISO 1461.

CONSTRUCTION DRAWING

PRESS-LOCKED GRATING P (DIN 24537) with:

- bearing bar $a \times b$;
- secondary bar 10*2, 10*3 sau 12*3mm;
- pitch: $c \times d$
- maximum dimension 2000*2000mm.



	DATA	NUME	SEMNATURA	ASCO Industrial Gratings S.R.L.
PROIECTAT	06.2018	S.G.		
DESEANAT	06.2018	S.G.		
VERIFICAT	06.2018	S.G.		
PROIECT :				DESEN NR
				FORMULAR A -SCD-011

FISA TEHNICA

GRATARE PRESATE

Descriere:

Gratarele presate sunt executate conform cu DIN 24537-1.
Materia prima (platbenzi metalice) este din S235JR conform cu standardul EN 10025.

Platbanda de rezistenta $a \times b$ mm (cu sau fara zimtare):

b (inaltime) de la 25 pina la 50mm;

a (grosime) de la 2 pina la 5mm.

Bara secundara variaza: 8x2, 10x2 sau 10x3, 12x3mm.

Platbanda de inchidere grosime 3 mm sau Profil "T" pentru bordare.

Dimensiuni inter-ax $c \times d$ mm



Gratarele presate din otel brut sunt produse cu un echipament automat pana la dimensiunea maxima de 2000x2000mm. Din aceste panouri se taie la dimensiunile cerute respectand proiectul clientului si se vor borda cu profil T sau cu platbanda prin sudura.

Interaxul uzual pentru aceste gratare este 33x33mm. Gratarele pot fi executate cu interax modul de 11.11mm (ex: 33x11, 50x11, 22x22 etc.)

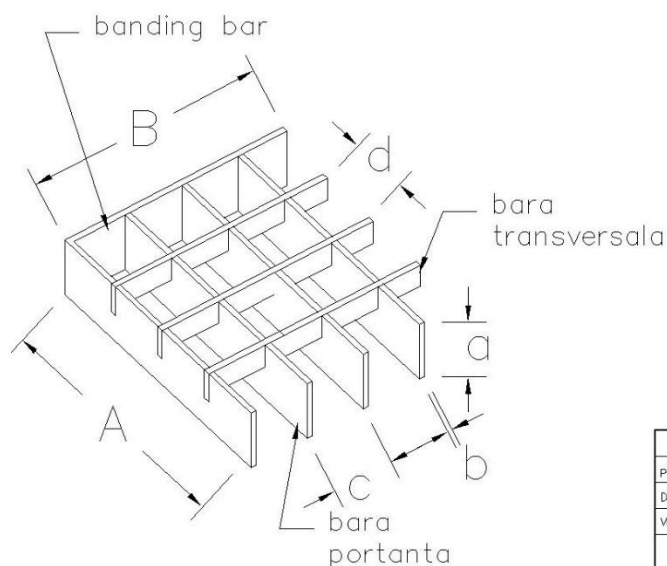
Tolerantele pentru gratare presate respecta RAL GZ 638.

Dupa ce gratarele ajung la forma finala, acestea vor fi zincate la cald conform ISO 1461.

DESEN DE EXECUTIE

GRATAR PRESAT P (DIN 24537) cu:

- platbanda de rezistenta $a \times b$;
- bara transversala platbanda 10*2, 10*3 sau 12*3mm;
- interaxe: $c \times d$
- dimensiune maxima 2000*2000mm.



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