

Roxtec S frame



EN Roxtec S frame is a metal frame available with a single opening, or in combinations with several openings in width and/or height.

- For use with Group RM components
- Attachment by welding
- SE PPS accessory available for plastic pipe seals

SE Roxtec S-ram är en metallram som finns med en öppning eller i kombinationer med flera öppningar i bredd och/eller höjd.

- För användning ihop med komponenter ur Grupp RM
- Infästning genom svetsning
- SE PPS finns som tillbehör för tätning av plaströr

FI Roxtec S-kehys on metallikehys, joka on saatavana yksiaukkoisena kehyksenä tai yhdistelmänä, jossa useita erikorkuisia ja -levyisiä aukkoja.

- Käytetään RM-tuoteryhmän komponenttien kanssa
- Kiinnitetään hitsaamalla
- SE PPS saatavana lisävarusteena muoviputkitiivisteisiin

IT Il telaio S di Roxtec è un telaio metallico da fissare prevalentemente mediante saldatura. Disponibile ad apertura singola o come combinazione di aperture variabili in larghezza e/o altezza.

- Fissaggio con saldatura
- Da utilizzare con componenti del gruppo RM
- Disponibile l'accessorio di tenuta per tubi in plastica (SE PPS)

RU Рама S от Roxtec - изготавливается из металла. Предлагаются конфигурации одно- и многосекционные. Секции могут добавляться по высоте и/или ширине.

- Для использования с компонентами группы RM
- Рама только для приваривания
- Для герметизации пластиковых труб необходимо дополнительно использовать раму SE PPS

S frames, primed, mild steel

S-kehykset, pohjamaalattu teräs » Рама S, окрашенная, стальная » S-ramar, lackerat konstruktionsstål » Telaio S, in acciaio con prima mano d'antiruggine



S 6x1 primed

Parts needed for a complete solution



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Optional



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See also Installation guidelines on page 189.

For information about other frame combinations that are not presented and for openable versions of this frame, please contact your local Roxtec supplier or e-mail: info@roxtec.com

RATINGS		Fire: A-Class, H-Class	Water pressure: 4 bar	Gas pressure: 2.5 bar				
FI	Kehys	Aukkojen lukumäärä	Pakkaustila (mm)	Ulkomitat (D=60 mm)		Paino		Tuotenumero
	Рама	Количество проёмов	Зона уплотнения (мм)	HxW (mm)	HxW (in)	(kg)	(lb)	
RU	Ram	Ramöppningar	Packningsutrymme (mm)	Yttermått (D=60 mm)		Vikt		Artikelnnummer
	Telaio	Aperture telaio	Spazio di riempimento (mm)	HxW (mm)	HxW (tum)	(kg)	(lb)	Art.Nr.
SE	Frame	Frame openings	Packing space (mm)	External dimensions (D=60 mm)		Weight		Art. No.
	S 1x1 primed	1	60 x 60	121 x 80	4.764 x 3.150	1.6	3.527	SS01000000112
IT	S 2x1 primed	1	60 x 120	121 x 141	4.764 x 5.551	2.2	4.938	S002000000112
	S 2x2 primed	2	60 x 120	121 x 271	4.764 x 10.669	3.9	8.488	S002000000212
EN	S 2x3 primed	3	60 x 120	121 x 402	4.764 x 15.827	5.5	12.037	S002000000312
	S 2x4 primed	4	60 x 120	121 x 532	4.764 x 20.945	7.1	15.609	S002000000412
	S 2x5 primed	5	60 x 120	121 x 663	4.764 x 26.102	8.7	19.158	S002000000512
	S 2x6 primed	6	60 x 120	121 x 793	4.764 x 31.220	10.3	22.707	S002000000612
	S 3x1 primed	1	120 x 60	180 x 80	7.087 x 3.150	2.3	5.071	SS03000000112
	S 4x1 primed	1	120 x 120	180 x 141	7.087 x 5.551	2.8	6.151	S004000000112
	S 4x2 primed	2	120 x 120	180 x 271	7.087 x 10.669	4.7	10.318	S004000000212
	S 4x3 primed	3	120 x 120	180 x 402	7.087 x 15.827	6.6	14.484	S004000000312
	S 4x4 primed	4	120 x 120	180 x 532	7.087 x 20.945	8.5	18.629	S004000000412
	S 4x5 primed	5	120 x 120	180 x 663	7.087 x 26.102	10.3	22.796	S004000000512
	S 4x6 primed	6	120 x 120	180 x 793	7.087 x 31.220	12.2	26.962	S004000000612
	S 4x7 primed	7	120 x 120	180 x 924	7.087 x 36.378	14.1	31.129	S004000000712
	S 4x8 primed	8	120 x 120	180 x 1054	7.087 x 41.496	16.0	35.296	S004000000812
	S 4x9 primed	9	120 x 120	180 x 1185	7.087 x 46.654	17.9	39.440	S004000000912

S frames, primed, mild steel

S-kehukset, pohjamaalattu teräs ▶ Рама S, окрашенная, стальная ▶ S-ramar, lackerat konstruktionsstål ▶ Telaio S, in acciaio con prima mano d'antiruggine

FI	Kehys	Aukkojen lukumäärä	Pakkaustila (mm)	Ulkomitat (D=60 mm)		Paino		Tuotenumero
	RU	Количество проёмов	Зона уплотнения (мм)	HxW (mm)	HxW (in)	(kg)	(lb)	
SE	Ram	Ramöppningar	Packningsutrymme (mm)	Yttermått (D=60 mm)		Vikt		Artikelnummer
	IT	Aperture telaio	Spazio di riempimento (mm)	HxW (mm)	HxW (tum)	(kg)	(lb)	
EN	Telaio	Frame openings	Packing space (mm)	External dimensions (D=60 mm)		Weight		Art. No.
	Frame	Frame openings	Packing space (mm)	HxW (mm)	HxW (in)	(kg)	(lb)	
	S 4+4x1 primed	2	120 x 120	349 x 141	13.740 x 5.551	5.0	11.067	S004400000112
	S 4+4x2 primed	4	120 x 120	359 x 271	14.134 x 10.669	9.5	20.878	S004400000212
	S 4+4x3 primed	6	120 x 120	359 x 402	14.134 x 15.827	13.5	29.321	S004400000312
	S 4+4x4 primed	8	120 x 120	359 x 532	14.134 x 20.945	17.1	37.743	S004400000412
	S 4+4x5 primed	10	120 x 120	359 x 663	14.134 x 26.102	21.0	46.186	S004400000512
	S 4+4x6 primed	12	120 x 120	359 x 793	14.134 x 31.220	24.8	54.630	S004400000612
	S 4+4x7 primed	14	120 x 120	359 x 924	14.134 x 36.378	28.6	63.096	S004400000712
	S 4+4x8 primed	16	120 x 120	359 x 1054	14.134 x 41.496	32.6	71.539	S004400000812
	S 4+4+4x1 primed	3	120 x 120	519 x 141	20.433 x 5.551	6.6	14.550	S004440000112
	S 4+4+4x2 primed	6	120 x 120	539 x 271	21.220 x 10.669	14.2	31.305	S004440000212
	S 4+4+4x3 primed	9	120 x 120	539 x 402	21.220 x 15.827	19.9	43.872	S004440000312
	S 4+4+4x4 primed	12	120 x 120	539 x 532	21.220 x 20.945	26.2	57.761	S004440000412
	S 4+4+4x5 primed	15	120 x 120	539 x 663	21.220 x 26.102	31.3	69.004	S004440000512
	S 4+4+4x6 primed	18	120 x 120	539 x 793	21.220 x 31.220	37.0	81.570	S004440000612
	S 5x1 primed	1	180 x 60	238 x 80	9.370 x 3.150	2.8	6.173	SS05000000112
	S 6x1 primed	1	180 x 120	238 x 141	9.370 x 5.551	3.3	7.363	S006000000112
	S 6x2 primed	2	180 x 120	238 x 271	9.370 x 10.669	5.5	12.147	S006000000212
	S 6x3 primed	3	180 x 120	238 x 402	9.370 x 15.827	7.7	16.909	S006000000312
	S 6x4 primed	4	180 x 120	238 x 532	9.370 x 20.945	9.8	21.671	S006000000412
	S 6x5 primed	5	180 x 120	238 x 663	9.370 x 26.102	12.0	26.455	S006000000512
	S 6x6 primed	6	180 x 120	238 x 793	9.370 x 31.220	14.2	31.217	S006000000612
	S 6x7 primed	7	180 x 120	238 x 924	9.370 x 36.378	16.3	35.979	S006000000712
	S 6x8 primed	8	180 x 120	238 x 1054	9.370 x 41.496	18.5	40.763	S006000000812
	S 6x9 primed	9	180 x 120	238 x 1185	9.370 x 46.654	20.7	45.525	S006000000912
	S 6+6x1 primed	2	180 x 120	466 x 141	18.346 x 5.551	6.1	13.492	S006600000112
	S 6+6x2 primed	4	180 x 120	476 x 271	18.740 x 10.669	11.1	24.537	S006600000212
	S 6+6x3 primed	6	180 x 120	476 x 402	18.740 x 15.827	15.5	34.171	S006600000312
	S 6+6x4 primed	8	180 x 120	476 x 532	18.740 x 20.945	19.9	43.827	S006600000412
	S 6+6x5 primed	10	180 x 120	476 x 663	18.740 x 26.102	24.3	53.506	S006600000512

S frames, primed, mild steel

S-kehyykset, pohjamaalattu teräs » Рама S, окрашенная, стальная » S-ramar, lackerat konstruktionsstål » Telaio S, in acciaio con prima mano d'antiruggine

FI	Kehys	Aukkojen lukumäärä	Pakkaustila (mm)	Ulkomitat (D=60 mm)		Paino		Tuotenumero
	Рама	Количество проёмов	Зона уплотнения (мм)	HxW (mm)	HxW (in)	(kg)	(lb)	Art. №
RU	Ram	Ramöppningar	Packningsutrymme (mm)	Yttermått (D=60 mm)		Vikt		Artikelnummer
	Telaio	Aperture telaio	Spazio di riempimento (mm)	HxW (mm)	HxW (tum)	(kg)	(lb)	Art.Nr.
SE	Frame	Frame openings	Packing space (mm)	External dimensions (D=60 mm)		Weight		Art. No.
				HxW (mm)	HxW (in)	(kg)	(lb)	
	S 6+6x6 primed	12	180 x 120	476 x 793	18.740 x 31.220	28.6	63.140	S006600000612
	S 6+6x7 primed	14	180 x 120	476 x 924	18.740 x 36.378	33.0	72.796	S006600000712
	S 6+6x8 primed	16	180 x 120	476 x 1054	18.740 x 41.496	37.4	82.474	S006600000812
	S 6+6x9 primed	18	180 x 120	476 x 1185	18.740 x 46.654	41.8	92.108	S006600000912
	S 6+6x10 primed	20	180 x 120	476 x 1315	18.740 x 51.772	46.2	101.764	S006600001012
	S 6+6+6x1 primed	3	180 x 120	694 x 141	27.323 x 5.551	8.2	18.078	S006660000112
	S 7x1 primed	1	240 x 60	298 x 80	11.732 x 3.150	3.3	7.363	SS07000000112
	S 8x1 primed	1	240 x 120	298 x 141	11.732 x 5.551	3.9	8.620	S008000000112
	S 8x2 primed	2	240 x 120	298 x 271	11.732 x 10.669	6.1	13.382	S008000000212
	S 8x3 primed	3	240 x 120	298 x 402	11.732 x 15.827	8.2	18.144	S008000000312
	S 8x4 primed	4	240 x 120	298 x 532	11.732 x 20.945	10.4	22.928	S008000000412
	S 8x5 primed	5	240 x 120	298 x 663	11.732 x 26.102	12.6	27.690	S008000000512
	S 8x6 primed	6	240 x 120	298 x 793	11.732 x 31.220	14.7	32.452	S008000000612
	S 8+8x1 primed	2	240 x 120	586 x 141	23.071 x 5.551	7.3	16.005	S008800000112
	S 8+8x2 primed	4	240 x 120	596 x 271	23.465 x 10.669	12.3	27.006	S008800000212
	S 8+8x3 primed	6	240 x 120	596 x 402	23.465 x 15.827	16.6	36.640	S008800000312
	S 8+8x4 primed	8	240 x 120	596 x 532	23.465 x 20.945	21.0	46.341	S008800000412
	S 8+8x5 primed	10	240 x 120	596 x 663	23.465 x 26.102	25.4	55.975	S008800000512
	S 8+8x6 primed	12	240 x 120	596 x 793	23.465 x 31.220	29.8	65.609	S008800000612
	S 8+8x7 primed	14	240 x 120	596 x 924	23.465 x 36.378	34.2	75.309	S008800000712
	S 8+8x8 primed	16	240 x 120	596 x 1054	23.465 x 41.496	38.5	84.943	S008800000812
	S 8+8x9 primed	18	240 x 120	596 x 1185	23.465 x 46.654	42.9	94.577	S008800000912
	S 8+8x10 primed	20	240 x 120	596 x 1315	23.465 x 51.772	47.3	104.278	S008800001012
	S 8+8+8x1 primed	3	240 x 120	874 x 141	34.409 x 5.551	9.9	21.826	S008880000112

S frames, acid proof stainless steel

S-kehukset, haponkestävä ruostumaton teräs ▶ Рама S, кислотоустойчивая, нержавеющая сталь ▶ S-ramar, syrafast rostfritt stål ▶ Telaio S, in acciaio inox resistente agli acidi



S 6x1 AISI 316

Parts needed for a complete solution

Optional

See also Installation guidelines on page 189.

For information about other frame combinations that are not presented and for openable versions of this frame, please contact your local Roxtec supplier or e-mail: info@roxtec.com

RATINGS	Fire: A-Class, H-Class	Water pressure: 4 bar	Gas pressure: 2.5 bar
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	FI RU SE IT EN	Kehys Рама Ram Telaio Frame	Aukkojen lukumäärä Количество проёмов Ramöppningar Apertura telaio Frame openings	Pakkaustila (mm) Зона уплотнения (мм) Packningsutrymme (mm) Spazio di riempimento (mm) Packing space (mm)	Ulkomitat (D=60 mm) HxW (mm) HxW (in)		Paino (kg) (lb)		Tuotenumero Арт. № Artikelnummer Art.Nr. Art. No.
					HxW (mm)	HxW (in)	Вес (кг)	(фунт)	
					Yttermått (D=60 mm) HxW (mm) HxW (tum)		Vikt (kg) (lb)		
					Dimensioni esterne (D=60 mm) HxW (mm) HxW (tum)		Peso (kg) (lb)		
					External dimensions (D=60 mm) HxW (mm) HxW (in)		Weight (kg) (lb)		
		S 2x1 AISI 316	1	60 x 120	121 x 141	4.764 x 5.551	2.2	4.938	S002000000121
		S 2x2 AISI 316	2	60 x 120	121 x 271	4.764 x 10.669	3.9	8.488	S002000000221
		S 2x3 AISI 316	3	60 x 120	121 x 402	4.764 x 15.827	5.5	12.037	S002000000321
		S 2x4 AISI 316	4	60 x 120	121 x 532	4.764 x 20.945	7.1	15.609	S002000000421
		S 2x5 AISI 316	5	60 x 120	121 x 663	4.764 x 26.102	8.7	19.158	S002000000521
		S 2x6 AISI 316	6	60 x 120	121 x 793	4.764 x 31.220	10.3	22.707	S002000000621
		S 4x1 AISI 316	1	120 x 120	180 x 141	7.087 x 5.551	2.8	6.151	S004000000121
		S 4x2 AISI 316	2	120 x 120	180 x 271	7.087 x 10.669	4.7	10.318	S004000000221
		S 4x3 AISI 316	3	120 x 120	180 x 402	7.087 x 15.827	6.6	14.484	S004000000321
		S 4x4 AISI 316	4	120 x 120	180 x 532	7.087 x 20.945	8.5	18.629	S004000000421
		S 4x5 AISI 316	5	120 x 120	180 x 663	7.087 x 26.102	10.3	22.796	S004000000521
		S 4x6 AISI 316	6	120 x 120	180 x 793	7.087 x 31.220	12.2	26.962	S004000000621
		S 4+4x1 AISI 316	2	120 x 120	349 x 141	13.740 x 5.551	5.0	11.067	S004400000121
		S 4+4+4x1 AISI 316	3	120 x 120	519 x 141	20.433 x 5.551	6.6	14.550	S004440000121
		S 6x1 AISI 316	1	180 x 120	238 x 141	9.370 x 5.551	3.3	7.363	S006000000121
		S 6x2 AISI 316	2	180 x 120	238 x 271	9.370 x 10.669	5.5	12.147	S006000000221

S frames, acid proof stainless steel

S-kehukset, haponkestävä ruostumaton teräs ▶ Рама S, кислотоустойчивая, нержавеющая сталь ▶ S-ramar, syrafast rostfritt stål ▶ Telaio S, in acciaio inox resistente agli acidi

FI	Kehys	Aukkojen lukumäärä	Pakkaustila (mm)	Ulkomitat (D=60 mm)		Paino		Tuotenumero
	RU	Количество проёмов	Зона уплотнения (мм)	HxW (mm)	HxW (in)	(kg)	(lb)	
SE	Ram	Ramöppningar	Packningsutrymme (mm)	Yttermått (D=60 mm)		Vikt		Artikelnummer
	IT	Apertura telaio	Spazio di riempimento (mm)	HxW (mm)	HxW (tum)	(kg)	(lb)	
EN	Telaio	Apertura telaio	Spazio di riempimento (mm)	Dimensioni esterne (D=60 mm)		Peso		Art.Nr.
	Frame	Frame openings	Packing space (mm)	HxW (mm)	HxW (in)	(kg)	(lb)	
	S 6x3 AISI 316	3	180 x 120	238 x 402	9.370 x 15.827	7.7	16.909	S006000000321
	S 6x4 AISI 316	4	180 x 120	238 x 532	9.370 x 20.945	9.8	21.671	S006000000421
	S 6x5 AISI 316	5	180 x 120	238 x 663	9.370 x 26.102	12.0	26.455	S006000000521
	S 6x6 AISI 316	6	180 x 120	238 x 793	9.370 x 31.220	14.2	31.217	S006000000621
	S 6+6x1 AISI 316	2	180 x 120	466 x 141	18.346 x 5.551	6.1	13.492	S006600000121
	S 6+6x2 AISI 316	4	180 x 120	476 x 271	18.740 x 10.669	11.1	24.537	S006600000221
	S 6+6x3 AISI 316	6	180 x 120	476 x 402	18.740 x 15.827	15.5	34.171	S006600000321
	S 6+6x4 AISI 316	8	180 x 120	476 x 532	18.740 x 20.945	19.9	43.872	S006600000421
	S 6+6x5 AISI 316	10	180 x 120	476 x 663	18.740 x 26.102	24.3	53.506	S006600000521
	S 6+6x6 AISI 316	12	180 x 120	476 x 793	18.740 x 31.220	28.6	63.140	S006600000621
	S 8x1 AISI 316	1	240 x 120	298 x 141	11.732 x 5.551	3.9	8.620	S008000000121
	S 8x2 AISI 316	2	240 x 120	298 x 271	11.732 x 10.669	6.1	13.382	S008000000221
	S 8x3 AISI 316	3	240 x 120	298 x 402	11.732 x 15.827	8.2	18.144	S008000000321
	S 8x4 AISI 316	4	240 x 120	298 x 532	11.732 x 20.945	10.4	22.928	S008000000421
	S 8x5 AISI 316	5	240 x 120	298 x 663	11.732 x 26.102	12.6	27.690	S008000000521
	S 8x6 AISI 316	6	240 x 120	298 x 793	11.732 x 31.220	14.7	32.452	S008000000621
	S 8+8x1 AISI 316	2	240 x 120	586 x 141	23.071 x 5.551	7.3	16.005	S008800000121
	S 8+8+8x1 AISI 316	3	240 x 120	874 x 141	34.409 x 5.551	9.9	21.826	S008880000121


S frames, aluminum

S-kehukset, alumiini ▶ Рама S, алюминиевая ▶ S-ramar, aluminium ▶ Telaio S, in alluminio




S 6x1 ALU


Parts needed for a complete solution




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Optional



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See also Installation guidelines on page 189.

For information about other frame combinations that are not presented and for openable versions of this frame, please contact your local Roxtec supplier or e-mail: info@roxtec.com

RATINGS	Fire: A-Class, H-Class	Water pressure: 4 bar	Gas pressure: 2.5 bar
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	FI RU SE IT EN	Kehys Рама Ram Telaio Frame	Aukkojen lukumäärä Количество проёмов Ramöppningar Apertura telaio Frame openings	Pakkaustila (mm) Зона уплотнения (мм) Packing space (mm)	Ulkomitat (D=60 mm) HxW (mm) HxW (in)		Paino (kg) (lb)		Tuotenumero Арт. № Artikelnummer Art.Nr. Art. No.
					HxW (mm)	HxW (in)	(kg)	(lb)	
					Внешние размеры (D=60 мм) HxW (мм) HxW (дюйм)		Вес (кг) (фунт)		
					Yttermått (D=60 mm) HxW (mm) HxW (tum)		Vikt (kg) (lb)		
					Dimensioni esterne (D=60 mm) HxW (mm) HxW (tum)		Peso (kg) (lb)		
					HxW (mm)	HxW (in)	(kg)	(lb)	
		S 2x1 ALU	1	60 x 120	121 x 141	4.764 x 5.551	0.8	1.698	S00200000131
		S 2x2 ALU	2	60 x 120	121 x 271	4.764 x 10.669	1.3	2.910	S00200000231
		S 2x3 ALU	3	60 x 120	121 x 402	4.764 x 15.827	1.9	4.145	S00200000331
		S 2x4 ALU	4	60 x 120	121 x 532	4.764 x 20.945	2.4	5.357	S00200000431
		S 2x5 ALU	5	60 x 120	121 x 663	4.764 x 26.102	3.0	6.592	S00200000531
		S 2x6 ALU	6	60 x 120	121 x 793	4.764 x 31.220	3.5	7.804	S00200000631
		S 2+2x1 ALU	2	60 x 120	232 x 141	9.134 x 5.551	1.3	2.965	S00220000131
		S 2+2+2x1 ALU	3	60 x 120	343 x 141	13.504 x 5.551	1.7	3.748	S00222000131
		S 4x1 ALU	1	120 x 120	180 x 141	7.087 x 5.551	1.0	2.116	S00400000131
		S 4x2 ALU	2	120 x 120	180 x 271	7.087 x 10.669	1.6	3.549	S00400000231
		S 4x3 ALU	3	120 x 120	180 x 402	7.087 x 15.827	2.3	4.982	S00400000331
		S 4x4 ALU	4	120 x 120	180 x 532	7.087 x 20.945	2.9	6.415	S00400000431
		S 4x5 ALU	5	120 x 120	180 x 663	7.087 x 26.102	3.6	7.848	S00400000531
		S 4x6 ALU	6	120 x 120	180 x 793	7.087 x 31.220	4.2	9.281	S00400000631
		S 4+4x1 ALU	2	120 x 120	349 x 141	13.740 x 5.551	1.7	3.762	S00440000131
		S 4+4x2 ALU	4	120 x 120	359 x 271	14.134 x 10.669	3.2	7.099	S00440000231

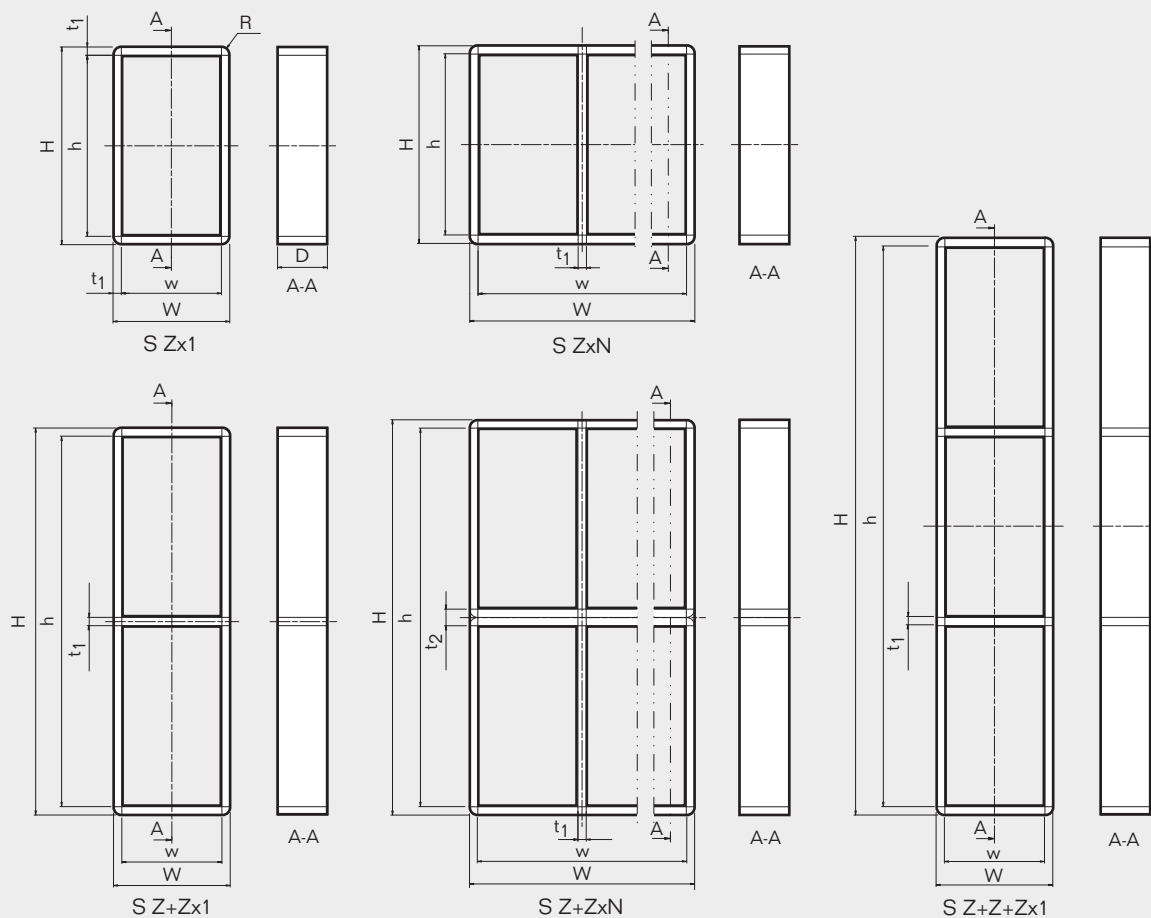
S frames, aluminum

S-kehäykset, alumiini » Рама S, алюминиевая » S-ramar, aluminium » Telaio S, in alluminio

FI	Kehys	Aukkojen lukumäärä	Pakkaustila (mm)	Ulkomitat (D=60 mm)		Paino		Tuotenumero
	RU	Количество проёмов	Зона уплотнения (мм)	HxW (mm)	HxW (in)	(kg)	(lb)	
SE	Ram	Ramöppningar	Packningsutrymme (mm)	Yttermått (D=60 mm)		Vikt		Artikelnummer
	IT	Aperture telaio	Spazio di riempimento (mm)	HxW (mm)	HxW (tum)	(kg)	(lb)	
EN	Telaio	Aperture telaio	Spazio di riempimento (mm)	Dimensioni esterne (D=60 mm)		Peso		Art.Nr.
	Frame	Frame openings	Packing space (mm)	External dimensions (D=60 mm)		Weight		
				HxW (mm)	HxW (in)	(kg)	(lb)	Art. No.
	S 4+4x3 ALU	6	120 x 120	359 x 402	14.134 x 15.827	4.5	9.965	S004400000331
	S 4+4x4 ALU	8	120 x 120	359 x 532	14.134 x 20.495	5.8	12.831	S004400000431
	S 4+4+4x1 ALU	3	120 x 120	519 x 141	20.433 x 5.551	2.3	5.071	S004440000131
	S 6x1 ALU	1	180 x 120	238 x 141	9.370 x 5.551	1.2	2.535	S006000000131
	S 6x2 ALU	2	180 x 120	238 x 271	9.370 x 10.669	1.9	4.167	S006000000231
	S 6x3 ALU	3	180 x 120	238 x 402	9.370 x 15.827	2.6	5.820	S006000000331
	S 6x4 ALU	4	180 x 120	238 x 532	9.370 x 20.495	3.4	7.452	S006000000431
	S 6x5 ALU	5	180 x 120	238 x 663	9.370 x 26.102	4.1	9.083	S006000000531
	S 6x6 ALU	6	180 x 120	238 x 793	9.370 x 31.220	4.9	10.736	S006000000631
	S 6+6x1 ALU	2	180 x 120	466 x 141	18.346 x 5.551	2.1	4.630	S006600000131
	S 6+6x2 ALU	4	180 x 120	476 x 271	18.740 x 10.669	3.8	8.333	S006600000231
	S 6+6x3 ALU	6	180 x 120	476 x 402	18.740 x 15.827	5.3	11.640	S006600000331
	S 6+6x4 ALU	8	180 x 120	476 x 532	18.740 x 20.495	6.8	14.903	S006600000431
	S 6+6x5 ALU	10	180 x 120	476 x 663	18.740 x 26.102	8.2	18.166	S006600000531
	S 6+6x6 ALU	12	180 x 120	476 x 793	18.740 x 31.220	9.7	21.473	S006600000631
	S 6+6+6x1 ALU	3	180 x 120	694 x 141	27.323 x 5.551	2.8	6.173	S006660000131
	S 8x1 ALU	1	240 x 120	298 x 141	11.732 x 5.551	1.3	2.954	S008000000131
	S 8x2 ALU	2	240 x 120	298 x 271	11.732 x 10.669	2.2	4.806	S008000000231
	S 8x3 ALU	3	240 x 120	298 x 402	11.732 x 15.872	3.0	6.658	S008000000331
	S 8x4 ALU	4	240 x 120	298 x 532	11.732 x 20.495	3.9	8.532	S008000000431
	S 8x5 ALU	5	240 x 120	298 x 663	11.732 x 26.102	4.7	10.385	S008000000531
	S 8x6 ALU	6	240 x 120	298 x 793	11.732 x 31.220	5.6	12.236	S008000000631
	S 8+8x1 ALU	2	240 x 120	586 x 141	23.071 x 5.551	2.5	5.467	S008800000131
	S 8+8+8x1 ALU	3	240 x 120	874 x 141	34.409 x 5.551	3.4	7.496	S008880000131

S frames, technical information

S-kehysten tekniset tiedot ► Рама S, техническая информация ► S-ramar, teknisk information ►
Telai S, informazioni tecniche



Pos	(mm)	(in)
h	H - 20	H - 0.787
w	W - 20	W - 0.787
D	60	2.362
t ₁	10	0.394
t ₂	20	0.787
R	R 10	R 0.394

Z = Frame size
N = Number of horizontal openings

Z = Kehyksen koko
N = Aukkojen lukumäärä vaakasuunnassa

Z - Размер рамы
N - Количество проемов/секций по горизонтали

Z = Ramstorlek
N = Antal öppningar i bredd

Z = Grandezza telaio
N = Numero delle aperture orizzontali

Note: All dimensions are nominal values
Huomaa: Kaikki mitat ovat nimellisarvoja
Внимание: Все размеры номинальные
Obs: Alla mått är nominella
Nota: tutte le dimensioni sono valori nominali

S frame, aperture dimensions for welded installations

S-kehysten aukkojen koot hitsattaviin asennuksiin

Рама S, размеры проёмов для приваривания

S-ram, håltagningsmått för svetsmontering

Telai S, dimensioni dell' apertura per installazioni a saldare



FI	Korkeustoleranssi ± 1 mm, ±0.039"				Leveystoleranssi ± 1 mm, ±0.039"									
	1 aukko leveysuunnassa (mm) (in)		> 1 aukko leveysuunnassa (mm) (in)		x1	x2	x3	x4	x5 (mm)/(in)	x6	x7	x8	x9	x10
RU	Допуск по высоте ± 1 мм, ±0.039"				Допуск по ширине ± 1 мм, ±0.039"									
	1 проём в ширину (мм) (дюйм)		> 1 проёма в ширину (мм) (дюйм)		x1	x2	x3	x4	x5 (мм)/(дюйм)	x6	x7	x8	x9	x10
SE	Höjdtolerans ± 1 mm, ±0.039"				Breddtolerans ± 1 mm, ±0.039"									
	1 öppning i bredd (mm) (tum)		> 1 öppning i bredd (mm) (tum)		x1	x2	x3	x4	x5 (mm)/(tum)	x6	x7	x8	x9	x10
IT	Tolleranza in altezza ± 1 mm, ±0.039"				Tolleranza in larghezza ± 1 mm, ±0.039"									
	1 apertura in larghezza (mm) (in)		> 1 apertura in larghezza (mm) (in)		x1	x2	x3	x4	x5 (mm)/(in)	x6	x7	x8	x9	x10
EN	Height tolerance ± 1 mm, ±0.039"				Width tolerance ± 1 mm, ±0.039"									
	1 opening in width (mm) (in)		> 1 opening in width (mm) (in)		x1	x2	x3	x4	x5 (mm)/(in)	x6	x7	x8	x9	x10
S 1	123	4.843			82 3.228									
S 2	123	4.843	123	4.409										
S 2+2	234	9.213	244	9.606	143 5.630	273 10.748	404 15.906	534 21.024	665 26.181	795 31.299	926 36.457	1056 41.575	1187 46.732	1317 51.850
S 2+2+2	345	13.583	365	14.370										
S 3	182	7.165			82 3.228									
S 4	182	7.165	182	7.165										
S 4+4	351	13.819	361	14.213	143 5.630	273 10.748	404 15.906	534 21.024	665 26.181	795 31.299	926 36.457	1056 41.575	1187 46.732	1317 51.850
S 4+4+4	521	20.512	541	21.299										
S 5	240	9.449			82 3.228									
S 6	240	9.449	240	9.449										
S 6+6	468	18.425	478	18.819	143 5.630	273 10.748	404 15.906	534 21.024	665 26.181	795 31.299	926 36.457	1056 41.575	1187 46.732	1317 51.850
S 6+6+6	696	27.402	716	28.189										
S 8	300	11.811	300	11.811										
S 8+8	588	23.150	598	23.543	143 5.630	273 10.748	404 15.906	534 21.024	665 26.181	795 31.299	926 36.457	1056 41.575	1187 46.732	1317 51.850
S 8+8+8	876	34.488	896	35.276										

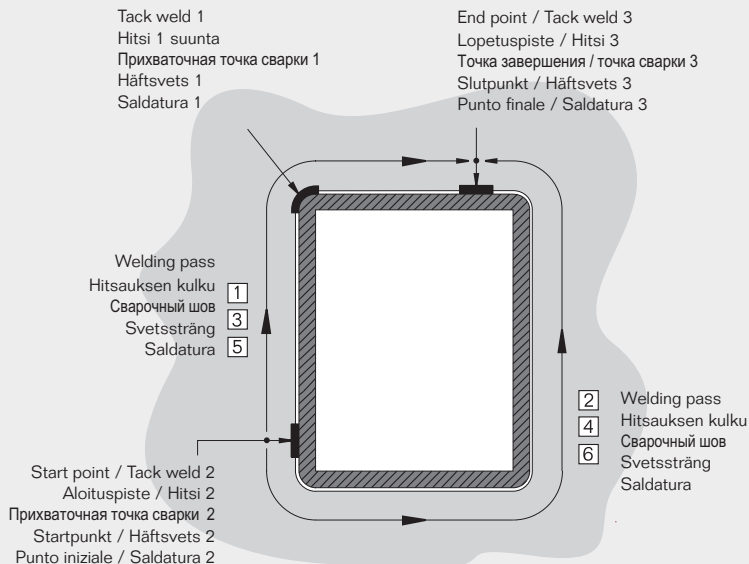
Theoretically recommended dimensions / Teoreettisesti suositeltavat mitat / Рекомендованные размеры - приблизительные / Rekommenderade beräknade mått / Dimensioni teoriche consigliate

S-, SRC-, SK ja SBTB-kehysten hitsausohjeet
 S, SRC, SK и SBTB рамы, Инструкция по привариванию
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 Telai S, SRC, SK e SBTB, linee guida per la saldatura



Welding sequence in bulkhead or deck

Hitsausjärjestys kanteen tai laipioon
 Очередность приваривания на палубу или переборку
 Svetsföljd i skott eller däck
 Procedura di saldatura su paratia e ponte



Buttering should be performed on the deck or bulkhead. Important: The root gap must be as small as possible to keep the tolerance of the openings.

Voitelu tulee suorittaa kanteen tai laipioon. Tärkeää: Raon on oltava mahdollisimman pieni aukkojen toleranssien säilyttämiseksi.

Наплавка соединительного шва. Наплавка должна быть сделана на переборке или палубе. Важно: зазор между свариваемыми кромками должен быть как можно меньше для сохранения допуска в проеме.

Påsvetsning (stumsvetsning) bör utföras på däck eller skottet. Viktigt: svetsspalten måste göras så liten som möjligt för att klara toleransen för ramöppningen.

Il cordone di saldatura deve essere fatto sulla paratia. Importante: Lo spazio deve essere il più stretto possibile per garantire la tolleranza delle aperture.

Max root gap for fillet joint.

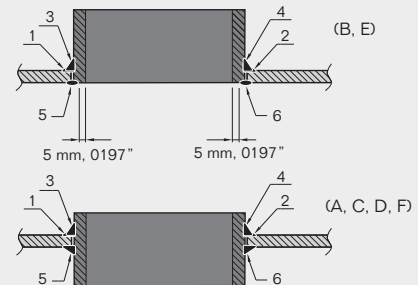
Maks. pienan liitoksen rako.

Максимальное расстояние от рамы до перегородки

Max spalt för insvetsning.

Spazio max. per il cordone di saldatura

Min. space for stayplates
 Min. tila välilevyjä varten.
 Минимальное пространство для разделительной пластины
 Min. frigång för stagbrickor
 Spazio min. per le piastre d'ancoraggio



The examples depict two passes fillet weld.

Esimerkit havainnollistavat kahden piena-hitsin kulkaa.

Пример двух-проходного сварного шва.

Exemplen visar två sekvenser kälsvets.

Gli esempi descrivono un doppio cordone di saldatura.

Important: Weld pass no. 5-6 are not to be started until welding no. 1-4 are completed and the temperature of welding pass no. 1-4 has cooled down to min. pre-heat temperature.

Tärkeää: Hitsauksen kohtia 5-6 ei tule aloittaa ennen kuin hitsaus kohdissa 1-4 on valmis ja kunnes lämpötila hitsauksen kohdissa 1-4 on viilentynyt minimi esikuumentusuämpötilaan.

Внимание: Нельзя продолжать сварку шва в точках 5-6, пока не остынет шов от точки 1 до точки 4.

Obs: Svetssträng nr 5-6 startas efter att svets 1-4 är avslutade och temperaturen på svets 1-4 har minskat till min. förvärmings-temperatur.

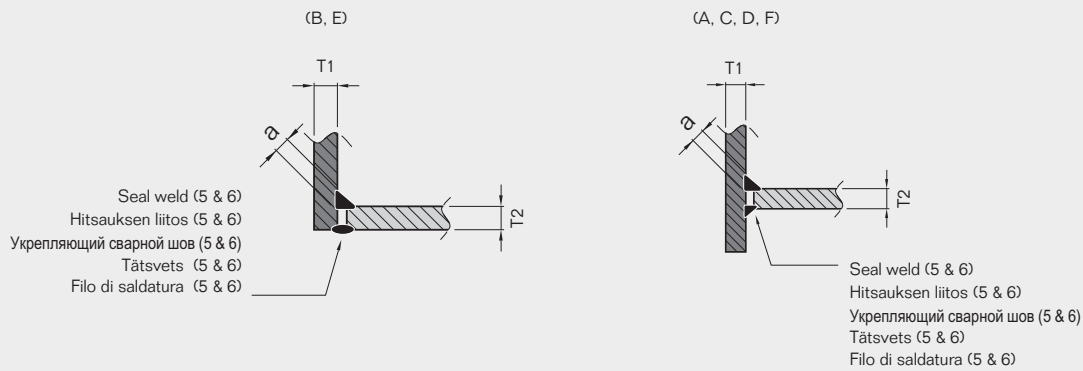
Importante: non cominciare le saldature 5 e 6 prima che le saldature 1 e 4 siano completate e le temperature ridiscendano alla temperatura di preriscaldamento minimo.

S, SRC, SK and SBTB frame, welding guidelines

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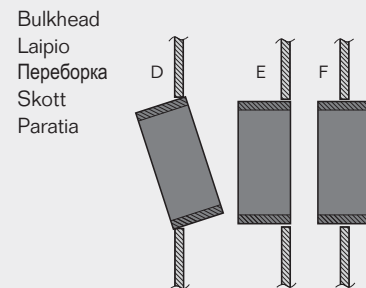
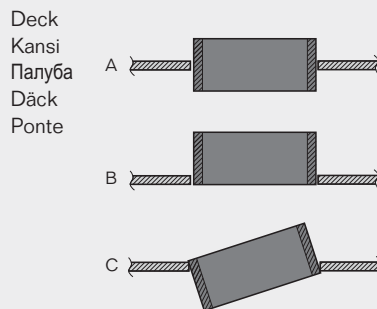


Fillet weld / Pienahitsi / Сварной шов / Kälsvets / Cordone di saldatura – weld sizes / hitsin koot / размеры шва / storlek / dimensione del cordone di saldatura		Fillet weld - weld sizes / Pienahitsi - hitsin koot / Сварной шов - размеры шва / Kälsvets - storlek / Cordone di saldatura - dimensione del cordone di saldatura	Welding pass / Hitsauksen kulku / Сварочный шов / Svetssträng / Saldatura					
T1 (Frame / Kehys / рама / Ram / Telai)	T2 (Bulkhead/Deck / Laipio / Kansi / Переборка/Палуба / Skott/Däck / Paratia/Ponte)		1	2	3	4	5	6
10	>=8	a6	X	X	X	X	X	X
10	>=7	a4	X	X			X	X



Possible positions

Mahdolliset asennot
 Допустимые положения
 Möjliga placeringar
 Posizioni possibili



S, SRC, SK and SBTB frame, welding guidelines

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**EN**

Mild steel welding, pre-heat temperature

Combined thickness (mm)/(in) T1+T2	Minimum pre-heat temperature
<50/1.969	10° C, 50° F
>50/1.969<80/3.150	50° C, 122° F

Aluminum welding, pre-heat temperature

Combined thickness (mm)/(in) T1+T2	Minimum pre-heat temperature
<25/0.984	10° C, 50° F
>25/0.984<50/1.969	50° C, 122° F

Stainless steel welding, no pre-heat

FI

Pohjamaalaton teräksen hitsaus, esikuumennuslämpötila

Yhdistetty vahvuus (mm) / (in) T1+T2	Minimi esikuumennuslämpötila
<50/1.969	10° C, 50° F
>50/1.969<80/3.150	50° C, 122o F

Alumiinin hitsaus, esikuumennuslämpötila

Yhdistetty vahvuus (mm) / (in) T1+T2	Minimi esikuumennuslämpötila
<25/0.984	10° C, 50° F
>25/0.984<50/1.969	50° C, 122o F

Ruostumattoman teräksen hitsaus, esikuumennusta ei tarvita

RU

Сталь, температура пред- нагрева

Общая толщина, мм/дюйм T1+T2	Минимальная температура нагрева
<50/1.969	10° C, 50° F
>50/1.969<80/3.150	50° C, 122° F

Алюминий, температура пред- нагрева

Общая толщина, мм/дюйм T1+T2	Минимальная температура нагрева
<25/0.984	10° C, 50° F
>25/0.984<50/1.969	50° C, 122° F

Нерж. сталь, без нагрева

SE

Svets i konstruktionsstål, förvärmningstemperatur

Sammanlagd tjocklek (mm)/(tum) T1+T2	Minimum förvärmningstemperatur
<50/1.969	10° C, 50° F
>50/1.969<80/3.150	50° C, 122° F

Aluminiumsvetsning, förvärmningstemperatur

Sammanlagd tjocklek (mm)/(tum) T1+T2	Minimum förvärmningstemperatur
<25/0.984	10° C, 50° F
>25/0.984<50/1.969	50° C, 122° F

Svetsning i rostfritt stål, ingen förvärmning

IT

Saldatura acciaio dolce, temperatura di riscaldamento

Spessore combinato (mm)/(in) T1+T2	min. temperatura di pre-riscaldamento
<50/1.969	10° C, 50° F
>50/1.969<80/3.150	50° C, 122° F

saldatura alluminio, temperatura di riscaldamento

Spessore combinato (mm)/(in) T1+T2	min. temperatura di pre-riscaldamento
<25/0.984	10° C, 50° F
>25/0.984<50/1.969	50° C, 122° F

Saldatura acciaio inox, senza pre-riscaldamento