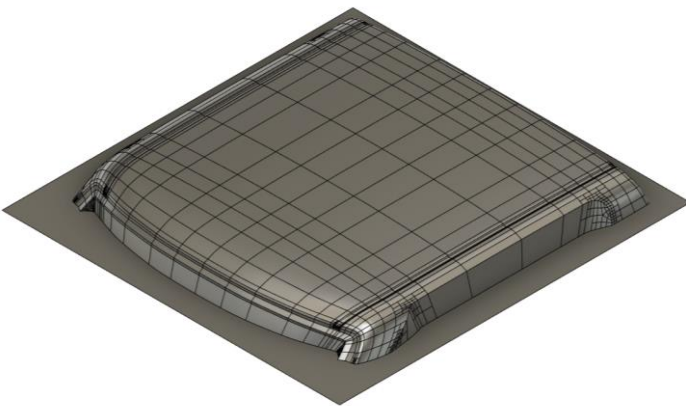
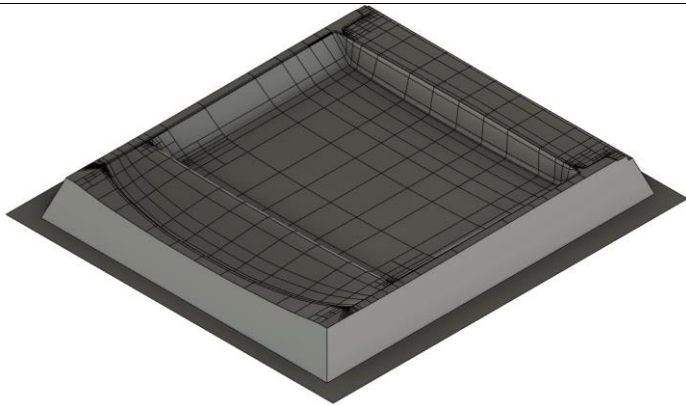


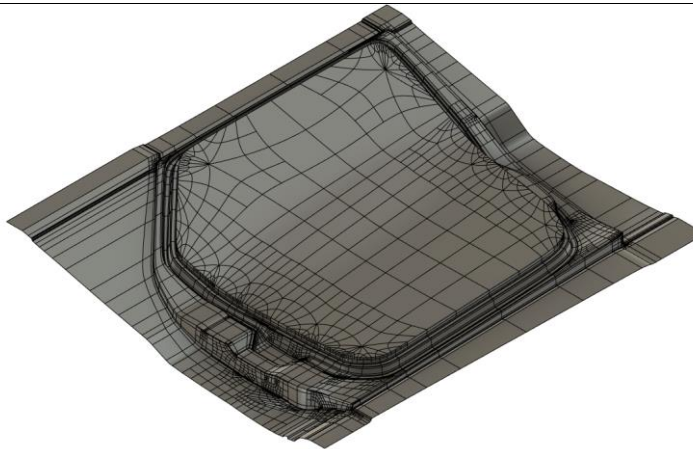
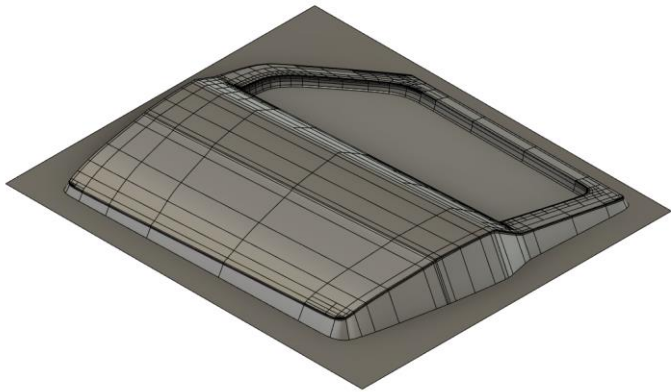
SPECIFICATII TEHNICE pentru
DISPOZITIVE DE PRODUCTIE (MATRITE) PENTRU PANOURI DE CAROSERIE VE L7e-CU = 1 SET, compus din:
A) - 1 set Matrite; B) - 1 set Dispozitive de taiere/prelucrare; C) - 1 set Dispozitive de montaj; D) - 1 set Dispozitive de control

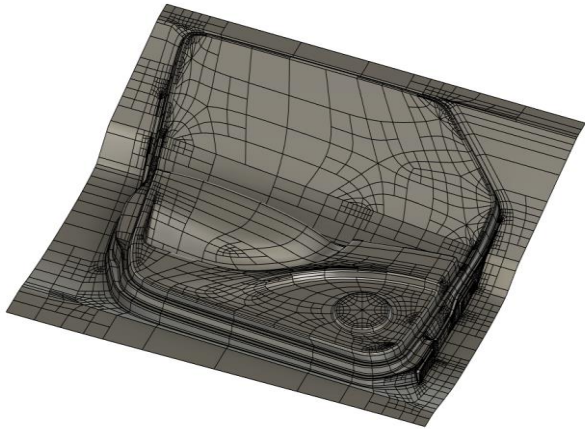
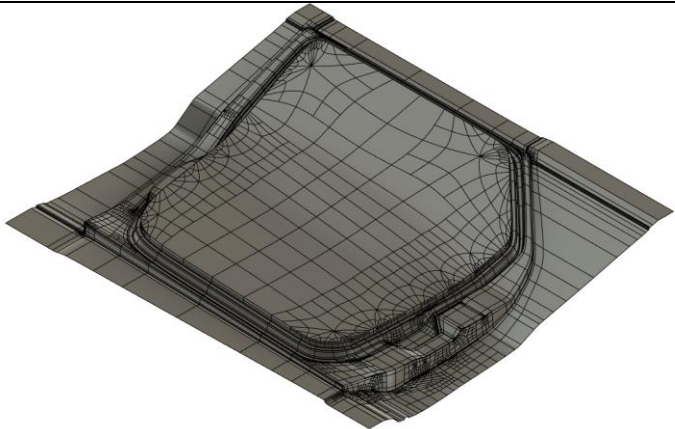
A - COMPONENTA SETULUI DE MATRITE PENTRU PANOURI DE CAROSERIE V.E L7e-CU

Nt. Crt.	Denumire matrita	Procedeu de lucru	Specificatii tehnice matrita	Imagine indicativa matrita
1	Plafon exterior	Termoforma-re prin vidare	<p>Dimens. LxIxh: 1290x1240x120 mm</p> <ul style="list-style-type: none"> – Constructie: suprafata activa a matritei este fixata cu adeziv pe o placa suport cu pereti de rigidizare. Placa suport are, pe perimetrul suprafetei in contact cu masa masinii, un canal cu garnitura pentru etansarea vidului. – Material matrita: tesatura din fibra de carbon preimpregnata ptr. matrite – Gros. finala matrita 8 mm, tol. -0,5/+1 mm; – Stratificatie matrita: 1 strat GG200T-TR25 + 10 straturi GG630T-TR25 – Caracterisitici tesatura GG200T-TR25: fibra carbon tip 3K HS; tip tesatura 2x2 Twill, matrice/rasina epoxidica; temperatura de tranzitie a sticlei Tg max. (ASTM D 3418), 195 °C dupa post intarire. – Caracterisitici tesatura GG630T-TR25: fibra carbon tip 12K HS;; tip tesatura 2x2 Twill, matrice/rasina epoxidica; temperatura de tranzitie a sticlei Tg max. (ASTM D 3418), 195 °C dupa post intarire. – Uscare/intarire in autoclava, conform Fisei tehnice a materialului – Grad de finisare: suprafata activa fata porozitati, polisata, clasa A – Toleranta la forma suprafetei: 1,5 mm ; – Diametru gauri de vidare: (0,8-1) mm. – Grosime pereti rigidizare intre suport si matrita: 10 -1/+ 1 mm; 	

			<ul style="list-style-type: none"> – Material pereti rigidizare: tesatura de carbon preimpregnata ptr. matrite, Stratificatie: (3 straturi GG630T-TR25) + (1 strat intaritura tip spuma Airex C71, gros. 10/5 mm) + (4 straturi GG630T-TR25) – Material suport matrita: Placa Tego, gros. 40 mm; – Abaterea la planeitate a suportului matritei, in partea de contact cu platoul de vidare: 0,5/1m; <p>Garnitura pentru etansarea vidului este tip tubular, diam. ext./int-10x5 mm , rezistenta la temperatura de minim 150 °C si compresiune;</p>	
2	Plafon interior	Termoformare prin vidare	<ul style="list-style-type: none"> – Dimens.: 1400x1300x130 mm Idem poz. 1 	

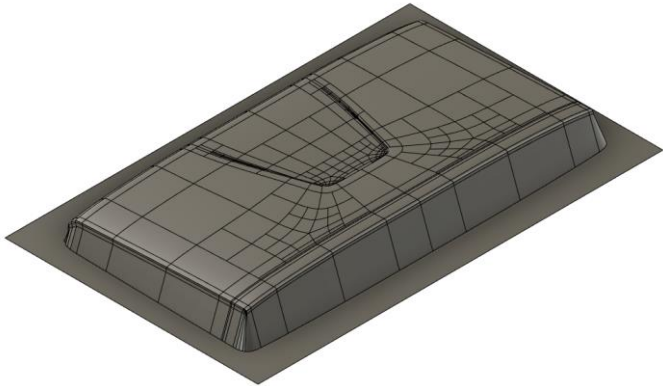

3	Usa dreapta	Termoformare prin vidare	<ul style="list-style-type: none"> – Dimens.: 1400x1400x180 mm Idem poz. 1 	
4	Interior usa dreapta	Laminare Prepreg, cu uscare in autoclava	<ul style="list-style-type: none"> – Dimens.: 1400x1400x150 mm – Material matrita: tesatura din fibra de carbon preimpregnata ptr. matrite; – Gros. finala matrita 8 mm, tol. -0,5/+1 mm; – Stratificatie matrita: 1 strat GG200T-TR25 + 10 straturi GG630T-TR25. – Caracterisitici tesatura GG200T-TR25: fibra carbon tip 3K HS;; tip tesatura 2x2 Twill, matrice/rasina epoxidica; temperatura de tranzitie a sticlei Tg max. (ASTM D 3418), 195 °C dupa post intarire. – Caracterisitici tesatura GG630T-TR25: fibra carbon tip 12K HS;; tip tesatura 2x2 Twill, matrice/rasina epoxidica; temperatura de tranzitie a sticlei Tg max. (ASTM D 3418), 195 °C dupa post intarire. – Uscare/intarire in autoclava, conform Fisei tehnice a materialului . – Grad de finisare: suprafata activa fara porozitati, polisata, clasa A Toleranta la forma suprafetei 1,5 mm; 	

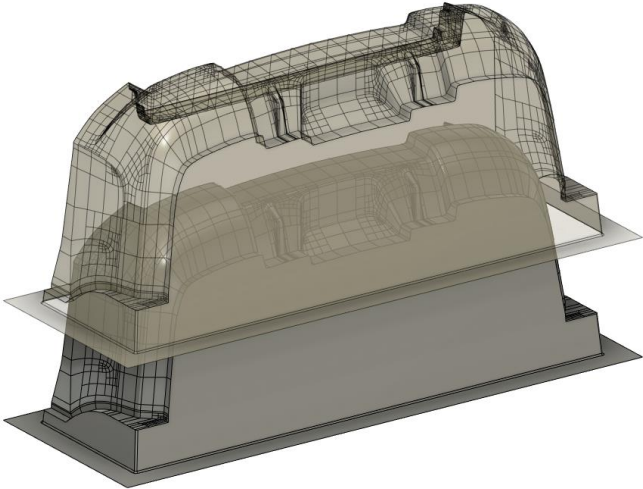
5	Cadru usa dreapta	Laminare Prepreg, cu uscare in autoclava	– Dimens.: 1500x1400x180 mm Idem poz. 4	
6	Usa stanga (ext.)	Termoformare prin vidare	– Dimens.: 1400x1400x180 mm Idem poz. 1	

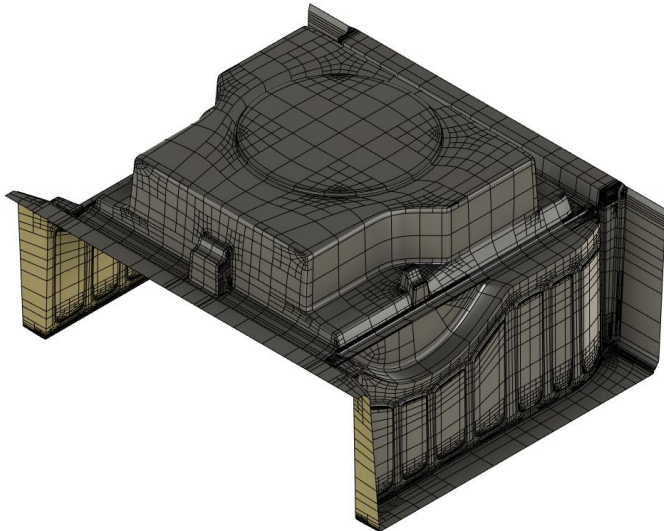
7	Interior usa stanga	Laminare Prepreg, cu uscare in autoclava	– Dimens.: 1400x1400x150 mm Idem poz. 4	
8	Cadru usa stanga	Laminare Prepreg, cu uscare in autoclava	– Dimens.: 1500x1400x180 mm Idem poz. 4	


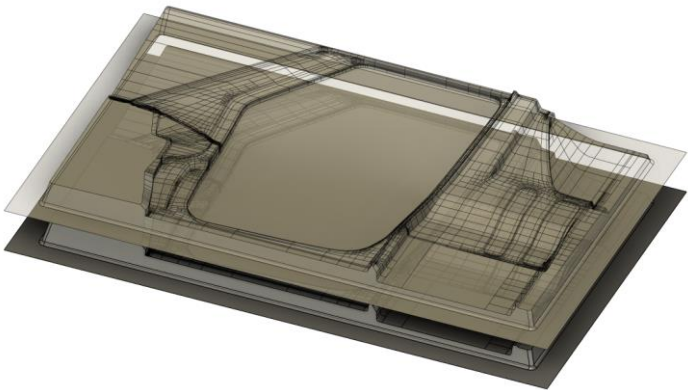
9	Prag dreapta	Termoformare prin vidare	– Dimens.: 1850x330x100 mm Idem poz. 1	
10	Prag stanga	Termoformare prin vidare	– Dimens.: 1850x330x100 mm Idem poz. 1	

11	Aripa spate dreapta	Termoformare prin vidare	– Dimens.: 1900x1300x230 mm Idem poz. 1	 
12	Aripa spate stanga	Termoformare prin vidare	– Dimens.: 1900x1300x230 Idem poz. 1	

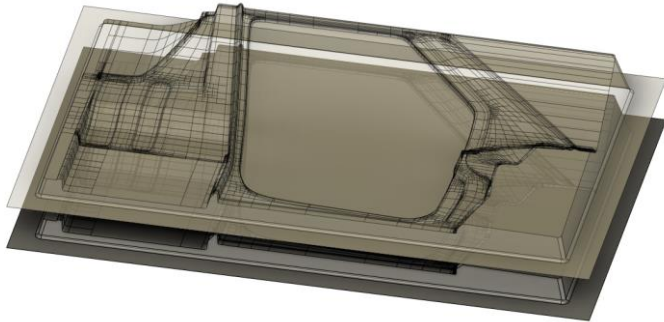

13	Usa lada spate, ext.	Termoformare prin vidare	– Dimens.: 1200x750x110 mm Idem poz. 1	
14.1 14.2	Usa lada spate, int	Transfer rasina in matrita, asistat de vacuum, la presiune joasa (VARTM-LP)	14.1 Matrita VARTM-LP – Dimens.: 1250x775x400 mm – Idem poz. 19.1 14.2 Matrita pentru preformarea straturilor de material compozit, care se transfera in matrita VARTM-LP. Constructie idem 14.1	
15.1 15.2	Bara spate	Transfer rasina in matrita, asistat de vacuum, la presiune joasa	15.1 Matrita VARTM-LP – _Dimens.: 1560x440x610 mm – Idem poz. 19.1 15.2 Matrita pentru preformarea straturilor de material compozit, care se transfera in matrita VARTM-LP. Constructie idem 15.1	


		(VARTM-LP)		
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16	Lada spate	Laminare Prepreg, cu uscare in autoclava	– Dimens.: 1330x1150x710 mm Idem poz. 4	
17	Podea lada spate	Laminare Prepreg, cu uscare in autoclava	– Dimens.: 1130x1110x10 mm Idem poz. 4	

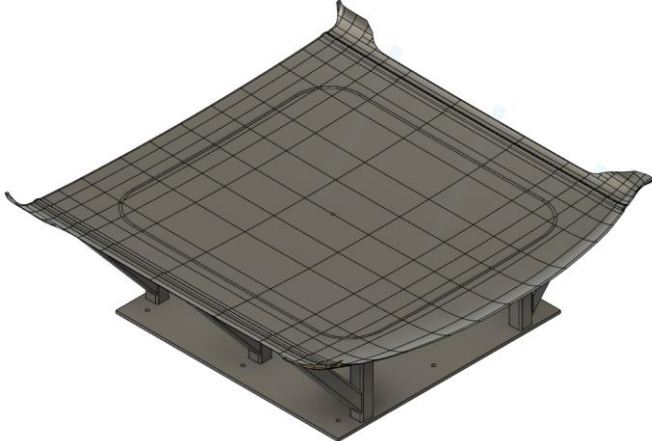
18	Capac Baterie (podea mica lada spate)	Preformare straturi de material compozit, pentru PMC pe presa hidr.	<ul style="list-style-type: none"> – Matrita pentru preformarea straturilor de material compozit (preforma se transfera in matrita de otel, in care se realizeaza componenta prin procesul PMC) <p>Constructie idem poz. 19.1, cu dimensi.: 800X750X250 mm</p>	
19. 1	Panou lateral dreapta	Transfer rasina in matrita, asistat de vacuum, la presiune joasa (VARTM – LP)	<p>19.1 Matrita VARTM-LP</p> <ul style="list-style-type: none"> – Dimensi.: Lxlxh: 2400X1450X230 mm – Constructie: matrita este compusa din parte inf. si parte sup., cu flanse, mufa de intrare si canal de injectie a rasinii, mufa de iesire a rasinii si circuit de vidare a interiorului matritei. Fiecare parte a matritei este rigidizata de placa/flansa de baza, intre care se realizeaza vidarea. Pe partea flanselor in contact este frezat un canal in care sunt garnituri pentru vidare. Pe perimetrul flanselor sunt montate 8 mecanisme articulate de inchidere, pentru asigurarea etanseitatii circuitului de rasina la forta dezvoltata in interiorul matritei, dupa inchidere, datorata presiunii de injectie. – Material matrita: tesatura din fibra de carbon preimpregnata ptr. matrite; – Gros. finala matrita 8 mm, tol. -0,5/+1 mm; – Stratificatie matrita: 1 strat GG200T-TR25 + 10 straturi GG630T-TR25; – Caracteristici tesatura GG200T-TR25: fibra carbon tip 3K HS; tip tesatura 2x2 Twill, matrice/rasina epoxidica; temperatura de tranzitie a sticlei Tg max. (ASTM D 3418), 195 °C dupa post intarire; 	

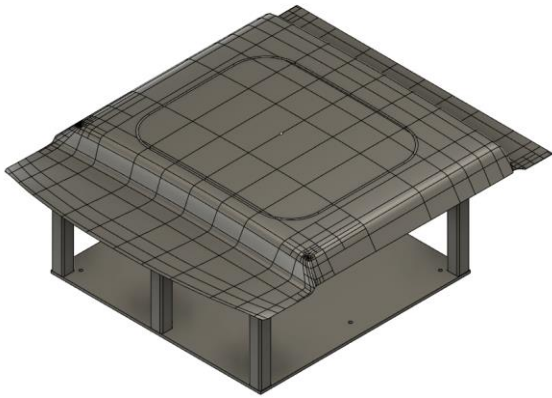
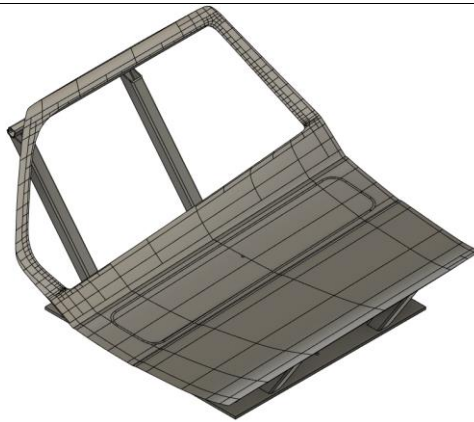
19. 2			<ul style="list-style-type: none"> – Caracteristici tesatura GG630T-TR25: fibra carbon tip 12K HS; tip tesatura 2x2 Twill, matrice/rasina epoxidica; temperatura de tranzitie a sticlei Tg max. (ASTM D 3418), 195 °C dupa post intarire; – Uscare/intarire in autoclava, conform Fisei tehnice a materialului ; – Material placa/flansa de baza: otel S235 JR , grosime 15 mm; suprafetele intre care se realizeaza vidarea pe flanse, se prelucraza; abaterea la planeitate: 0,2 mm/1m; – Rigidizare matrita: partea exterioara a matritei superioare si inferioare, sunt consolidate cu structura metalica, inglobata in ciment epoxidic; gros. minima a zonei rigidizate cu ciment epoxidic, 100 mm. – Sistem de centrare/ghidare pe flanse la inchiderea matritei, in patru puncte, cu pini metalici. – Grad de finisare: suprafata activa fara porozitati, polisata, clasa A – Toleranta la forma suprafetei: 1,5 mm <p>19.2 Matrita pentru preformarea straturilor de material compozit, care se transfera in matrita VARTM-LP. Constructie idem 19.1</p>	
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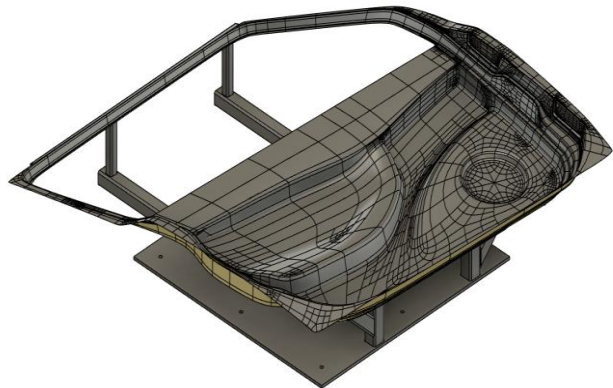
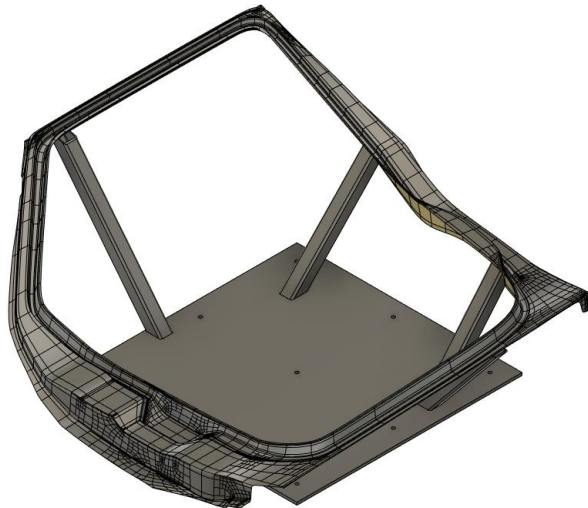
20. 1	Panou lateral stanga	Transfer rasina in matrita, asistat de vacuum, la presiune joasa (VARTM – LP)	<p>20.1 Matrita VARTM-LP</p> <ul style="list-style-type: none"> – Dimens.: 2400X1450X230 mm – Idem poz. 19.1 <p>20.2 Matrita pentru preformarea straturilor de material compozit, care se transfera in matrita VARTM-LP. Constructie idem 20.1</p>	
21	Panou podea sasiu	Preformare straturi de material compozit, pentru PMC pe presa hydr.	<ul style="list-style-type: none"> – Matrita pentru preformarea straturilor de material compozit (preforma se transfera in matrita de otel, in care se realizeaza componenta prin procesul PMC) <p>Constructie idem poz. 19.1, cu dimensiunile 1350x1250x 250 mm</p>	

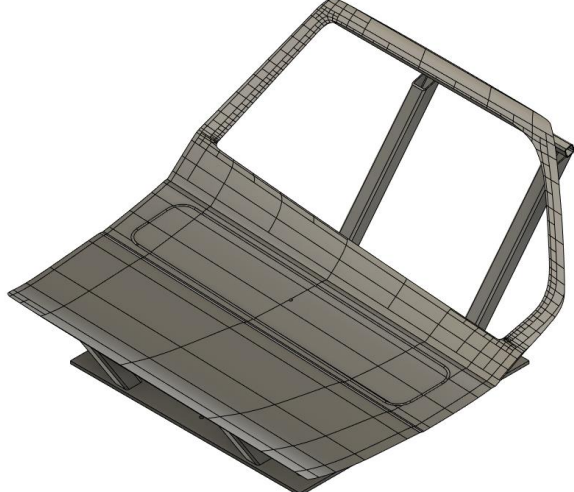
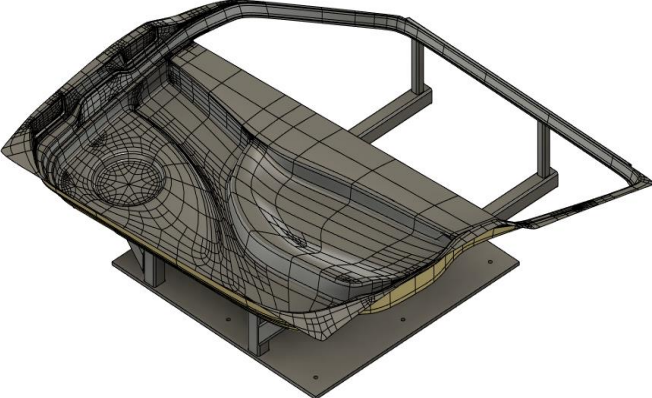
22	Panou spate (cabina sofer +pasager)	Preformare straturi de material compozit, pentru SMC pe presa hidr.	<p>– Matrita pentru preformarea straturilor de material compozit (preforma se transfera in matrita de otel, in care se realizeaza componenta prin procesul SMC)</p> <p>Constructie idem poz. 19.1, cu dimensiunile: 1500x1470x110 mm</p>	
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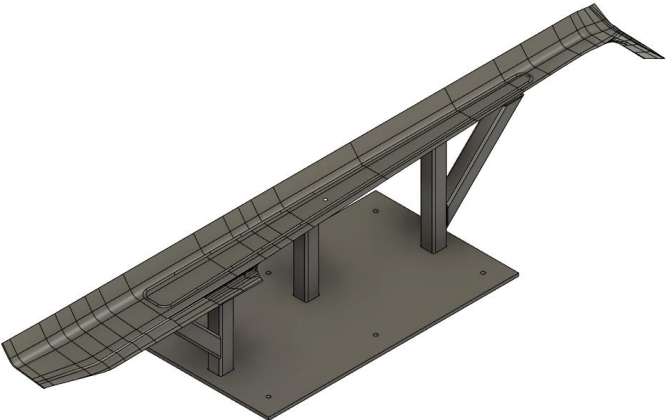
B - COMPONENTA SETULUI DE DISPOZITIVE DE TAIERE/PRELUCRARE, PENTRU PANOURI DE CAROSERIE V.E L7e-CU

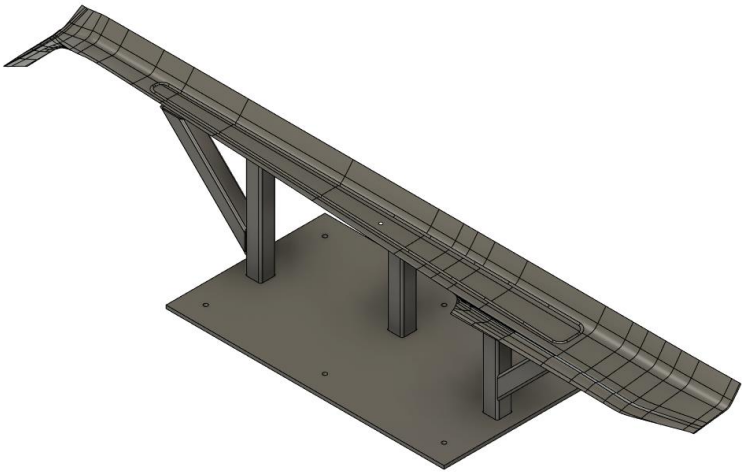
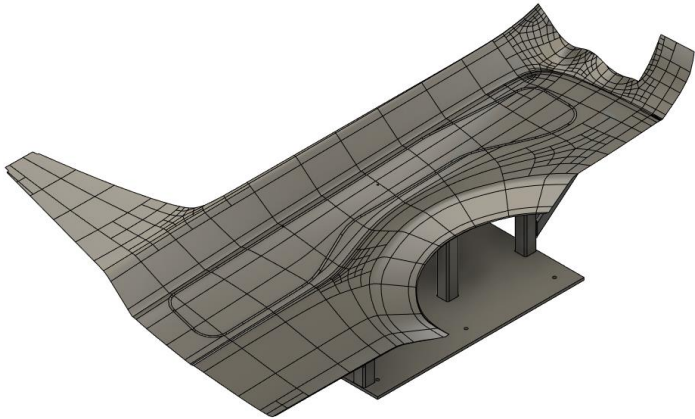
Nt. Crt.	Dispozitiv de taiere / prelucrare, pentru:	Specificatii tehnice dispozitiv	Imagine indicativa dispozitiv
1	Plafon exterior	<ul style="list-style-type: none"> – Dimens.: 1050x1070x105 mm – Constructie: format dintr-o suprafata de fixare pentru taiere/prelucrare piesa, placa de baza, sistem de prindere a suprafetei de fixare de placa de baza, suprafata delimitata perimetral cu garnitura pentru fixarea prin vidare a piesei in timpul prelucrarii. – Material suprafata de fixare/ prelucrare: tesatura din fibra de carbon preimpregnata ptr. matrite; grosime finala suprafata: 8 -0,5/+1 mm; stratificatie materiale: 1 strat GG200T-TR25 + 10 straturi GG630T-TR25. – Caracterisitici tesatura GG200T-TR25: fibra carbon tip 3K HS;; tip tesatura 2x2 Twill, matrice/rasina epoxidica; temperatura de tranzitie a sticlei Tg max. (ASTM D 3418), 195 °C dupa post intarire. – Caracterisitici tesatura GG630T-TR25: fibra carbon tip 12K HS;; tip tesatura 2x2 Twill, matrice/rasina epoxidica; temperatura de tranzitie a sticlei Tg max. (ASTM D 3418), 195 °C dupa post intarire. – Uscare/intarire in autoclava, conform Fisei tehnice a materialului. – Grad de finisare: polisata, clasa B – Toleranta la forma suprafetei 1,5 mm; – Garnitura tubulara, diametru 6 mm, profil semicerc, pentru delimitarea suprafetei de vidare – Placa de baza: material otel, gros. 8 mm, 700x700 mm – Stalpi pentru prindere pe placa de baza a suprafetei de fixare a piesei: Teava patrata, 40x40x2 mm, lungime totala 3000 mm 	

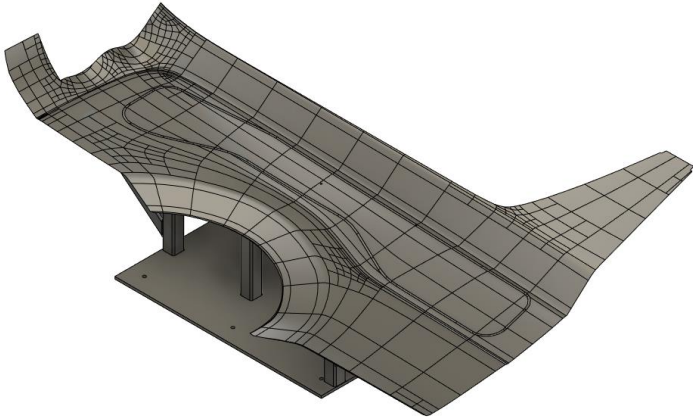
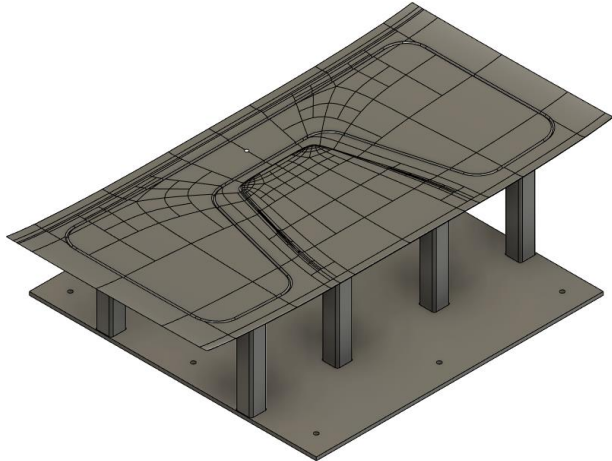
2	Plafon interior	<p>Dimens.: 1050x900x85 mm</p> <p>Idem poz. 1, cu placa de baza Lxl 700 x 700 mm</p> <p>Stalpi pentru prindere pe placa de baza a suprafetei de fixare a piesei: profil din otel, 40x40x2 mm, lungime totala 2200 mm</p>	
3	Usa dreapta	<p>Dimens.: 1200x1120x110 mm</p> <p>Idem poz. 1, cu placa de baza Lxl 700 x 700 mm</p> <p>Stalpi pentru prindere pe placa de baza a suprafetei de fixare a piesei: profil din otel, 40x40x2 mm, lungime totala 2700, profil din otel, 30x30, gros. 1,5, lungime totala 700 mm</p>	

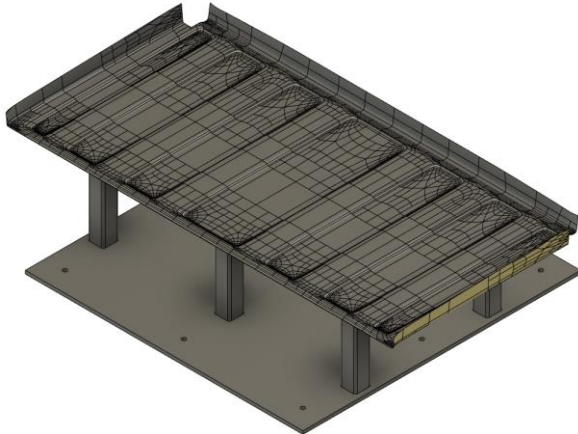
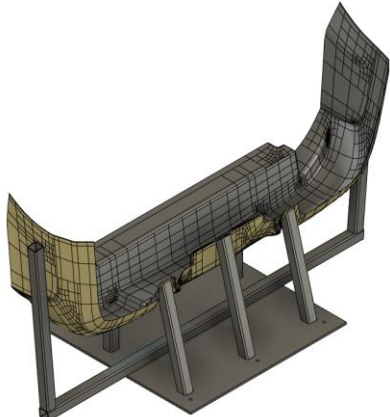
4	Interior usa dreapta	<p>Dimens.: 1200x1100x150 mm</p> <p>Idem poz. 1, cu placa de baza Lxl 700 x 700 mm</p> <p>Stalpi pentru prindere pe placa de baza a suprafetei de fixare a piesei: profil din otel, 40x40x2 mm, lungime totala 3000, profil din otel, 30x30, gros. 1.5, lungime totala 1000 mm</p>	
5	Cadru usa dreapta	<p>Dimens.: 1280x1200x160 mm</p> <p>Idem poz. 1, cu placa de baza Lxl 700 x 700 mm</p> <p>Stalpi pentru prindere pe placa de baza a suprafetei de fixare a piesei: profil din otel, 40x40x2 mm, lungime totala 2400 mm</p>	

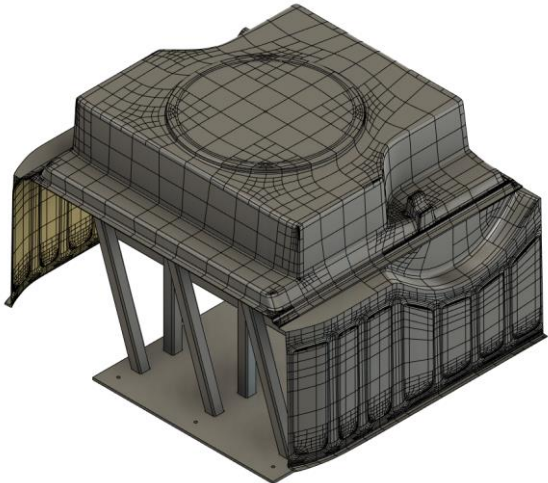

6	Usa stanga (ext).	<p>Dimens.: 1200x1120x110 mm</p> <p>Idem poz. 1, cu placa de baza Lxl 700 x 700 mm</p> <p>Stalpi pentru prindere pe placa de baza a suprafetei de fixare a piesei: profil din otel, 40x40x2 mm, lungime totala 2700, 30x30x1,5 mm, lungime totala 700 mm</p>	
7	Interior usa stanga	<p>Dimens.: 1200x1100x150 mm</p> <p>Idem poz. 1, cu placa de baza Lxl 700 x 700 mm</p> <p>Stalpi pentru prindere pe placa de baza a suprafetei de fixare a piesei: profil din otel, 40x40x2 mm, lungime totala 3000, profil din otel, 30x30, gros. 1,5, lungime totala 1000</p>	

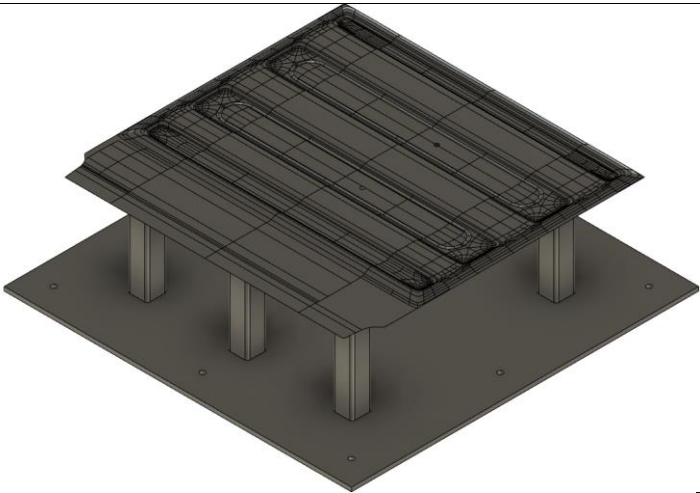
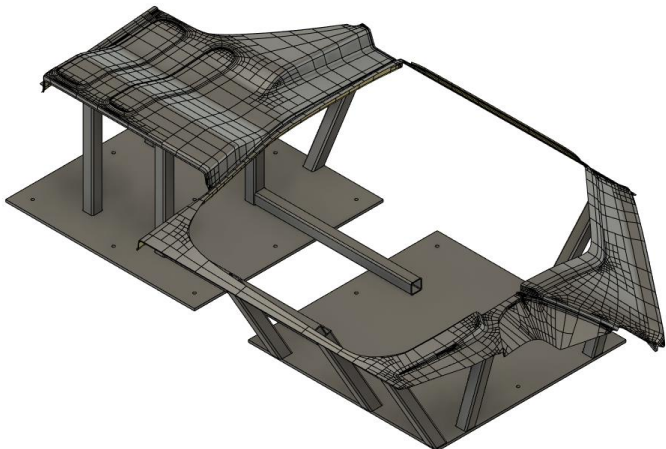
8	Cadru usa stanga	<p>Dimens.: 1280x1200x160 mm</p> <p>Idem poz. 1, cu placa de baza Lxl 700 x 700 mm</p> <p>Stalpi pentru prindere pe placa de baza a suprafetei de fixare a piesei: profil din otel, 40x40x2 mm, lungime totala 2400 mm</p>	
9	Prag dreapta	<p>Dimens.: 1700x180x60 mm</p> <p>Idem poz. 1, cu placa de baza Lxl 700 x 400 mm</p> <p>Stalpi pentru prindere pe placa de baza a suprafetei de fixare a piesei: profil din otel, 40x40x2 mm, lungime totala 1400 mm</p>	

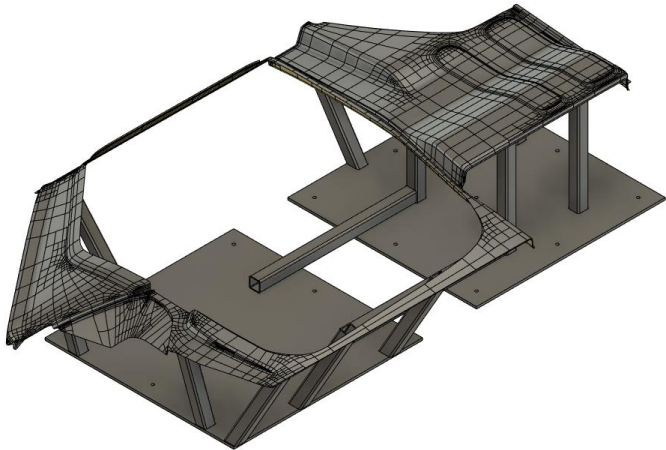
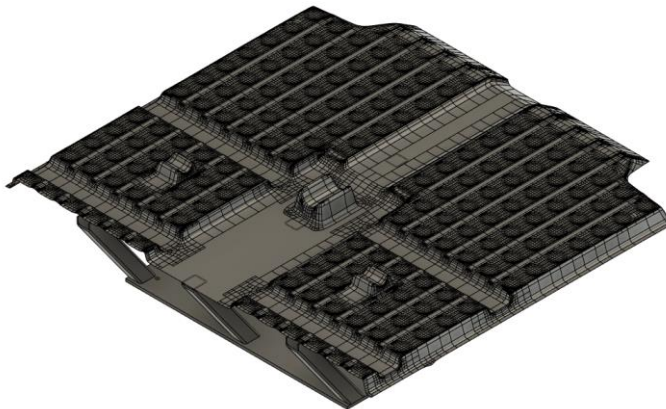
10	Prag stanga	<p>Dimens.: 1700x180x60 mm</p> <p>Idem poz. 1, cu placa de baza Lxl 700 x 400 mm</p> <p>Stalpi pentru prindere pe placa de baza a suprafetei de fixare a piesei: profil din otel, 40x40x2 mm, lungime totala 1400 mm</p>	
11	Aripa spate dreapta	<p>Dimens.: 1640x1080x200 mm</p> <p>Idem poz. 1, cu placa de baza Lxl 700 x 700 mm</p> <p>Stalpi pentru prindere pe placa de baza a suprafetei de fixare a piesei: profil din otel, 40x40x2 mm, lungime totala 2800 mm</p>	

12	Aripa spate stanga	<p>Dimens.: 1640x1080x200 mm</p> <p>Idem poz. 1, cu placa de baza Lxl 700 x 700 mm</p> <p>Stalpi pentru prindere pe placa de baza a suprafetei de fixare a piesei: profil din otel, 40x40, gros. 1,5, lungime totala 2800</p>	
13	Usa lada spate, ext.	<p>Dimens.: 1000x500x50 mm</p> <p>Idem poz. 1, cu placa de baza Lxl 700 x 700 mm</p> <p>Stalpi pentru prindere pe placa de baza a suprafetei de fixare a piesei: profil din otel, 40x40x2 mm, lungime totala 1700 mm</p>	

14	Usa lada spate, int	<p>Dimens.: 1000x500x50 mm</p> <p>Idem poz. 1, cu placa de baza Lxl 700 x 700 mm</p> <p>Stalpi pentru prindere pe placa de baza a suprafetei de fixare a piesei: profil din otel, 40x40x2 mm, lungime totala 1700 mm</p>	
15	Bara spate	<p>Dimens.: 1500x340x600 mm</p> <p>Idem poz. 1, cu placa de baza Lxl 700 x 700 mm</p> <p>Stalpi pentru prindere pe placa de baza a suprafetei de fixare a piesei: profil din otel, 40x40x2 mm, lungime totala 4700 mm</p>	

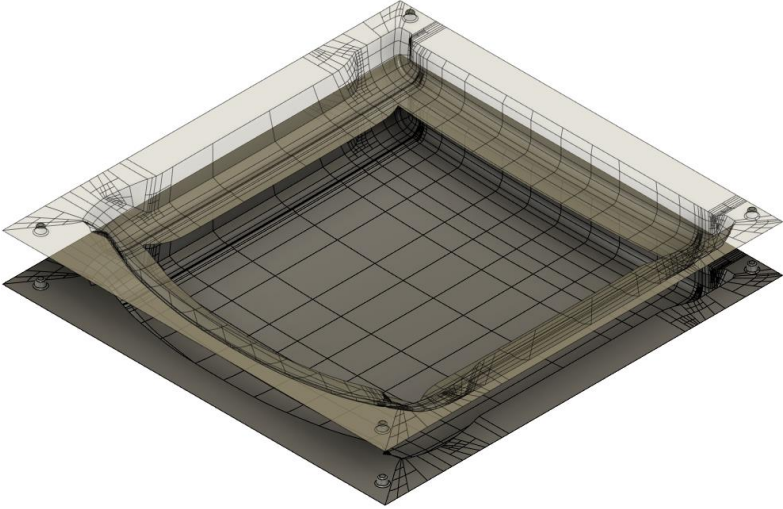
16	Lada spate	<p>Dimens.: 1200x950x700 mm</p> <p>Idem poz. 1, cu placa de baza Lxl 700 x 700 mm</p> <p>Stalpi pentru prindere pe placa de baza a suprafetei de fixare a piesei: profil din otel, 40x40x2, lungime totala 10000 mm</p>	
17	Podea lada spate	<p>Dimens.: 960x950x10 mm</p> <p>Idem poz. 1, cu placa de baza Lxl 700 x 700 mm</p> <p>Stalpi pentru prindere pe placa de baza a suprafetei de fixare a piesei: profil din otel, 40x40x2 mm, lungime totala 1800 mm</p>	

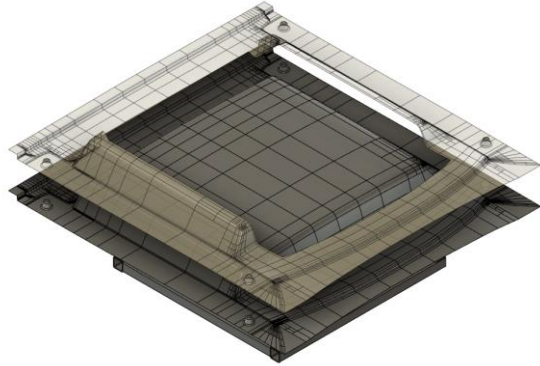
18	Capac Baterie (podea mica lada spate)	Dimens.: 610x590x10 mm Idem poz. 1, cu placa de baza Lxl 700 x 700 mm Stalpi pentru prindere pe placa de baza a suprafetei de fixare a piesei: profil din otel, 40x40x2 mm, lungime totala 1200 mm	
19	Panou lateral dreapta	Dimens.: 2000x1150x200 mm Idem poz. 1, cu 2 placi de baza Lxl 700 x 700 mm Stalpi pentru prindere pe placa de baza a suprafetei de fixare a piesei: profil din otel, 40x40x2 mm, lungime totala 5000	

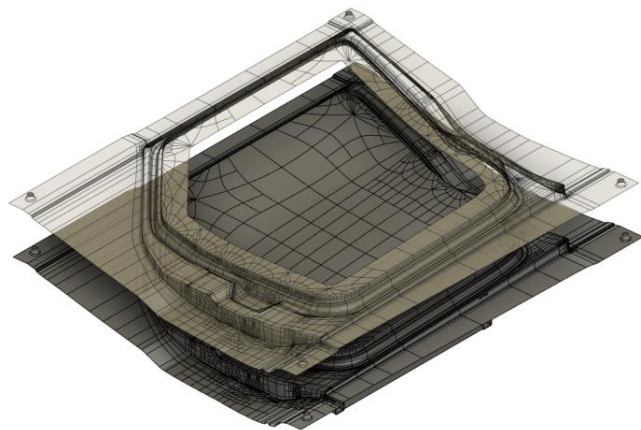
20	Panou lateral stanga	<p>Dimens.: 2000x1150x200 mm</p> <p>Idem poz. 1, cu 2 placi de baza Lxl 700 x 700 mm</p> <p>_Stalpi pentru prindere pe placa de baza a suprafetei de fixare a piesei: profil din otel, 40x40x2 mm, lungime totala 5000 mm</p>	
21	Panou podea sasiu	<p>Dimens.: 1170x1100x65 mm</p> <p>Idem poz. 1, cu placa de baza Lxl 700 x 700 mm</p> <p>Stalpi pentru prindere pe placa de baza a suprafetei de fixare a piesei: profil din otel, 40x40x2 mm, lungime totala 4000 mm</p>	

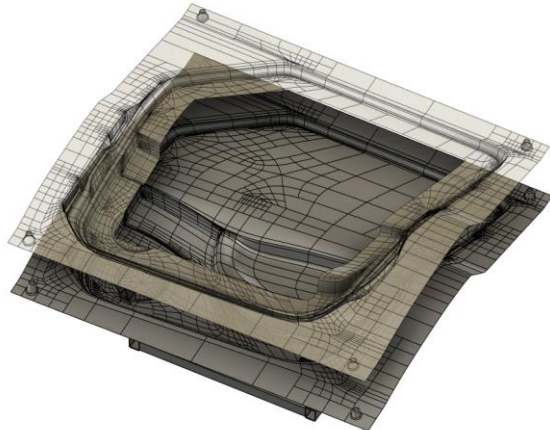
22	Panou spate (cabina sofer +pasager)	<p>Dimens.: 1200x1150x40 mm</p> <p>Idem poz. 1, cu placa de baza Lxl 700 x 700 mm</p> <p>Stalpi pentru prindere pe placa de baza a suprafetei de fixare a piesei: profil din otel, 40x40x2 mm, lungime totala 4000 mm</p>	
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C - COMPONENTA SETULUI DE DISPOZITIVE DE MONTAJ, PENTRU PANOURI DE CAROSERIE V.E L7e-CU

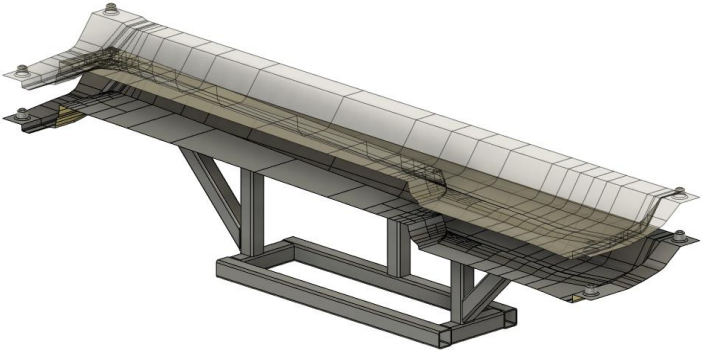
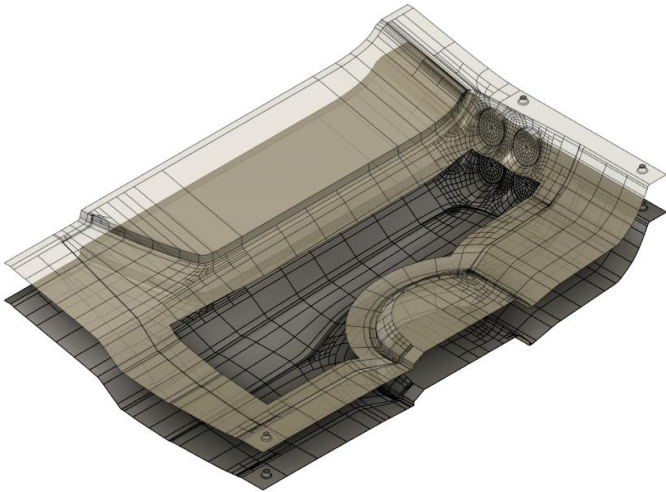
Nt. Crt.	Dispozitiv de montaj, pentru:	Specificatii tehnice dispozitiv	Imagine indicativa dispozitiv
1	Plafon exterior	<p>Dimens. LxIxh: 1290x1240x120 mm</p> <ul style="list-style-type: none"> – Constructie: format dintr-o suprafata de asezare prevazuta cu strangatoare/ mecanisme articulate de fixare a componentei, repere pentru pozitionarea pieselor/insertiilor care se monteaza, structura compozita de rigidizare si bazare. – Material pentru suprafata de fixare/ prelucrare: tesatura din fibra de carbon preimpregnata ptr. matrite; grosime finala suprafata: 8 -0,5/+1 mm; stratificatie materiale: 1 strat GG200T-TR25 + 10 straturi GG630T-TR25. – Caracteristici tesatura GG200T-TR25: fibra carbon tip 3K HS;; tip tesatura 2x2 Twill, matrice/rasina epoxidica; temperatura de tranzitie a sticlei Tg max. (ASTM D 3418), 195 °C dupa post intarire. – Caracteristici tesatura GG630T-TR25: fibra carbon tip 12K HS;; tip tesatura 2x2 Twill, matrice/rasina epoxidica; temperatura de tranzitie a sticlei Tg max. (ASTM D 3418), 195 °C dupa post intarire; – Uscare/intarire in autoclava, conform Fisei tehnice a materialului. – Grad de finisare: polisata, clasa B – Toleranta la forma suprafetei 1,5 mm; – Mecanismele/Strangatoarele articulate sunt dispuse pe perimetrul dispozitivului, la o distanta de aprox. 600 mm intre ele. <p>Material structura de rigidizare: profil patrat 30x30x1,5 mm din material compozit, dimensiuni baza de asezare 700x700 mm, lungime totala profil 5,70 m.</p>	

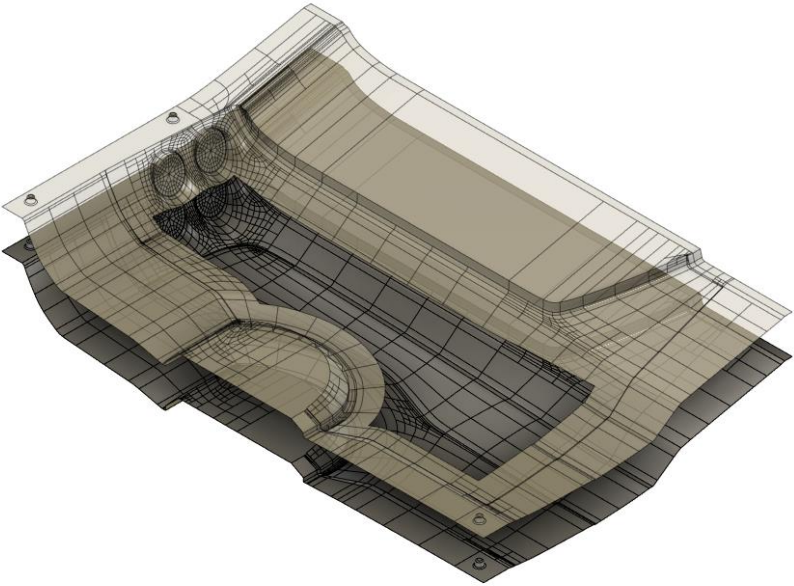
2	Plafon interior	Dimens.: 1170x1080x85 mm Idem poz. 1	
3	Usa dreapta	Dimens.: 1390x1390x170 mm Idem poz. 1	

4	Interior usa dreapta	Dimens.: 1395x1400x150 Idem poz. 1 mm	
5	Cadru usa dreapta	Dimens.: 1480x1375x220 mm Idem poz. 1	

6	Usa stanga (ext.)	Dimens.: 1390x1390x170 mm Idem poz. 1	
7	Interior usa stanga	Dimens.: 1395x1400x150 mm Idem poz. 1	

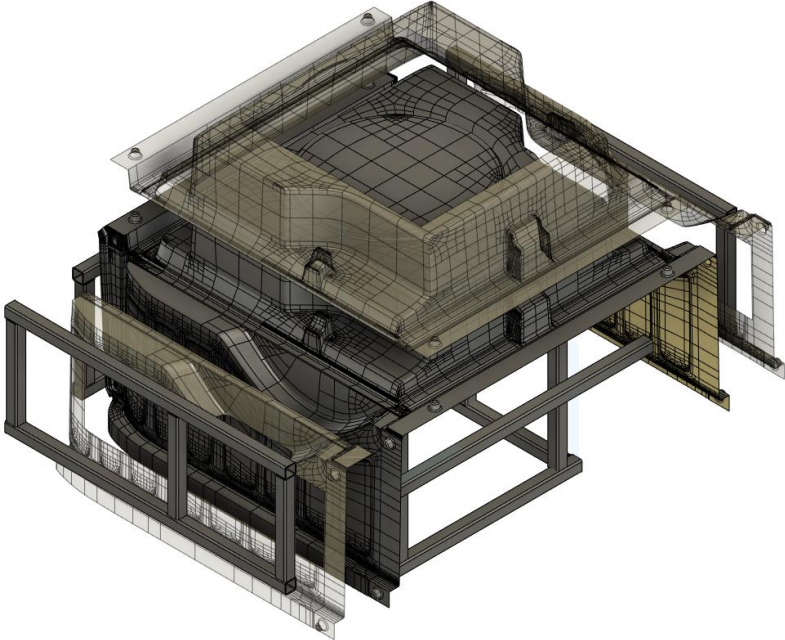
8	Cadru usa stanga	Dimens.: 1480x1375x220 mm Idem poz. 1	
9	Prag dreapta	Dimens.: 1830x340x95 mm Idem poz. 1, cu baza L x l = 700x250, lungime totala profil 4,70 m	

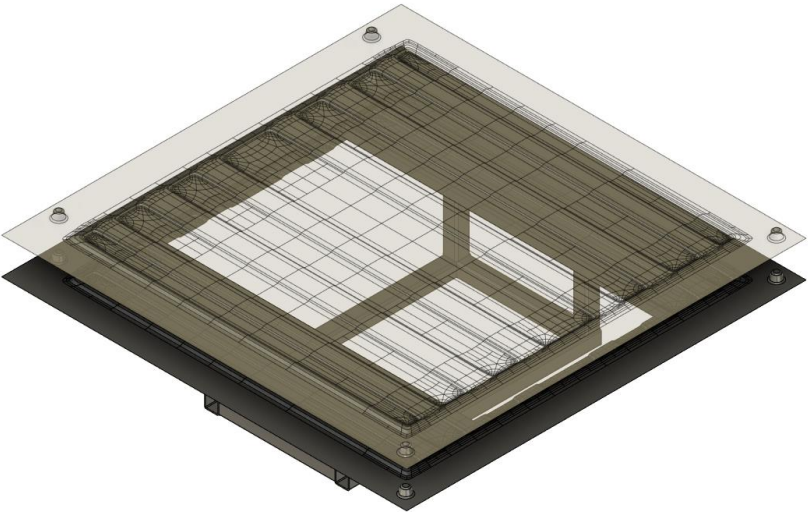
10	Prag stanga	<p>Dimens.: 1830x340x95</p> <p>Idem poz. 1, cu baza L x l = 700x250, lungime totala profil 4,70 m</p>	
11	Aripa spate dreapta	<p>Dimens.: 1870x1190x300</p> <p>Idem poz. 1, cu baza L x l = 700x400 mm, lungime totala profil 5 m</p>	

12	Aripa spate stanga	<p>Dimens.: 1870x1190x300</p> <p>Idem poz. 1, cu baza L x l =700x400 mm, lungime totala profil 5 m</p>	
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13	Usa lada spate, ext.	<p>Dimens.: 1230x640x90</p> <p>Idem poz. 1, cu baza L x l = 700x400 mm, lungime totala profil 5 m</p>	
14	Usa lada spate, int	<p>Dimens.: 1155x615x85</p> <p>Idem poz. 1, cu baza L x l = 700x250 mm, lungime totala profil 5 m</p>	

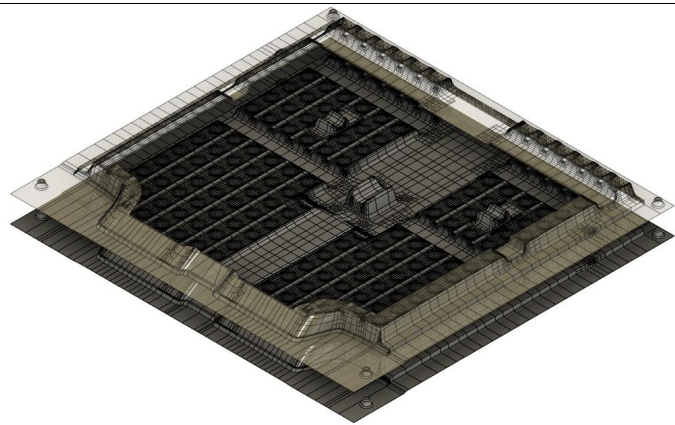
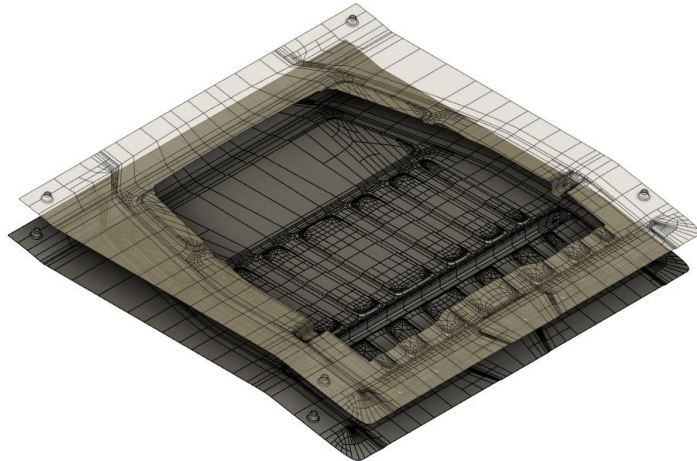
15	Bara spate	<p>Dimens.: 1560X440X620</p> <p>Idem poz. 1, cu baza L x l = 700x400 mm, lungime totala profil 5 m</p>	 <p>A 3D wireframe model of a curved metal structure, likely a backrest or a component of a larger assembly. The structure is mounted on a rectangular frame with four legs. The main body of the structure is curved and features a grid-like pattern, possibly representing a mesh or a series of ribs. The base of the structure is flat and rectangular, matching the dimensions specified in the text. The overall design is functional and industrial.</p>
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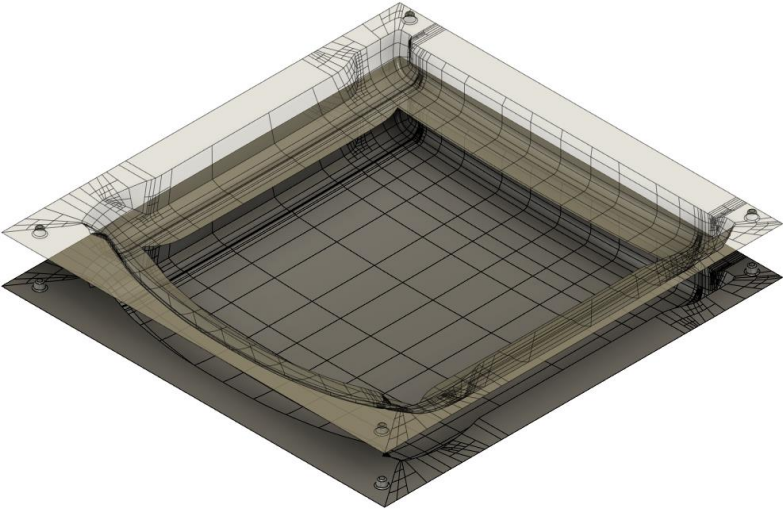
16	Lada spate	<p>Dimens.: 1270x1150x755 mm</p> <p>Idem poz. 1, cu placa de baza L x l = 950x700, lungime totală profil 11,5 m</p>	
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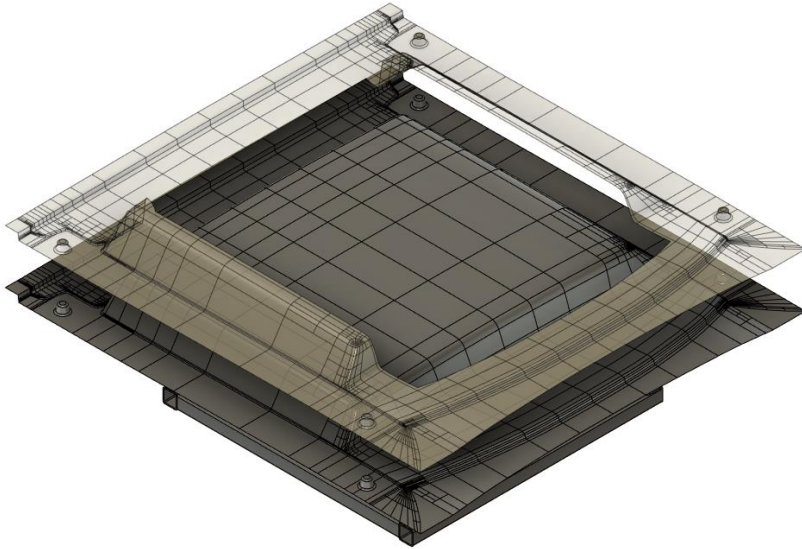
17	Podea lada spate	<p>Dimens.: 1125X1115X20 mm</p> <p>Idem poz. 1, cu baza L x l =700x400 mm, lungime totala profil 5 m</p>	
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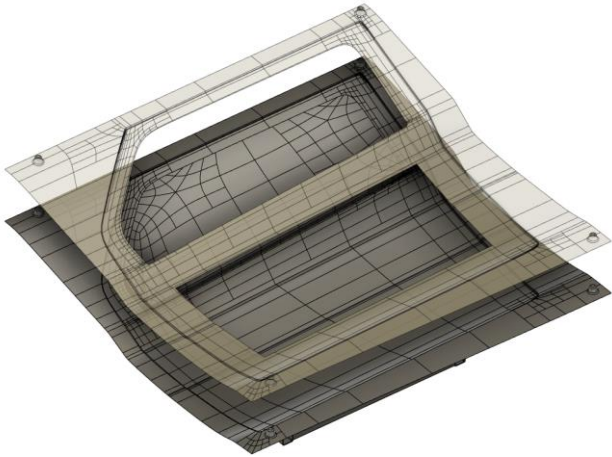
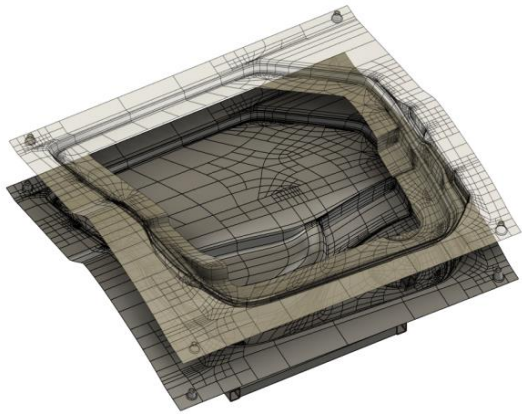
18	Capac Baterie (podea mica lada spate)	<p>Dimens.: 760X730X20 mm</p> <p>Idem poz. 1, cu baza L x l =700x400 mm, lungime totala profil 5 m</p>	
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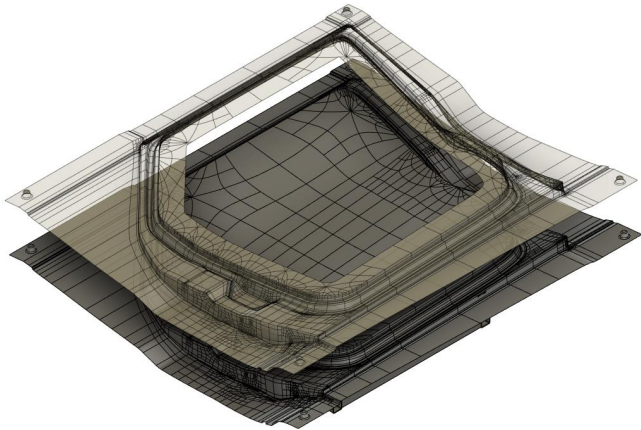
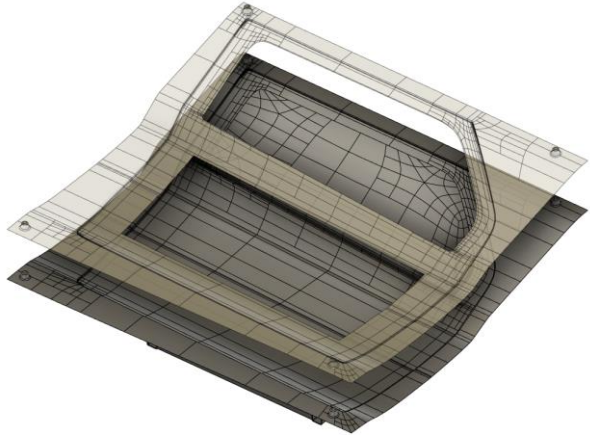
19	Panou lateral dreapta	<p>Dimens.: 2190X1245X195 mm</p> <p>Idem poz. 1, cu baza L x l = 950X700, lungime totala profil 6,20 m</p>	 
20	Panou lateral stanga	<p>Dimens.: 2190X1245X195 mm</p> <p>Idem poz. 1, cu baza L x l = 950X700, lungime totala profil 7,20 m</p>	

21	Panou podea sasiu	Dimens.: 1320x1230x80 mm Idem poz. 1	
22	Panou spate (cabina sofer +pasager)	Dimens.: 1390x1340x80 mm Idem poz. 1	

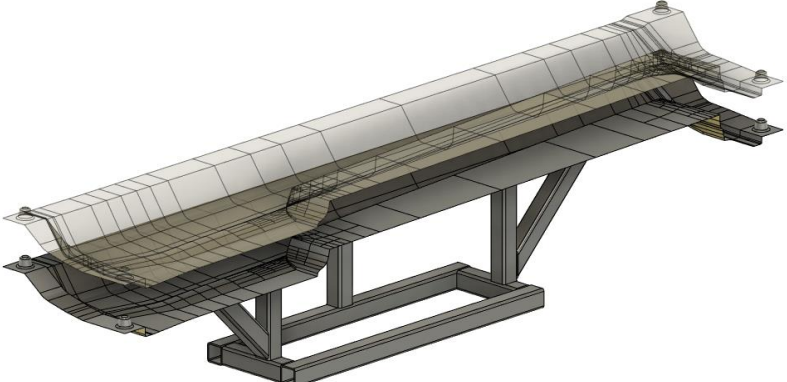
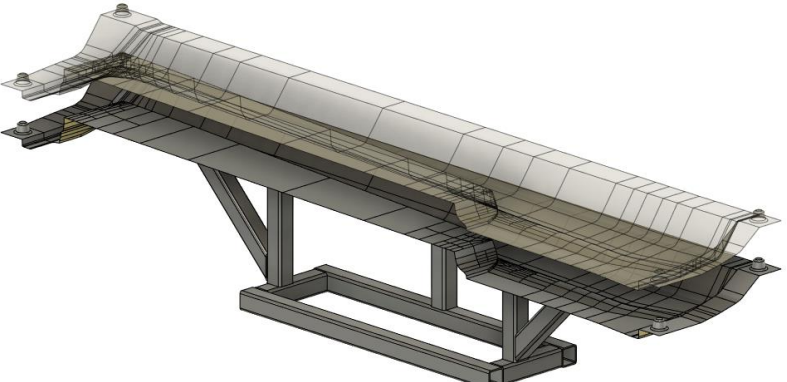
CD - OMPONENTA SETULUI DE DISPOZITIVE DE CONTROL, PENTRU PANOURI DE CAROSERIE V.E L7e-CU			
Nt. Crt.	Dispozitiv de control, pentru:	Specificatii tehnice dispozitiv	Imagine indicativa ansamblu dispozitiv
1	Plafon exterior	<p>Dimens. Lxlxh: 1290x1240x120 mm</p> <ul style="list-style-type: none"> – Constructie: format dintr-o suprafata de asezare prevazuta cu strangatoare/ mecanisme articulate de fixare a componentei, repere pentru pozitionarea pieselor/insertiilor care se monteaza, structura compozita de rigidizare si baze. – Material pentru suprafata de fixare/ prelucrare: tesatura din fibra de carbon preimpregnata ptr. matrite; grosime finala suprafata: 8 -0,5/+1 mm; stratificatie materiale: 1 strat GG200T-TR25 + 10 straturi GG630T-TR25. – Caracteristici tesatura GG200T-TR25: fibra carbon tip 3K HS;; tip tesatura 2x2 Twill, matrice/rasina epoxidica; temperatura de tranzitie a sticlei Tg max. (ASTM D 3418), 195 °C dupa post intarire. – Caracteristici tesatura GG630T-TR25: fibra carbon tip 12K HS;; tip tesatura 2x2 Twill, matrice/rasina epoxidica; temperatura de tranzitie a sticlei Tg max. (ASTM D 3418), 195 °C dupa post intarire; – Uscare/intarire in autoclava, conform Fisei tehnice a materialului. – Grad de finisare: polisata, clasa B – Toleranta la forma suprafetei 1,5 mm; – Mecanismele/Strangatoarele articulate sunt dispuse pe perimetrul dispozitivului, la o distanta de aprox. 600 mm intre ele. <p>Material structura de rigidizare: profil patrat 30x30x1,5 mm din material compozit, dimensiuni baza de asezare 700x700 mm, lungime totala profil 5,70 m.</p>	

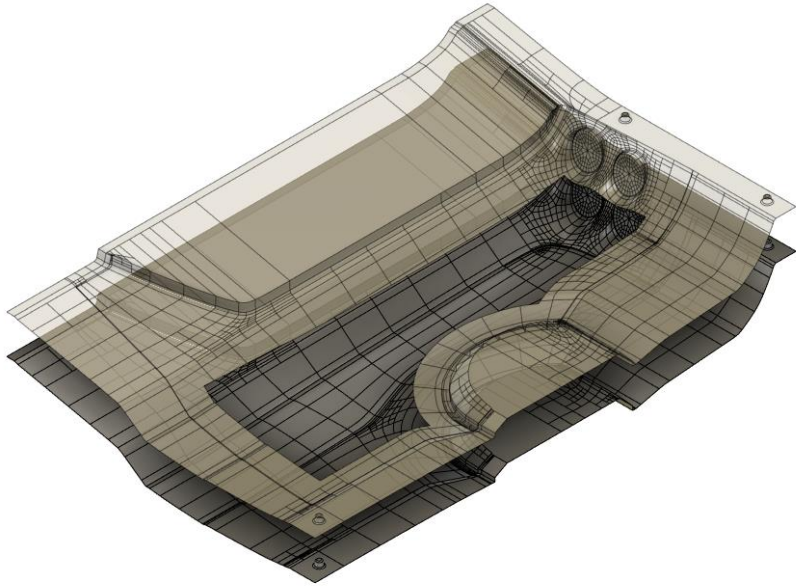
2	Plafon interior	Dimens.: 1170x1080x85 mm Idem poz. 1	
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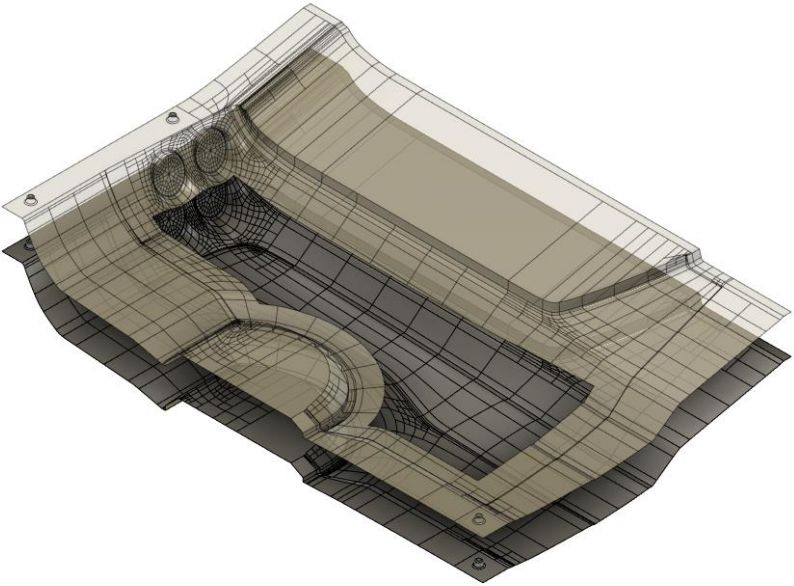
3	Usa dreapta	Dimens.: 1390x1390x170 mm Idem poz. 1	
4	Interior usa dreapta	Dimens.: 1395x1400x150 Idem poz. 1 mm	

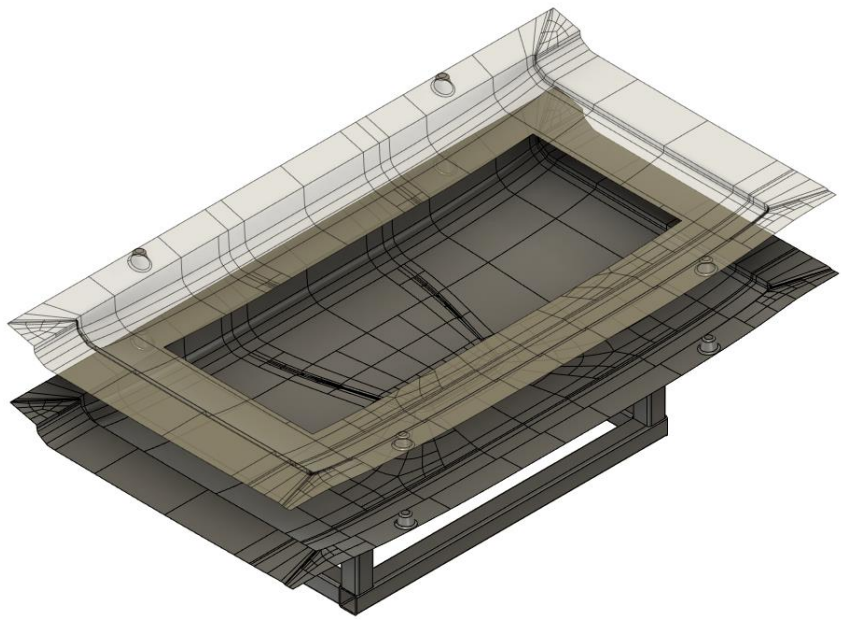
5	Cadru usa dreapta	Dimens.: 1480x1375x220 mm Idem poz. 1	
6	Usa stanga (ext.)	Dimens.: 1390x1390x170 mm Idem poz. 1	

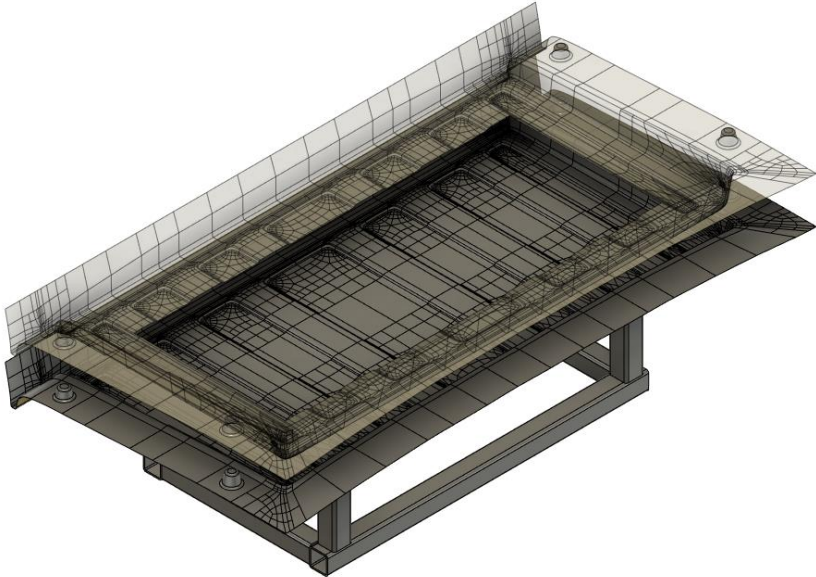
7	Interior usa stanga	Dimens.: 1395x1400x150 mm Idem poz. 1	
8	Cadru usa stanga	Dimens.: 1480x1375x220 mm Idem poz. 1	

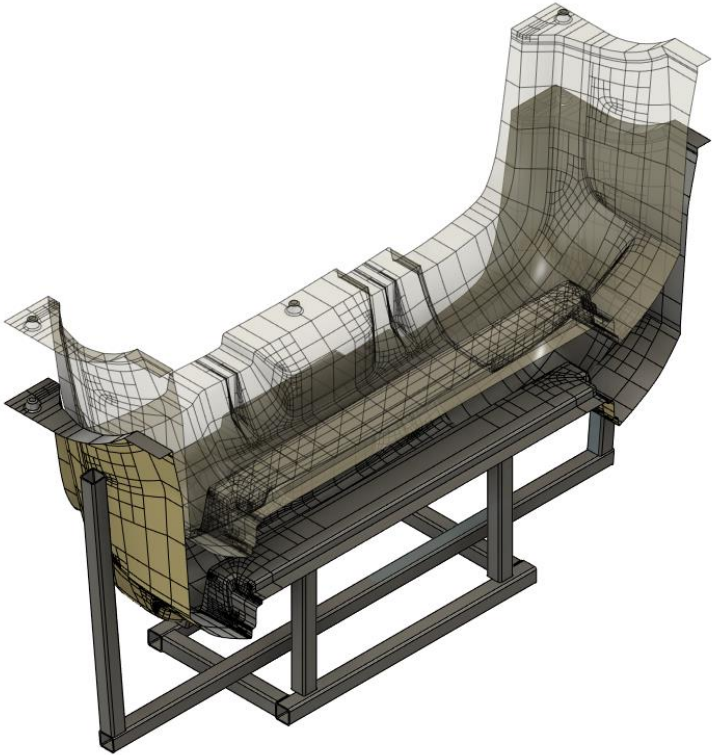
9	Prag dreapta	Dimens.: 1830x340x95 mm Idem poz. 1, cu baza L x l = 700x250, lungime totala profil 4,70 m	
10	Prag stanga	Dimens.: 1830x340x95 mm Idem poz. 1, cu baza L x l = 700x250, lungime totala profil 4,70 m	

11	Aripa spate dreapta	<p>Dimens.: 1870x1190x300</p> <p>Idem poz. 1, cu baza L x l =700x400 mm, lungime totala profil 5 m</p>	
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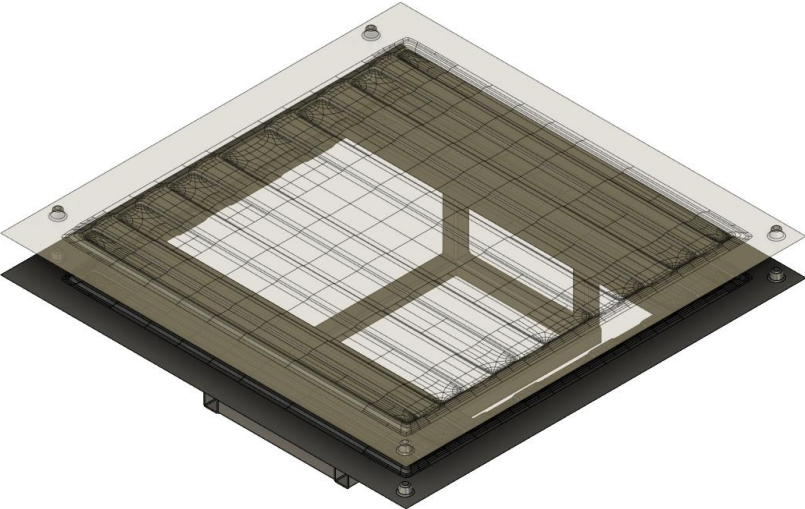
12	Aripa spate stanga	<p>Dimens.: 1870x1190x300</p> <p>Idem poz. 1, cu baza L x l =700x400 mm, lungime totala profil 5 m</p>	
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13	Usa lada spate, ext.	<p>Dimens.: 1230x640x90</p> <p>Idem poz. 1, cu baza L x l =700x400 mm, lungime totala profil 5 m</p>	
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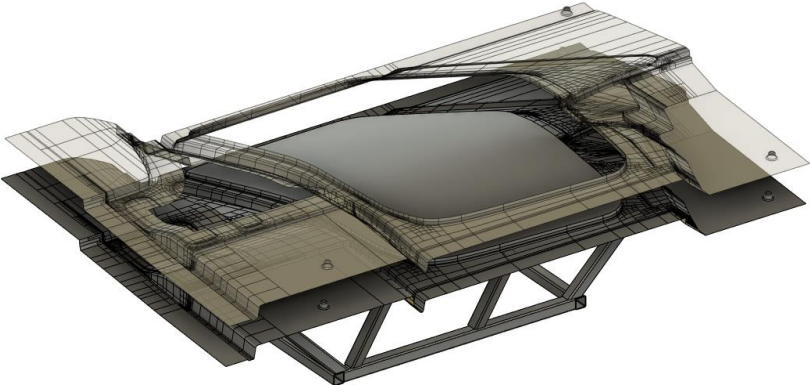

14	Usa lada spate, int	<p>Dimens.: 1155X615X85</p> <p>Idem poz. 1, cu baza L x l =700x250 mm, lungime totala profil 5 m</p>	
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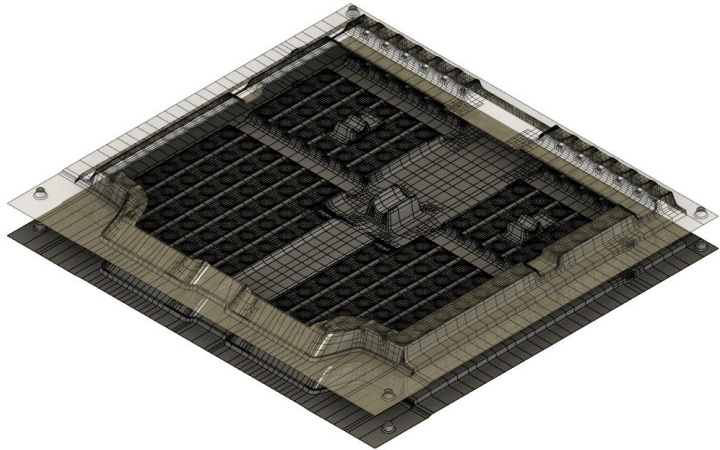
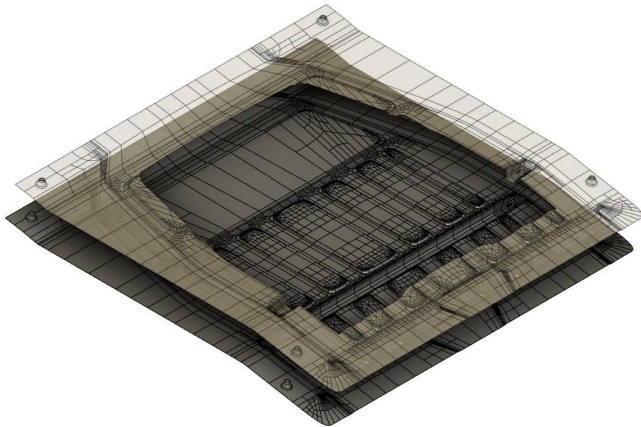
15	Bara spate	<p>Dimens.: 1560X440X620</p> <p>Idem poz. 1, cu baza L x l =700x400 mm, lungime totala profil 5 m</p>	 <p>The image shows a 3D CAD model of a curved metal backrest assembly. The backrest is made of a mesh of rectangular panels and is mounted on a frame consisting of two vertical support legs and a horizontal base. The backrest is curved upwards and backwards, with a small rectangular panel at the top. The model is shown in a perspective view, highlighting its three-dimensional structure and the way it is supported by the frame.</p>
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16	Lada spate	<p>Dimens.: 1270x1150x755 mm</p> <p>Idem poz. 1, cu placa de baza L x l = 950x700, lungime totală profil 11,5 m</p>	 <p>The image is a 3D CAD model of a rear loading platform. It features a robust metal frame with vertical and horizontal supports. A large, flat base plate is mounted on the frame. A mesh structure, likely for a conveyor or sorting system, is integrated into the design. The model is shown from an isometric perspective, highlighting the complex assembly of components.</p>
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17	Podea lada spate	<p>Dimens.: 1125X1115X20 mm</p> <p>Idem poz. 1, cu baza L x l =700x400 mm, lungime totala profil 5 m</p>	 <p>A 3D perspective rendering of a square metal mesh tray. The tray is composed of a grid of metal wires. It features a central divider that splits the tray into four quadrants. The tray is mounted on a dark-colored base plate, which is secured by four screws at the corners. The entire assembly is shown from an isometric perspective, highlighting its three-dimensional structure.</p>
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18	Capac Baterie (podea mica lada spate)	Dimens.: 760X730X20 mm Idem poz. 1, cu baza L x l =700x400 mm, lungime totala profil 5 m	
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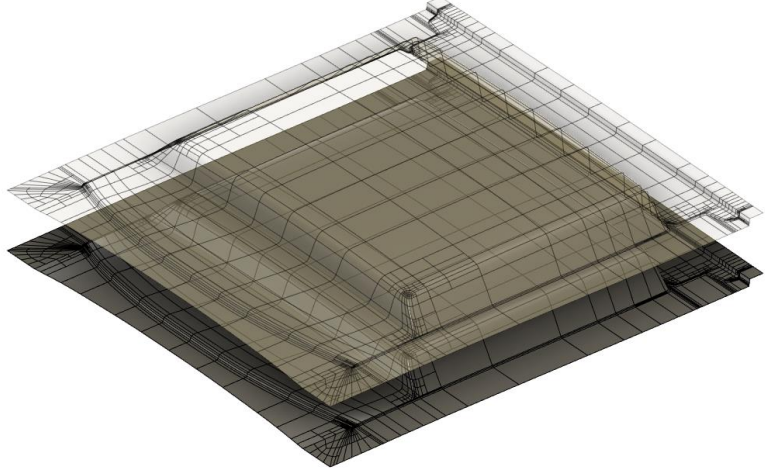
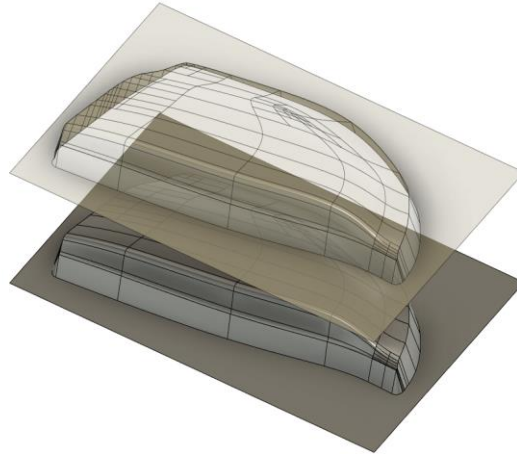
19	Panou lateral dreapta	Dimens.: 2190X1245X195 mm Idem poz. 1, cu baza L x l = 950X700, lungime totala profil 6,20 m	 
20	Panou lateral stanga	Dimens.: 2190X1245X195 mm Idem poz. 1, cu baza L x l = 950X700, lungime totala profil 7,20 m	

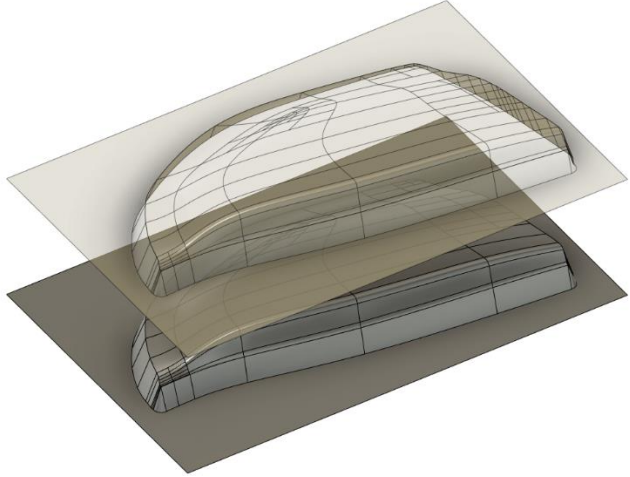
21	Panou podea sasiu	Dimens.: 1320x1230x80 mm Idem poz. 1	
22	Panou spate (cabina sofer +pasager)	Dimens.: 1390x1340x80 mm Idem poz. 1	

SPECIFICATII TEHNICE, pentru
DISPOZITIVE DE PRODUCTIE (MATRITE) PENTRU ELEMENTE INTERNE ALE V.E L7e-CU = 1 SET

COMPONENTA SETULUI DE MATRITE PENTRU ELEMENTE INTERNE ALE V.E L7e-CU

Nt. Crt.	Denumire matrita	Procedeu de lucru	Specificatii tehnice matrita	Imagine ilustrativa ansamblu matrita
1	Capitonaj podea	Formare prin compresie in matrita, cu preincalzire material	<ul style="list-style-type: none"> – Dimens.: 1320x1230x85 mm – Constructie: matrita este compusa din parte inf. si parte sup., cu flanse si limitare a cursei de compresie. Fiecare parte a matritei este rigidizata cu o structura metalica cu baza de asezare plana. – Material matrita: tesatura din fibra de carbon preimpregnata ptr. matrite; – Gros. finala matrita 8 mm, tol. -0,5/+1 mm; – Stratificatie matrita: 1 strat GG200T-TR25 + 10 straturi GG630T-TR25; – Caracterisitici tesatura GG200T-TR25: fibra carbon tip 3K HS; tip tesatura 2x2 Twill, matrice/rasina epoxidica; temperatura de tranzitie a sticlei Tg max. (ASTM D 3418), 195 °C dupa post intarire; – Caracterisitici tesatura GG630T-TR25: fibra carbon tip 12K HS; tip tesatura 2x2 Twill, matrice/rasina epoxidica; temperatura de tranzitie a sticlei Tg max. (ASTM D 3418), 195 °C dupa post intarire; – Uscare/intarire in autoclava, conform Fisei tehnice a materialului; – Partea inf. si sup. a matritei se rigidizeaza cu structura metalica din teava de otel, 30x30 x2. – Sistem de centrare/ghidare pe flanse la inchiderea matritei, in patru puncte, cu pini metalici. – Toleranta la forma suprafetei: 1,5 mm Grad de finisare suprafata activa matrita: clasa B 	

2	Capitonaj plafon	Formare prin compresie in matrita, cu preincalzire material	Dimens.: 1155x1080x85 mm Constructie idem poz. 1	
3	Capitonaj panou intern usa dr.	Formare prin compresie in matrita, cu preincalzire material	Dimens.: 700x450x80 mm Constructie idem poz. 1	

4	Capitonaj panou intern usa stg.	Formare prin compresie in matrita, cu preincalzire material	Dimens.: 700x450x80 mm Constructie idem poz. 1	
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