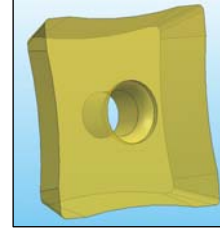
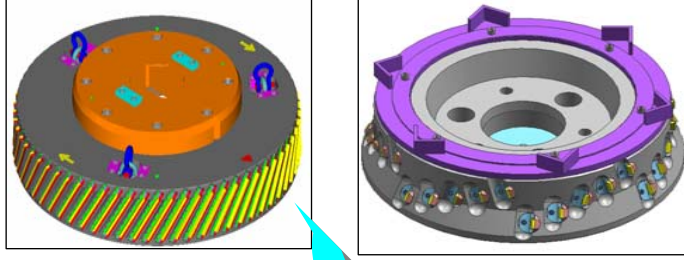


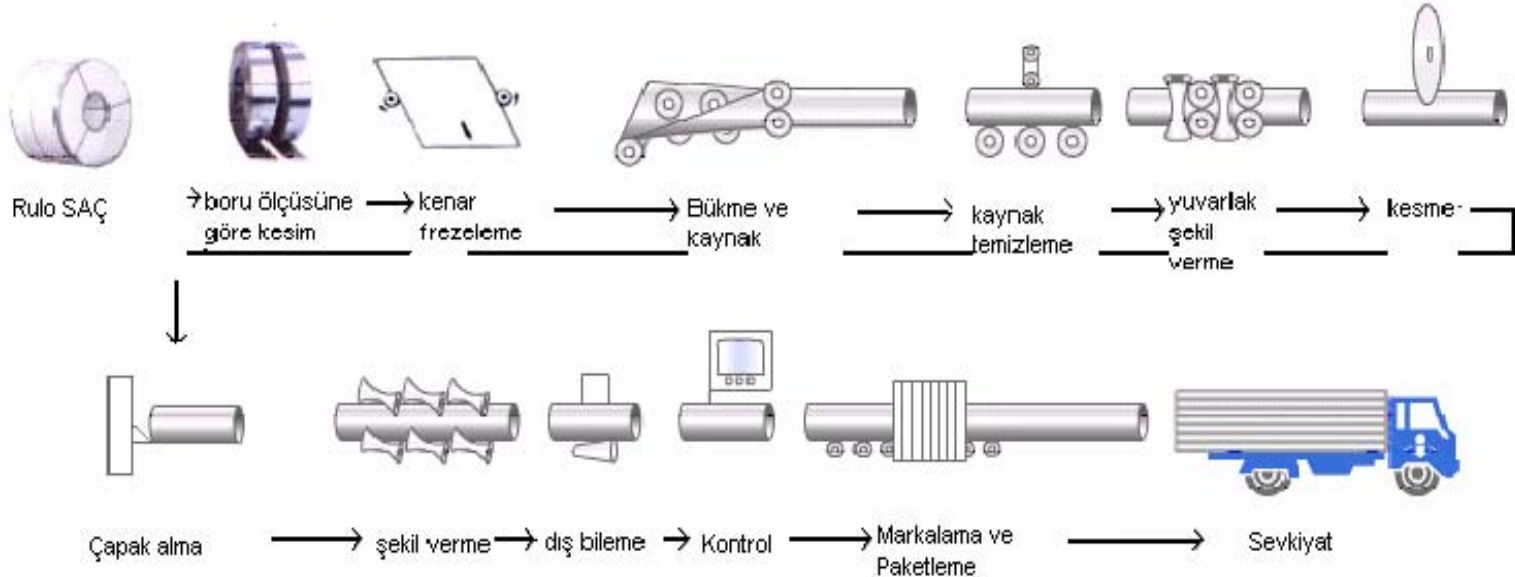
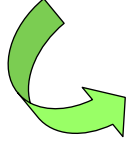
ERW Boru Üretiminde Verimli Çözümler

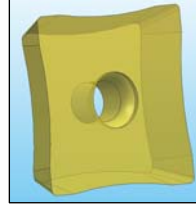
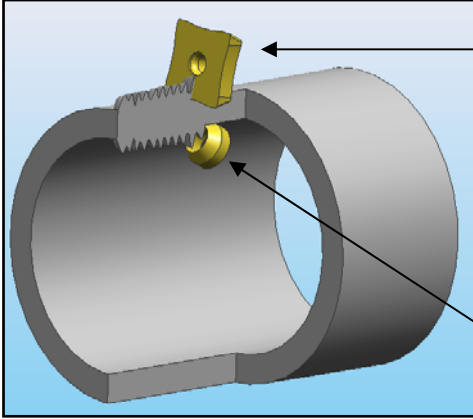


BORU üretim hattı

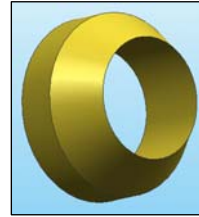


METAL TESTERE

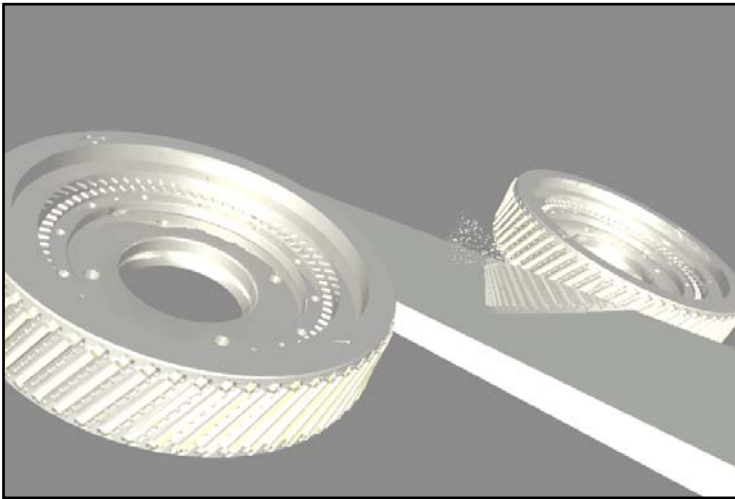




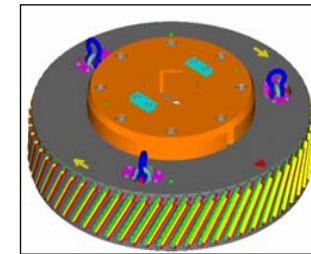
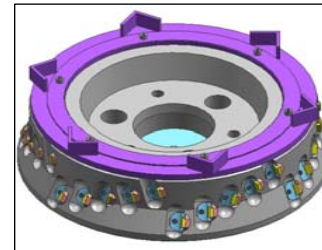
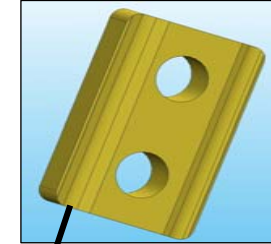
**BORU dış çap
kaynak üstü temizleme**



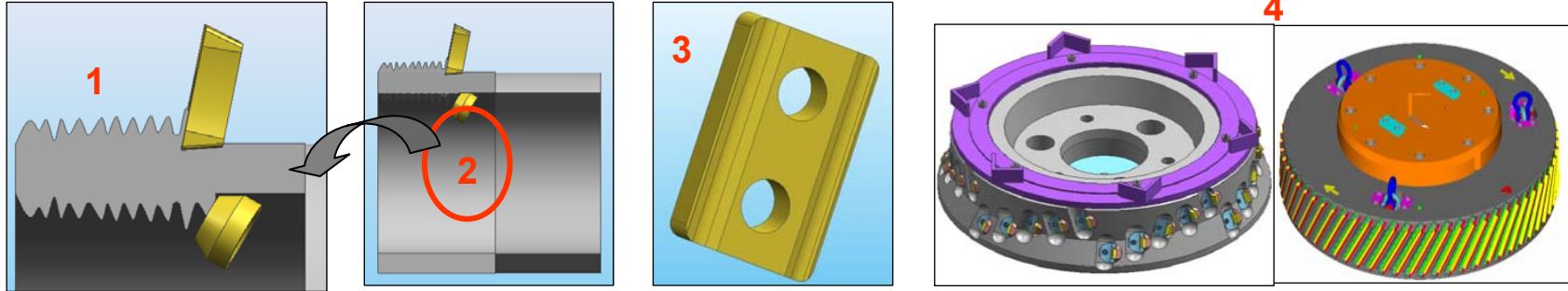
**BORU iç çap
Kaynak üstü temizleme**



Çapak alma

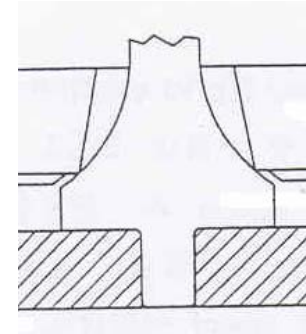
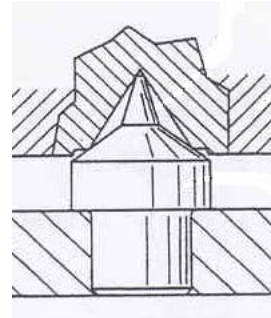
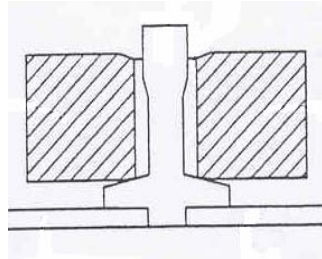
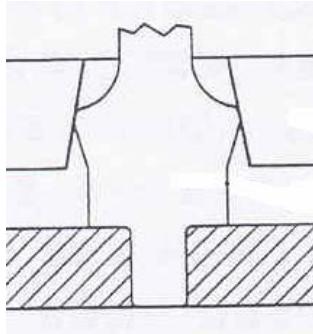


Boru İşleme Uçları

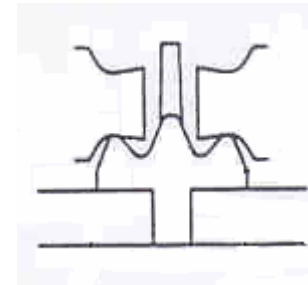
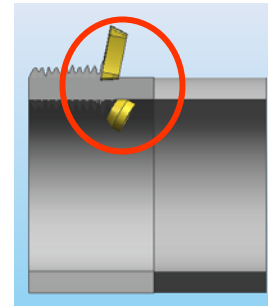
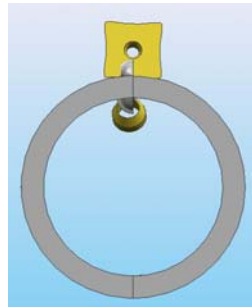
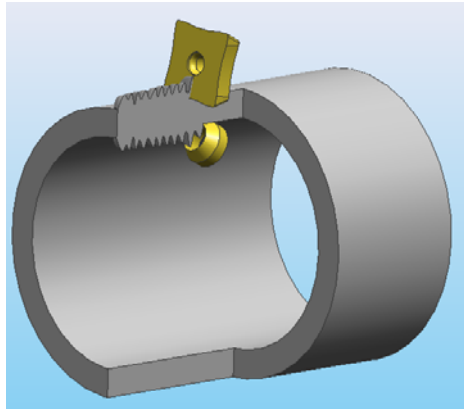


Kesme parçası	Kullanılacak Uç	Takım
① Boru kaynak Üstü temizleme Uçları (dış çap için)	SDMX85 - R__ / SEGW54 - R__ SNMG 150708 - R__ / SNMN1207(SUN452)-__R SNMN 1507 (SUN552) - __R SOET1906-254 / SEGX2509-__	Özel yapım
② Boru kaynak Üstü temizleme (iç çap için)	AR__ - __ SF__R - __.	
③ Boru Kaynak Ağızı Açma Uçları	LNMG 400924/ LNUX 400924 / LNUX500924 SNMG250616 / TNMG440912Z / CNHQ1606	
④ Kenar İşleme Uçları	SNMG190608/ SNMN250716/ SOCX2010-__ LNEN160604 / LNUX501224-__ / LOCX3010Z LOCX4010Z / SOCX1810ZZ / LNMN500604	

■ BORU işleme uçları.

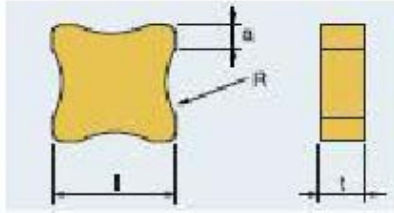


①



Boru Dış Çap Kaynak Üstü Temizleme Uçları

SNMN

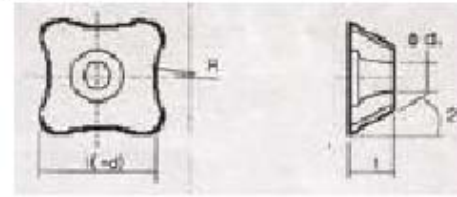


Kaplama: NC3030

Kod	R	l(=d)	t
SNMN1207-10R	10	12,7	7,94
SNMN1207-12R	12		
SNMN1207-16R	16		
SNMN1207-18R	18		
SNMN1207-20R	20		
SNMN1207-30R	30		
SNMN1207-35R	35		
SNMN1207-40R	40		
SNMN1207-45R	45		
SNMN1207-50R	50		
SNMN1207-60R	60		
SNMN1207-70R	70		
SNMN1207-80R	80		
SNMN1207-90R	90		
SNMN1207-100R	100		
SNMN1507-40R	40	15,875	7,94
SNMN1507-50R	50		
SNMN1507-60R	60		
SNMN1507-70R	70		
SNMN1507-80R	80		
SNMN1507-100R	100		
SNMN1507-120R	120		

SNMN Boru Radüs Seçimi		
Boru Çapı		Önerilen
min. Çap	max. Çap	Uç Radüsü
16	21	14
21	25	20
25	35	24
35	50	45
50	65	50
65	75	60
75	90	70
90	114	90
114		110

SEGW

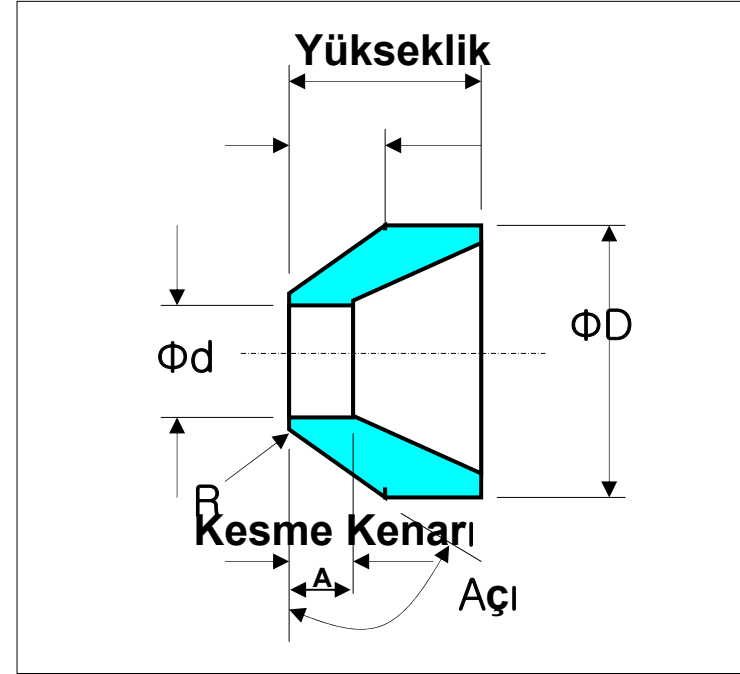
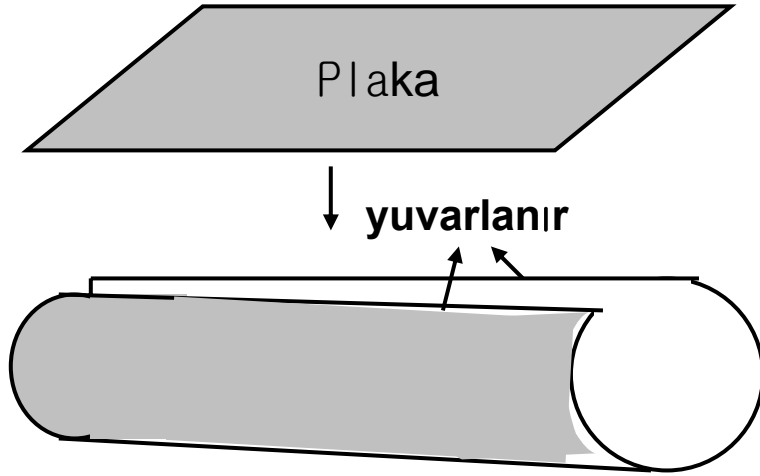


Kaplamasız: ST40
CVD Kaplama: NC3020
PVD Kaplama: PC3130

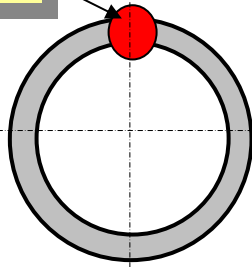
Kod	R	l(=d)	t	d1
SEGW150408-R50	50	15,875	4,76	5,6
SEGW150408-R60	60			
SEGW150408-R70	70			
SEGW150608	15	19,05	6,35	6,5
SEGW1506-R15	15			
SEGW1506-R20	20			
SEGW1506-R25	25			
SEGW1506-R30	30			
SEGW1506-R35	35			
SEGW1506-R40	40			
SEGW1506-R25	25			
SEGW1906-R8	8			
SEGW2507-R10	10			
SEGW2507-R12	12	25,4	7,94	
SEGW2507-R13	13			
SEGW2507-R14	14			
SEGW2507-R15	15			
SEGW2507-R16	16			
SEGW2507-R18	18			

Kod	R	l(=d)	t	d1
SEGW2507-R20	20	25,4	7,94	6,5
SEGW2507-R23	23			
SEGW2507-R25	25			
SEGW2507-R28	28			
SEGW2507-R30	30			
SEGW2507-R32	32			
SEGW2507-R35	35			
SEGW2507-R38	38			
SEGW2507-R40	40			
SEGW2507-R43	43			
SEGW2507-R45	45			
SEGW2507-R50	50			
SEGW2507-R55	55			
SEGW2507-R60	60			
SEGW2507-R70	70			
SEGW2507-R80	80			
SEGW2507-R100	100			
SEGW2507-R170	170			

Boru nasıl kaynak yapılır?



kaynak



Dış kaynak temizleme

Kaynak

İç Kaynak Temizleme

Kaplamasız	Kaplamalı	Φd	ΦD	Yükseklik	Açı	A	Kesme Kenarı
AR4.5	AR4.5 AC	8,0	5,0	4,5	42°	1,4	2,5
AR6.5	AR6.5 AC	10,0	6,0	4,5	48°	2,2	1,2
AR6.5S	AR6.5S AC	10,0	5,5	5,0	48°	2,5	1,9
AR6.5S-1	AR6.5S-1 AC	10,0	4,5	5,0	48°	3,1	2,9
AR6.5S-2	AR6.5S-2 AC	10,0	5,0	4,5	48°	2,8	1,2
AR7	AR7 AC	13,0	6,0	6,0	42°	3,2	3,2
AR7.5		13,0	6,5	6,0	42°	3,2	3,2
AR8	AR8 AC	13,0	7,0	6,0	42°	2,7	3,2
AR8.5		13,0	7,5	6,0	42°	2,7	3,2
AR9	AR9 AC	13,0	8,0	6,0	42°	2,3	2,9
AR9.5	AR9.5 AC	13,0	8,5	6,0	42°	2,0	2,9
AR9.5S		19,0	8,5	10,0	42°	4,7	3,0
AR10	AR10 AC	19,0	9,0	10,0	42°	4,5	3,0
AR10.5	AR10.5 AC	19,0	9,5	10,0	42°	4,3	3,0
AR10-1		19,0	9,0	10,0	42°	4,5	1,5
AR11	AR11 AC	19,0	10,0	10,0	42°	4,1	2,0
AR11.5	AR11.5 AC	19,0	10,5	10,0	42°	3,8	3,0
AR12	AR12 AC	19,0	11,0	10,0	42°	3,6	3,0
AR12S		19,0	11,0	10,0	54°18'	5,3	3,0
AR13	AR13 AC	19,0	11,5	10,0	42°	3,4	3,0

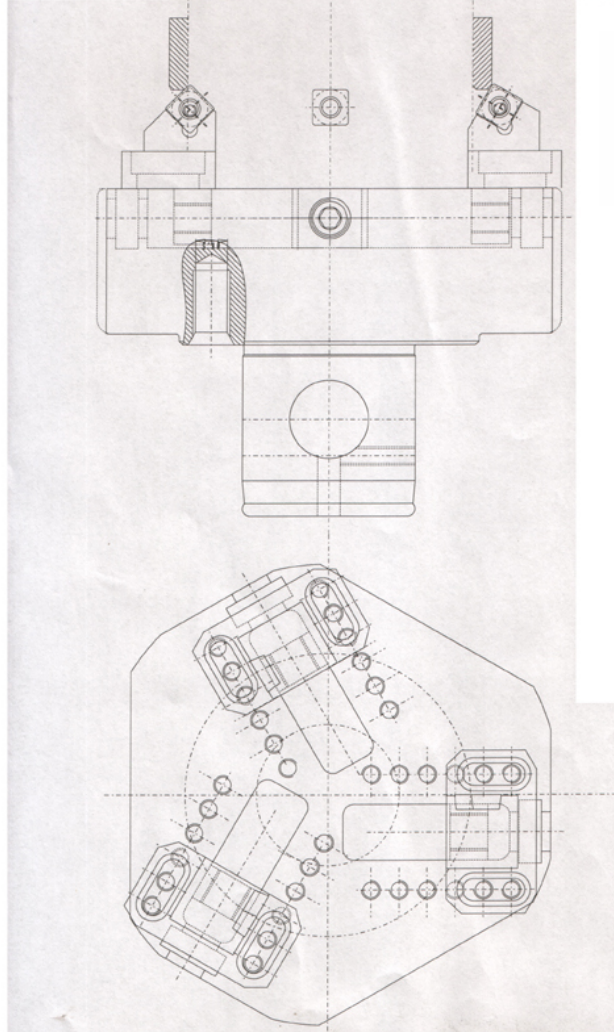
Kaplamasız	Kaplamalı	Φd	ΦD	Yükseklik	Açı	A	Kesme Kenarı
AR14	AR14 AC	22,0	12,0	12,0	36°	3,6	4,1
AR14S	AR14S AC	22,0	11,0	12,0	36°	4,0	4,1
AR15	AR15 AC	22,0	13,0	12,0	36°	3,3	4,1
AR15.5	AR15.5 AC	22,0	13,5	12,0	36°	3,1	4,1
AR16	AR16 AC	22,0	14,0	12,0	36°	2,9	4,1
AR17	AR17 AC	22,0	15,0	12,0	36°	2,5	4,6
AR16S	AR16S AC	24,0	13,5	12,0	36°	3,8	4,6
AR17S	AR17S AC	24,0	13,5	12,0	36°	3,8	4,6
AR19S	0-0.05	30,0	17,0	12,0	40°	5,26	5,5
AR19	AR19 AC	35,0	17,0	12,0	36°	6,5	4,6
AR20	AR20 AC	35,0	17,5	12,0	36°	6,4	4,6
AR21	AR21 AC	35,0	18,0	12,0	36°	6,2	4,6
AR22	AR22 AC	35,0	19,0	12,0	36°	5,8	4,6
AR23	AR23 AC	35,0	20,0	12,0	36°	5,4	4,6
AR23-1		35,0	20,0	12,0	36°	5,4	2,0
AR23-1	AR23-1 AC	35,0	20,0	12,0	36°	5,4	5,4
AR23S	AR23S AC	35,0	20,0	12,0	42°	6,8	4,6
AR24	AR24 AC	35,0	21,0	12,0	36°	5,1	4,6
AR25	AR25 AC	35,0	22,0	12,0	36°	4,7	4,6
AR26	AR26 AC	35,0	23,0	12,0	36°	4,4	4,6

Kaplamasız	Kaplamalı	Φd	ΦD	Yükseklik	Açı	A	Kesme Kenarı
AR27	AR27 AC	35,0	24,0	12,0	36°	4,0	4,6
AR28	AR28 AC	35,0	25,0	12,0	36°	3,6	4,6
AR25S		45,0	22,0	15,0	36°	8,3	4,6
AR26S		45,0	23,0	15,0	36°	8,0	4,6
AR27S		45,0	24,0	15,0	36°	7,6	4,6
AR28X	AR28X AC	45,0	25,0	15,0	36°	7,3	4,6
AR30	AR30 AC	45,0	27,0	15,0	36°	6,5	4,6
AR31	AR31 AC	45,0	28,0	15,0	36°	6,2	4,6
AR32	AR32 AC	45,0	28,5	15,0	36°	6,0	4,6
AR33	AR33 AC	45,0	29,0	15,0	36°	5,8	4,6
AR34	AR34 AC	45,0	30,0	15,0	36°	5,4	4,6
AR34-1	AR34-1 AC	45,0	30,0	15,0	36°	5,4	4,6
AR30S		50,0	28,0	15,0	36°	8,0	4,6
AR34S	AR35S AC	50,0	30,0	16,7	36°	7,2	4,6
AR35	AR35 AC	50,0	31,0	15,0	36°	6,9	4,6
AR36	AR36 AC	50,0	32,0	15,0	36°	6,5	4,6
AR37	AR37 AC	50,0	33,0	15,0	36°	6,2	4,6
AR38	AR38 AC	50,0	34,0	15,0	36°	5,8	4,6
AR39	AR39 AC	50,0	35,0	15,0	36°	5,4	4,6
AR40	AR40 AC	50,0	36,0	15,0	36°	5,1	4,6

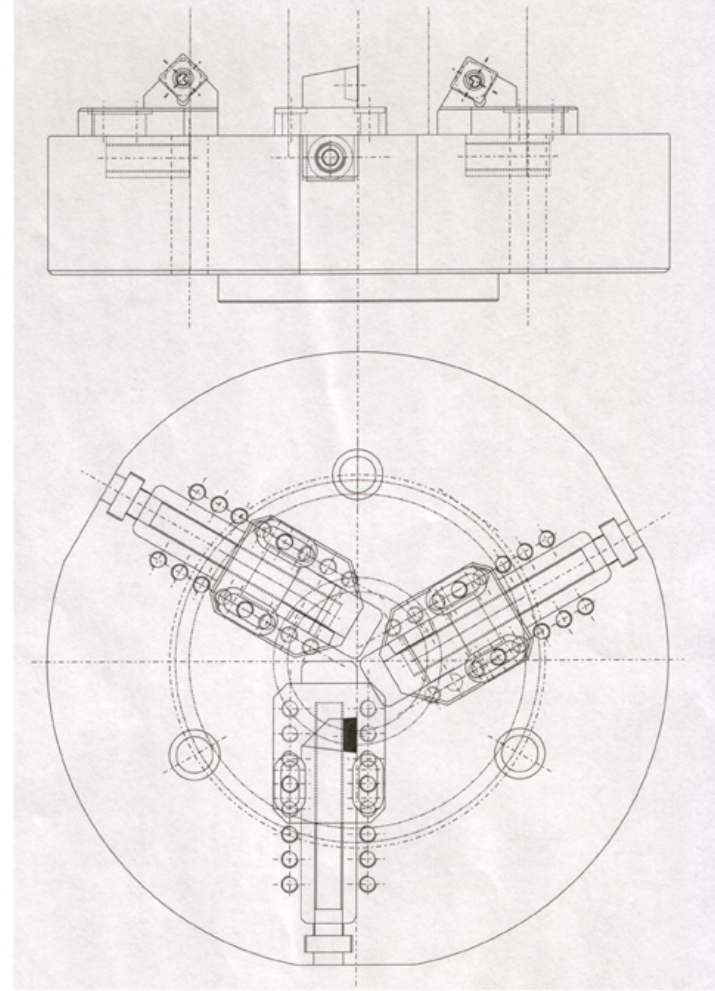
Kaplamasız	Kaplamalı	Φd	ΦD	Yükseklik	Açı	A	Kesme Kenarı
AR41	AR41 AC	55,0	37,0	18,0	36°	6,5	5,0
AR42	AR42 AC	55,0	38,0	18,0	36°	6,2	5,0
AR44	AR44 AC	55,0	39,0	18,0	36°	5,8	5,0
AR46	AR46 AC	55,0	40,0	18,0	36°	5,4	5,0
AR46-1	AR46-1 AC	55,0	40,0	18,0	36°	5,4	5,0
AR46-2		55,0	40,0	18,0	36°	5,1	5,0
AR47	AR47 AC	55,0	43,0	18,0	36°	4,4	5,0
AR47S		55,0	42,0	18,0	36°	8,9	5,0
AR46S	AR46S AC	60,0	40,0	18,0	36°	7,0	5,0
AR50S		65,0	44,0	20,0	36°	7,6	5,0
AR52		65,0	46,0	20,0	36°	5,8	7,0
AR52S		65,0	46,0	20,0	36°	6,9	7,0
AR56	AR56 AC	65,0	49,0	20,0	36°	5,8	7,0

Boru Ağız İşleme Takımları

ERBİLEKLER



ERBİLEKLER



Şekil Verme Makaraları

