TECHNOFORM

Unless otherwise noted, use pocket Ⓐ

+Denotes PA 66 GF40
*Denotes article added in 2024

12 mm
- 259700
- 958241

14 mm
14.22 mm
- 514300 Ⓚ

14.6 mm
- 259600
- 259900 Ⓑ
- 263400
- 313000
- 355700

14.8 mm
- 216800
- 259500
- 486100
- 945500
- 953241
- 948500

15 mm
- 432100 Ⓗ

16 mm
- 270000
- 277600 Ⓔ
- 925100
- 955900

16.6 mm
- 420800 Ⓒ

17 mm
- 286600 Ⓓ

17.8 mm
- 325300

18 mm
- 270200
- 357400
- 908300
- 955000
- 550500

18.6 mm
- 279200
- 279300

19 mm
19.23mm
- 514200

19.5 mm
- 354300 (19.50)

20 mm
- 279400
- 279500
- 297800
- 361000
- 439500 (4.05)
- 924900
- 590100
- 516100
- 301700*

20.8 mm
- 541300

21 mm
- 357500

21.17 mm
- 474700*

22 mm
- 245800
- 413700
- 439100
- 978700

23 mm
- 306300 (23.00)

24 mm
- 279600
- 279700
- 418200
- 439400
- 448400
- 599600
- 546100

24.21 mm
- 512000 Ⓚ

25 mm
- 946700

25.98 mm
- 514400 Ⓚ

26 mm
- 978800

26.99 mm
- 567800

27 mm
- 271900
- 971605

27.75 mm
- 578100 Ⓚ

28 mm
- 223500
- 321300
- 975100
- 271600

29 mm
29.15 mm
- 379700

30 mm
- 279800
- 540500
- 547500

31.9 mm
- 541800

32 mm
- 259800
- 306200 Ⓕ
- 355800
- 587200
- 216100
- 619600*
- 619700*

34 mm
- 949200
- 986200
- 986300
- 581700
- 590500
- 384200

35 mm
- 423500
- 423700
- 386400
- 310700 (4.00)
- 310800 (4.00)
- 310900 (4.00)
- 311000 (4.00)
- 311100 (4.00)
- 611200
- 606900

35.59 mm
- 550100 Ⓚ

35.98 mm
- 579700 Ⓚ

36 mm
- 412100

37 mm
- 394400
- 394500
- 394600

38 mm
- 266700
- 335900 / 463400+

>39 mm
- 550200 (39.26) Ⓚ
- 412000 (40.00)
- 332500 (44.00)
- 391500 (48.18)
- 301800 (49.40)
- 470800 (50.00)
- 311300 (58.60)
- 463500 (60.00)
- 328600 (64.00)
- 567900 (68.10) Ⓚ
- 261000 (77.00)

Solutions for curtainwall application
Standard operating rod profiles
- 222400 (19.50 / 4.50)

Standard pressure plates
- 518800 (48.25)
- 449500 (60.95)

Standard curtainwall clip profiles
- 472500 / 489800+ Ⓖ

Shearless solution
20 mm
- 598700

32 mm
- 584815

34 mm
- 584715

24 mm
- 554715

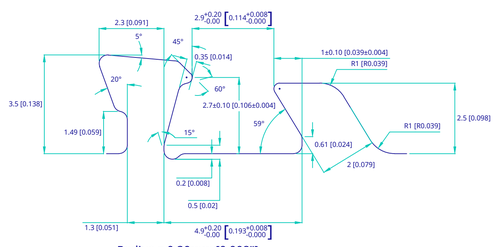
Thermal isolator clip
41.65 mm
- 567700

88.27 mm
- 540200

Reglet design

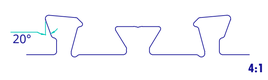
Strip reglets

Ⓐ 4.20 mm Standard Head Dual Strips	Ⓑ 5.77 mm Special Head Hollow Strip	Ⓒ 6.48 mm Special Head Hollow Strip	Ⓓ 6.70 mm Special Head Hollow Strip	Ⓔ 8.27 mm Special Head Hollow Strip	Ⓕ 5.20 mm Special Head Special Strip	Ⓖ Clip interface for 472500	Ⓗ 5.77 mm Special Head Special Strip	Ⓚ 2.31 mm Special Head Special Strip
Variable distance per application; Recommended minimum separation is 2mm (0.08") (2.00)		Hammers are different, due to strip contact.			Variable distance per application	Aluminum shown for reference only. Customer to verify actual tolerance required.		



Radius = 0.20mm [0.008"]
Typical Radius = 0.30mm [0.012"]
** Reglet design for use with Aluminum Alloy 6063. All other alloys require design team review. **
Scale 10:1

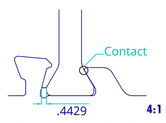
Reglets setup



The standard reglet should be used for any strip with a standard head (4.2mm).

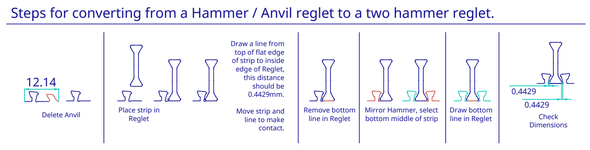
Interior of the reglet should not be changed.

The exterior can be modified some, but the 20° angle should not. This angle is critical to the crimping process.



Correct strip positioning

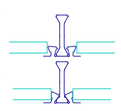
Steps for converting from a Hammer / Anvil reglet to a two hammer reglet.



Steps for hammer rotation

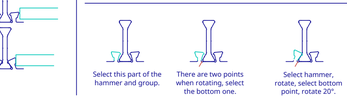
Correct rotation of hammers helps when designing systems and it's a very good way to check for clearance and assembly.

During the crimping process, the hammer outer edge will pressed by a crimp disc. Hammers will rotate until the two surfaces are parallel. Rotation will be 20°.

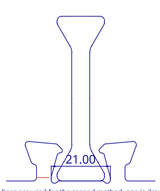


Two methods can be use for rotation, first is a quick check and the second is a more accurate but will take a little longer.

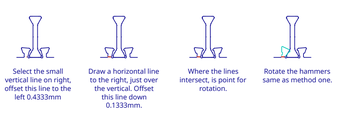
Method one



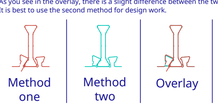
Method two



Two lines are used for the second method, one is drawn from bottom/ left vertical. The other is the small vertical on right.



As you see in the overlay, there is a slight difference between the two.
It is best to use the second method for design work.



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