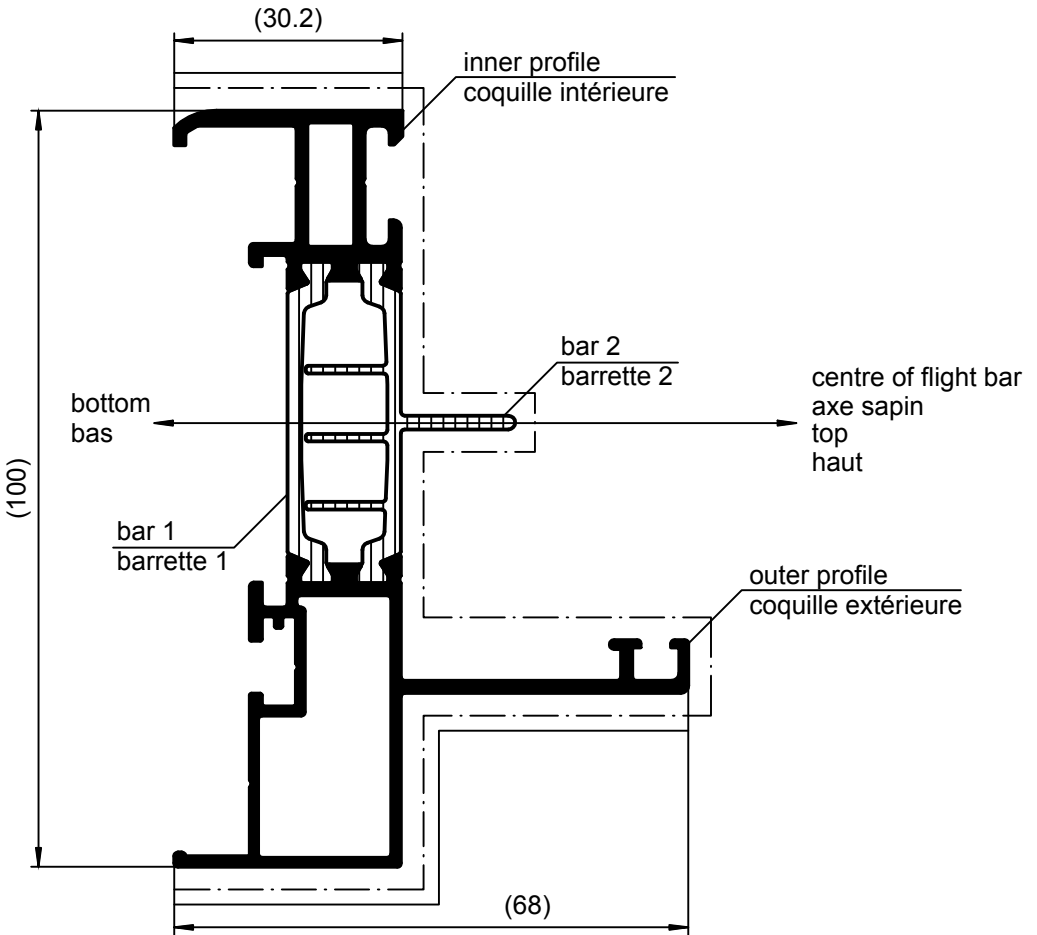




Coating:

Profiles to be coated preferably in vertical position.

In general, the profiles must be jigged, without bow or twist, in both aluminium hollow chambers.

The temperature must not exceed 180°C.

Failure to observe this maximum temperature may result in the profiles being out of square.

Anodising:

In general, the profiles must be jigged, without bow or twist, in both aluminium hollow chambers.

After desmitting and pickling,

the profiles must be rinsed repeatedly until the rinsing water is clean.

Laquage :

Profilés à laquer de préférence en position verticale.

La mise hors tension des 2 coquilles Alumunium doit se faire de manière progressive.

La température du profil ne doit en aucun cas dépasser 180°.

Ne pas respecter ces recommandations risque de provoquer une déformations des demi-coquilles.

### Anodisation :

La mise hors tension des 2 coquilles Alumunium doit se faire de manière progressive.

L'opération de lavage après décapage doit se poursuivre jusqu'à obtention d'une eau parfaitement propre.

|                                           |  |                                               |  |                                                                                     |                                        |                                        |                       |                           |       |                                                                                         |  |                                  |  |
|-------------------------------------------|--|-----------------------------------------------|--|-------------------------------------------------------------------------------------|----------------------------------------|----------------------------------------|-----------------------|---------------------------|-------|-----------------------------------------------------------------------------------------|--|----------------------------------|--|
| L [m]                                     |  | Assemlby /<br>Assemblage                      |  | inner profile /<br>coquille intérieure                                              |                                        | outer profile /<br>coquille extérieure |                       | bar PA1 /<br>barrette PA1 |       | bar PA2 /<br>barrette PA2                                                               |  |                                  |  |
| 6,5                                       |  | 475940                                        |  | 478830                                                                              |                                        | 478770                                 |                       | 278099                    |       | 278095                                                                                  |  |                                  |  |
|                                           |  | Zulässige Abweichung<br>Permissible tolerance |  |                                                                                     | Oberflächenabwicklung<br>Circumference |                                        | VP<br>PU              |                           |       |                                                                                         |  |                                  |  |
|                                           |  |                                               |  |                                                                                     | mech.<br>polished                      |                                        | 122                   |                           |       |                                                                                         |  |                                  |  |
|                                           |  |                                               |  |                                                                                     | uml.<br>total                          |                                        | 388                   |                           |       |                                                                                         |  |                                  |  |
| Paßmaße<br>Close tol.                     |  |                                               |  |                                                                                     | Abmaße<br>Std. tolerance               |                                        | beschichtet<br>coated |                           | — - — |                                                                                         |  |                                  |  |
| Original / Änderung<br>Revision / Version |  |                                               |  | 0302                                                                                |                                        |                                        | Datum<br>Date         |                           | Name  |                                                                                         |  |                                  |  |
| Name                                      |  |                                               |  |                                                                                     |                                        | 23.07.2015                             |                       |                           |       |                                                                                         |  |                                  |  |
| Länge geändert                            |  |                                               |  | gez.<br>drawn                                                                       |                                        | Schade                                 |                       |                           |       |                                                                                         |  |                                  |  |
|                                           |  |                                               |  | gepr.<br>checked                                                                    |                                        | Cengiz                                 |                       |                           |       |                                                                                         |  |                                  |  |
|                                           |  |                                               |  | ges.<br>seen                                                                        |                                        | Lückingsmeier                          |                       |                           |       |                                                                                         |  |                                  |  |
|                                           |  |                                               |  |  |                                        |                                        |                       |                           |       | Zeichn.-Nr.<br>Drawing No.                                                              |  | 475940_BP_0000                   |  |
|                                           |  |                                               |  |                                                                                     |                                        |                                        |                       |                           |       | EDV erstellt<br>Ohne Unterschrift gültig<br>generated by EDP<br>valid without signature |  | Ersatz für<br>Replacement<br>for |  |
|                                           |  |                                               |  |                                                                                     |                                        |                                        |                       |                           |       |                                                                                         |  |                                  |  |
|                                           |  |                                               |  |                                                                                     |                                        |                                        |                       |                           |       |                                                                                         |  |                                  |  |
|                                           |  |                                               |  |                                                                                     |                                        |                                        |                       |                           |       |                                                                                         |  |                                  |  |