SLÉVÁRENSKÉ PODPĚRKY

FOUNDRY CHAPLETS

JANDEJSEK s.r.o.

KATALOG SLÉVÁRENSKÝCH PODPĚREK

CATALOGUE OF FOUNDRY CHAPLETS

JANDEJSEK
s.r.o.

NAŠE SPOLEČNOST

Již více než 20 let se specializujeme na výrobu slévárenských podpěrek a chladicích hřebů pro slévárenský průmysl. Díky dlouholetým zkušenostem, důrazu na kvalitu a preciznost jsme schopni nabídnout produkty, které splňují i ty nejnáročnější požadavky našich zákazníků.

Náš sortiment čítá více než **3000 variant** slévárenských podpěrek a chladících hřebů vyráběných z kvalitní **oceli**, **nerezové oceli** a **hliníku**.

Naše výroba je certifikována podle normy **ISO 9001:2015**, což je zárukou dodržování přísných standardů kvality ve všech fázích výrobního procesu.

Každý produkt přizpůsobíme specifickým potřebám vaší výroby, proto nás neváhejte kontaktovat, pokud máte **individuální potřeby** na tvar, zpracování nebo velikost podpěrky.

OCELOVÉ

Podpěrky jsou vyrobeny z nízkouhlíkové oceli s obsahem C max. 0,2 %. Všechny výrobky z oceli jsou standardně opatřeny povrchovou úpravou **galvanického cínování** (5 µm 99,9% Sn), které zajišťuje jejich odolnost a dlouhou životnost.

NEREZOVÉ

Podpěrky jsou vyrobeny z **chromniklové oceli 18/10**, která se vyznačuje vysokou korozní odolností a dobrou svařitelností. Tato ocel je nemagnetická.

HLINÍKOVÉ

Podpěrky jsou vyrobeny ze **slitiny hliníku EN AW 5754**, která se vyznačuje dobrou svařitelností a také odolností proti korozi. Chemické složení materiálu dle evropské normy EN 573-3.

OUR COMPANY

For more than 20 years, we have specialized in the production of foundry supports and cooling pins for the foundry industry. Thanks to our extensive experience, commitment to quality, and precision, we are able to offer products that meet even the most demanding requirements of our customers.

*Our product range includes over **3,000 variants** of foundry supports and cooling pins, manufactured from high-quality **steel**, **stainless steel**, and **aluminum**.*

*Our production is certified according to **ISO 9001:2015**, ensuring compliance with strict quality standards at every stage of the manufacturing process.*

Each product can be tailored to the specific needs of your production. Therefore, please do not hesitate to contact us if you have **individual requirements** *regarding the shape, processing, or size of the support.*

ISO 9001
LL-C (Certification)

STEEL

The supports are made from low-carbon steel with a maximum carbon content of 0.2 %. All steel products are standardly finished with a **galvanic tin plating** *(5 µm 99.9% Sn), ensuring their durability and long service life.*

STAINLESS STEEL

The supports are made from **18/10 chromium-nickel stainless steel**, *characterized by high corrosion resistance and good weldability. This steel is non-magnetic.*

ALUMINUM

The supports are made from **aluminum alloy EN AW 5754**, *which is characterized by good weldability and excellent corrosion resistance. The chemicalcomposition of the material complies with the Europeanstandard EN 573-3.*

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OCELOVÉ POCÍNOVANÉ
TIN-PLATED STEEL

SP
SLÉVÁRENSKÉ PODPĚRKY
FOUNDRY CHAPLETS

RÁMKOVÉ PODPĚRKY

Podpěrky jsou vyrobeny z jednoho kusu ohýbaného plechu - bez svárů. Vhodné pro tenkostěnné odlitky a automatizovanou výrobu.

- Varianty: neděrované, děrované
- Možnost upevnění samolepicí vrstvou (str. 45)

PERFORATED (BOX) CHAPLETS

Supports are manufactured from a single piece of bent sheet metal – without any welds. Suitable for thin-walled castings and automated production.

- *Versions: non-perforated, perforated*
- *Can be secured with a self-adhesive layer (page 45)*

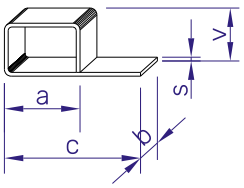
TYPY/*TYPES*

A)

neděrované
non-perforated

B)

děrované
perforated



SP axbxs - Vv

axb [mm]	ROZMĚR PLECHU *PLATE DIMENSION*
s [mm]	TLOUŠŤKA PLECHU *PLATE THICKNESS*
v [mm]	VÝŠKA *HEIGHT*

RÁMKOVÉ PODPĚRKY/*PERFORATED (BOX) CHAPLETS*

axb [mm]	s [mm]	v [mm]	TYP/*TYPE*
10x5	0,5	5, 6, 7, 8, 9, 10	A
10x10	0,5	5, 6, 7, 8, 9	A
20x10	0,5	8, 10	B
20x15	0,5	6,5; 12	B

OCELOVÉ POCÍNOVANÉ
TIN-PLATED STEEL

SP SLÉVÁRENSKÉ PODPĚRKY
FOUNDRY CHAPLETS

KRUHOVÉ PODPĚRKY

Kulatá základna umožňuje snadné a přesné umístění ve formě. Ideální pro automatizované výrobní procesy.

- Varianty: neděrované, děrované, s drážkami a kombinované
- Možnost upevnění hřebem nebo samolepicí vrstvou (str. 44-45)

ROUND-PLATE CHAPLETS

The round base allows easy and precise positioning in the mold. Ideal for automated production processes.

- *Versions: non-perforated, perforated, ringed and combined*
- *Can be secured with a nail or self-adhesive layer (page 44-45)*

TYPY/*TYPES*

A)

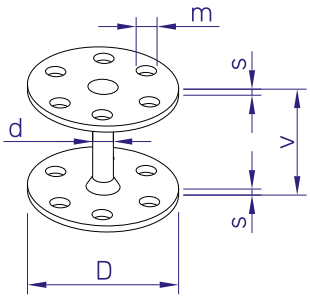
neděrované, hladký stonek
non-perforated, smooth stem

B)

děrované, hladký stonek
perforated, smooth stem

C)

děrované, stonek s drážkami
perforated, ringed stem
(d ≥ ø8 mm)



SP ø Dxs - dVv

D [mm]	ROZMĚR PLECHU *PLATE DIMENSION*
s [mm]	TLOUŠŤKA PLECHU *PLATE THICKNESS*
d [mm]	PRŮMĚR STONKU *STEM DIAMETER*
v [mm]	VÝŠKA *HEIGHT*

KRUHOVÉ PODPĚRKY / *ROUND-PLATE CHAPLETS*

D [mm]	s [mm]	d [mm]	v [mm]	TYP/*TYPE*
ø 10	0,5	2,5	6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16	A, B
ø 10	0,8	2,5	6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16	A, B
ø 10	0,8	2,8	5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22, 25	A, B
ø 12	0,5	2,5	6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16	A, B
ø 12	0,8	2,5	6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16	A, B
ø 12	0,8	2,8	5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22, 25	A, B
ø 14	0,8	2,8	5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25	A, B
ø 15	0,6	2,0	12	A, B
ø 15	0,8	2,8	5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25	A, B
ø 15	1,0	4,0	7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25	A, B
ø 20	0,5	2,8	12, 14, 16 20	A, B
ø 20	0,8	2,8	5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25 27, 30 32, 33, 35, 36, 49	A, B
ø 20	1,0	4,0	7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22, 24, 25	A, B
ø 20	1,0	5,0	8, 10, 12, 13, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35	A, B
ø 20	2,0	5,0	10, 12, 14, 15, 16, 17, 18, 20, 22, 24, 26, 27, 28, 30, 32, 34, 37	A, B
ø 24	2,0	5,0	10, 12, 14, 15, 16, 17, 18, 20, 22, 24, 26, 27, 28, 30, 32, 34, 37	A, B
ø 25	0,8	2,8	5, 6, 7, 8, 9, 10, 11, 12, 14, 15, 16, 18, 19, 20, 22, 24, 25, 27, 30, 32, 35	A, B
ø 25	1,0	4,0	7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22	A, B
ø 25	1,0	5,0	8, 10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35	A, B
ø 25	1,0	8,0	26, 52	C
ø 25	1,0	10	55, 70	C

OCELOVÉ POCÍNOVANÉ
TIN-PLATED STEEL

SP
SLÉVÁRENSKÉ PODPĚRKY
FOUNDRY CHAPLETS

NESOUMĚRNÉ KRUHOVÉ PODPĚRKY

Vhodné pro složitá jádra nebo nakloněné formy. Spodní zvětšená základna disponuje vetší kontaktní plochou a stabilitou. Prodloužená základna umožňuje kotvení podpěrky za spodní desku, což je vhodné zvláště u podpěrek s tavnou deskou.

- Varianty: neděrované, děrované
- Možnost upevnění hřebem nebo samolepicí vrstvou (str. 44-45)

ASYMMETRICAL ROUND-PLATE CHAPLETS

Suitable for complex cores or inclined molds.The enlarged bottom base provides a greater contact surface and improved stability.The extended base enables anchoring of the support beneath the bottom plate, which is particularly advantageous f or supports with a hot plate.

- *Versions: non-perforated, perforated*
- *Can be secured with a nail or self-adhesive layer (page 44-45)*

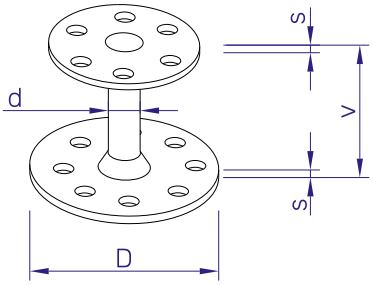
TYPY/*TYPES*

A)

neděrované, hladký stonek
non-perforated, smooth stem

B)

děrované, hladký stonek
perforated, smooth stem



SP ø Dxs - dVv

D [mm]	ROZMĚR PLECHU *PLATE DIMENSION*
s [mm]	TLOUŠŤKA PLECHU *PLATE THICKNESS*
d [mm]	PRŮMĚR STONKU *STEM DIAMETER*
v [mm]	VÝŠKA *HEIGHT*

NESOUMĚRNÉ KRUHOVÉ PODPĚRKY / *ASYMMETRICAL ROUND-PLATE CHAPLETS*

D [mm]	s [mm]	d [mm]	v [mm]	TYP/*TYPE*
⌀ 10/⌀ 15	0,8	2,8	5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25	A
⌀ 15/⌀ 20	1,0	4,0	7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22, 24, 25	A, B
⌀ 15/⌀ 25	0,8	2,8	5, 6, 7, 8, 9, 10, 11, 12, 14, 15, 16, 18, 19, 20, 22, 24, 25, 27, 30, 32, 35	A, B
⌀ 20/⌀ 24	2,0	5,0	10, 12, 14, 15, 16, 17, 18, 20, 22, 24, 26, 27, 28, 30, 32, 34, 37	A, B
⌀ 20/⌀ 25	1,0	5,0	8, 10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35	A, B

POZNÁMKA: Výše jsou uvedeny pouze některé z možných druhů nesouměrných kruhových podpěrek. Velikosti základen lze kombinovat s následujícími rozměry plechů: **⌀ 10, 12, 14, 15, 20, 24 a 25 mm.**

NOTE: *The types of asymmetrical round-plate chaplets listed above represent only a selection of the available options. Base sizes can be combined with the following plate dimensions:* ***⌀ 10, 12, 14, 15, 20, 24, and 25 mm.***

OCELOVÉ POCÍNOVANÉ
TIN-PLATED STEEL

SPTD

SLÉVÁRENSKÉ PODPĚRKY
S TAVNOU DESKOU
FOUNDRY CHAPLETS
WITH FUSION PLATE

KRUHOVÉ PODPĚRKY S TAVNOU DESKOU

Tento druh podpěrek s tavnou deskou je využíván pro jeho lepší spojení s odlitkem. Tavná deska zajišťuje nepropustné spojení s kovem - vhodné pro odlitky s vyššími nároky na tlakovou těsnost.

- Varianty: neděrované, děrované, s drážkami a kombinované
- Možnost upevnění hřebem nebo samolepicí vrstvou (str. 44-45)

ROUND-PLATE CHAPLETS WITH FUSION PLATE

This type of support with a hot plate is used for its better connection with the casting. The fusion plate ensures an impermeable bond with the metal – suitable for castings with higher demands on pressure tightness.

- *Versions: non-perforated, perforated, ringed and combined*
- *Can be secured with a nail or self-adhesive layer (page 44-45)*

TYPY/*TYPES*

A)

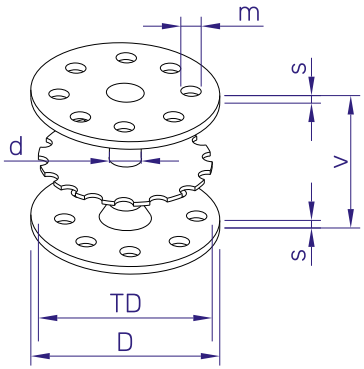
děrované, hladký stonek
perforated, smooth stem

B)

děrované, hladký stonek
nesouměrná
non-perforated, smooth stem
asymmetrical

C)

děrované, stonek s drážkami
perforated, ringed stem
(d ≥ ø8 mm)



SPTD ø Dxs - dVv

D [mm]	ROZMĚR PLECHU	*PLATE DIMENSION*
s [mm]	TLOUŠŤKA PLECHU	*PLATE THICKNESS*
d [mm]	PRŮMĚR STONKU	*STEM DIAMETER*
v [mm]	VÝŠKA	*HEIGHT*

KRUHOVÉ PODPĚRKY S TAVNOU DESKOU - **SOUMĚRNÉ**/ *ROUND-PLATE CHAPLETS WITH FUSION PLATE - **SYMMETRICAL***

D [mm]	s [mm]	d [mm]	v [mm]	TYP/*TYPE*
⌀ 10	0,8	2,5	6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20	A
⌀ 12	0,8	2,5	6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20	A
⌀ 14	0,8	2,8	7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22	A
⌀ 15	0,8	2,8	7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22, 25, 30	A
⌀ 15	0,8	4,0	7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22	A
⌀ 20	0,8	2,8	7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22, 25, 28, 30, 33	A
⌀ 20	1,0	4,0	7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22, 25	A
⌀ 20	1,0	5,0	7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22, 25, 28, 30, 37	A
⌀ 25	0,8	2,8	7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22	A
⌀ 25	1,0	5,0	8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22, 24, 25, 28, 30, 32, 35	A
⌀ 25	1,0	10,0	15, 20, 22, 24, 25, 30, 35, 40, 50, 55, 60, 65, 70	C
⌀ 25	1,0	8,0	10, 12, 14, 15, 16, 18, 20, 25, 30, 32, 35, 37, 40, 44, 46, 48	C

KRUHOVÉ PODPĚRKY S TAVNOU DESKOU - **NESOUMĚRNÉ**/ *ROUND-PLATE CHAPLETS WITH FUSION PLATE - **ASYMMETRICAL***

D [mm]	s [mm]	d [mm]	v [mm]	TYP/*TYPE*
⌀ 10/⌀ 15	0,8	2,8	10	B
⌀ 10/⌀ 20	0,8	2,8	20	B

POZNÁMKA: Výše jsou uvedeny pouze některé z možných druhů nesouměrných kruhových podpěrek. Velikosti základen lze kombinovat s následujícími rozměry plechů: **⌀ 10, 12, 14, 15, 20, 24 a 25 mm.**

NOTE: *The types of asymmetrical round-plate chaplets listed above represent only a selection of the available options. Base sizes can be combined with the following plate dimensions:* ***⌀ 10, 12, 14, 15, 20, 24, and 25 mm.***

OCELOVÉ POCÍNOVANÉ
TIN-PLATED STEEL

SP SLÉVÁRENSKÉ PODPĚRKY
FOUNDRY CHAPLETS

ČTVERCOVÉ JEDNOSTONKOVÉ PODPĚRKY

Čtvercová patka zajišťuje lepší rozložení zatížení a zvyšuje přilnavost k formě. Podpěrky jsou vhodné pro těžší nebo tvarově náročné odlitky, kde je klíčová stabilita jádra.

- Varianty: hladký stonek, stonek s drážkami
- Možnost upevnění hřebem nebo samolepicí vrstvou (str. 44-45)

SQUARE-PLATE SINGLE-STEM CHAPLETS

The square base provides better load distribution and increased adhesion to the mold. These chaplets are suitable for heavier or geometrically complex castings, where core stability is essential.

- *Versions: smooth stem, ringed stem*
- *Can be secured with a nail or self-adhesive layer (page 44-45)*

TYPY/*TYPES*

A)

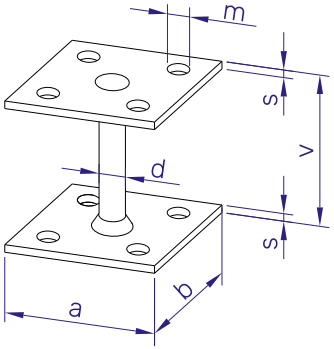
děrované, hladký stonek souměrné
perforated, smooth stem symmetrical

B)

děrované, stonek s drážkami souměrné
perforated, ringed stem symmetrical
(d ≥ ø8 mm)

C)

děrované, hladký stonek nesouměrné
perforated, smooth stem asymmetrical



SP axbxs - dVv

axb [mm]	ROZMĚR PLECHU *PLATE DIMENSION*
s [mm]	TLOUŠŤKA PLECHU *PLATE THICKNESS*
d [mm]	PRŮMĚR STONKU *STEM DIAMETER*
v [mm]	VÝŠKA *HEIGHT*

ČTVERCOVÉ JEDNOSTONKOVÉ PODPĚRKY - **SOUMĚRNÉ** / *SQUARE-PLATE SINGLE-STEM CHAPLETS* - ***SYMMETRICAL***

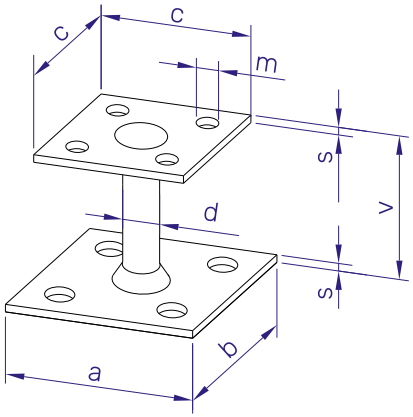
axb[mm]	s [mm]	d [mm]	v [mm]	TYP/*TYPE*
10x10	0,8	2,5	8, 10, 12	A
15x15	0,8	2,8	5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25 27, 30, 32, 33, 35	A
15x15	1,0	4,0	7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22, 24, 25	A
20x20	0,8	2,8	5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25 27, 30, 32, 33, 35	A
20x20	1,0	4,0	7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22, 24, 25	A
20x20	1,0	5,0	8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22, 24, 25, 26, 28, 30, 40	A
20x20	1,0	8,0	10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 34, 35, 36, 38, 40	B
25x25	1,0	5,0	8, 10, 12, 14, 15, 16, 17, 18, 19, 20, 21, 22, 24, 25, 26, 27, 28, 30, 32, 35 36, 38, 40, 42	A
25x25	1,3	5,0	10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35	A
25x25	1,0	8,0	10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 34, 35, 36, 38, 40	B
25x25	1,3	8,0	10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 34, 35, 36, 38, 40	B
30x30	0,5	2,5	10, 13, 15, 17, 20, 21, 22, 23, 25, 30	A
30x30	1,0	5,0	10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 27, 28, 30, 32, 34, 35, 36, 40	A
30x30	1,5	5,0	15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 34, 35, 36, 40	A
30x30	1,0	6,0	15, 20, 30, 40	A
30x30	1,0	8,0	10, 12, 14, 15, 16, 20, 22, 24, 25, 26, 28, 30, 32, 35, 36, 38, 40, 42, 45, 48, 50	B
30x30	1,3	8,0	12, 14, 15, 16, 20, 22, 24, 25, 26, 28, 30, 32, 35, 38, 40, 42, 45, 48, 50	B
30x30	1,5	8,0	10, 12, 14, 15, 16, 17, 20, 22, 24, 25, 26, 28, 30, 32, 35, 38, 40, 42, 45, 48, 50	B
40x40	1,0	8,0	10, 12, 15, 16, 18, 20, 22, 25, 26, 28, 30, 35, 40, 45, 50, 55	B
40x40	1,5	8,0	10, 12, 15, 16, 17, 18, 20, 22, 25, 26, 28, 30, 35, 40, 45, 50	B
40x40	1,0	10,0	10, 12, 15, 16, 18, 20, 22, 25, 26, 28, 30, 35, 40, 45, 50, 55	B
40x40	1,5	10,0	10, 12, 15, 16, 17, 18, 20, 22, 25, 26, 28, 30, 35, 40, 45, 50	B
50x50	1,0	8,0	20, 22, 25, 28, 30, 35, 40, 45, 50, 55, 60, 65, 70, 75, 80	B
50x50	1,5	8,0	20, 22, 25, 28, 30, 35, 40, 45, 50, 55	B
50x50	1,0	10,0	8, 10, 12, 14, 15, 18, 20, 22, 24, 30, 32, 35, 40, 45, 50, 55, 60, 65, 70 75, 80, 85, 90, 95, 100	B
50x50	1,5	10,0	9, 10, 12, 14, 15, 18, 20, 22, 24, 25, 28, 30, 32, 35, 40, 45, 50, 55, 60 65, 70, 75, 80, 85, 90, 95, 100	B

ČTVERCOVÉ JEDNOSTONKOVÉ PODPĚRKY - **SOUMĚRNÉ** / *SQUARE-PLATE SINGLE-STEM CHAPLETS* - ***SYMMETRICAL***

axb[mm]	s [mm]	d [mm]	v [mm]	TYP/*TYPE*
50x50	1,5	22,0	45	B
60x60	1,5	22,0	20, 22, 25, 27, 28, 30, 32, 35, 38, 40, 42, 45, 48, 50, 52, 55, 58, 60 65, 70, 75, 80, 85, 90, 95, 100, 108, 130, 135	B
60x60	2,0	22,0	21, 23, 25, 26, 28, 30, 32, 35, 38, 40, 42, 45, 50, 55, 60, 65, 70, 75 80, 85, 90, 95, 100	B

ČTVERCOVÉ JEDNOSTONKOVÉ PODPĚRKY - **NESOUMĚRNÉ** / *SQUARE-PLATE SINGLE-STEM CHAPLETS* - ***ASYMMETRICAL***

cxc/axb [mm]	s [mm]	d [mm]	v [mm]	TYP/*TYPE*
20x20/25x25	1,0	5,0	8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20	C



SP cxc/axbxs - dVv

cxc [mm]	ROZMĚR PLECHU *PLATE DIMENSION*
axb [mm]	ROZMĚR PLECHU *PLATE DIMENSION*
s [mm]	TLOUŠŤKA PLECHU *PLATE THICKNESS*
d [mm]	PRŮMĚR STONKU *STEM DIAMETER*
v [mm]	VÝŠKA *HEIGHT*

POZNÁMKA: Výše jsou uvedeny pouze některé z možných druhů nesouměrných jednostonkových podpěrek. Velikosti základen lze kombinovat s následujícími rozměry plechů:
10x10, 15x15, 20x20, 25x25, 30x30, 40x40, 50x50, 60x60 mm.

NOTE: *The types of asymmetrical single-stem chaplets listed above represent only a selection of the available options. Base sizes can be combined with the following plate dimensions:*
10x10, 15x15, 20x20, 25x25, 30x30, 40x40, 50x50, 60x60 mm.

OCELOVÉ POCÍNOVANÉ
TIN-PLATED STEEL

SP SLÉVÁRENSKÉ PODPĚRKY
FOUNDRY CHAPLETS

JEDNOSTONKOVÉ PODPĚRKY S „L“ ZÁKLADNOU

Patka tvaru "L" poskytuje stabilní uchycení i z boční strany.
Vhodné pro svislou nebo šikmou oporu i ve stísněných prostorech.

- Varianty: hladký stonek, stonek s drážkami
- Možnost upevnění hřebem nebo samolepicí vrstvou (str. 44-45)

SINGLE-STEM CHAPLETS WITH „L” PLATE

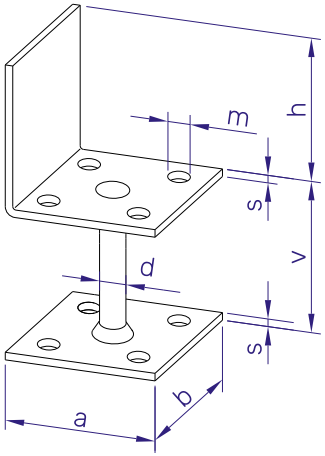
The L-shaped base provides stable anchoring, including from the side. Suitable for vertical or angled support, even in confined spaces.

- *Versions: smooth stem, ringed stem*
- *Can be secured with a nail or self-adhesive layer (page 44-45)*

TYPY/*TYPES*

A)

děrované, hladký stonek
perforated, smooth stem



SP axbLxs - dVv

axb [mm]	ROZMĚR PLECHU *PLATE DIMENSION*
s [mm]	TLOUŠŤKA PLECHU *PLATE THICKNESS*
d [mm]	PRŮMĚR STONKU *STEM DIAMETER*
v [mm]	VÝŠKA *HEIGHT*

JEDNOSTONKOVÉ PODPĚRKY S „L" ZÁKLADNOU / *SINGLE-STEM CHAPLETS WITH „L" PLATE*

axb [mm]	s [mm]	d [mm]	v [mm]	TYP/*TYPE*
20x20L	0,8	2,8	7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 27 30, 32, 33, 35	A
20x20L	1,0	5,0	8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22	A
25x25L	1,0	5,0	8, 10, 12, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 30, 32 35, 36, 38, 40, 42	A
30x30L	0,5	2,5	10, 13, 15, 17, 20, 21 , 22, 23, 25, 30	A

OCELOVÉ POCÍNOVANÉ
TIN-PLATED STEEL

SPTD

SLÉVÁRENSKÉ PODPĚRKY
S TAVNOU DESKOU
FOUNDRY CHAPLETS
WITH FUSION PLATE

JEDNOSTONKOVÉ PODPĚRKY S TAVNOU DESKOU

Tento druh podpěrek s tavnou deskou je využíván pro jeho lepší spojení s odlitkem. Tavná deska zajišťuje nepropustné spojení s kovem - vhodné pro odlitky s vyššími nároky na tlakovou těsnost.

- Varianty: hladký stonek, stonek s drážkami
- Možnost upevnění hřebem nebo samolepicí vrstvou (str. 44-45)

SINGLE-STEM CHAPLETS WITH FUSION PLATE

This type of support with a hot plate is used for its better connection with the casting. The fusion plate ensures an impermeable bond with the metal – suitable for castings with higher demands on pressure tightness.

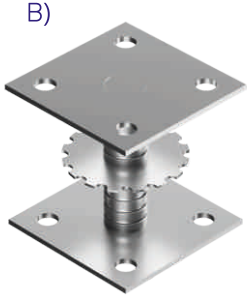
- *Versions: smooth stem, ringed stem*
- *Can be secured with a nail or self-adhesive layer (page 44-45)*

TYPY/*TYPES*

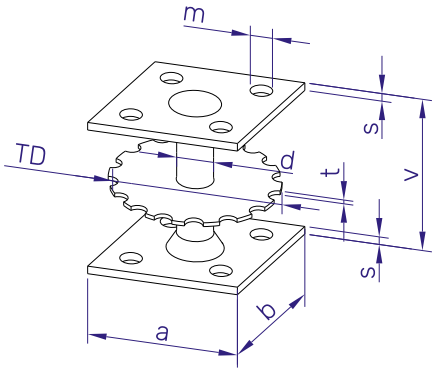
A)

děrované, hladký stonek
perforated, smooth stem

B)



děrované, stonek s drážkami
perforated, ringed stem
(d ≥ ø8 mm)



SPTD axbxs - dVv

axb [mm]	ROZMĚR PLECHU *PLATE DIMENSION*
s [mm]	TLOUŠŤKA PLECHU *PLATE THICKNESS*
d [mm]	PRŮMĚR STONKU *STEM DIAMETER*
v [mm]	VÝŠKA *HEIGHT*

JEDNOSTONKOVÉ PODPĚRKY S TAVNOU DESKOU / *SINGLE-STEM CHAPLETS WITH FUSION PLATE*

axb [mm]	s [mm]	d [mm]	v [mm]	TYP/*TYPE*
15x15	0,8	2,8	7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22	A
20x20	0,8	2,8	7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22	A
20x20	1,0	5,0	8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22, 25, 30	A
20x20	1,0	8,0	10, 12, 14, 15, 16, 18, 20, 22, 25, 30, 35, 40	B
20x20	1,0	10,0	10, 12, 14, 15, 16, 18, 20, 22, 25, 30, 35, 40	B
25x25	1,0	5,0	8, 9, 10, 12, 13, 14 ,15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35	A
25x25	1,0	8,0	10, 12, 13, 14, 15, 16, 18, 20, 22, 25, 28, 30, 35, 40	B
25x25	1,5	8,0	10, 12, 13, 14, 15, 16, 18, 20, 22, 25, 28, 29, 30, 35, 40	B
30x30	1,0	5,0	8, 9, 10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35	A
30x30	1,3	5,0	8, 9, 10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35	A
30x30	1,5	5,0	8, 9, 10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35	A
30x30	1,0	8,0	10, 12, 13, 14, 15, 16, 18, 20, 22, 25, 28, 30, 35, 40	B
30x30	1,5	8,0	10, 12, 13, 14, 15, 16, 18, 20, 22, 25, 28, 30, 35, 38, 40, 50	B
30x30	2,0	8,0	10, 12, 13, 14, 15, 16, 18, 20, 22, 25, 28, 30, 35, 40, 50	B
40x40	1,0	10,0	10	B
40x40	1,5	10,0	15, 20, 25, 30, 35, 40, 45, 50, 60, 65	B
40x40	1,5	12,0	70, 80	B
50x50	1,0	10,0	10	B
50x50	1,5	10,0	15, 20, 25, 30, 35, 40, 50, 60, 65	B
50x50	1,5	12,0	70, 80	B

OBDÉLNÍKOVÉ DVOUSTONKOVÉ PODPĚRKY

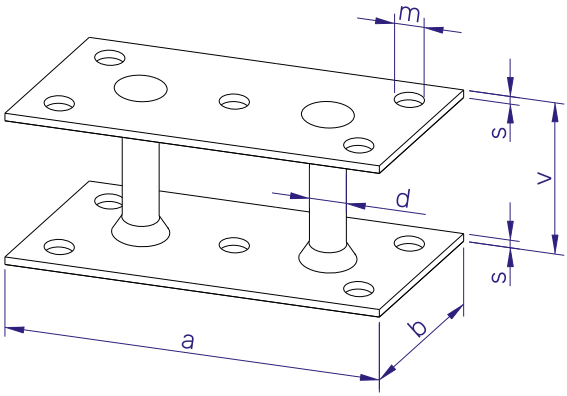
Obdélníková patka s 2 stonky disponuje vetší kontaktní plochou a stabilitou. Vhodné do úzkých nebo tvarově složitých částí forem.

- Varianty: hladký stonek, stonek s drážkami
- Možnost upevnění hřebem nebo samolepicí vrstvou (str. 44-45)

RECTANGULAR-PLATE TWO-STEM CHAPLETS

The rectangular plate with two stems offers greater contact area and stability. Suitable for narrow or geometrically complex sections of the mould.

- *Versions: smooth stem, ringed stem*
- *Can be secured with a nail or self-adhesive layer (page 44-45)*



axb [mm]	ROZMĚR PLECHU	*PLATE DIMENSION*
s [mm]	TLOUŠŤKA PLECHU	*PLATE THICKNESS*
d [mm]	PRŮMĚR STONKU	*STEM DIAMETER*
v [mm]	VÝŠKA	*HEIGHT*

SP axbxs - dVv

TYPY/*TYPES*

A)

děrované, hladký stonek
perforated, smooth stem

B)

děrované, stonek s drážkami
perforated, ringed stem
(d ≥ ø8 mm)

OBDÉLNÍKOVÉ DVOUSTONKOVÉ PODPĚRKY / *RECTANGULAR-PLATE TWO-STEM CHAPLETS*

axb [mm]	s [mm]	d [mm]	v [mm]	TYP/*TYPE*
30x15	0,8	2,8	5, 6, 7, 8, 9, 10, 11, 12, 14, 15, 16, 18, 19, 20, 24, 25, 32	A
30x15	1,0	4,0	7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22, 24, 25	A
40x20	1,0	4,0	7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22, 24, 25	A
40x20	1,0	5,0	8, 10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 35	A
50x25	1,0	5,0	8, 10, 12, 14, 15, 16, 17, 18, 19, 20, 21, 22, 24, 25, 26, 27, 28, 30, 32 35, 36, 38, 40, 42, 50	A
50x25	1,3	5,0	10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35	A
50x25	1,5	5,0	9, 11, 13, 15, 16, 17, 18, 19, 20, 21, 22, 23, 25, 26, 27, 28, 29, 31, 33, 36	A
50x25	1,0	8,0	10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 34, 35, 36, 38 40, 45, 50, 55, 60, 65	B
50x25	1,5	8,0	10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 34, 35, 36, 38, 40, 65	B
60x30	1,0	5,0	10, 12, 13, 14, 15, 16, 18, 19, 20, 22, 24, 25, 26, 28, 30, 32, 34, 35, 36, 40	A
60x30	1,0	8,0	10, 12, 13, 14, 15, 16, 17, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35, 38, 40 42, 45, 48, 50, 55, 60, 65	B
60x30	1,5	8,0	10, 12, 14, 15, 16, 17, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35, 38, 40, 42 45, 48, 50, 55, 60, 65	B
70x40	1,5	8,0	10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35, 38, 40, 42, 45 50, 55, 60, 65, 70	B
70x40	1,5	10,0	9, 10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35, 38, 40, 42 45, 50, 55, 60, 65, 70, 75, 80	B
70x40	1,5	12,0	9, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35, 38, 40, 42, 45 48, 50, 55, 60, 65, 70, 75, 80, 85, 90, 95, 100	B
80x25	2,0	10,0	40, 50, 54, 60, 66, 80, 82, 96, 114, 126	B
80x40	1,0	8,0	10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 34, 35, 36, 38, 40 45, 50, 55	B
80x40	1,5	8,0	10, 12, 14, 15, 16, 17, 18, 20, 22, 24, 25, 26, 28, 30, 32, 34, 35, 36, 38 40, 45, 50, 55, 60	B
80x40	1,5	10,0	9, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35, 38, 40, 42, 45 50, 55, 60, 65, 70, 80, 90	B
80x40	2,0	10,0	10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 34, 35, 36, 38, 40 45, 50, 55, 60, 65, 70, 80, 85, 90, 100	B

OBDÉLNÍKOVÉ DVOUSTONKOVÉ PODPĚRKY / *RECTANGULAR-PLATE TWO-STEM CHAPLETS*

axb [mm]	s [mm]	d [mm]	v [mm]	TYP/*TYPE*
80x40	2,0	12,0	10, 12, 15, 18, 20, 25, 30, 35, 40, 42, 45, 48, 50, 52, 55, 58, 60, 65, 70 75, 80, 85, 90, 95, 100	B
80x40	2,0	14,0	15, 18, 20, 25, 30, 35, 40, 45, 50, 55, 60, 65, 70, 75, 80, 85, 90, 95, 100	B

OCELOVÉ POCÍNOVANÉ
TIN-PLATED STEEL

SP SLÉVÁRENSKÉ PODPĚRKY
FOUNDRY CHAPLETS

NESOUMĚRNÉ DVOUSTONKOVÉ PODPĚRKY

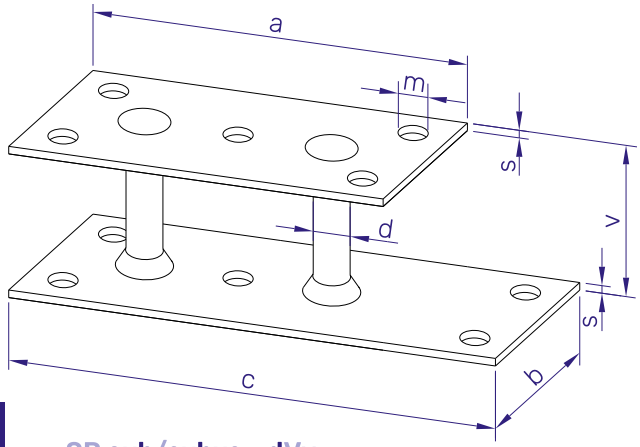
Vhodné pro složitá jádra nebo nakloněné formy. Spodní zvětšená základna disponuje vetší kontaktní plochou a stabilitou.

- Varianty: hladký stonek, stonek s drážkami
- Možnost upevnění hřebem nebo samolepicí vrstvou (str. 44-45)

ASYMMETRICAL TWO-STEM CHAPLETS

Suitable for complex cores or inclined molds. The enlarged bottom base provides a greater contact surface and improved stability.

- *Versions: smooth stem, ringed stem*
- *Can be secured with a nail or self-adhesive layer (page 44-45)*



SP axb/cxbxs - dVv

axb [mm]	ROZMĚR PLECHU *PLATE DIMENSION*
cxb [mm]	ROZMĚR PLECHU *PLATE DIMENSION*
s [mm]	TLOUŠŤKA PLECHU *PLATE THICKNESS*
d [mm]	PRŮMĚR STONKU *STEM DIAMETER*
v [mm]	VÝŠKA *HEIGHT*

TYPY/*TYPES*

A)

děrované, hladký stonek
perforated, smooth stem

B)

děrované, stonek s drážkami
perforated, ringed stem
(d ≥ ø8 mm)

NESOUMĚRNÉ DVOUSTONKOVÉ PODPĚRKY / *ASYMMETRICAL TWO-STEM CHAPLETS*

axb/cxb [mm]	s [mm]	d [mm]	v [mm]	TYP/*TYPE*
50x25/65x25	1,0	5,0	8, 10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35	A
50x25/65x25	1,3	5,0	10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35	A
50x25/65x25	1,5	5,0	10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35	A
50x25/65x25	1,0	8,0	10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 34, 35, 36, 38, 40	B
50x25/65x25	1,5	8,0	10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 34, 35, 36, 38, 40	B
70x40/80x40	1,5	8,0	20, 22, 24, 25, 26, 28, 30, 32, 34, 35, 36, 38, 40, 45, 50, 55, 60, 65, 70	B
70x40/80x40	1,5	10,0	9, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35, 38, 40, 42, 45 48, 50, 52, 55, 58, 60, 65, 70, 75, 80, 85, 90, 95, 100	B
70x40/80x40	1,5	12,0	9, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35, 38, 40, 42, 45 48, 50, 55, 60, 65, 70, 75, 80, 85, 90, 95, 100	B

OCELOVÉ POCÍNOVANÉ
TIN-PLATED STEEL

SPTD

SLÉVÁRENSKÉ PODPĚRKY
S TAVNOU DESKOU
FOUNDRY CHAPLETS
WITH FUSION PLATE

DVOUSTONKOVÉ PODPĚRKY S TAVNOU DESKOU

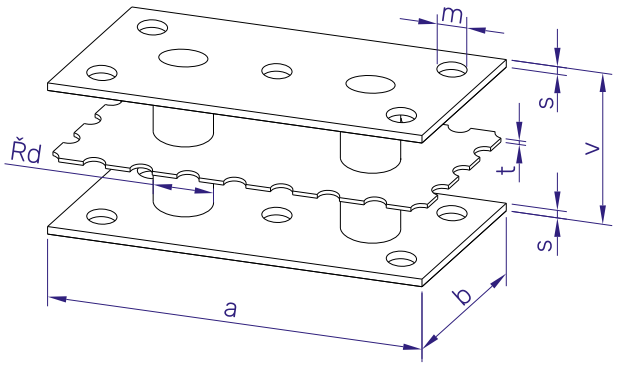
Tento druh podpěrek s tavnou deskou je využíván pro jeho lepší spojení s odlitkem. Tavná deska zajišťuje nepropustné spojení s kovem - vhodné pro odlitky s vyššími nároky na tlakovou těsnost.

- Varianty: hladký stonek, stonek s drážkami
- Možnost upevnění hřebem nebo samolepicí vrstvou (str. 44-45)

TWO-STEM CHAPLETS WITH FUSION PLATE

This type of support with a hot plate is used for its better connection with the casting. The fusion plate ensures an impermeable bond with the metal – suitable for castings with higher demands on pressure tightness.

- *Versions: smooth stem, ringed stem*
- *Can be secured with a nail or self-adhesive layer (page 44-45)*

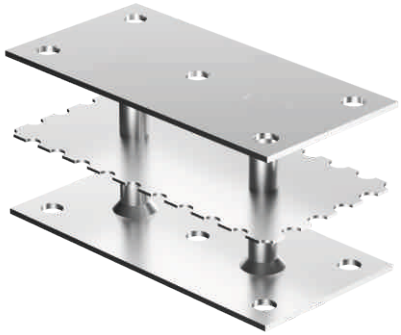


axb [mm]	ROZMĚR PLECHU *PLATE DIMENSION*
s [mm]	TLOUŠŤKA PLECHU *PLATE THICKNESS*
d [mm]	PRŮMĚR STONKU *STEM DIAMETER*
v [mm]	VÝŠKA *HEIGHT*

SPTD axbxs - dVv

TYPY/*TYPES*

A)



děrované, hladký stonek
perforated, smooth stem

B)

děrované, stonek s drážkami
perforated, ringed stem
(d ≥ ø8 mm)

DVOUSTONKOVÉ PODPĚRKY S TAVNOU DESKOU / *TWO-STEM CHAPLETS WITH FUSION PLATE*

axb [mm]	s [mm]	d [mm]	v [mm]	TYP/*TYPE*
50x25	1,0	4,0	12	A
50x25	1,0	5,0	10, 11, 12, 14, 15, 16, 18, 19, 20, 22, 25, 29, 30, 35, 40	A
50x25	1,3	5,0	10, 12, 14, 15, 16, 18, 20, 22, 25, 27, 30, 35, 40	A
50x25	1,5	5,0	10, 12, 14, 15, 16, 18, 20, 22, 25, 27, 30, 35, 40	A
50x25	1,0	8,0	10, 12, 14, 15, 16, 18, 20, 22, 25, 30, 35, 38, 40	B
50x25	1,5	8,0	10, 12, 14, 15, 16, 18, 20, 25, 27, 30, 35, 40	B
60x30	1,0	5,0	10, 12, 14, 15, 16, 18, 20, 22, 25, 27, 30, 35, 37, 40	A
60x30	1,5	5,0	10, 12, 14, 15, 16, 18, 20, 22, 25, 27, 30, 35, 37, 40	A
60x30	1,0	8,0	10, 12, 14, 15, 16, 18, 20, 25, 30, 35, 40	B
60x30	1,5	8,0	10, 12, 14, 15, 16, 18, 20, 25, 30, 32, 35, 37, 40, 44, 46, 48	B
80x40	1,5	8,0	20, 22, 24	B
80x40	1,0	10,0	10	B
80x40	1,5	10,0	15, 20, 22, 24, 25, 30, 35, 40, 50, 60 ,65	B
80x40	1,5	12,0	70, 80	B
80x40	2,0	10,0	18, 20, 25, 30, 35, 40, 50, 60	B
80x40	2,0	12,0	70, 80	B

OCELOVÉ POCÍNOVANÉ
TIN-PLATED STEEL

SPTD

SLÉVÁRENSKÉ PODPĚRKY
S TAVNOU DESKOU
FOUNDRY CHAPLETS
WITH FUSION PLATE

NESOUMĚRNÉ DVOUSTONKOVÉ PODPĚRKY S TAVNOU DESKOU

TYPY/*TYPES*

Obdélníková patka disponuje vetší kontaktní plochou a stabilitou. Tavná deska zajišťuje pevné spojení s kovem. Vhodné pro náročnější odlitky s vysokými nároky na přesnost a slinutí.

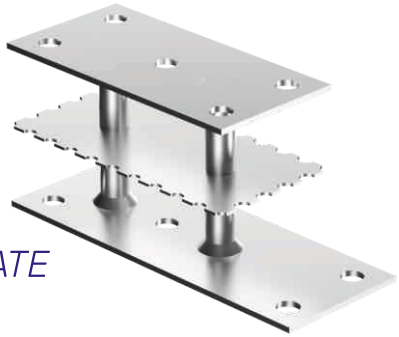
- Varianty: hladký stonek, stonek s drážkami
- Možnost upevnění hřebem nebo samolepicí vrstvou (str. 44-45)

ASYMMETRICAL TWO-STEM CHAPLETS WITH FUSION PLATE

The rectangular base offers greater contact area and stability. The fusion plate ensures strong bonding with the metal. Suitable for demanding castings with high requirements for precision and sintering.

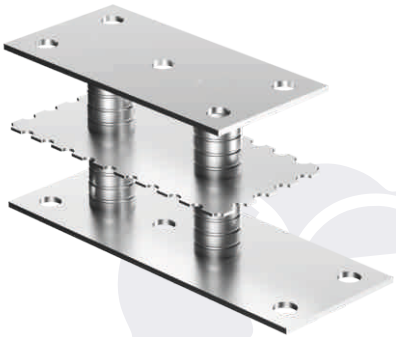
- *Versions: smooth stem, ringed stem*
- *Can be secured with a nail or self-adhesive layer (page 44-45)*

A)

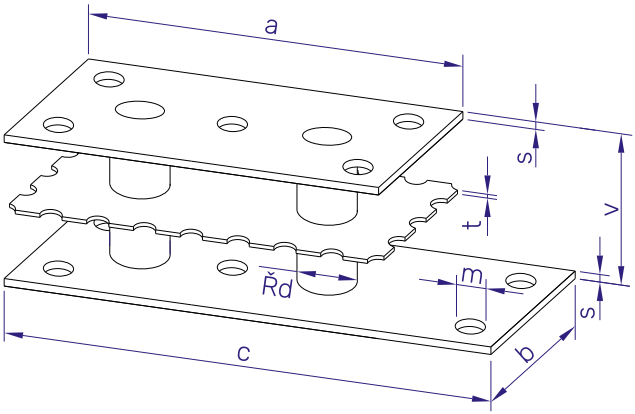


děrované, hladký stonek
perforated, smooth stem

B)



děrované, stonek s drážkami
perforated, ringed stem
(d ≥ ø8 mm)



axb [mm]	ROZMĚR PLECHU *PLATE DIMENSION*
cxb [mm]	ROZMĚR PLECHU *PLATE DIMENSION*
s [mm]	TLOUŠŤKA PLECHU *PLATE THICKNESS*
d [mm]	PRŮMĚR STONKU *STEM DIAMETER*
v [mm]	VÝŠKA *HEIGHT*

SPTD axb/cxbxs - dVv

ASYMETRICKÉ DVOUSTONKOVÉ PODPĚRKY S TAVNOU DESKOU / *ASYMMETRICAL TWO-STEM CHAPLETS WITH FUSION PLATE*

axb/cxb [mm]	s [mm]	d [mm]	v [mm]	TYP/*TYPE*
50x25/65x25	1,0	5,0	10, 12, 14, 15, 16, 18, 19, 20, 22, 25, 29, 30, 35, 40	A
50x25/66x25	1,0	5,0	10, 12, 14, 15, 16, 18, 19, 20, 22, 25, 29, 30, 35, 40	A
50x25/65x25	1,0	8,0	10, 12, 14, 15, 16, 18, 20, 25, 30, 35, 40	B
50x25/65x25	1,5	8,0	10, 12, 14, 15, 16, 18, 20, 25, 30, 35, 40	B
50x25/60x30	1,5	8,0	10, 12, 14, 15, 16, 18, 20, 25, 30, 35, 40	B
60x30/75x30	1,0	8,0	10, 12, 14, 15, 16, 17, 18, 20, 25, 30, 35, 40	B
60x30/75x30	1,5	8,0	10, 12, 14, 15, 16, 18, 20, 25, 30, 35, 40	B
80x40/95x40	1,5	10,0	15, 20, 22, 24, 25, 26, 28, 30, 35, 40, 45, 50, 60, 65	B
80x40/95x40	1,5	12,0	70, 80, 90, 100, 110	B
80x40/95x40	2,0	10,0	20, 25, 30, 35, 40, 50, 60	B
80x40/95x40	2,0	12,0	70, 80	B

CHLADÍCÍ HŘEBY

Hřeby slouží k lokálnímu urychlení chladnutí v masivních oblastech odlitku a tím k omezení smršťovacích vad. Zvyšují kvalitu a soudržnost odlitku.

COOLING NAILS

Cooling nails are designed to promote faster local solidification in heavy casting sections, minimizing shrinkage-related defects and enhancing overall casting quality and cohesion.

TYPY/*TYPES*

A)

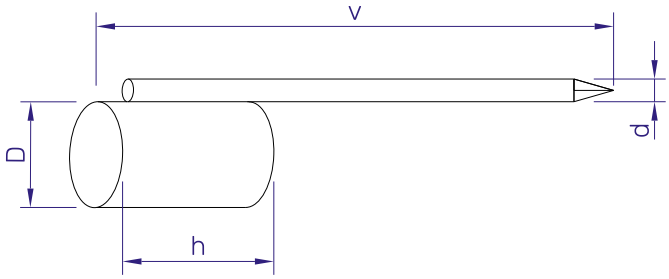
stonek s drážkami
ringed stem

B)

stonek s drážkami
ringed stem

CHLADÍCÍ HŘEBY / *COOLING NAILS*

D [mm]	h [mm]	v [mm]	TYP/*TYPE*
ø 8	10	50	A
ø 12	20	65	A
ø 14	14	65	A
ø 14	20	65	A



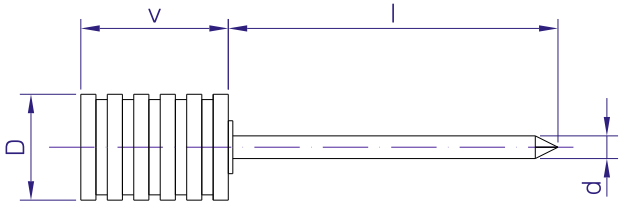
SPCH Dxh L v

D [mm] PRŮMĚR CHLADÍCÍHO TĚLESA
COOLING ELEMENT DIAMETER

h [mm] DÉLKA CHLADÍCÍHO TĚLESA
LENGTH OF THE COOLING ELEMENT

v [mm] CELKOVÁ DÉLKA
TOTAL LENGTH

D [mm]	v [mm]	d [mm]	l [mm]	TYP/*TYPE*
ø 6	10, 20, 30, 40, 50	2,5	30	B
ø 8	10, 20, 30, 40, 50, 60	2,5	30	B
ø 10	10, 20, 25, 30, 40, 50, 60	2,5	30	B
ø 12	10, 20, 30, 40, 50, 60, 70, 80	2,5	30	B
ø 14	10, 20, 30, 40, 50, 60, 70, 80, 90, 100	3,0	40	B
ø 22	20, 30, 40, 50, 60, 70, 80, 90, 100	3,0	40	B



SPCH DxVv/HR dxl

D [mm] PRŮMĚR CHLADÍCÍHO TĚLESA
COOLING ELEMENT DIAMETER

v [mm] DÉLKA CHLADÍCÍHO TĚLESA
LENGTH OF THE COOLING ELEMENT

d [mm] PRŮMĚR HŘEBÍKU
NAIL DIAMETER

l [mm] DÉLKA HŘEBÍKU
NAIL LENGTH

OCELOVÉ POCÍNOVANÉ
TIN-PLATED STEEL

PD PODPĚRNÉ DESKY
CORE PLATES

PODPĚRNÉ DESKY

tyto desky lze využít v případech, kdy je nutno upravit výšku nebo plochu slévárenských podpěrek. Lze je použít i jako zachycovací vtoky pro případné nečistoty.

- Varianty: neděrované, děrované (pouze kruhové)

CORE PLATES

These plates can be used in cases where it is necessary to adjust the height or surface area of foundry chaplets. They can also be used as skim gates to trap potential impurities.

- *Versions: non-perforated, perforated (only round)*

TYPY/*TYPES*

A)

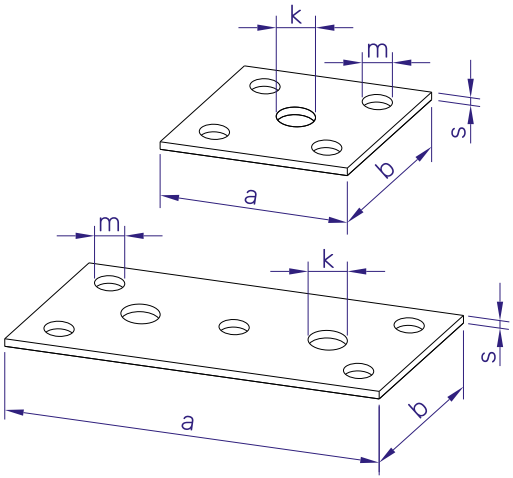
čtvercové
square

B)

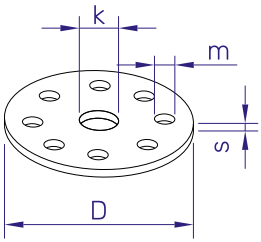
obdélníkové
rectangular

C)

kruhové
round



PD axbxs



PD øDxs

axb [mm]	ROZMĚR PLECHU *PLATE DIMENSION*
D [mm]	ROZMĚR PLECHU *PLATE DIMENSION*
s [mm]	TLOUŠŤKA PLECHU *PLATE THICKNESS*

PODPĚRNÉ DESKY / *CORE PLATES*

axb [mm]	s [mm]	TYP/*TYPE*
10x10	0,8; 1,0	A
15x15	0,8; 1,0	A
20x20	0,8; 1,0	A
25x25	1,0; 2,0	A
30x30	1,0; 1,5; 2,0	A
40x40	1,0; 1,5; 2,0	A
50x50	1,0; 1,5; 2,0	A
60x60	1,0; 1,5; 2,0	A
axb [mm]	**s [mm]**	**TYP/*TYPE***
30x15	0,8; 1,0	B
40x20	1,0	B
50x25	1,0; 1,3; 1,5; 2,0	B
65x25	1,0; 2,0	B
60x30	1,0; 1,5	B
70x40	1,0; 1,5	B
80x25	2,0	B
80x40	1,0; 1,5; 2,0	B
95x40	1,5	B
100x25	1,0	B
100x50	3,0	B
100x80	3,0	B
D [mm]	**s [mm]**	**TYP/*TYPE***
ø 10	0,5; 0,8	C
ø 12	0,5; 0,8	C
ø 14	0,8	C
ø 15	0,5; 0,8; 1,0	C
ø 20	0,5; 0,8; 1,0; 2,0	C
ø 24	2,0	C
ø 25	0,8; 1,0	C
ø 90	0,5	C
ø 110	1,0	C

NEREZOVÉ PODPĚRKY

Podpěrky jsou vyrobeny z **chromniklové oceli 18/10**, která se vyznačuje vysokou korozní odolností a dobrou svařitelností. Tato ocel je nemagnetická.

- Varianty: hladký stonek, stonek s drážkami
- Možnost upevnění hřebem nebo samolepicí vrstvou (str. 44-45)

STAINLESS STEEL CHAPLETS

The supports are made from **18/10 chromium-nickel stainless steel**, *characterized by high corrosion resistance and good weldability. This steel is non-magnetic.*

- *Versions: smooth stem, ringed stem*
- *Can be secured with a nail or self-adhesive layer (page 44-45)*

TYPY/*TYPES*

A)

děrované, hladký stonek
perforated, smooth stem

NEREZOVÉ PODPĚRKY S TAVNOU DESKOU / *STAINLESS STEEL CHAPLETS WITH FUSION PLATE*

axb [mm]	s [mm]	d [mm]	v [mm]	TYP/*TYPE*
15x15	0,8	2,8	7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25 26, 27, 28, 29, 30	A

SPTD Cr/Ni axb/cxbxs - dVv

HLINÍKOVÉ PODPĚRKY

Podpěrky jsou vyrobeny ze **slitiny hliníku EN AW 5754**, která se vyznačuje dobrou svařitelností a také odolností proti korozi. Chemické složení materiálu dle evropské normy EN 573-3.

- Varianty: hladký stonek, stonek s drážkami
- Možnost upevnění samolepicí vrstvou (str. 45)

ALUMINUM CHAPLETS

The supports are made from **aluminum alloy EN AW 5754**, *which is characterized by good weldability and excellent corrosion resistance. The chemicalcomposition of the material complies with the Europeanstandard EN 573-3.*

- *Versions: smooth stem, ringed stem*
- *Can be secured with a self-adhesive layer (page 45)*

TYPY/*TYPES*

A)

děrované, hladký stonek
perforated, smooth stem

B)

děrované, hladký stonek souměrné
perforated, smooth stem symmetrical

C)

děrované, hladký stonek nesouměrné
perforated, smooth stem asymmetrical

D)

děrované, hladký stonek
perforated, smooth stem

HLINÍKOVÉ KRUHOVÉ PODPĚRKY / *ALUMINIUM ROUND-PLATE CHAPLETS*

D [mm]	s [mm]	d [mm]	v [mm]	TYP/*TYPE*
ø 10	0,8	2,5	6, 7, 8, 9, 10, 11, 12, 13, 14, 20	A
ø 12	0,8	2,5	6, 7, 8, 9, 10, 11, 12, 13, 14	A
ø 14	0,8	2,8	7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22	A
ø 15	0,8	2,8	7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22	A
ø 20	0,8	2,8	7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22	A
ø 20	1,0	5,0	8, 10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35	A
ø 25	1,0	5,0	8, 10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35	A

SP ø Dxs - dVv

HLINÍKOVÉ JEDNOSTONKOVÉ PODPĚRKY / *ALUMINIUM SINGLE-STEM CHAPLETS*

axb [mm]	s [mm]	d [mm]	v [mm]	TYP/*TYPE*
15x15	0,8	2,8	6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20	B
20x20	0,8	2,8	7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22	B
20x20	1,0	5,0	8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 22	B
25x25	1,0	5,0	8, 10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35	B
30x30	1,0	5,0	10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 34, 35, 36, 40	B
20x20/25x25	1,0	5,0	8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20	C

SP axbxs - dVv

HLINÍKOVÉ DVOUSTONKOVÉ PODPĚRKY / *ALUMINIUM TWO-STEM CHAPLETS*

axb [mm]	s [mm]	d [mm]	v [mm]	TYP/*TYPE*
50x25	1,0	5,0	8, 10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 35, 40, 42, 45, 50	D
60x30	1,0	5,0	10, 12, 14, 15, 16, 18, 20, 22, 24, 25, 26, 28, 30, 32, 34, 35, 36, 40	D

SP axbxs - dVv

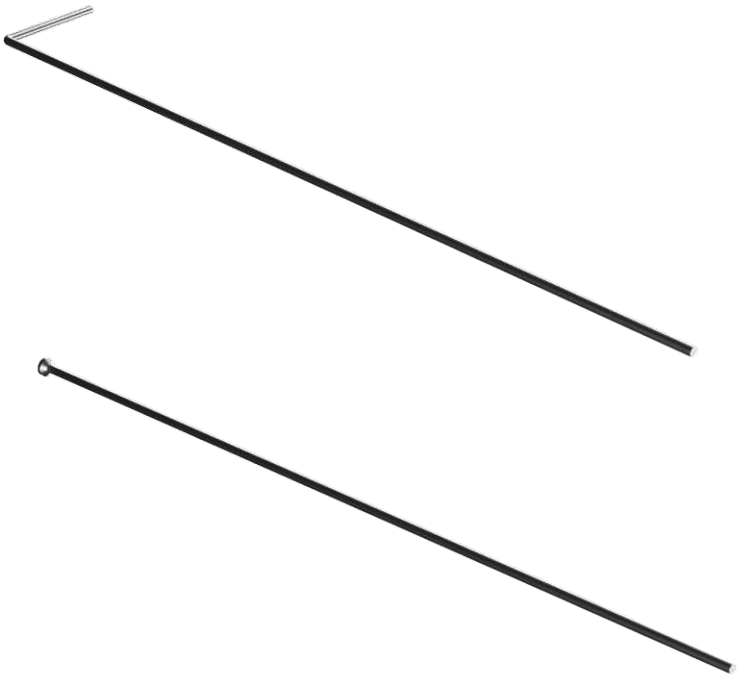
PÍSKOVÁKY

Speciální kovové hřebíky používané k upevnění jader (např. pískových) uvnitř formy během lití kovu.

CORE NAILS

Special metal nails used to secure cores (e.g., sand cores) inside the mold during metal casting.

TYPY/*TYPES*



HLAVA HŘEBÍKU 2-3 mm / *NAIL HEAD 2-3 mm*

PRŮMĚR HŘEBÍKU [mm] *NAIL DIAMETER [mm]*	DÉLKA HŘEBÍKU [mm] *NAIL LENGTH [mm]*
⌀ 1,25	50
⌀ 1,25	63
⌀ 1,6	60
⌀ 1,6	80
⌀ 1,6	100
⌀ 1,6	125
⌀ 1,8	125
⌀ 1,8	160
⌀ 1,8	180

Větší atypické pískováky lze vyrobit jakékoliv délky s průměrem hřebíků: **⌀ 1,8; 2,0; 2,5; 3,1...mm**

Larger custom core nails can be manufactured in any lengths with nail diameters of: **⌀ 1,8; 2,0; 2,5; 3,1...mm**

HÁKOVÁ HLAVA / HOOKED HEAD

PRŮMĚR HŘEBÍKU [mm] *NAIL DIAMETER [mm]*	DÉLKA HŘEBÍKU [mm] *NAIL LENGTH [mm]*
⌀ 1,25	70
⌀ 1,6	70
⌀ 1,6	160

PODPĚRKY S KOTEVNÍM HŘEBEM

Všechny slévárenské podpěrky je možné dodat s kotevním hřebíkem. Průměr a délka hřebíku viz. tabulka.

CHAPLETS WITH ANCHORING NAIL

All foundry chaplets can be supplied with an anchoring nail. Nail diameter and length – see table below.

HŘEBÍKY K UCHYCENÍ PODPĚREK
NAILS FOR SECURING CHAPLETS

PRŮMĚR HŘEBÍKU [mm] *NAIL DIAMETER [mm]*	DÉLKA HŘEBÍKU [mm] *NAIL LENGTH [mm]*
ø 1,6	13
ø 1,6	18
ø 1,6	23
ø 1,8	15
ø 1,8	20
ø 1,8	25
ø 2,0	15
ø 2,6	20
ø 2,6	25
ø 2,6	30
ø 3,1	40

NAPŘ./*E.G.*

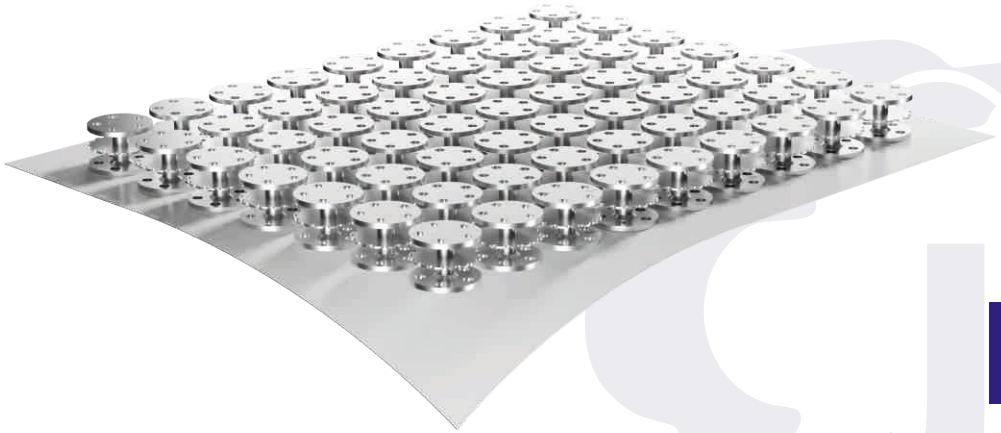
SAMOLEPÍCÍ PODPĚRKY

NAPŘ./*E.G.*

Všechny naše slévárenské podpěrky nabízíme také v praktické samolepicí verzi. Podpěrky jsou umístěny na arších **silikonizovaný papíru** a opatřeny tenkou vrstvou speciálního lepidla, které zajišťuje okamžité přilnutí k jakémukoli povrchu. Tento způsob aplikace výrazně zjednodušuje a urychluje instalaci podpěrek do forem, zvyšuje efektivitu práce a minimalizuje riziko chyb při montáži.

SELF-ADHESIVE CHAPLETS

All our foundry chaplets are also available in a practical self-adhesive version.The chaplets are placed on sheets of **siliconized paper** *and coated with a thin layer of special adhesive that ensures instant adhesion to any surface. This application method significantly simplifies and speeds up the installation of chaplets into molds, increases work efficiency, and minimizes the risk of assembly errors.*



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