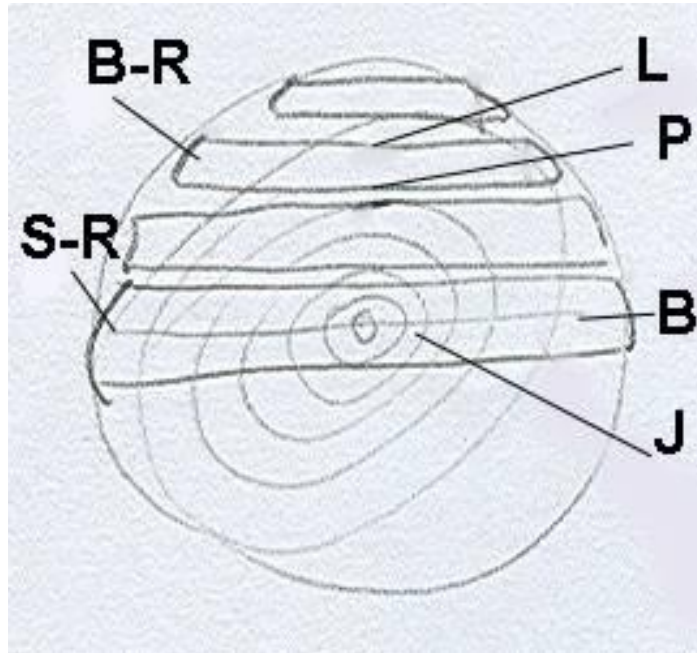


Nastavovanie dosák a prúťov

- 1) Rozširovacie väzby
- 2) Zvlaky a okrajnice
- 3) Nastavovanie na dĺžku

1) Rozširovacie väzby



L = ľavá strana (bližšie k okraju), „viac“ tangenciálna

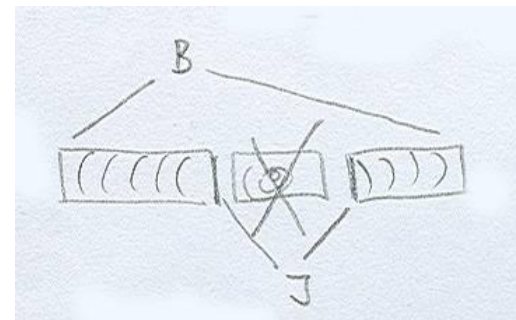
P = pravá strana (bližšie k stredu), „menej“ tangenciálna

B = beľová časť

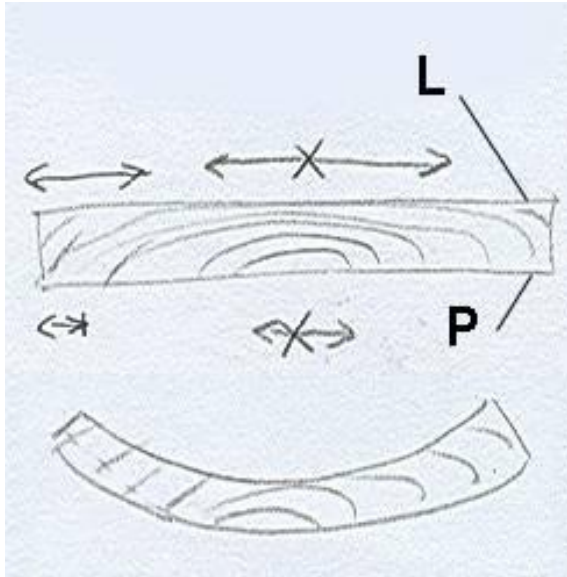
J = jadrová časť

B-R = bočné (tangenciálne) rezivo

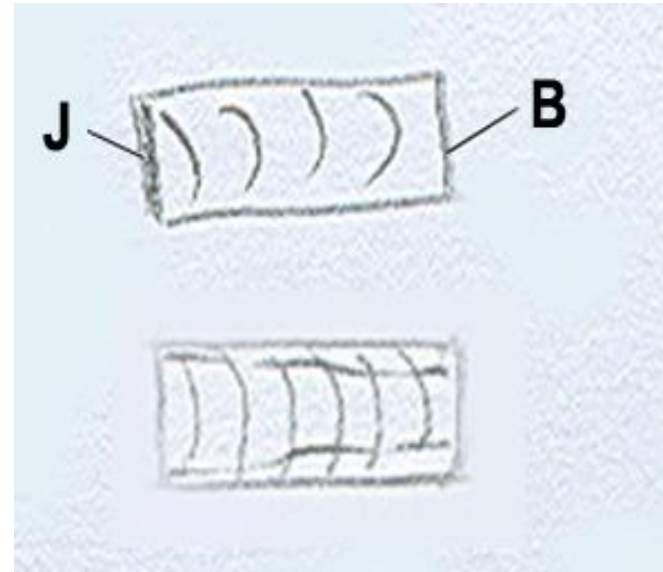
S-R = stredové (radiálne) rezivo



Šúverenie

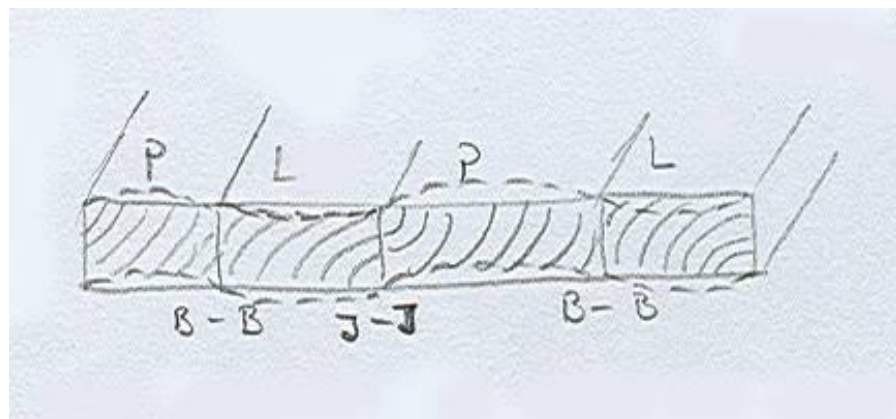


bočné rezivo

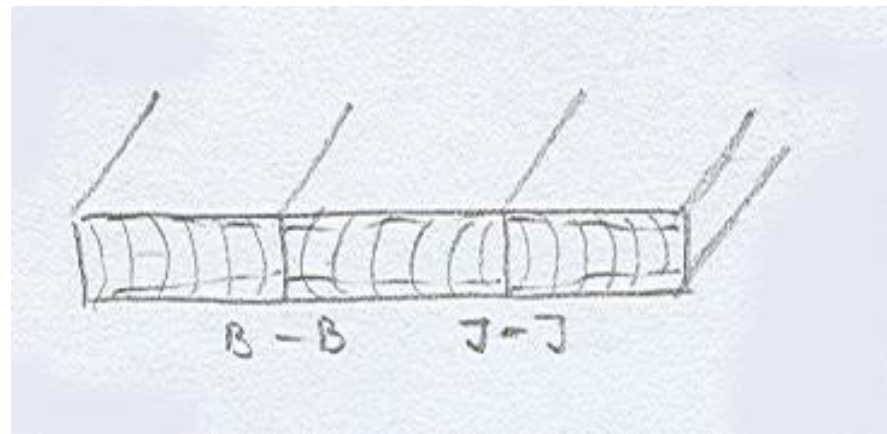


stredové rezivo

Skladba



bočné rezivo

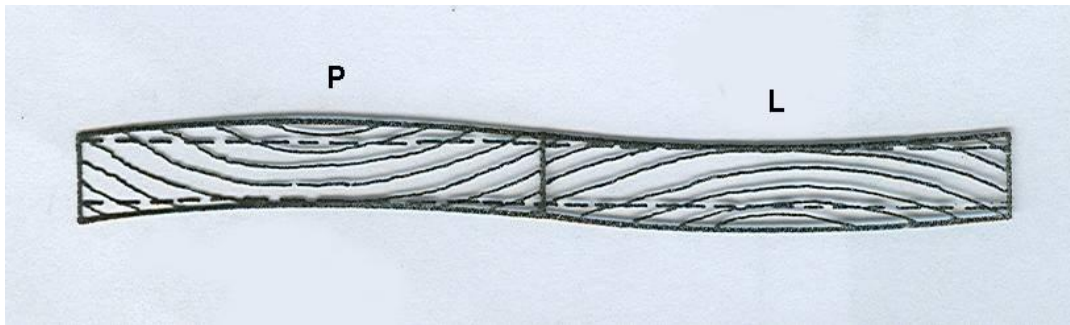


stredové rezivo

Šúverenie

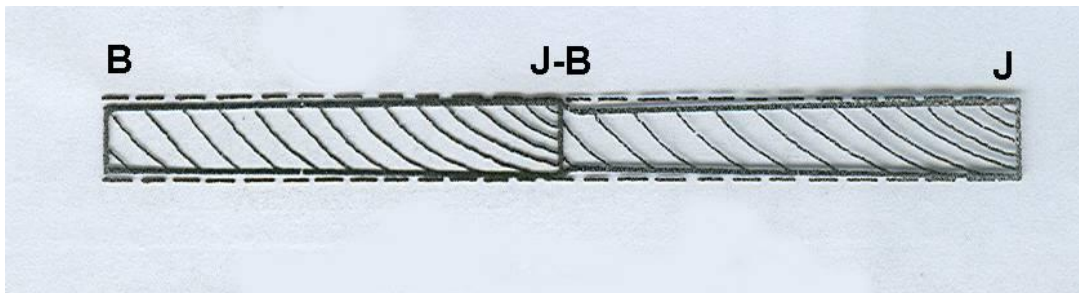


Menšia rovinnosť,
väčšia hrúbka



Väčšia rovinnosť,
menšia hrúbka

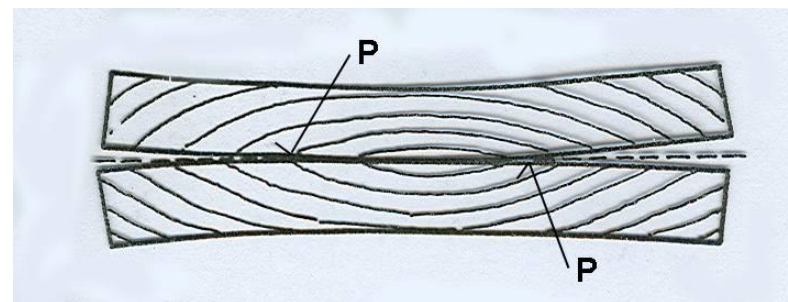
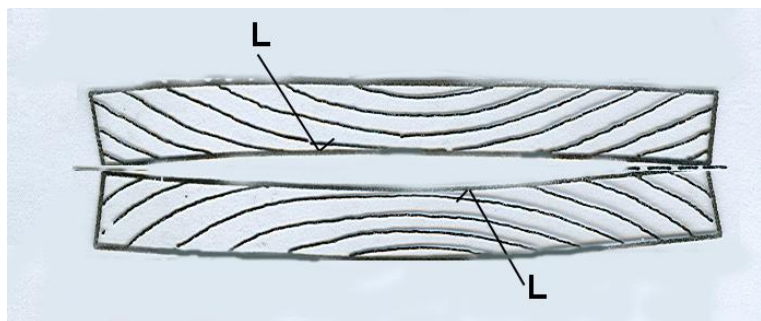
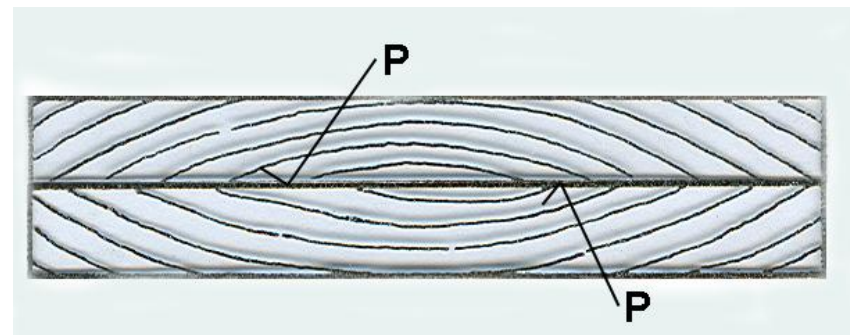
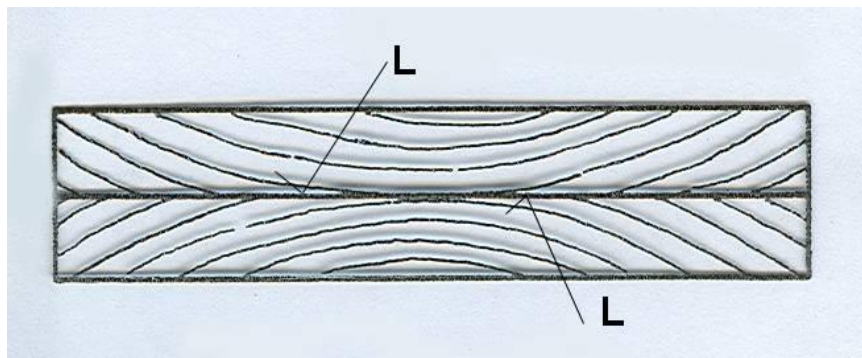
Bočné rezivo



Nerovný povrch

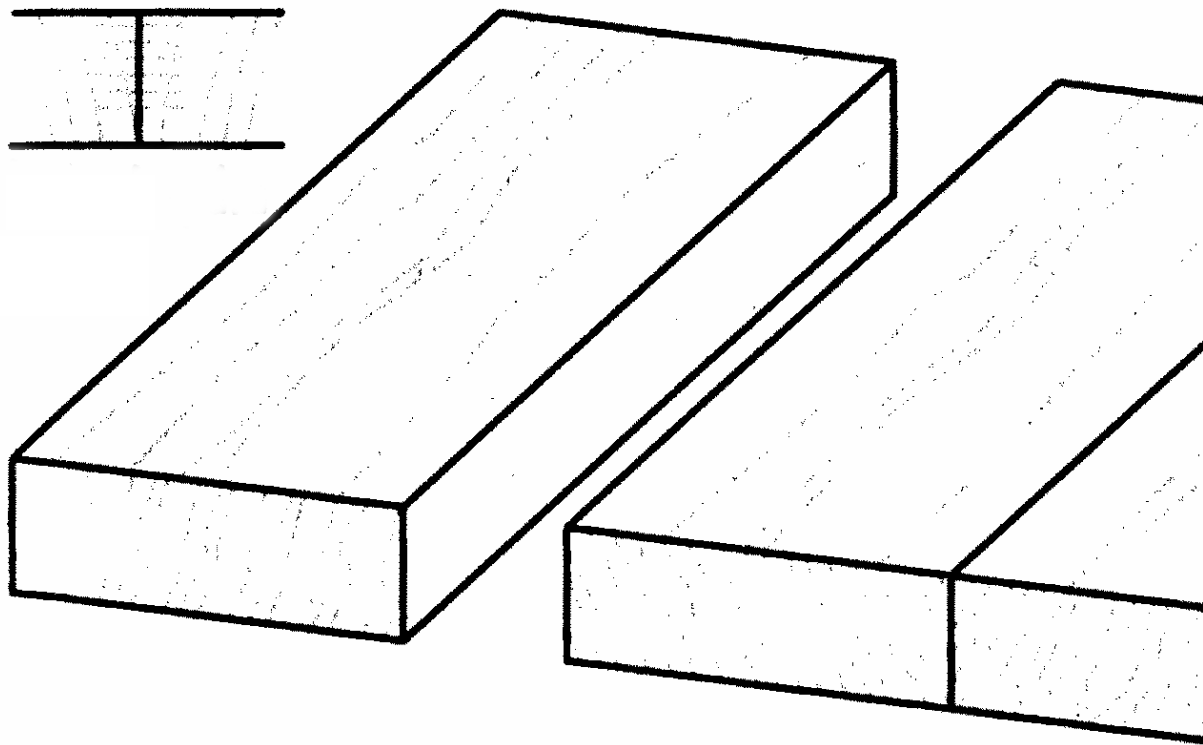
Stredové rezivo

Lepenie a šúverenie širokých dosák na hrúbku

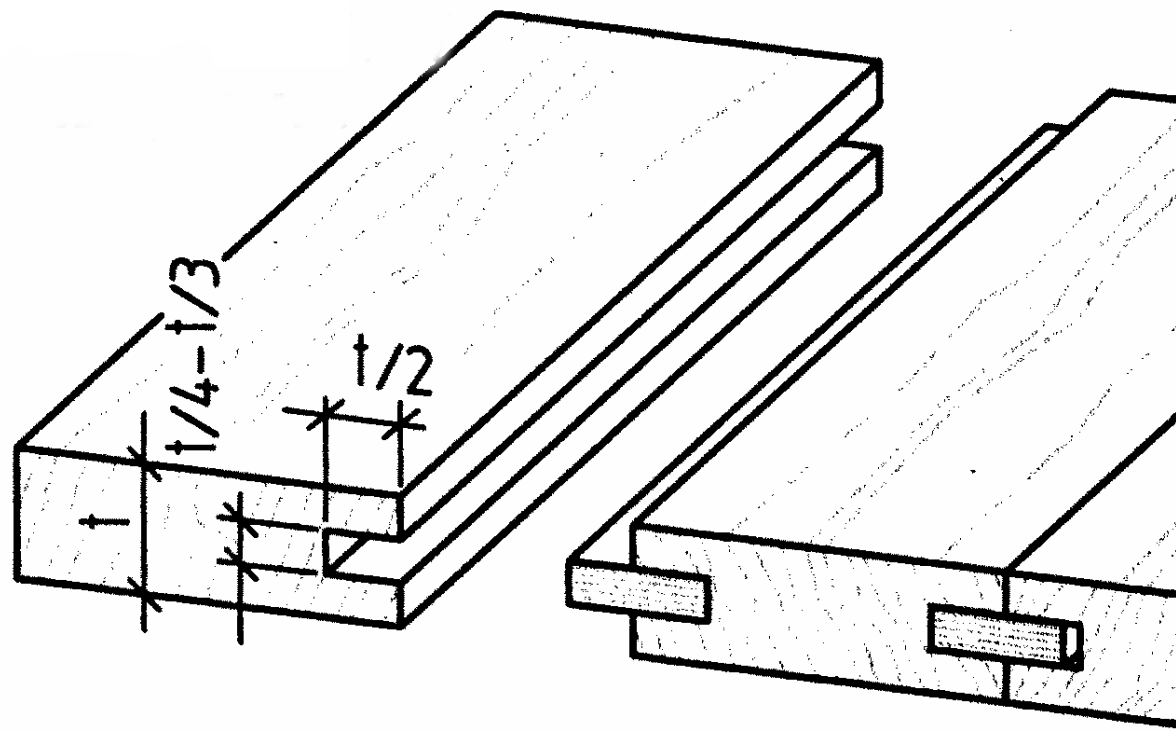


Ľavými stranami –
vhodné (rozlepenie od
stredu)

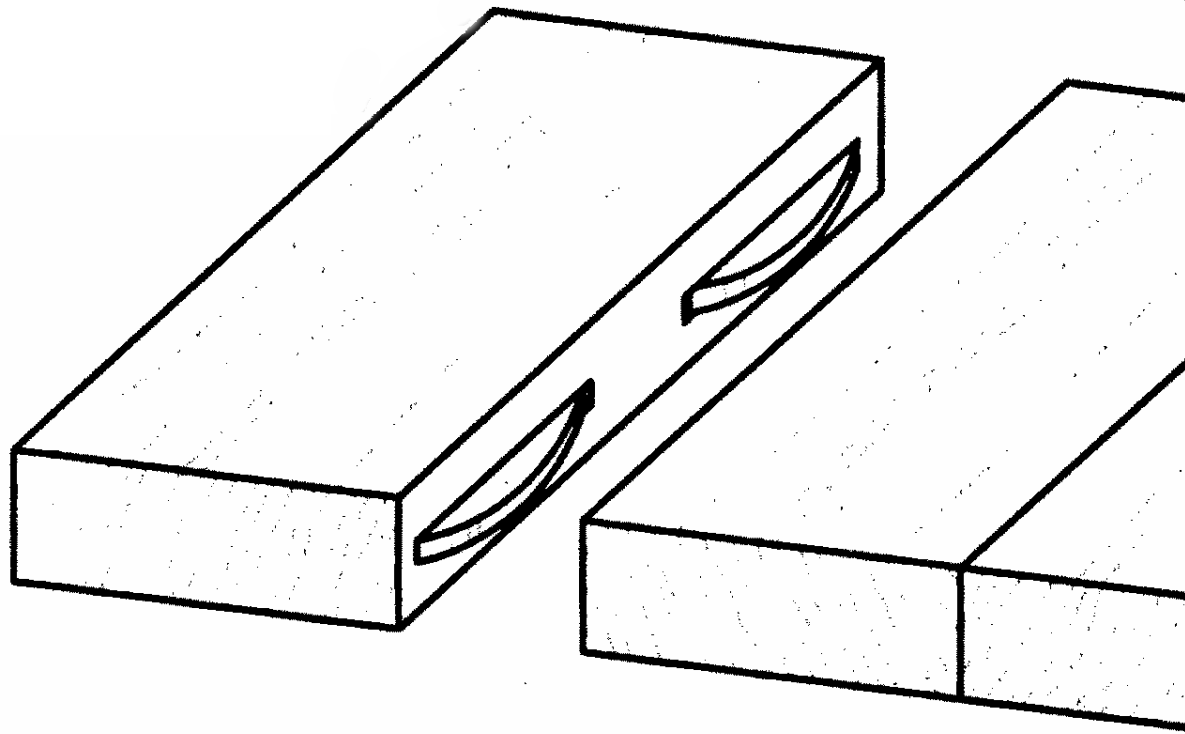
Pravými stranami –
nevhodné (rozlepenie od
okrajov)



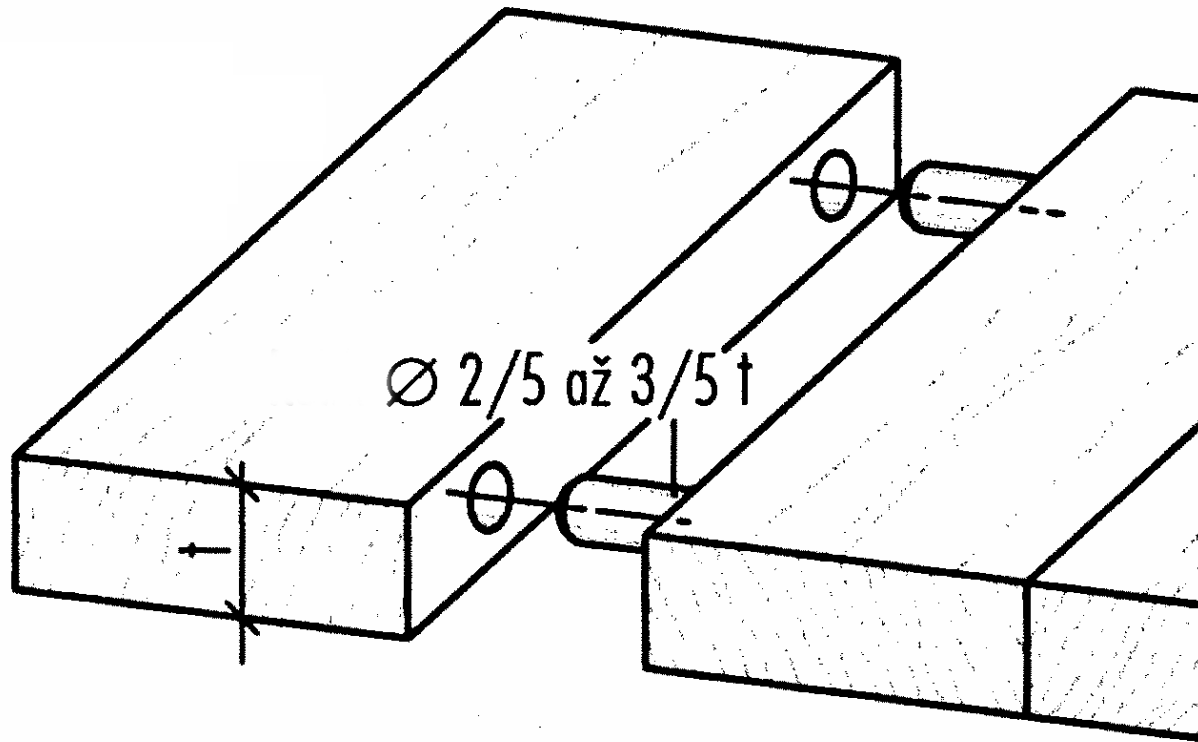
Na tupo - lepená škára



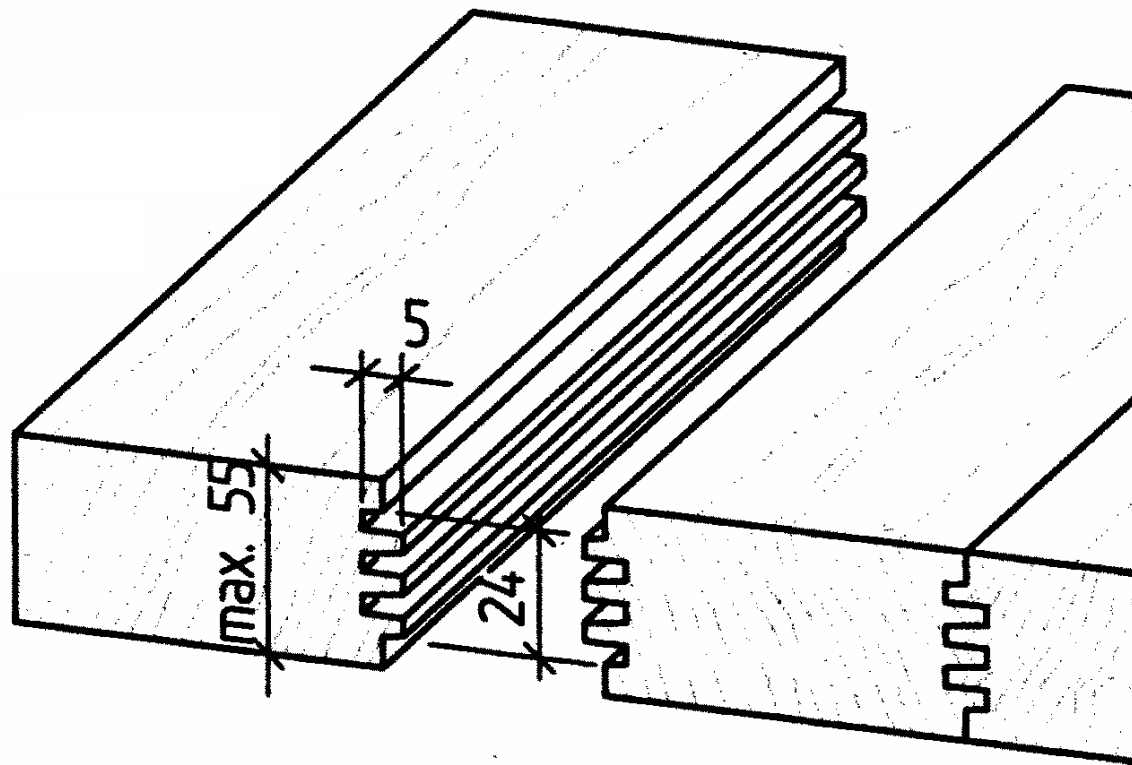
Vložené pero – zväčšenie lepenej škáry



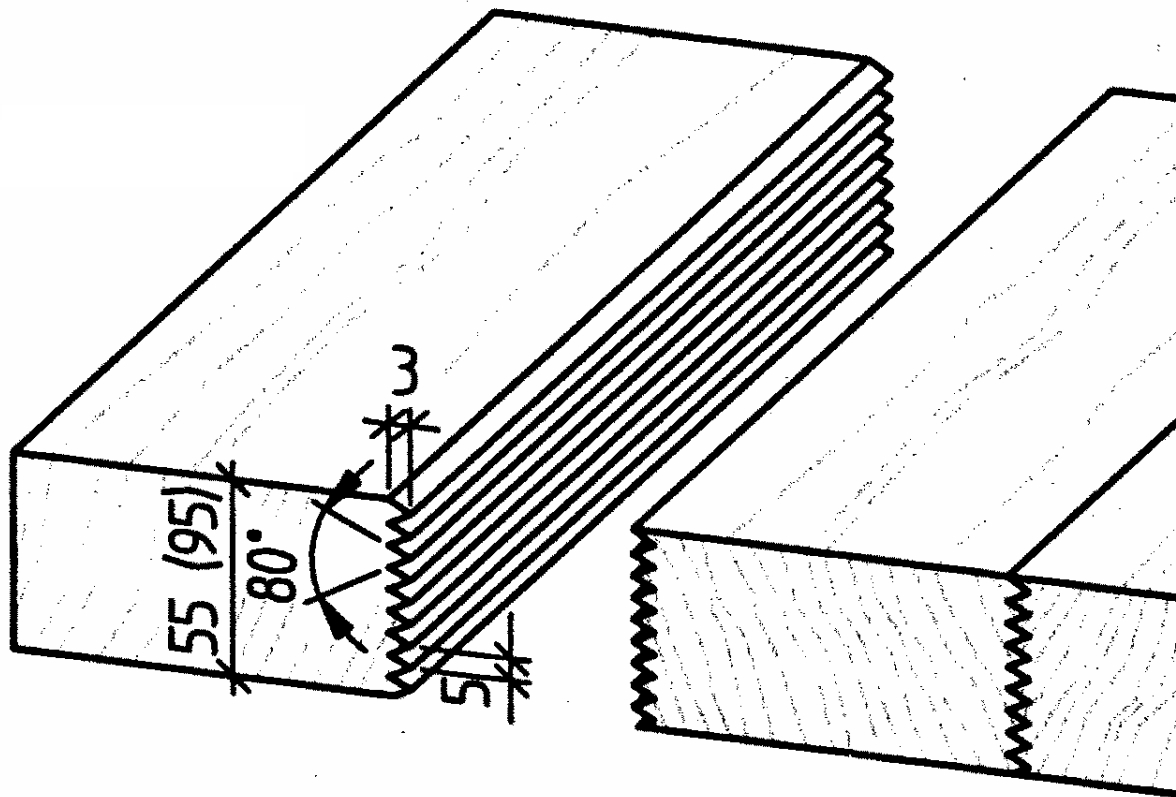
Spoj s lamellom - tvarované pero



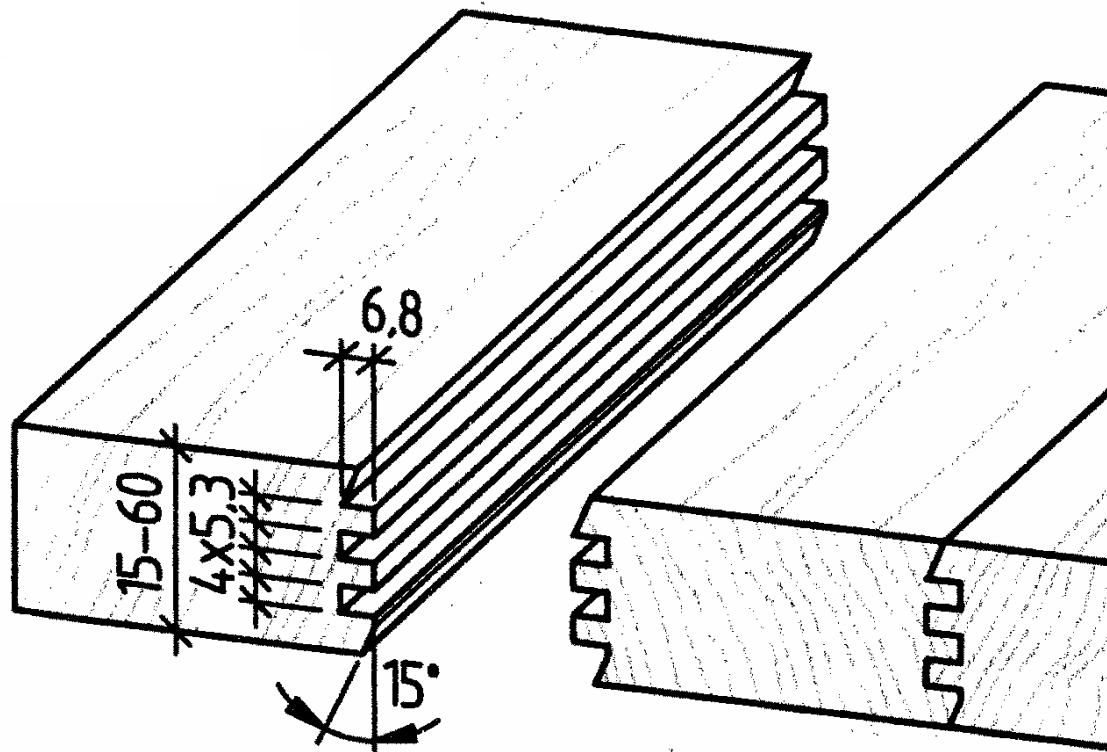
Na tupo – škára zaistená kolíkmi



Zubovitá tupá škára

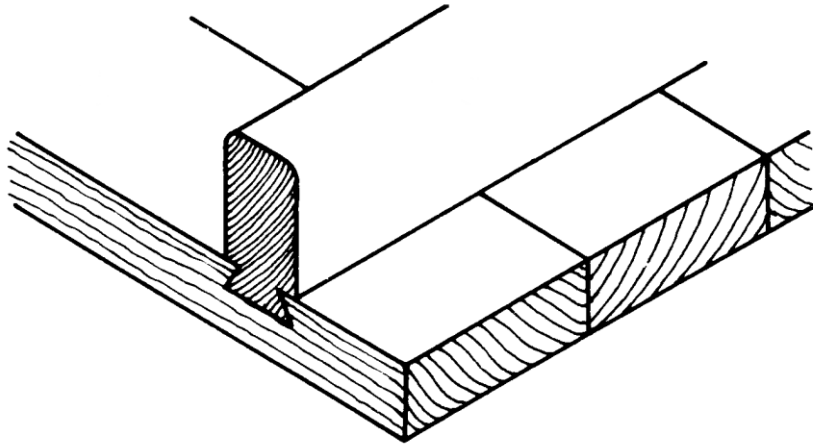


Klinové ozuby

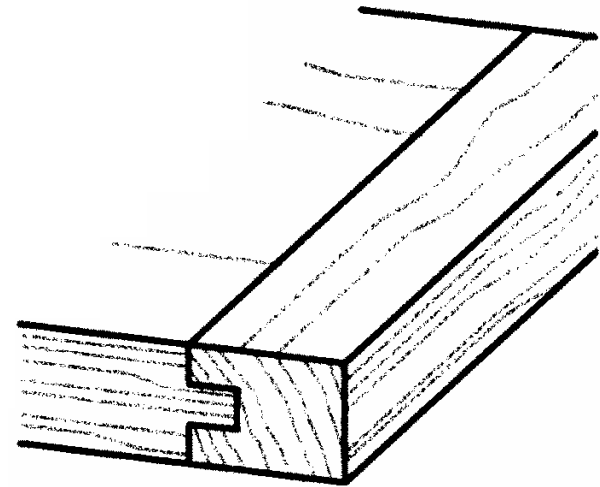


Viacnásobné pero a drážka

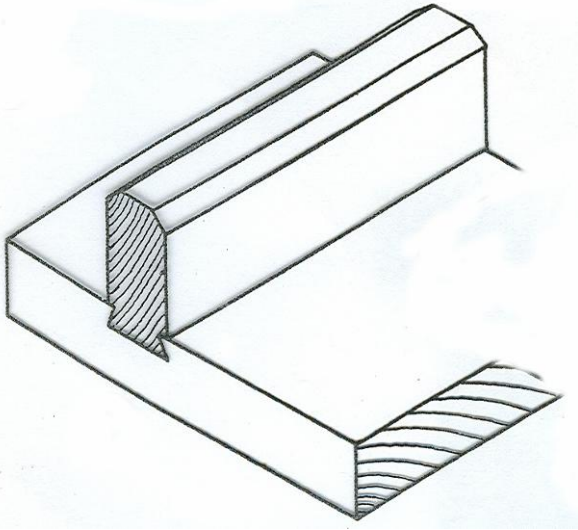
2) Zvlaky a okrajnice



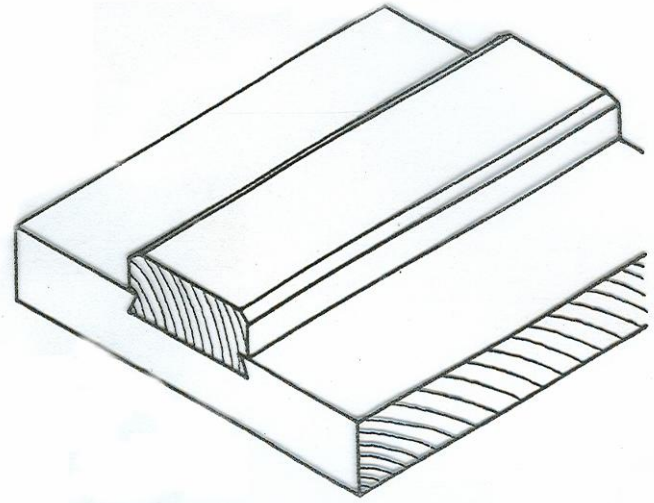
Zvlak



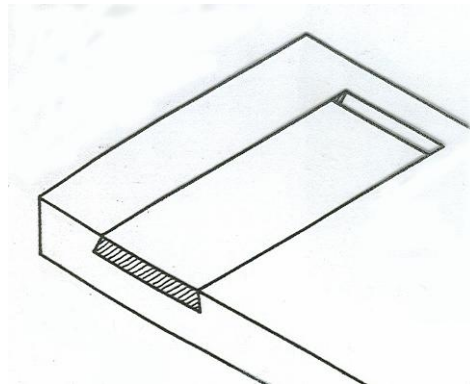
Okrajnica (privlačka)



Zvlak vysoký

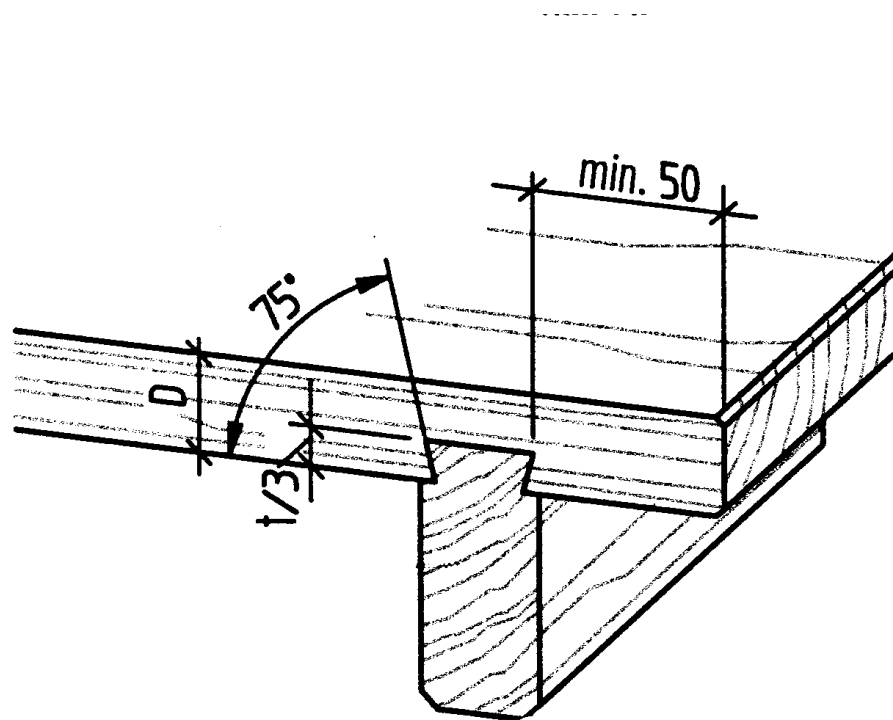


Zvlak nízky

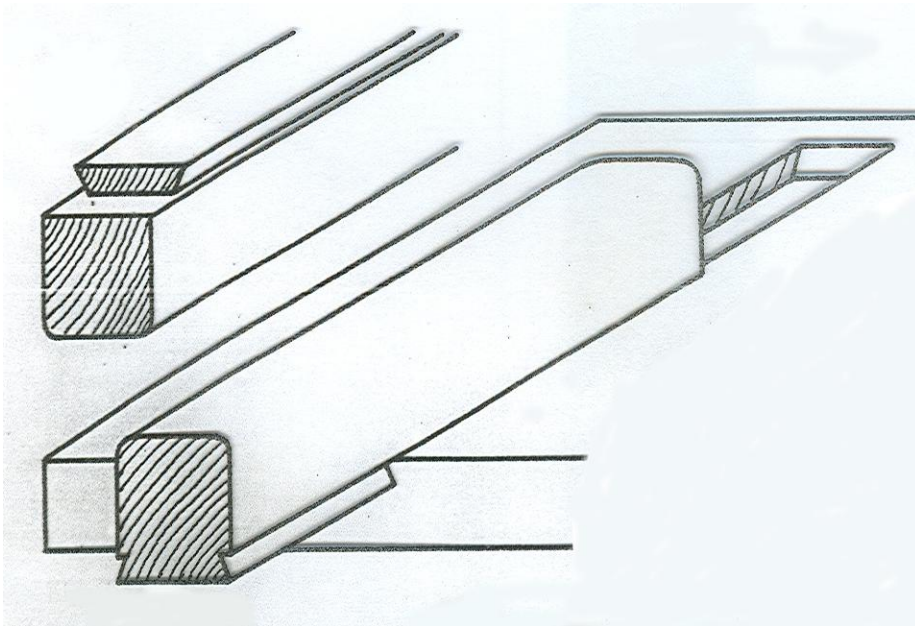


Zvlak zapustený

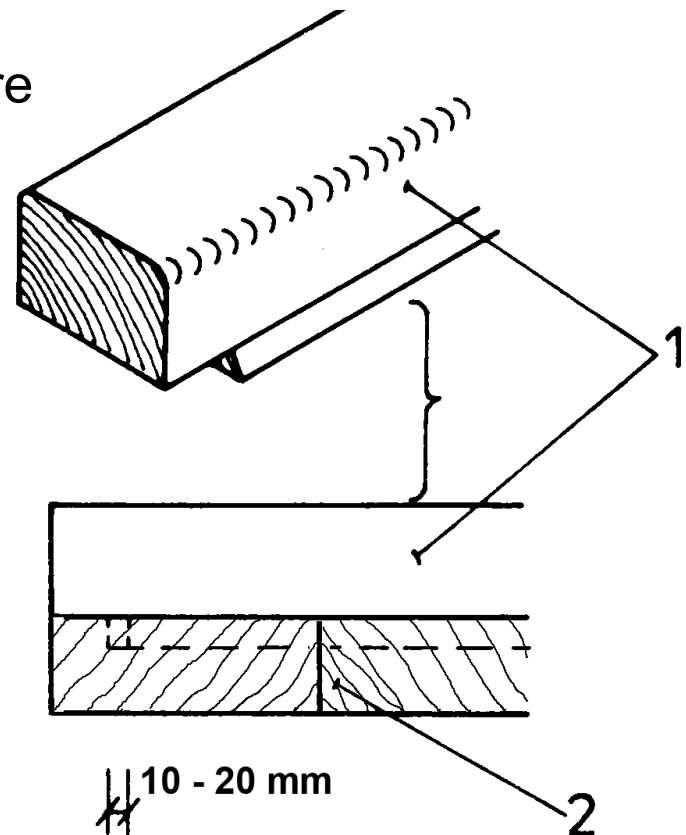
Zvlak – geometrické parametre



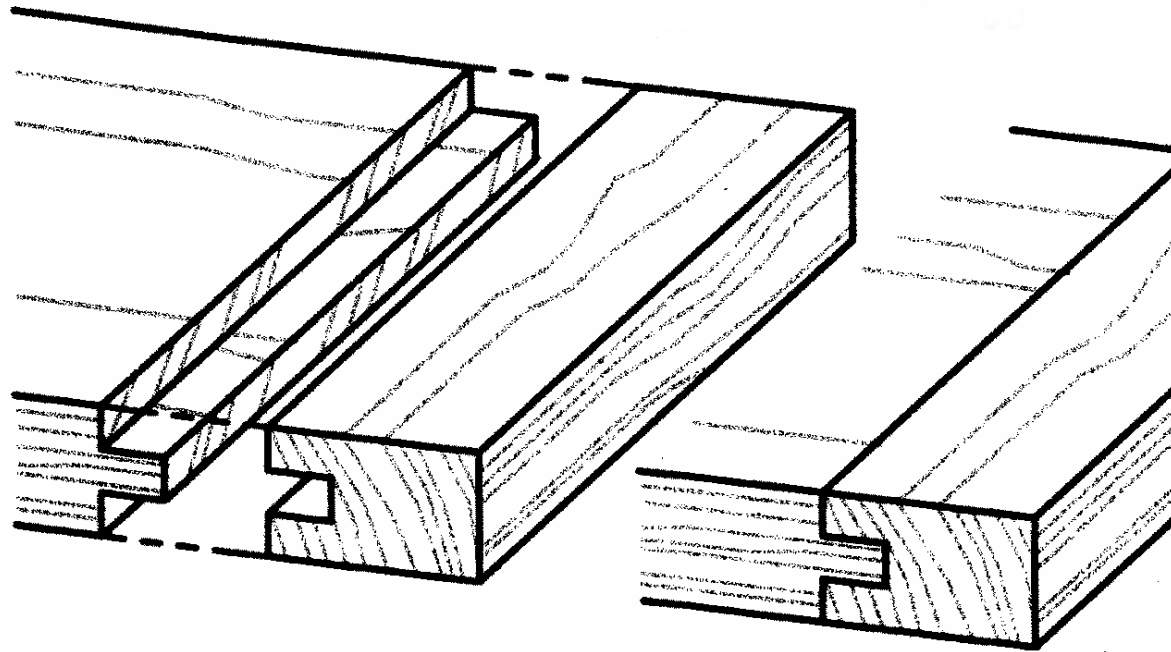
Zvlak – geometrické parametre



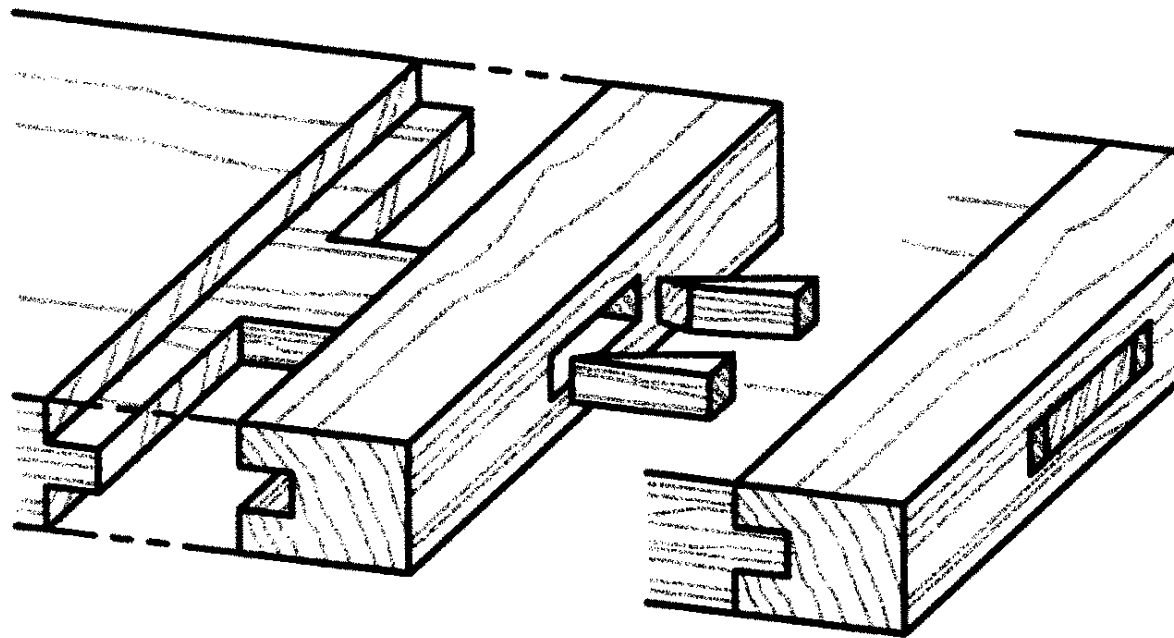
Zvlak – nepriebežná
zvlaková lišta



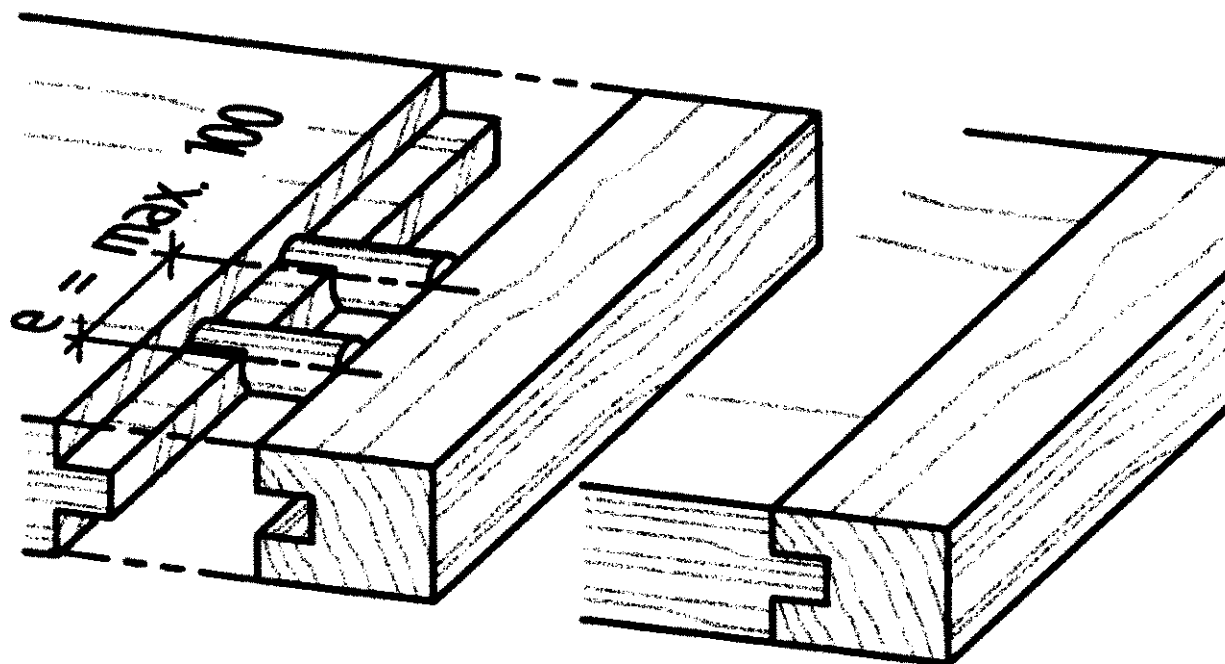
Zvlak – drážka musí byť 10-
20 mm dlhšia ako zvlakové
pero; 1 – zvlaková lišta,
2 - škárovka



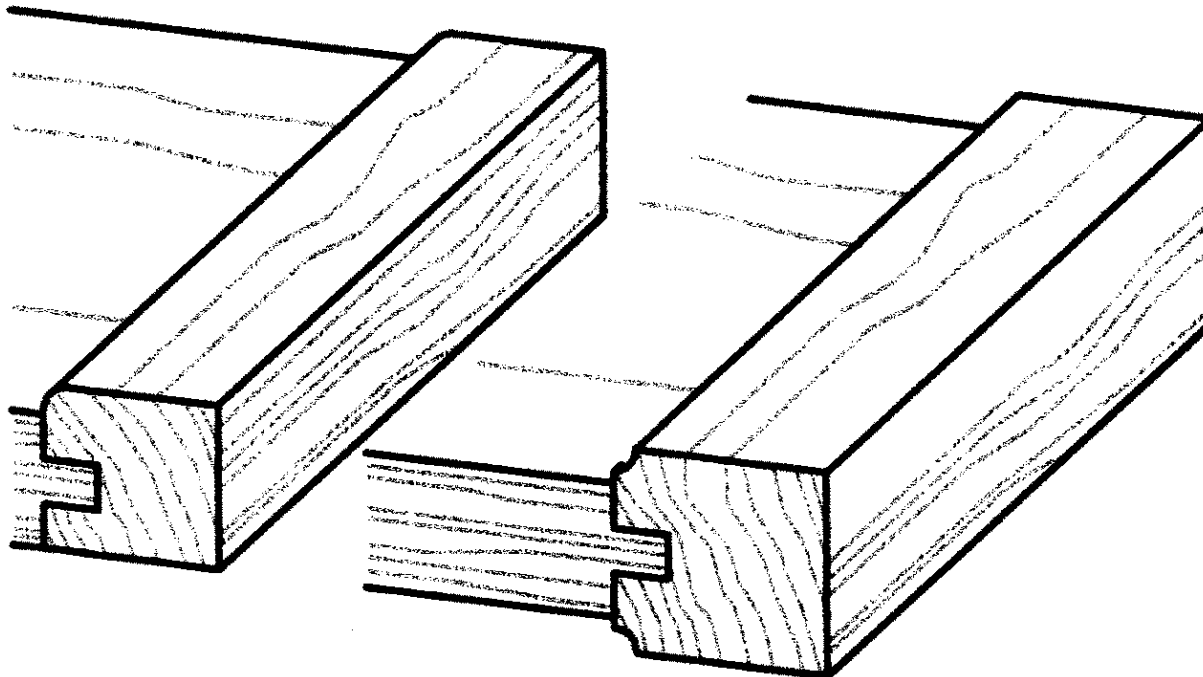
Okrajnica s drážkou



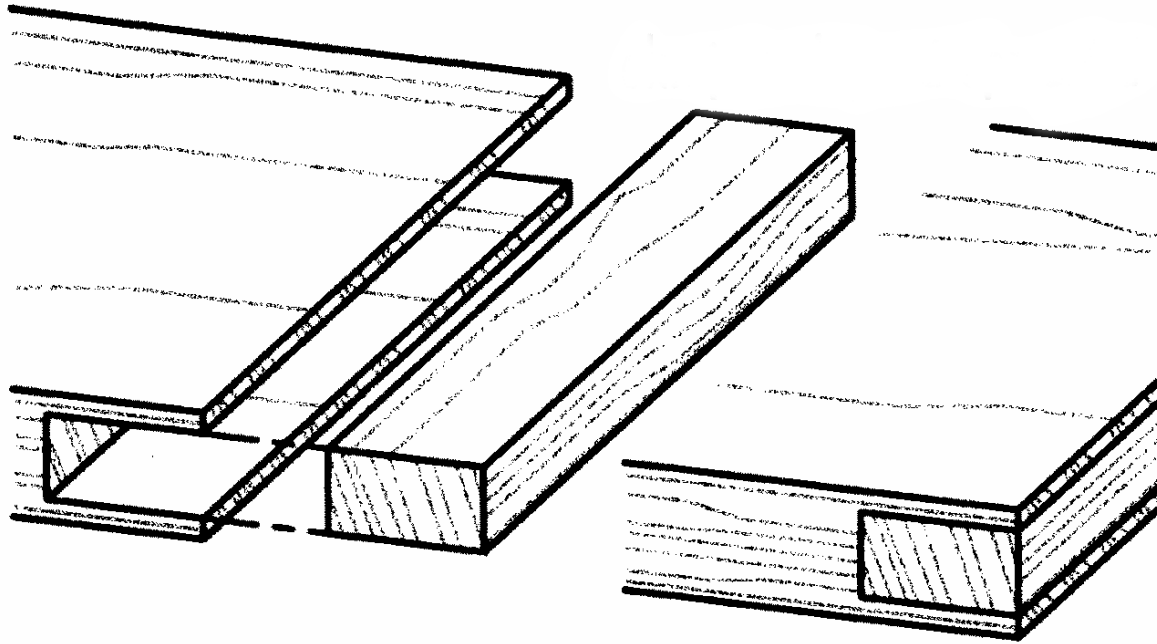
Okrajnica s drážkou a s čapom - zaklinovaná



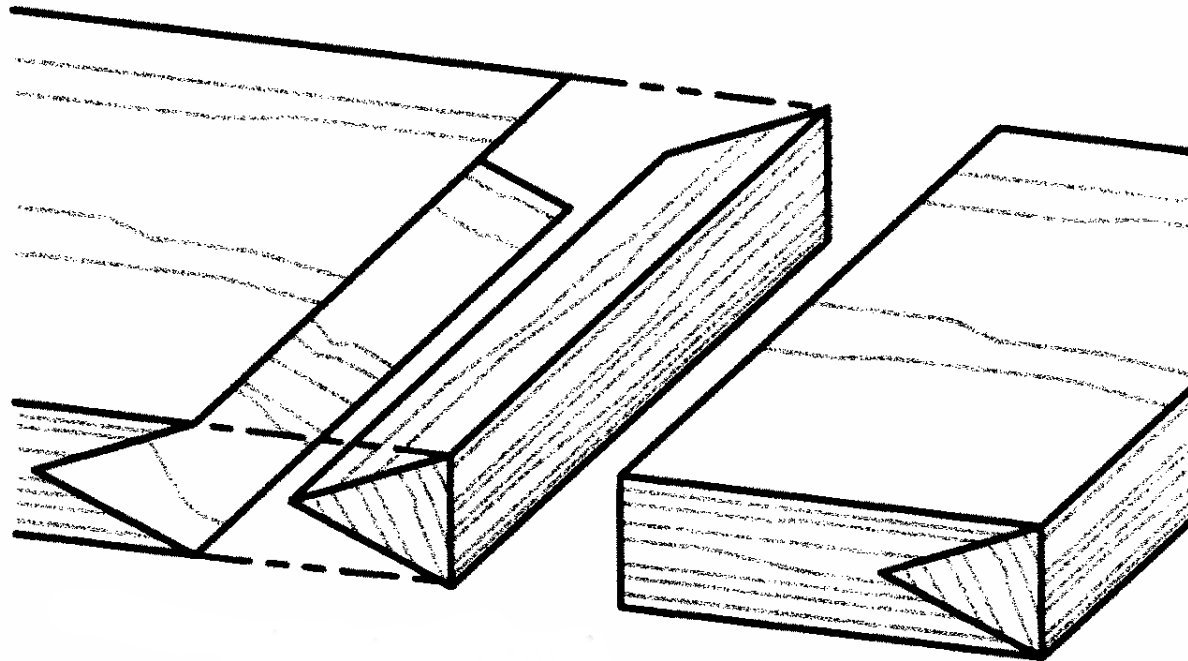
Okrajnica s drážkou a s kolíčky



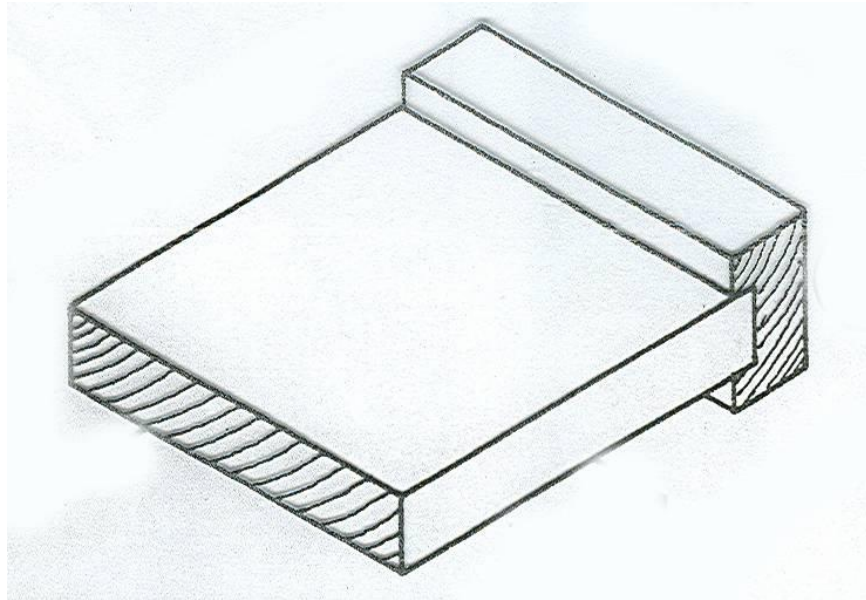
Okrajnica s drážkou - hrubá



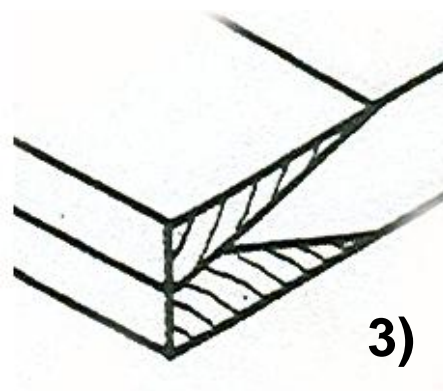
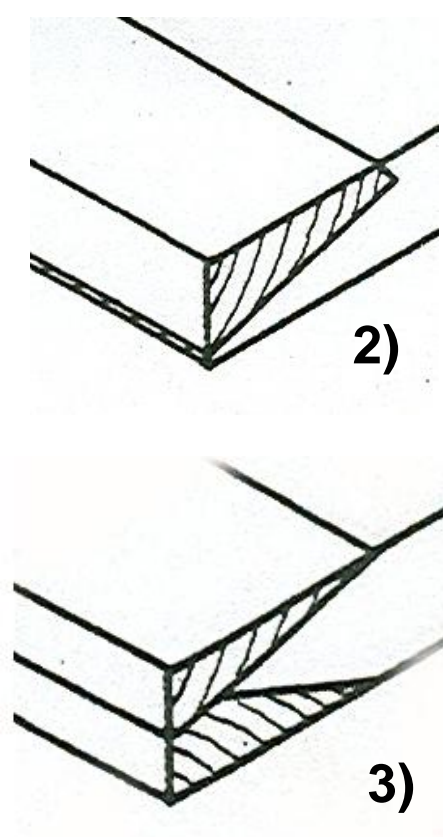
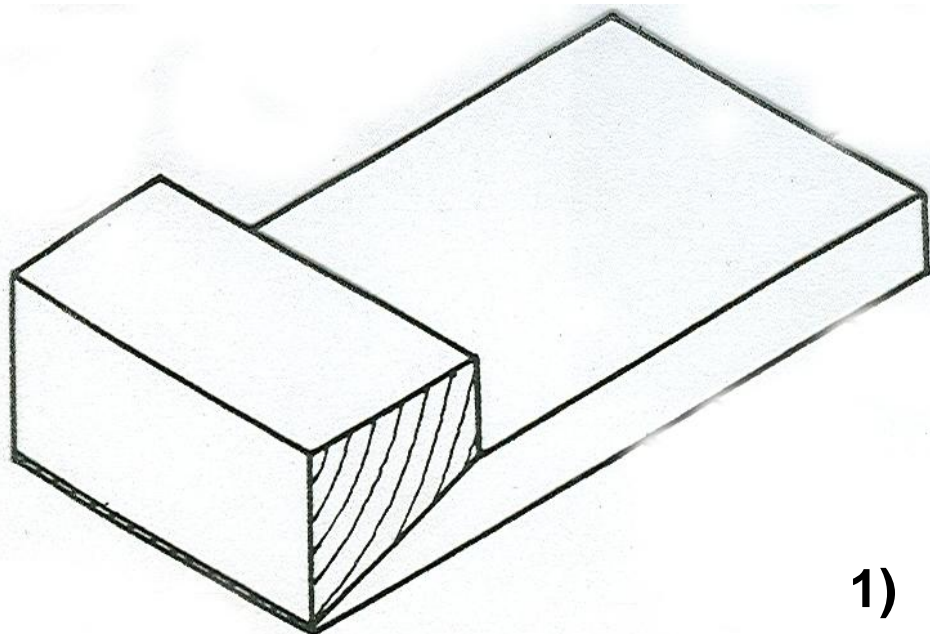
Okrajnica obdĺžniková - vlepená (náglejok)



Okrajnica klinová - vlepená (náglejok)



Okrajnica so zapustením na celú hrúbku, hrubá



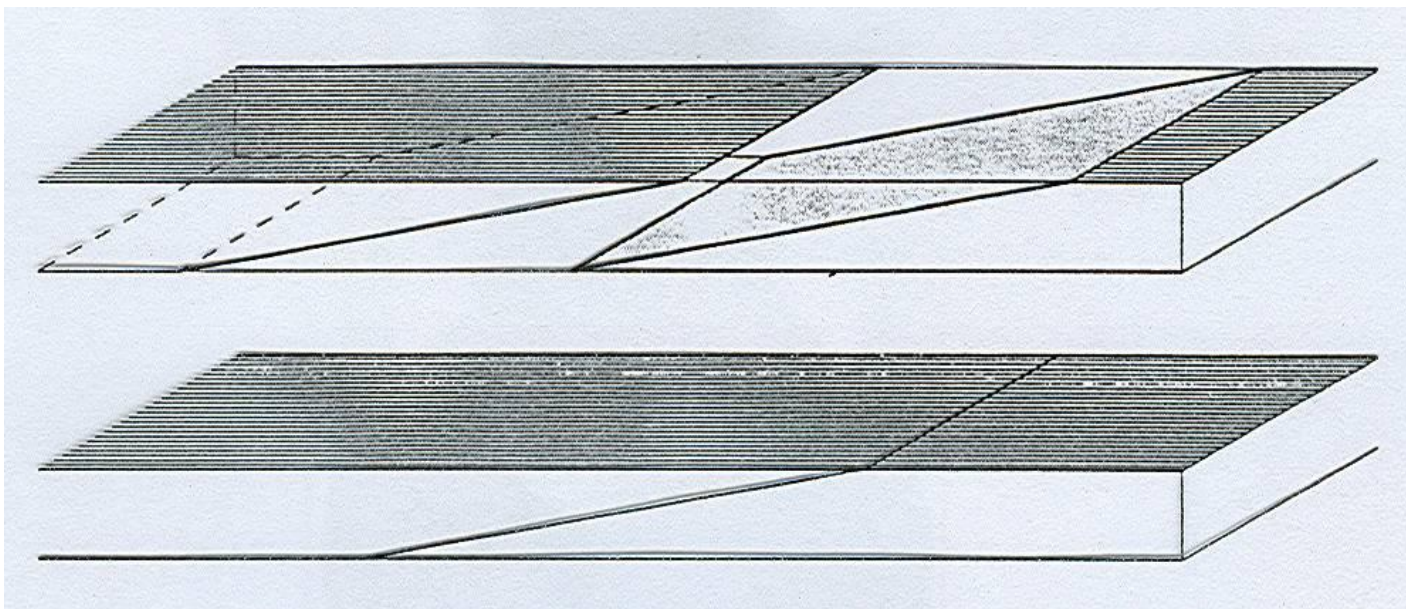
Okrajnica so zošikmením

1- hrubá

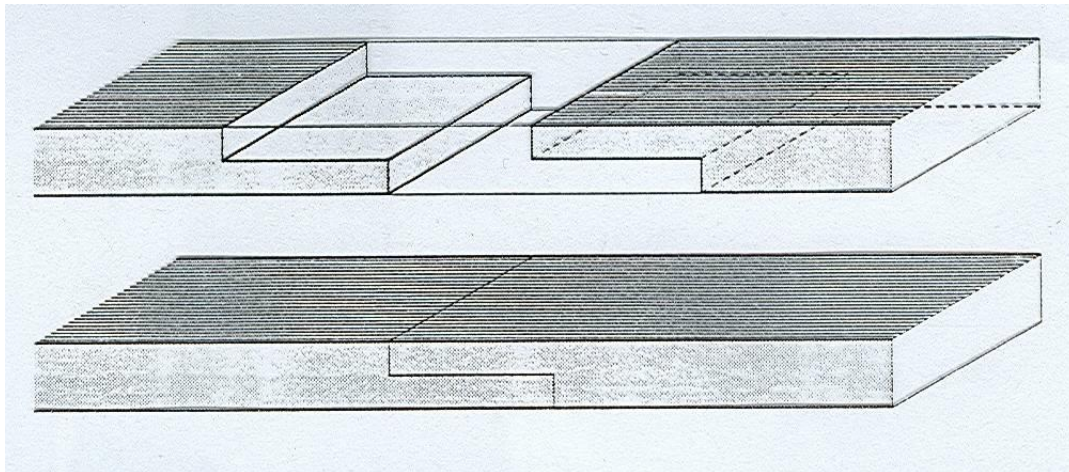
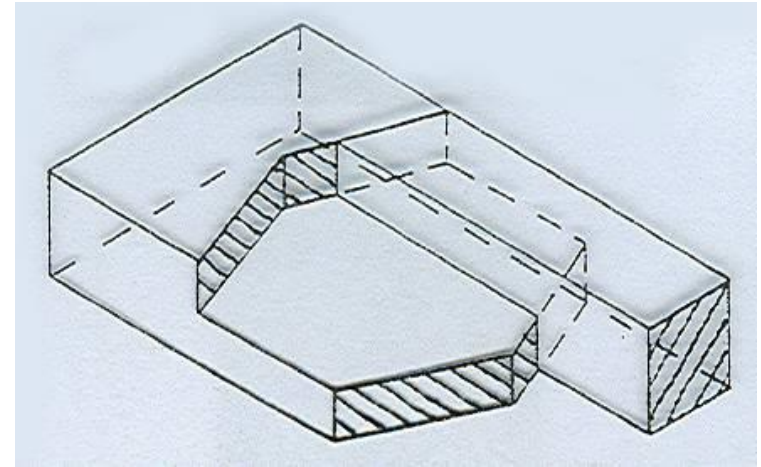
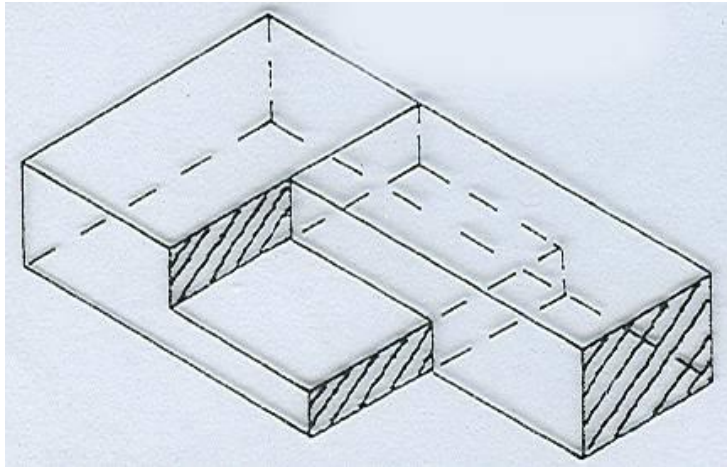
2 – zarovnaná v rovine dosky

3- dve časti, zarovnané v rovine dosky

3) Nastavovanie na dĺžku

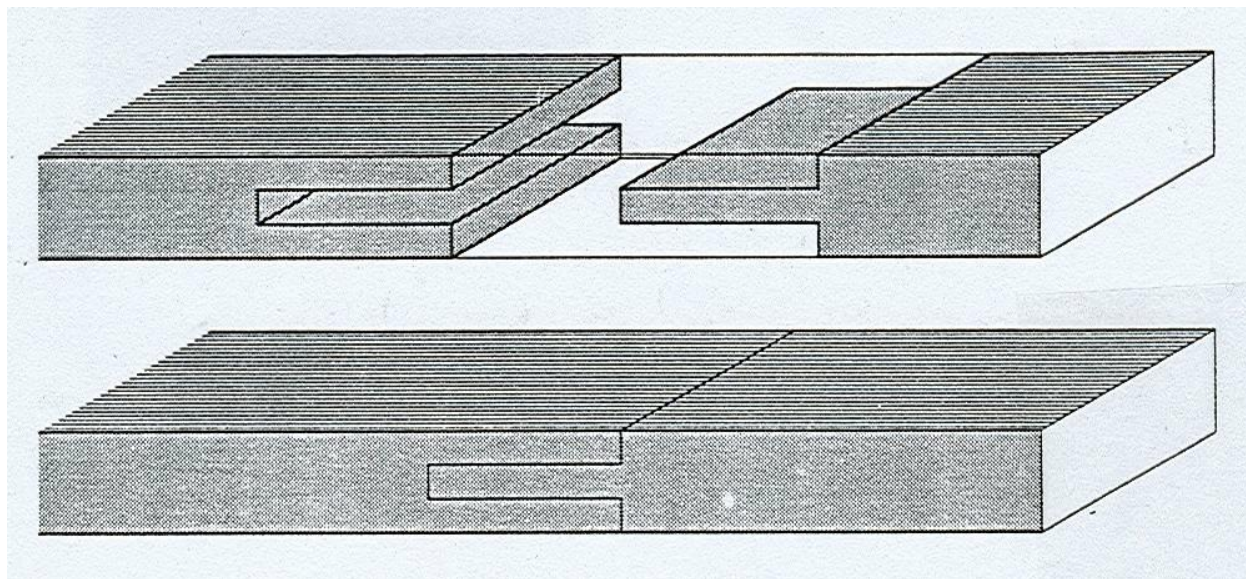


Zošikmenie (na úkos)

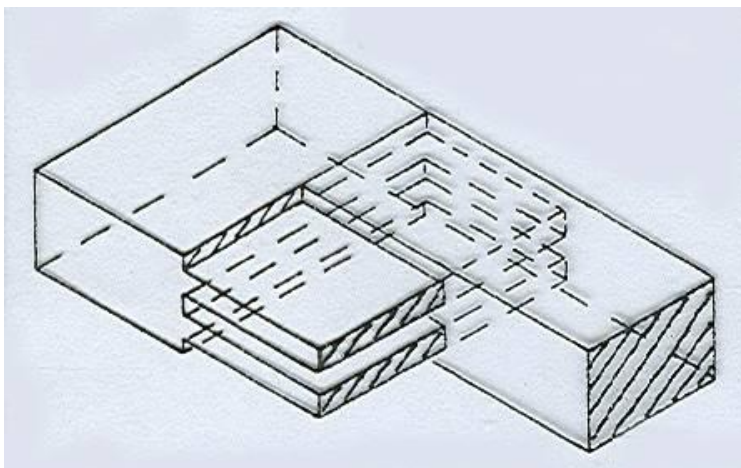


**Preplatovanie – so šikmou
prednou hranou**

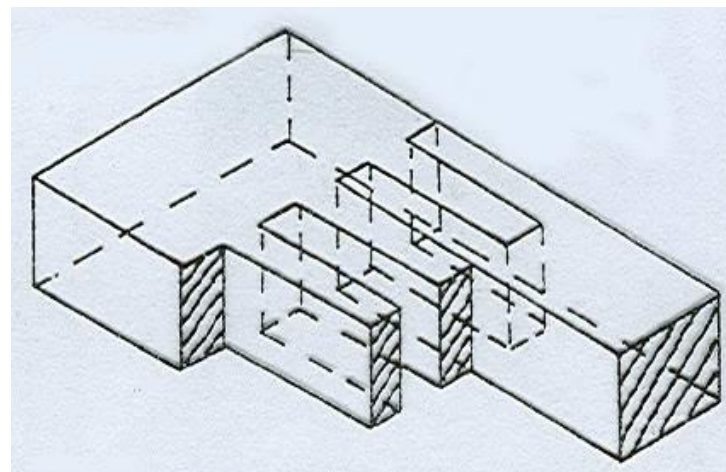
Preplatovanie - jednoduché



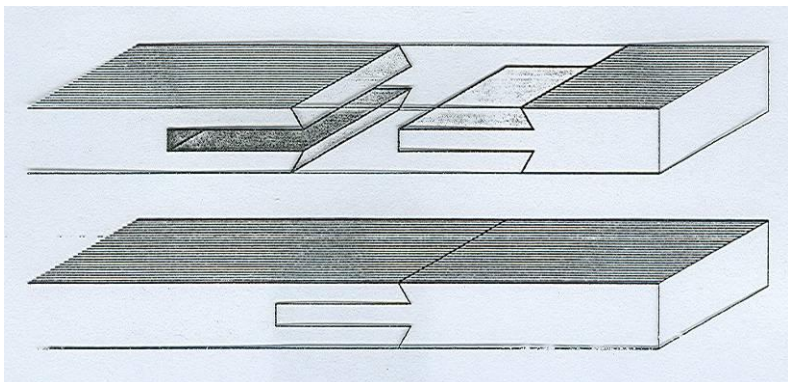
Jednoduchý čap



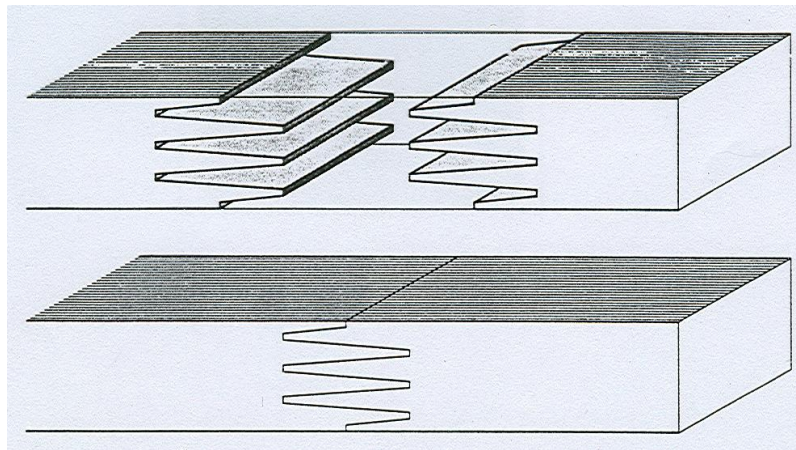
Dvojitý čap – po hrúbke



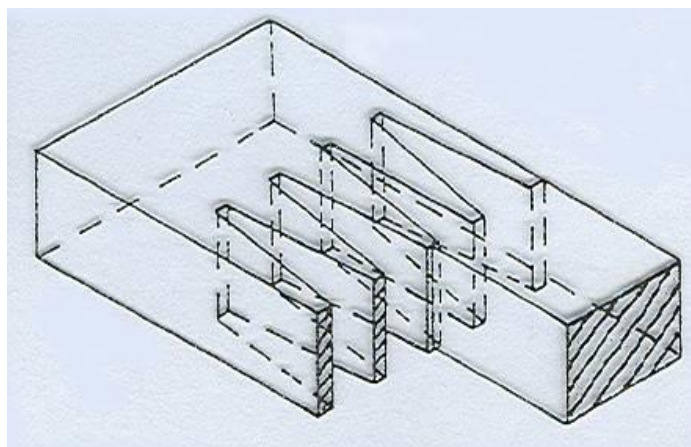
Viacnásobné čapy (rovné ozuby) - po šírke



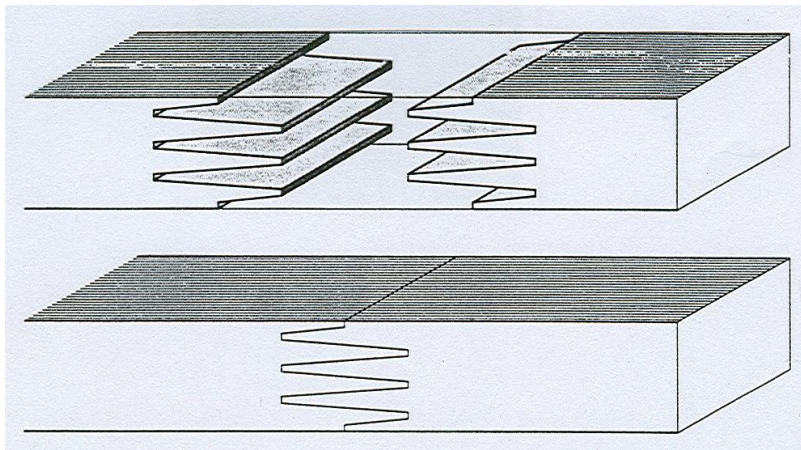
Jednoduchý čap – so skoseným osadením



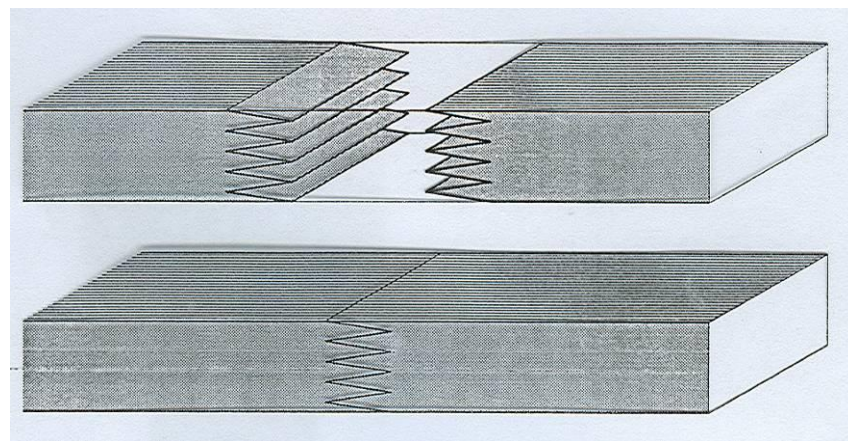
Klinové ozuby, zrezané – po hrúbke



Klinové ozuby, zrezané – po šírke



Klinové ozuby, ostré - velké



Klinové ozuby, ostré - středné

Účinnosť

- Na tupo – len 25 % účinnosť
- Na zošikmenie
 - 1:10 až 85 % účinnosť
 - 1:15 až 100 % účinnosť
 - nevýhoda – veľký odpad materiálu (až 10 %)
- Na klinové ozuby
 - vysoká účinnosť, 85 – 100 %
 - menší odpad