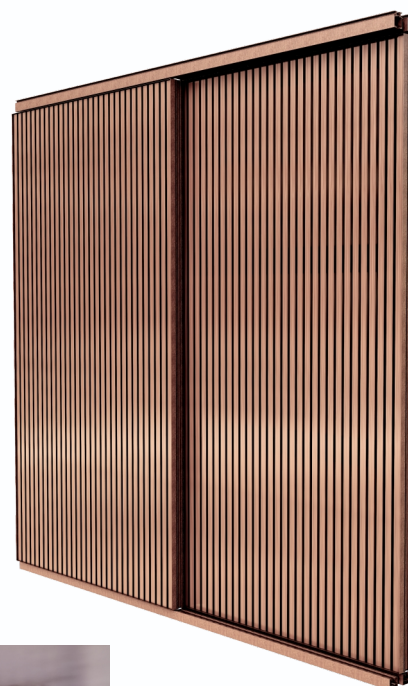
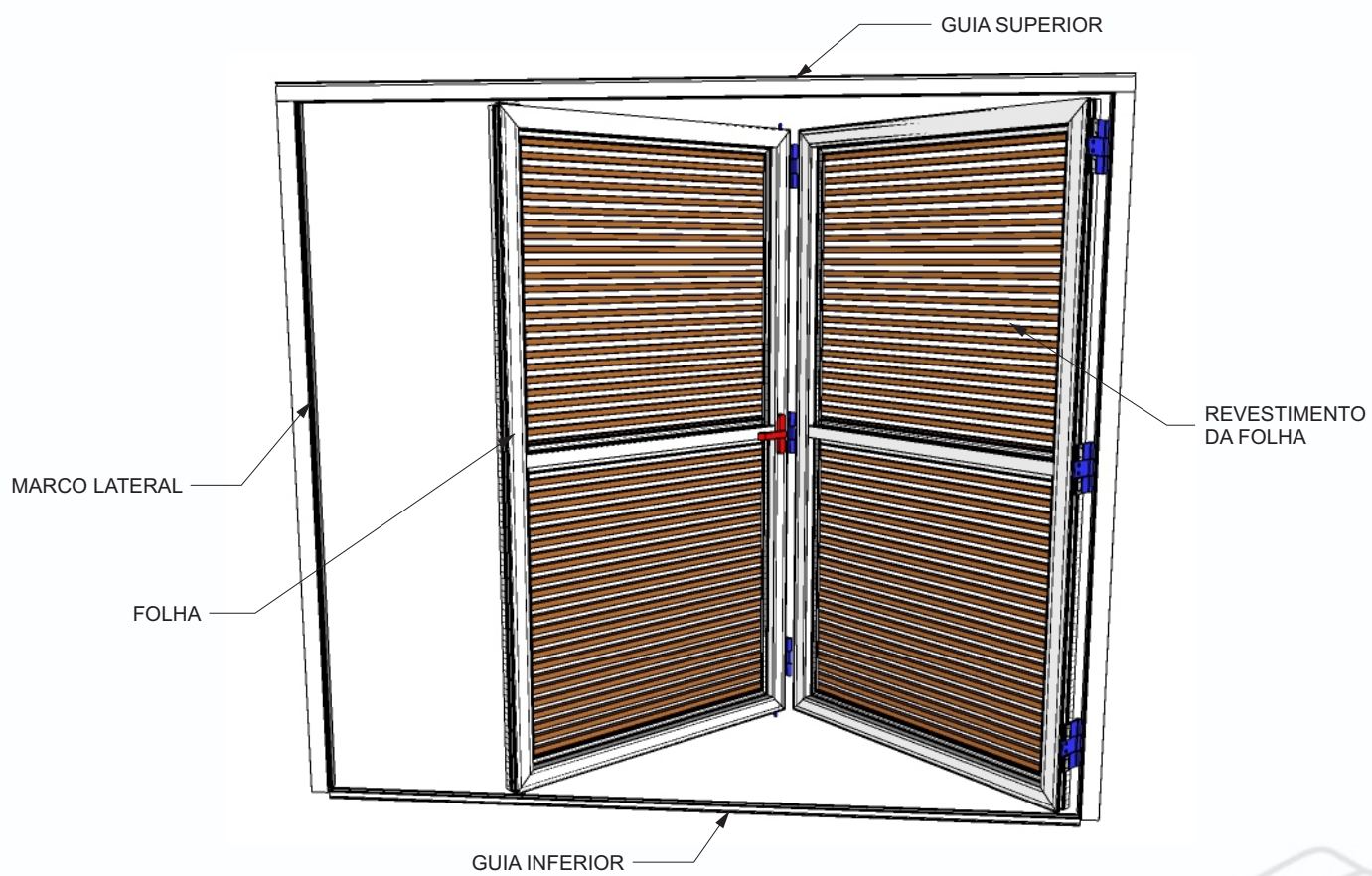




MANUAL DE FABRICAÇÃO E MONTAGEM BRISES





ROLDANA SUPERIOR

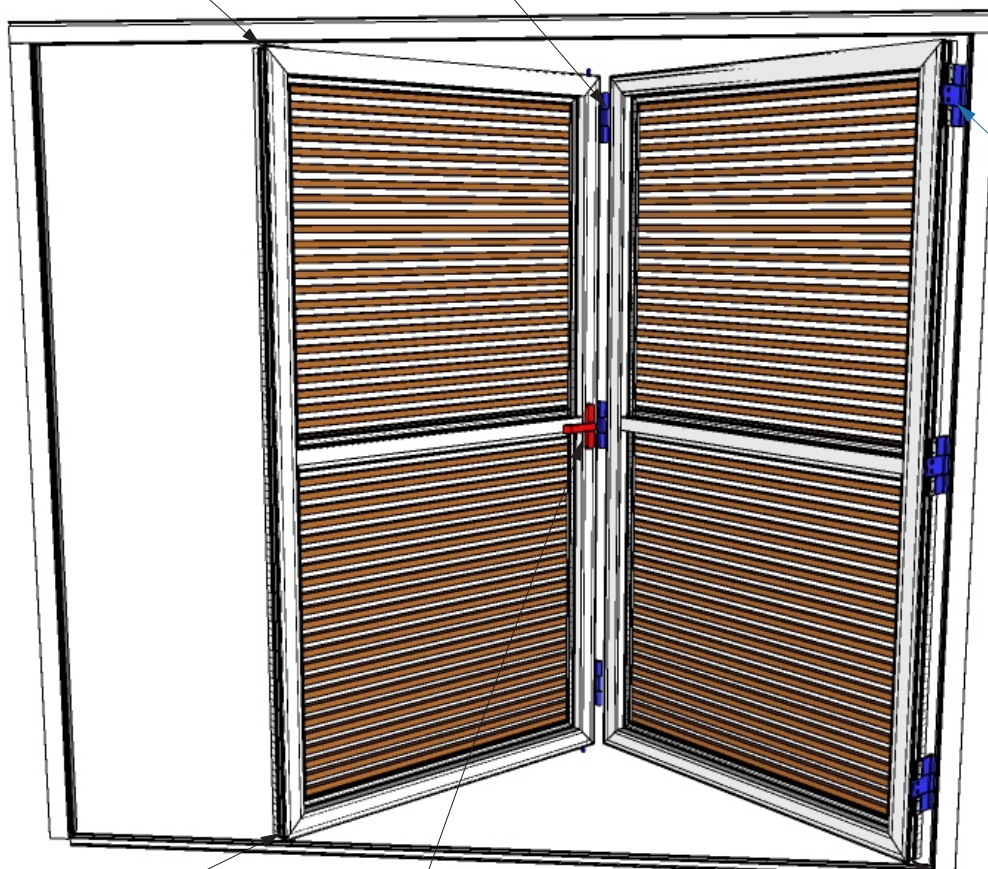
DOBRADIÇA
INTERNA

DOBRADIÇA
EXTERNA

GUIA INFERIOR

CEMONA MR2100
CREMONA MR2006R

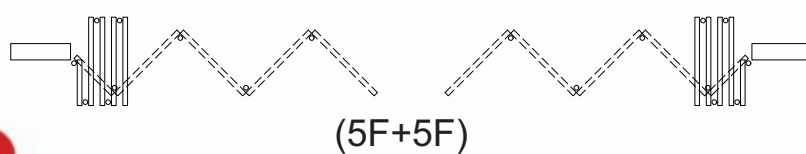
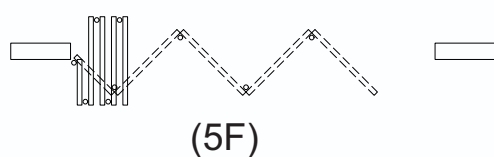
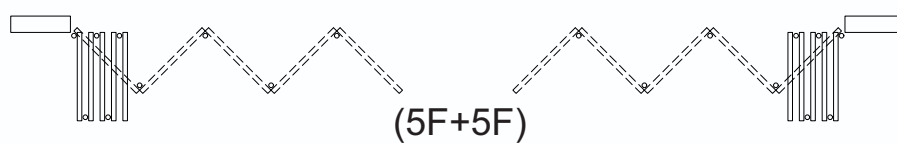
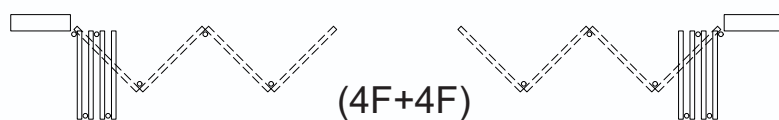
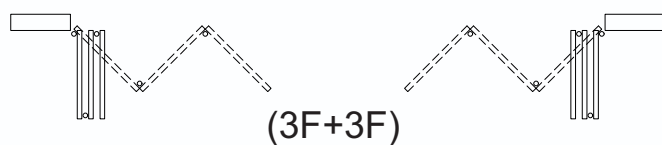
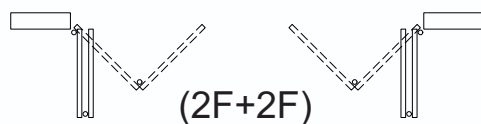
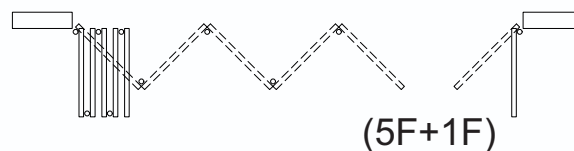
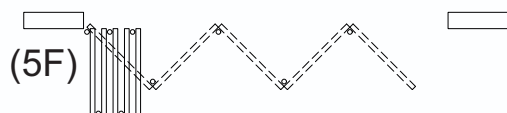
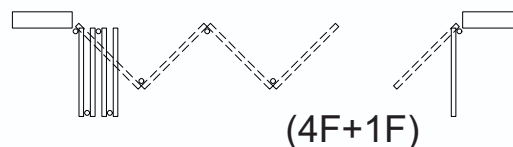
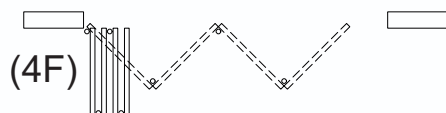
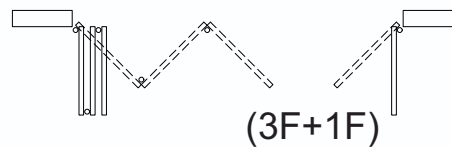
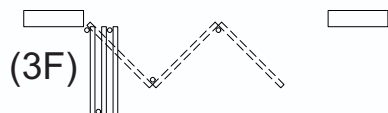
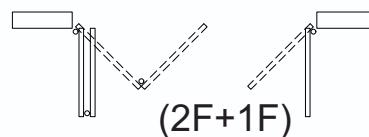
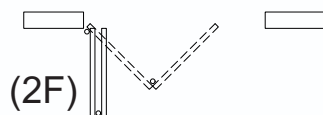
CONEXÕES

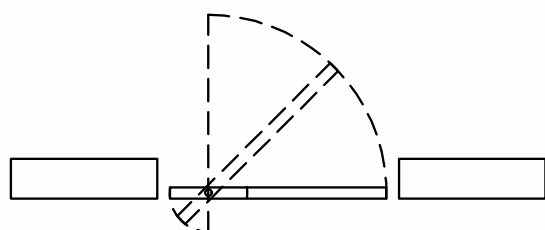


ÍNDICE

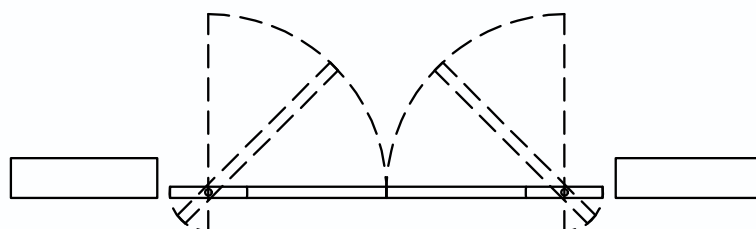
1. TIPOLOGIAS
2. CORTE DOS PERFIS
3. PERFIS
4. USINAGEM DOS PERFIS
5. MONTAGEM DE ACESSÓRIOS - BRISE CAMARÃO
6. MONTAGEM DE ACESSÓRIOS - BRISE PIVOTANTE
7. MONTAGEM DE ACESSÓRIOS - BRISE DE CORRER33

1. TIPOLOGIAS
BRISE CAMARÃO

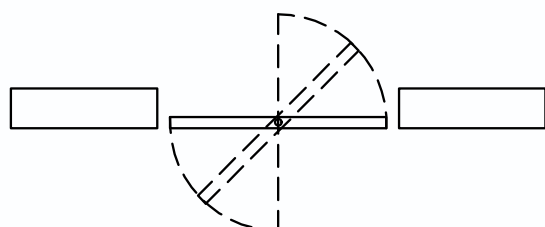




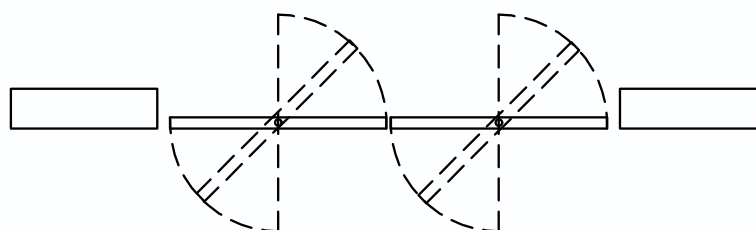
(1F pivot lateral)



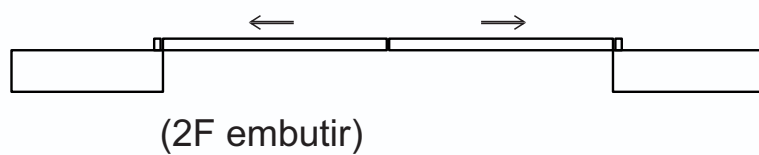
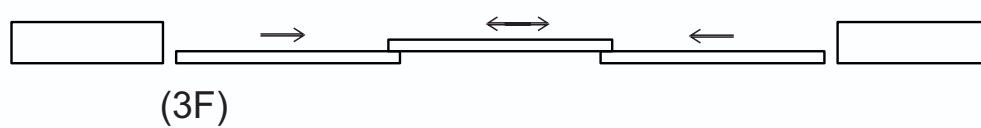
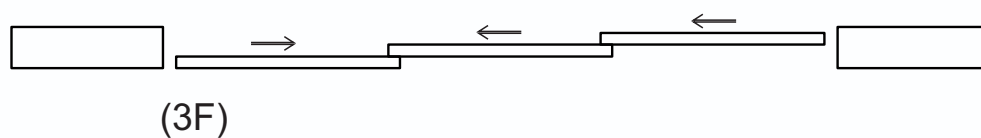
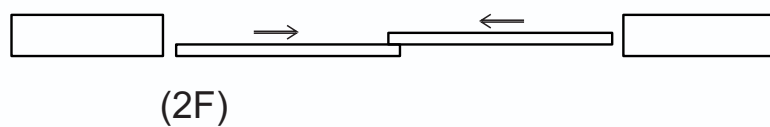
(2F pivot lateral)



(1F pivot central)

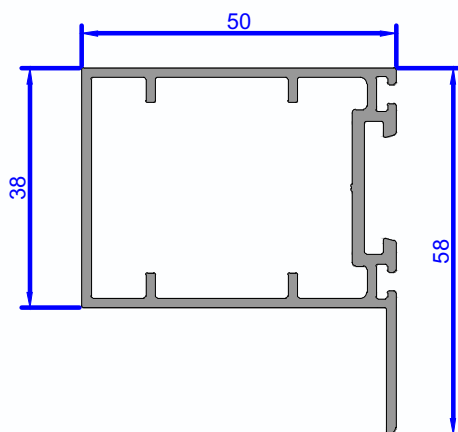


(2F pivot central)

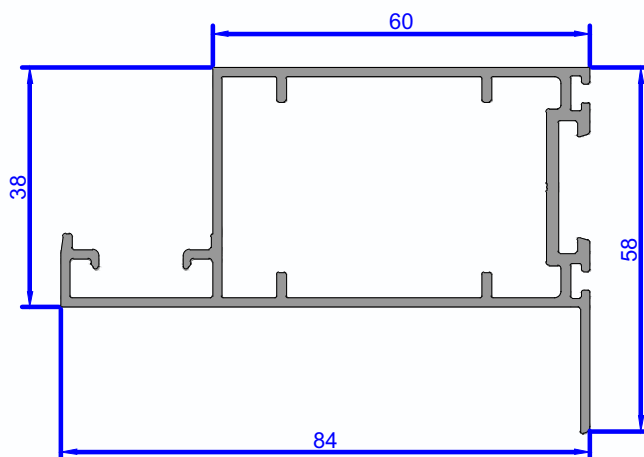


2. PERFIS

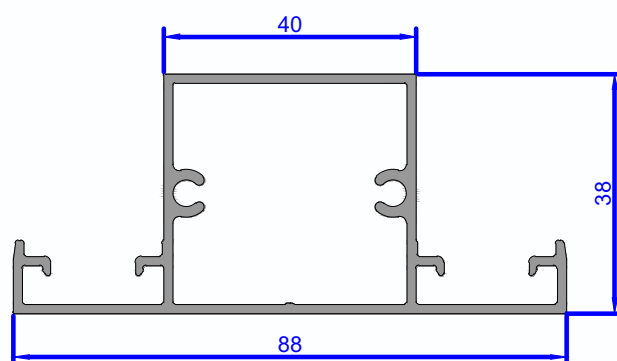
MARCO
PBR-01
0,951 Kg/m



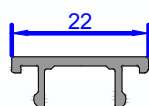
FOLHA
PBR-02
1,217 Kg/m



TRAVESS
PBR-03
1,074 Kg/m

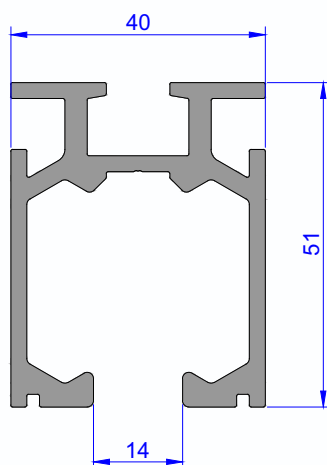


TAMPA
PBR-07
0,136 Kg/m

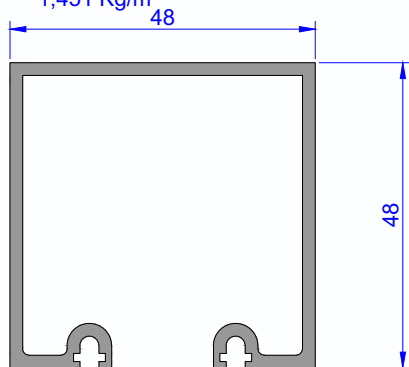


GUIAS SUPERIOR E INFERIOR

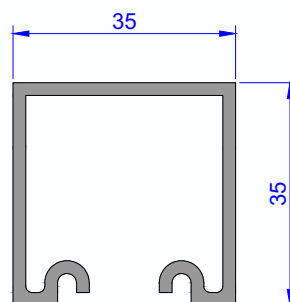
TRILHO SUPERIOR
PBR-04
1,522 Kg/m



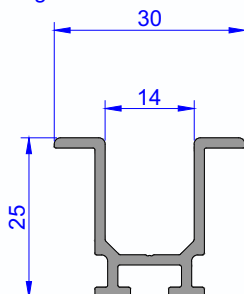
CALHA SUPERIOR 48x48
PBR-11
1,451 Kg/m



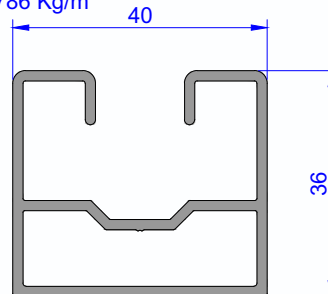
CALHA SUPERIOR 35x35
PBR-14
0,526 Kg/m



TRILHO INFERIOR EMBUTIDO
PBR-05
0,363 Kg/m

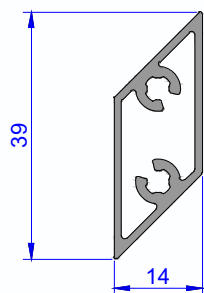


TRILHO INFERIOR
PBR-06
0,786 Kg/m

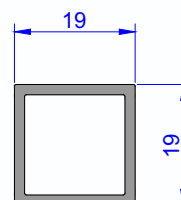


PERFIS DE REVESTIMENTO DAS FOLHAS

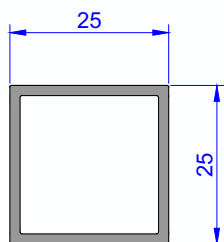
PERFIL BRISE
PBR-16
0,388 Kg/m



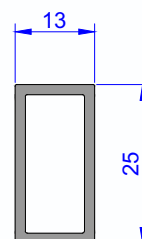
TUBO QUADRADO
PBR-08
0,302 Kg/m



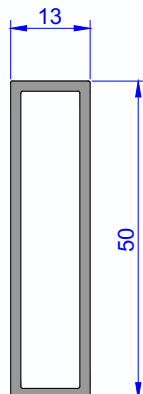
TUBO QUADRADO
PBR-09
0,405 Kg/m



TUBO QUADRADO
PBR-10
0,225 Kg/m

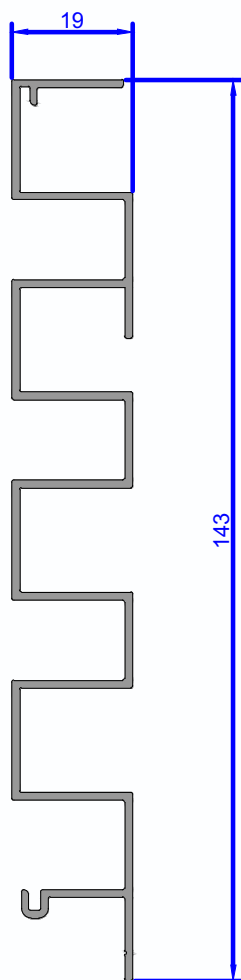


TUBO QUADRADO
PBR-15
0,545 Kg/m

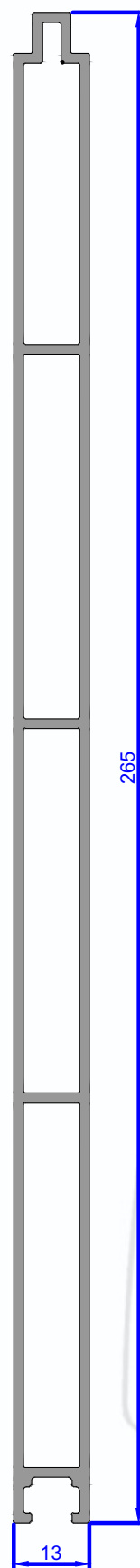


PERFIS DE REVESTIMENTO DAS FOLHAS

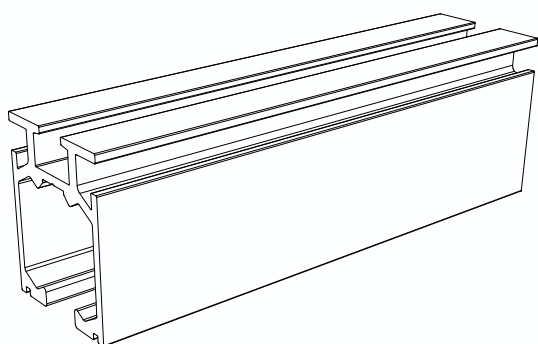
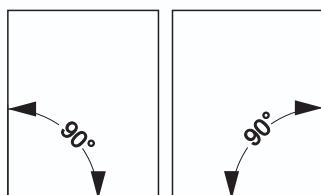
PERFIL RIPADO
PBR-12
1,051 Kg/m
PASSO DE 127mm



LAMBRI
PBR-13
2,684 Kg/m
PASSO DE 247,5mm

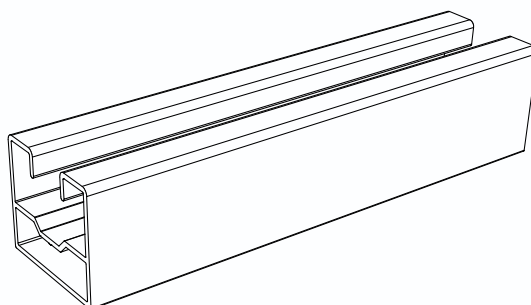
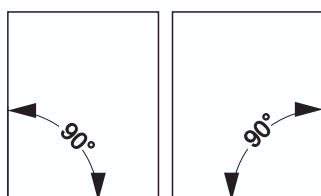


3. CORTE DE PERFIS



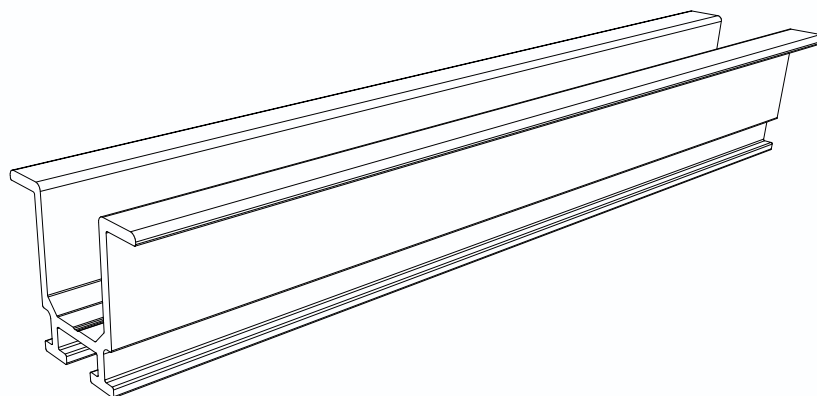
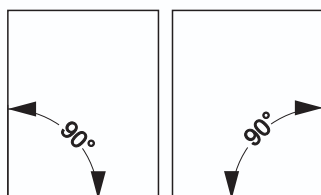
Perfil PBR-04

4.1. Cortar o perfil de calha superior, a 90° em ambos os extremos, seguindo as dimensões e descontos a aplicarem na esquadria.



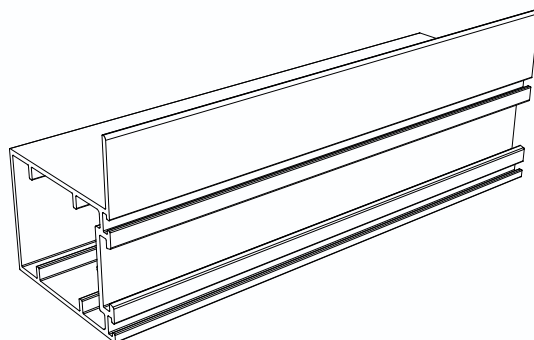
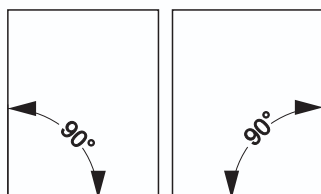
Perfil PBR-06

4.2. Cortar o perfil de calha inferior, a 90° em ambos os extremos, seguindo as dimensões e descontos a aplicarem na esquadria.



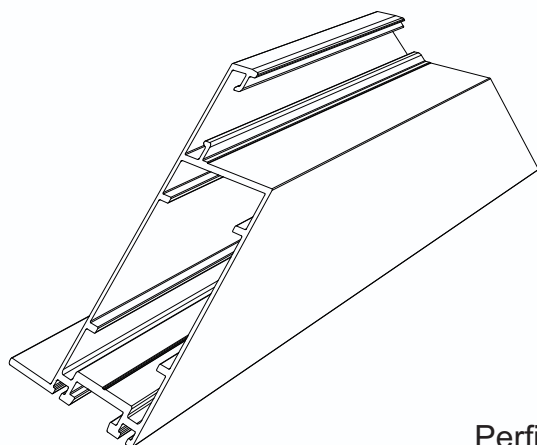
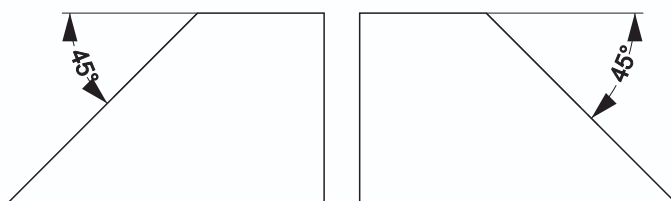
Perfil PBR-05

4.3. Cortar o perfil de calha inferior, a 90° em ambos os extremos, seguindo as dimensões e descontos a aplicarem na esquadria.



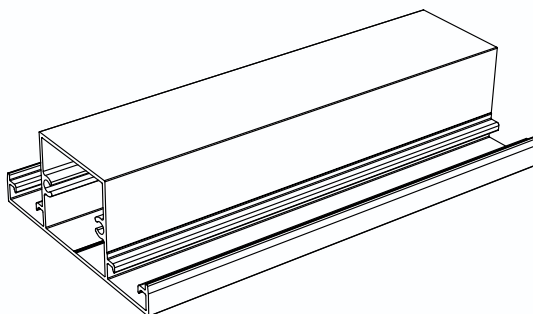
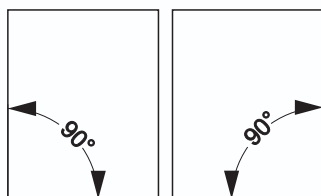
Perfil PBR-01

4.4. Cortar o perfil de marco lateral, a 90° em ambos os extremos, seguindo as dimensões e descontos a aplicarem na esquadria.



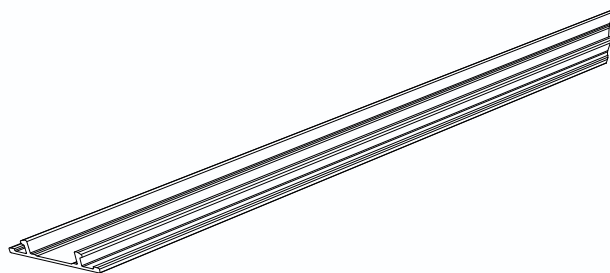
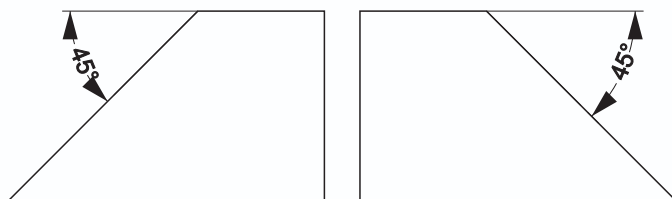
Perfil PBR-02

4.5. Cortar o perfil de quadro de folha, a 45° em ambos os extremos, seguindo as dimensões e descontos a aplicarem na esquadria.



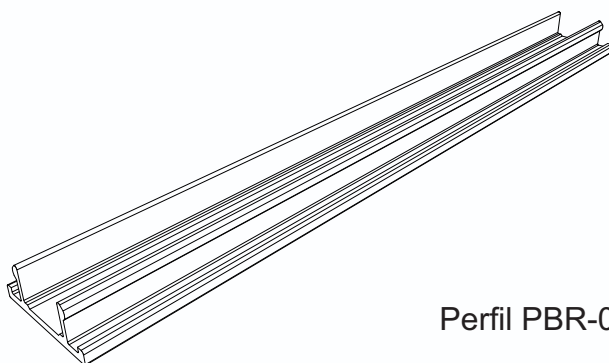
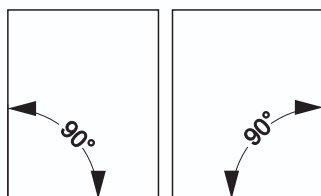
Perfil PBR-03

4.6. Cortar o perfil de travessa do quadro de folha, a 90° em ambos os extremos, seguindo as dimensões e descontos a aplicarem na esquadria.



Perfil PBR-07

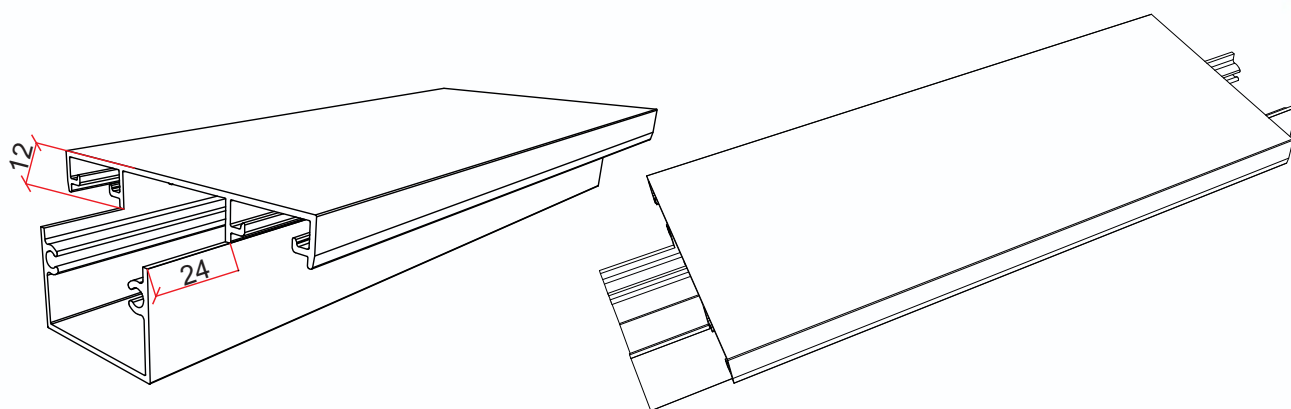
4.7. Cortar o perfil da tampa de quadro de folha perimetral, a 45° em ambos os extremos, seguindo as dimensões e descontos a aplicarem na esquadria.



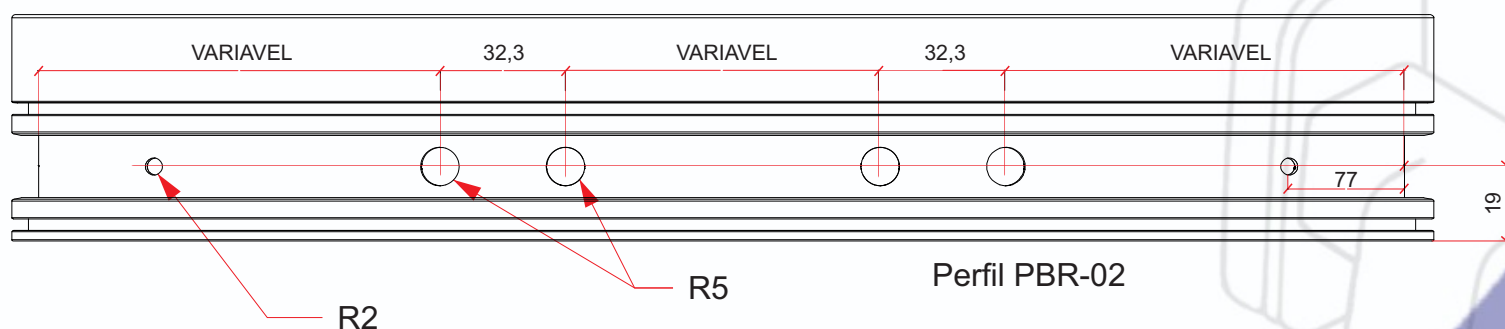
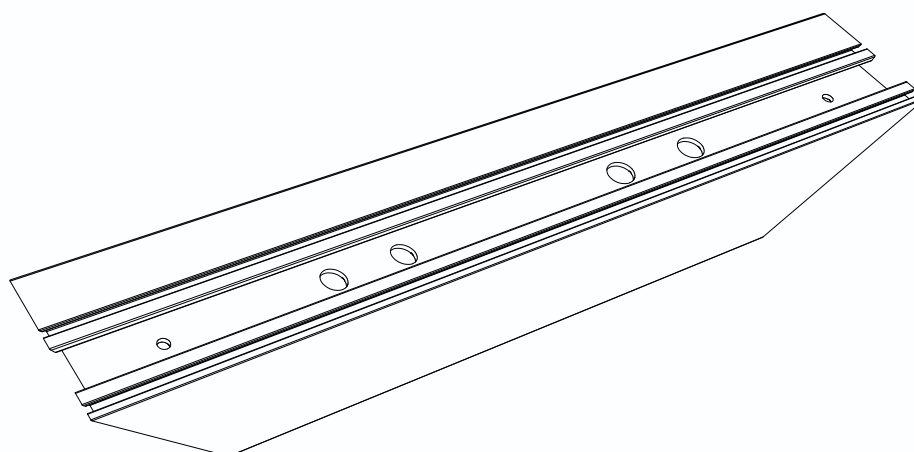
Perfil PBR-07

4.8. Cortar o perfil de tampa da travessa do quadro de folha, a 90° em ambos os extremos, seguindo as dimensões e descontos a aplicarem na esquadria.

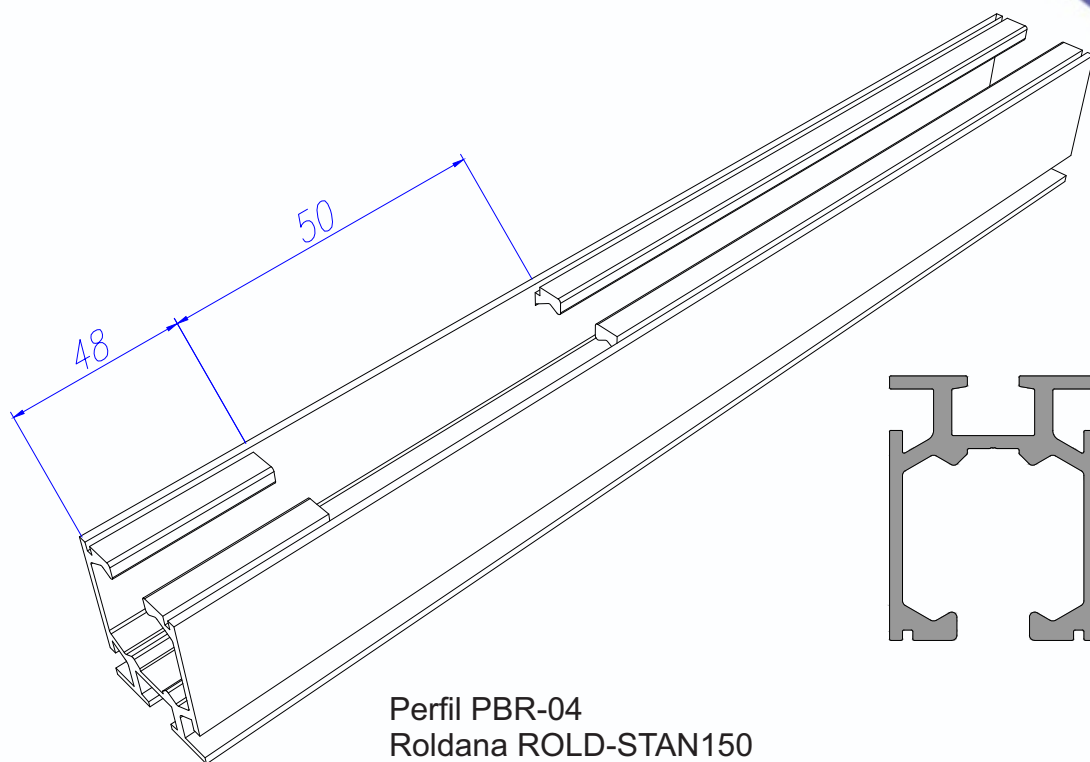
4. USINAGEM DOS PERFIS - BRISE CAMARÃO



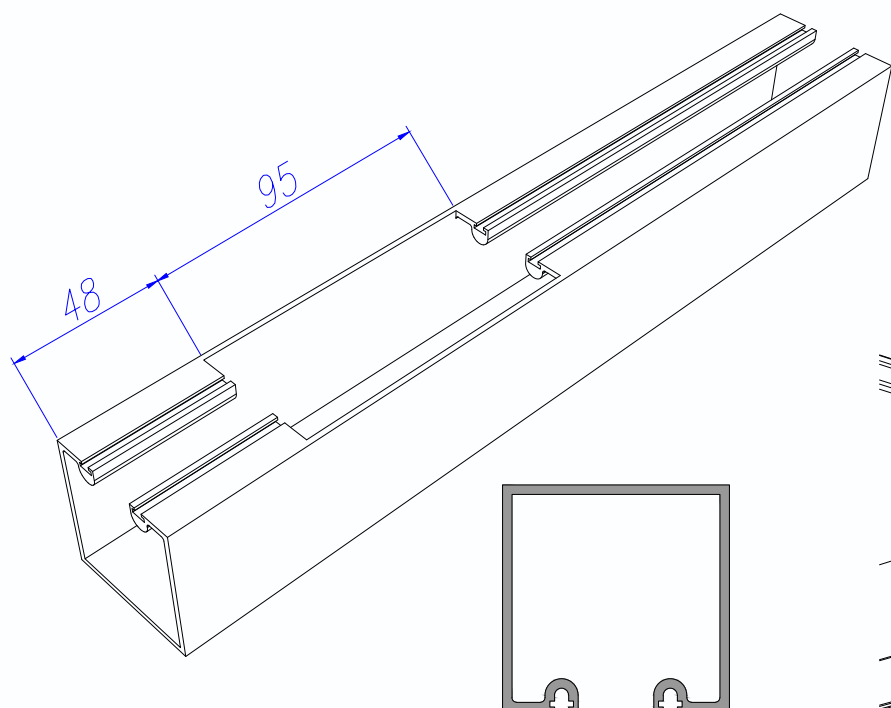
Perfil PBR-03



Perfil PBR-02



Perfil PBR-04
Roldana ROLD-STAN150
Roldana Simples 150 Kg

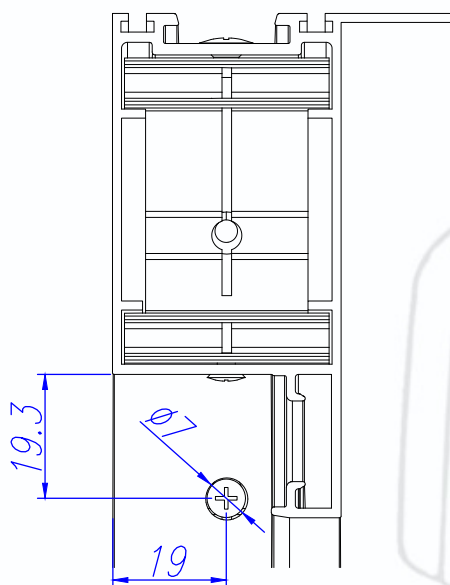
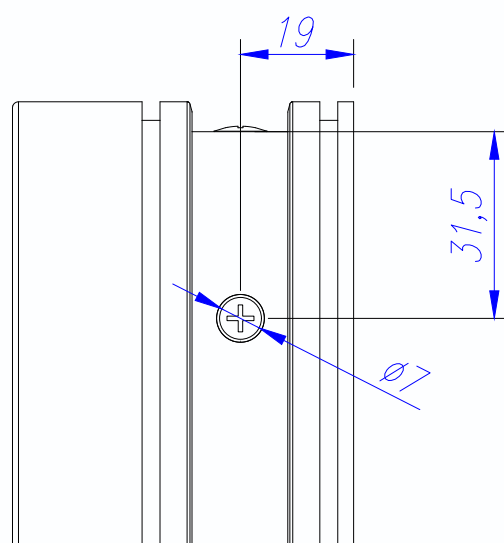
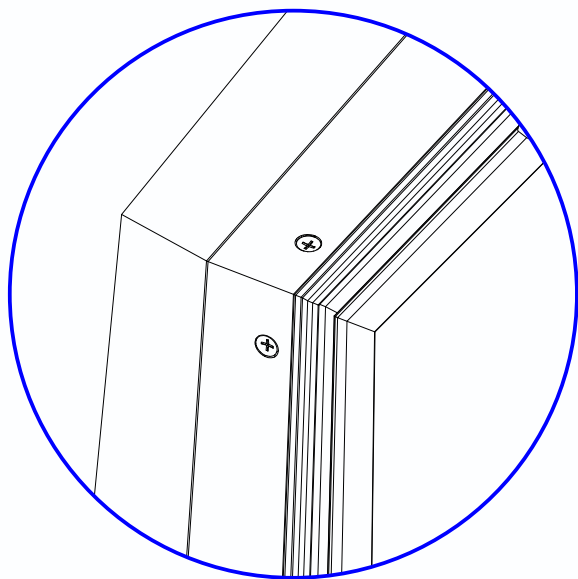
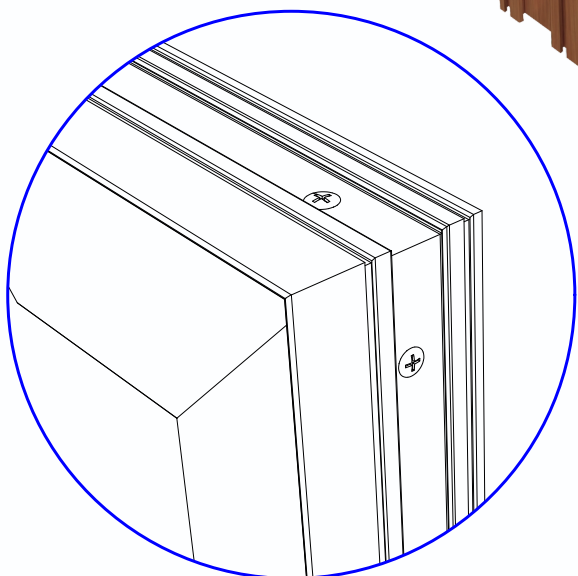


Perfil PBR-11
Roldana 10.12.11
Roldana dupla 80Kg

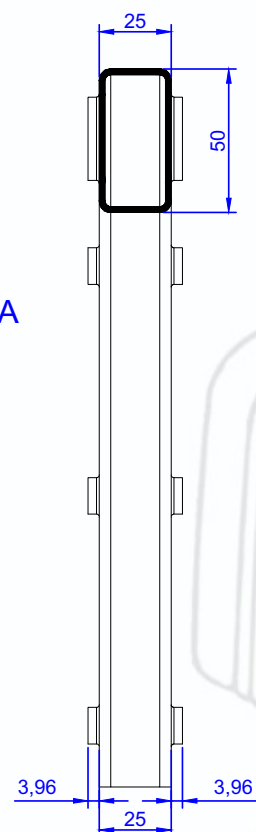
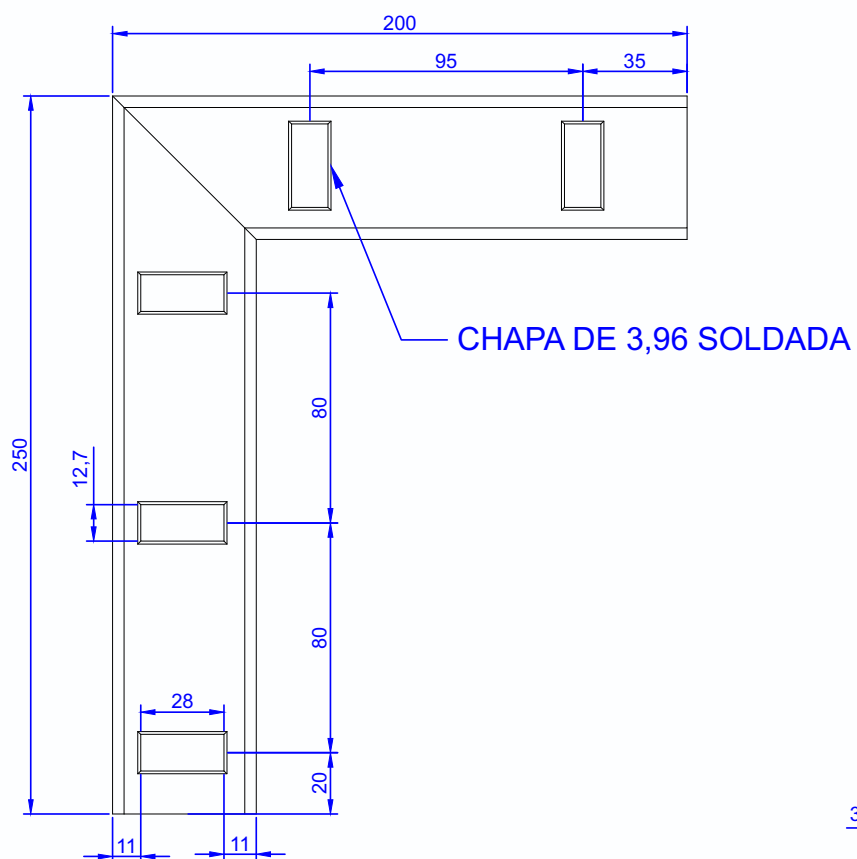
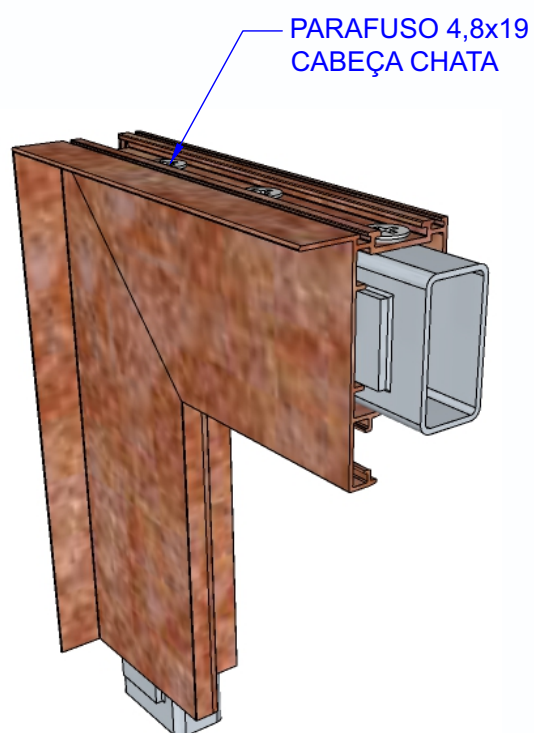
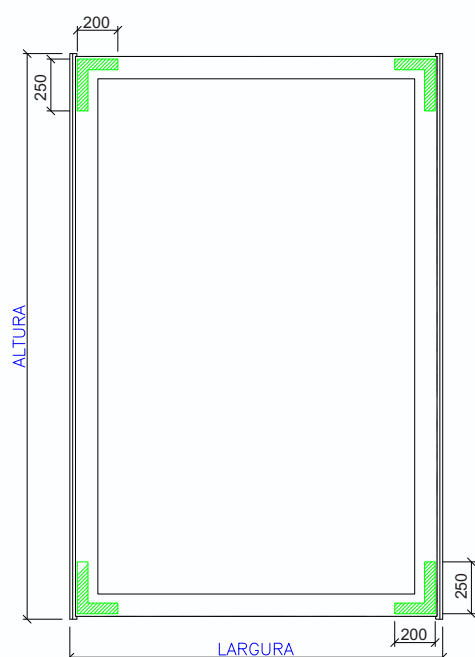




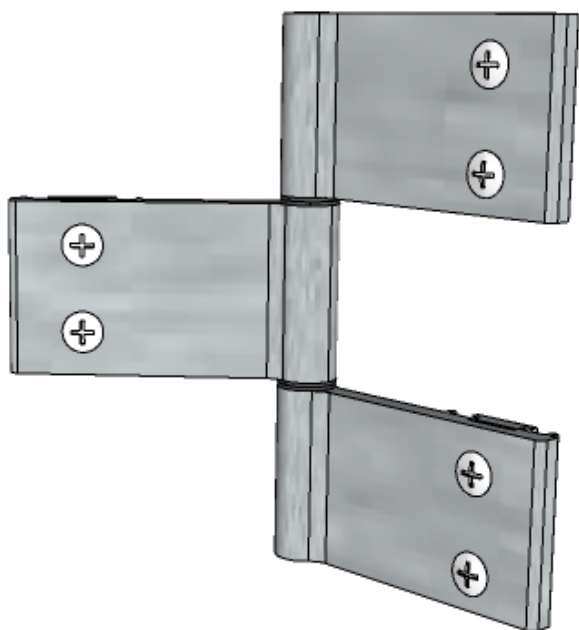
MR67358C
Conexão Expansiva



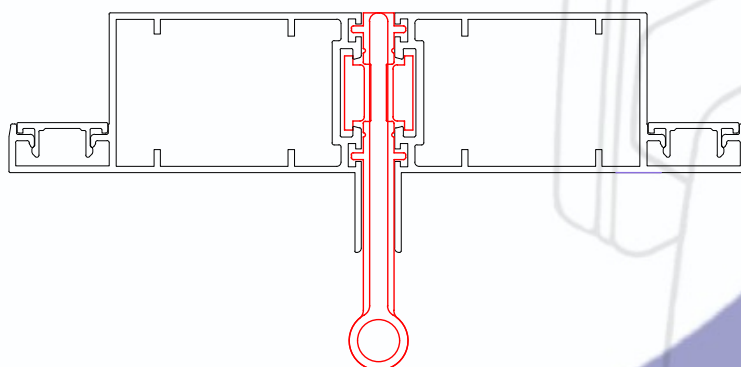
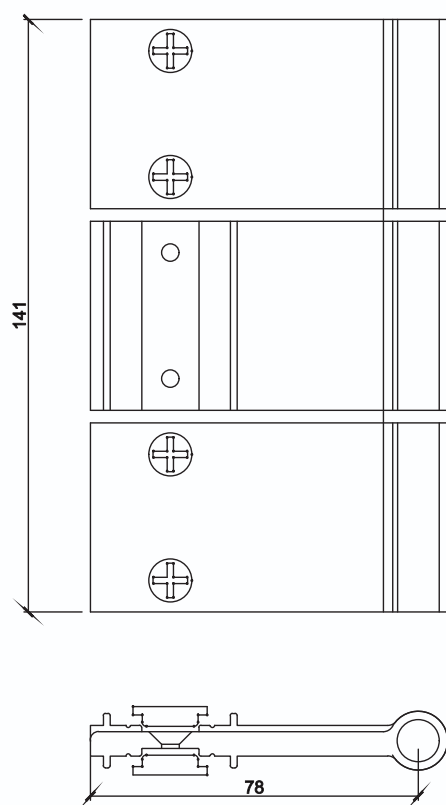
Montagem de reforço da folha

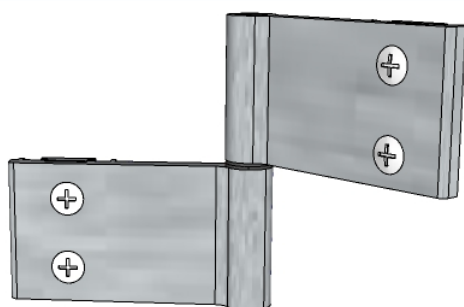


5. MONTAGEM DE ACESSÓRIOS - BRISE CAMARÃO

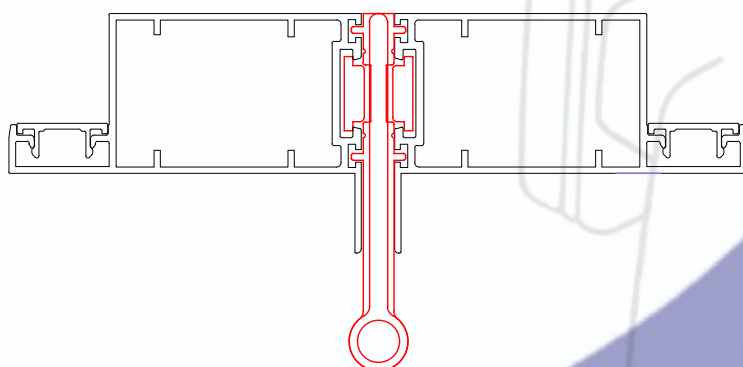
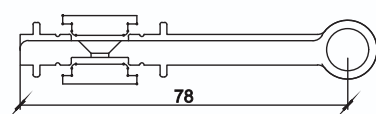
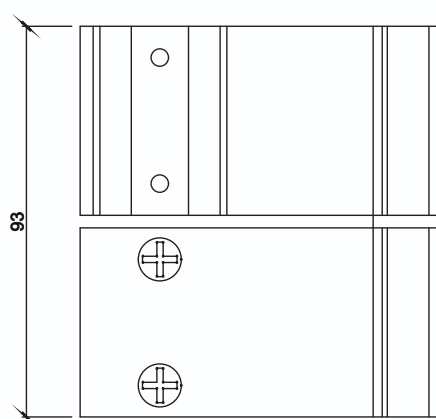


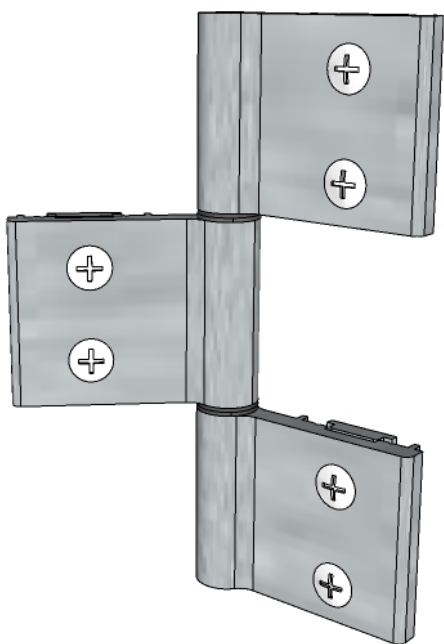
DOB-BR01T
Dobradiça de Balanço Tripla
Máximo 90kg por folha
4 unidades



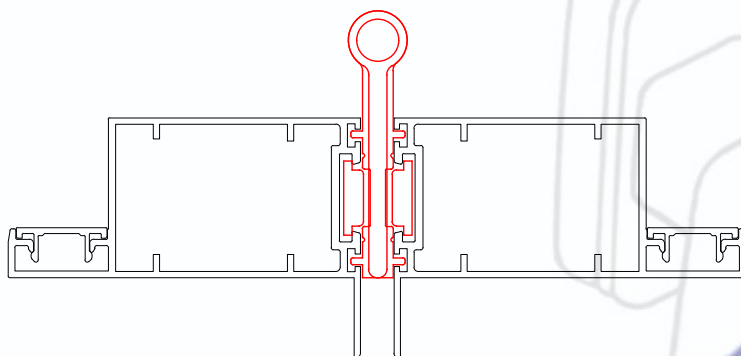
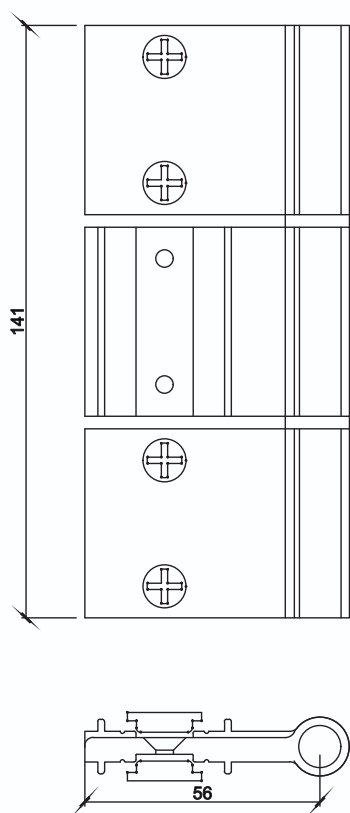


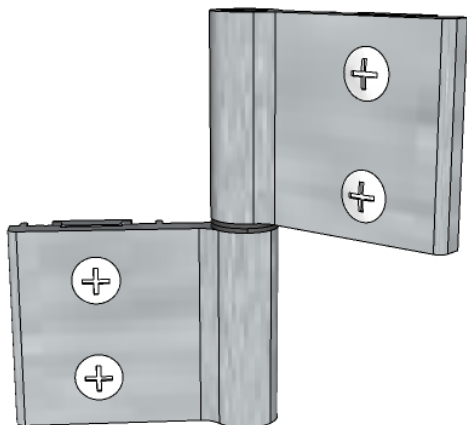
DOB-BR01
Dobradiça de Balanço
Máximo 60kg por folha
3 unidades



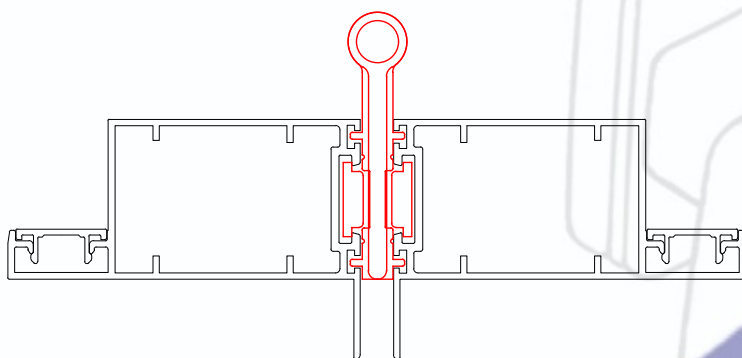
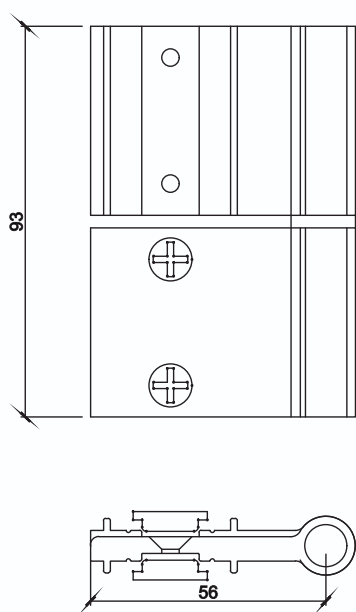


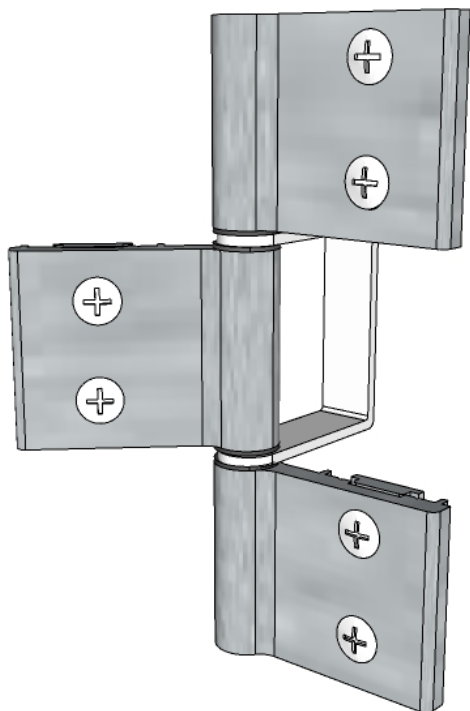
DOB-BR02T
Dobradiça Tripla
Máximo 90kg por folha
4 unidades



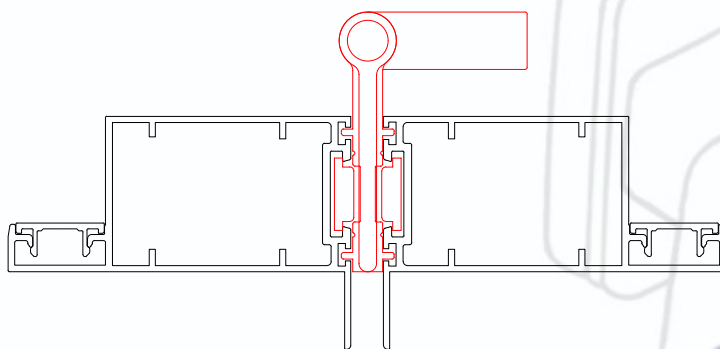
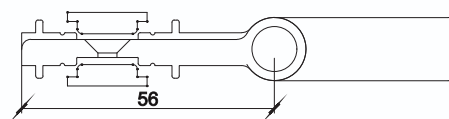
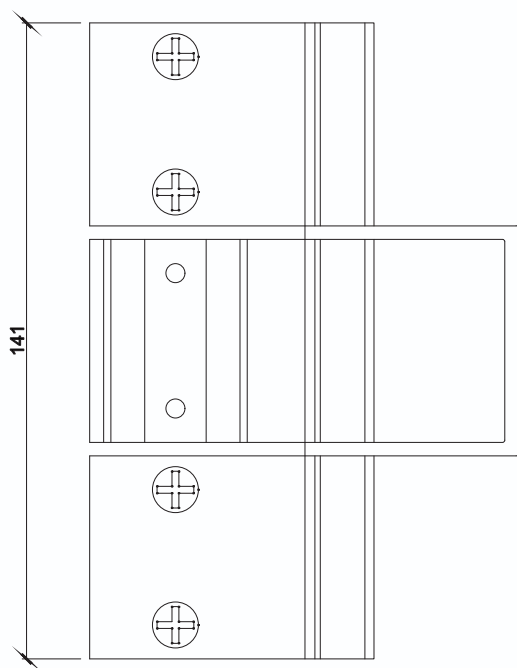


DOB-BR02
Dobradiça
Máximo 60kg por folha
3 unidades

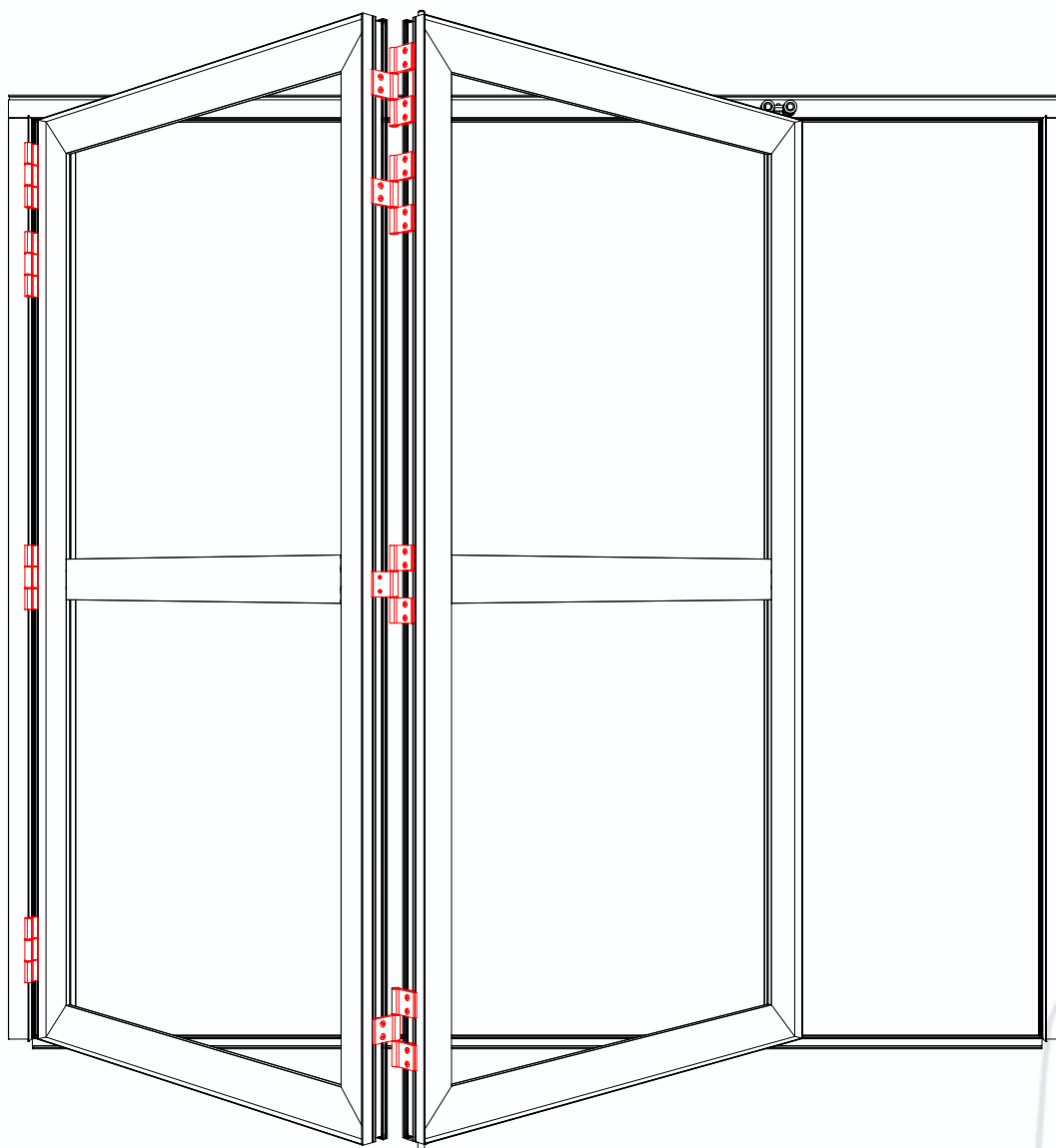


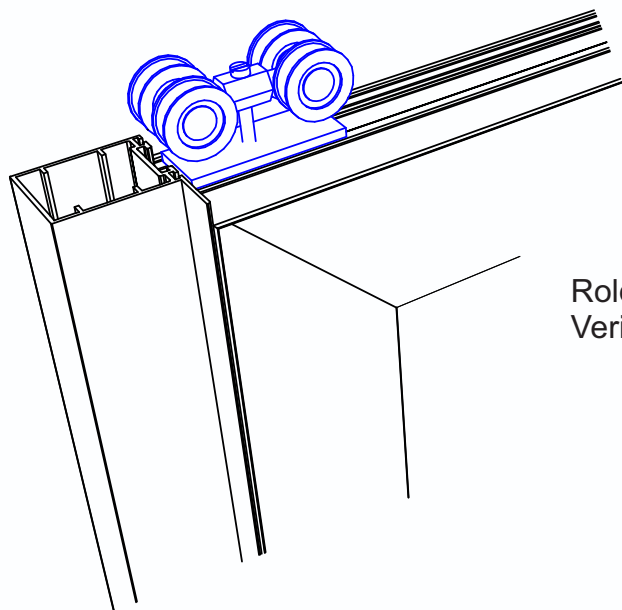


DOB-BR02T PUX
 Dobradiça Tripla com Puxador
 Máximo 90kg por folha
 3 unidades

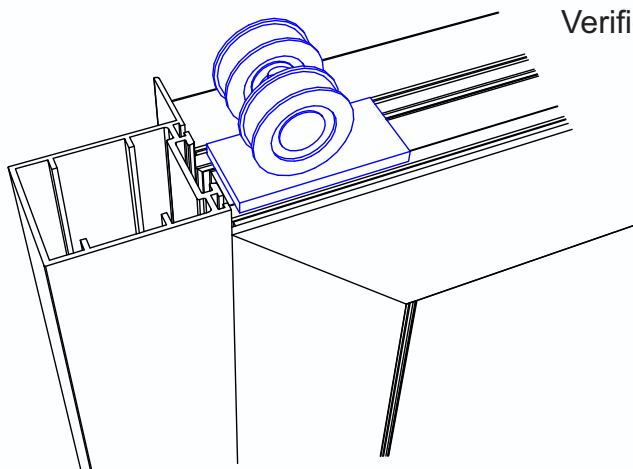
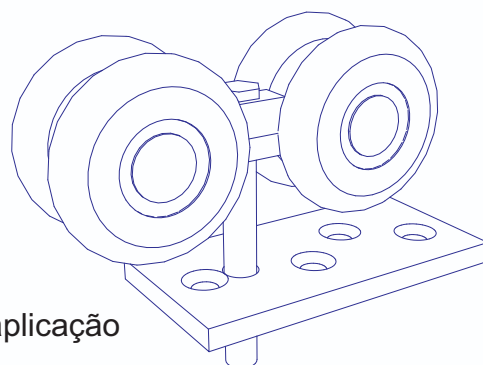


POSICIONAMENTO DAS DOBRADIÇAS SISTEMA DE BRISES

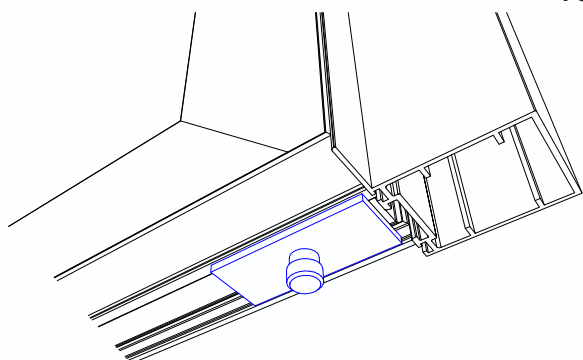




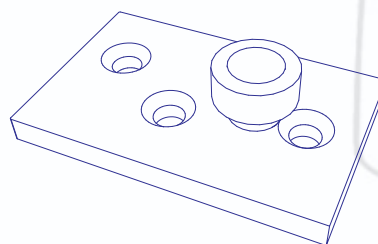
Roldana Dupla
Verificar código de aplicação



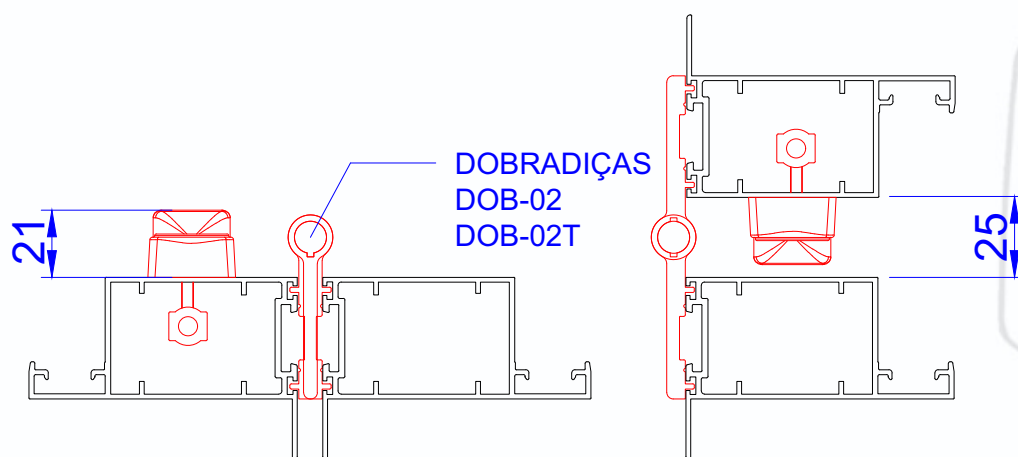
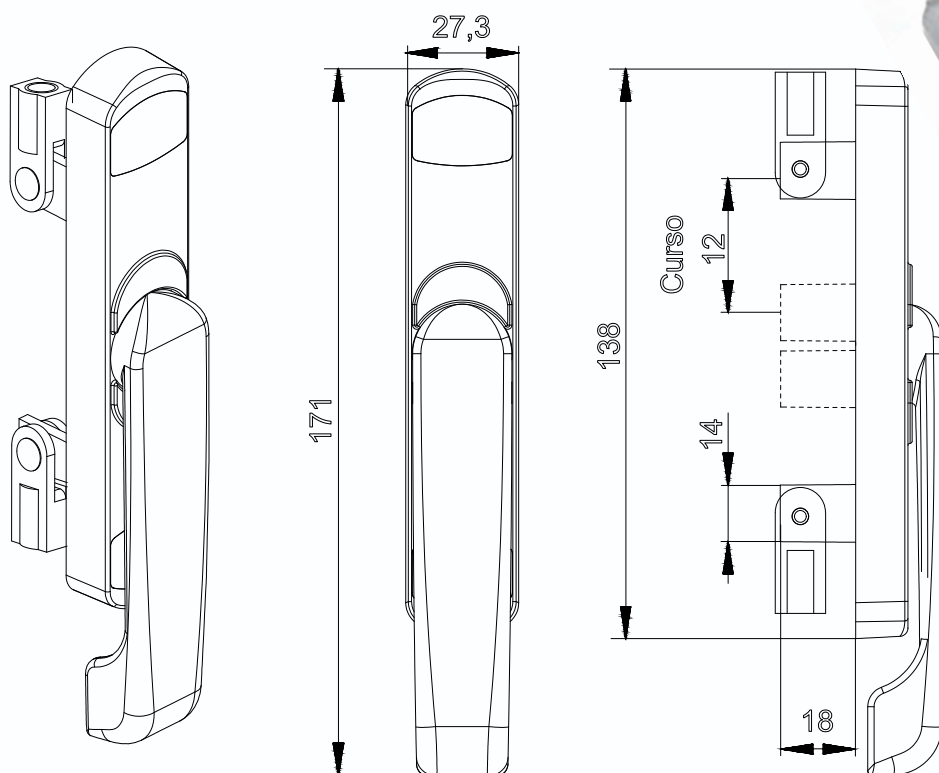
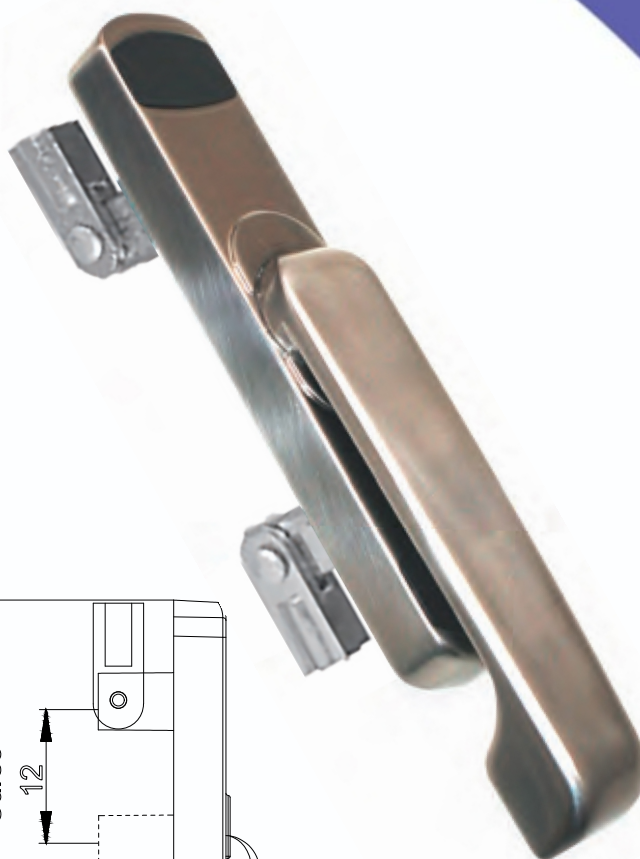
Roldana Simples
Verificar código de aplicação



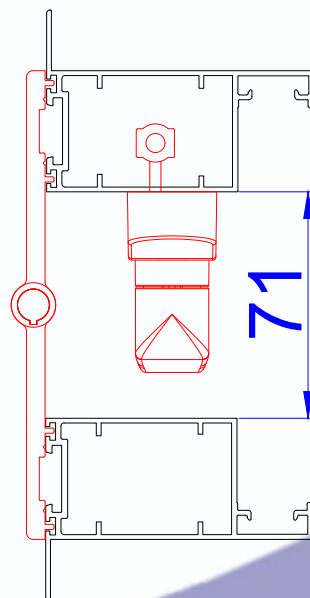
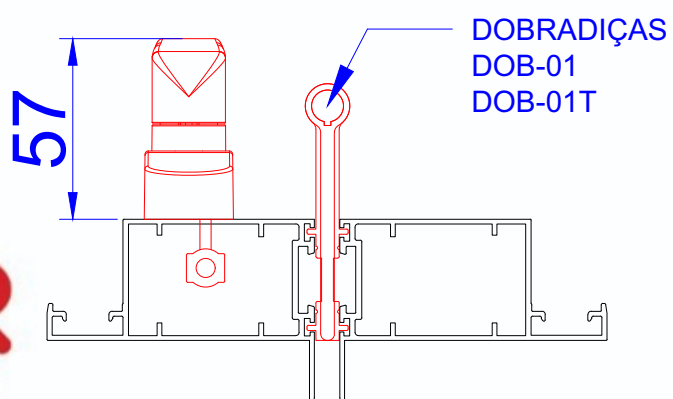
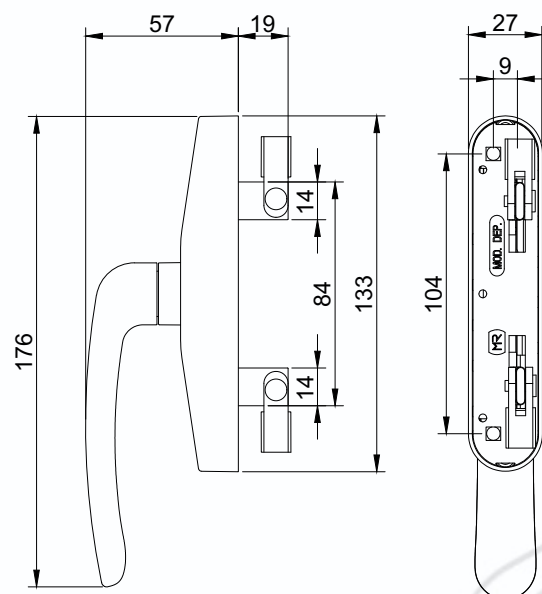
Guia Inferior
Verificar código de aplicação



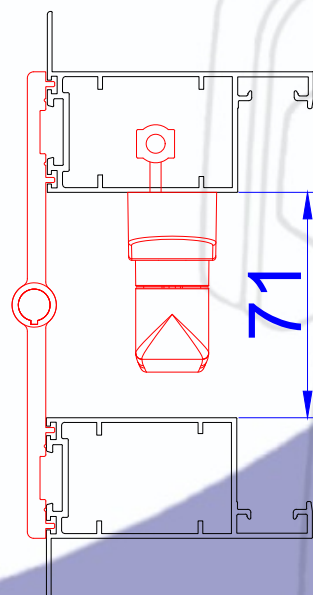
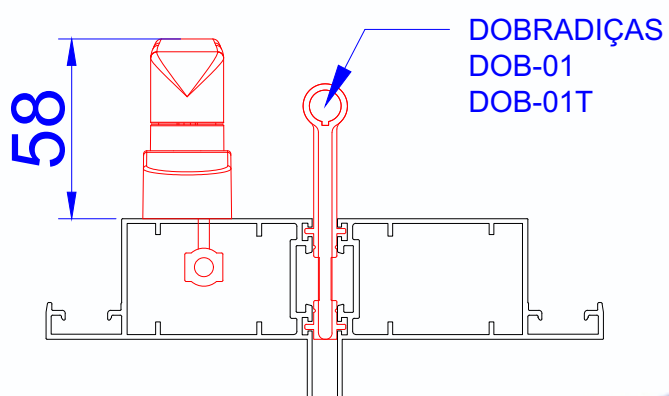
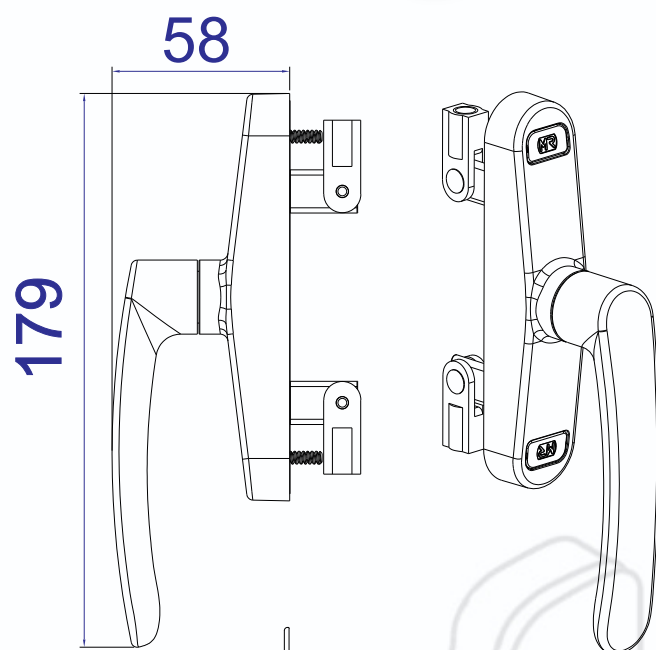
Mr2100
CREMONA DE ABERTURA EXTERIOR
REBAIXADA - 21mm



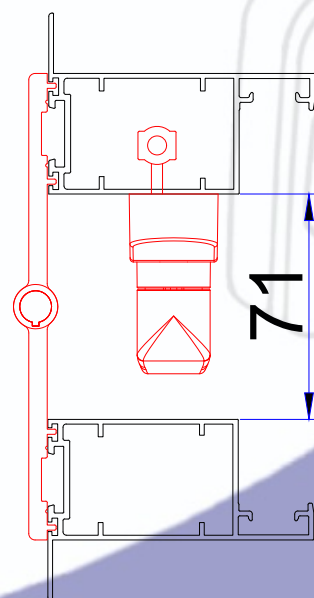
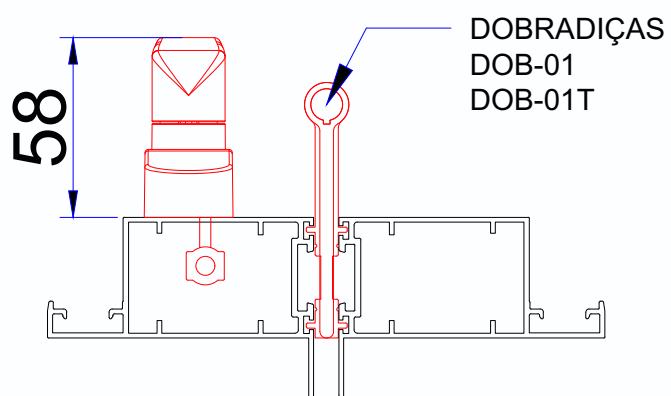
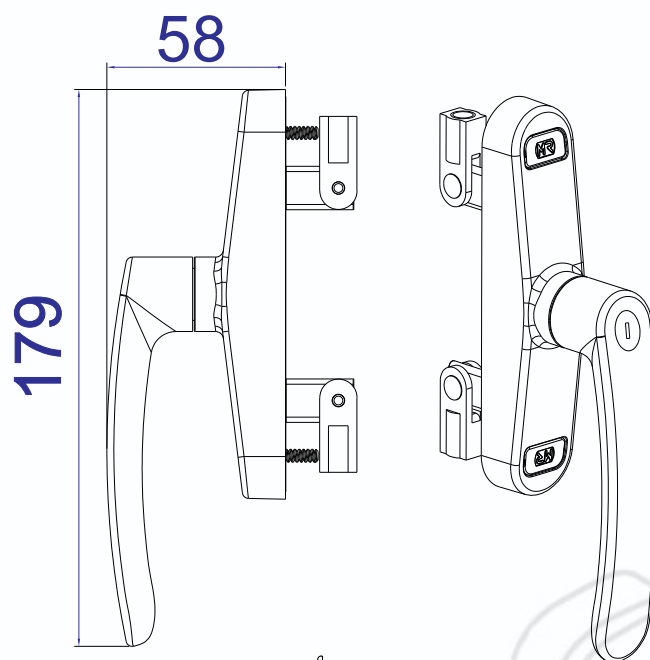
MR2006R
CREMONA DE ABERTURA EXTERIOR

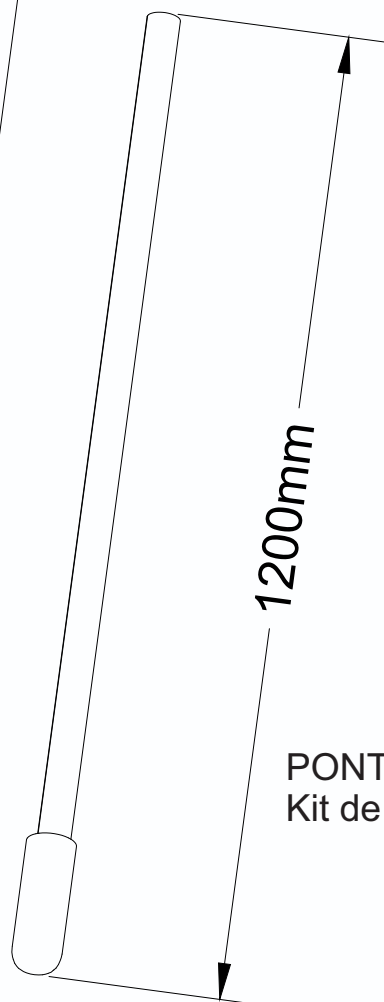
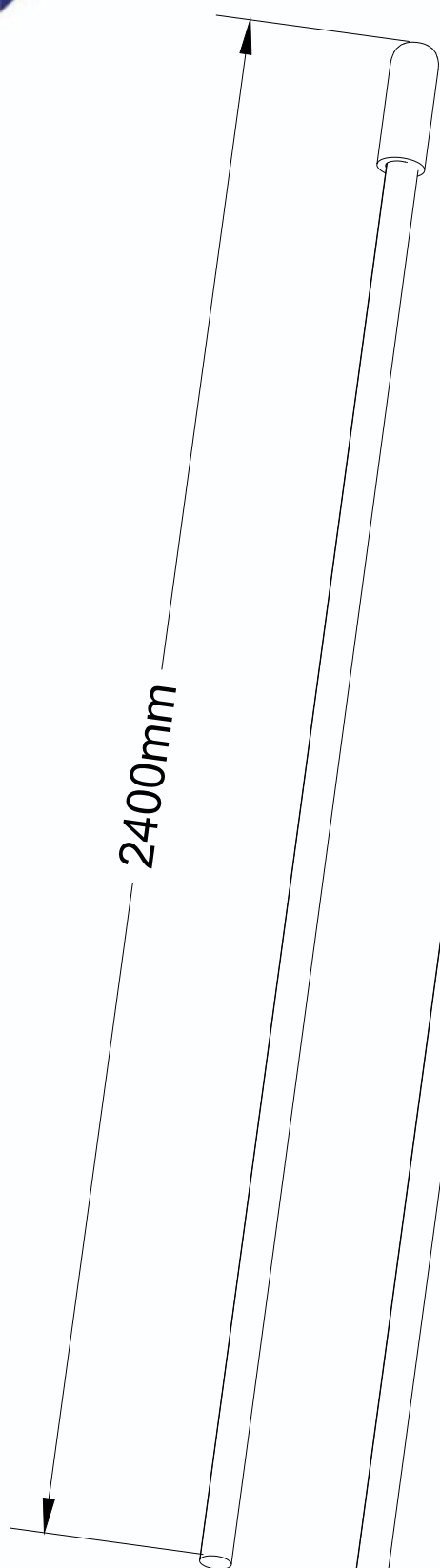


9510
CREMONA DE ABERTURA EXTERIOR

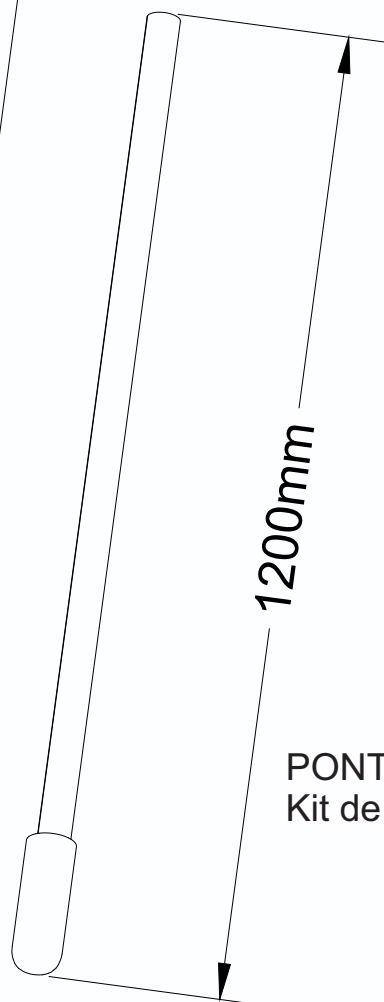
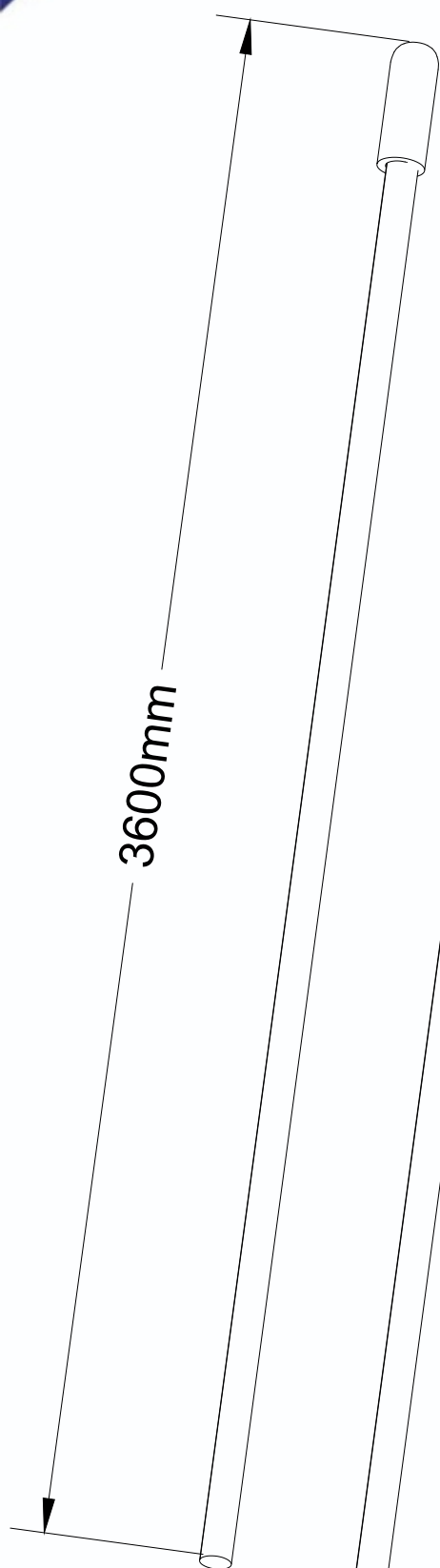


9510CC
CREMONA DE ABERTURA EXTERIOR
COM CHAVE





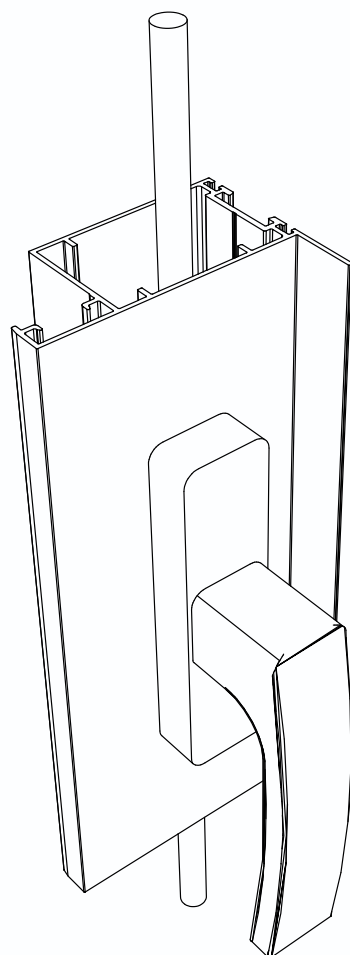
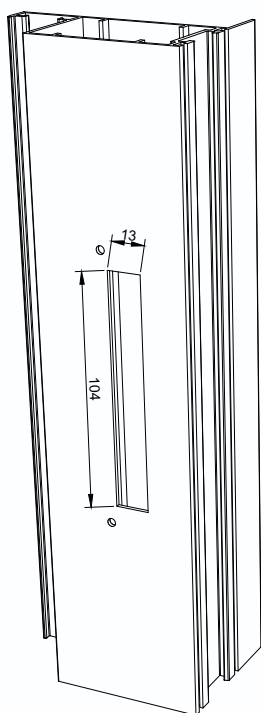
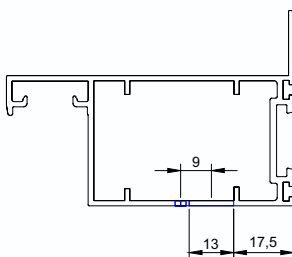
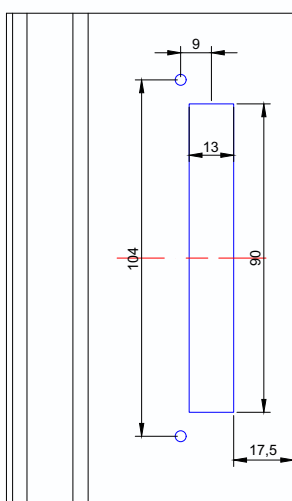
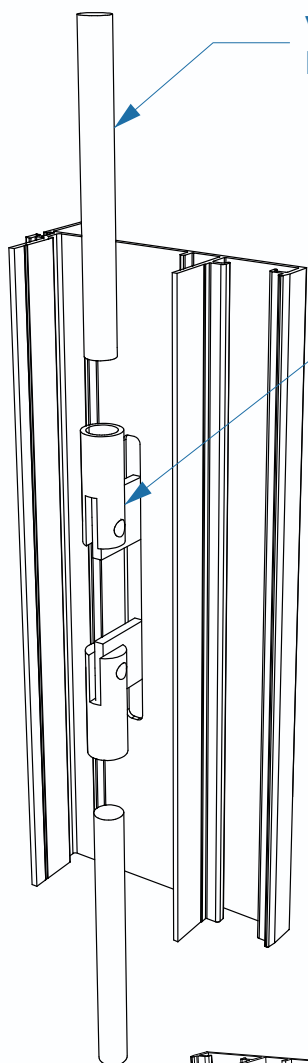
PONT-01
Kit de Ponteira Cremona Mr2100/MR2006R Brise



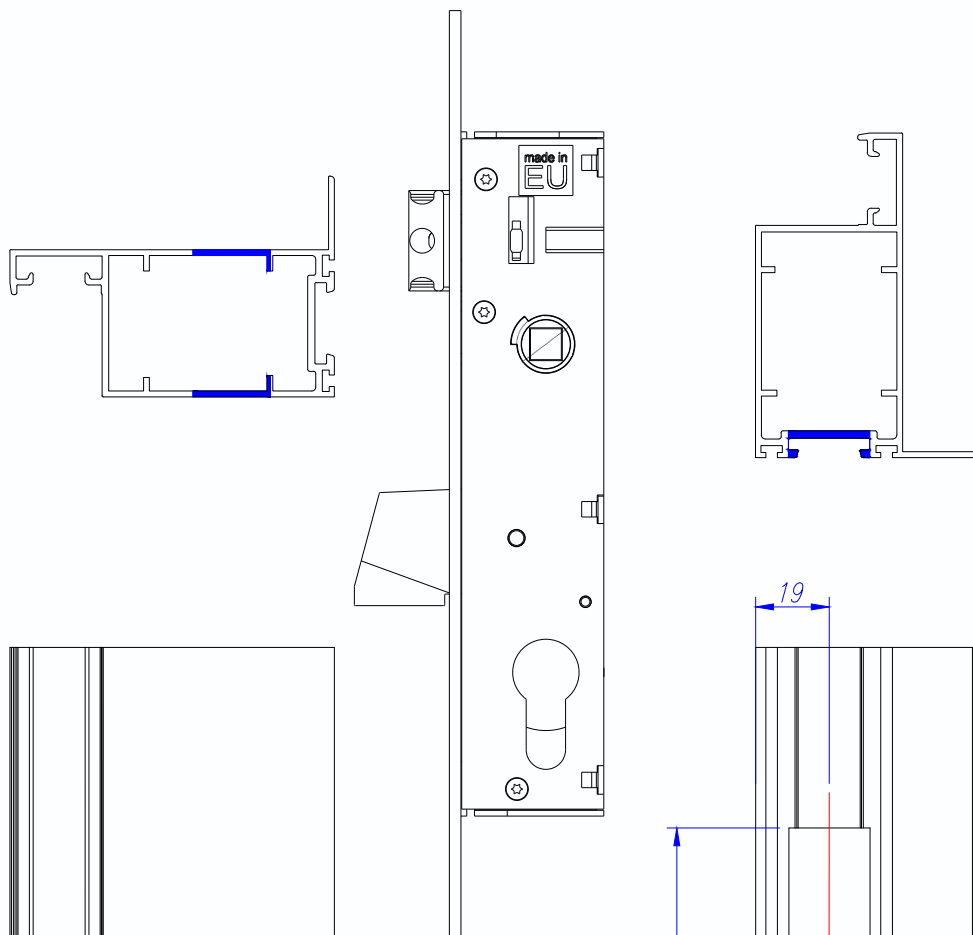
PONT-02
Kit de Ponteira Cremona Mr2100/MR2006R Brise

VARÃO DE 6 mm
ROSCADO NA PONTA

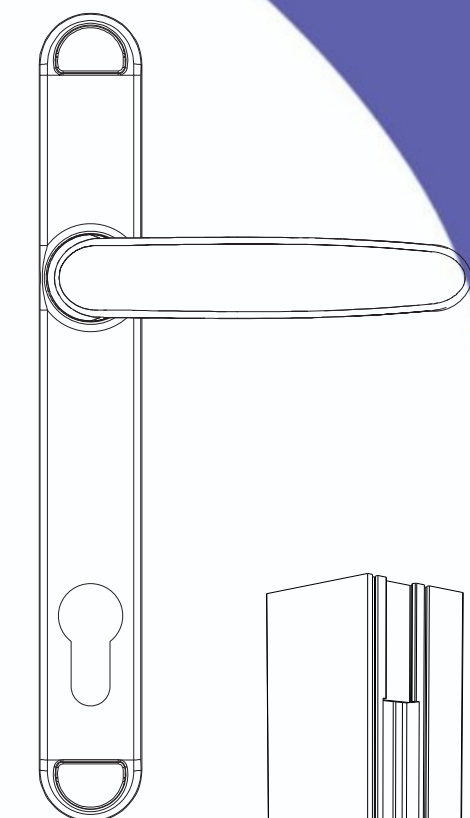
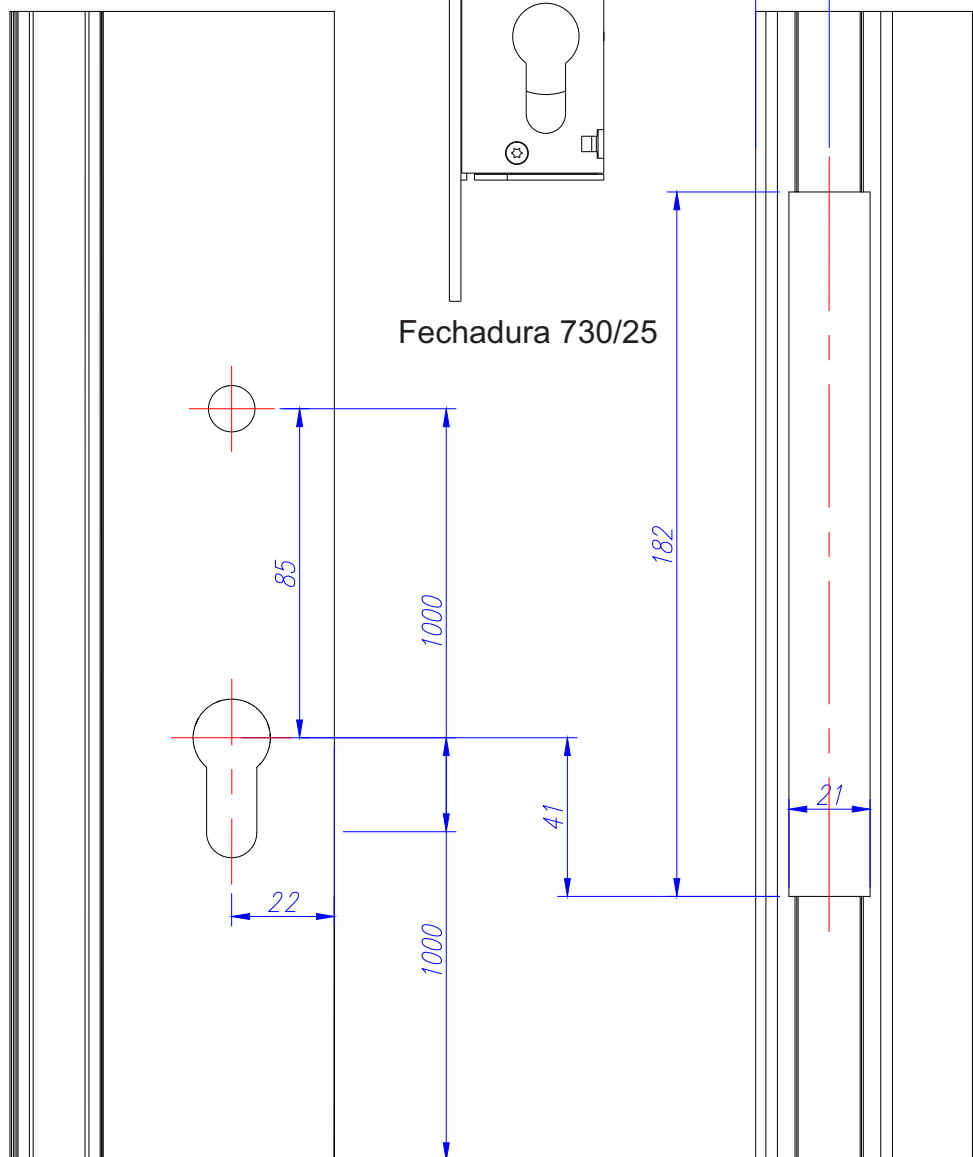
CREMONA



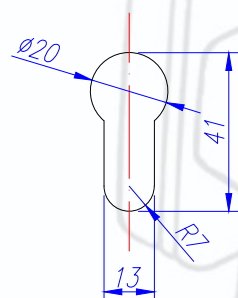
USINAGEM



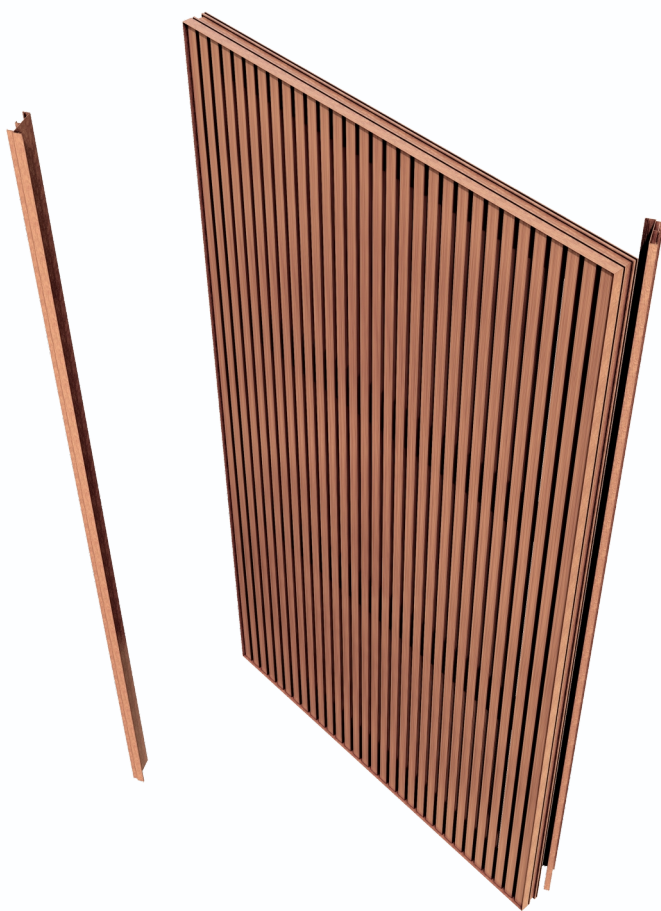
Fechadura 730/25



Maçaneta 9575



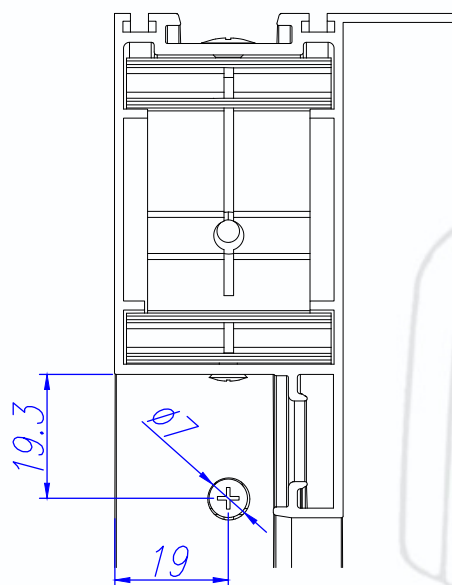
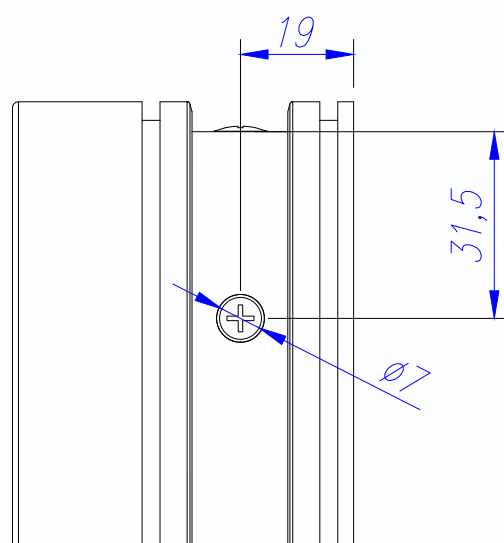
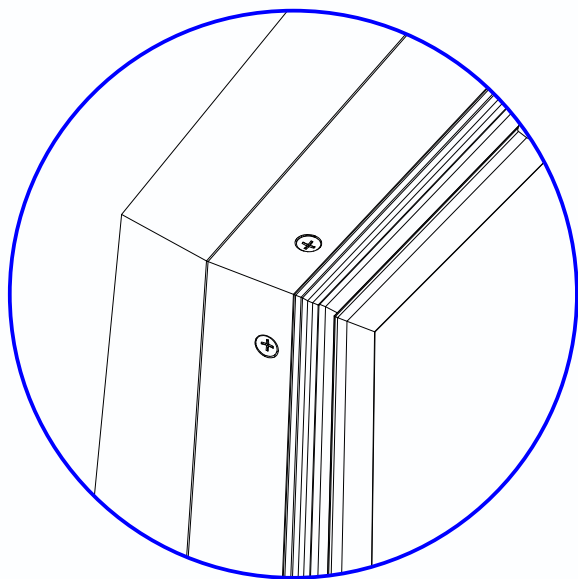
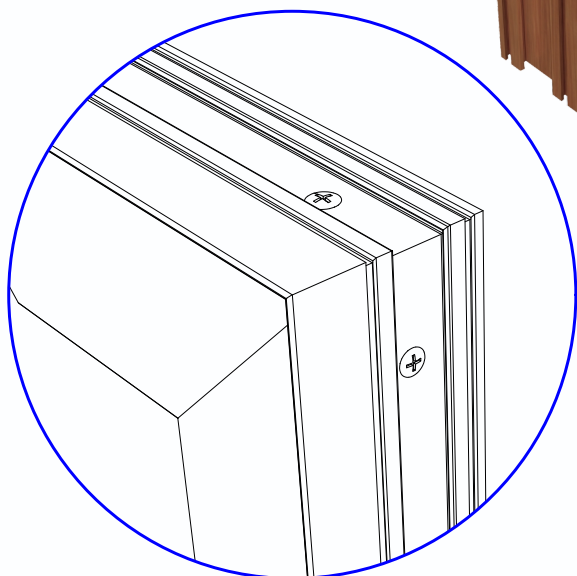
BRISE PIVOTANTE

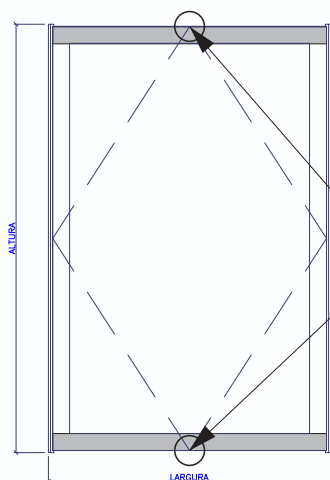


6. MONTAGEM DE ACESSÓRIOS - BRISE PIVOTANTE



MR67358C
Conexão Expansiva



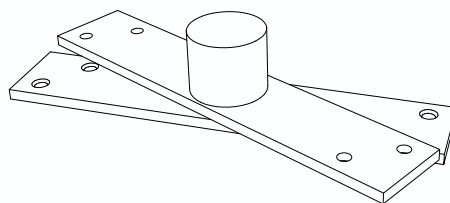
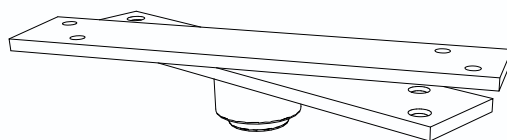


FURO Ø 35mm

FURO Ø 35mm

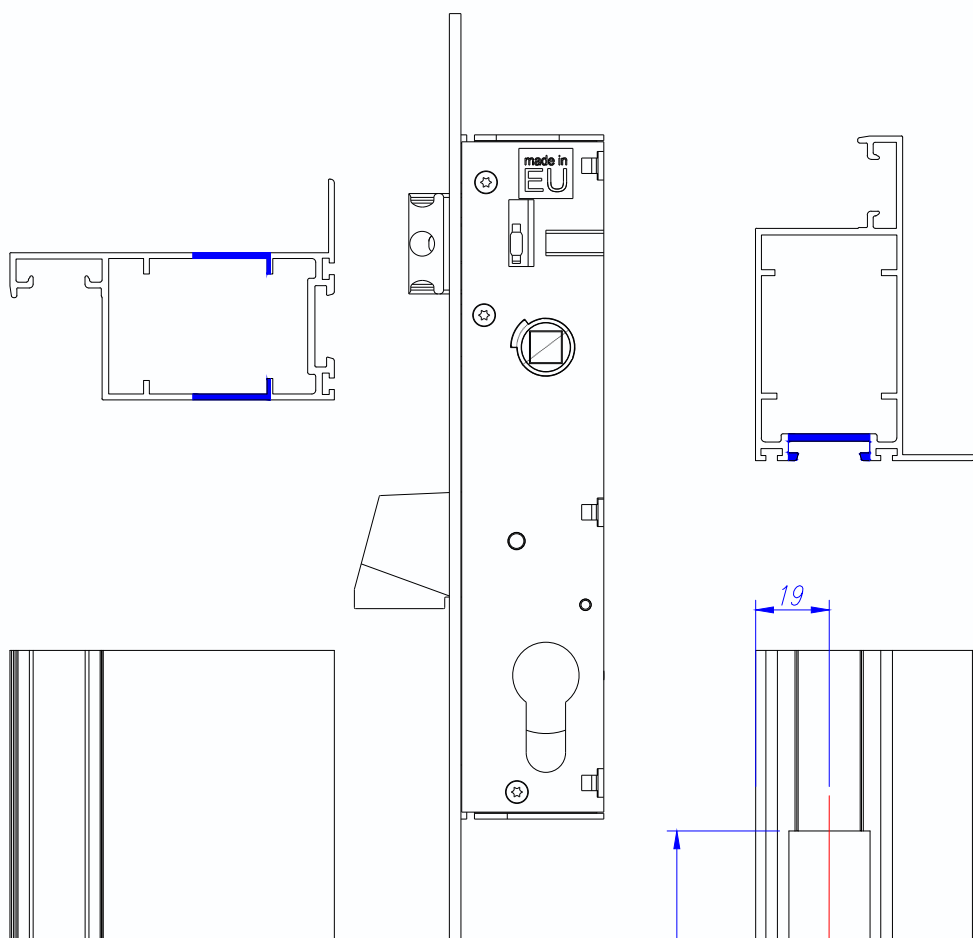
DIMENSÃO A DEFINIR PELO PROJETO

Perfil PBR-02

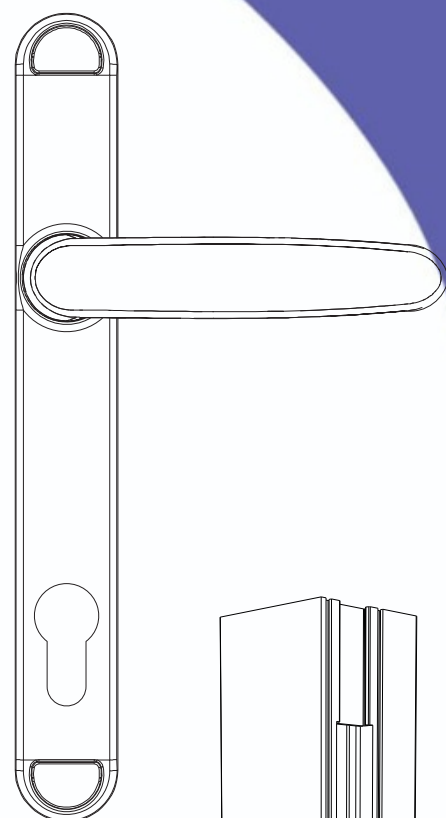
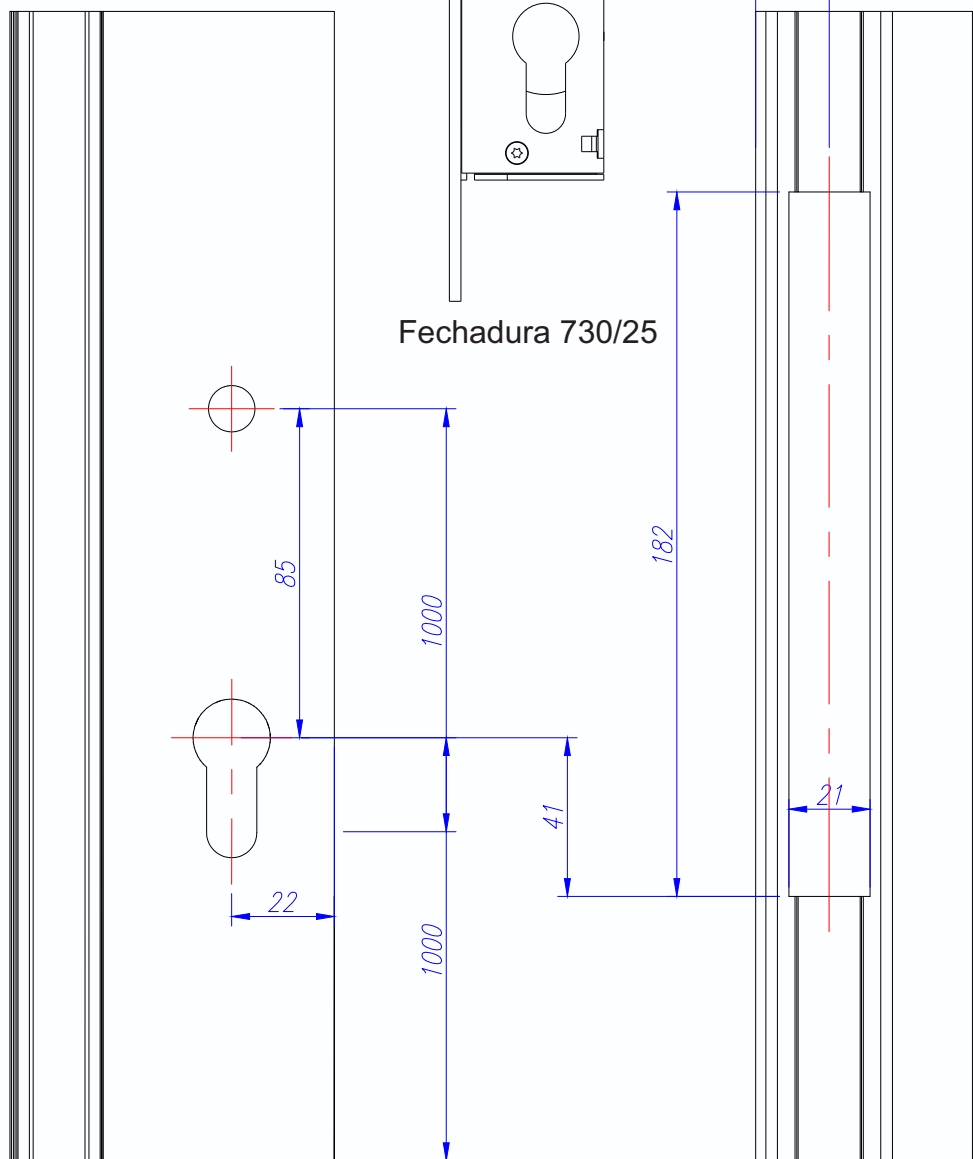


PIVOT INOX COM ESFERA

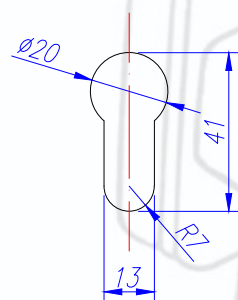
DOB-PV080 - DOBRADIÇA PIVOT 3/4"x1/8" C/BRILHO 80KG
 DOB-PV120 - DOBRADIÇA PIVOT D120 - 80x19mm C/BRILHO 120KG
 DOB-PV200 - DOBRADIÇA PIVOT D200 - 130x25mm C/BRILHO 200KG
 DOB-PV250 - DOBRADIÇA PIVOT 250KG FORT - 130x25mm C/ BRILHO
 DOB-PV350 MX - DOBRADIÇA PIVOT MX 1"x5/16"x180mm C/BRILHO 350KG
 DOB-PV500 PLUS - DOBRADIÇA PIVOT PLUS 1.1-4"x5/16"x180mm C/BRILHO 500KG



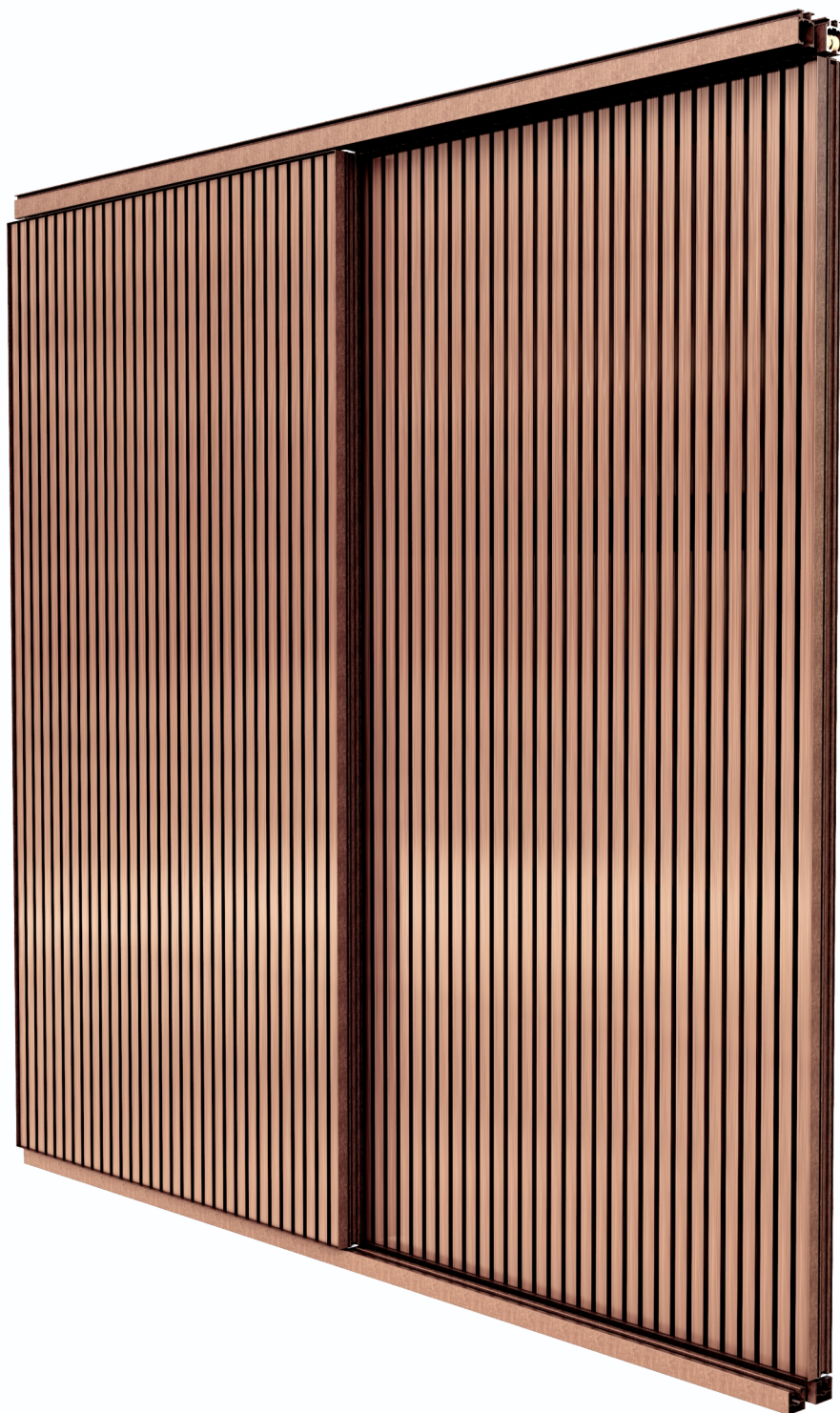
Fechadura 730/25



Maçaneta 9575



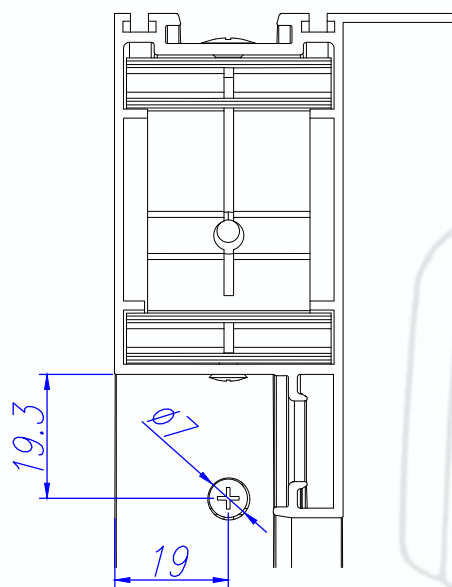
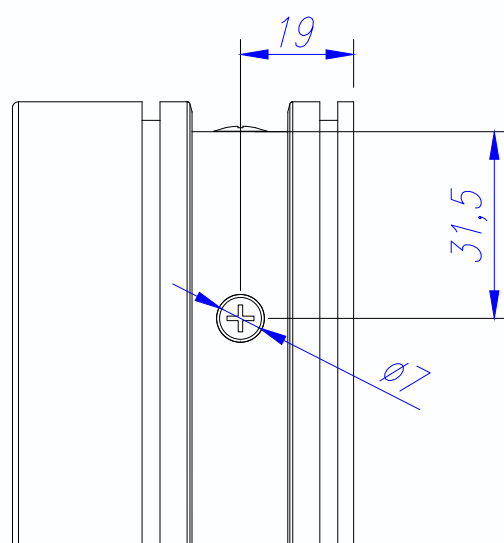
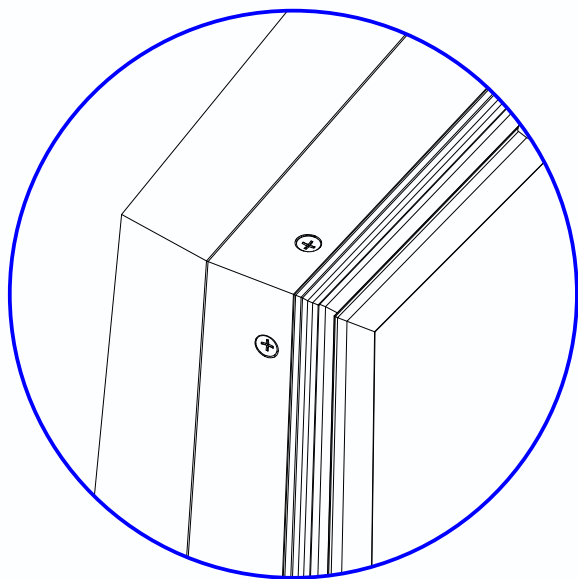
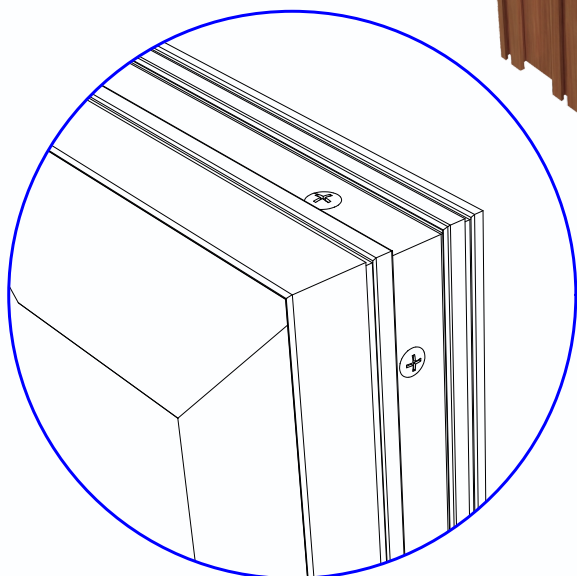
BRISE DE CORRER

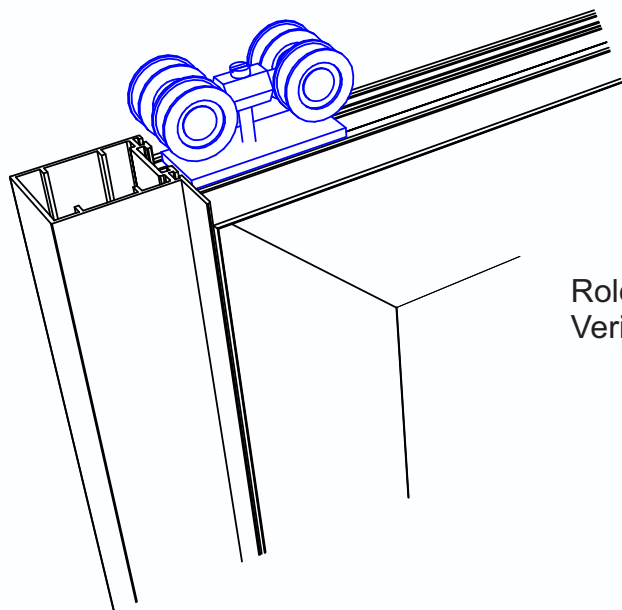


7. MONTAGEM DOS ACESSÓRIOS - BRISE DE CORRER

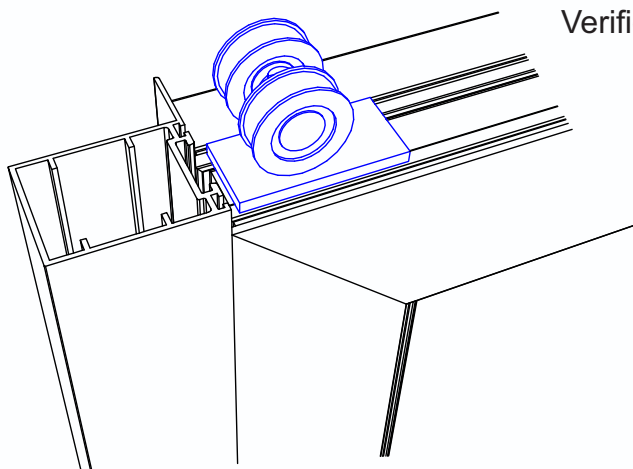
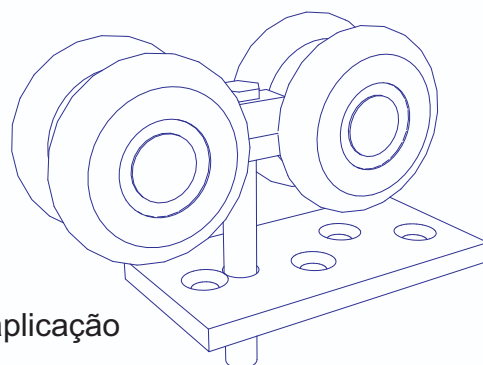


MR67358C
Conexão Expansiva

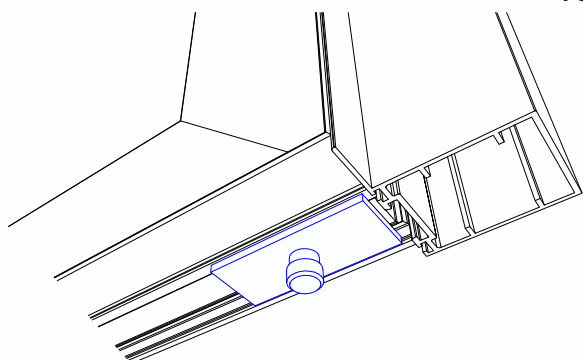




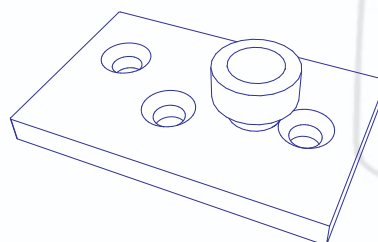
Roldana Dupla
Verificar código de aplicação

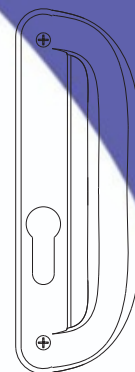
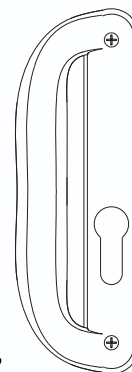
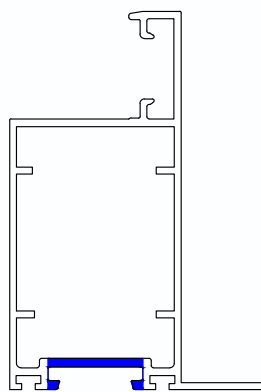
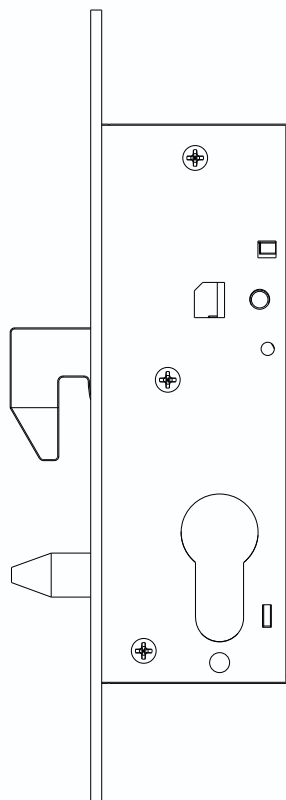
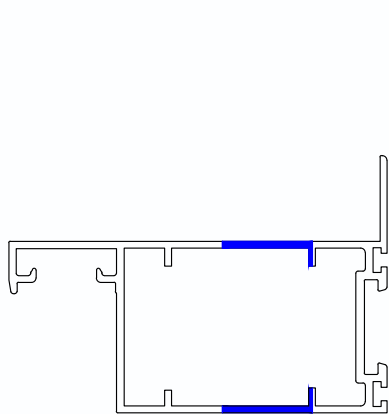


Roldana Simples
Verificar código de aplicação



Guia Inferior
Verificar código de aplicação

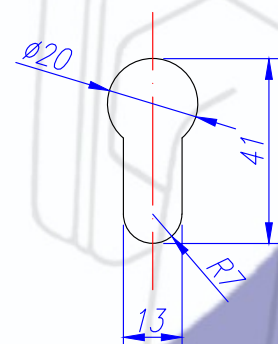
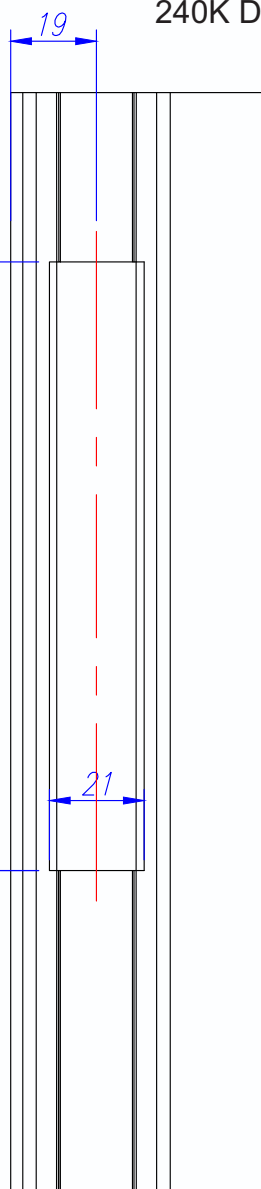
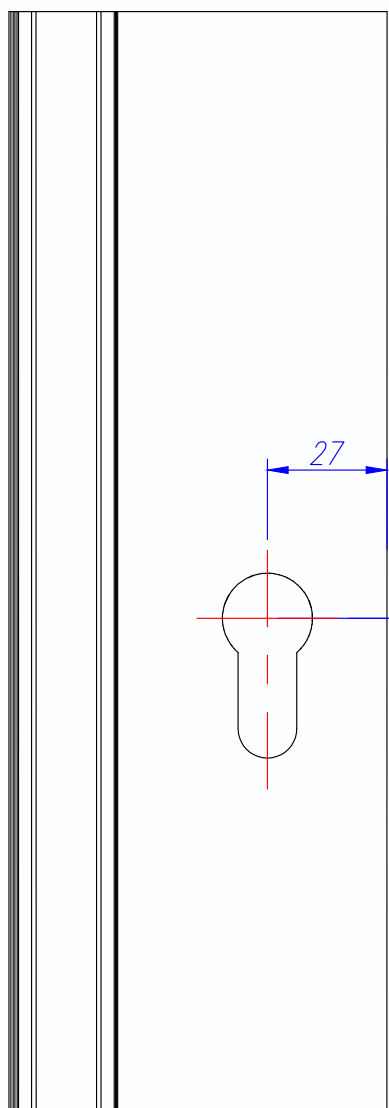


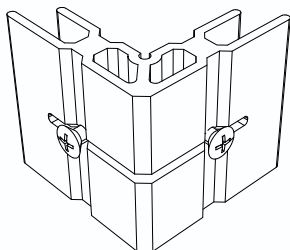


Puxador
240K DTO

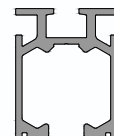
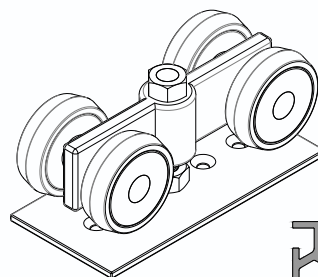
Puxador
240K ESQ

Fechadura 732

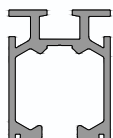
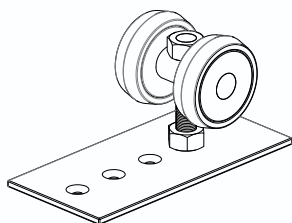




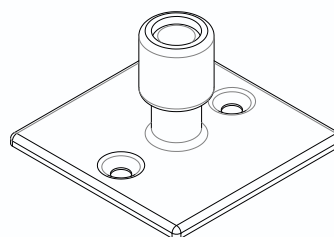
CONEXÃO EXPANSIVA
MR67358C



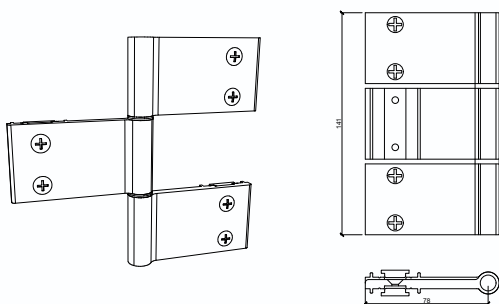
ROLDANA DUPLA 300Kg
ROLDG300



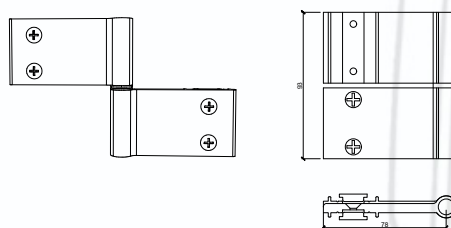
ROLDANA SIMPLES 150Kg
ROLDG150



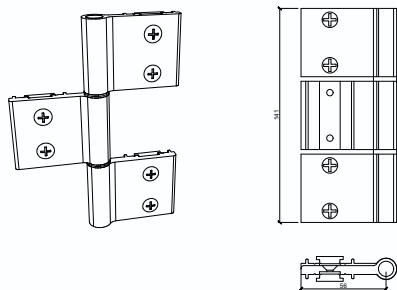
GUIA INFERIOR
GUA12



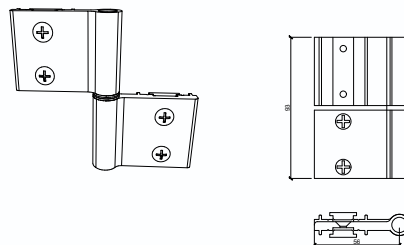
DOBRADIÇA DE BALANÇO TRIPLA
DOB-BR01T



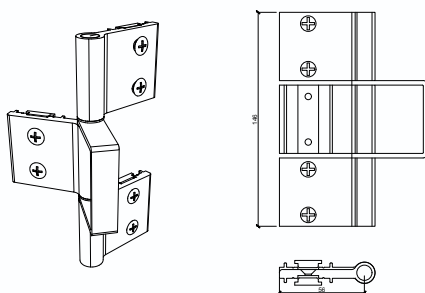
DOBRADIÇA DE BALANÇO
DOB-BR01



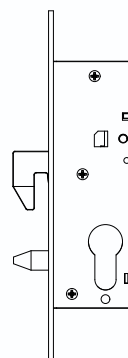
DOBRADIÇA TRIPLA
DOB-BR02T



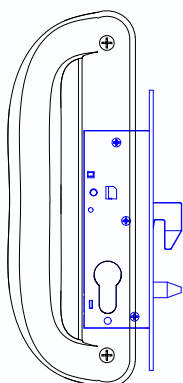
DOBRADIÇA
DOB-BR02



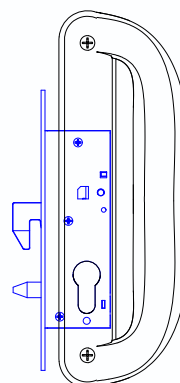
DOBRADIÇA TRIPLA COM PUXADOR
DOB-BR02T PUX



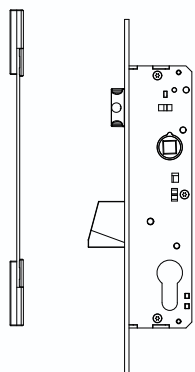
FECHADURA DE CORRER
732LG



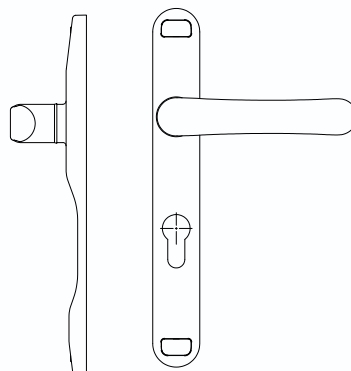
PUXADOR CILINDRO EUROPEU
240KE - ESQUERDO



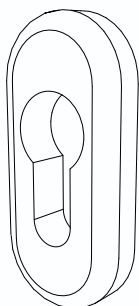
PUXADOR CILINDRO EUROPEU
240KD - DIREITO



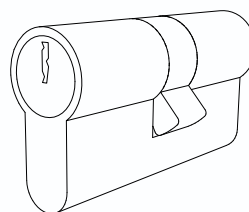
**FECHADURA DE GIRO
730/25**



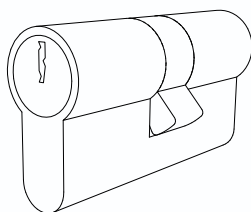
**MAÇANETAA DE GIRO
9575**



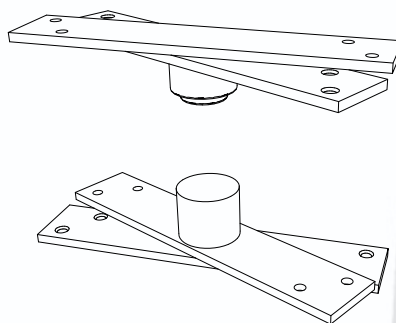
**ROSETA CILINDRO EUROPEU
M69**



**CILINDRO 30 / 50
E100 30/50**

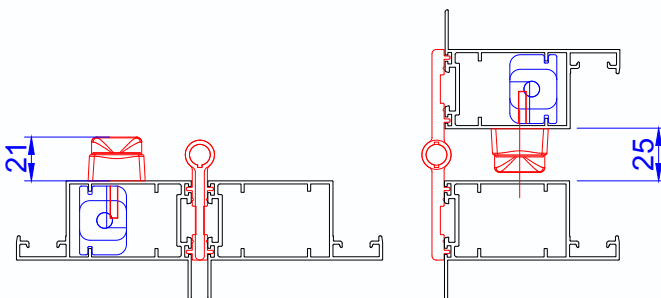
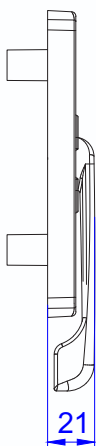
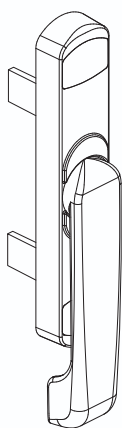


**CILINDRO 30 / 60
E100 30/60**

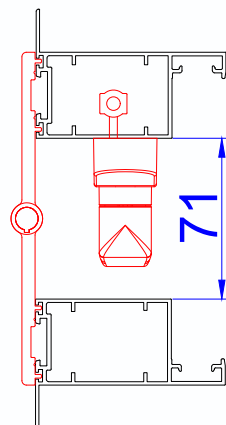
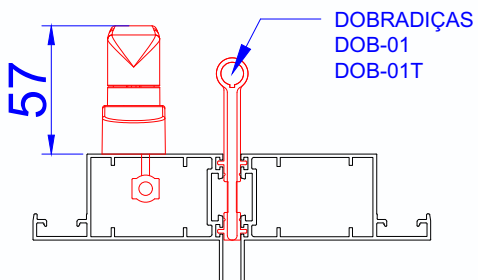
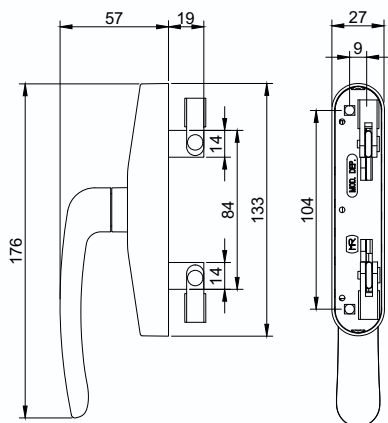


PIVOT INOX COM ESFERA

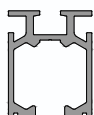
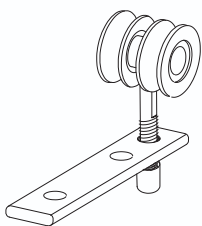
DOB-PV080 - DOBRADIÇA PIVOT 3/4"x1/8" C/BRILHO 80KG
DOB-PV120 - DOBRADIÇA PIVOT D120 - 80x19mm C/BRILHO 120KG
DOB-PV200 - DOBRADIÇA PIVOT D200 - 130x25mm C/BRILHO 200KG
DOB-PV250 - DOBRADIÇA PIVOT 250KG FORT - 130x25mm C/ BRILHO
DOB-PV350 MX - DOBRADIÇA PIVOT MX 1"x5/16"x180mm C/BRILHO 350KG
DOB-PV500 PLUS - DOBRADIÇA PIVOT PLUS 1.1-4"x5/16"x180mm C/BRILHO 500KG



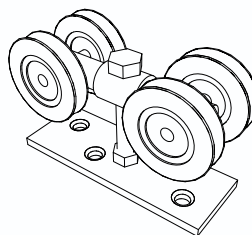
CREMONA BAIXA
MR-2100



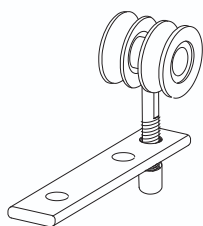
DOBRADIÇAS
DOB-01
DOB-01T



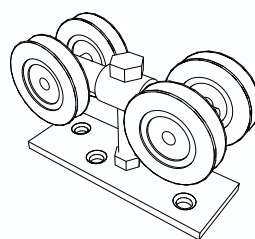
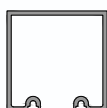
ROLDANA SIMPLES 150Kg
ROLDG150



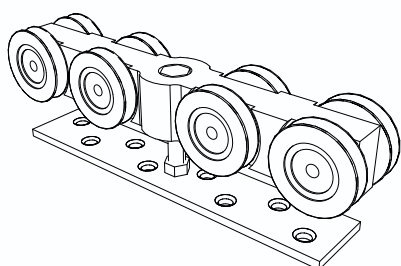
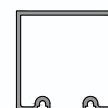
ROLDANA DUPLA 300Kg
ROLDG300



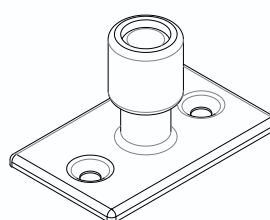
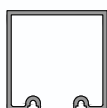
10.98.11
ROLDANA SIMPLES 40KG
PERFIL PBR-11



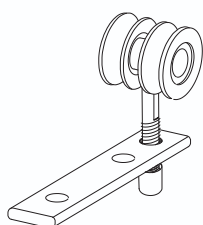
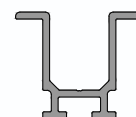
10.12.11
ROLDANA DUPLA 80KG
PERFIL PBR-11



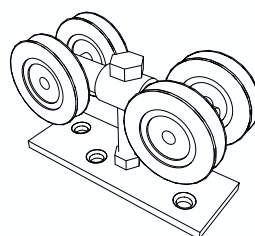
10.17.00 - PAR
ROLDANA QUADRUPLA 160KG
PERFIL PBR-11



10.04.10
GUIA INFERIOR 12mm



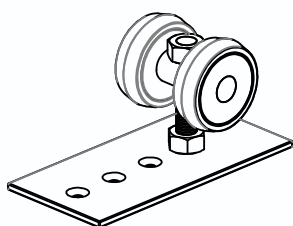
10.03.11
ROLDANA SIMPLES 20KG
PERFIL PBR-14



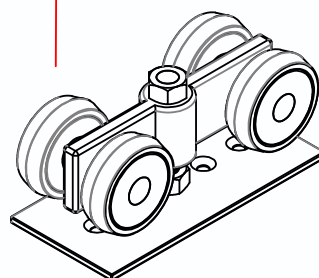
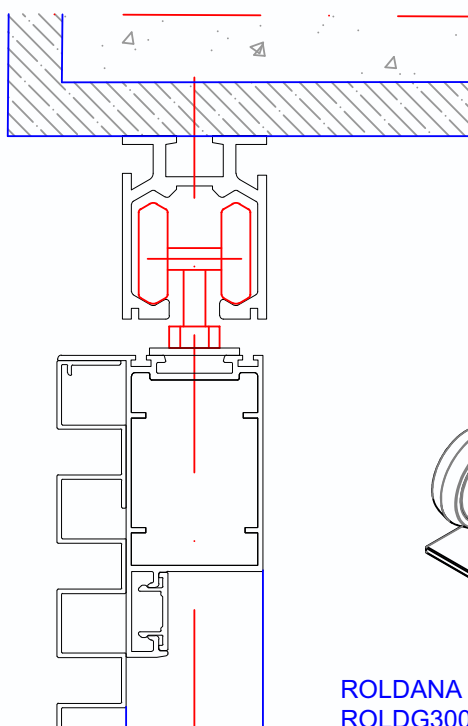
10.05.11
ROLDANA DUPLA 40KG
PERFIL PBR-14



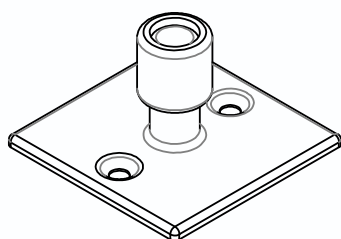
SISTEMA DE BRISE



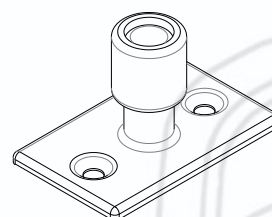
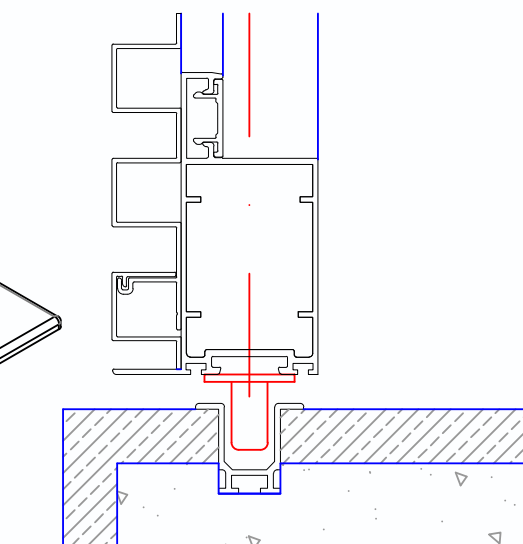
ROLDANA SIMPLES 150Kg
ROLDG150



ROLDANA DUPLA 300Kg
ROLDG300

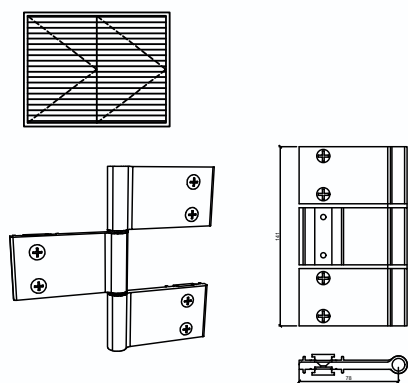


GUIA INFERIOR
511k

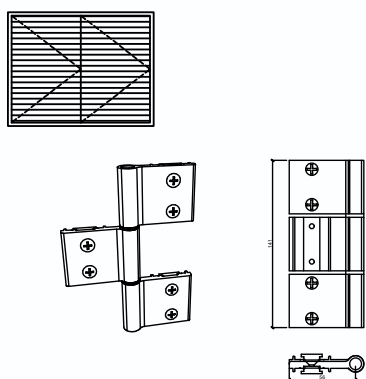
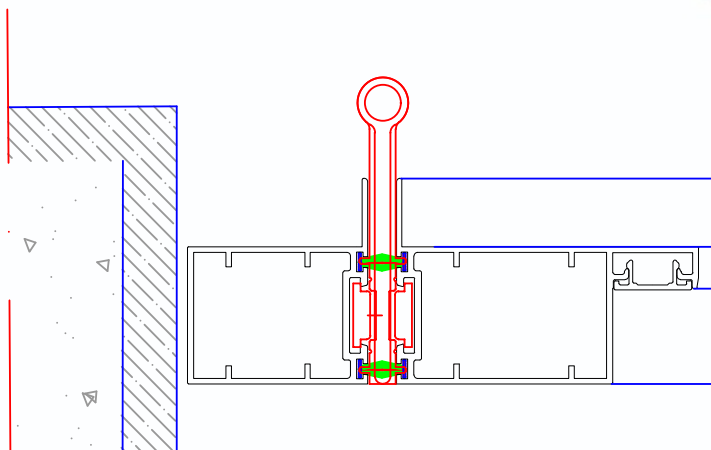


14.04.10
GUIA INFERIOR 12mm

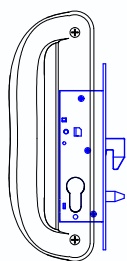
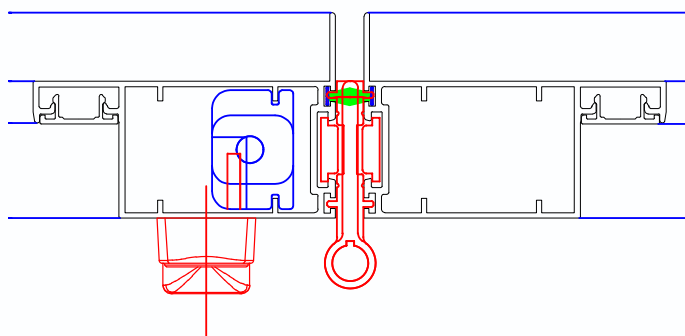
SISTEMA DE BRISE



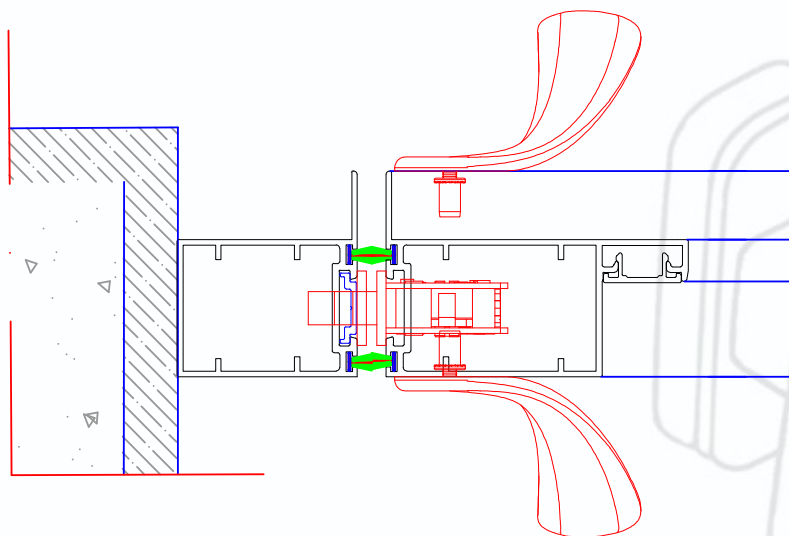
DOBRADIÇA DE BALANÇO TRIPLA
DOB-BR01T



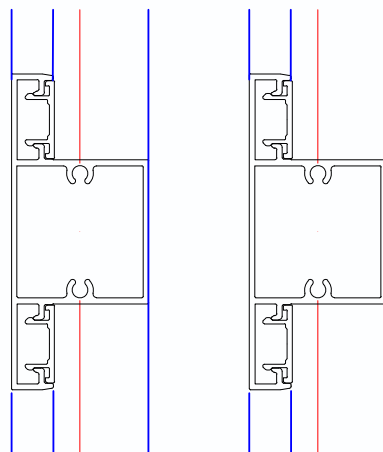
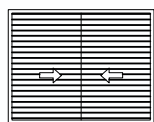
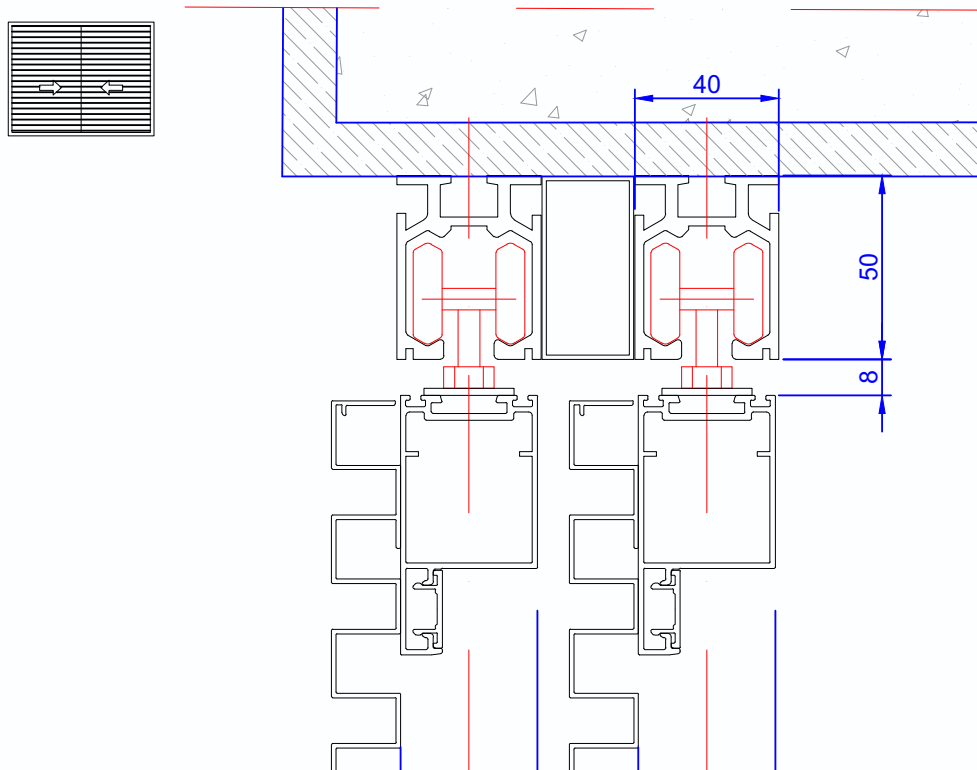
DOBRADIÇA TRIPLA
DOB-BR02T



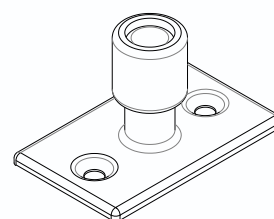
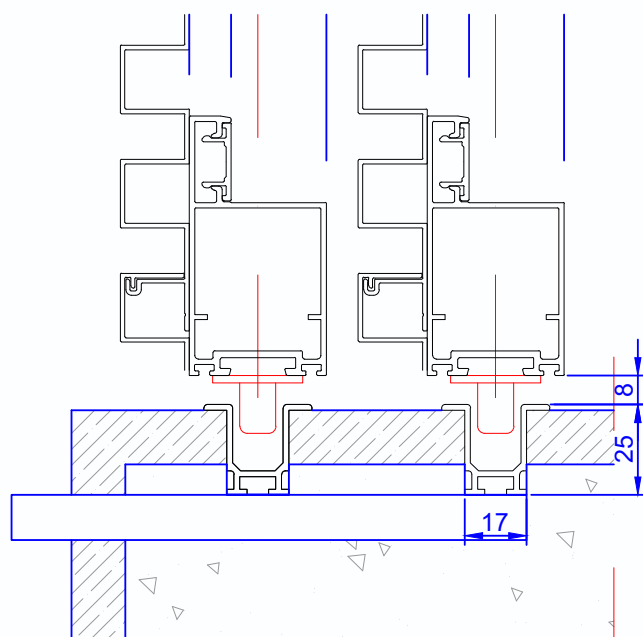
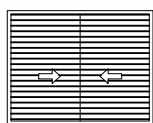
FECHADURA BICO DE PAPAGAIO
PUXADOR ESQ / DIREITO
CILINDRO EUROPEU



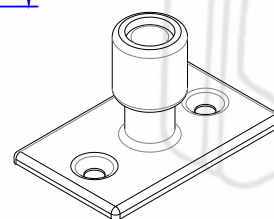
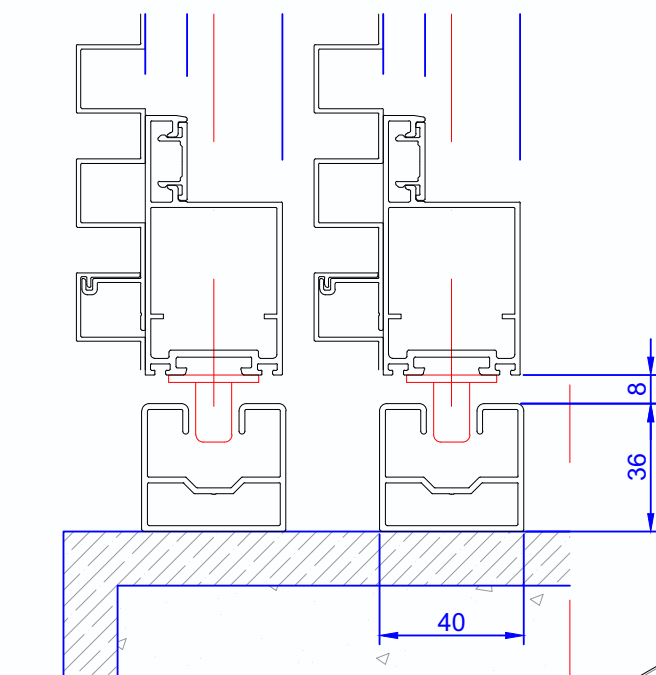
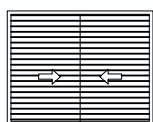
SISTEMA DE BRISE



SISTEMA DE BRISE

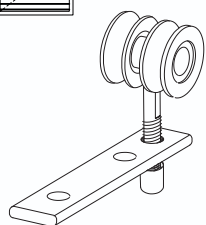
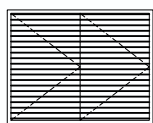


14.04.10
GUIA INFERIOR 12mm

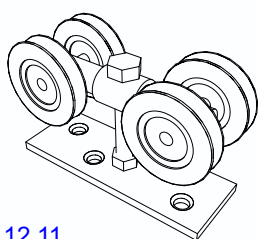


14.04.10
GUIA INFERIOR 12mm

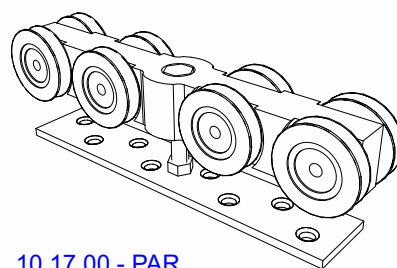
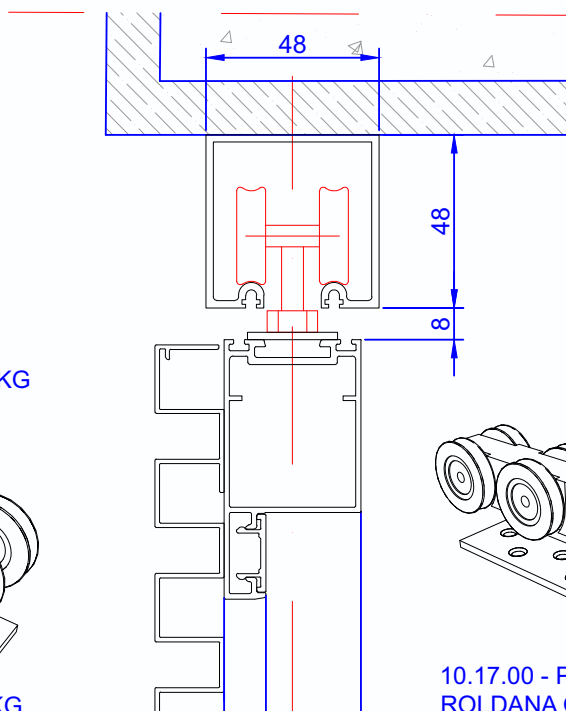
SISTEMA DE BRISE



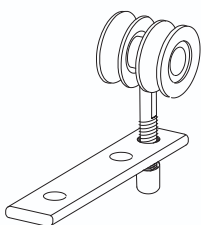
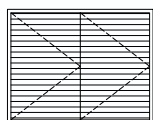
10.98.11
ROLDANA SIMPLES 40KG
PERFIL PBR-11



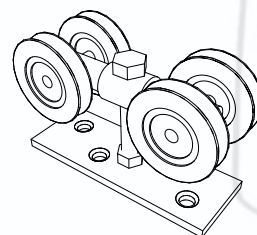
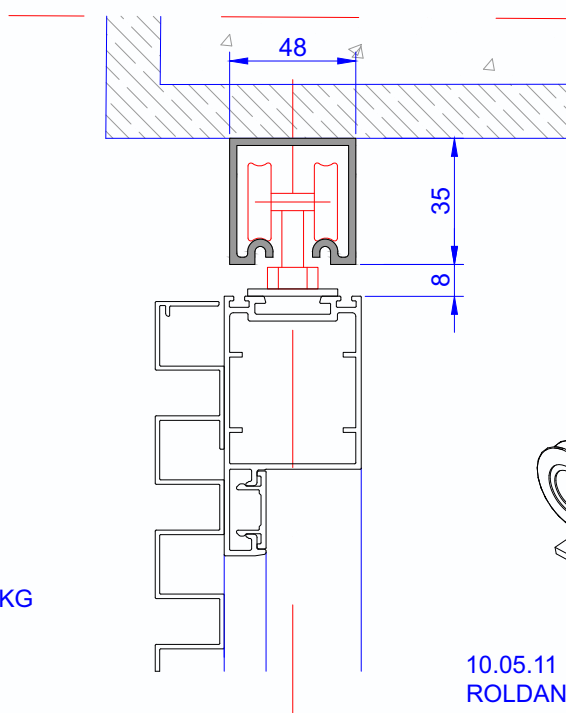
10.12.11
ROLDANA DUPLA 80KG
PERFIL PBR-11



10.17.00 - PAR
ROLDANA QUADRUPLA 160KG
PERFIL PBR-11



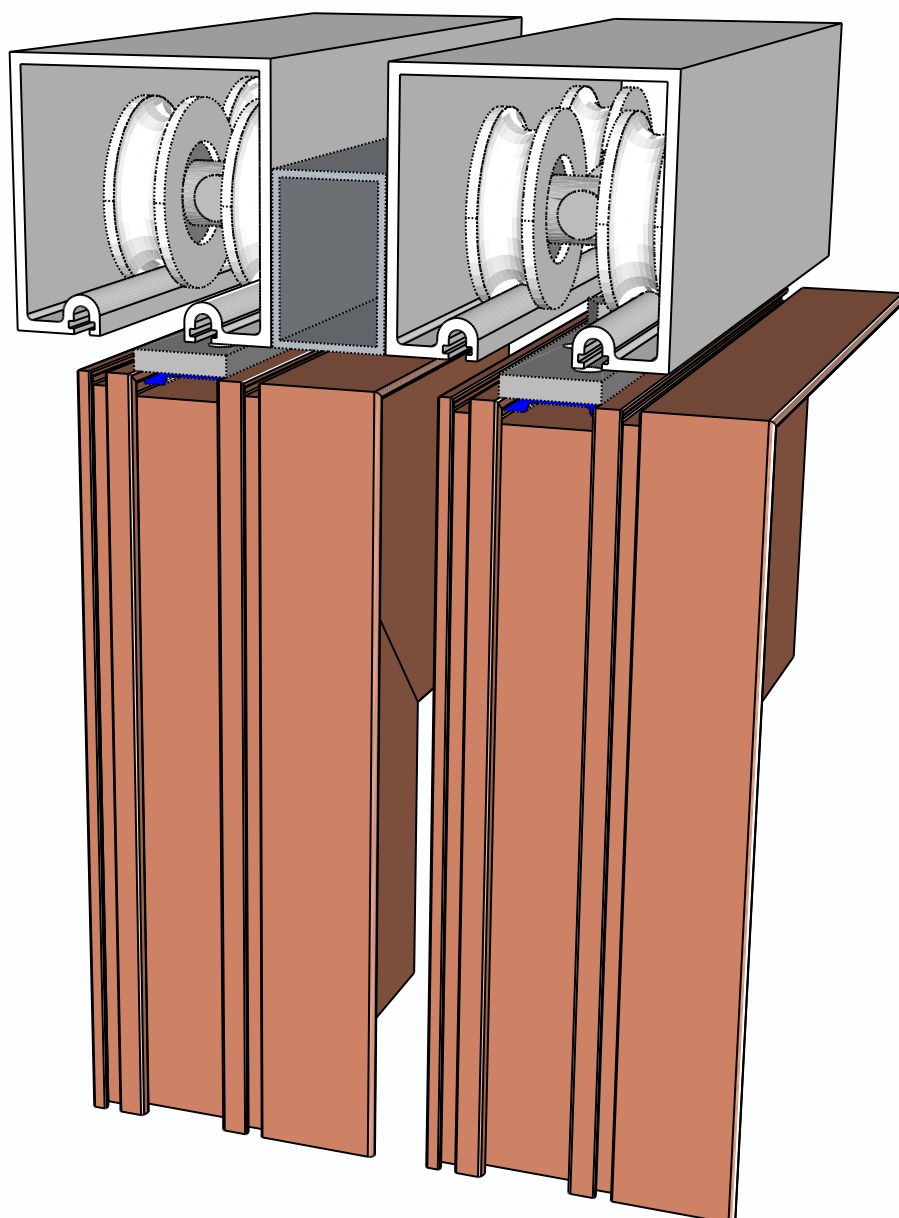
10.03.11
ROLDANA SIMPLES 20KG
PERFIL PBR-14



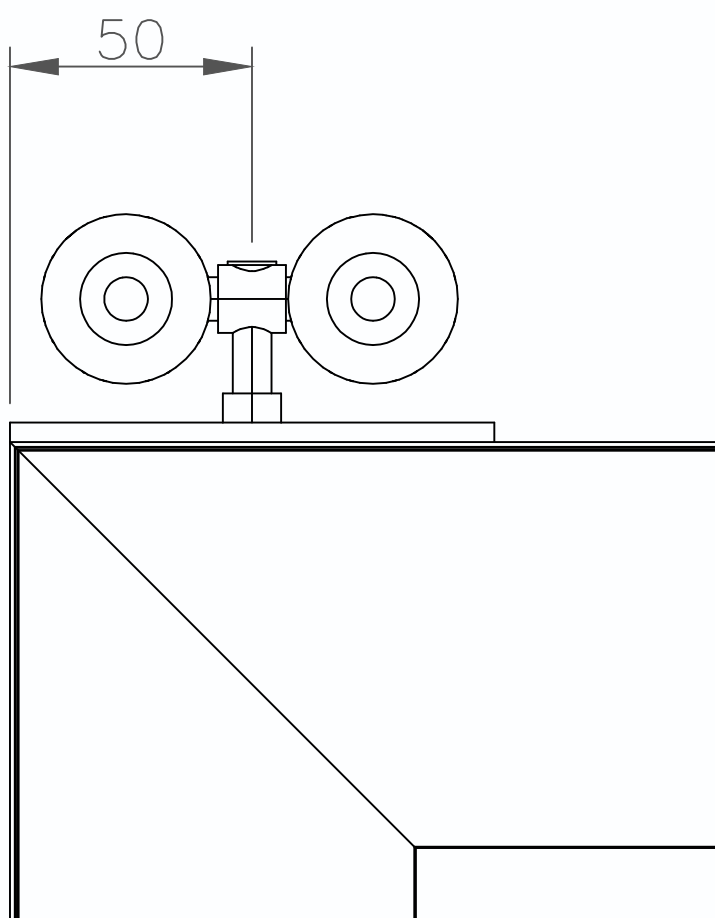
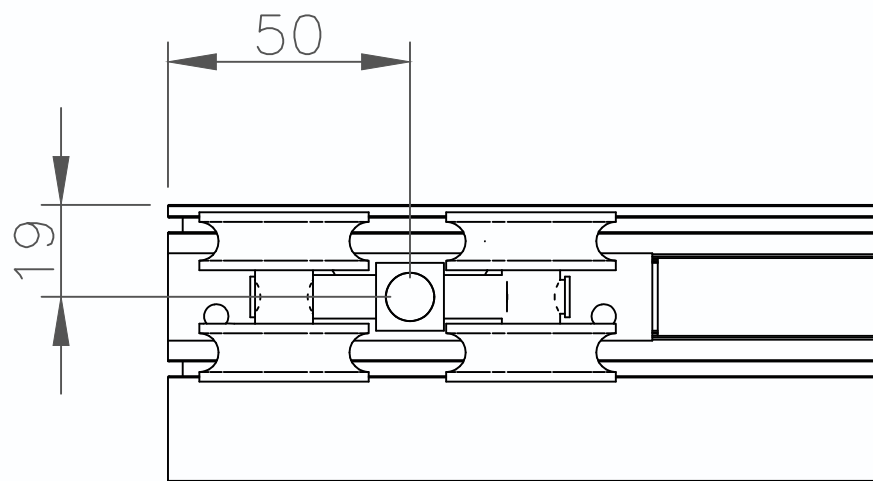
10.05.11
ROLDANA DUPLA 40KG
PERFIL PBR-14

SISTEMA DE BRISE

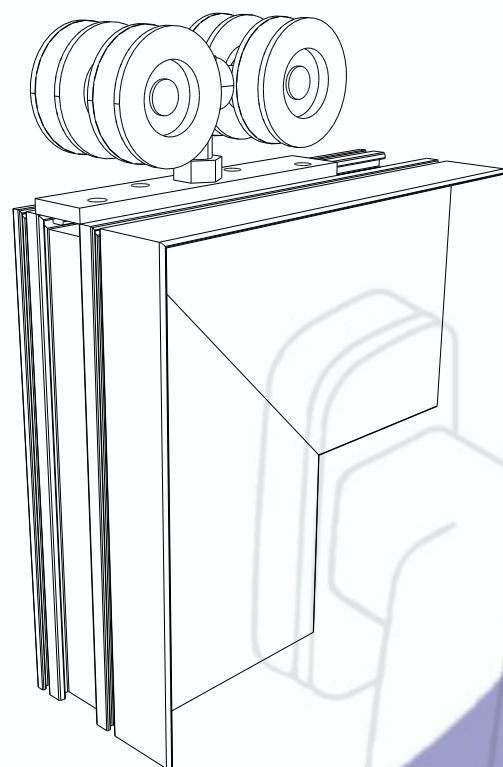
ACABAMENTO ENTRE TRILHOS COM TUBO 20x30 - TG002



SISTEMA DE BRISE CALCULO DA DIMENSÃO DAS FOLHAS

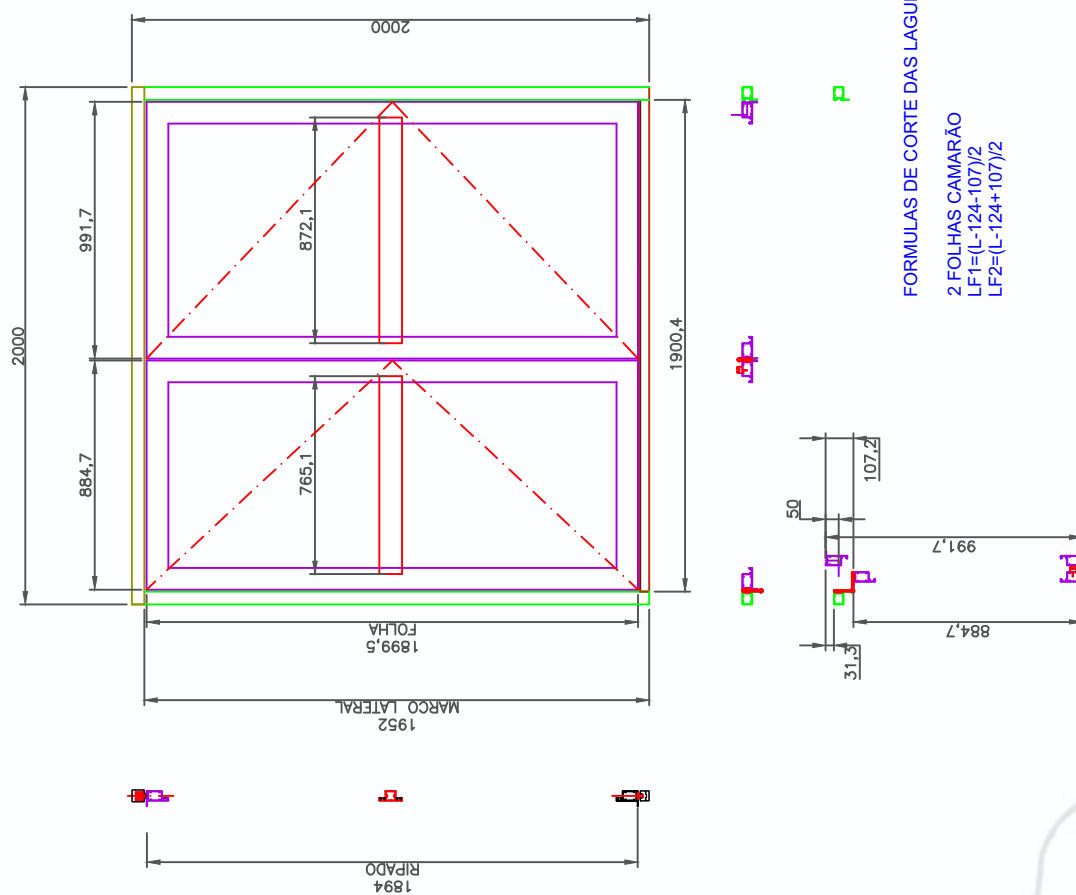


POSICIONAMENTO DA ROLDANA DUPLA



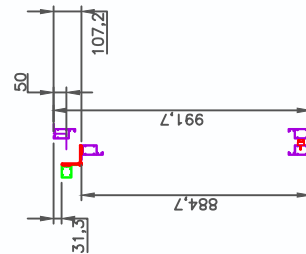
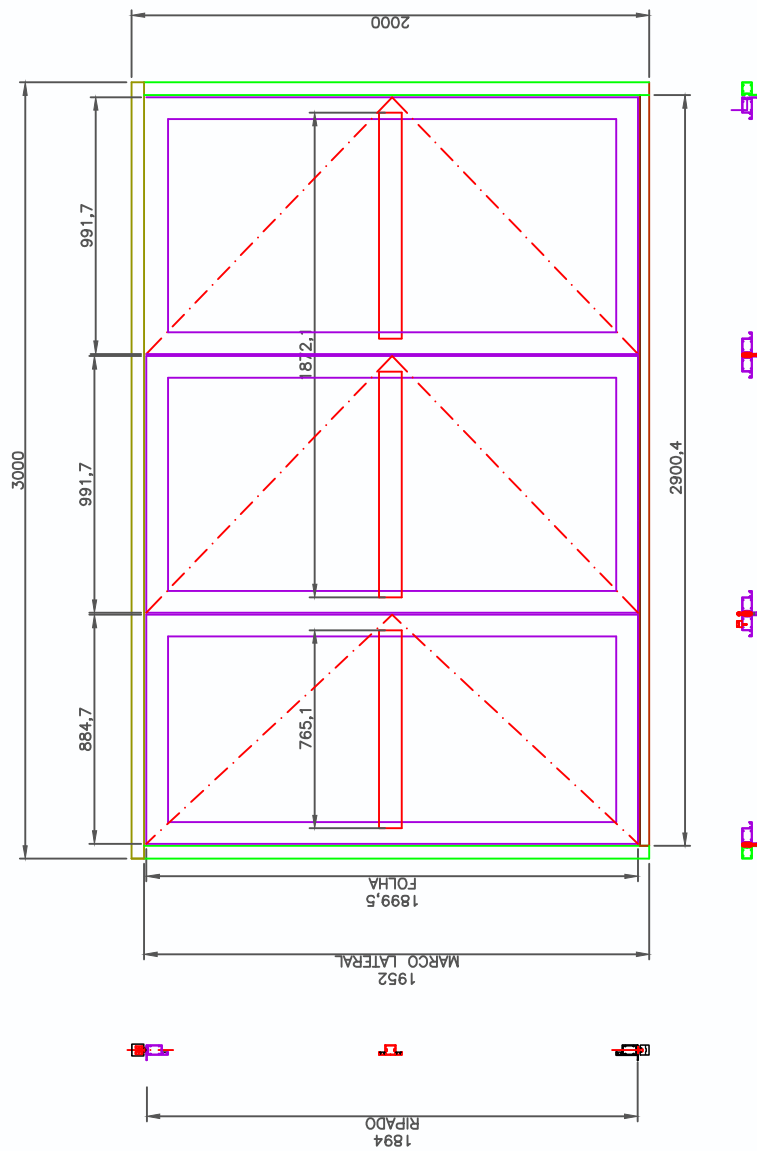
SISTEMA DE BRISE

CALCULO DA DIMENSÃO DAS FOLHAS



SISTEMA DE BRISE

CALCULO DA DIMENSÃO DAS FOLHAS

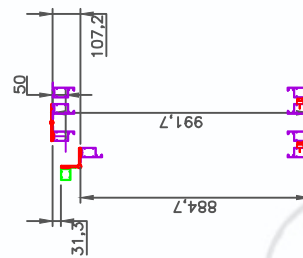


FORMULAS DE CORTE DAS LAGURAS DAS FOLHAS

3 FOLHAS CAMARÃO

$LF1 = (L - 132 - 214) / 3$

$LF2 = (L - 132 + 107) / 3$



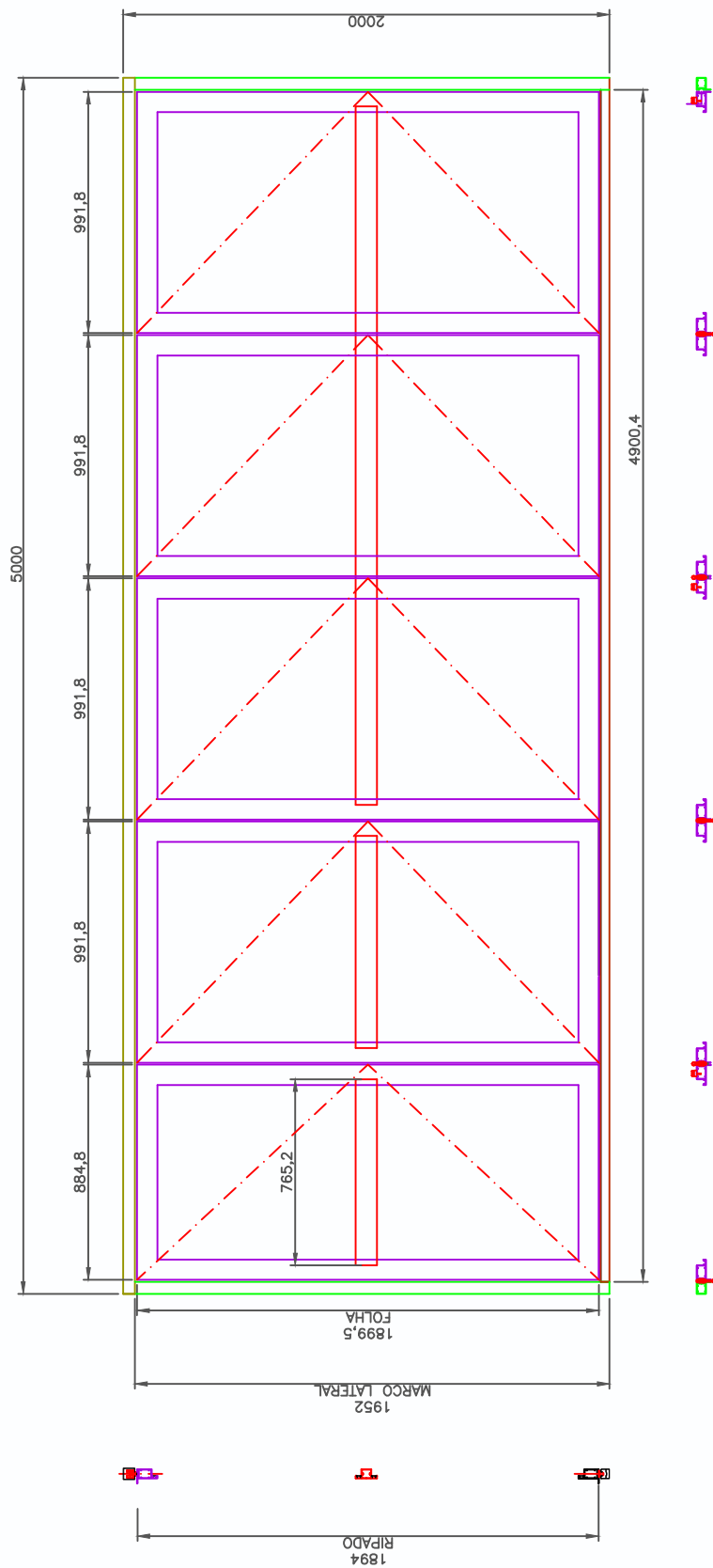
4 FOLHAS CAMARÃO

$$LF1=(L-140-321)/4$$

$$\begin{aligned} LF1 &= (L-140-321)/4 \\ LF2 &= (L-140+107)/4 \end{aligned}$$

SISTEMA DE BRISE

CALCULO DA DIMENSÃO DAS FOLHAS

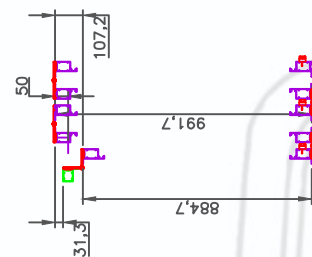


FORMULAS DE CORTE DAS LAGURAS DAS FOLHAS

4 FOLHAS CAMARÃO

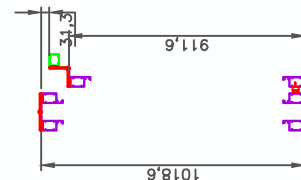
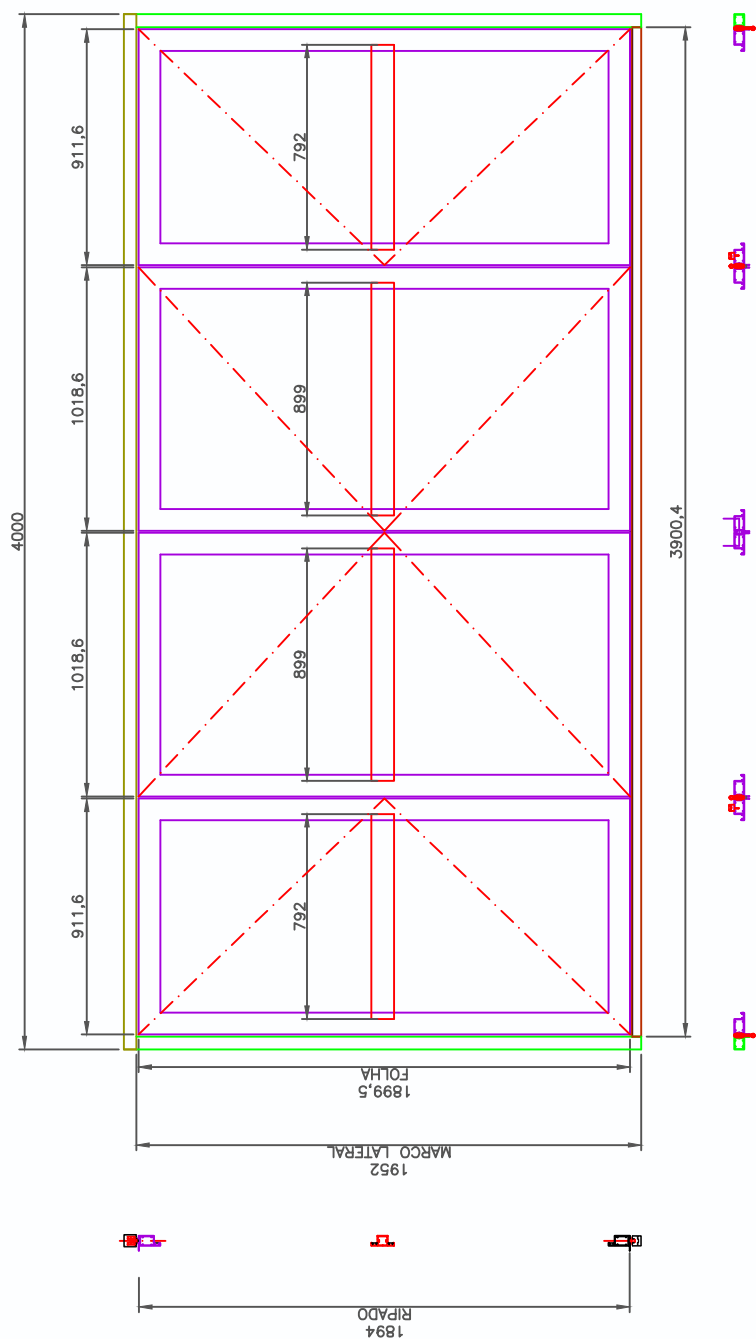
LF1=(L-148-428)/4

LF2=(L-148+107)/4



SISTEMA DE BRISE

CALCULO DA DIMENSÃO DAS FOLHAS

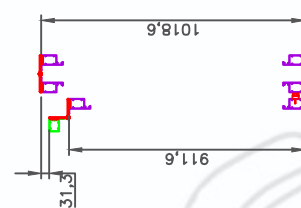


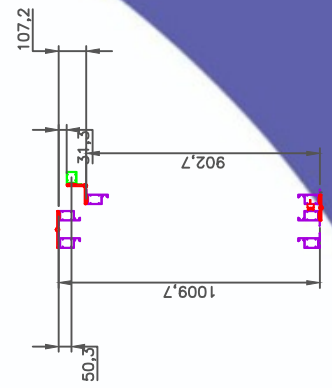
FORMULAS DE CORTE DAS LAGURAS DAS FOLHAS

4 FOLHAS (2+2) CAMARÃO

LF1=(L-140-214)/4

LF2=(L-140+214)/4

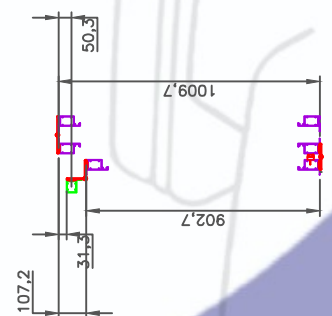




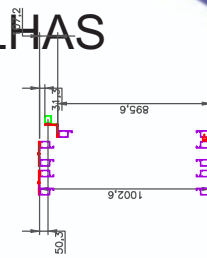
6 FOLHAS (3+3) CAMARÃO

$$LF1 = (L - 156 - 428) / 6$$

$$LF2=(L-156+214)/6$$






$$\begin{aligned} \text{LF1} &= (L-188-856)/10 \\ \text{LF2} &= (L-188+214)/10 \end{aligned}$$
