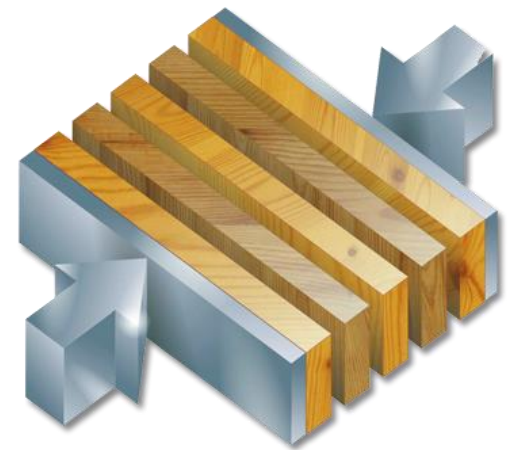
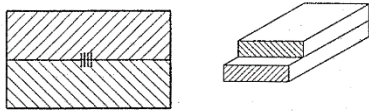
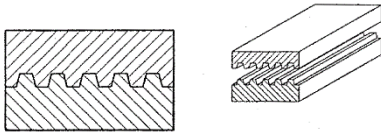


Nastavljanje gredica po debljini

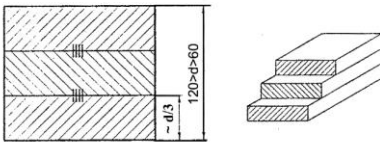




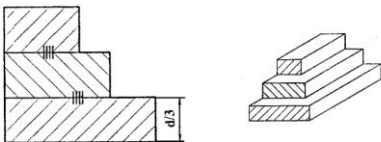
Debljinsko nastavljanje na ravnu sljubnicu



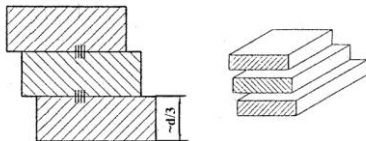
Debljinsko nastavljanje klinastim zatupljenim zupcima



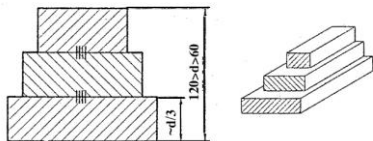
Troslojno debljinsko nastavljanje na ravnu sljubnicu



Troslojno debljinsko nastavljanje na ravnu sljubnicu, asimetrično



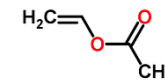
Troslojno debljinsko nastavljanje na ravnu sljubnicu, dvostrano asimetrično



Troslojno debljinsko nastavljanje na ravnu sljubnicu, dvostrano asimetrično

Tehnološke operacije

1. Priprema površine za lepljenje
2. Kontrola i slaganje gredica
3. Izbor lepka i nanošenje lepka
4. Presovanje
5. Kondicioniranje
6. Obrada sastava

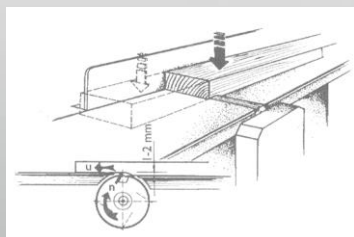


1.Faza

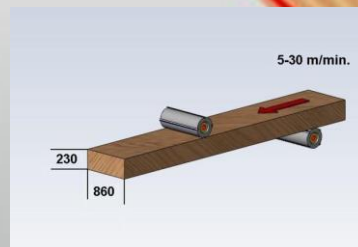
Dimenzionisanje poprečnog preseka (3 načina)



1. način

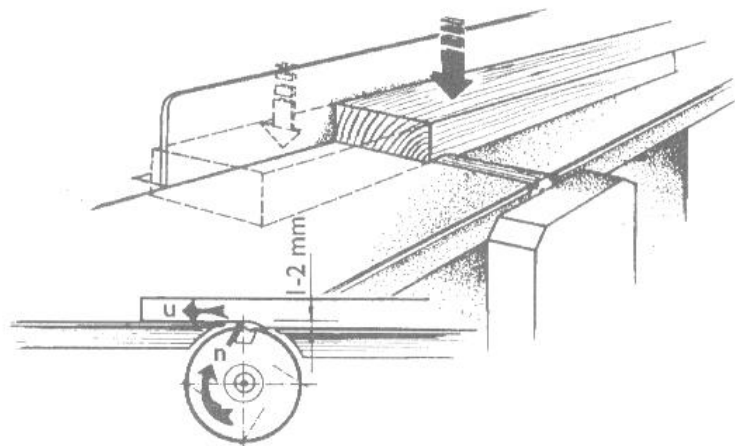


2. način

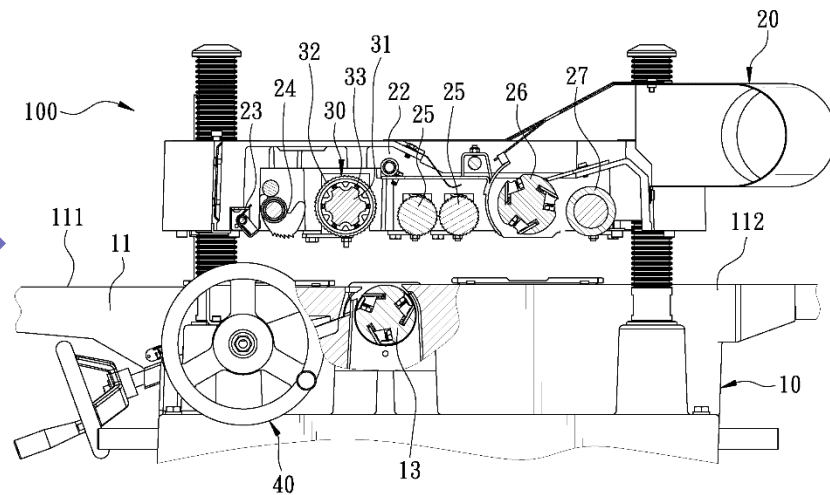
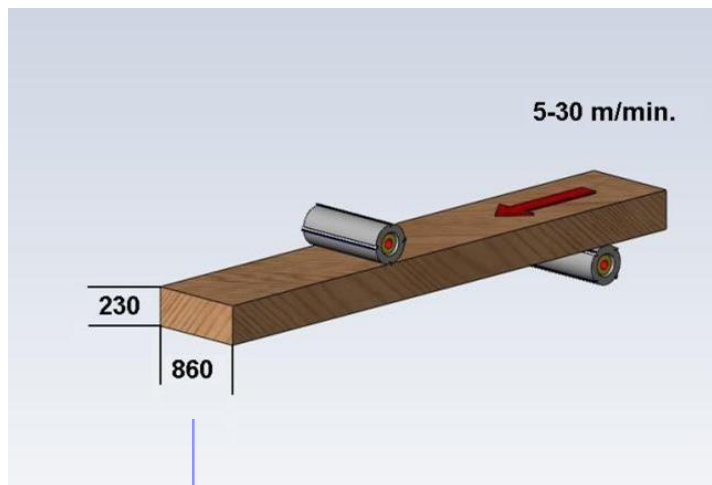


3. način





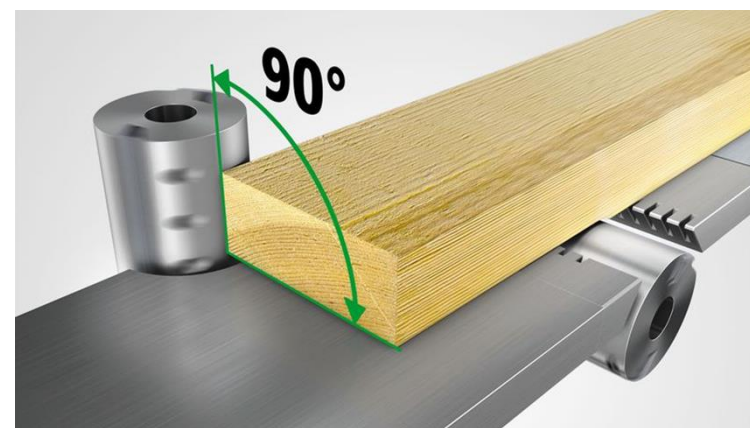
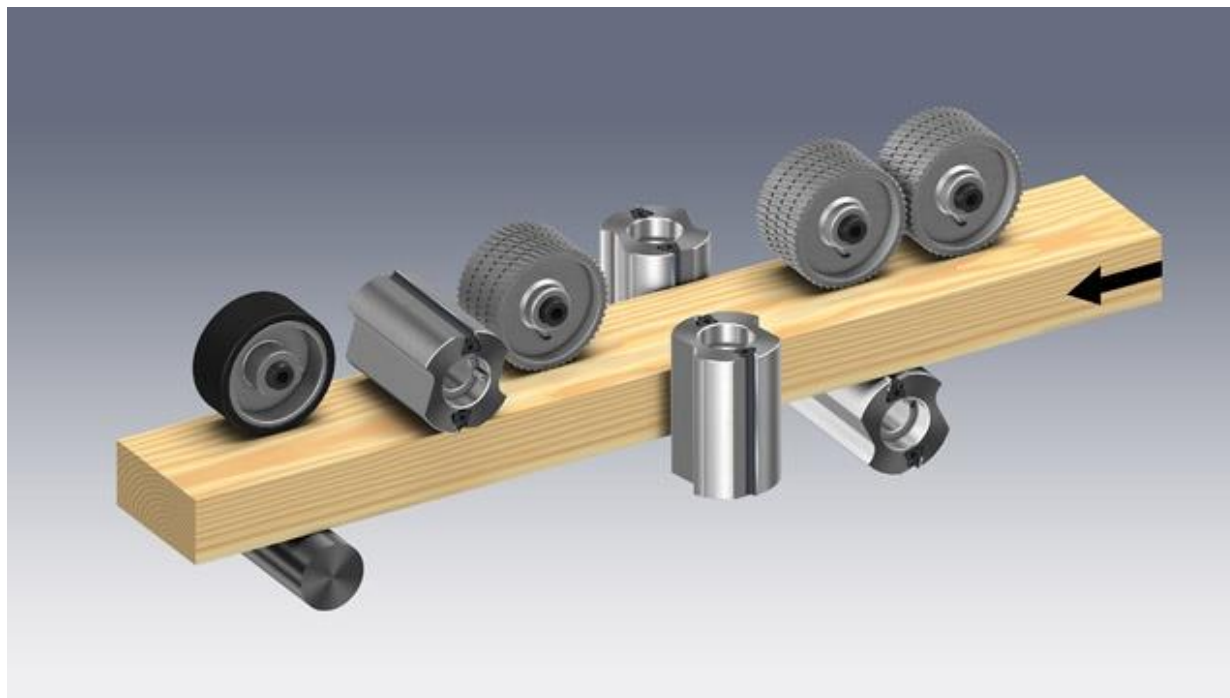
2. način



$b = 400 \div 860 (600)$
($\wedge 50$ mm) mm

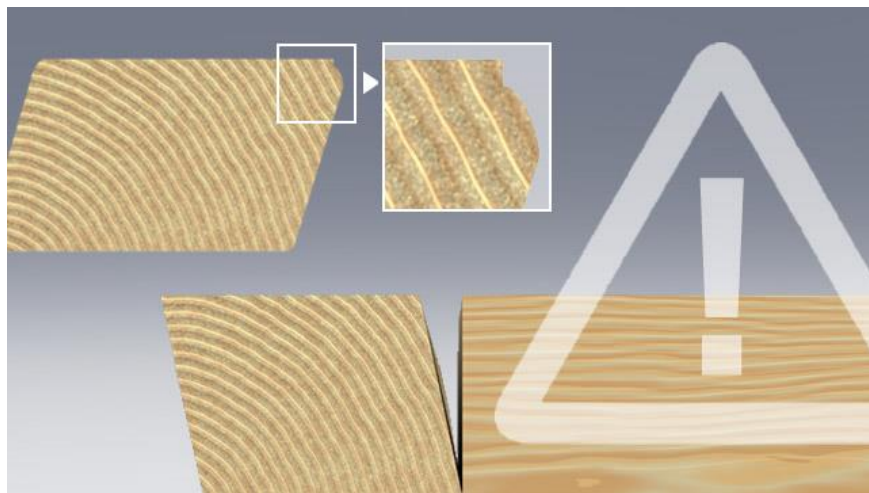


https://www.youtube.com/watch?v=pUQD_YVAzWY&t=39s

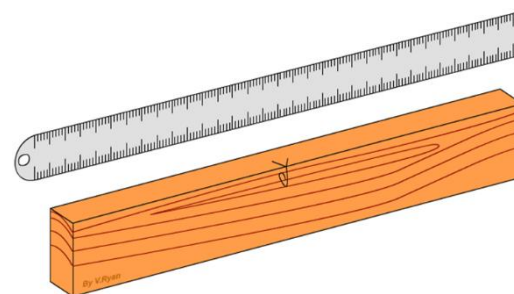
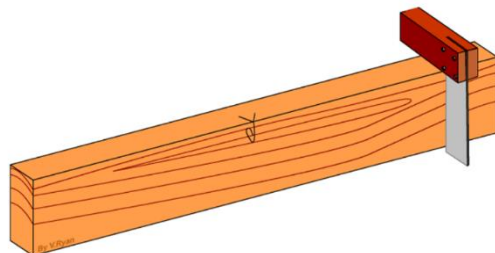
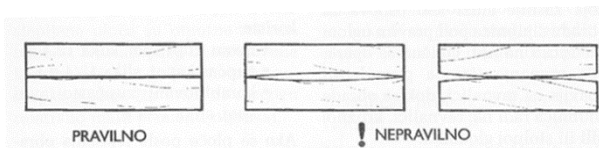


2. Faza

Kontrola i slaganje gredica

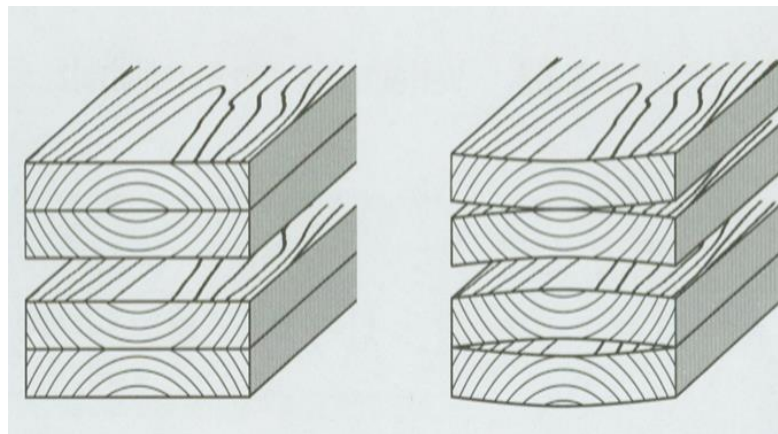


Kontrola kvaliteta obrade



Slaganje gredica

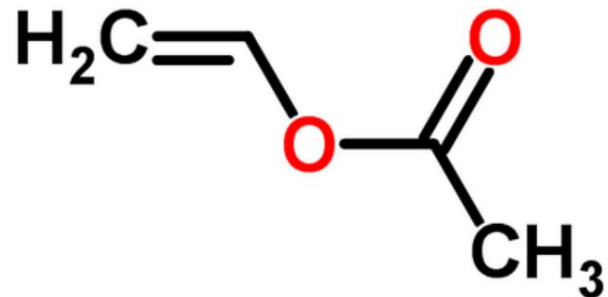
- „Po dimenzijama“
- Po teksturi (pravcu pružanja vlaknaca) i boji



3.Faza izbor lepka i nanošene lepka

Lepak:

- PVA-c
- $T = 18\div 22^{\circ}\text{C}$
- $P = 1,5 \text{ N/mm}^2$
- $q = 250 \text{ g/m}^2$
- $t = 15/40 \text{ min}$



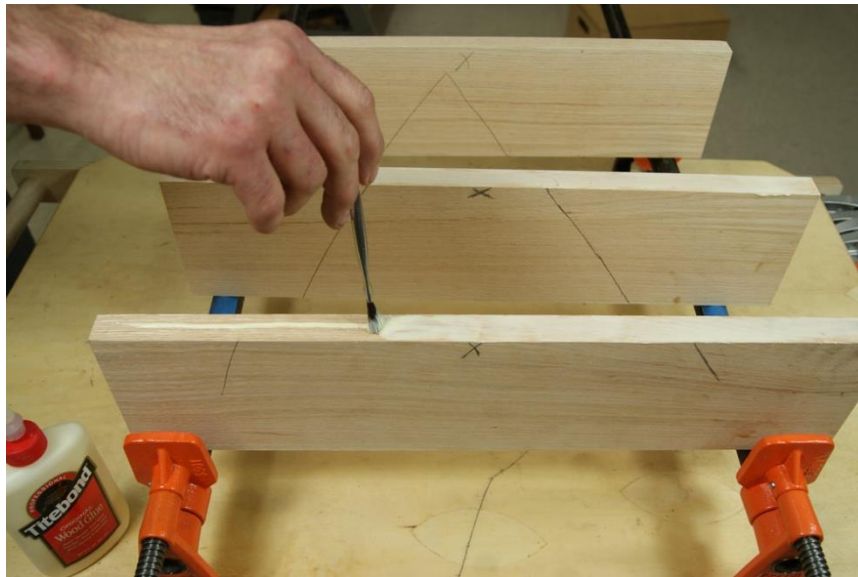
Nanošenje lepka

- Četka
- Valjak – ručni
- **Nanosačica lepka**



Nanošenje lepka

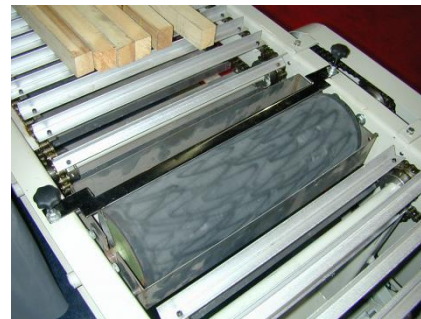
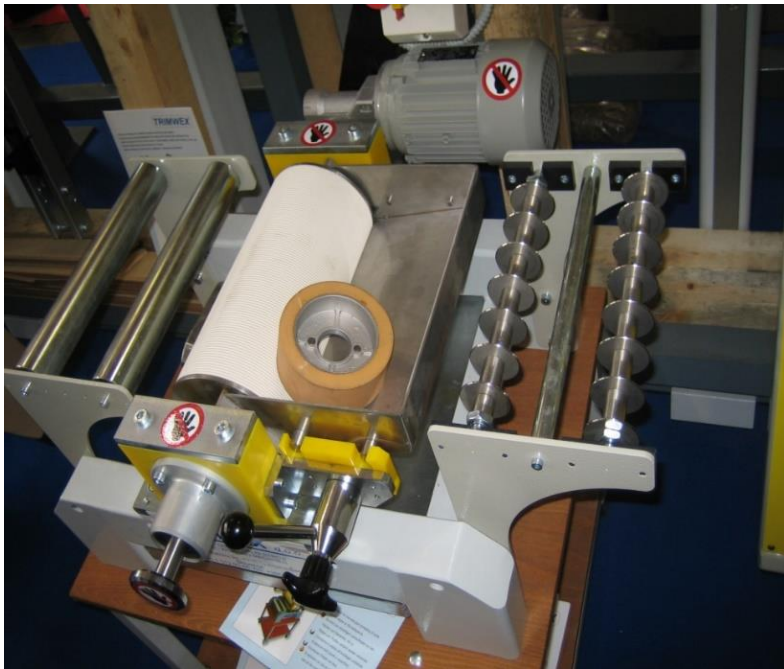
- Četkom



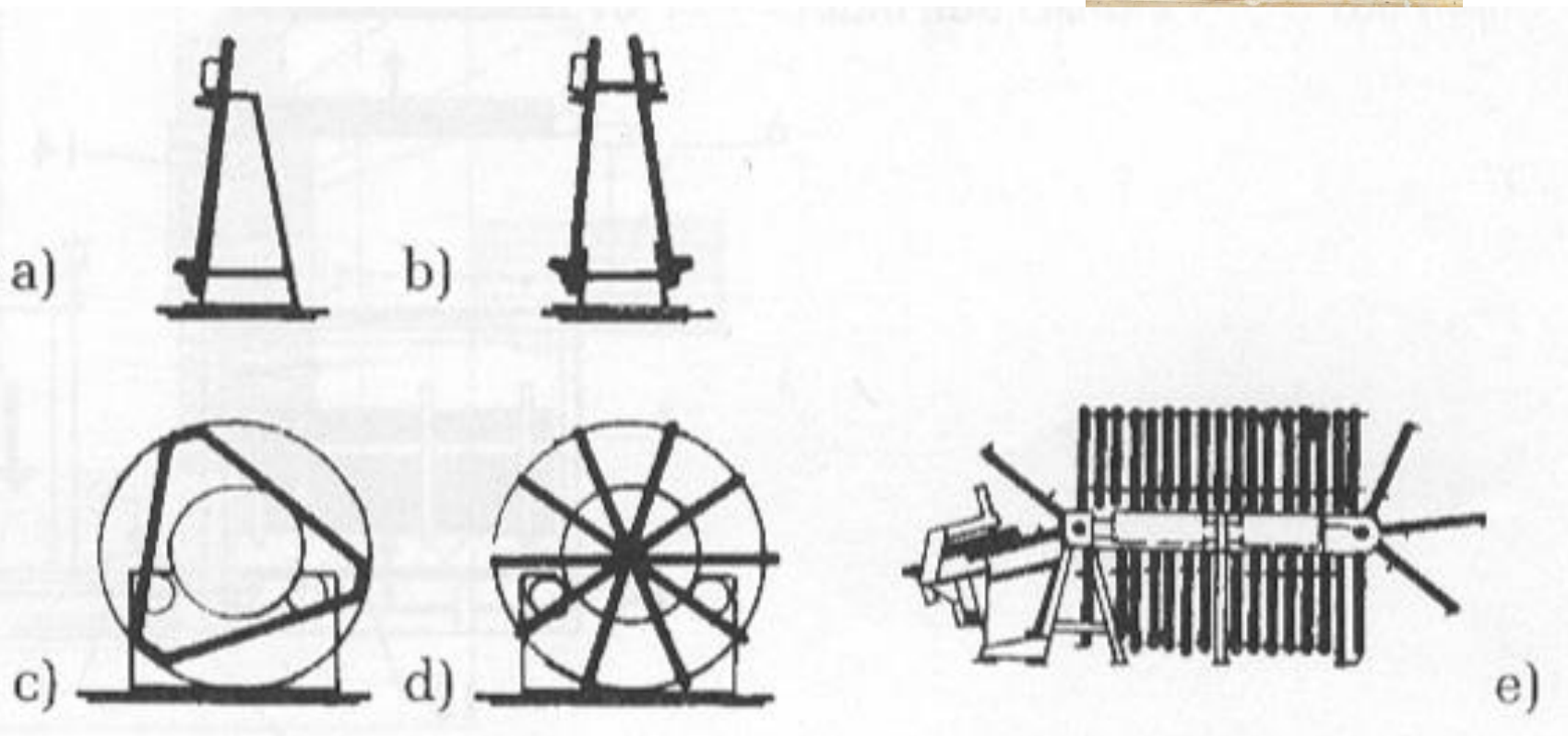
- Valjkom – ručnim



Nanošenje lepka – nanosačice lepka



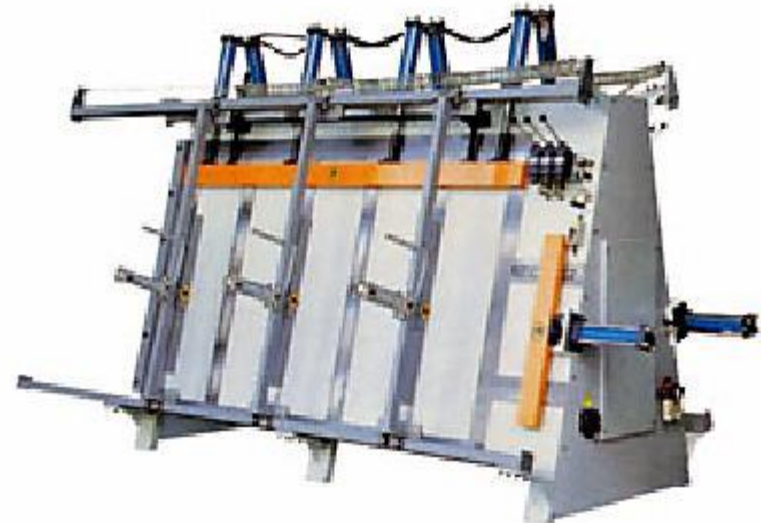
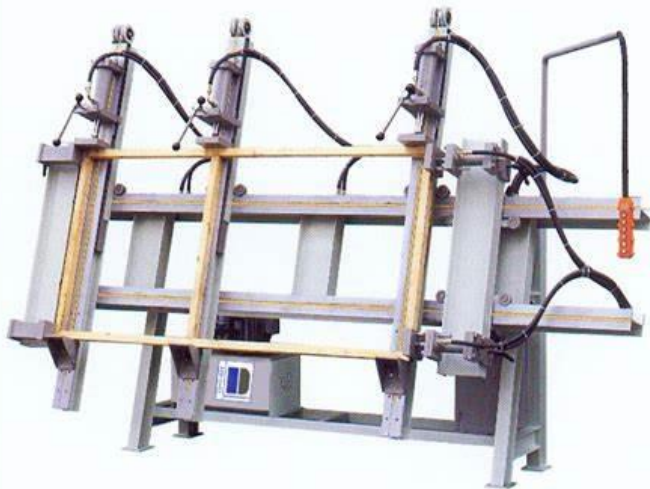
4.Faza Presovanje



Ramovske prese

■ jednostrane

■ dvostrane



<https://www.bing.com/videos/search?q=Taylor+Clamp+Carrier+-+JJ+Smith&&view=detail&mid=0A226084869F8691FB180A226084869F8691FB18&&FORM=VRDGAR&ru=%2Fvideos%2Fsearch%3Fq%3DTaylor%2BClamp%2BCarrier%2B-%2BJJ%2BSmith%26qpvt%3DTaylor%2BClamp%2BCarrier%2B-%2BJJ%2BSmith%26FORM%3DVDRE>

Ramovske prese - zvezdaste



- <https://www.bing.com/videos/search?q=Taylor+Clamp+Carrier+-+JJ+Smith&&view=detail&mid=09AAD34C59C6A480A39609AAD34C59C6A480A396&&FORM=VRDGAR&ru=%2Fvideos%2Fsearch%3Fq%3DTaylor%2BClamp%2BCarrier%2B-%2BJJ%2BSmith%26qpvt%3DTaylor%2BClamp%2BCarrier%2B-%2BJJ%2BSmith%26FORM%3DVDRE>

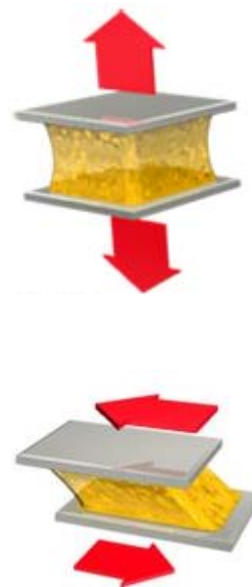
Ramovske prese - konvejerne



<https://www.bing.com/videos/search?q=Taylor+Clamp+Carrier++JJ+Smith&&view=detail&mid=7A614A36CBF7896AEB4C7A614A36CBF7896AEB4C&&FORM=VRDGAR&ru=%2Fvideos%2Fsearch%3Fq%3DTaylor%2BClamp%2BCarrier%2B-%2BJJ%2BSmith%26qpvt%3DTaylor%2BClamp%2BCarrier%2B-%2BJJ%2BSmith%26FORM%3DVDRE>

5.Faza kondicioniranje

vrsta PVA-c lepka



Zatezna čvrstoća

Simicajna čvrstoća

4÷8h (polu smena ili smena)

6.Faza obrada sastava

