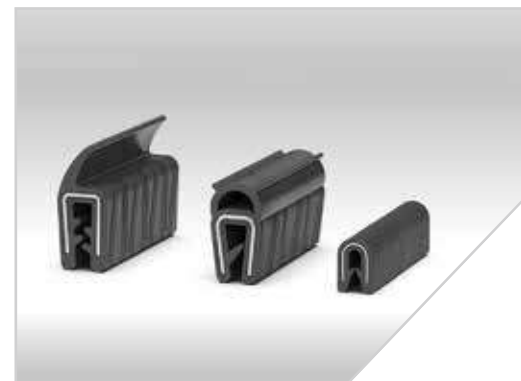




Ingenious Locking Technology for HVACR Systems according to VDI 6022

Product catalogue 2020



**GERMAN
INNO
VATION
AWARD '19
WINNER**





Inside the gasketing



Outside the gasketing



Concealed hinge



Prominent hinge



Lift-off version hinge



Hinge limited lift-off version



Hinge for single cabinets



Hinge for in-line cabinets with single door



Hinge for in-line cabinets with double door



Door RH version



Door LH-version



Door RH or LH version



IP-rating, such as IP 65



PUR-foamed seal



Compression specification of lock



With earthing or earthing possible



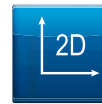
ELM Electronic Locking & Monitoring System application



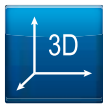
Resistance class 2 tested acc. to DIN EN 1630



2D nut in use



2D adjustable product



3D adjustable product



Assembly without tool



Clip-in assembling



Item with graffiti resistant paint



meets hygiene requirements acc. to DIN EN 1672-2



meets hygiene requirements acc. to DIN EN ISO 14159



Shock and vibration test according to DIN EN 61373



Plastic flame-resistant according to classification UL94



Stainless steel
AISI 303 resp. 1.4301
AISI 316 resp. 1.4305
AISI 304 resp. 1.4401
AISI 316 Ti resp. 1.4571

Meaning of the Icons

The icons on the catalogue pages show the special properties of the items presented there.

Info

1 Locks

Modular locking system	K1-100
Door locks	K1-210
Heavy duty latches	K1-310
Quarter turns	K1-410
Compression latches	K1-510
Accessories for latches	K1-610

2 Hinges

Latch-Hinges	K2-110
Screw-on hinges	K2-210
Accessories for hinges	K2-410

3 Gasketings

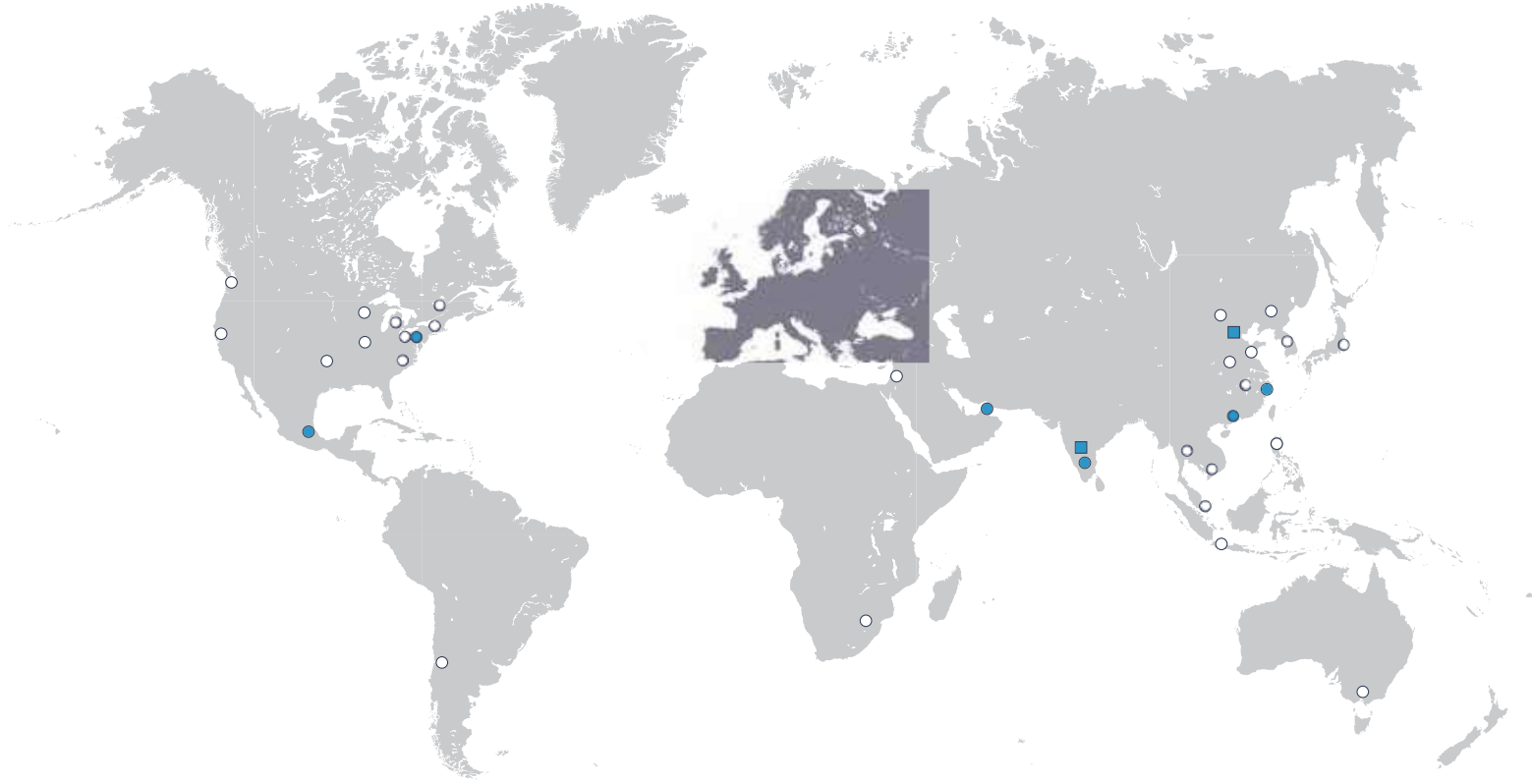
Information	K3-100
Gasketings self-gripping	K3-210
Gasketings secured in an U-section	K3-310
Cell sponge rubber	K3-410
Edge protection	K3-510
Examples	K3-610

4 Accessories

Connectors	K4-110
Recessed grips	K4-210
Bow-type handles	K4-310
Miscellaneous	K4-410

Article number index

List of contents



- Company headquarters
- Production site
- Subsidiary
- Agencies



EMKA worldwide

Production worldwide



Company headquarters Velbert, Germany



Wuppertal, Germany



Henriville, France



Arnedo, Spain



Birmingham, UK



Goražde (Plant 1), Bosnia and Herzegovina



Tianjin, China



Mionica, Serbia



Goražde (Plant 2),
Bosnia and Herzegovina



Bhilai, India

Global sales



Kittsee, Austria



Interlaken, Switzerland



Bourré, France



Veghel, Netherlands



Bedzin (Katowice), Poland



Pastrengo, Italy



Arnedo, Spain



Coventry, UK



Jönköping, Sweden



Sibiu, Romania



Middletown, USA



Çerkeşli-Dilovası (Kocaeli), Turkey



Bangalore, India



Tjanjin, China



Dubai, UAE

The EMKA GROUP is the world market leader for locking systems, hinges and gasketing that are used in switch and control cabinets. In the areas air conditioning technology and transport, EMKA is one of the leading manufacturers of locking technology.

Currently, the overall range comprises more than 15,000 articles, which are developed, manufactured, refined and assembled at ten production sites in Germany, France, Great Britain, Spain, Bosnia-Herzegovina, Serbia, China and India.

With 2,100 employees, the company is represented in 52 countries worldwide.

Locking Systems



Locks



Hinges

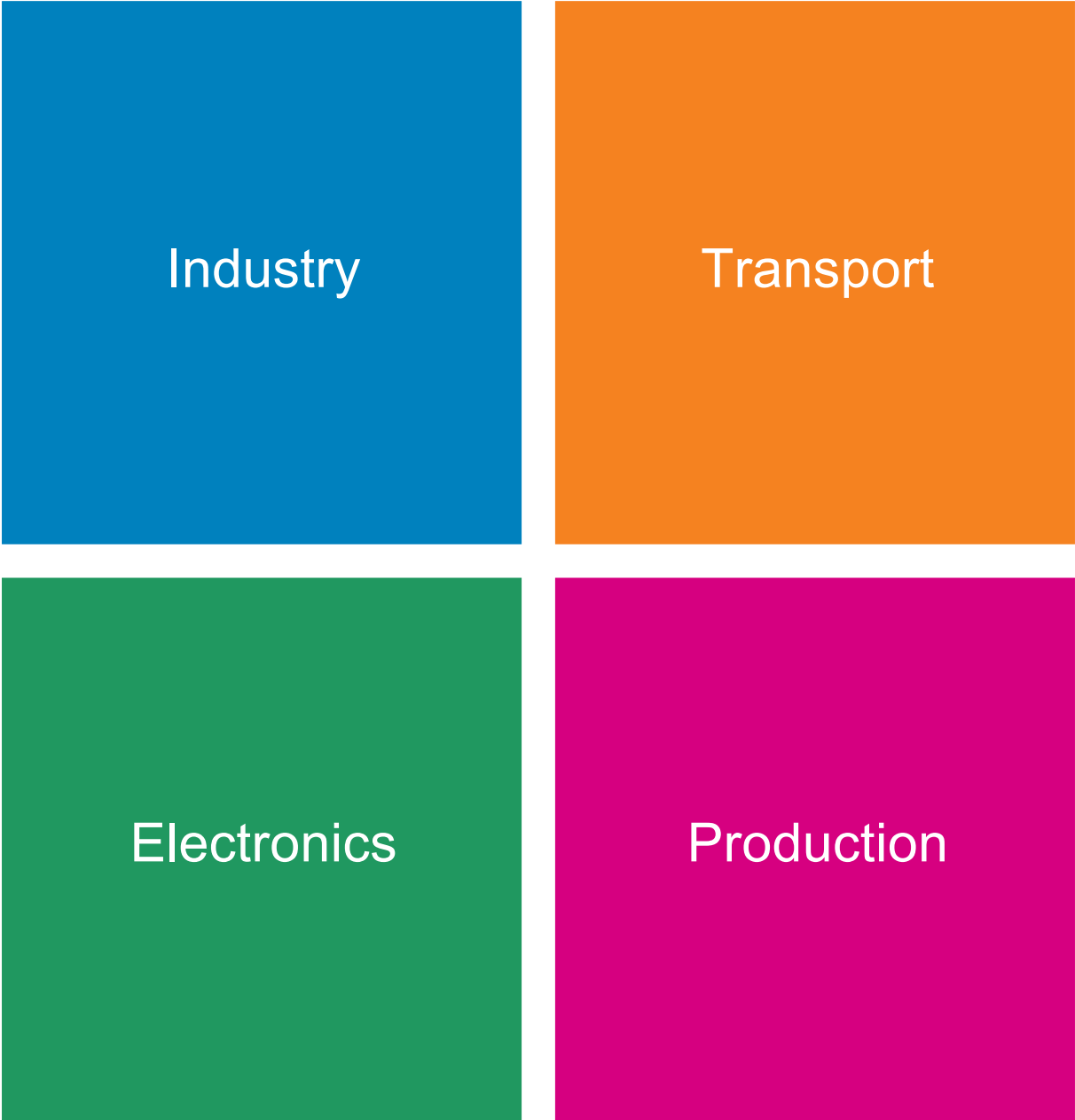


Gasketings

Product areas

EMKA offers a comprehensive product range of ingenious locking technology from a single source. The modular program structure allows a unique variety of components.

The high quality and product standards are guaranteed by an excellent manufacturing know-how and by the certified process control according to ISO 9001.



Industry

Transport

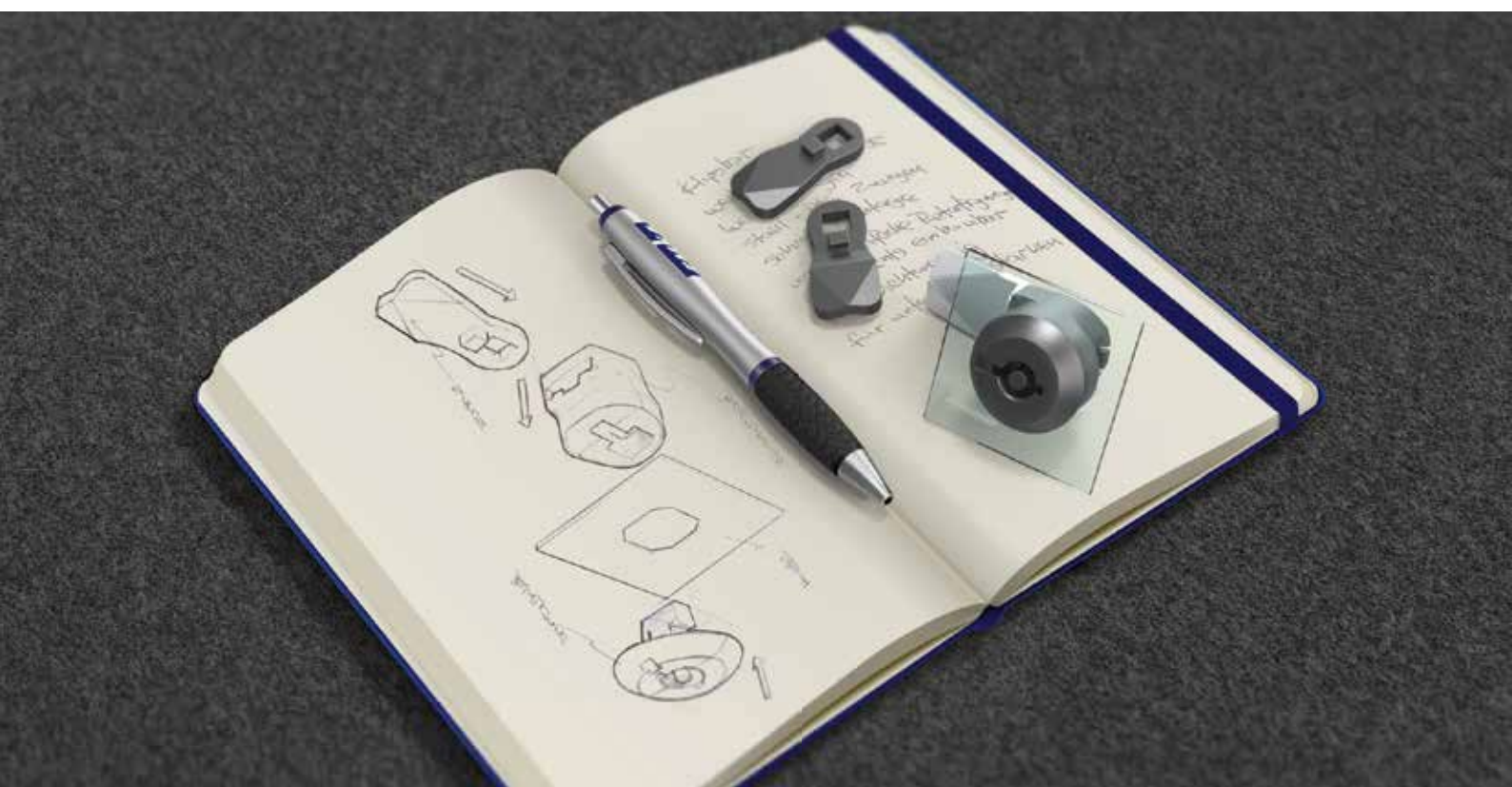
Electronics

Production

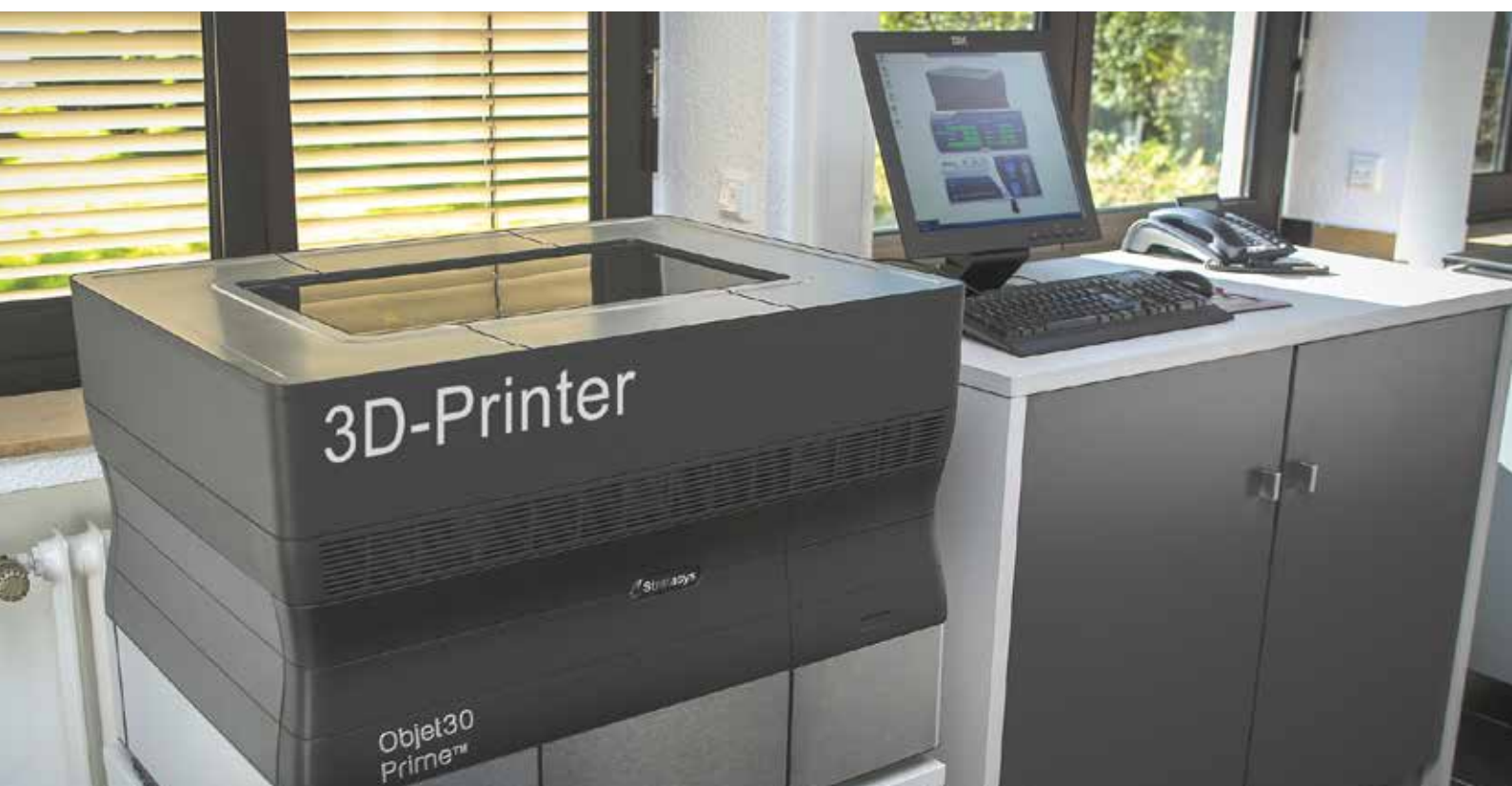
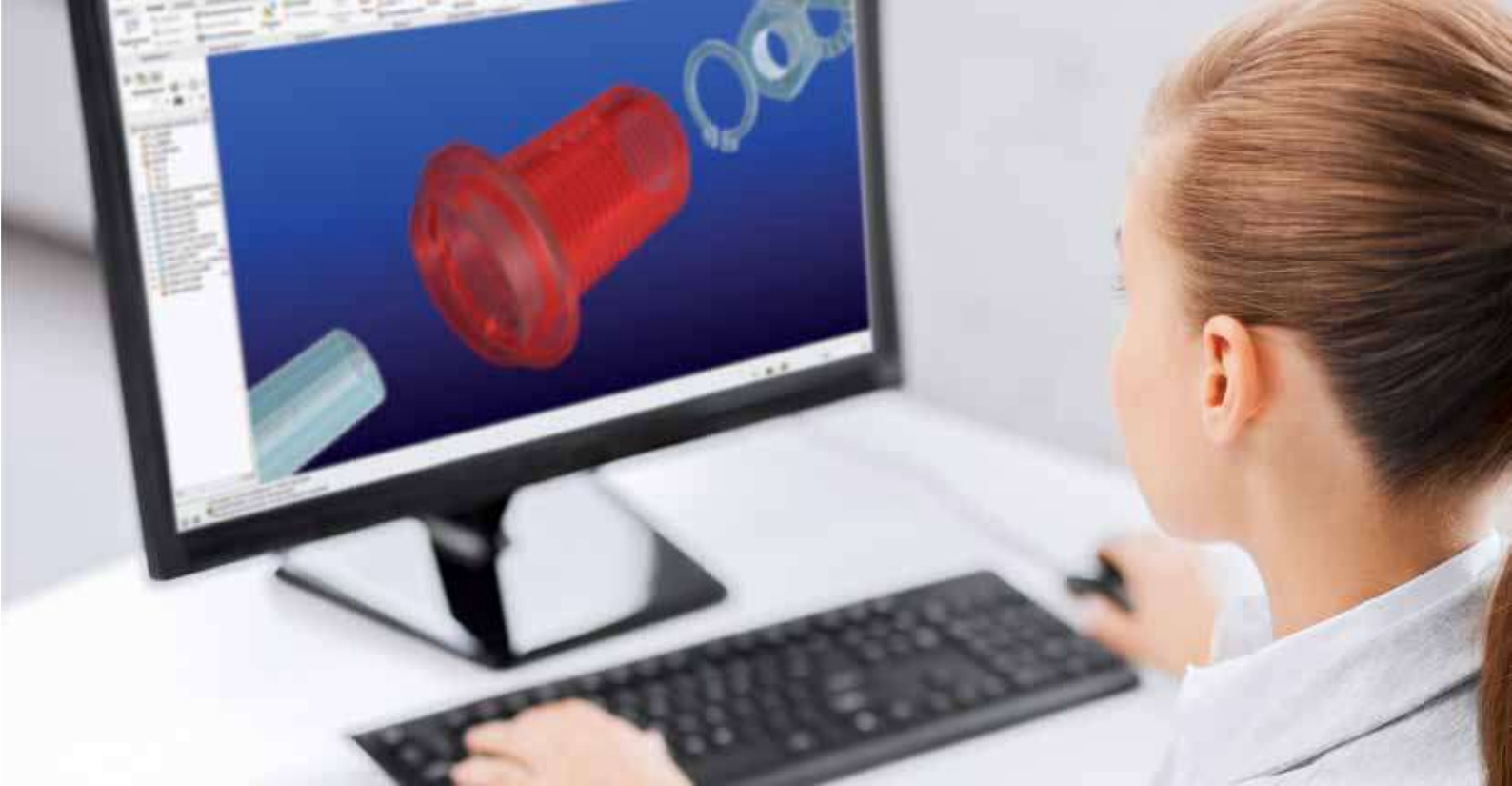
Business units

The EMKA group is divided into four business units which allow a clear focus on individual sectors and taylormade solutions for customers.

With its high level of in-house production, EMKA is in control of the entire production flow in every unit – from the concept to the finished product.



Close communication
with the customer
from the idea to the product



In the EMKA Technology Centre the innovative products of tomorrow are created. 30 designers and design engineers convert ideas into finished products in close collaboration with the customer. Quite a few of these products are incorporated into the EMKA main catalogue which is thus strongly focused on the current market and customer needs. To this day round 20,000 additional special parts have been created in this way that were tailor-made for special customer requirements by our specialists, intensely tested in our internal test lab and finally produced by EMKA.

State-of-the-art CAD systems and development methods such as finite elements method, rapid prototyping and 3D print are only some of the processes that are used in this context. A powerful project management software completes the range of services.

You have got an idea?

Together, let's make a product out of it!



Injection Moulding



Punching, bending
and metal working



Zinc die Casting



SST Precision Casting

Production from A to Z



PUR foam technology



Surface finishing



Extrusion of Profiles



Assembly of profiles

EMKA is an expert not only in stainless steel casting and in injection moulding of zinc and high performance plastics, but also in extruding rubber and plastic profiles.

Other production technologies are stamping, bending, turning, milling, coating, and the final assembly of modular product solutions.

Thus, EMKA sets quality standards in locking technology.

MANAGEMENT SYSTEM ZERTIFIKAT

Zertifikat-Nr.:
194710-2016-AQ-GER-DAKKS

Datum der Erstzertifizierung:
16. Februar 2013
Ablaufdatum des letzten
Zertifizierungszyklus:
15. Februar 2019
Datum der letzten Rezertifizierung:
24. Januar 2019

Gültig:
28. Februar 2019 - 15. Februar 2022

Hiermit wird bescheinigt, dass das Unternehmen

EMKA Beschlagteile GmbH & Co. KG

Langenberger Str. 32, 42551 Velbert, Deutschland
sowie die im Anhang aufgeführten Standorte

ein Qualitäts-Managementsystem in Übereinstimmung mit dem folgenden Standard
eingeführt hat und anwendet:

ISO 9001:2015

Dieses Zertifikat ist gültig für die folgenden Produkt- oder Dienstleistungsbereiche:

**Entwicklung, Herstellung und Vertrieb von mechanischen / elektronischen
Verschluss- Systemen; Scharnieren, Kunststoffspritz-, Automatendrehteilen
und Sonderanfertigungen. Management des Herstellungsprozesses von
Dichtungen und Druckgussteilen.**

Ort und Datum:
Essen, 28. Februar 2019



Zertifizierungsstelle:
DNV GL - Business Assurance
Schnieringhof 14, 45329 Essen, Germany



Thomas Beck
Thomas Beck
Leiter Zertifizierungsstelle

Bei Verstoß gegen die im Zertifizierungsvertrag genannten Bedingungen kann das Zertifikat seine Gültigkeit verlieren.
AKKREDITIERUNGSTELLE: DNV GL Business Assurance Zertifizierung und Umweltzertifikat GmbH, Schnieringhof 14, 45329 Essen, Germany.
TEL: +49 201 7296-222. www.dnvgl.de/assurance



Quality assurance

MANAGEMENT SYSTEM CERTIFICATE

Certificate No:
194710-2016-AQ-GER-DAKKS

Initial certification date:
16. February 2013
Expiry date of last certification cycle:
15. February 2019
Date of last re-certification:
24. January 2019

Valid:
28. February 2019 - 15. February 2022

This is to certify that the management system of

EMKA Beschlagteile GmbH & Co. KG

Langenberger Str. 32, 42551 Velbert, Germany
and the sites as mentioned in the appendix accompanying this certificate

has been found to conform to the Quality Management System standard:

ISO 9001:2015

This certificate is valid for the following scope:

Development, manufacturing and sales of mechanical / electronic locking systems; hinges, injection moulded parts, robot turned parts, specially manufactured products. Management of the production process of gaskets and die casting products.

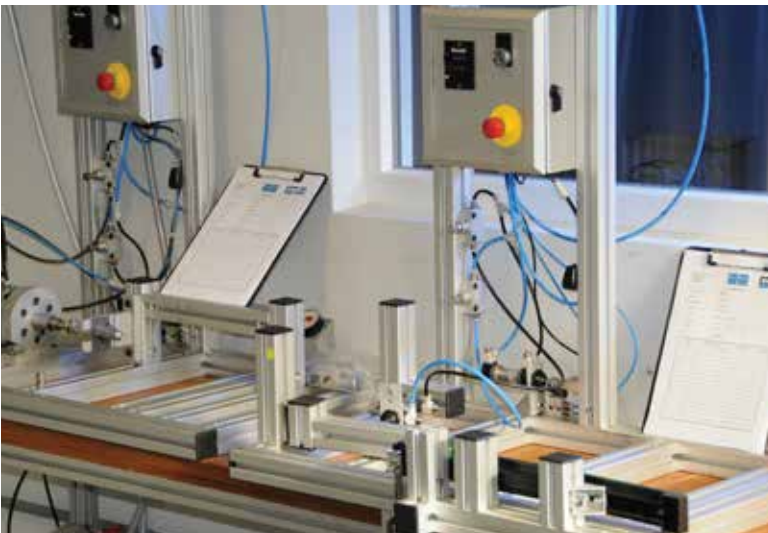
Place and date:
Essen, 28. February 2019



For the issuing office:
DNV GL - Business Assurance
Schnieringhof 14, 45329 Essen, Germany

Thomas Beck
Thomas Beck
Technical Manager

Lack of fulfillment of conditions as set out in the Certification Agreement may render this Certificate invalid.
ACCREDITED UNIT: DNV GL Business Assurance Zertifizierung und Umweltgutachter GmbH, Schnieringhof 14, 45329 Essen, Germany.
TEL: +49 201 7296-222. www.dnvgl.de/assurance



The high quality and product standards are guaranteed by an excellent manufacturing know-how and by the certified process control according to ISO 9001.

The in-house tool and mould making as well as state-of-the-art development, manufacturing and testing methods ensure a maximum of product quality and reliability.

Modular locking system

- New modular handle with an innovative design
- Suitable for doors opening inwards and outwards
- Suitable for various door thicknesses (25 - 110 mm)
- Fits 2 standard cut outs (13 mm, 19 mm)
- Variety of locking options (round cylinder, blind plug, square insert, further inserts on request)
- Roller Cam with adjustable clamping load
- Adjustable eccentric roller
- Removable handle during transport
- Meets the industry-specific national and international standards
- Conforms with the entire EMKA range
- Material: Polyamide with 30% glass filled (VDI 6022 / ISO 846 compliant materials)
- Air Tightness class L1-L3 possible
- Protected design



Surface mounted modular door lock with internal handle

- New modular locking system especially for use on large doors (>1.6 m door height)
- Various inserts and handle options in combination with different cams possible (stepped cam, pressure relief cam, etc.)
- System for various door thicknesses (50 mm - 60 mm)
- Also available as a version without inside handle
- VDI 6022 / ISO 846 compliant materials on the inside of the door

Compression Latch-Hinge large

- Especially suitable for use on large doors (>1.6 m door height)
- When the door is closed, the latch is adjustable (3 mm) to achieve perfect alignment
- The favourable pivot point of the handle makes a seal compression of 5 mm possible using low actuation forces
- Door or panel can be removed by unlatching the handles on both sides
- 3D adjustable (tolerance compensation)
- Latch hinge can be mounted as one piece with the door / flap in place
- Right or left hinged
- Hinge 180° opening angle
- Optional: HVACR Compression Latch-Hinge available with safety feature "pressure relief"
- VDI 6022 / ISO 846 compliant materials on the inside of the door
- ATEX compliant explosion protection version available on request
- Patent submitted



New products at a glance

Compression Latch-Hinge medium

- For door surfaces > 0.8 m²
- The favourable pivot point of the handle allows for low actuation forces a seal compression of 5 mm
- When the door is closed, the latch is adjustable (3 mm) to achieve perfect alignment
- Door or panel can be removed by unlatching the handles on both sides
- Hinge 180° opening angle
- 3D adjustable (tolerance compensation)
- Available with or without pressure relief
- ATEX compliant explosion protection version available on request
- Patent submitted



Compression Latch-Hinge small

- For door surfaces < 0.8 m²
- 40 % reduced size
→ significant price advantage
- The favourable pivot point of the handle allows for low actuation forces a seal compression of 5 mm
- Door or panel can be removed by unlatching the handles on both sides
- Hinge 180° opening angle
- 2D Adjustable (tolerance compensation)
- Available with or without pressure relief
- ATEX compliant explosion protection version available on request
- Patent submitted



3D-unit connector

- Spherical shaping allows 3D positioning with max.
X-axis 7 mm
Y-axis 3 mm
Z-axis 5 mm
- Fixing by M6 cylinder screws or riveted bolts possible
- Socket head screw inclusive
- Industry standard mounting dimensions
- Covering cap optionally available
- VDI 6022 / ISO 846 compliant materials



Window

- Quick assembly by snap-in joint without mounting screws
- Inspection window halves with undetachable foamed seals
- Viewing area Ø 176 mm
- Suitable for systems with positive or negative pressure
- Inspection windows are available for door thicknesses of 30-34, 40-44, 50-54 and 60-64 mm
- Optionally, for sandwich doors with soft filling material, a one-piece support ring with circumferentially foamed seals in the sizes 30, 40, 50 and 60 mm can be ordered. This also serves as a visual barrier and allows a secure seal between insulating material and inspection window.
- Impact resistant, UV stabilized polycarbonate; approved according to VDI 6022



Bow-type handle

- Ergonomic bow-type handle made of reinforced polyamide
- Mounting of the bow-type handle by choice. The use of cylinder head screw, hexagon head screw, counter-sunk screw or nuts can be accommodated, depending on the version
- Handle and cover are available in color and / or antibacterial version (on request)
- Bow-type handle can also be used without cover
- Protected design



Clip-on profile according to hygiene standard VDI 6022

- Higher functionality when sealed with sponge rubber in the hose area
- Gasket does not provide any breeding ground for micro-organisms
- They can be cleaned easily
- Moisture repellent
- Odorless



EMKA does not only provide every kind of gasket but also locking systems and hinges, i. e. complete HVACR locking solutions from one single source!

It stands out due to its modular structure, versatility and high quality. The EMKA locking solutions comply with the special requirements of the sector and meet the relevant standards. In addition, EMKA provides individual special solutions that arise in dialogue with the customer.

As a long-time system partner of the HVACR industry EMKA is constantly working on new and innovative products.

In addition to newly developed and enhanced locking solutions, EMKA complements its product portfolio with innovative locking systems, special hinges, gasketings and special solutions, thus responds to the current requirements of the market.

EMKA already has the trends that will become the standard tomorrow!



1 Locks

Modular locking system
Door locks
Heavy duty latches
Quarter turns
Compression latches
Accessories for latches

K1-100
K1-210
K1-310
K1-410
K1-510
K1-610



2 Hinges



3 Gasketings



4 Accessories



For doors opening inwards (In-Swing)

For doors opening outwards (Out-Swing)

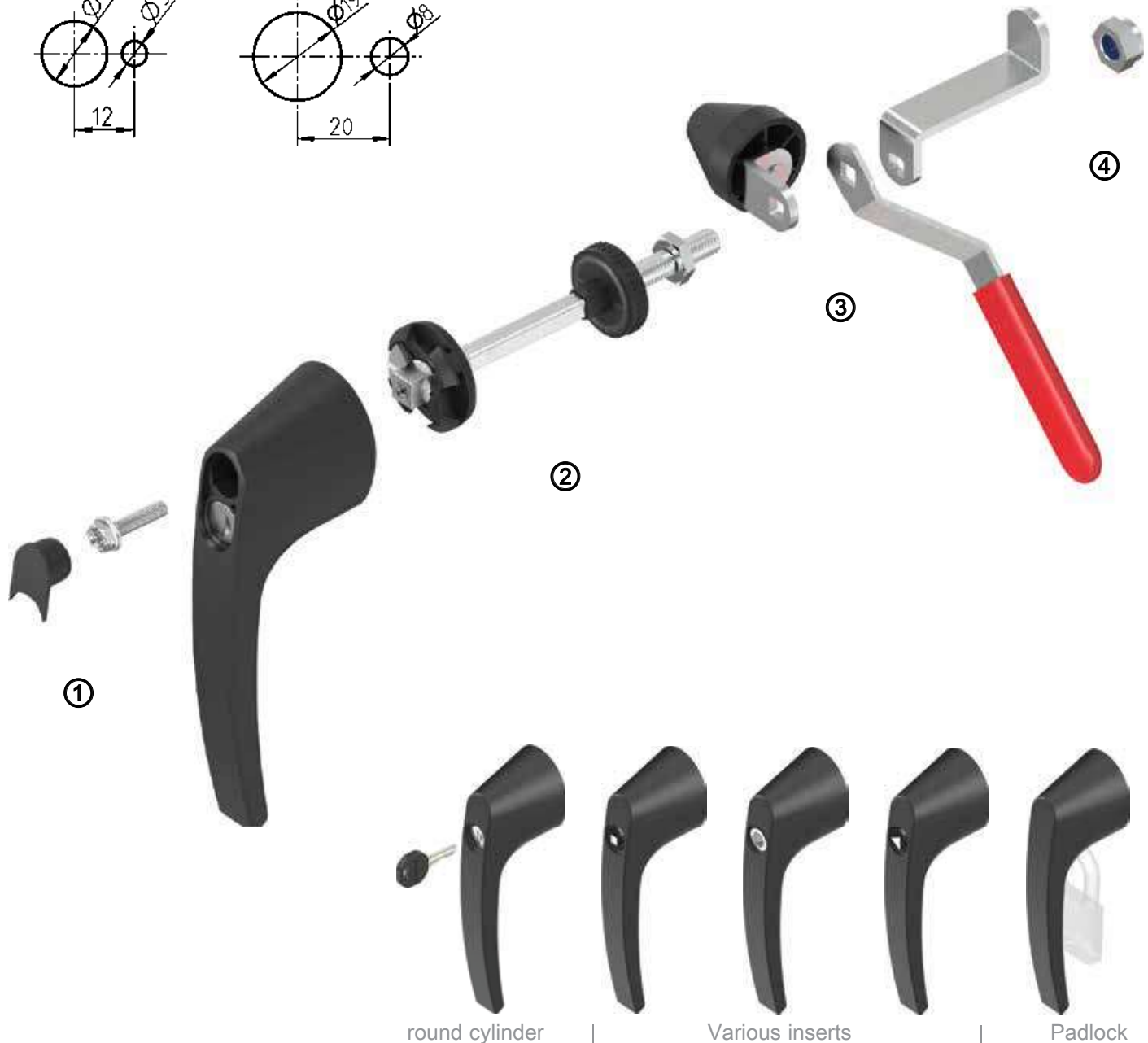
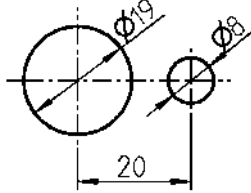
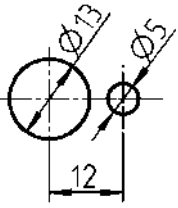
Product benefits

- New modular handle with an innovative design
- Suitable for doors opening inwards and outwards
- Suitable for various door thicknesses (25 - 110 mm)
- **Fits 2 standard cut outs (13 mm, 19 mm)**
- Variety of locking options (round cylinder, blind plug, square insert, further inserts on request)
- Roller Cam with Adjustable Clamping Load
- Adjustable eccentric roller
- **Removable handle during transport**
- Meets the industry-specific national and international standards
- Conforms with the entire EMKA range
- Material: Polyamide with 30% glass filled
- Air Tightness class L1-L3 possible
- Protected design

Cut out E1

or

Cut out E2



① Sleak ergonomic lines shape the design of the new EMKA HVACR handle. The handle system makes simple and quick mounting of all components possible. Suitable for doors opening inwards and outwards. Variety of locking options (round cylinder, blind plug, square insert, further inserts on request)

② The inside mechanism is the heart of the new locking system of EMKA as it connects the outside handle with the inside components. This set-up of the lock has been specially developed for use in panel and sandwich doors used in HVACR installations. The handles are available in a variety of locking options.

③ Roller cam with adjustable clamping load can be mounted quickly and easily to ensure the desired compression. In addition, EMKA offers the possibility of multi-point latching.

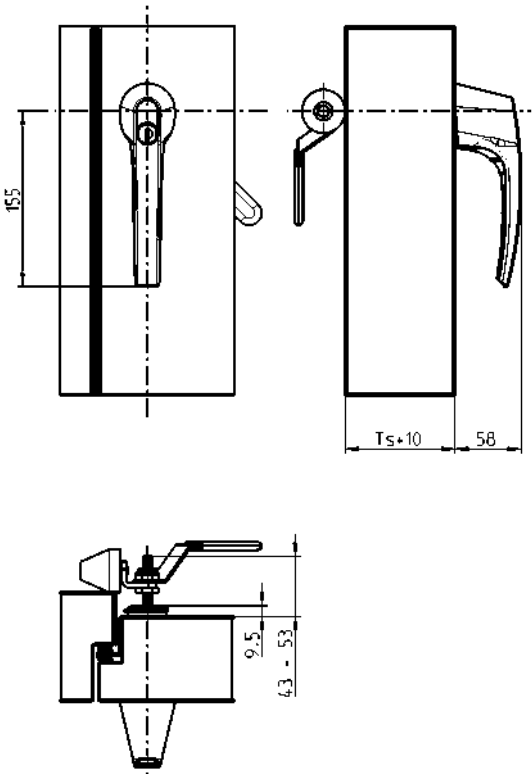
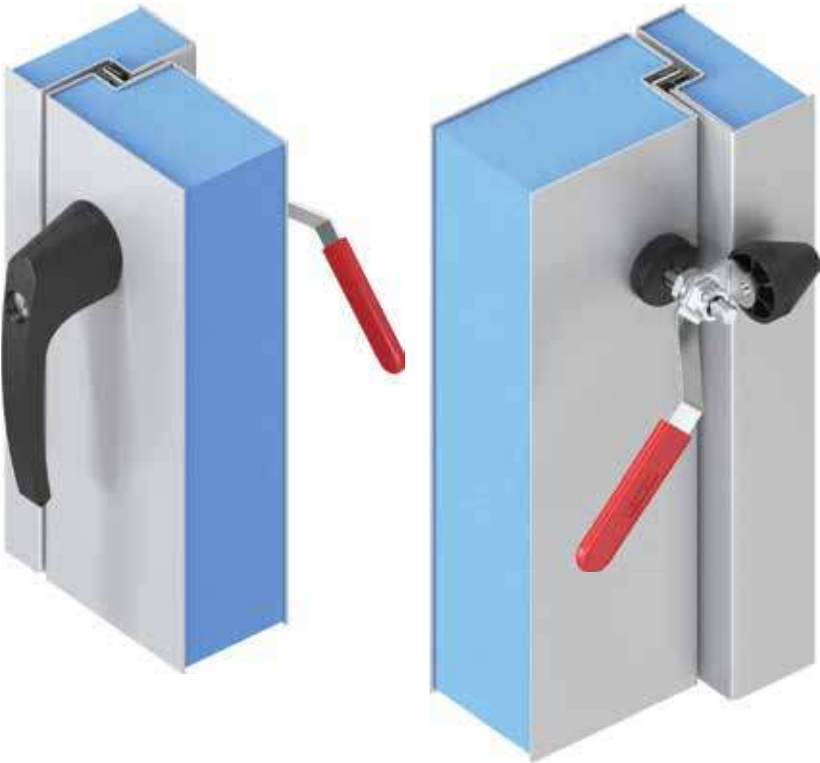
④ EMKA offers a variety of optional components such as inside unlocking and the two-step opening system important for over-pressure installations. The comprehensive choice of hinges and gaskets completes the range.

Overview (Out-Swing)

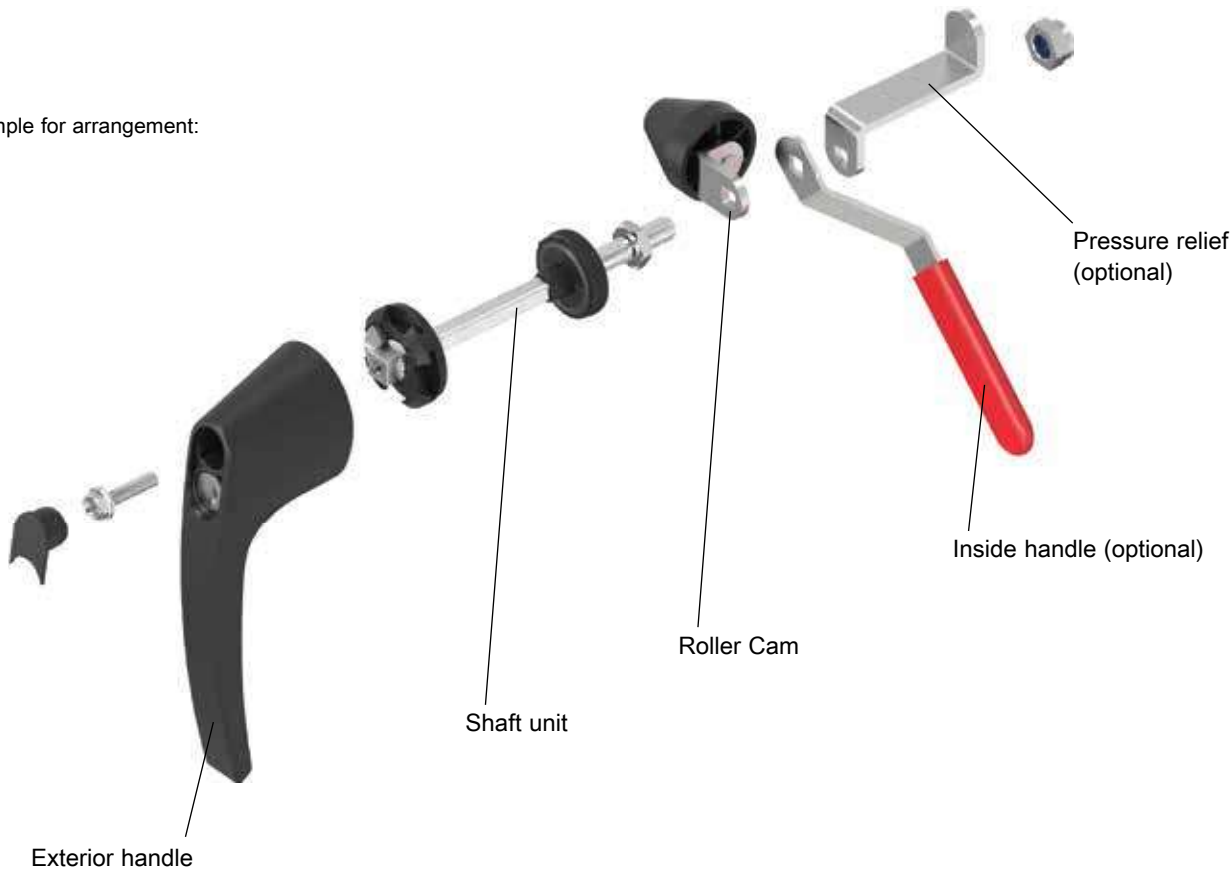
PROGRAM 1091



For doors opening outwards (Out-Swing)



Example for arrangement:

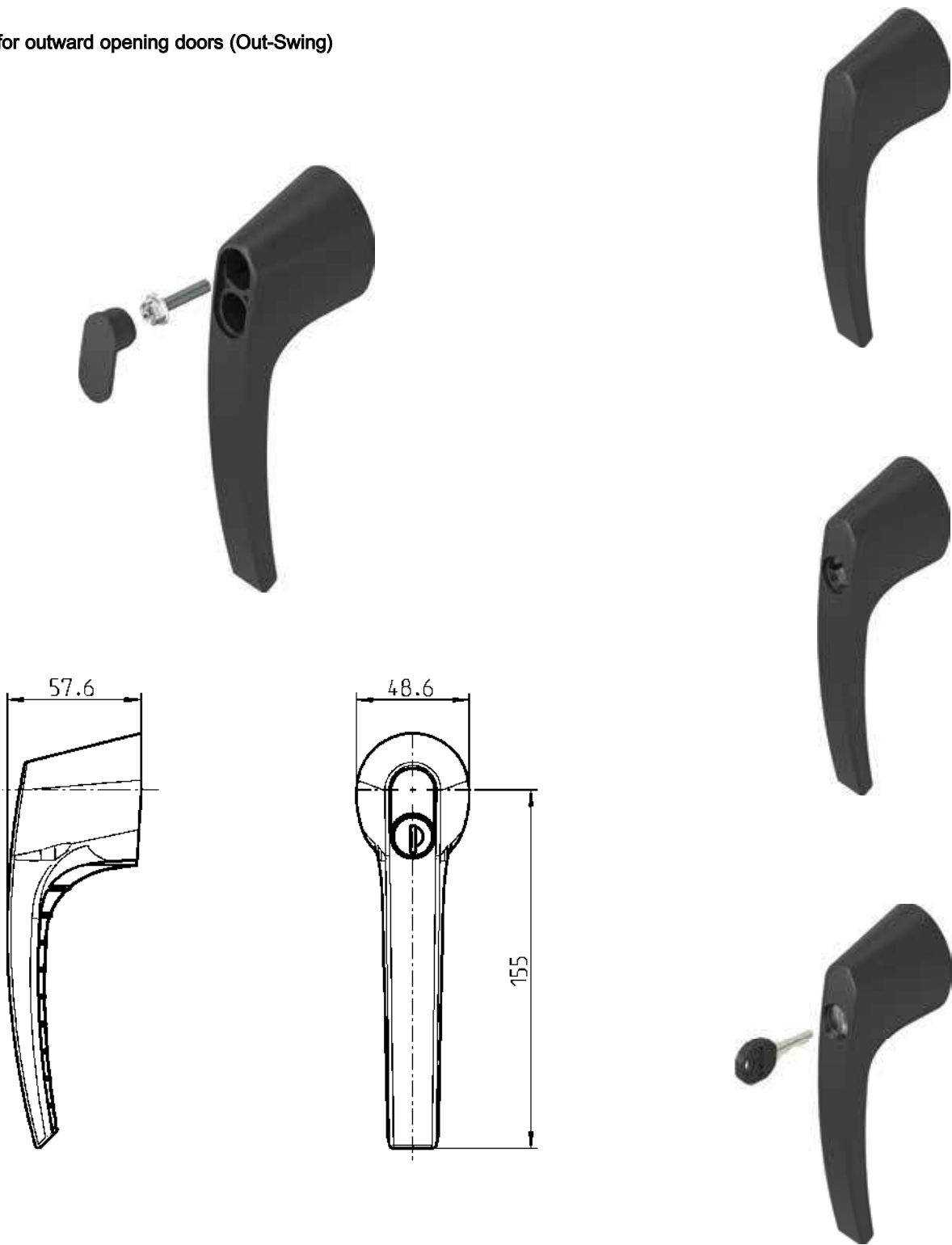


Exterior handle (Out-Swing)

PROGRAM 1091



External handle for outward opening doors (Out-Swing)



Handle polyamide GF black; locking cam AISI 316; cover cap polyethylene black; Insert zinc die chrome plated; spacer ring brass, with o-ring; round cylinder zinc die with stainless steel cap and dust cap; screws m.s. zinc-plated; Each round cylinder has one nickel silver key with polyamide grip GF black	
non locking	1091-U159
Double bit 5	1091-U160
Keyed EK 333	1091-U161
Keyed different	on request

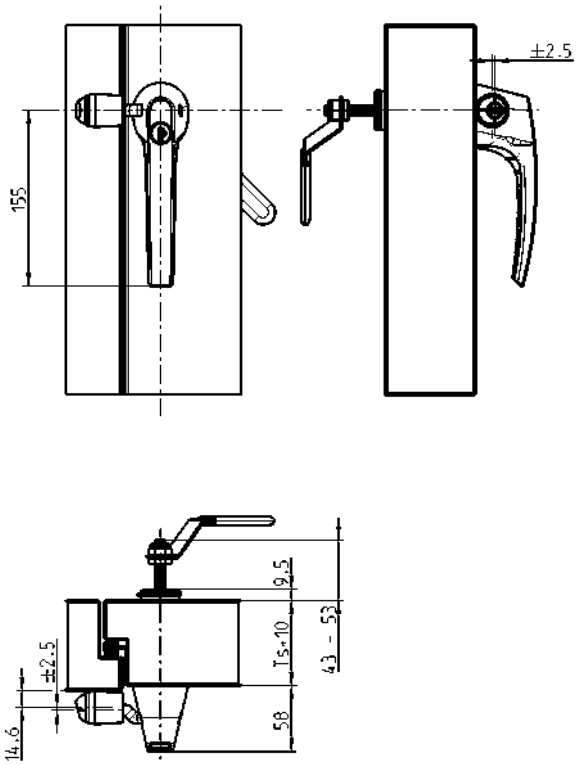
Further parts see page	
– Overview	K1-110
– Shaft unit	K1-150
– Roller Cam	K1-160
– Interior handle	K1-170
– Pressure relief	K1-170
– Rod control	K1-180

Overview (In-Swing)

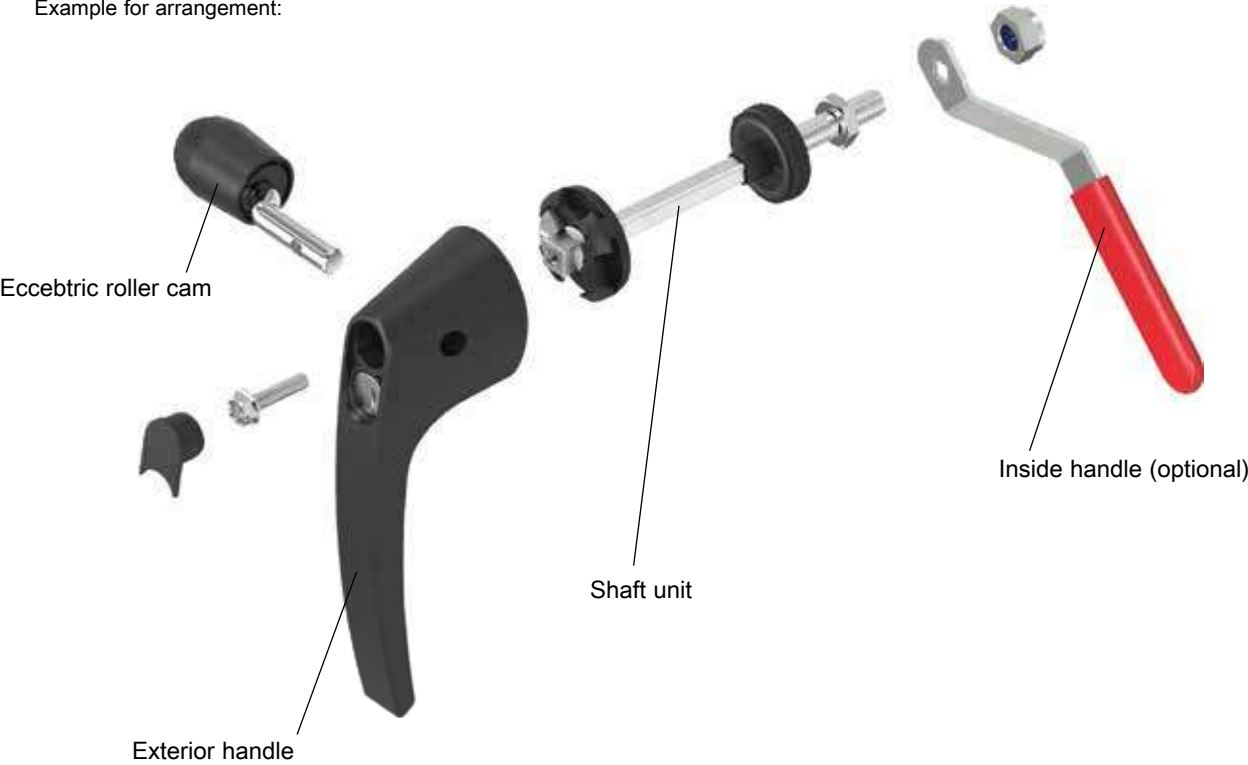
PROGRAM 1091



For doors opening inwards (In-Swing)



Example for arrangement:

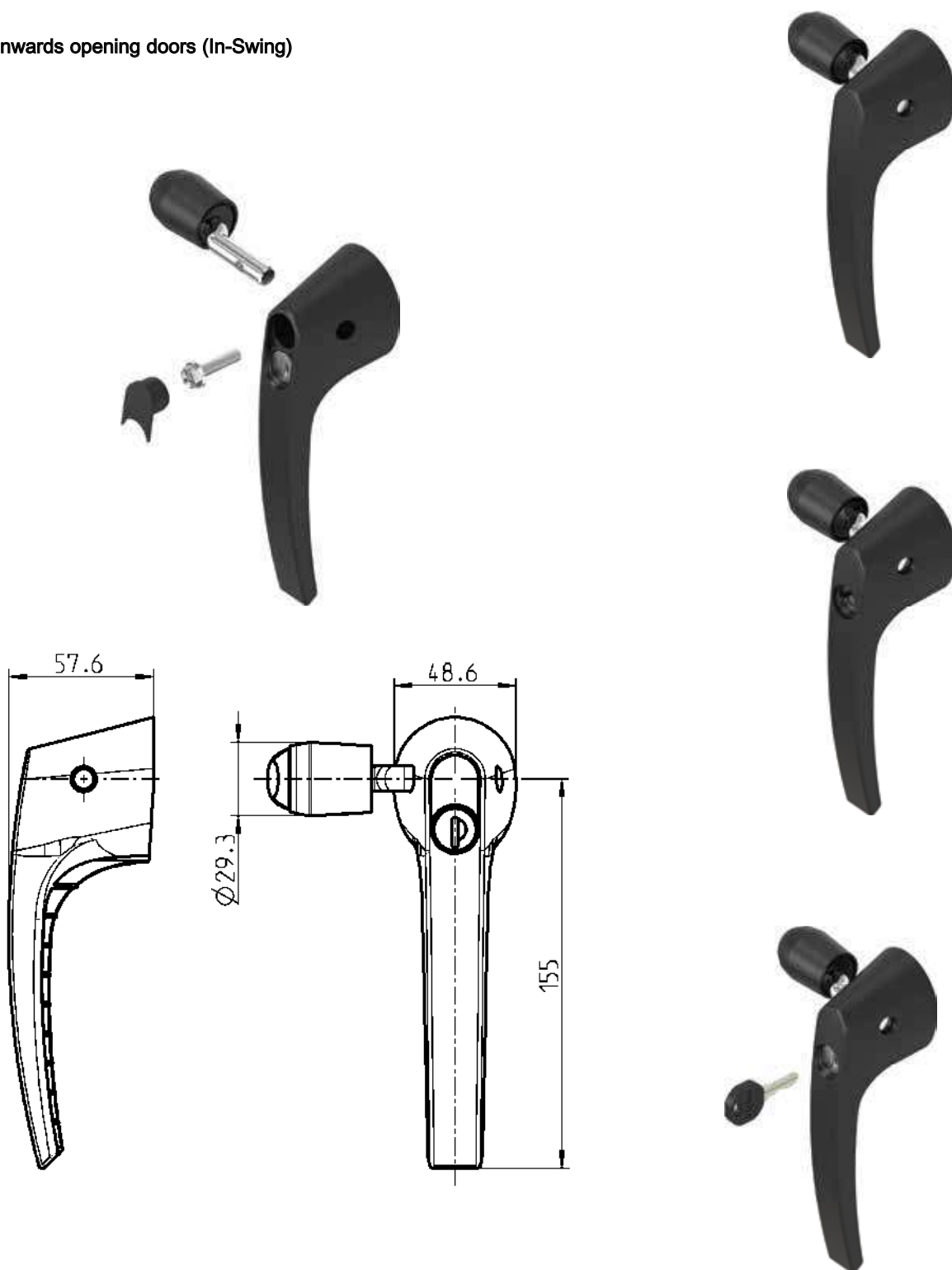


Exterior handle (In-Swing)

PROGRAM 1091



External handle for inwards opening doors (In-Swing)



Handle polyamide GF black; locking cam AISI 316; cover cap polyethylene black;
Insert zinc die chrome plated; spacer ring brass, with o-ring;
round cylinder zinc die with stainless steel cap and dust cap; screws m.s. zinc-plated;
Each round cylinder has one nickel silver key with polyamide grip GF black;
Eccentric roller cam: roll POM black; eccentric polyamide GF black; Shaft m.s. zinc plated

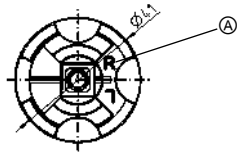
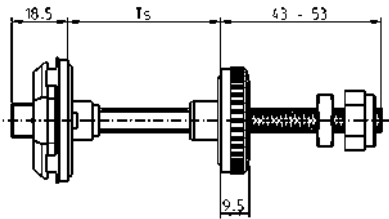
non locking	1091-U163
Double bit 5	1091-U164
Keyed EK 333	1091-U165
Keyed different	on request

Further parts see page

– Overview	K1-130
– Shaft unit	K1-150
– Interior handle	K1-170

Shaft unit E1 and E2

PROGRAM 1091

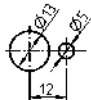


A The readability of the letter (R / L) indicates the orientation of the axis to the door stop.

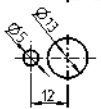
Cut out (inside)



Cut out front for right hand version



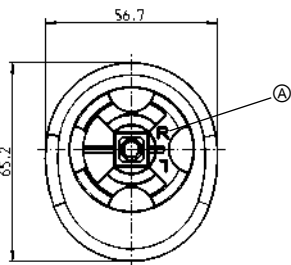
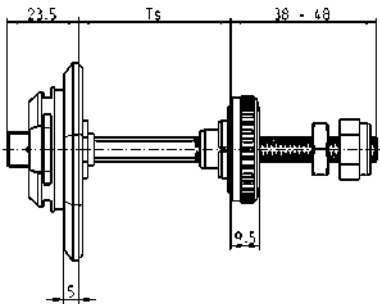
Cut out front for left hand version



Bezel inside self catching

Shaft unit E1, small cut out:
Mild steel shaft with 90° stop zinc die in assembly zinc plated;
bezel outside zinc die black powder coated;
bezel inside polyamide GF black;
nut and counter nut m.s. zinc plated, with seal

Ts = 25 up to 35 mm	1091-U158-25
Ts = 50 up to 60 mm	1091-U158-50
Ts = 75 up to 85 mm	1091-U158-75
Ts = 100 up to 110 mm	1091-U158-100

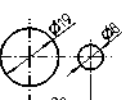


A The readability of the letter (R / L) indicates the orientation of the axis to the door stop.

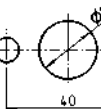
Cut out (inside)



Cut out front for right hand and left hand version



Cut out front alternative



Bezel inside self catching

Shaft unit E2, large cut out:
Mild steel shaft with 90° stop zinc die in assembly zinc plated;
bezel outside zinc die black powder coated;
bezel inside polyamide GF black with foamed seal;
nut and counter nut m.s. zinc plated, with seal

Ts = 25 up to 35 mm	1091-U215-25
Ts = 50 up to 60 mm	1091-U215-50
Ts = 75 up to 85 mm	1091-U215-75
Ts = 100 up to 110 mm	1091-U215-100

Further parts see page

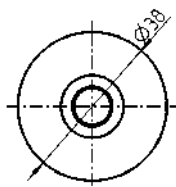
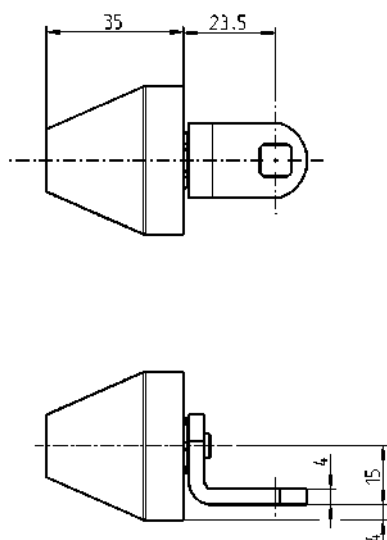
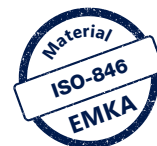
– Overview	K1-110
	K1-130
– Exterior handle	K1-120
	K1-140
– Roller Cam	K1-160
– Interior handle	K1-170
– Pressure relief	K1-170
– Rod control	K1-180

Conical roller cam for inside the door

PROGRAM 1000



Conical roller cam big for inside the door

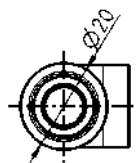
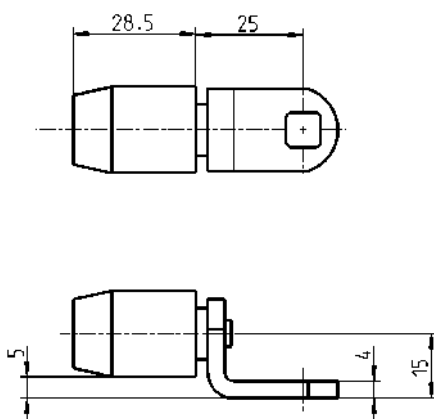
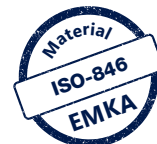


Roller polyamide GF black;
cam and shaft m.s. zinc plated

1000-U897



Conical roller cam small for inside the door



Roller polyamide GF black;
cam and shaft m.s. zinc plated

1000-U898

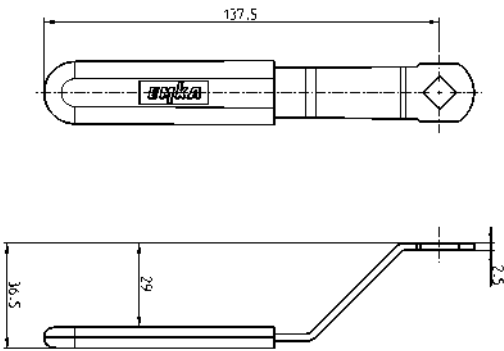
Further parts see page

- Overview K1-110
- Exterior handle K1-120
- Shaft unit K1-150
- Interior handle K1-170
- Pressure relief K1-170
- Rod control K1-180

Interior handle;
Pressure relief
PROGRAM 1091



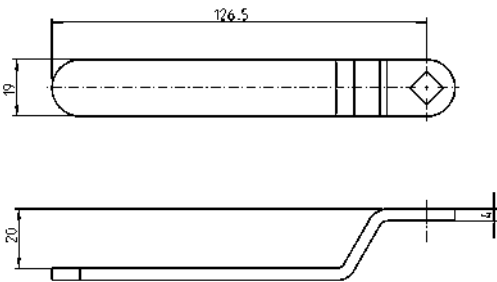
Interior handle



Interior handle m.s. zinc plated; end stay polyamide GF red	
	1091-133



Interior handle

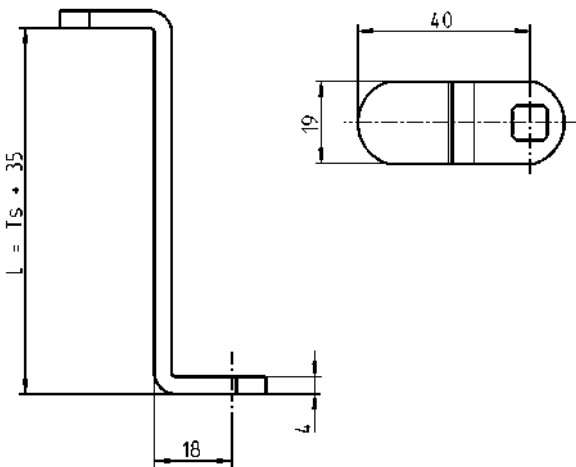


Interior handle m.s. zinc plated	
	1000-617-20

Other dimensions on request



Pressure relief



Pressure relief m.s. zinc-plated	
L = 60 mm	1000-579-01
L = 85 mm	1000-579-02
L = 110 mm	1000-579-03
L = 135 mm	1000-579-04

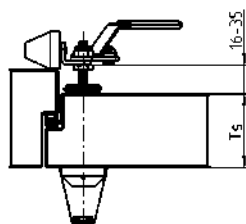
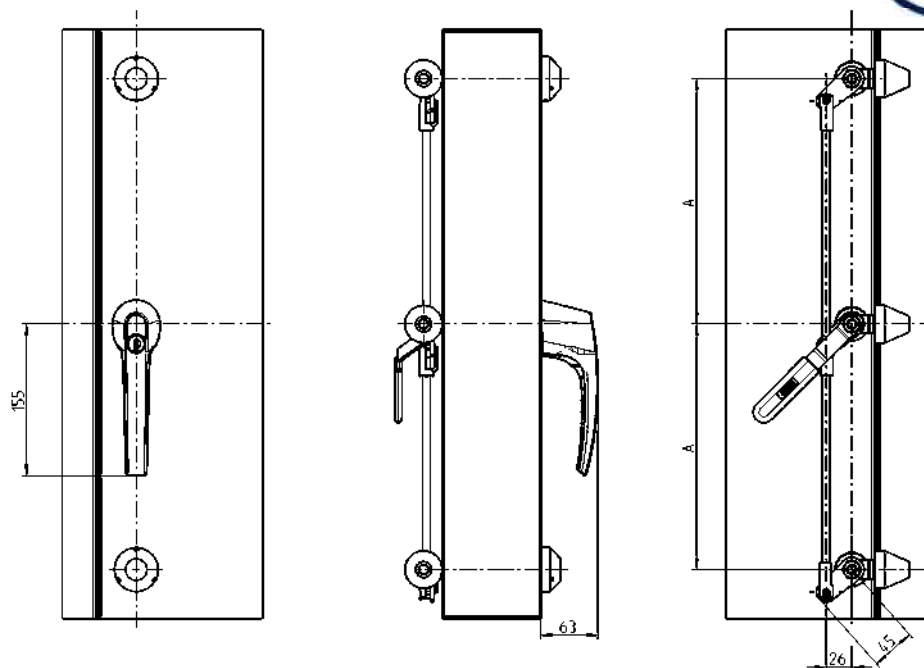
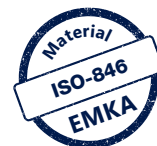
Further parts see page

– Overview	K1-110
	K1-130
– Exterior handle	K1-120
	K1-140
– Shaft unit	K1-150
– Roller Cam	K1-160
– Rod control	K1-180

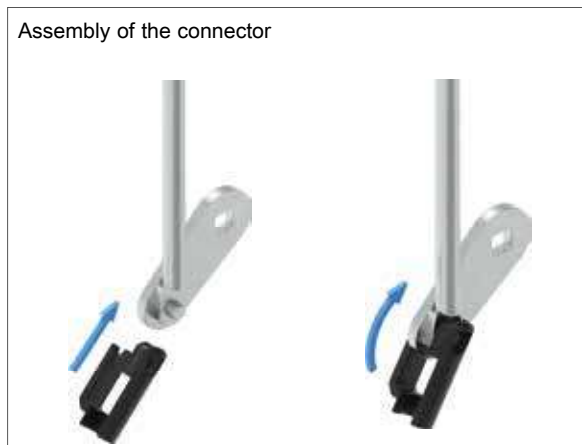
Rod control; Cover clip-in PROGRAM 1091



Rod control for multiple interlocking



Assembly of the connector



1x Rod control m.s. zinc plated; 1x connercor polyamide GF black

on request

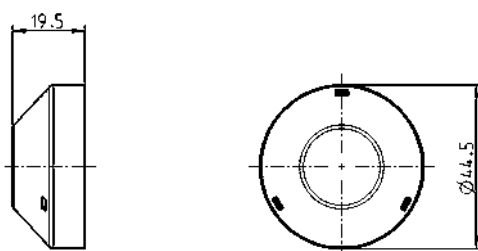
Rod control m.s. zinc-plated

Dimension A by choice of costumer

on request



Cover clip-in for the inactive shaft units of the multi-point-locking



Cover clip-in polyamide GF black

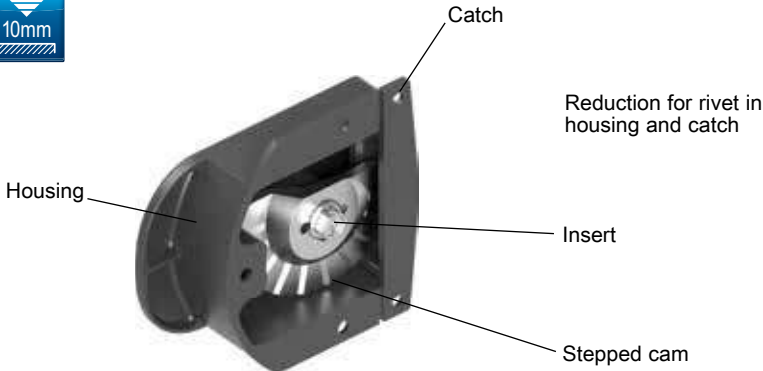
on request

Further parts see page

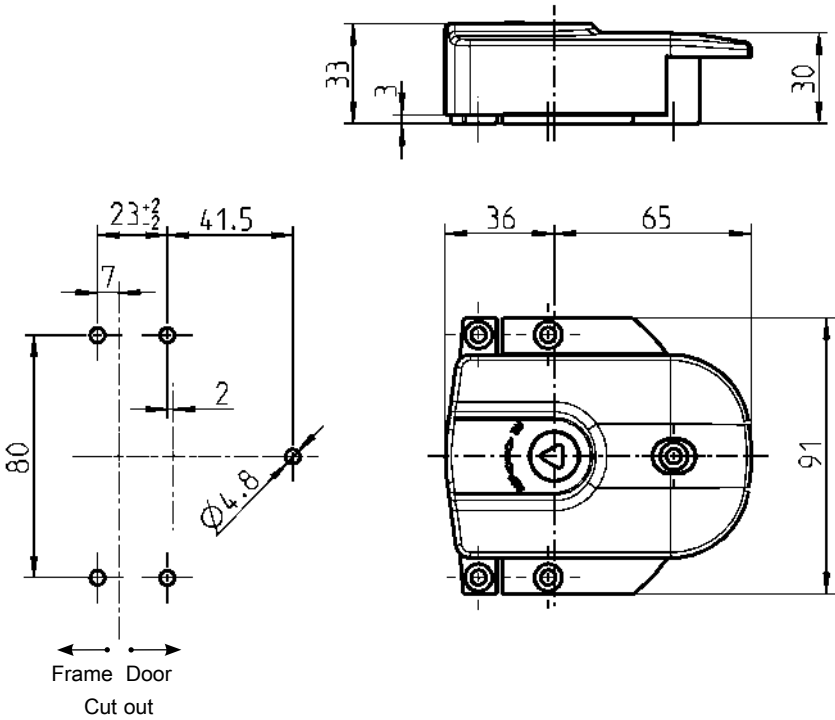
- Overview K1-110
- Exterior handle K1-120
- Shaft unit K1-150
- Roller Cam K1-160
- Interior handle K1-170
- Pressure relief K1-170

Surface mounted door lock

PROGRAM 1000

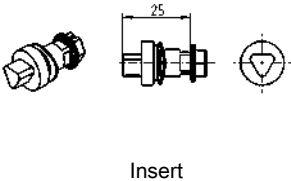


Catch



Surface mounted door lock black powder coated zinc die; stepped cam zinc die raw	
without insert	1000-U779
Surface mounted door lock polyamide 66 GF 50 black; stepped cam zinc die raw	
without insert	1000-U957
Catch zinc die black powder coated	
	1000-488

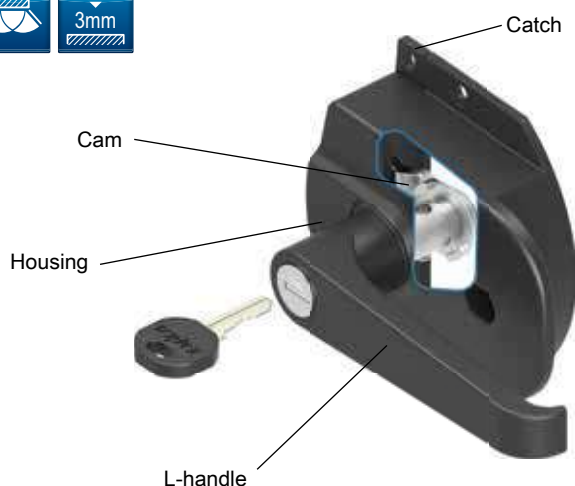
Insert zinc die surfaces on choice; fixing material m.s. zinc plated	Zinc die chrome plated	Zinc die black powder coated
Square 6	1000-U17	1000-U322
Square 7	1000-U1	1000-U323
Square 8	1000-U2	1000-U324
Triangular 7	1000-U3	1000-U325
Triangular 8	1000-U4	1000-U326
Double bit 3	1000-U5	1000-U327
Double bit 5	1000-U6	1000-U328
Hexagon female 10mm	1000-U96	–
Slot 2 x 4	1000-U142	1000-U329
Slot 2 x 4 coinproof	1000-U738	1000-U739



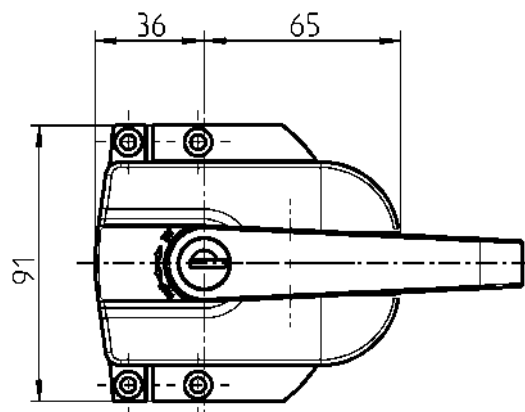
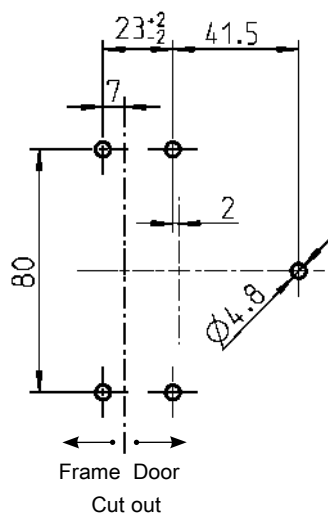
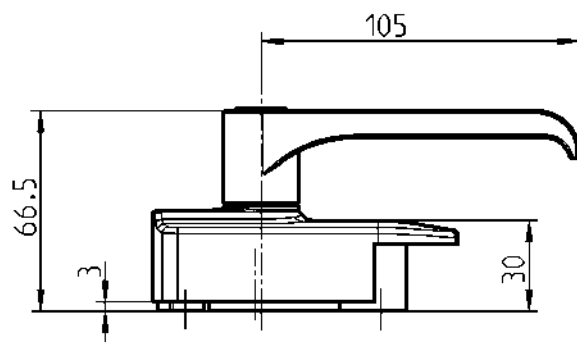
Attention:
Insert not included
Catch to be ordered separately
Housing and catch with long slots on request!
Further parts see page – Key

Surface mounted door lock

PROGRAM 1000



Reduction for rivet in housing and catch



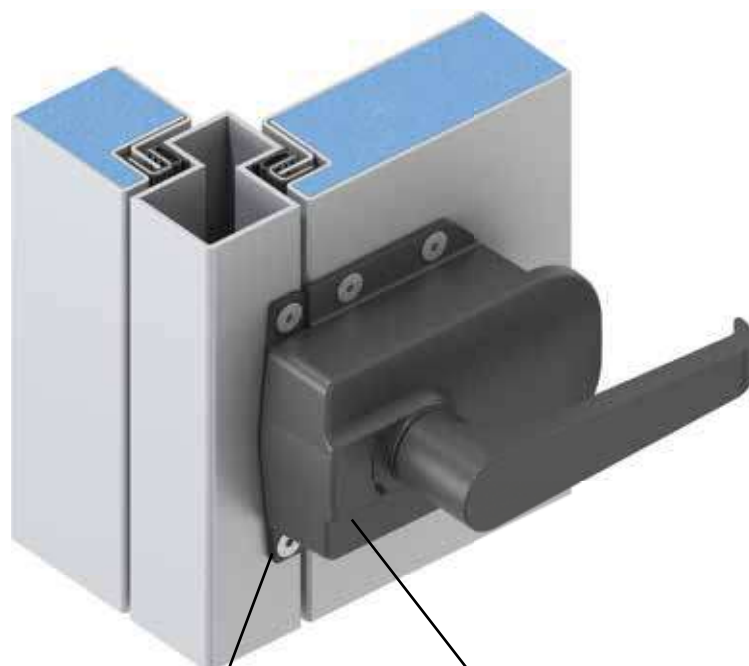
Catch

Surface mounted door lock zinc die black powder coated; L-handle polyamide GF black; stepped cam zinc die raw; screw m.s. zinc plated		Catch to be ordered separately
non locking	1000-U780	90° locking stroke with lockable handles
Surface mounted door lock zinc die black powder coated; L-handle polyamide GF black; cam and screw m.s. zinc plated; round cylinder zinc die with stainless steel cap and dust cap		Housing and catch with long slots on request!
Keyed EK 333	1000-U781	Suitable lockable or non lockable T-handles on request!
Keyed different	1000-U781-V	
Catch zinc die black powder coated		Further parts see page – Spare key
	1000-488	

K1-644

Surface mounted door lock with internal handle

PROGRAM 1000

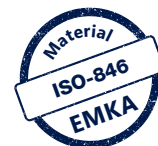


Catch

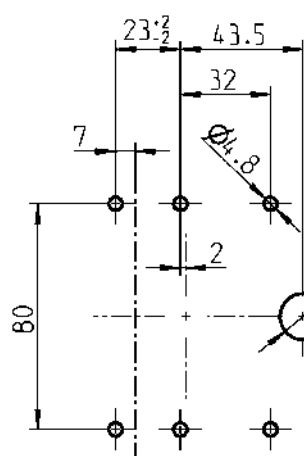
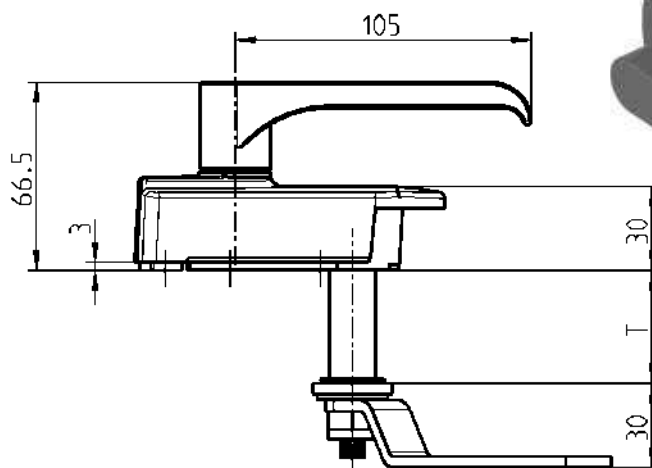
Housing

Product benefits

- New modular locking system especially for use on large doors (>1.6 m door height)
- Various inserts and handle options in combination with different cams possible (stepped cam, pressure relief cam, etc.)
- System for various door thicknesses (50 mm - 60 mm)
- Also available as a version without inside handle
- VDI 6022 / ISO 846 compliant materials

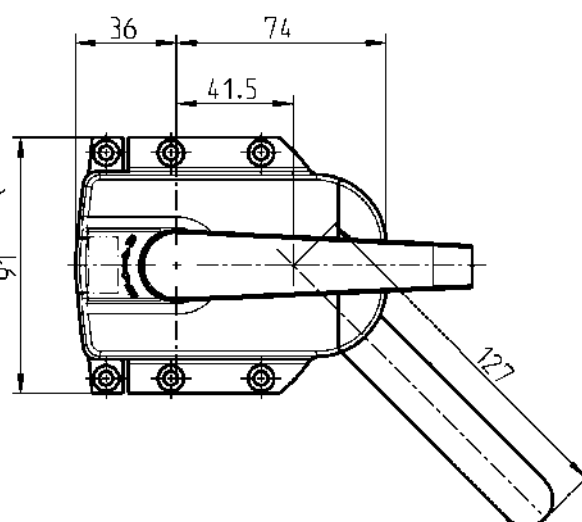


Reduction for rivet in
housing and catch



Catch Housing
Cut out front

Bore Ø16.3 continuous



Catch

Surface mounted door lock with internal handle:

housing polyamide 66 GF 50 black;

L-handle, bezel, fastening module and spacer piece polyamide GF black;

adapter plate POM GF black; gearwheels zinc die zinc plated;

square shaft, cam, pin and inside handle m.s. zinc plated; washer, nut m.s. zinc plated; with seal

T = 50 mm

1000-U938

T = 60 mm

1000-U939

other dimensions and handles on request

Catch zinc die black powder coated

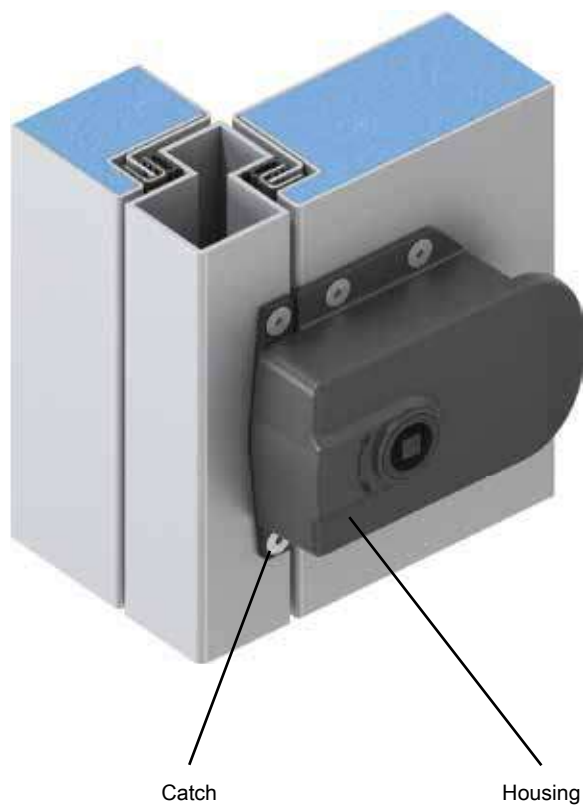
1000-488-AA

Catch to be ordered separately

90° Turn

Surface mounted door lock with internal handle

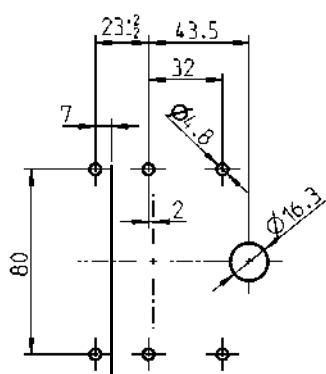
PROGRAM 1000



Product benefits

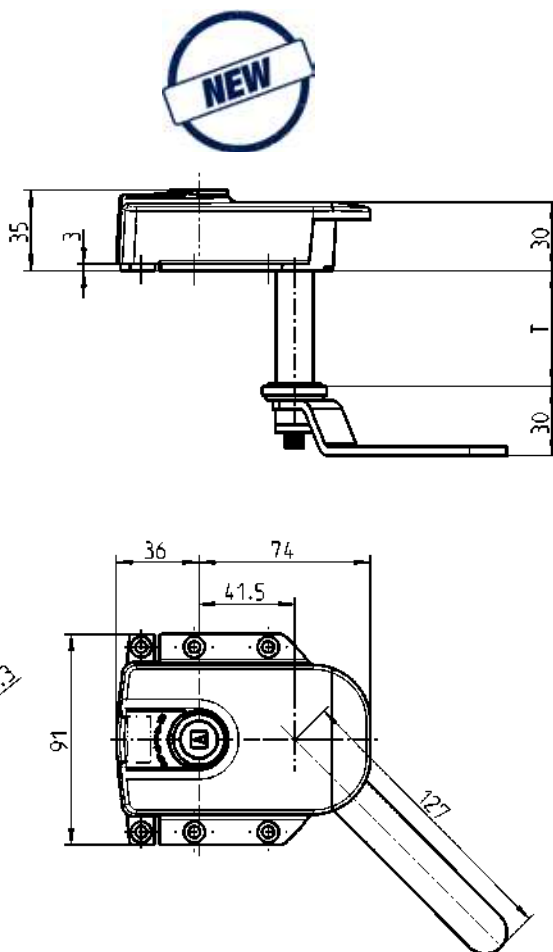
- New modular locking system especially for use on large doors (>1.6 m door height)
- Various inserts and handle options in combination with different cams possible (stepped cam, pressure relief cam, etc.)
- System for various door thicknesses (30 mm - 60 mm)
- Also available as a version without inside handle
- VDI 6022 / ISO 846 compliant materials

Reduction for rivet in housing and catch



Catch Housing
Cut out front

Bore Ø16.3 continuous



Ⓐ = Door lock with stepped cam

Ⓑ = Door lock with pressure relief cam

Surface mounted door lock with internal handle
housing polyamide 66 GF 50 black;
bezel, fastening module and spacer piece polyamide GF black;
adapter plate POM GF black; gearwheels zinc die zinc plated;
square shaft, cam, pin and inside handle m.s. zinc plated; washer, nut m.s. zinc plated; with seal

Ⓐ = Door lock with stepped cam

Square 7 ; T = 50 mm	1000-U943
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Square 7 ; T = 60 mm	1000-U944
----------------------	-----------

Ⓑ = Door lock with pressure relief cam

Square 7 ; T = 50 mm	1000-U945
----------------------	-----------

Square 7 ; T = 60 mm	1000-U946
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other dimensions and inserts available on request

Catch zinc die black powder coated

1000-488-AA



Catch

Catch to be ordered separately

Further parts see page
– Key

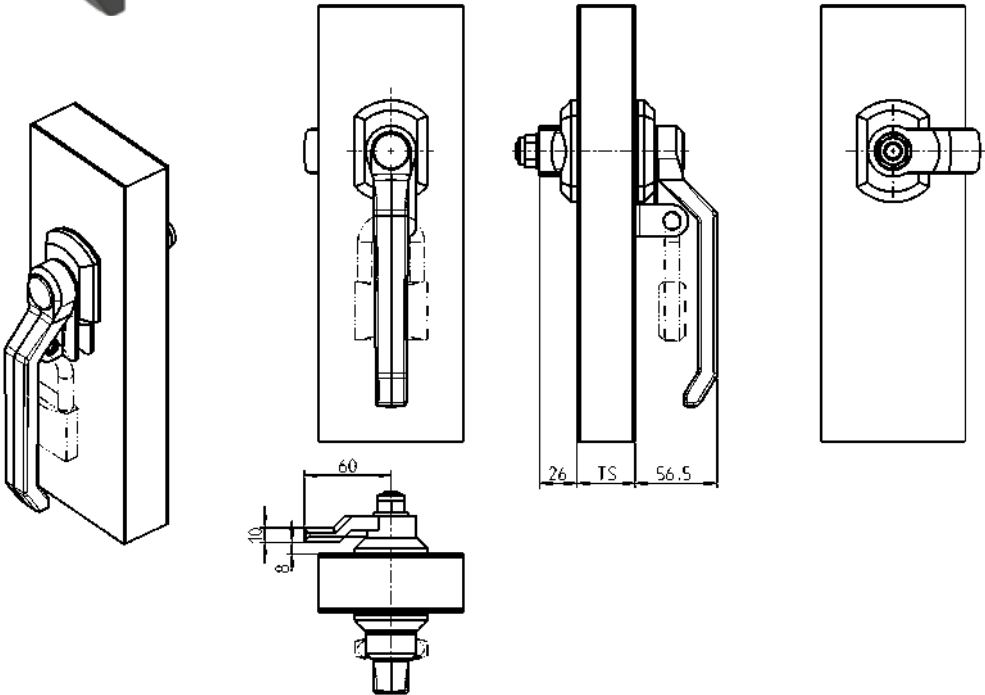
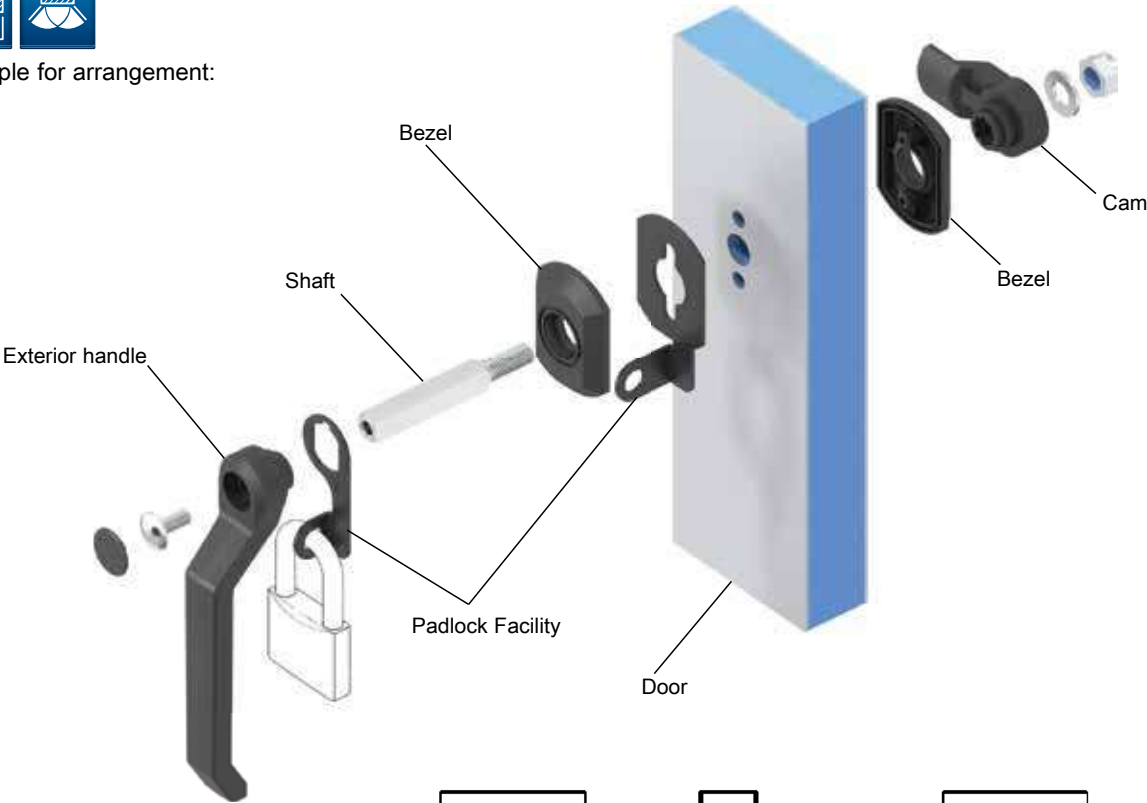
K1-650

Heavy duty latch with m.s. shaft

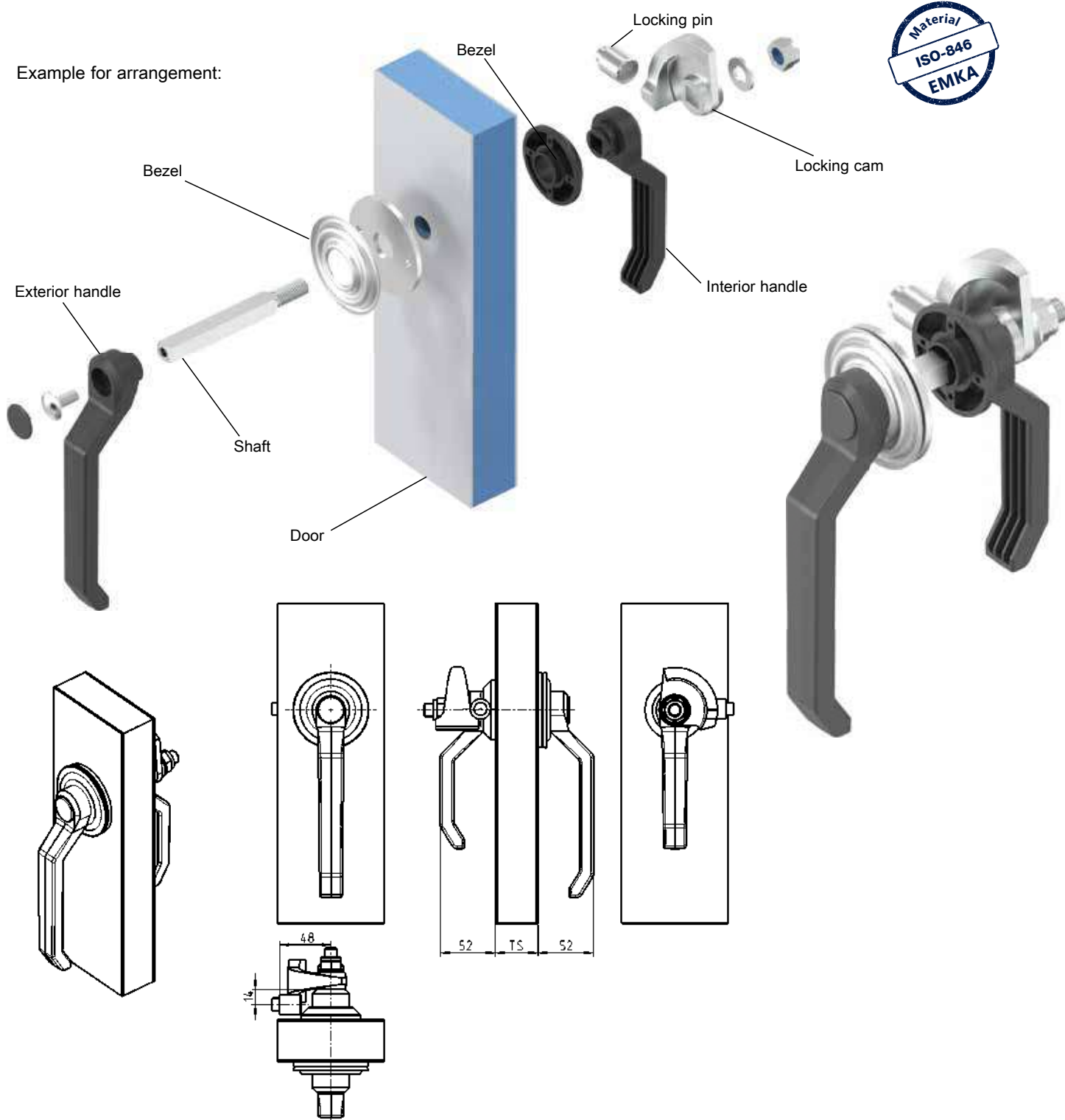
PROGRAM 1091



Example for arrangement:



Example for arrangement:



Heavy duty latch consisting of:

Shaft m.s. zinc plated, screw M8, washer A13,
nyloc nut M12 m.s. zinc plated and plastic plug black polyamide

Ts	20	30	40	50	60	80	100	Tolerance
for cam and inside handle								
	1091-U8	1091-U9	1091-U10	1091-U11	1091-U12	1091-U13	1091-U14	± 5
for cam without inside handle								
	1091-U6	1091-U7	1091-U8	1091-U9	1091-U10	1091-U12	1091-U13	± 10
for inside handle, or spacer and locking cam								
	1091-U8	1091-U9	1091-U10	1091-U11	1091-U12	1091-U13	1091-U14	± 5

Further parts see page

– Handle	K1-320
– Locking cam	K1-330
– Cam	K1-330
– Bezel	K1-340
– Padlock facility	K1-350

Heavy duty latch-handles

PROGRAM 1091

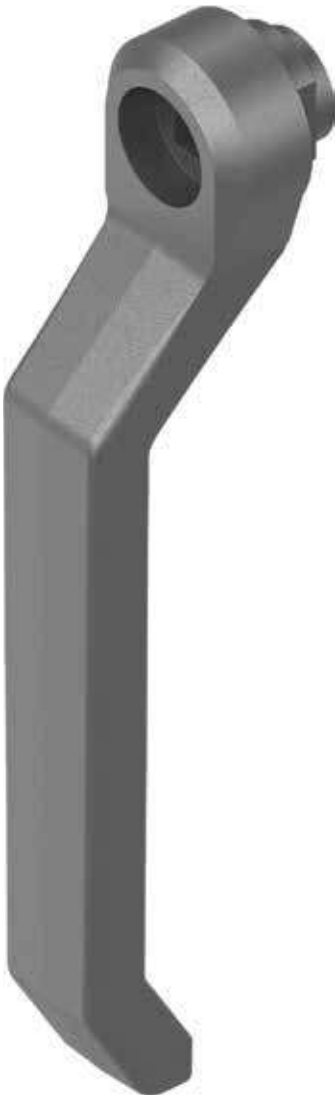
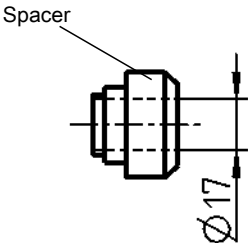
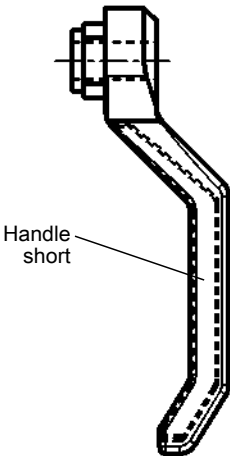
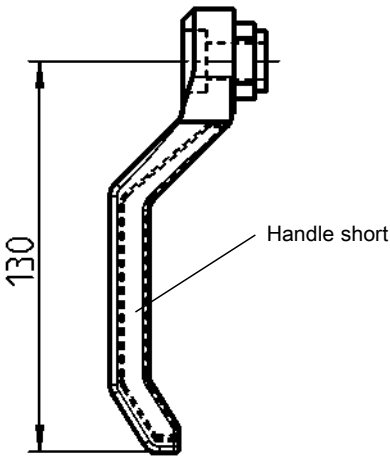
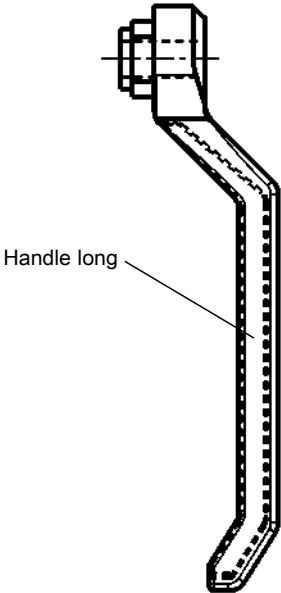
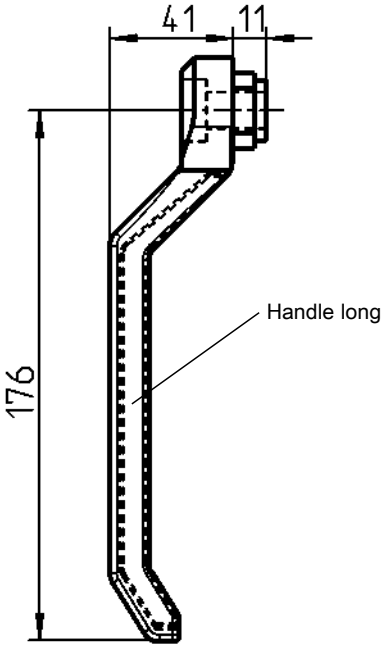


Handles



Outside

Inside



Handle long polyamide GF black	1091-20	Handle long polyamide GF black	1091-24
Handle long polyamide GF black with embedded steel	1091-22	Handle long polyamide GF black with embedded steel	1091-26
Handle short polyamide GF black	1091-21	Handle short polyamide GF black	1091-25
Handle short polyamide GF black with embedded steel	1091-23	Handle short polyamide GF black with embedded steel	1091-27
		Spacer (replaces handle), m.s. zinc plated	1091-28

Attention:
The spacer is needed when using the cam lock without inner handle.

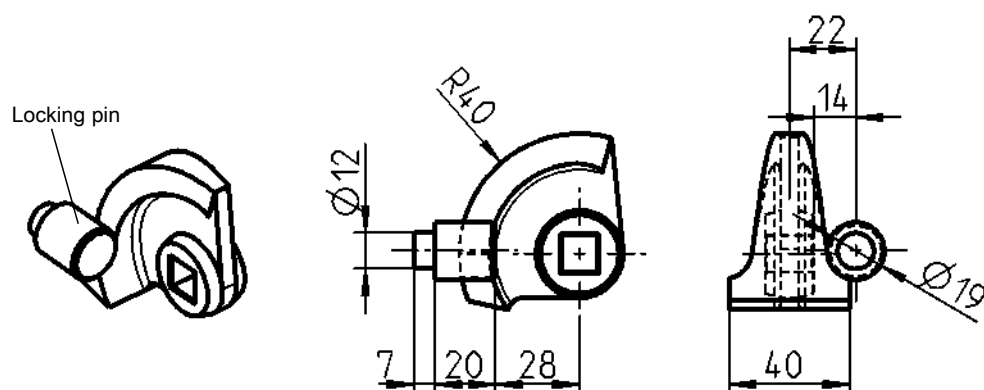
Further parts see page
– Heavy duty latch K1-310
– Heavy duty latch, outside the door K1-390

Accessories for heavy duty latch

PROGRAM 1091



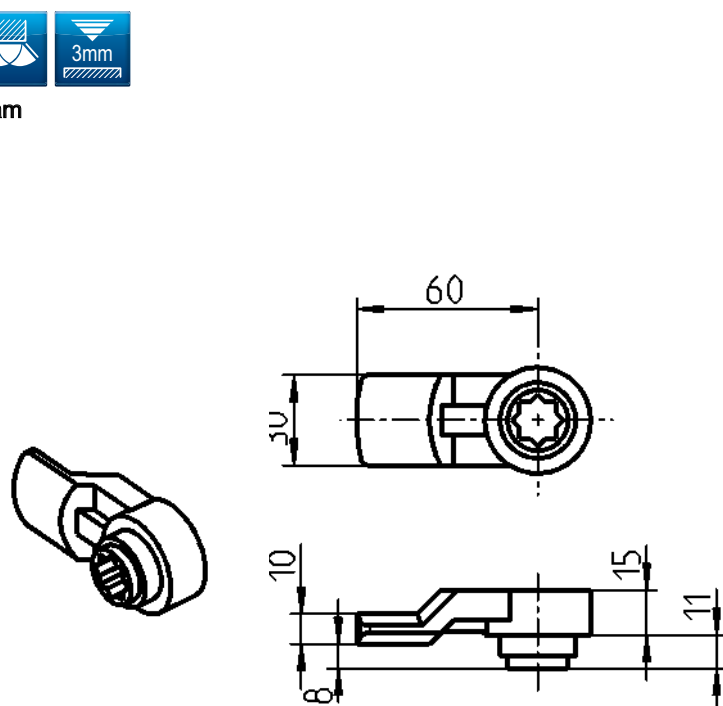
Locking cam



Locking cam zinc die raw	1091-04
Locking stud m.s. zinc plated	1091-01



Cam

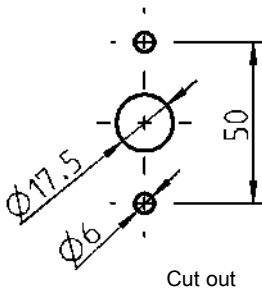
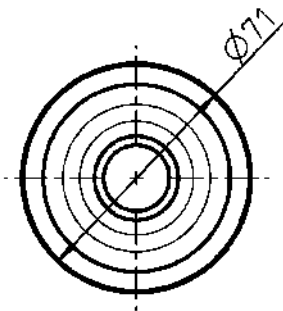
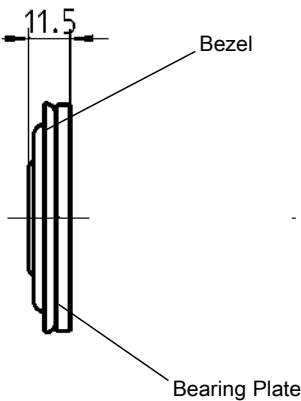


Cam zinc die zinc plated	1091-18
Cam PA GF black	1091-18-01

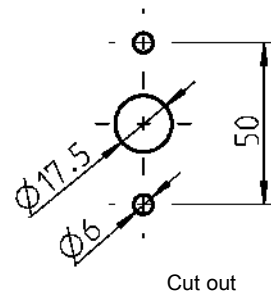
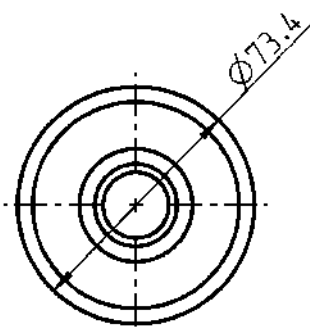
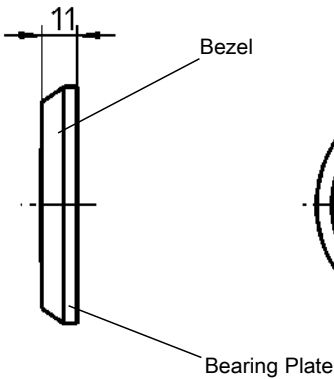
Further parts see page
 – Heavy duty latch K1-310
 – Heavy duty latch, outside the door (Cam) K1-390

Accessories for heavy duty latch

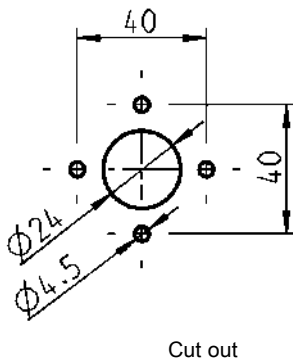
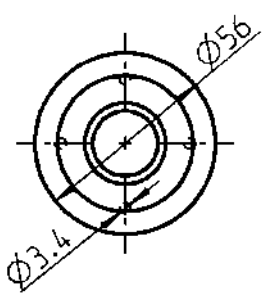
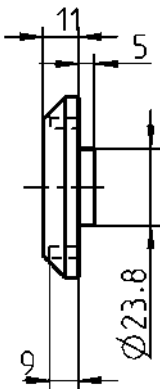
PROGRAM 1091



Bezel, m.s. zinc plated	1091-07
Bearing plate, m.s. zinc plated	1091-06



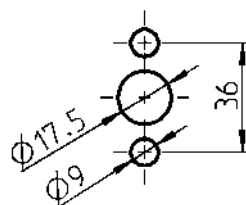
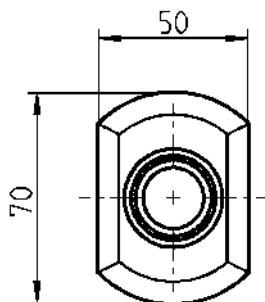
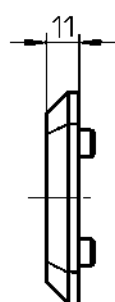
Bezel, polyamide GF black	1091-31
Bearing plate, m.s. zinc plated	1091-06



Bezel, polyamide GF black	1091-30
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Accessories for heavy duty latch

PROGRAM 1091



Cut out



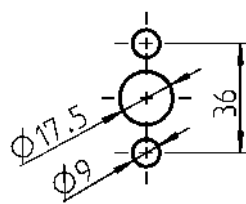
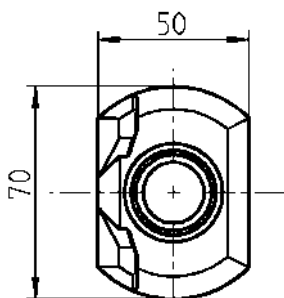
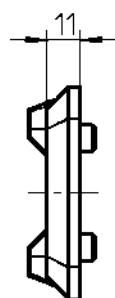
Bezel, polyamide GF black, with foamed seal

1091-17-G

IP 65 achieved by:

Set of O-rings

1091-U90



Cut out



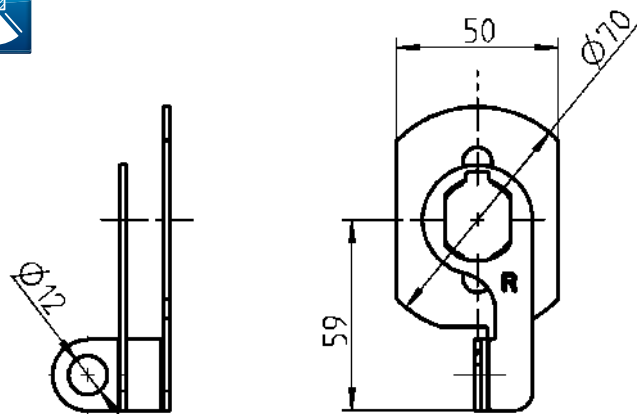
Bezel with stop dogs, polyamide GF black, with foamed seal

1091-17-01G

IP 65 achieved by:

Set of O-rings

1091-U90



Padlock facility, m.s. black powder coated

RH version

1091-U86

LH version

1091-U87

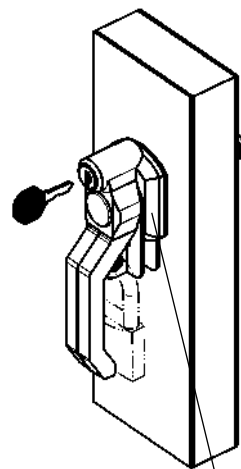
Further parts see page

– Heavy duty latch
– Bezel

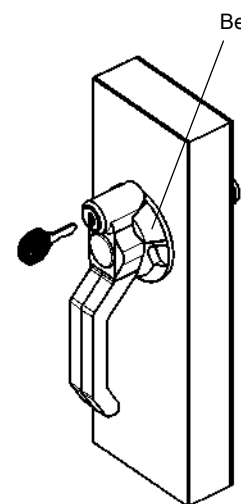
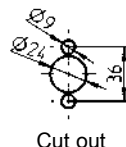
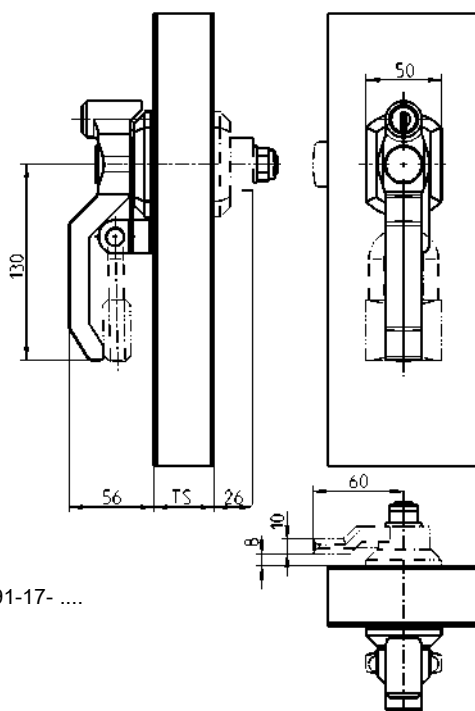
K1-310
K1-360

Heavy duty latch with m.s. shaft

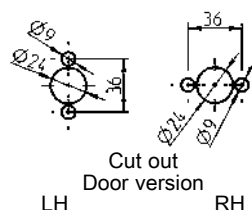
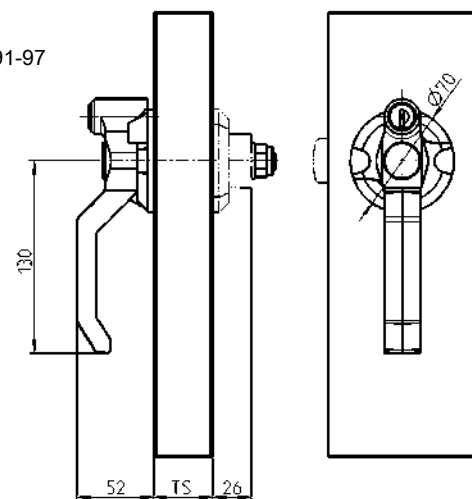
PROGRAM 1091



Bezel 1091-17-



Bezel 1091-97



Handle polyamide GF black for shaft m.s.;
 round cylinder zinc die with stainless steel cap and dust cover;
 insert zinc die chrome plated

Keyed EK 333	1091-U50	Keyed different	1091-U51
Square 7	1091-U52	Square 8	1091-U53
Triangular 8	1091-U54	Double bit 3	1091-U55
Double bit 5	1091-U56	Slot 2 x 4	1091-U57

(order separately)

Bezel polyamide black for lockable handle

180°-stopper	1091-17-03	90°-stopper, LH	1091-17-04
90°-stopper, RH	1091-17-05	90°-stopper, round bezel	1091-97

Shaft m.s., screw, nut M12 and washer A13 m.s. zinc plated;
 blind plug polyamide GF black

Ts	20	30	40	50	60	80	100
for cam							
	1091-U6	1091-U7	1091-U8	1091-U9	1091-U10	1091-U12	1091-U13
for spacer and locking cam							
	1091-U8	1091-U9	1091-U10	1091-U11	1091-U12	1091-U13	1091-U14

Round bezel with 90°-stopper
 1091-97 also suitable for
 non-locking handles.

Other inserts available on request

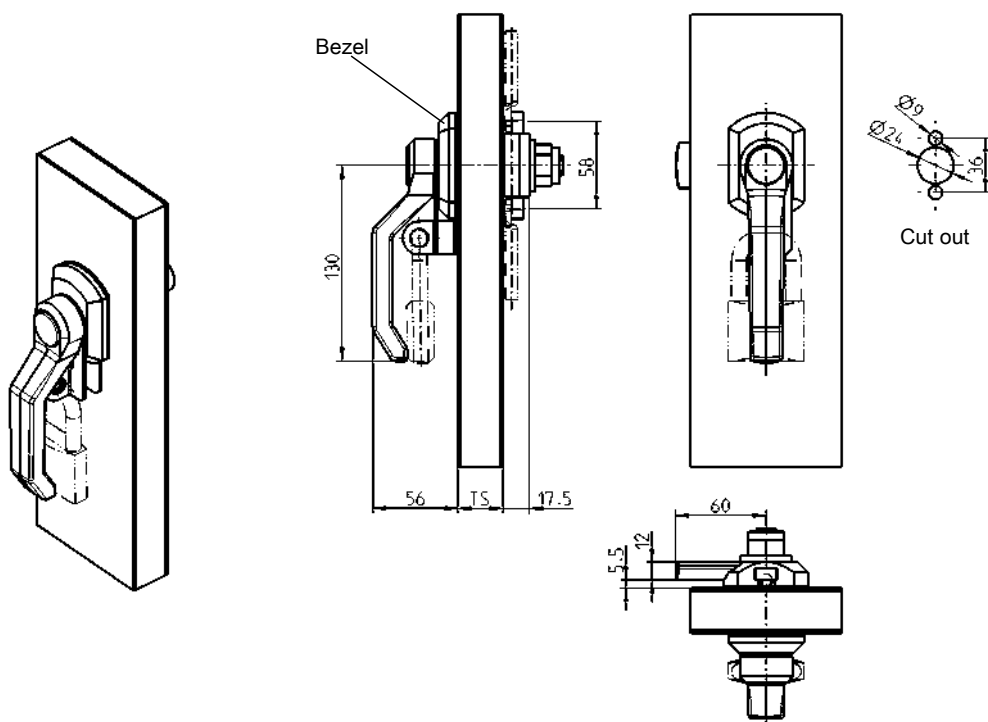
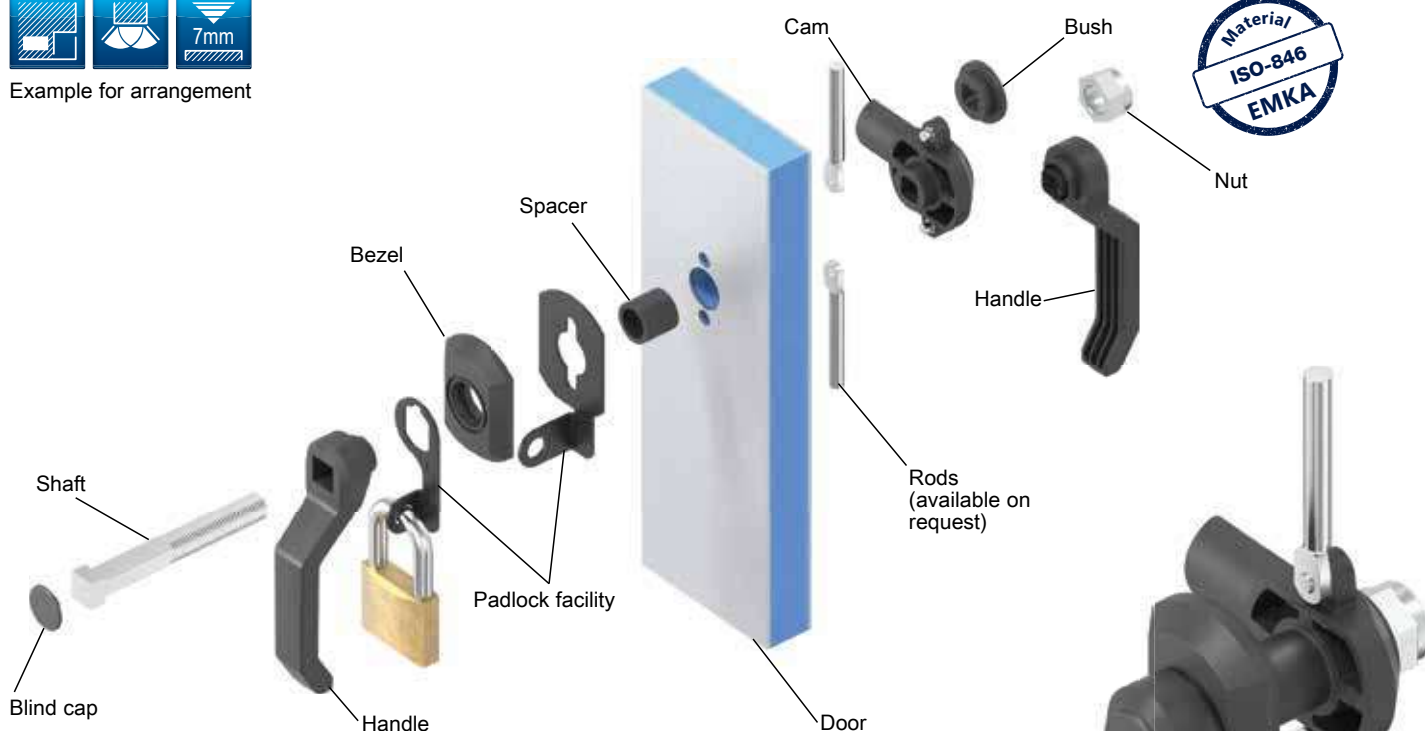
Further parts see page

– Spacer	K1-320
– Cam	K1-330
– Locking cam	K1-330
– Padlock accessories	K1-350
– Key	K1-650
– Spare key	K1-644

Heavy duty latch with zinc die shaft PROGRAM 1091



Example for arrangement



Handle polyamide GF black (outside and inside)

1091-42

Shaft zinc die; nut m.s. zinc plated;
bezel-cam, spacer, bush and blind plug polyamide GF black

Ts	10 – 30	31 – 50	51 – 70
without rod control	1091-U80	1091-U81	1091-U82
with rod control	1091-U83	1091-U84	1091-U85

Attention:

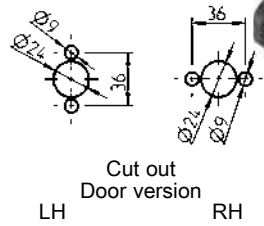
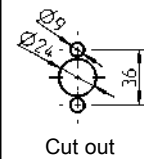
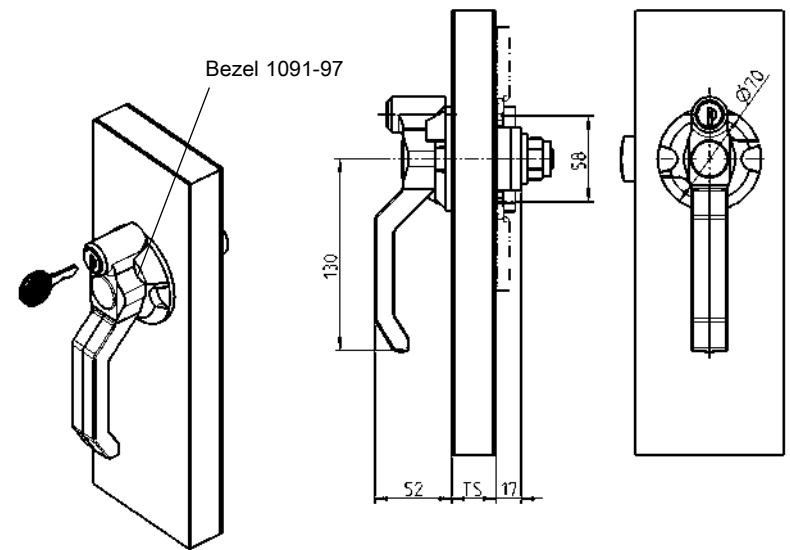
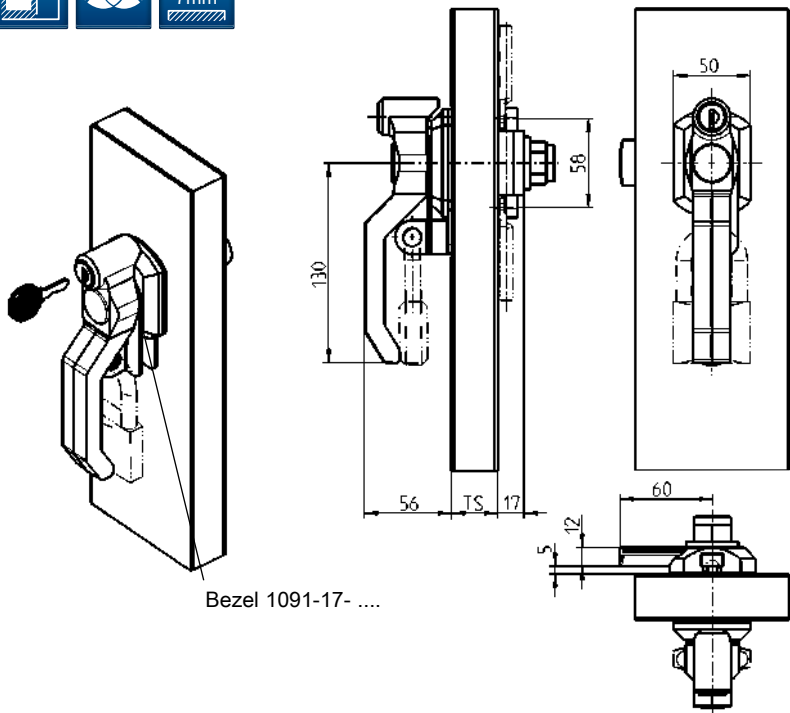
If an internal handle is installed, the maximum door gauge is reduced by 10 mm.

Further parts see page

– Bezel from K1-340 to K1-350
– Padlock accessories K1-350
– Connecting rod on request

Heavy duty latch with zinc die shaft

PROGRAM 1091



Handle polyamide GF black for shaft zinc die, round cylinder zinc die with stainless steel cap and dust cover, insert zinc die chrome plated			
Keyed EK 333	1091-U72	Keyed different	1091-U73
Square 7	1091-U74	Square 8	1091-U75
Triangular 8	1091-U76	Double bit 3	1091-U77
Double bit 5	1091-U78	Slot 2 x 4	1091-U79
(order separately)			
Bezel polyamide GF black for lockable handle			
180°-stopper	1091-17-03	90°-stopper, LH	1091-17-04
90°-stopper, RH	1091-17-05	90°-stopper, round bezel	1091-97
Shaft zinc die; nut m.s. zinc plated, bezel-cam, spacer, bush and blind plug polyamide GF black			
Ts	10 – 30	31 – 50	51 – 70
without rod control	1091-U80	1091-U81	1091-U82
with rod control	1091-U83	1091-U84	1091-U85

Round bezel with 90°-stopper 1091-97 also suitable for non-locking handles.

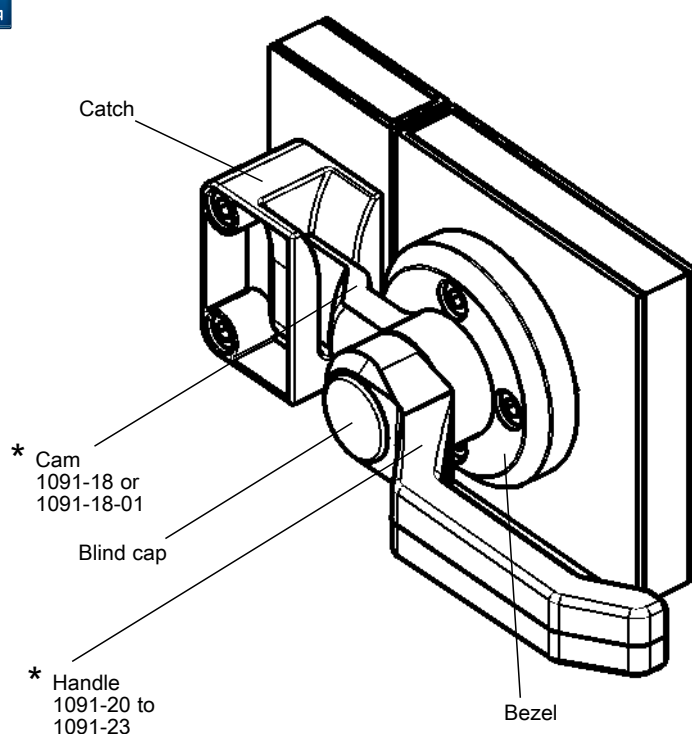
Other inserts available on request

Further parts see page

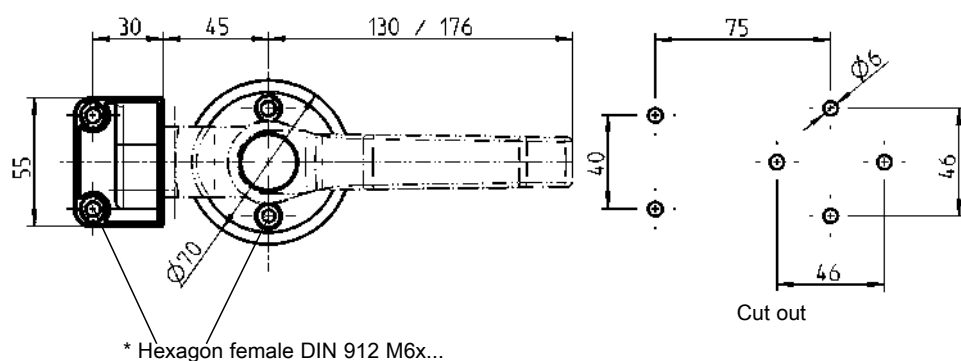
- Padlock accessories K1-330
- Key K1-650
- Spare key K1-644
- Connecting rod on request

Heavy duty latch, outside the door

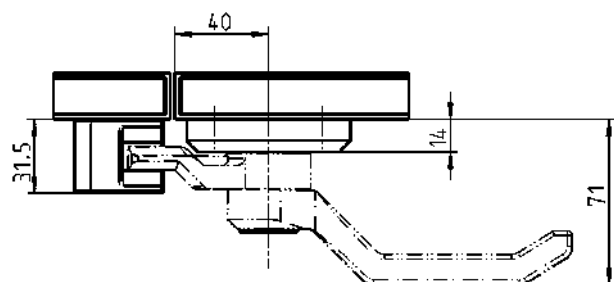
PROGRAM 1091



Combination of:
1091-U121; 1091-96,
handle 1091-21 and
cam 1091-18



* not included in
the scope of supply



Bezel and blind plug polyamide GF black
Shaft brass, fixing m.s. zinc plated

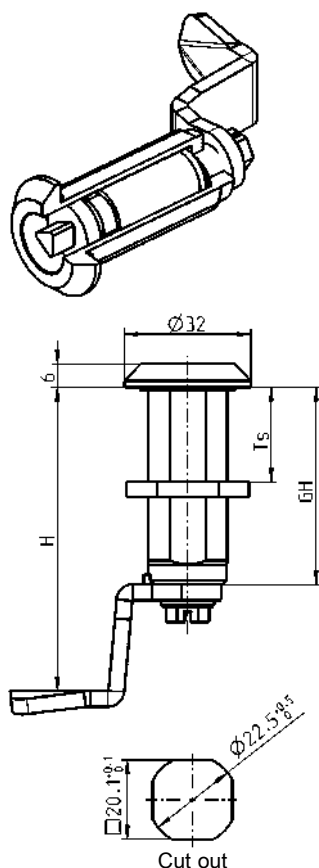
1091-U121

Catch polyamide GF black

1091-96

Further parts see page
– Outside handle
– Cam

K1-320
K1-330



GH	Ts
30 mm	1.5 up to 20 mm
36 mm	1.5 up to 26 mm
40 mm	1.5 up to 30 mm
50 mm	1.5 up to 40 mm
60 mm	1.5 up to 50 mm

Assembly instruction

IP 65 achieved by:

** Flat seal	1000-23
** O-ring	1000-24

IP 66 achieved by:

Seal set	1000-U769
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IP 69K achieved by:

* Seal set	1000-U841
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Assembly on request:

without O-ring	1000-990
with O-ring	1000-991

Housing material on choice; nut or earthnut m.s. zinc plated or nut stainless steel
 Adapter zinc die or AISI 303; screw m.s. zinc plated or stainless steel

GH in mm	Zinc die chrome plated		Zinc die black powder coated		polyamide black Nut	AISI 316 Nut
	Nut	Earthnut	Nut	Earthnut		
30	1000-U51	1000-U65	1000-U225	1000-U226	1000-U876	1000-U878
- adapter	1000-U164					1000-U879
36	1000-U246	1000-U248	1000-U317	1000-U318	-	-
- adapter	1000-U198					-
40	1000-U66	1000-U67	1000-U227	1000-U228	1000-U737	-
- adapter	1000-U165					-
50	1000-U68	1000-U69	1000-U229	1000-U230	1000-U736	-
- adapter	1000-U166					-
60	1000-U504	1000-U505	1000-U506	1000-U507	-	-
- adapter	1000-U535					-

** included in case of stainless st. version

* Seal set only completely assembled with housing, insert and cam available

Further parts see page

- Quarter turn with stepped cam	K1-420
- Cam with catch	K1-640
- Accessories	K1-630
- Key	K1-650

Further parts see General Catalogue
 - Escutcheon

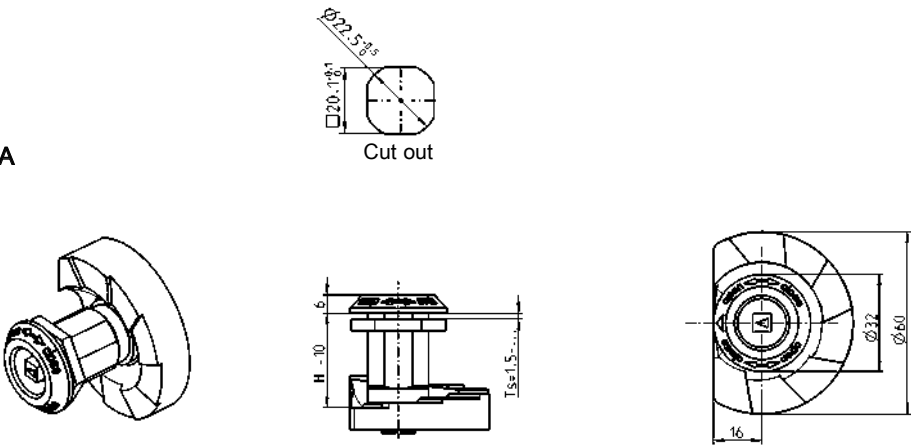
3B-140

Quarter turn with stepped cam

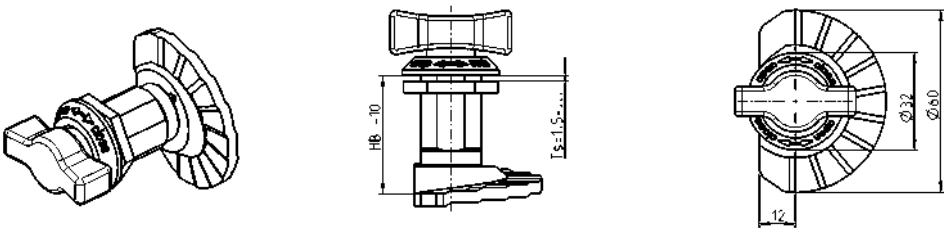
PROGRAM 1000



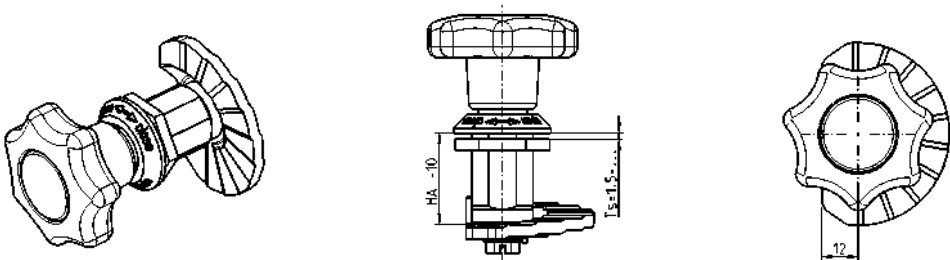
Version A



Version B



Version B



Stepped cam							
Version A				zinc plated m.s., no stop		1000-127	
				zinc plated m.s., with stop		1000-244	
Version B				zinc alloy, with stop		1000-387	
Housing zinc die surface as requested; nut m.s. zinc plated; adapter and spacer zinc alloy; screw m.s. zinc plated							
Ts	H	HA	HB	Zinc alloy housing		with adapter zinc die	Spacer, zinc alloy
1.5 –				chrome-plated	black powder-coated	(Flush mounted insert)	for 5 mm tolerance and screw zinc plated
8	19	19	27	1000-U157	1000-U231	no need	1000-U539
20	31	31	39	1000-U158	1000-U232	1000-U164	1000-U540
26	37	37	45	1000-U247	1000-U250	1000-U198	1000-U541
30	41	41	49	1000-U159	1000-U233	1000-U165	1000-U542
40	51	51	59	1000-U160	1000-U234	1000-U166	1000-U543

Housing with 270° stop

Advice:
Quarter turn-assembling K1-410

Further parts see page
– Insert K1-410
– IP 65 or IP 66 K1-410
– Accessories K1-630
– Key K1-650

Further parts see General Catalogue
– Escutcheon 3B-140

Compression latch

PROGRAM 1000

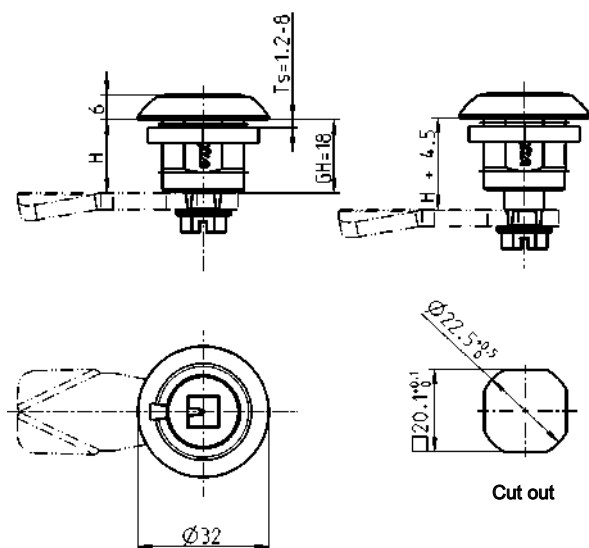


Tamper and vibration proof

The compression latch is designed to be vibration-proof as such. Depending on the installation location and operational conditions, specific checks are necessary and/or supplementary measures of fastening required.



for stainless steel version



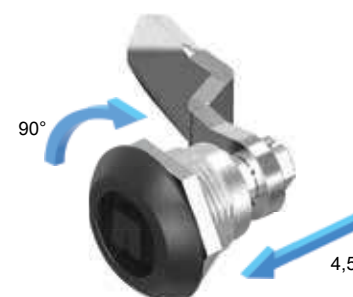
Product benefits

- Compact design
- Compatible with other quarter-turns with GH = 18 mm
- Fire protection according to DIN EN 45545-2 with E20
- Short housing GH = 18 mm
- Foamed sealing
- Standard cutout



Open

By rotation of the operation of 90° the cam rotates.



Housing and insert material of your choice; nut and screw m.s. zinc plated or stainless steel; with spring and seal

	Zinc die black powder-coated	Zinc die chrome plated	AISI 316
Square 6	on request	on request	on request
Square 7	on request	1000-U859-IA	1000-U859-PH
Square 8	1000-U852	1000-U852-IA	1000-U852-PH
Triangular 6.5 CNOMO	on request	on request	on request
Triangular 7	on request	1000-U864-IA	1000-U864-PH
Triangular 8	1000-U853	on request	1000-U853-PH
Triangular 9	on request	on request	on request
Triangular 10	on request	on request	on request
Double bit 3	1000-U854	on request	1000-U854-PH
Double bit 5	1000-U855	on request	1000-U855-PH
Hexagon male SW 11.1 with marking	on request	on request	on request
Hexagon female 8	on request	on request	on request
Hexagon female SW 8 with pin	on request	on request	on request
Hexagon female 10mm	on request	on request	on request
Square female 6	on request	on request	on request
Square female 7mm	on request	on request	on request
Square female 8	on request	on request	on request
Daimler Benz	on request	on request	on request
Slot 1.2 x 3	on request	on request	on request
Slot 2 x 4	on request	on request	on request
Slot 2 x 4 coinproof	on request	on request	on request
Crown type	on request	on request	on request
Federal Railway	1000-U856	on request	1000-U856-PH
Tube with indicator	on request	on request	on request

Closed

By further rotation of the operation of 90° the cam moves 4.5 mm in axial direction.



Compressed

Open

Reversed motion

Further parts see page

- Cam without catch K1-640 (not for cam with rod control)
- Accessories K1-630
- Key K1-650

Further parts see General Catalogue
– Escutcheon 3B-140

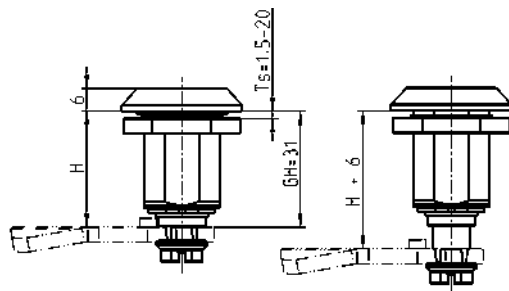
Compression latch

PROGRAM 1000

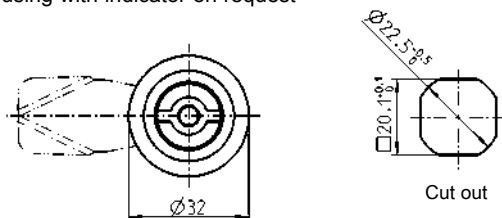


Tamper and vibration proof

The compression latch is designed to be vibration-proof as such. Depending on the installation location and operational conditions, specific checks are necessary and/or supplementary measures of fastening required.



Housing with indicator on request



Cut out



for stainless steel version



Open

By rotation of the operation of 90° the cam rotates.



Closed

By further rotation of the operation of 90° the cam moves 6 mm in axial direction.



Compressed

Open
Reversed motion

Further parts see page

- Cam with or without catch K1-640 (not for cam with rod control)
- Accessories K1-630
- Key K1-650

Further parts see
General Catalogue
– Escutcheon

3B-140

Housing and insert zinc die black powder-coated or AISI 316;
nut and screw m.s. zinc plated respective stainless steel;
with spring and seal

	Zinc die black powder-coated	AISI 316
Square 6 with arrow	on request	on request
Square 7 with arrow	1000-U796	on request
Square 8 with arrow	1000-U798	on request
Square 8 with marking	on request	1000-U755-01
Triangular 6.5 CNOMO	on request	on request
Triangular 7	1000-U795	on request
Triangular 8	1000-U783	on request
Triangular 9	on request	on request
Triangular 10	on request	on request
Double bit 3	1000-U749	1000-U749-01
Double bit 5	1000-U748	1000-U748-01
Hexagon male SW 11.1 with marking	on request	on request
Hexagon female 8	1000-U807	on request
Hexagon female SW 8 with pin	1000-U805	on request
Hexagon female 10mm	1000-U809	on request
Square female 6	on request	on request
Square female 7mm	on request	on request
Square female 8	1000-U811	on request
Slot 2 x 4	1000-U777	1000-U777-01
Slot 2 x 4 coinproof	on request	on request
Crown type	on request	on request
Insert railway	1000-U831	1000-U831-01
Tube with indicator	1000-U833	on request
Wing knob	1000-U882	on request

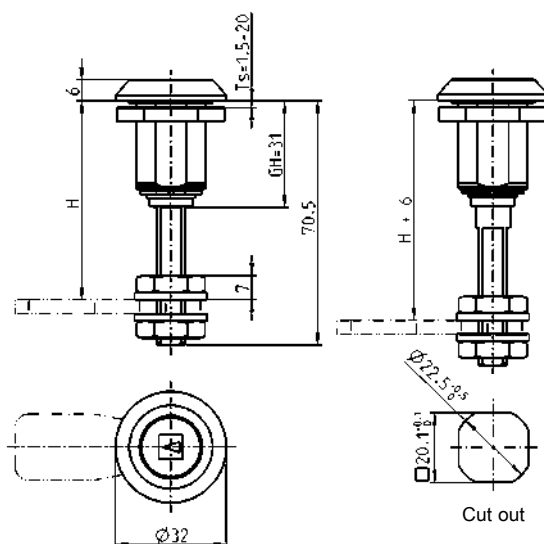
Compression latch with adjustable cam

PROGRAM 1000



Tamper and vibration proof

The compression latch is designed to be vibration-proof as such. Depending on the installation location and operational conditions, specific checks are necessary and/or supplementary measures of fastening required.

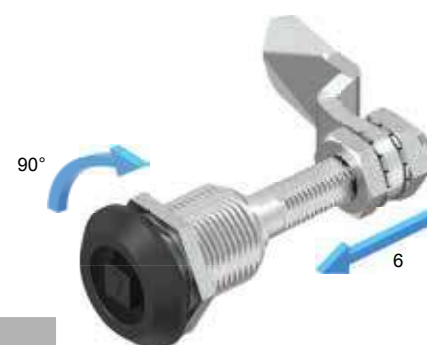


for stainless steel version



Open

By rotation of the operation of 90° the cam rotates.



Closed

By further rotation of the operation of 90° the cam moves 6 mm in axial direction.

Housing and insert zinc die black powder-coated or AISI 316;
shaft zinc die, m.s. zinc plated or AISI 316;
nut and washer m.s. zinc plated or AISI 316, with spring and gasket

	Housing and insert zinc die black powder coated		Housing and insert AISI 316
	shaft zinc die	shaft m.s. zinc plated	shaft AISI 316
Square 6 with arrow	on request	on request	on request
Square 7 with arrow	1000-U786	1000-SU720	on request
Square 8 with arrow	1000-U799	1000-SU861	1000-U755-02
Triangular 6.5 CNOMO	on request	on request	on request
Triangular 7	1000-U794	1000-SU724	on request
Triangular 8	1000-U802	1000-SU725	on request
Triangular 9	on request	on request	on request
Triangular 10	on request	on request	on request
Double bit 3	1000-U803	1000-SU730	on request
Double bit 5	1000-U804	1000-SU752	on request
Hexagon male SW 11.1 with marking	1000-U816	1000-SU324	on request
Hexagon female 8	1000-U808	1000-SU735	on request
Hexagon female SW 8 with pin	1000-U806	1000-SU733	on request
Hexagon female 10mm	1000-U810	on request	on request
Square female 6	on request	on request	on request
Square female 7mm	on request	on request	on request
Square female 8	1000-U812	on request	on request
Slot 2 x 4	1000-U813	on request	on request
Slot 2 x 4 coinproof	on request	on request	on request
Crown type	on request	on request	on request
Insert railway	1000-U832	on request	1000-U831-02
Tube with indicator	1000-U830	1000-SU736	on request
Wing knob	1000-U880	on request	on request



Compressed

Open

Reversed motion

Note:

Only cams without a catch can be used.

Further parts see page

– Cam (GH = 31) K1-642
– Accessories K1-630
– Key K1-650

Further parts see
General Catalogue
– Escutcheon

3B-140



Example:
compression latch with T-handle



Open

Open
The first 90° of rotation of the handle turns the cam 90°.



Closed

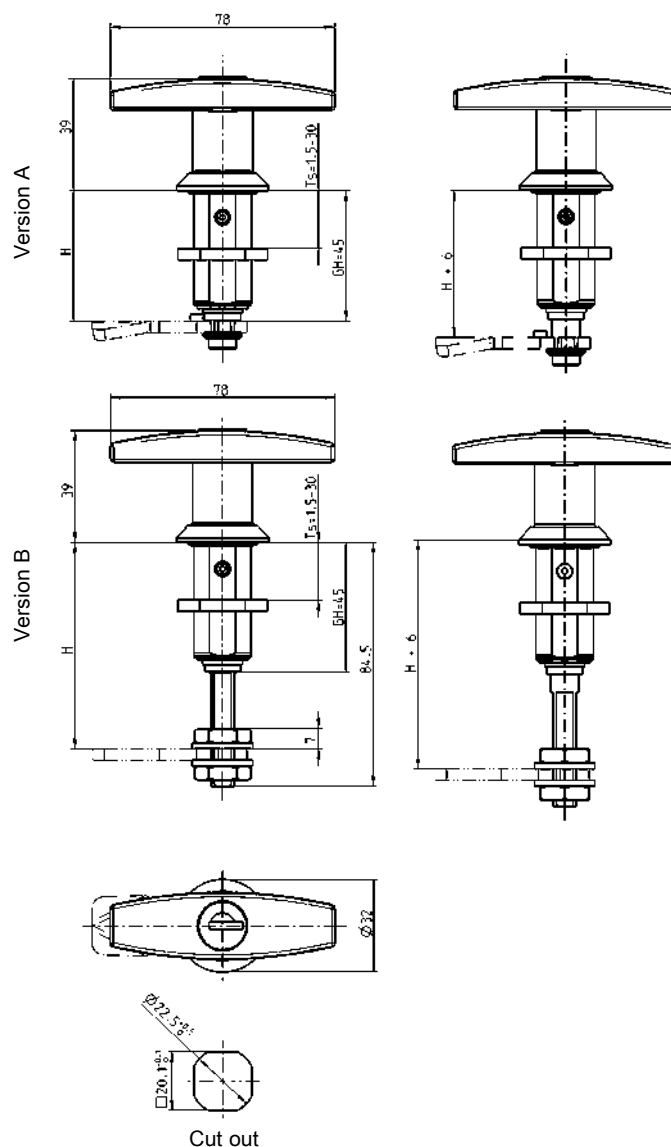
Closed
The second 90° of rotation draws the cam 6mm axially towards the door.



Compressed
Key removable

Open
Reversed motion

Compression latch with T-handle



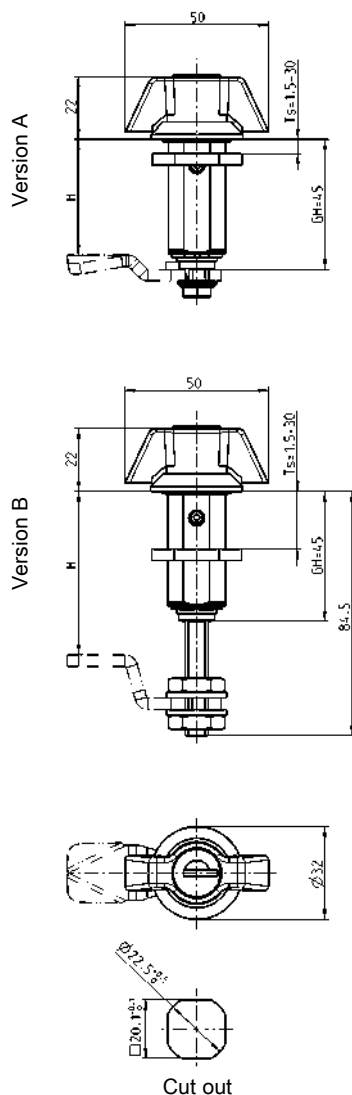
Note:

For version B only cams without catch can be used!

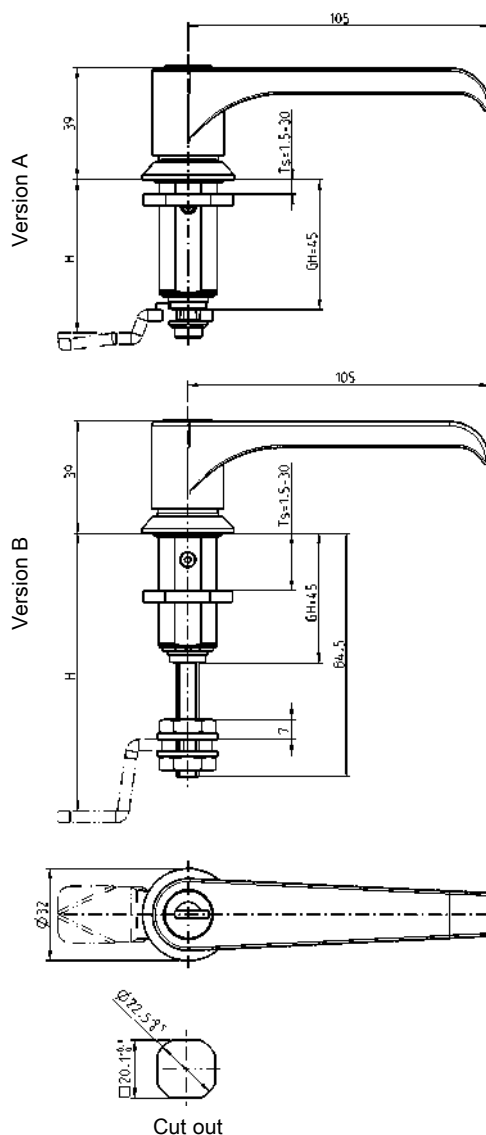
Tamper and vibration proof

The compression latch is designed to be vibration-proof as such. Depending on the installation location and operational conditions specific checks are necessary and/or supplementary measures of fastening required.

Compression latch with wing knob



Compression L handle



Stainless steel version on request.



Handle and housing zinc die, black powder coated;
 cylinder zinc die, with stainless steel cap and shutter;
 nut and screw or washer zinc plated m.s.; with spring and seal
 Each cylinder has one silver steel key with polyamid grip.
 Key removable in both positions

Version A: captive cam level	non locking	Keyed EK 333	Keyed different
Wing knob	1000-U826	1000-U827	1000-U828
T-Handle	1000-U820	1000-U821	1000-U822
L-handle	1000-U823	1000-U824	1000-U825
Version B: for adjustable cam level			
Wing knob	1000-U790	1000-U789	1000-U791
T-Handle	1000-U785	1000-U784	1000-U792
L-handle	1000-U788	1000-U787	1000-U793

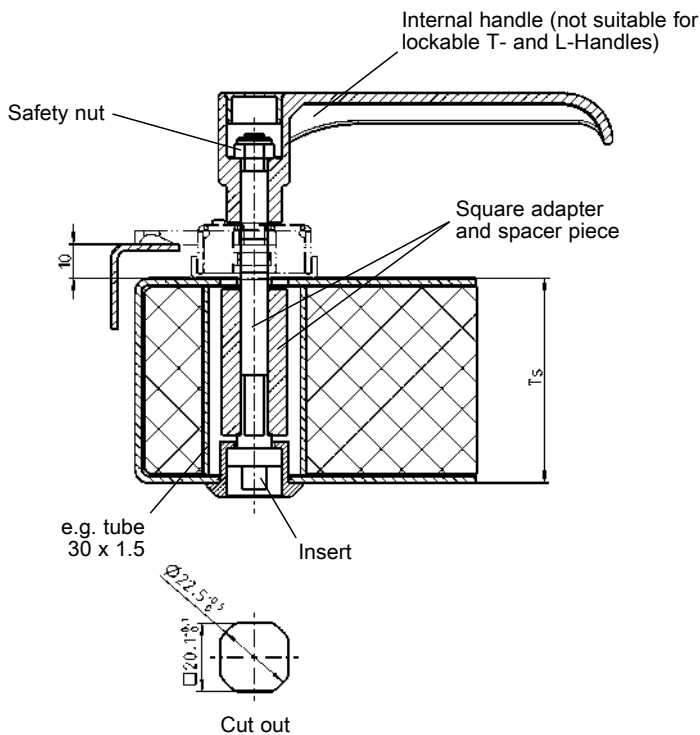
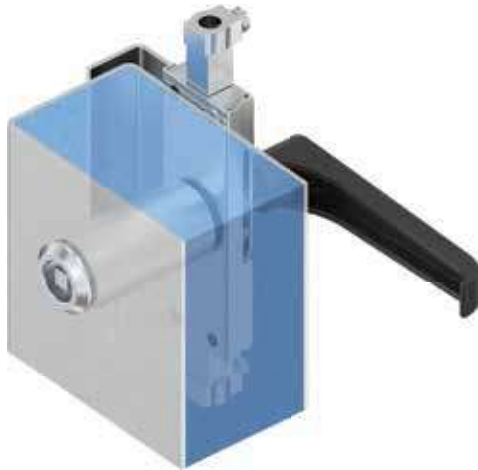
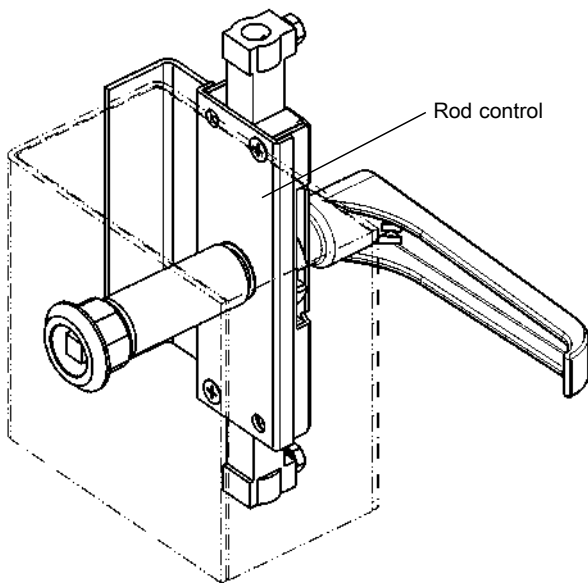
Further parts see page
 for fixed cam height
 – Cam with or without catch K1-640
 (not for cam with rod control)

for adjustable cam level
 – Cam (GH = 45) K1-642
 – Spare key K1-644

Further parts see
General Catalogue
 for both versions
 – Dust cap for T-Handle 1C-340

Adapter system for insulation doors

PROGRAM 1001



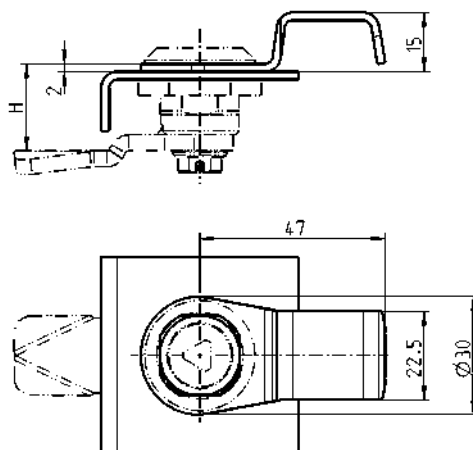
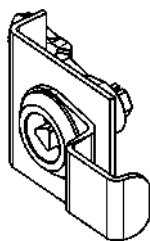
Adapter system pre-assembled with handle or insert, inserted into the aperture and held by locking nut M6.

Insert, m.s. zinc plated key guide zinc die chrome plated safety nut m.s.zinc plated		Door gauge Ts	Square adapter m.s.z.pl.	Spacer piece aluminium
Square 7	1001-U21	20	–	–
Square 8	1001-U22	40	1x1001-65	1001-69
Double bit 5	1001-U23	50	1x1001-66	1001-70
Adapter for interior handle m.s.zinc plated		60	1x1001-67	1001-71
	1001-65	80	2x1001-66	1001-72
Int. handle polyamide black		100	2x1001-67	1001-73
	1000-U829			

Further parts see page
– Rod control K1-610
– Key K1-650

Further parts see
General Catalogue
– T- or L-Handle A = 26 2A-140
– Anti-rotation device 1C-360

Finger pull; Dust cap PROGRAM 1000



Finger pull m.s. black powder coated

1000-359

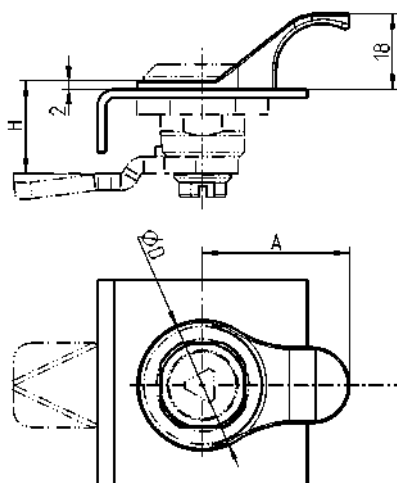
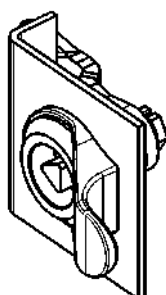
IP 65 achieved by:

Flat seal

1000-23

Attention:

The H-dimension will be reduced by 2 mm with the finger pull installed.



Finger pull polyamide GF black

for housing with head diameter Ø 28

; D = 31, A = 35

1000-358

for housing with head diameter Ø 30 and 32

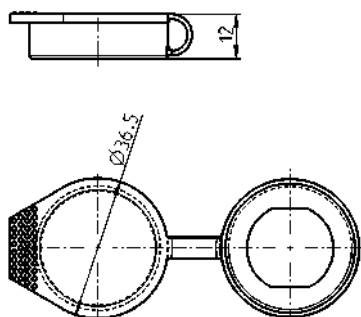
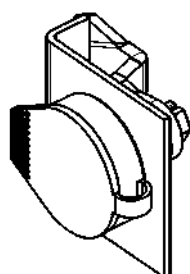
; D = 35, A = 36

1000-358-01

IP 65 achieved by:

Flat seal

1000-23



Dust cap polyethylene black

1000-97-01

Attention:

The H-dimension will be reduced by 2 mm when this dust cap is installed.

Further parts see page
– Quarter turns

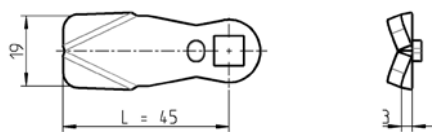
K1-410

Cams

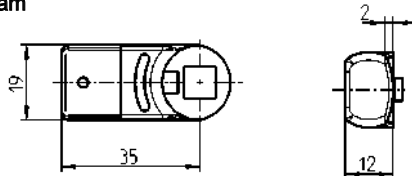
PROGRAM 1000



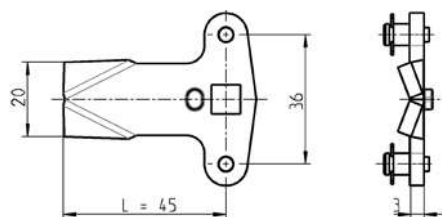
Version 1
Cam



Version 2
Cam

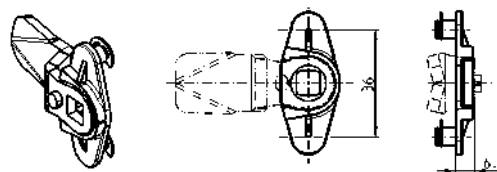


Version 3
Cam with rod control



Version 4

Rod control for steel cam or stainless steel cam



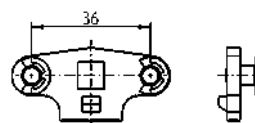
Rod control zinc die,
zinc plated circlip m.s. zinc plated

1000-U776

Rod control AISI 316,
circlip stainless steel

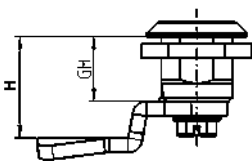
1000-U776-PH

Version 5
Rod control



2-point rod control m.s. zinc plated

1000-U167



Cam with catch material as requested

H dimensions for GH =

12	18	22	28	30	31	36	39	40	50	60	Version 1	
											L = 45	
											m.s. zinc pl.	
-	4	8	14	16	17	22	25	26	36	46	1000-112	
-	6	10	16	18	19	24	27	28	38	48	1000-22	
2	8	12	18	20	21	26	29	30	40	50	1000-113	
4	10	14	20	22	23	28	31	32	42	52	1000-21	
7	13	17	23	25	26	31	34	35	45	55	1000-20	
8	14	18	24	26	27	32	35	36	46	56	1000-19	
9	15	19	25	27	28	33	36	37	47	57	-	
10	16	20	26	28	29	34	37	38	48	58	1000-18	
12	18	22	28	30	31	36	39	40	50	60	1000-17	
14	20	24	30	32	33	38	41	42	52	62	1000-16	
16	22	26	32	34	35	40	43	44	54	64	1000-15	
18	24	28	34	36	37	42	45	46	56	66	1000-14	
19	25	29	35	37	38	43	46	47	57	67	1000-27	
20	26	30	36	38	39	44	47	48	58	68	1000-50	
22	28	32	38	40	41	46	49	50	60	70	1000-13	
24	30	34	40	42	43	48	51	52	62	72	1000-28	
26	32	36	42	44	45	50	53	54	64	74	1000-26	
28	34	38	44	46	46	52	55	56	66	76	1000-12	
29	35	39	45	47	48	53	56	57	67	77	1000-11	
30	36	40	46	48	49	54	57	58	68	78	1000-51	
32	38	42	48	50	51	56	59	60	70	80	1000-52	
34	40	44	50	52	53	58	61	62	72	82	1000-25	
36	42	46	52	54	55	60	63	64	74	84	1000-53	
38	44	48	54	56	57	62	65	66	76	86	1000-54	
39	45	49	55	57	58	63	66	67	77	87	1000-10	
41	47	51	57	59	60	65	68	69	79	89	1000-55	
44	50	54	60	62	63	68	71	72	82	92	1000-56	

minus offset
↑
straight version
↓
plus offset



Cam with catch


 Cam without catch
on request

Note:

This catalogue page does not show all available cams.

Other versions such as:

- Cam without catch
- Cams with other H and L dimension
- Cams with recess in the opposite direction
- etc.

please ask.

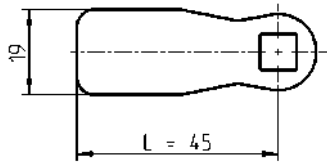
Version 1		Version 1		Version 2	Version 3
L = 45 AISI 304	L = 45 AISI 316	L = 35 m.s. zinc pl.	L = 35 polyamide black ①	polyamide black	m.s. zinc pl.
-	-	-	-	-	1000-U63
1000-221	1000-221-PD	-	-	-	1000-U21
-	-	-	-	-	1000-U64
1000-223	1000-223-PD	-	-	-	1000-U22
-	-	-	-	-	1000-U23
1000-225	1000-225-PD	-	-	-	1000-U24
-	-	-	1000-5043-SI	-	-
-	-	-	-	-	1000-U25
1000-227	1000-227-PD	1000-5046	1000-5046-SI	1000-386-18	1000-U26
1000-228	1000-228-PD	1000-5161	-	1000-386-20	1000-U27
1000-179	1000-179-PD	1000-5119	-	1000-386-22	1000-U28
1000-229	1000-229-PD	-	-	1000-386-24	1000-U29
-	-	-	-	-	1000-U30
1000-230	1000-230-PD	-	-	-	1000-U31
1000-180	1000-180-PD	1000-5164	-	1000-386-28	1000-U32
-	-	-	-	1000-386-30	1000-U33
-	-	-	-	-	1000-U34
-	-	-	-	-	1000-U35
-	-	-	-	-	1000-U36
-	-	-	-	-	1000-U37
-	-	-	-	-	1000-U38
-	-	-	-	-	1000-U39
-	-	-	-	-	1000-U40
-	-	-	-	-	1000-U41
-	-	-	-	-	1000-U42
-	-	-	-	-	1000-U43
-	-	-	-	-	1000-U44

 ①
only for light doors and covers

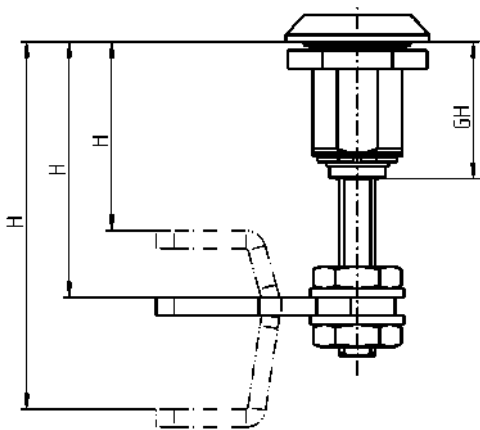
 Further parts see page
– Locks

 K1-410
to K1-550

Cam m.s. for GH = 31, 45 and 64
Compression latch
PROGRAM 1000



straight cam



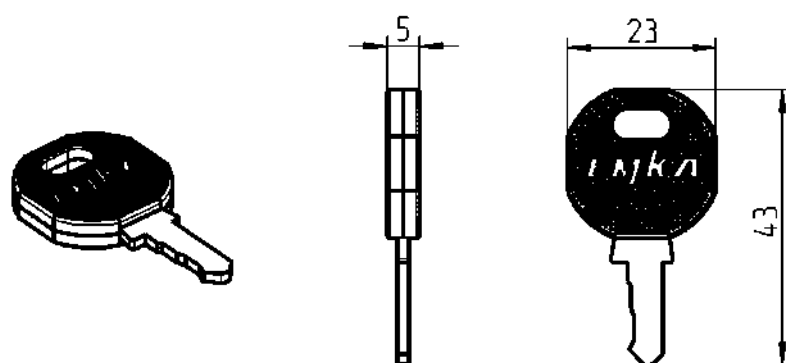
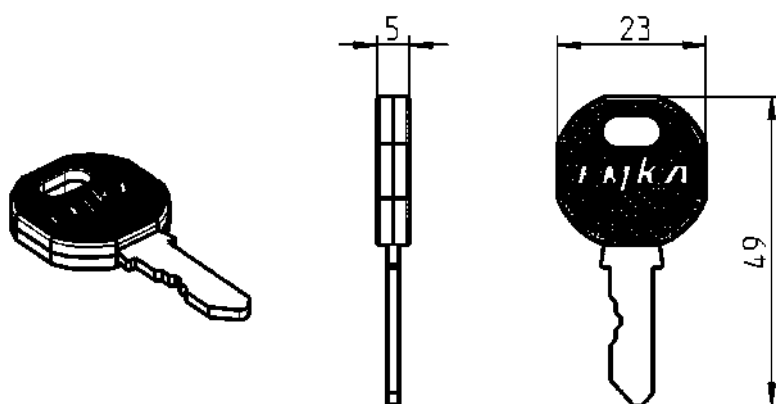
cranked cam

Cam m.s. zinc pl.		
for GH = 31	H	GH = 31
straight	38 - 58	1000-476
offset +/- 14 mm	24 - 44 ; 52 - 72	1000-478
offset +/- 26 mm	12 - 32 ; 64 - 84	1000-477
for GH = 45	H	GH = 45
straight	52 - 72	1000-476
offset +/- 14 mm	38 - 58 ; 66 - 86	1000-478
offset +/- 26 mm	26 - 46 ; 78 - 98	1000-477
for GH = 64	H	GH = 64
straight	71 - 91	1000-476
offset +/- 14 mm	57 - 77 ; 85 - 105	1000-478
offset +/- 26 mm	45 - 65 ; 97 - 117	1000-477

Note:
Insert of cranked cam optionally
positive or negative

Further parts see page
– Compression latch
with insert

K1-530



EMKA-key silver steel with grip polyamide black for program
1000, 1048, 1091, 1109, 1121, 1125, 1150, 1160, 1180, 1200, 1210, 1225,
2100, 2400,

Keyed EK 333

1108-U35

Keyed different

1108-U36-Keyed

for program 1022, 1109, 1200, 2100, 2400

Keyed 2233X

1108-U37

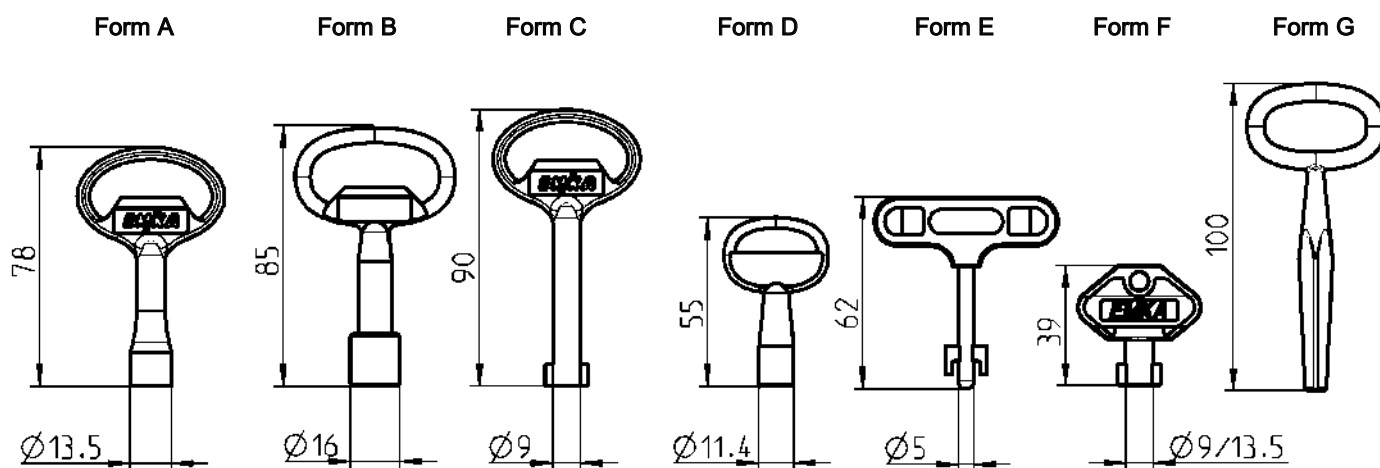
Keyed different

1108-U38-Keyed

Note:
Further keys on request

Key

PROGRAM 1004



Keys can be supplied on request with customer logo

Minimum quantity: Form A, B, C, D

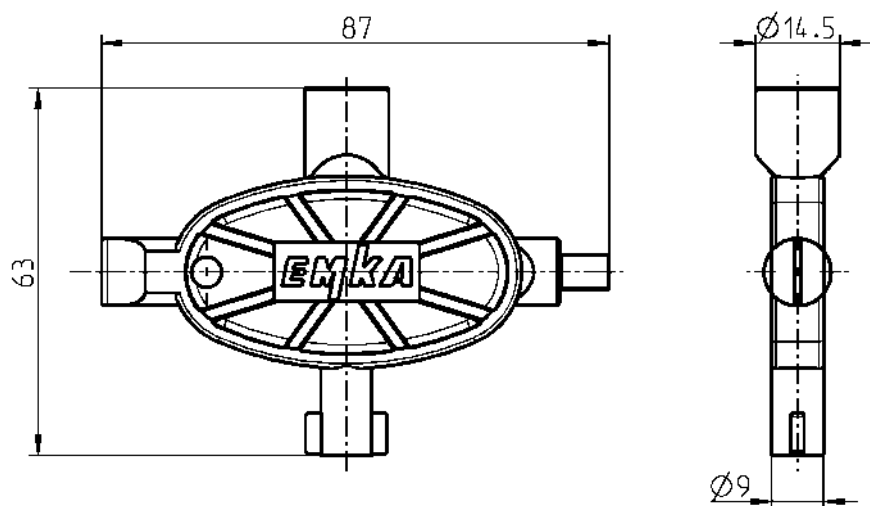
2,000 pieces

Minimum quantity: Form E, F, H

5,000 pieces

Key form	A	B	C	D	E	F	G
	Zinc die black powder coated	Zinc die black powder coated	Zinc die black powder coated	Zinc die black powder coated	zinc die/ polyamide	Polyamide GF black	GTW nickel plated
Square 6	1004-18	–	–	1004-20	–	1004-37	–
Square 7	1004-01	–	–	–	–	1004-36	–
Square 8	1004-02	–	–	–	–	1004-35	–
Triangular 6.5	–	–	–	1004-21	–	–	–
Triangular 6.5 CNOMO	1004-26	–	–	–	–	–	–
Triangular 7	1004-03	–	–	–	–	1004-39	–
Triangular 8	1004-04	–	–	–	–	1004-38	–
Triangular 10	–	1004-24	–	–	–	–	–
Crown type	–	1004-31	–	–	–	–	–
Eastern Europe Ø13 half round	–	1004-42	–	–	–	–	–
Double bit 3	–	–	1004-05	–	–	1004-34	–
Double bit 5	–	–	1004-06	–	–	1004-33	–
Male hexagon 11.1	–	1004-54	–	–	–	–	–
Daimler Benz	1004-17	–	–	–	–	–	–
FIAT	–	–	–	–	1004-41	–	–
Square male 6	1004-29	–	–	–	–	–	–
Square male 8	1004-30	–	–	–	–	–	–
Square male 6 – 9.5	–	–	–	–	–	–	1004-19
Hexagon head 8 with bore hole	1004-49	–	–	–	–	–	–
Tube	–	–	–	1004-51	–	–	–

Form H

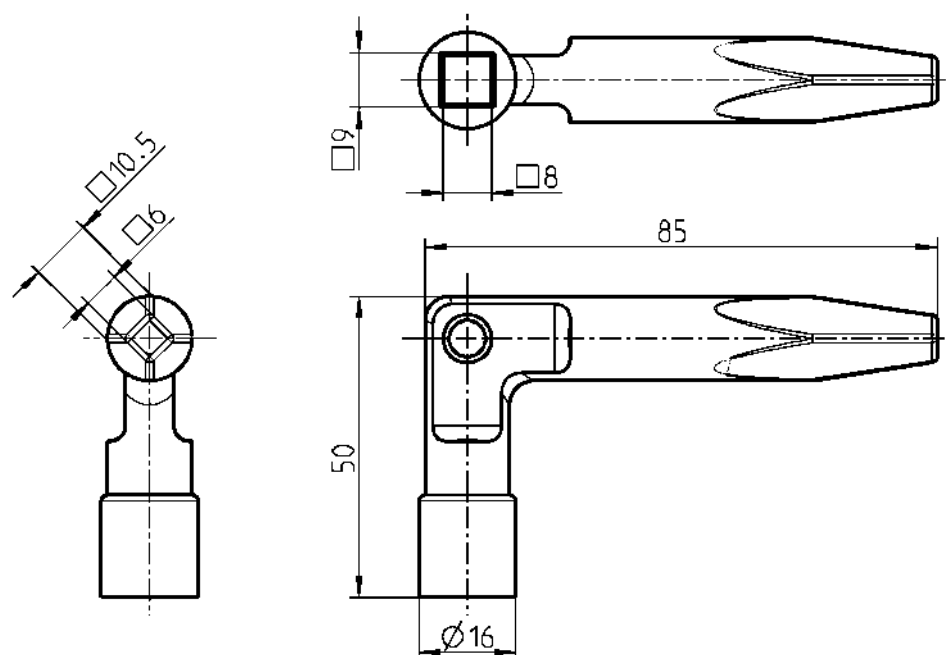


Form H, universal key polyamide blue

Square male 6, Square 8, double bit 5 and slot insert

1004-48

Form I



Form I, railway version, zinc die black

Square 8 - 9, square male 6 - 10.5

1004-52

Stainless steel key
on request





1 Locks



2 Hinges

Latch-Hinges
Screw-on hinges
Accessories for hinges

K2-110
K2-210
K2-410



3 Gasketings



4 Accessories

Compression Latch-Hinge small with or without pressure relief

PROGRAM 1091



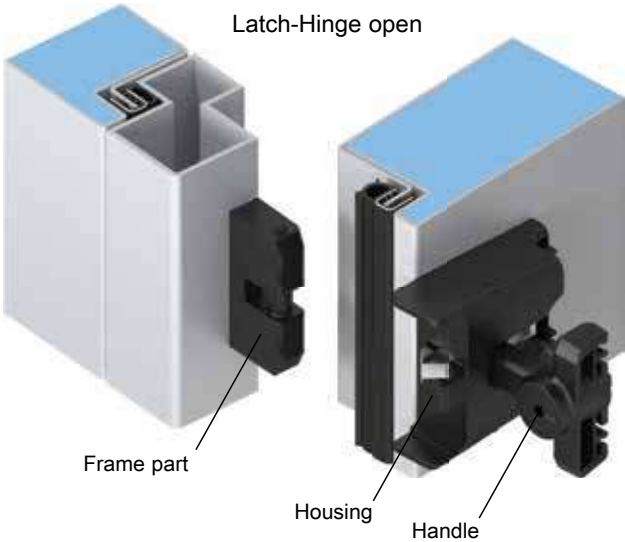
Compression Latch-Hinge locked



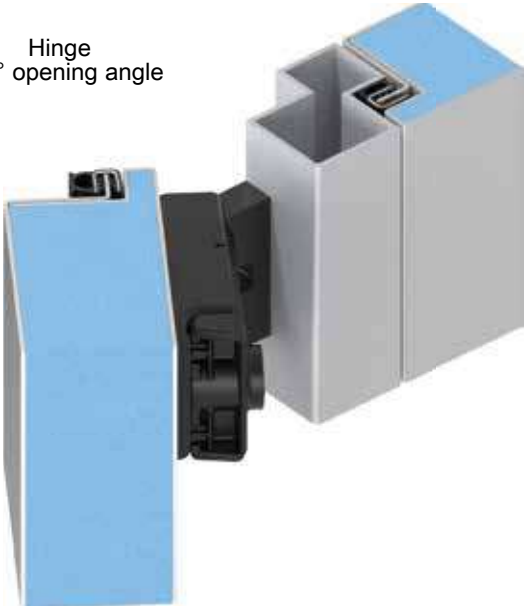
Latch-Hinge with pressure relief, handle unlocked



Latch-Hinge open

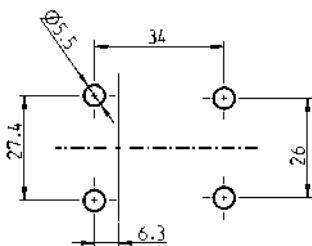
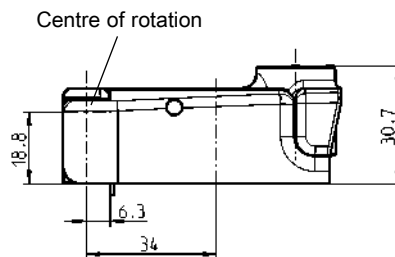
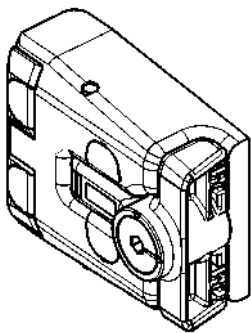


Hinge
180° opening angle

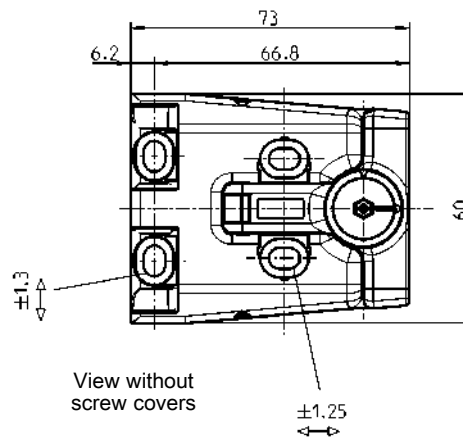


Product benefits

- The favourable pivot point of the handle makes a seal compression of 5 mm possible using low actuation forces
- Door or panel can be removed by unlatching the handles on both sides
- 2D Adjustable (tolerance compensation)
- Latch hinge can be mounted as one piece with the door / flap in place
- Right or left hinged
- Hinge 180° opening angle
- Optional HVACR Compression Latch-Hinge available with safety feature "pressure relief"
- ATEX compliant explosion protection version available on request
- Patent submitted



Frame part Housing
Cut out



Compression Latch-Hinge small:
housing, handle, frame part polyamide GF black;
screw covers polyamide black;
latch zinc die nickel-plated and Top Coat;
pin AISI 303; with spring

① insert hexagon female BS 4 polyamide GF black

② Round cylinder Series 9000 zinc die with stainless steel cap and dust cap.
Each round cylinder has two silver steel nickel plated reversible keys at a ring.

	① Insert	② Keyed 9081	② Keyed different
without pressure relief	1091-U169	on request	on request
with pressure relief	1091-U168	on request	on request

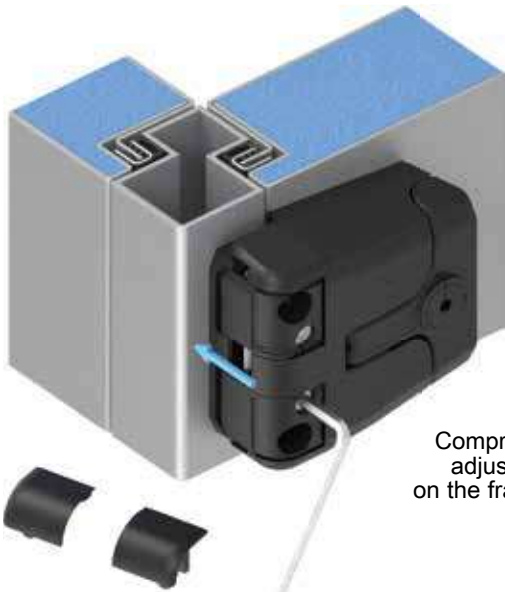
Further inserts
on request

Compression Latch-Hinge medium with or without pressure relief

PROGRAM 1091



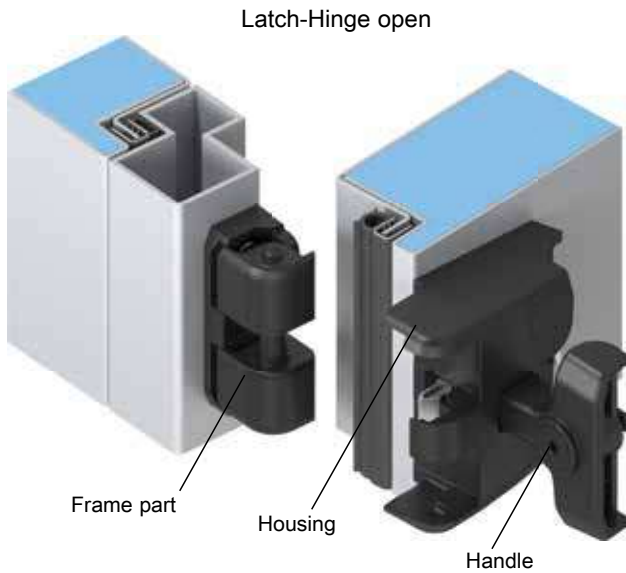
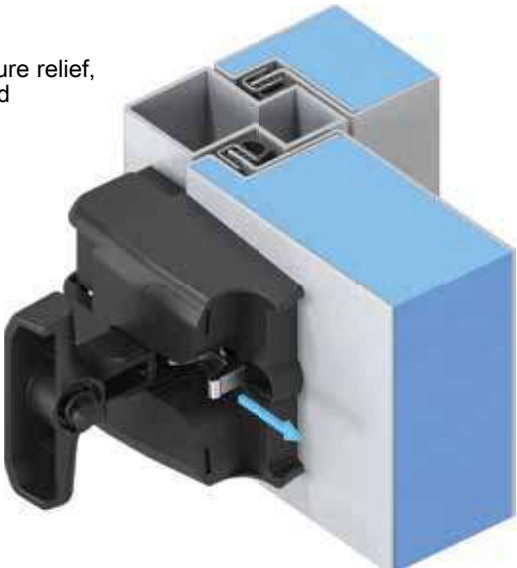
Compression Latch-Hinge locked



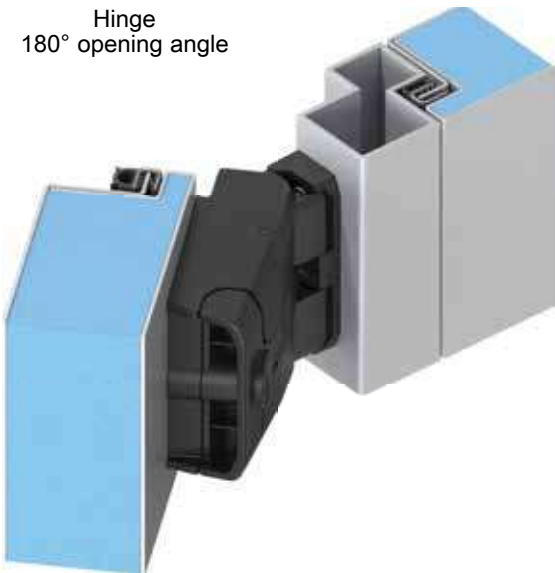
Compression adjustable on the frame part



Latch-Hinge with pressure relief, handle unlocked



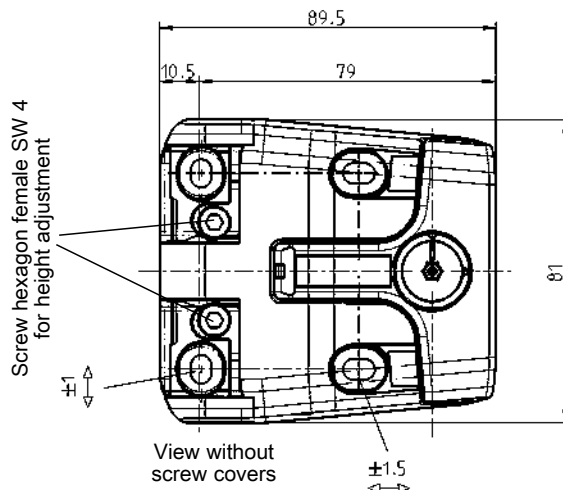
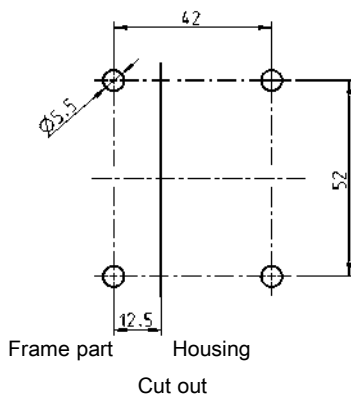
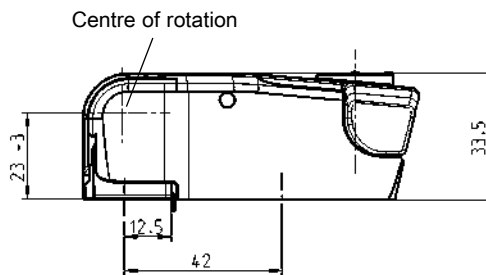
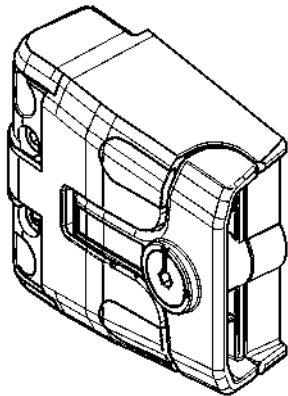
Latch-Hinge open



Hinge 180° opening angle

Product benefits

- When the door is closed, the latch is adjustable by 3 mm to achieve perfect alignment
- The favourable pivot point of the handle makes a seal compression of 5 mm possible using low actuation forces
- Door or panel can be removed by unlatching the handles on both sides
- 3D adjustable (tolerance compensation)
- Latch hinge can be mounted as one piece with the door / flap in place
- Right or left hinged
- Hinge 180° opening angle
- Optional HVACR Compression Latch-Hinge available with safety feature "pressure relief"
- ATEX compliant explosion protection version available
- Patent submitted



Compression Latch-Hinge medium:
housing, handle, screw covers polyamide GF black;
top and bottom frame part zinc die black powder-coated;
latch zinc die nickel-plated and Top Coat; pin AISI 303;
screw for height adjustment, washer and nut m.s. zinc-plated; with spring

① Insert hexagon female BS 4 polyamide GF black

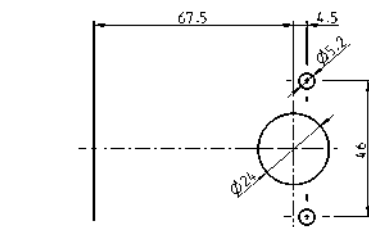
② Round cylinder Series 9000 zinc die with stainless steel cap and dust cap.
Each round cylinder has two silver steel nickel plated reversible keys at a ring.

	① Insert	② Keyed 9081	② Keyed different
without pressure relief	1091-U146	on request	on request
with pressure relief	1091-U147	on request	on request

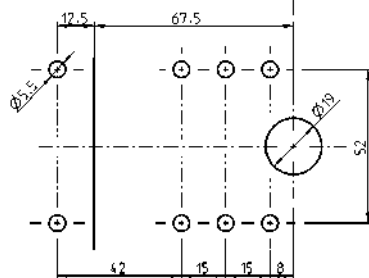
Further inserts
on request

Product benefits

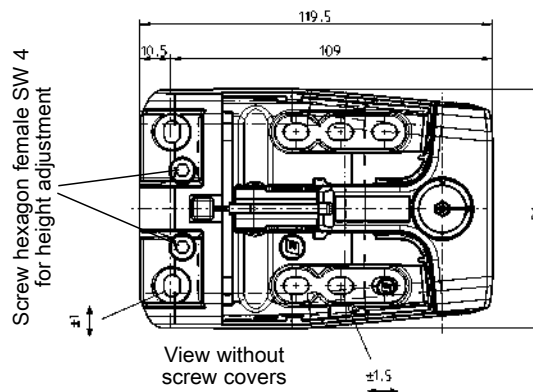
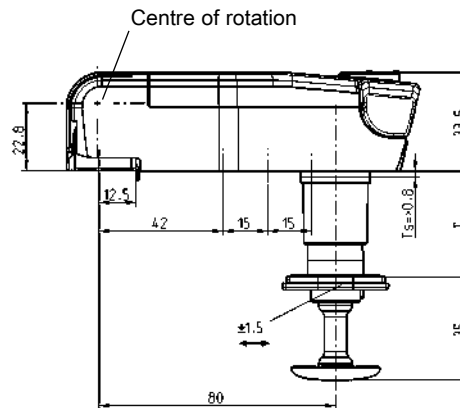
- When the door is closed, the latch is adjustable by 3 mm to achieve perfect alignment
- The favourable pivot point of the handle makes a seal compression of 5 mm possible using low actuation forces
- Door or panel can be removed by unlatching the handles on both sides
- 3D adjustable (tolerance compensation)
- Latch hinge can be mounted as one piece with the door / flap in place
- Right or left hinged
- Hinge 180° opening angle
- Optional HVACR Compression Latch-Hinge available with safety feature “pressure relief”
- ATEX compliant explosion protection version available on request
- Patent submitted



Cut out rear



Frame part Housing
Cut out front



Screw hexagon female SW 4
for height adjustment

View without
screw covers

Compression Latch-Hinge large:
housing, handle, screw covers polyamide GF black;
top and bottom frame part zinc die black powder-coated;
latch zinc die nickel-plated and Top Coat; pin AISI 303;
screw for height adjustment, washer and nut m.s. zinc-plated; with springs and seal

① insert hexagon female BS 4 polyamide GF black

② Round cylinder Series 9000 zinc die with stainless steel cap and dust cap. Each round cylinder has two silver steel nickel plated reversible keys at a ring.

	① Insert	② Keyed 9081	② Keyed different
without pressure relief	1091-U190	1091-U194	1091-U198
with pressure relief	1091-U191	1091-U195	1091-U199

Further inserts
on request

Emergency opening
bezel, wrap polyamide GF black; trigger polyamide GF red; with foamed seal

T = 30 +4.5 mm	1091-U175-30
T = 50 +4.5 mm	1091-U175-50
T = 60 +4.5 mm	1091-U175-60
T = 40, 70 - 100 mm	on request

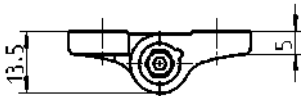
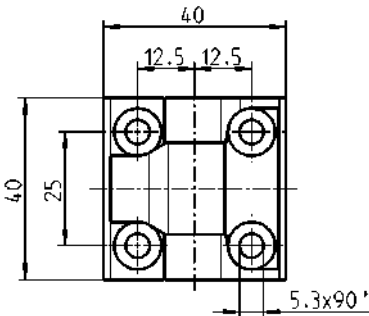
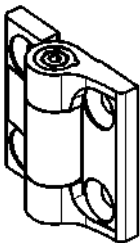
180° Screw-on torque hinge with adjustment function

PROGRAM 1056



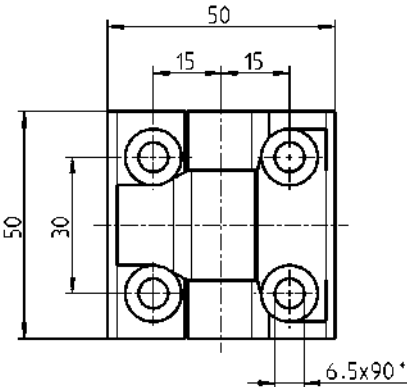
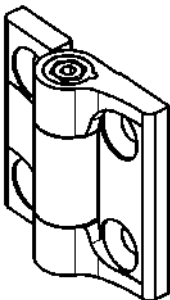
Product benefits

- Adjustable torque
- Holds any position continuously at adequate load
- Constant torque across 180° adjustment range
- Same torque while opening and closing
- Compatible with all hinges of the 1056 program with identical cut out
- Can replace door stops, cover stays or gas springs depending on installation location



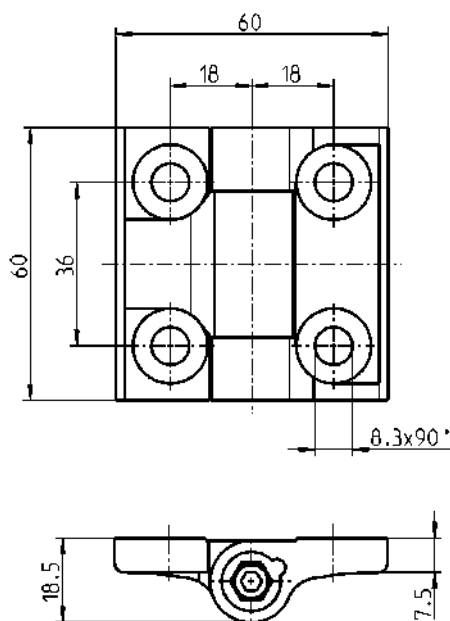
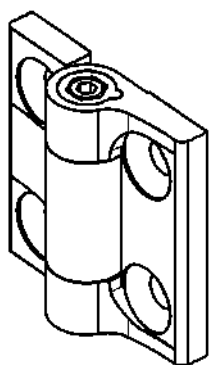
180° Screw-on torque hinge zinc-die black powder-coated for countersunk screw M5; friction cone polyacetal POM; screw and nut m.s. zinc-plated

Nm	max. tightening torque of screw in Nm	
to ~ 2	0,5	1056-U6-01



180° Screw-on torque hinge zinc-die black powder-coated for countersunk screw M6 (2D nut can be used); friction cone polyacetal POM; screw and nut m.s. zinc-plated

Nm	max. tightening torque of screw in Nm	
to ~ 4	0,75	1056-U10-01



180° Screw-on torque hinge zinc-die black powder-coated for countersunk screw M8; friction cone polyacetal POM; screw and nut m.s. zinc-plated

Nm	max. tightening torque of screw in Nm
to ~ 6.5	1,5

1056-U14-01

Dimensioning / Calculation:

The number of hinges in case of covers depends on the size and the weight of the cover. We are pleased to help you with the dimensioning of the hinges on request.

Example:

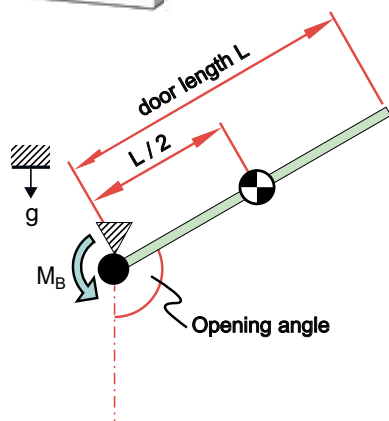
Opening angle: $\alpha = 120^\circ$
 Door length: $L = 0,8 \text{ m}$
 Door mass: $m = 3,5 \text{ kg}$
 Gravitational pull: $g = 9,81 \text{ m/s}^2$
 Torque hinge: $M = 6,5 \text{ Nm}$
 Number of hinges: $n = ?$

Formula:

$$\text{Total } M = \left(\frac{L \times m \times g \times \sin \alpha}{2} \right)$$

Result:

11.9 Nm = 2 hinges of item no. 1056-U14-01



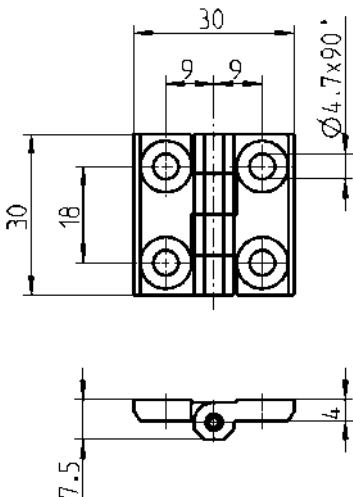
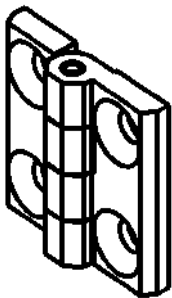
Torque hinge

The hinge can be set continuously in any position. There it remains at the same position. The torque is similar when opening and closing.

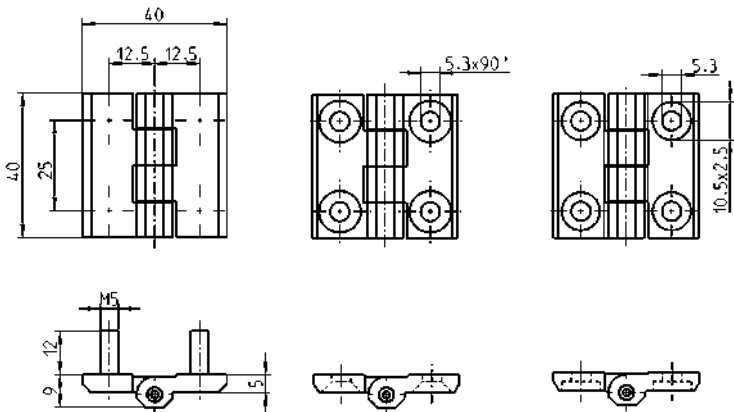
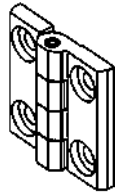
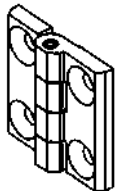
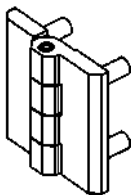
Application:

This torque hinge is suitable for doors and covers.

180° Screw-on hinge
PROGRAM 1056



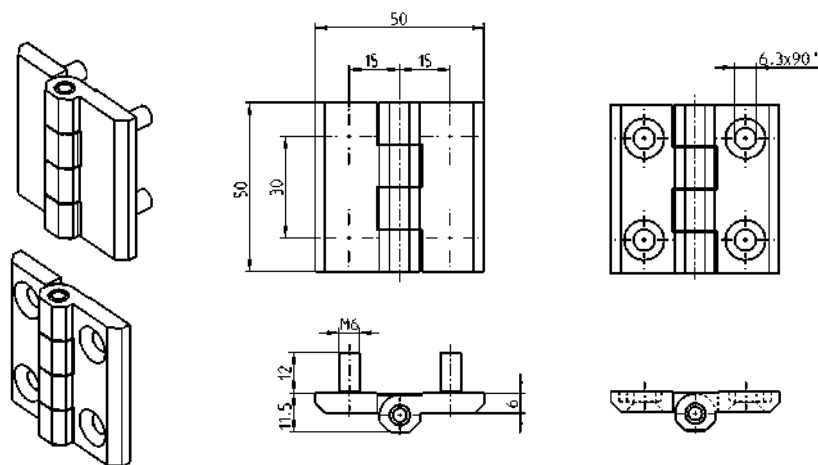
Screw-on hinge for countersunk screw M4; zinc-die surface at buyer's option; pin stainless steel	
black powder-coated	1056-U60
chrome-plated	1056-U61



Screw-on hinge zinc die, Polyamide black or stainless steel; grub screw M5 stainless steel				
	Pin	Threaded stud M5	for countersunk screw M5	for cylinder screw M5
Zinc die chrome plated	Stainless steel	1056-U3	1056-U5	–
Zinc die black powder coated	Stainless steel	1056-U4	1056-U6	–
Polyamide black	Stainless steel	–	1056-U30	1056-U30-01
Polyamide black	Polyamide	–	1056-U41	–
AISI 316 bright polished	Stainless steel	–	1056-U5-PPPH	–
AISI 316 polished	Stainless steel	–	1056-U5-PH	–

180° Screw-on hinge

PROGRAM 1056

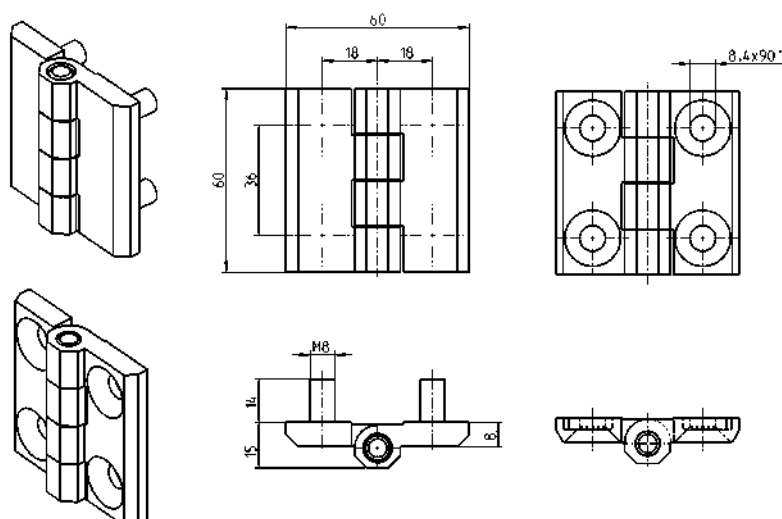


Screw-on hinge zinc die, polyamide black or stainless steel; grub screw M6 stainless steel

① = (2D-nut possible)	Pin	Threaded pin M6	① for countersunk screw M6
Zinc die chrome plated	Stainless steel	1056-U7	1056-U9
Zinc die black powder coated	Stainless steel	1056-U8	1056-U10
Polyamide black	Stainless steel	–	1056-U31
Polyamide black	Polyamide	–	1056-U42
AISI 316 bright polished	Stainless steel	–	1056-U9-PPPH
AISI 316 polished	Stainless steel	–	1056-U9-PH

Further parts see page
– 2D-nut

K2-410

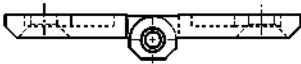
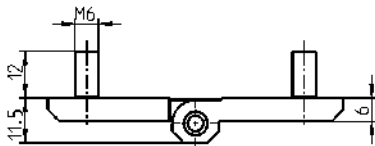
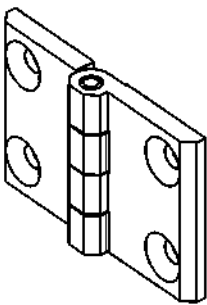
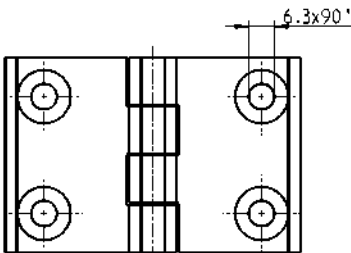
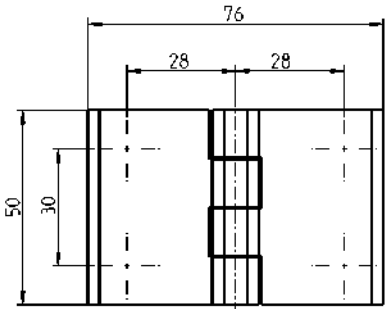
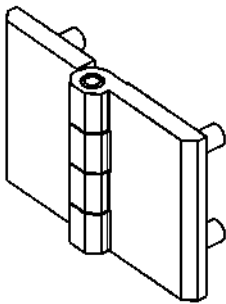


Screw-on hinge zinc-die or stainless steel; threaded stud M8 stainless steel

	Pin	Threaded stud M8	for countersunk screw M8
Zinc die chrome plated	Stainless steel	1056-U11	1056-U13
Zinc die black powder coated	Stainless steel	1056-U12	1056-U14
AISI 316 bright polished	Stainless steel	–	1056-U13-PPPH
AISI 316 polished	Stainless steel	–	1056-U13-PH

270° Screw-on hinge

PROGRAM 1056

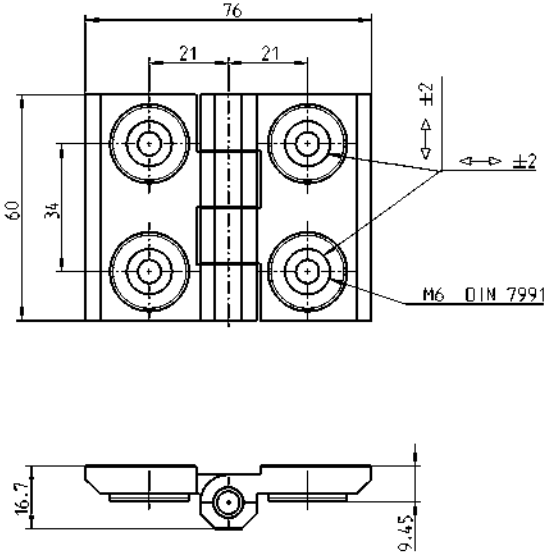
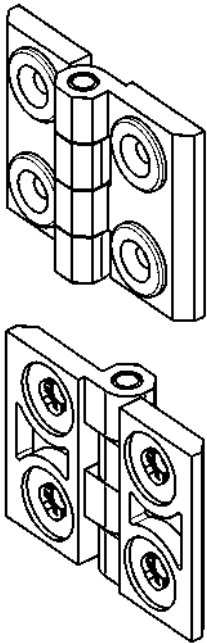


Screw-on hinge zinc-die or stainless steel; threaded stud M6 stainless steel			
	Pin	Threaded pin M6	① for countersunk screw M6
① = (2D-nut possible)			
Zinc die chrome plated	Stainless steel	1056-U15	1056-U17
Zinc die black powder coated	Stainless steel	1056-U16	1056-U18
AISI 316 bright polished	Stainless steel	–	1056-U17-PPPH
AISI 316 polished	Stainless steel	–	1056-U17-PH

Further parts see page
– 2D-nut

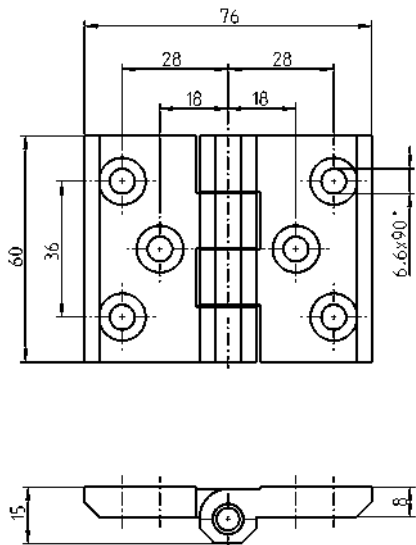
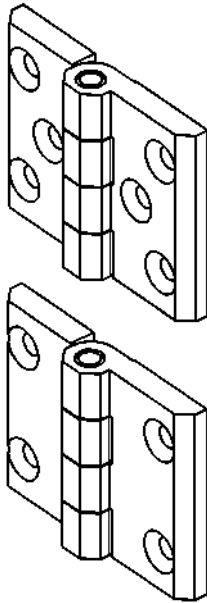
K2-410

180° Screw-on hinge
PROGRAM 1056

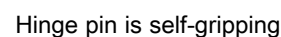


Recess for rivet nut M6 customary in trade

2D screw-on hinge zinc die black powder coated; pin stainless steel		Adjustable ± 2 mm in the horizontal and vertical direction
	1056-U27	



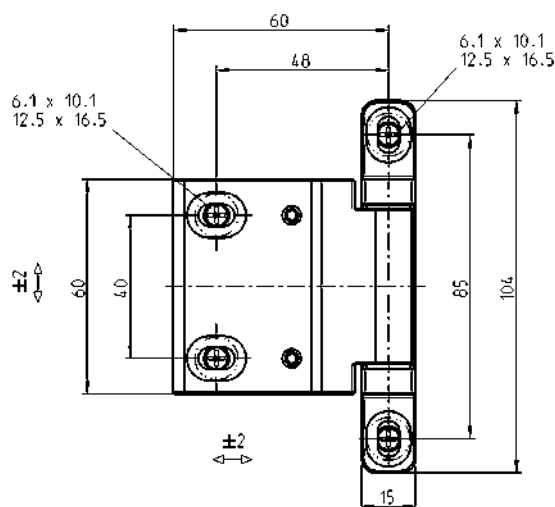
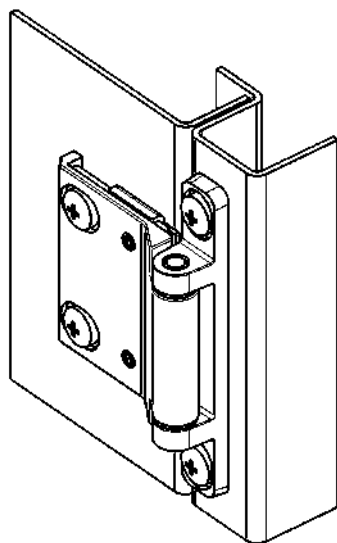
Screw-on hinge zinc-die black powder-coated; pin stainless steel		Further parts see page – 2D-nut	K2-410
with 4 countersunk holes (2D-nut possible)	1056-U29		
with 6 countersunk holes (2D-nut possible)	1056-U28		



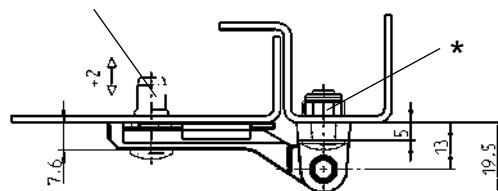
**small head = DIN ISO 2009,
2010, 7046-1, 7046-2, 7047**

180° 3D-Screw-on hinge

PROGRAM 1054



* Centre part prepared for pan head rivet nut M6



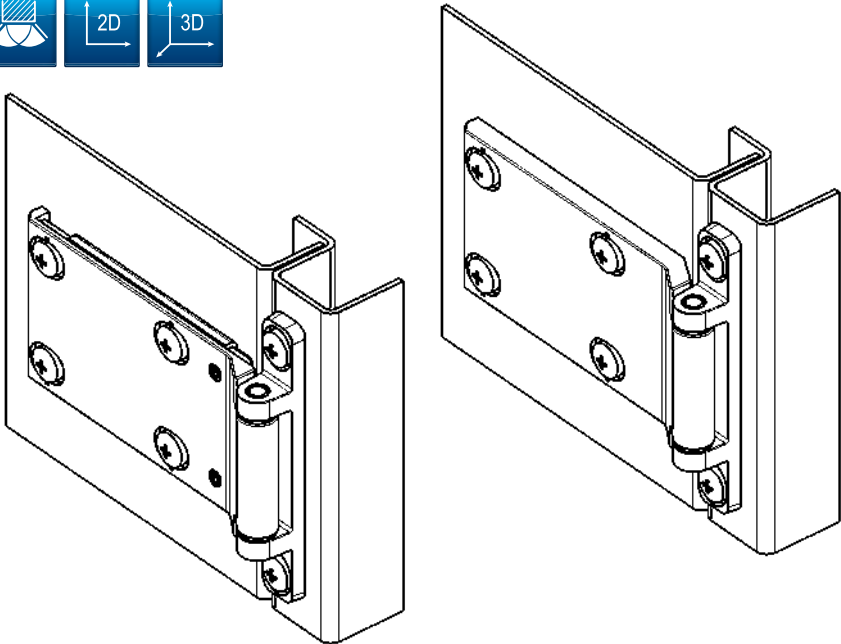
3D Screw-on hinge door part and centre part zinc-die black powder-coated;
axle, pin and washers stainless steel; bushes plastic

1054-U42-01

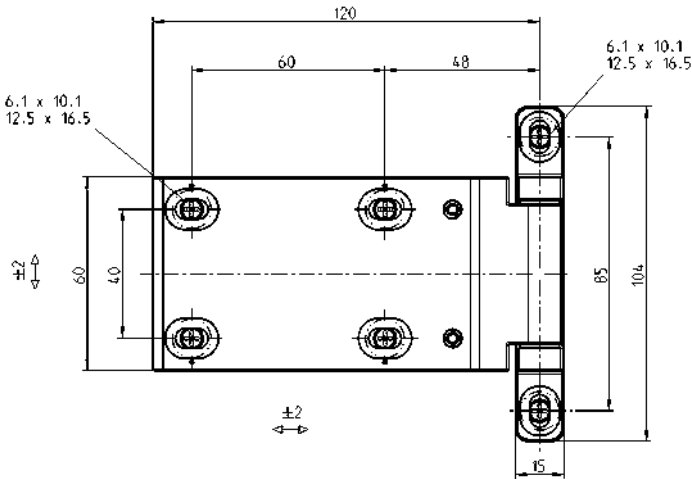
* Oval head screw DIN ISO
7380 M6x...
not included in
the scope of supply

180° 2D- and 3D-Screw-on hinge

PROGRAM 1054



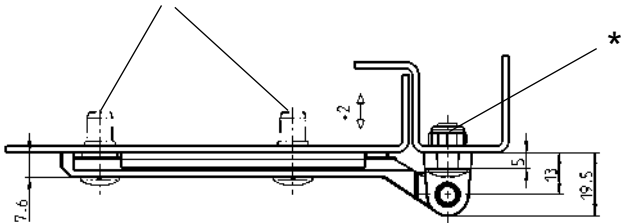
3D-Screw-on hinge



2D-Screw-on hinge

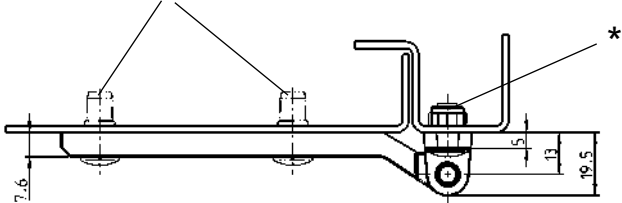


* Centre part prepared for pan head rivet nut M6



3D-Screw-on hinge

* Centre part prepared for pan head rivet nut M6



2D-Screw-on hinge

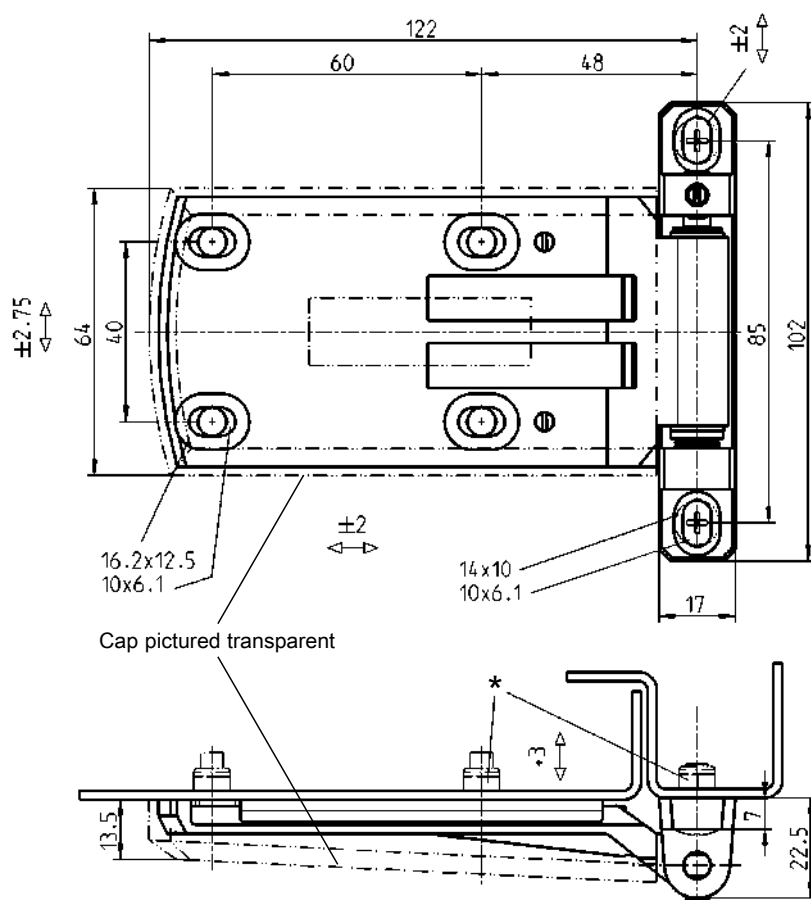
3D Screw-on hinge door part and centre part zinc die black powder-coated; axle, pin and washers stainless steel; bushes plastic	
	1054-U43-01
2D-Screw-on hinge door part and centre part zinc die black powder-coated; axle stainless steel; bushes plastic	
	1054-U44-01

* Oval head screw DIN ISO 7380
M6x...
not included in
the scope of supply

180° 3D-Screw-on hinge PROGRAM 1054



Logo: 49 x 14.5 x 0.6
Multicolour pad printing possible.



3D-Screw-on hinge zinc die black p.c., axle stainless steel,
pin and washer steel zinc pl., cap and bush polyamide black

RH version

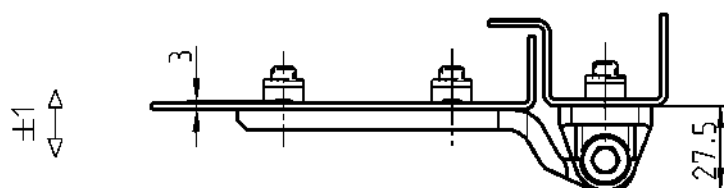
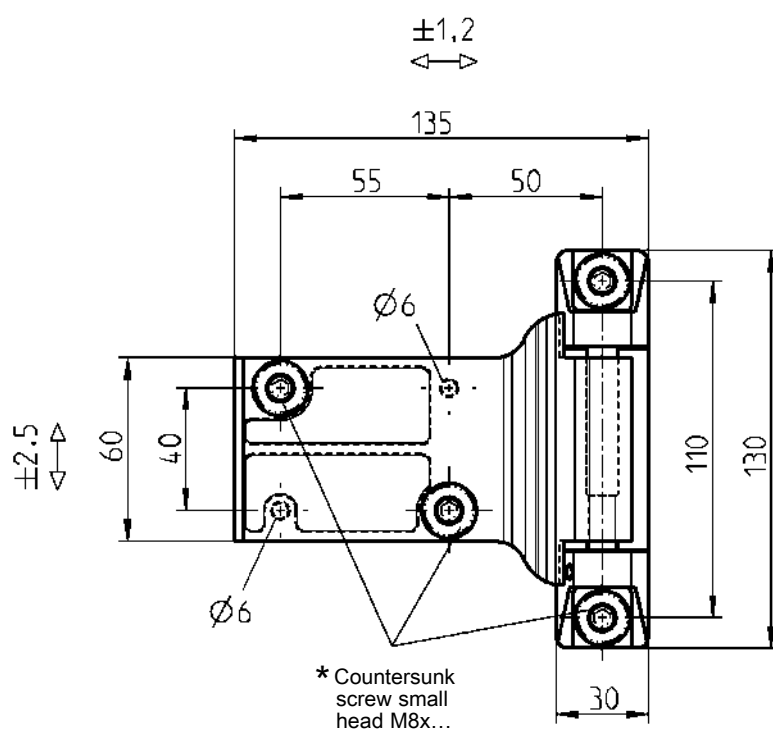
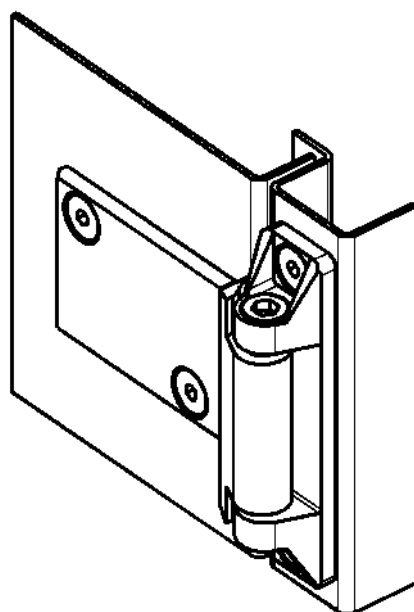
1054-U36-RE

LH version

1054-U36-LI

* not included in the scope of supply

Version for RH use respectively version for LH use is created by turning the hinge pin with flag.



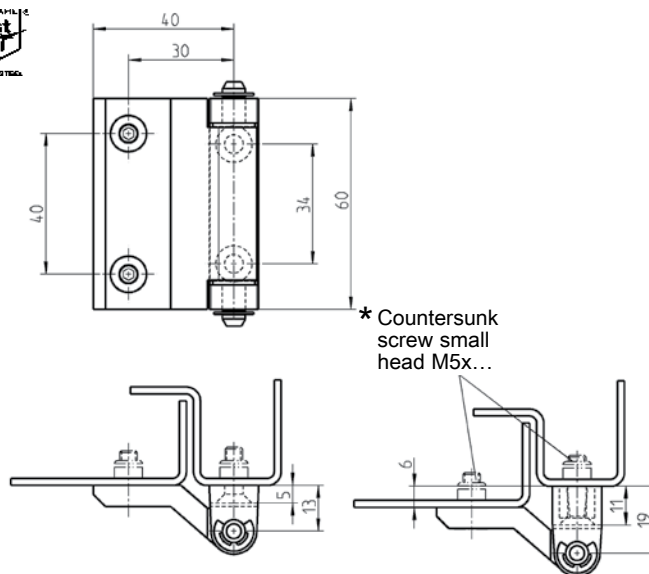
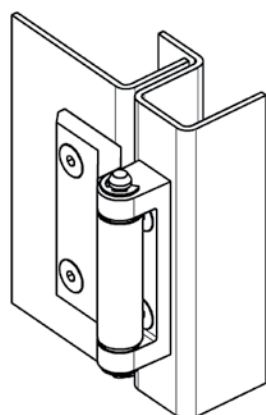
3D-Screw-on hinge zinc die, shaft and grub screw stainless steel		
	LH version	RH version
black powder-coated	1054-U32	1054-U31
raw	1054-U32-01	1054-U31-01

* not included in the scope of supply

small head = DIN ISO 2009, 2010, 7046-1, 7046-2, 7047

180° Screw-on hinge

PROGRAM 1054



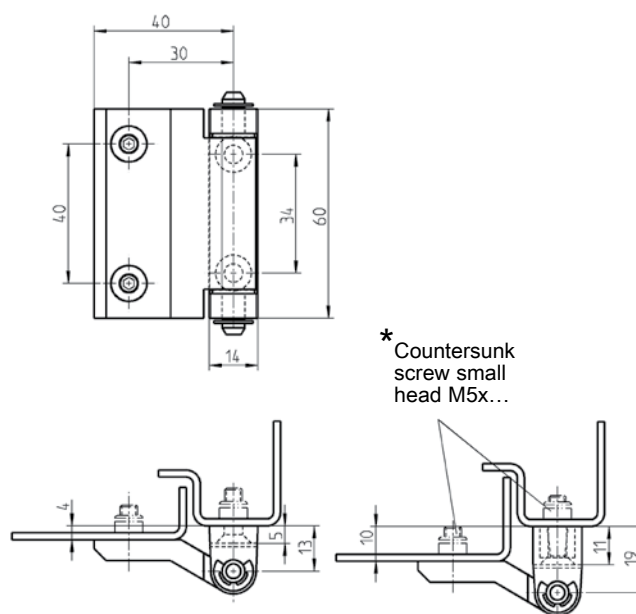
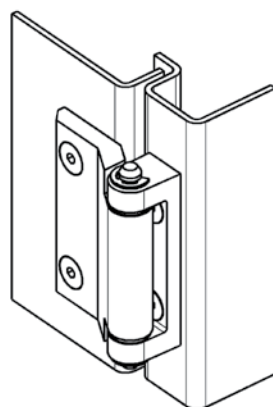
Screw-on hinge zinc die, pin and washer m.s. zinc plated and bush polyamide

	straight	6 mm higher
chrome-plated	1054-U4	1054-U27
black powder-coated	1054-U5	1054-U28
raw	1054-U22**	1054-U29**

** = Minimum order quantity 1000 pcs.

Screw-on hinge AISI 316 and bushes polyamide

	1054-U5-PH	-
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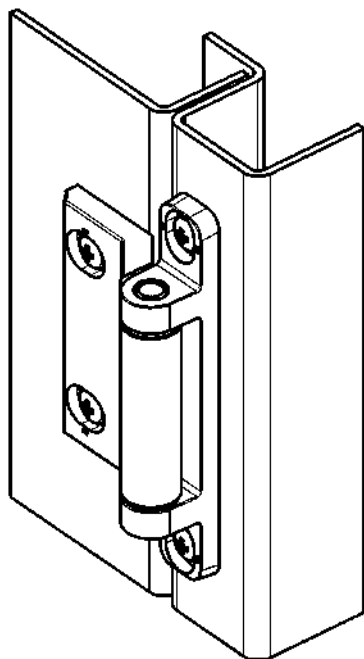
Screw-on hinge zinc die, pin and washer m.s. zinc plated and bush polyamide

	4 mm higher	10 mm higher
chrome-plated	1054-U7	1054-U19
black powder-coated	1054-U10	1054-U20
raw	1054-U18**	1054-U21**

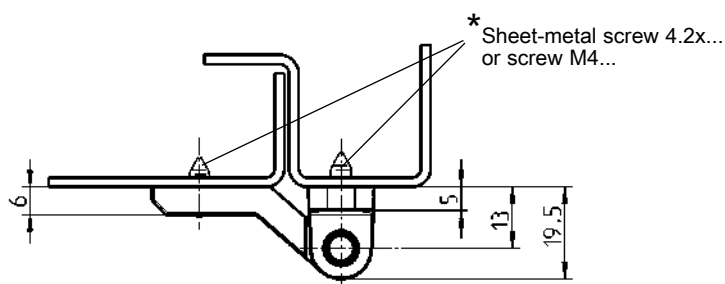
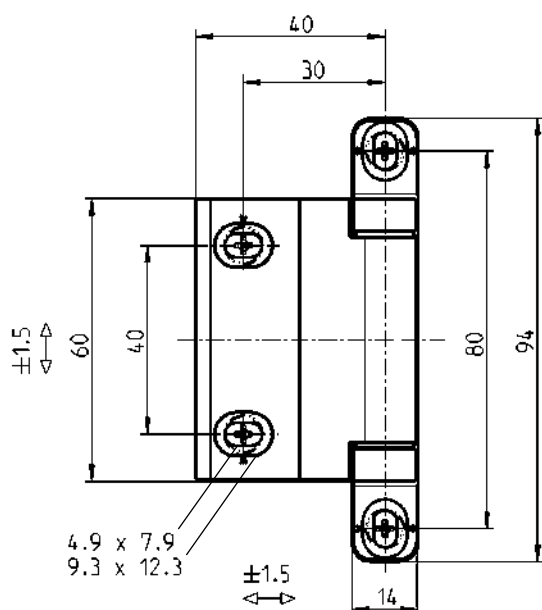
** = Minimum order quantity 1000 pcs.

* not included in the scope of supply

small head = DIN ISO 2009, 2010, 7046-1, 7046-2, 7047



Frame part

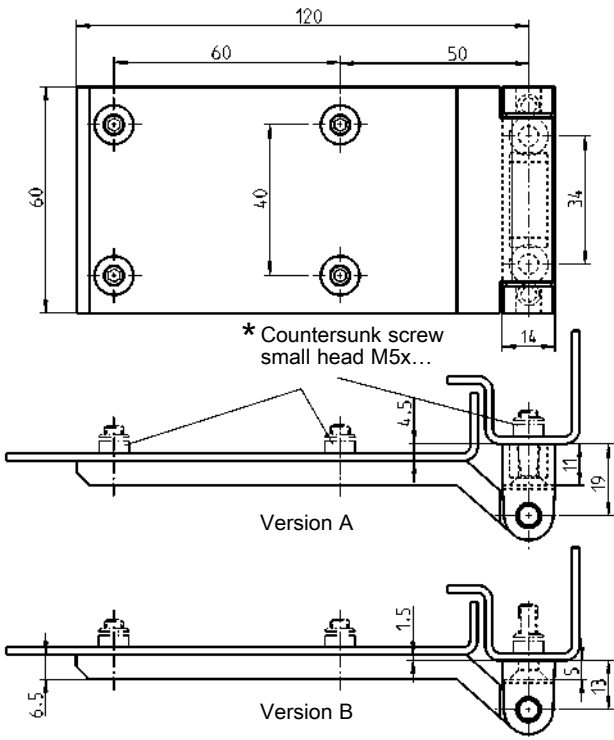
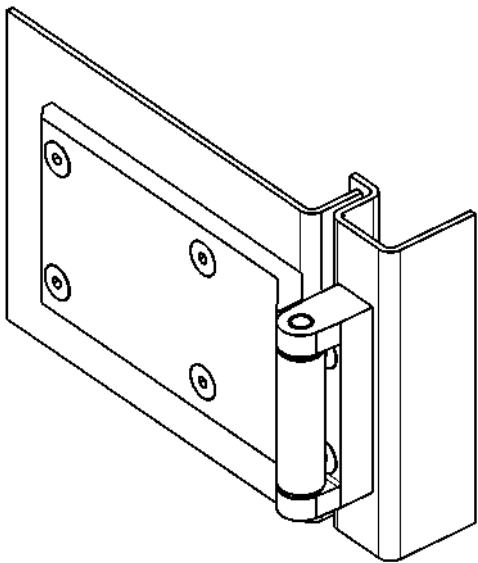


* not included in
the scope of supply

180° 2D-hinge zinc die black powder coated, pin stainless steel, bushes polyamide

1054-U37

180° Screw-on hinge
PROGRAM 1054

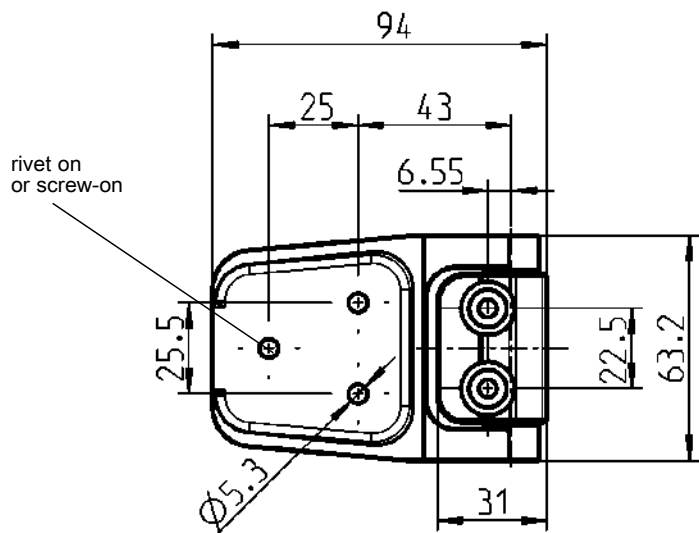
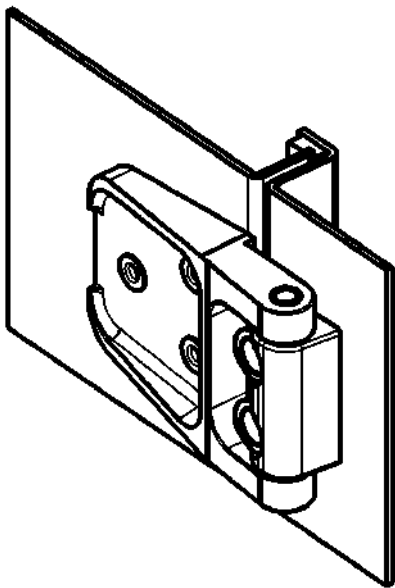


Frame part

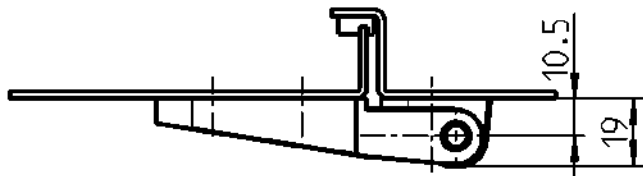
Screw-on hinge zinc die, pin stainless steel and bushes polyamide		
	Version A	Version B
black powder-coated	1054-U11	1054-U6
raw	1054-U13**	1054-U12**
** = Minimum order quantity 1000 pcs.		

* not included in the scope of supply

small head = DIN ISO 2009, 2010, 7046-1, 7046-2, 7047



Application
for double skin doors



Hinge polyamide GF black, pin m.s. zinc pl.

1091-U117

2D-nut example for screw-on hinge

PROGRAM UNIVERSAL

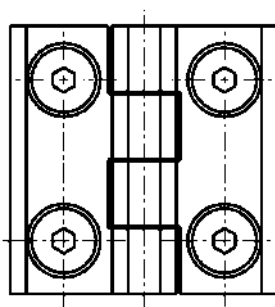
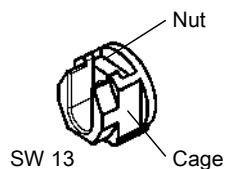
Example
for assembling hinge for in-line door



Cut out
Ø10



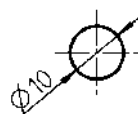
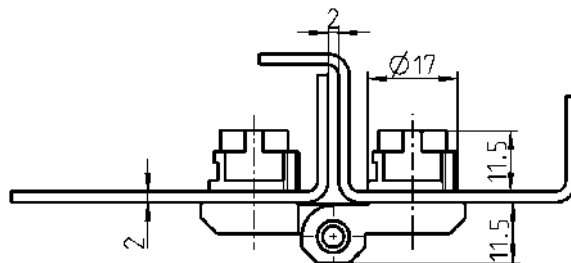
Attention:
Every 2D-nut is adjustable
± 2 mm in the horizontal
and vertical direction.



Convenience:

1. Identification of adjustability is not possible from the outside.
2. By using the 2D-nut it is possible to use every front-mounted hinge or catch as a 2D-hinge or 2D-catch.

Other thread parameters
on request



Cut out for 2D-nut M6

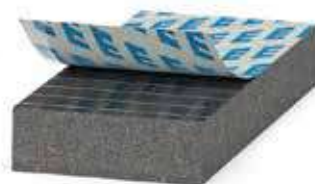
2D-nut cage zinc die zinc plated, nut m.s. zinc plated

M6 with SW 13

1056-U51

Further parts see page
– Screw-on hinge

K2-230
to K2-250





1 Locks



2 Hinges



3 Gasketings

Information	K3-100
Gaskets self-gripping	K3-210
Gasketings secured in an U-section	K3-310
Cell sponge rubber	K3-410
Edge protection	K3-510
Examples	K3-610



4 Accessories

Info
1 Locks
2 Hinges
3 Gasketings
4 Accessories
Index



EMKA specializes in extruding rubber and plastic in a variety of profiles. At own plants in the UK and Spain rubber profiles are made in a wide range of types as standard and custom made solution.

As carrier sections meshed tape and metalreinforced strips can be used and textile yarn can be worked in. Moreover, flocking is also possible.

In the further processing department fixed lengths, vulcanised rings and frames can be made to size. Some EMKA branches have machines for vulcanising corner joints. The application of adhesive tape or lubricant varnish completes the range.

EMKA know-how guarantees top quality.

EMKA manufactures more than 1,500 sealing profiles.

Many of which are catalogue standard parts, some custom-made unique copies. Either way, for every requirement the right sealing.

On request we supply our high quality goods with the respective certification and / or test panels for further tests at customer's site.

Product categories	Materials
Sealing profiles	EPDM
Rubber profile	NBR
Edge protection	SBR
Foam rubber	PVC
Moulded rubber parts	TPE
Plastic profiles	TPV
	PP

The gasketings that are shown in the product catalog are mainly selected according to VDI 6022.

Many more gasketings can be found in the EMKA general catalog as well as on the internet at www.emka.com

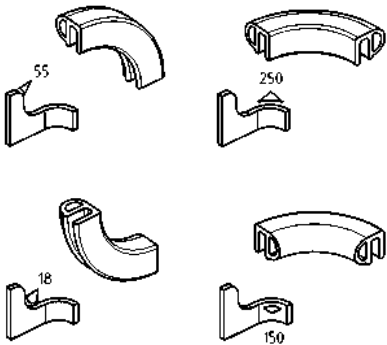
Information on VDI Guideline 6022: Hygienic standards for ventilation and air-conditioning systems

In guideline 6022 issued by "Verein Deutscher Ingenieure" (VDI) – Association of German Engineers – you can find a description of the minimum hygienic standards for ventilation and air conditioning systems. The guideline formulates requirements that have to be observed for planning, installation, operation and maintenance of ventilation and airconditioning systems in order to guarantee absolute faultless hygienic condition of the systems as well as the outside air inlets for the air-conditioned premises.

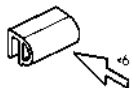
VDI guideline 6022 is valid for the domain of builders, architects, engineers, ventilation planners, manufacturers of air-conditioning systems, machine builders, authorising bodies, operators, service companies, stakeholders of room users (e.g. staff associations or committees as well as company physicians and public health officers).

In line with the latest technical development and scientific knowledge, this guideline is intended to guarantee a precise operation and condition of ventilation and air-conditioning systems by means of preventive technical provisions.

Minimum bending radius



Compression





Clip-on profile with sealing balloon or sealing lip top

The clip-on profile is clipped onto the designated edge.

There are various shape and material types to choose from. Depending on the installation situation a sealing balloon or sealing lip is to be used.



Clip-on profile with sealing balloon or sealing lip on the side

The clip-on profile is clipped onto the designated edge.

There are various shape and material types to choose from. Depending on the installation situation a sealing balloon or sealing lip is to be used.



Insert profile with sealing balloon on top

The insert profile is inserted into the respective designated duct.

There are various heights, widths and types to choose from.

Frames and rings information

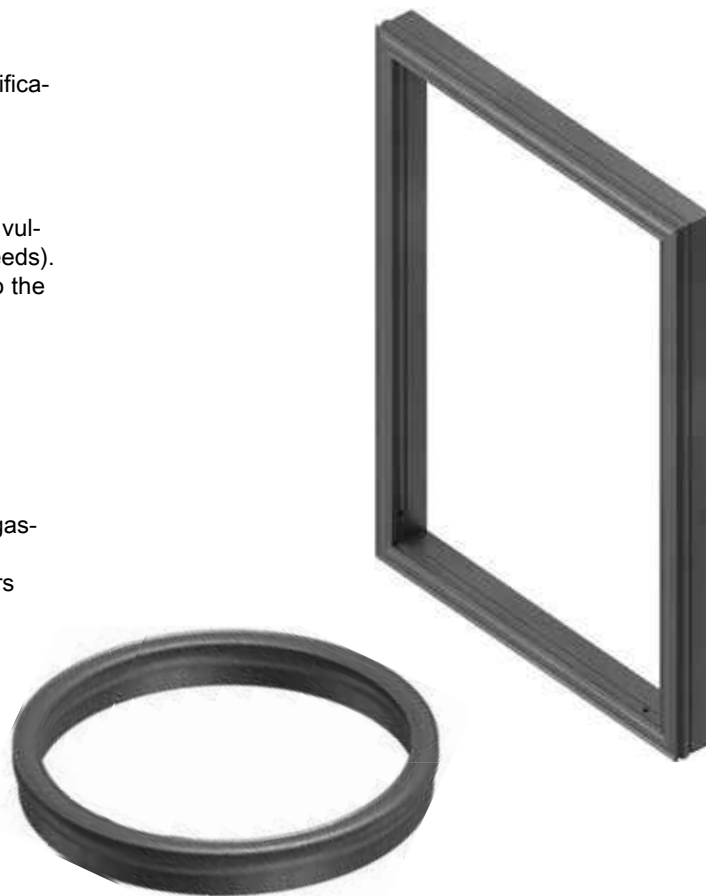
Readily customised frames and rings according to customer specifications possible.

We offer numerous assembly possibilities for the known profiles in fixed lengths.

For frames and rings the butt and corner joints can be glued, film vulcanised or realised by injection moulding (formed corners / end feeds). Possibly arising tool costs needs to be clarified beforehand due to the required assembly option.

Product benefits

- The exact and time-intensive mitre-cutting of the gasket or the observance of the given minimum bending radius of the gaskets are not necessary
- The assembled frames and rings facilitate the mounting on doors and cabinets frames
- No leakiness at butt ends and mitre joints



Glueing

The most simple process is to glue two profile ends.

For all rings, vent holes are strongly recommended as the compression force increases in a closed ring.

A better solution to glueing two profiles is film vulcanization.



Film vulcanising

Film vulcanising is a permanent and durable process.

A foil of the same material is inserted between the profile ends that are to be vulcanised. The required time for film vulcanising is longer than for glueing.



Injection moulding

Injection moulding means formed corners and end injection moulding.

Injection molding is e.g. a process to produce special corners for frame. The example next shows ① a rounded frame while the clamping range ② is produced rectangular.

This option is not possible for vulcanising gasket ends with mitre joint ①.

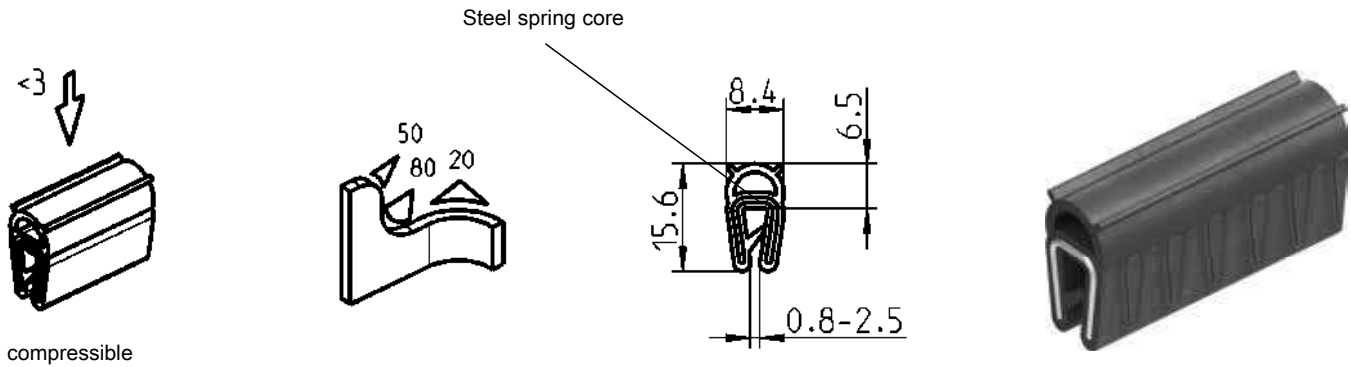


Gasketings self-gripping

PROGRAM 1011

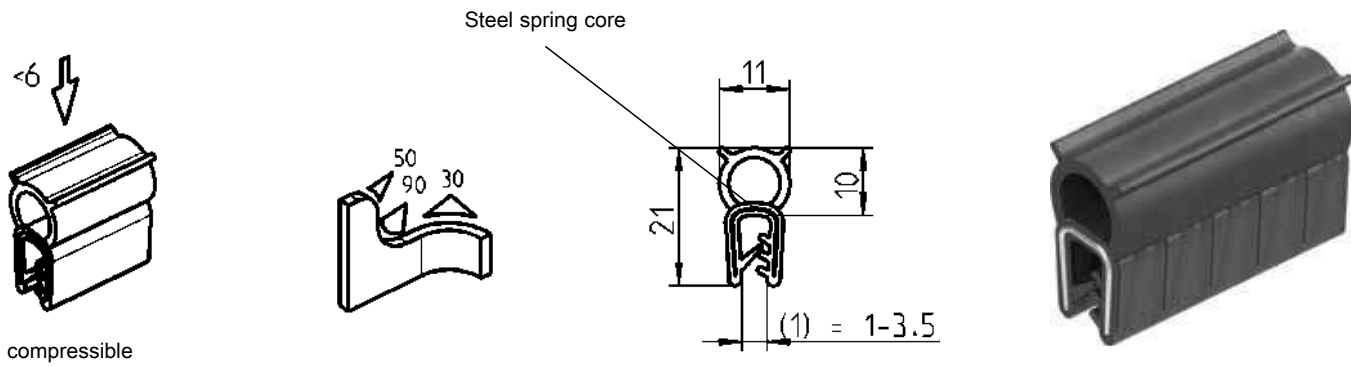


According to VDI 6022



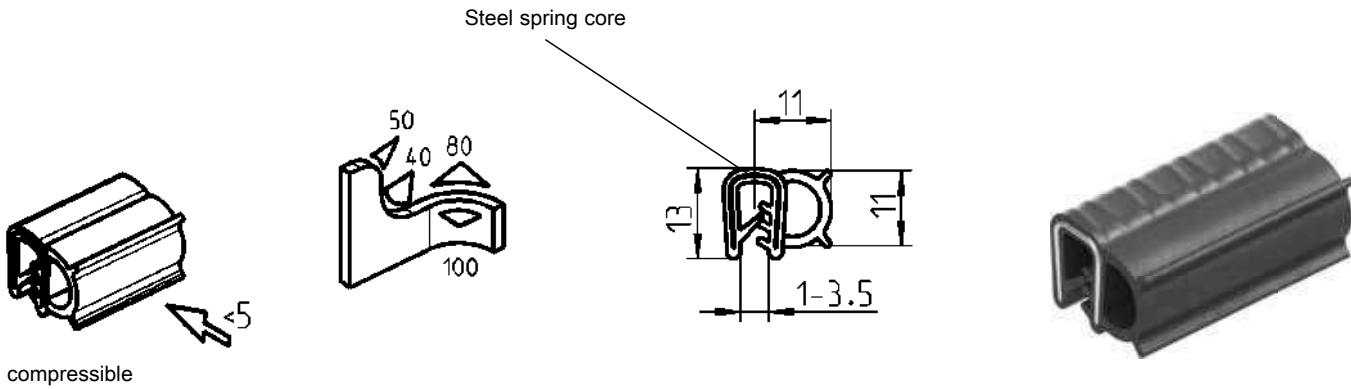
Gasket profile (EPDM) black 45 ± 5 Shore A	
Clamping profile (EPDM) black 60 ± 5 Shore A	
	1011-10-09

According to VDI 6022



Gasket profile (EPDM) black 45 ± 5 Shore A	
Clamping profile (EPDM) black 60 ± 5 Shore A	
	1011-05-09

According to VDI 6022

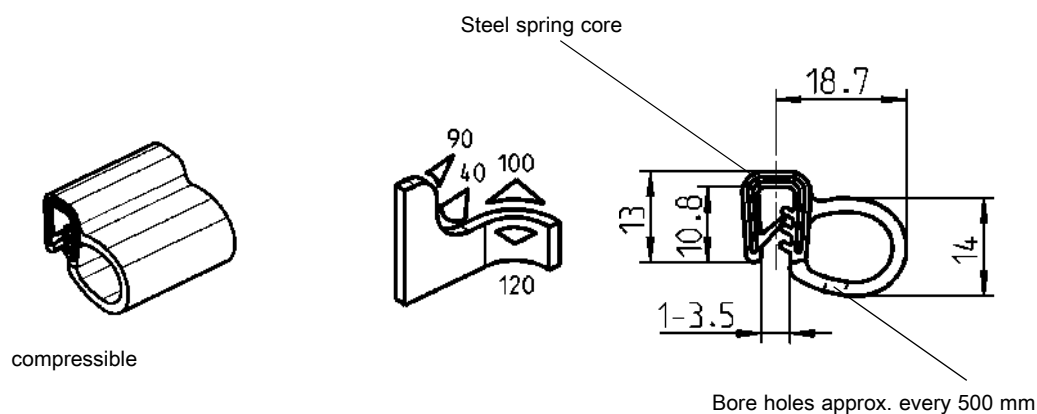


Gasket profile (EPDM) black 45 ± 5 Shore A	
Clamping profile (EPDM) black 60 ± 5 Shore A	
	1011-06-09

Gasketings self-gripping

PROGRAM 1011

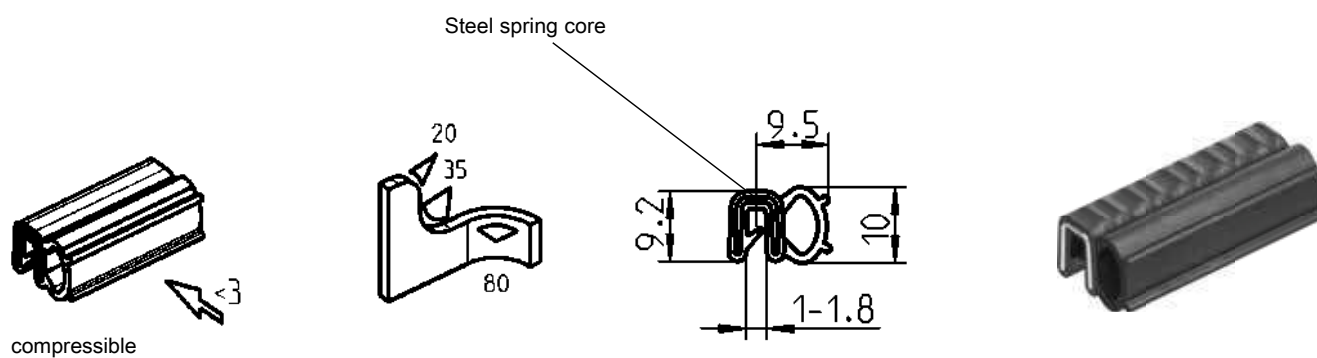
According to VDI 6022



Gasket profile sponge rubber (EPDM) black (clamping profile EPDM 64 ± 5 Shore A)

1011-19-09

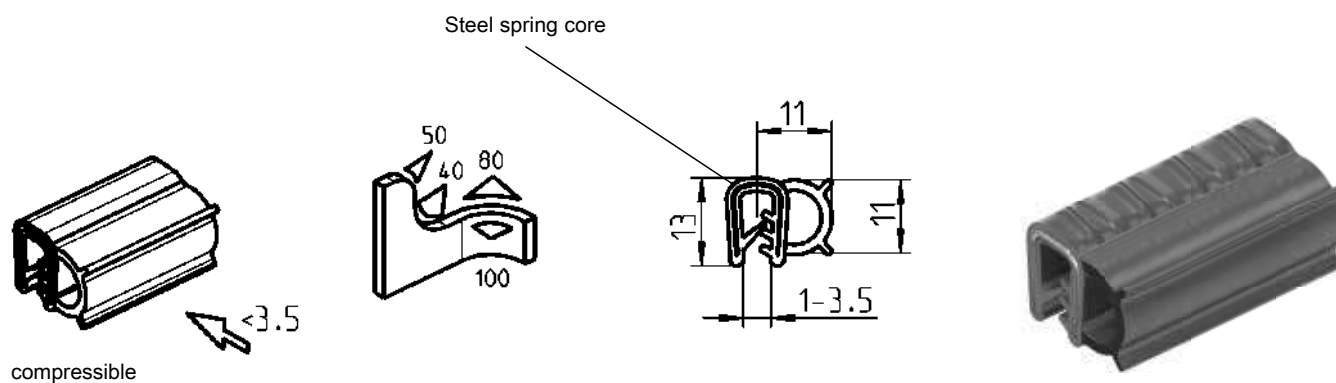
According to VDI 6022



Gasket profile sponge rubber (EPDM) black (clamping profile EPDM 64 ± 5 Shore A)

1011-S102

According to VDI 6022



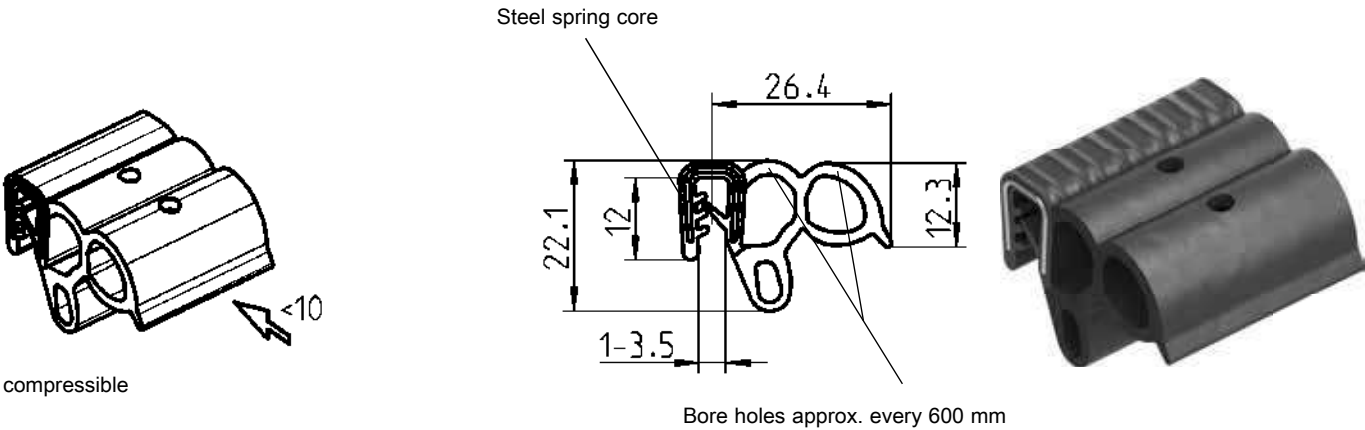
Gasket profile sponge rubber (EPDM) black (clamping profile EPDM 64 ± 5 Shore A)

1011-S122

Gasketings self-gripping;
Gasketings secured in an U-section
PROGRAM 1003, 1011

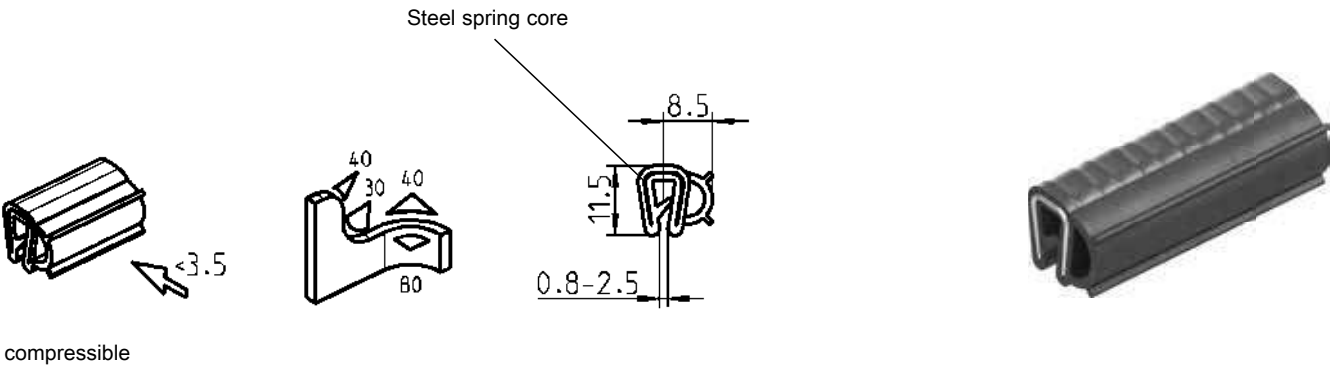


According to VDI 6022



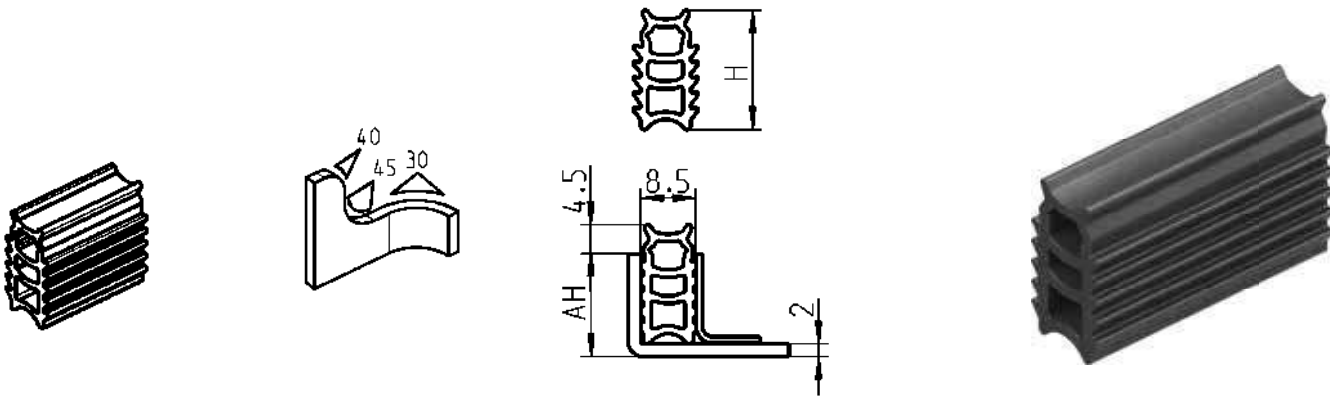
Gasket profile sponge rubber (EPDM) black (clamping profile EPDM 64 ± 5 Shore A)	
	1011-S154

According to VDI 6022



Gasket profile (EPDM) black 45 ± 5 Shore A Clamping profile (EPDM) black 60 ± 5 Shore A	
	1011-09-09

According to VDI 6022



4 lip gasket (EPDM) black 45 ± 5 Shore A		
AH	Height H	
16	18,5	1003-11-N9
18	20,5	1003-12-N9

Cell sponge rubber

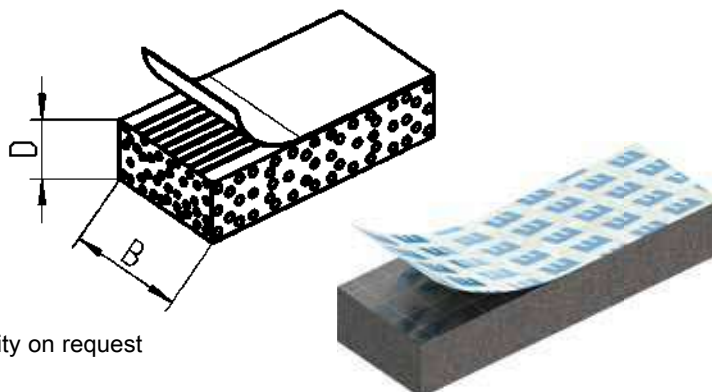
PROGRAM 1016

Coil length:

For depths 3 – 7 = Coil length a 10 m

For depths 8 – 10 = Coil length a 5 m

For depths 11 = in strip a 1 m



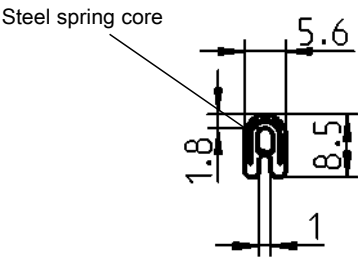
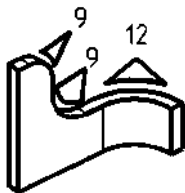
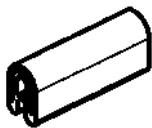
These items can be delivered from stock.
All others will have a lead time of 2 - 3 weeks.

Special lengths available in 6 to 8 weeks. Minimum quantity on request
(Article-No.: 1016- ... L mm) e.g. 1016-118-1400

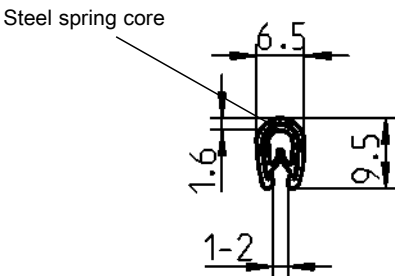
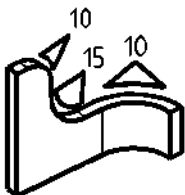
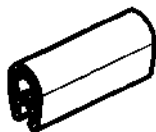
Cell sponge rubber, material on choice, black, with stretch eliminating self-adhesive backing							
Measurement				Measurement			
Width	Depth	EPDM	CR	Width	Depth	EPDM	CR
10	3	1016-13	1016-61	30	10	1016-123	1016-159
	4	1016-14	1016-62		12	1016-124	1016-160
	5	1016-15	1016-63		15	1016-125	1016-161
10	6	1016-75	1016-99		20	1016-126	1016-162
	8	1016-76	1016-100		25	1016-127	1016-163
	10	1016-77	1016-101	40	5	1016-128	1016-164
15	3	1016-16	1016-64		10	1016-129	1016-165
	4	1016-17	1016-65		15	1016-130	1016-166
	5	1016-18	1016-66		20	1016-131	1016-167
15	6	1016-78	1016-102		25	1016-132	1016-168
	8	1016-79	1016-103		30	1016-133	1016-169
	10	1016-80	1016-104	50	5	1016-134	1016-170
	12	1016-81	1016-105		10	1016-135	1016-171
	15	1016-82	1016-106		15	1016-136	1016-172
20	3	1016-19	1016-67		20	1016-137	1016-173
	4	1016-20	1016-68		25	1016-138	1016-174
	5	1016-21	1016-69		30	1016-139	1016-175
20	6	1016-83	1016-107	60	5	1016-140	1016-176
	8	1016-84	1016-108		10	1016-141	1016-177
	10	1016-85	1016-109		15	1016-142	1016-178
	12	1016-86	1016-110		20	1016-143	1016-179
	15	1016-87	1016-111		25	1016-144	1016-180
	20	1016-88	1016-112		30	1016-145	1016-181
25	3	1016-89	1016-113	70	5	1016-146	1016-182
	4	1016-90	1016-114		10	1016-147	1016-183
	6	1016-91	1016-115		15	1016-148	1016-184
	8	1016-92	1016-116		20	1016-149	1016-185
	10	1016-93	1016-117		25	1016-150	1016-186
	12	1016-94	1016-118		30	1016-151	1016-187
	15	1016-95	1016-119	80	5	1016-152	1016-188
	20	1016-96	1016-120		10	1016-153	1016-189
30	3	1016-22	1016-70		15	1016-154	1016-190
	4	1016-23	1016-71		20	1016-155	1016-191
	5	1016-24	1016-72		25	1016-156	1016-192
	6	1016-97	1016-121		30	1016-157	1016-193
	8	1016-98	1016-122		40	1016-158	1016-194

Edge protection

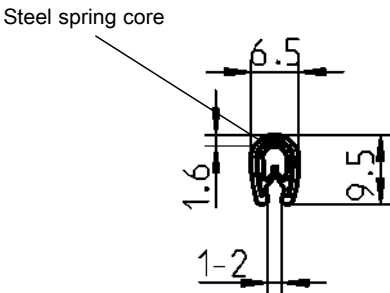
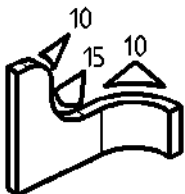
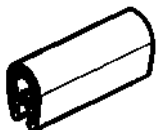
PROGRAM 1010



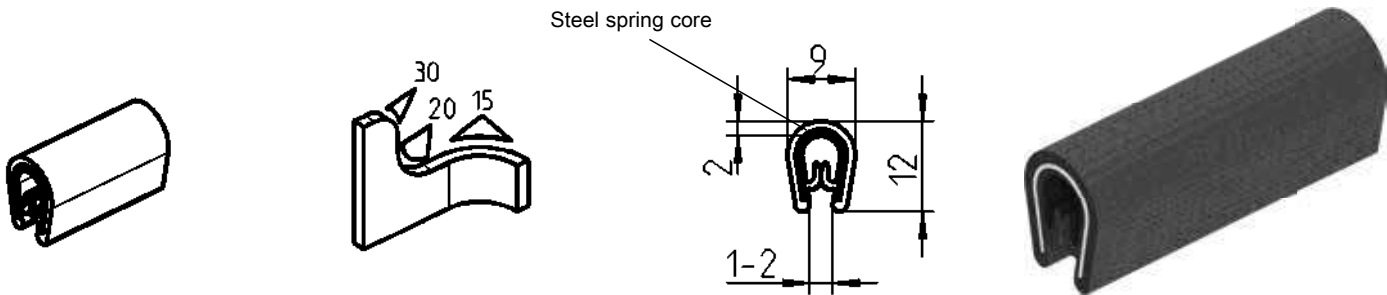
Edge protection PVC 70 ± 5 Shore A colour as requested	
black	1010-03
light grey	1010-03-01



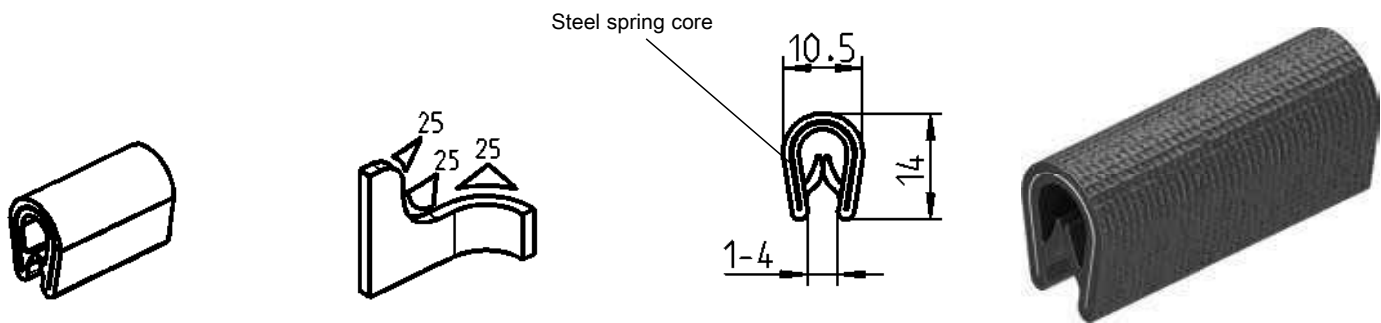
Edge protection PVC 70 ± 5 Shore A black	
	1010-02



Edge protection PVC 70 ± 5 Shore A colour as requested	
white	1010-04-01
silver	1010-04-02



Edge protection PVC 70 ± 5 Shore A black	
	1010-10



Edge protection PVC 70 ± 5 Shore A black	
	1010-01

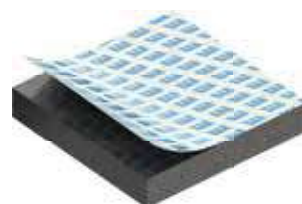
Variety of shapes and materials

EXAMPLES

More gasketings can be found in the EMKA general catalog as well as on the internet at www.emka.com

Examples of different shapes:





No suitable gasket or profile for your requirements?

No problem, just contact us!

With two own production sites for sealing technology in Spain and UK, EMKA is the perfect partner for custom-made sealing profiles.

The big number of production possibilities made of various materials enables EMKA to respond individually to customers requests.

Together, we develop a suitable concept for your requirements.





1 Locks



2 Hinges



3 Gasketings



4 Accessories

Connectors	K4-110
Recessed grips	K4-210
Bow-type handles	K4-310
Miscellaneous	K4-410

3D-Unit connector

PROGRAM 1076



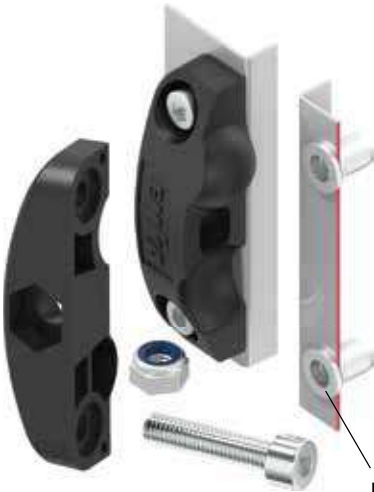
3D-unit connector

- without recess

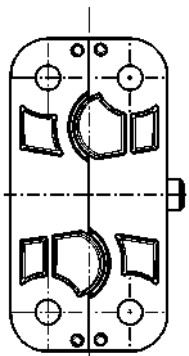
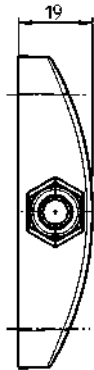
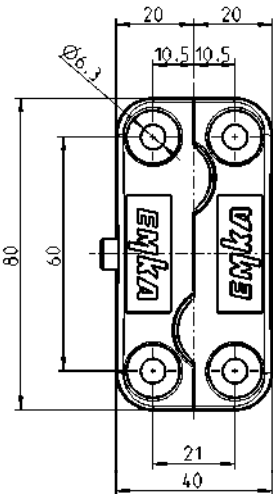
= for socket head screw M6 DIN EN ISO 4762 and washer 6 DIN EN ISO 7089 / 7090 or blind-rivet with flat head DIN EN ISO 15973

- with recess

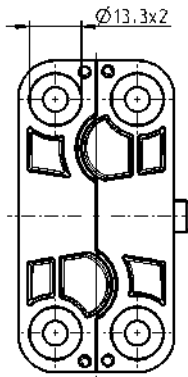
= for socket head screw M6 DIN EN ISO 4762 and washer 6 DIN EN ISO 7089 / 7090



Pan head rivet nut M6

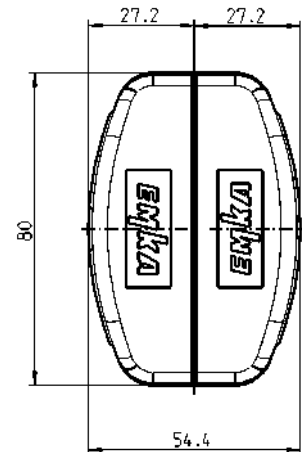


without recess

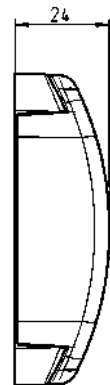


with recess for rivet nut M6 customary in trade

Note:
3D-Unit connector without fixing material



Cover for 3D-unit connector

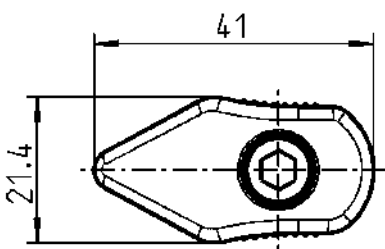
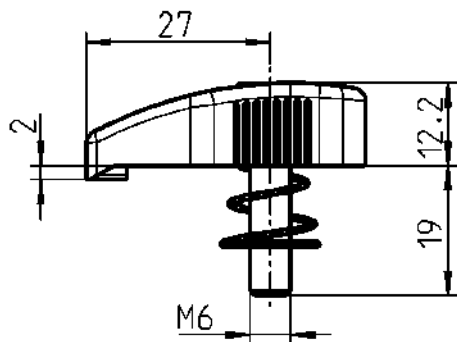
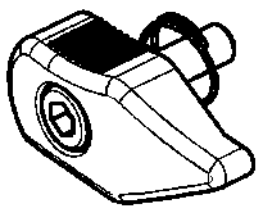


Spherical shaping allows 3D positioning

Lateral offset 7 mm
Vertical offset 5 mm
Depth offset 3 mm



3D-Unit connector polyamide 66 GF 50 black; safety nut M8 and socket head screw M8x35 m.s. zinc plated	
without recess	1076-U14
with recess	1076-U15
Cover polyamide black for 3D-unit connector	
2-part	1076-U16

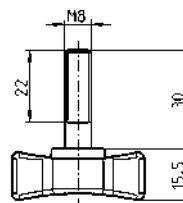
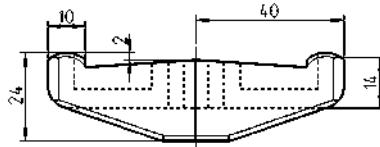
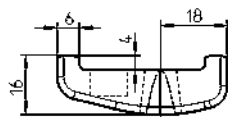
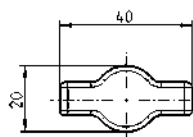
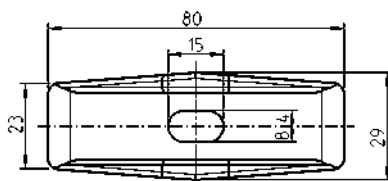
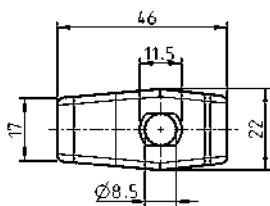


Bridge clamp polyamide black;
socket head screw m.s. zinc plated; with spring

1076-U13

Version A

Version B



Bridge clamp polyamide black

Version A

Version B

1076-19

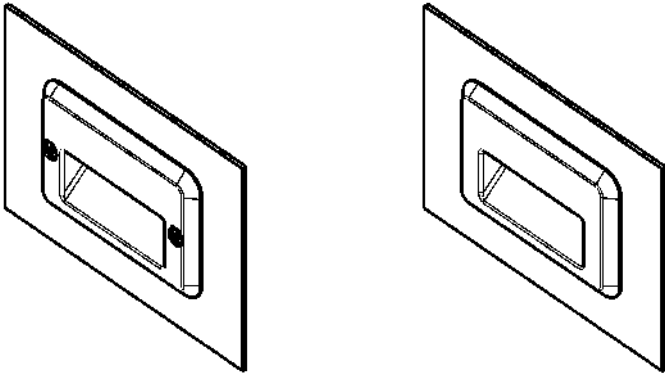
1076-20

Tommy screw m.s. zinc plated; wing knob polyamide GF black

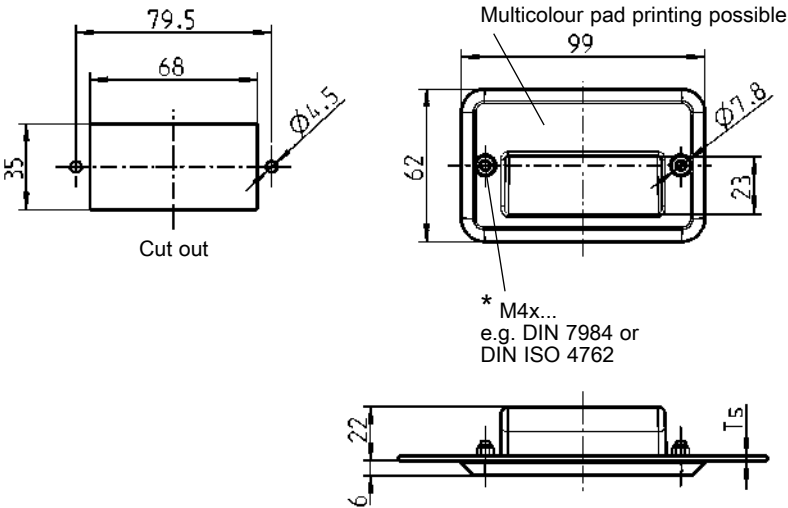
1076-15

Pull

PROGRAM 1091



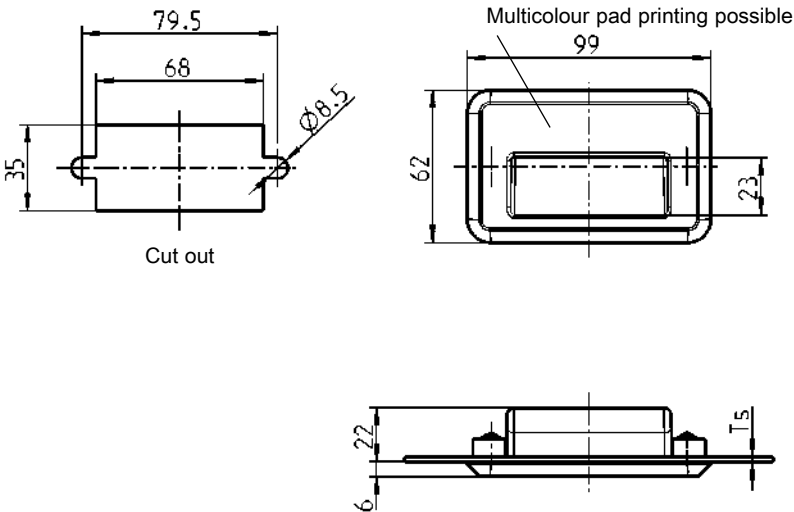
Version A



Version A



Version B



Version B



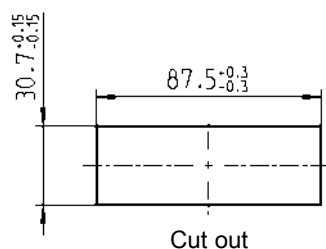
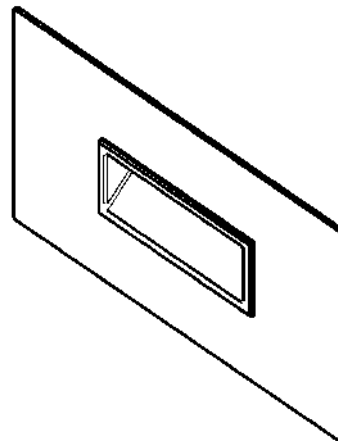
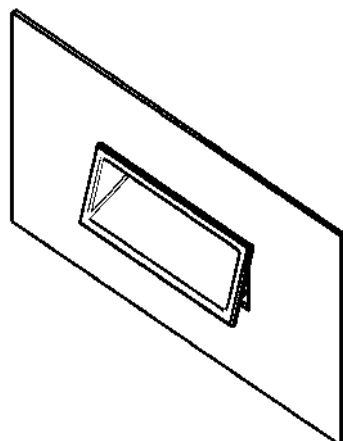
Pull polyamide GF black, with seal			
Version B clip polyamide GF black, fixing material m.s. zinc pl.			
Version A	IP 54	Ts 0.8 - 7	1091-105
Version B	IP 65	Ts 0.8 - 3 **	1091-U144
Plug polyethylene black for version A			
(2 plugs are needed per pull)			1091-106

* not included in the scope of supply
** other door thickness on request

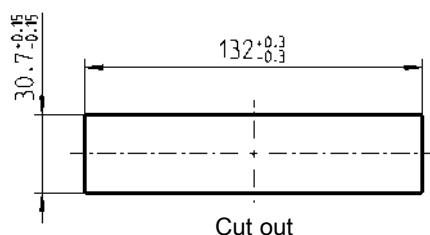
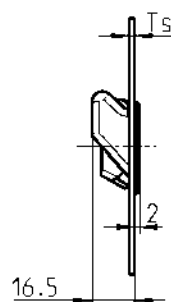
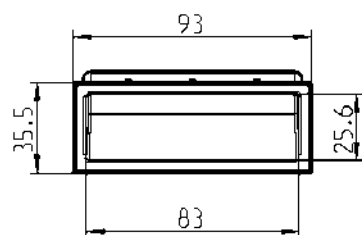


Press pull into cut out

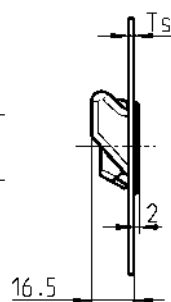
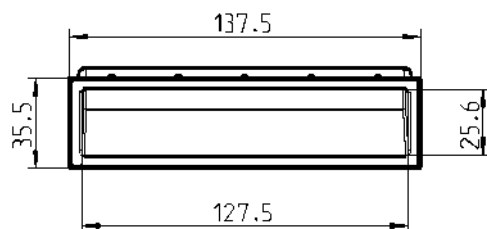
Ready for operating



Version A



Version B



Product benefits

- Cost savings due to quick mounting without tools
- Escutcheon automatically clicks into place behind the door leaf
- Corrosion-resistant of PA6 GF30

Pull Polyamide GF Black

	Version A	Version B
Ts 0.8 - 1.2 mm	1091-103-01	1091-109-01
Ts 1.2 - 1.6 mm	1091-103-02	1091-109-02
Ts 1.75 - 2.2 mm	1091-103-03	1091-109-03

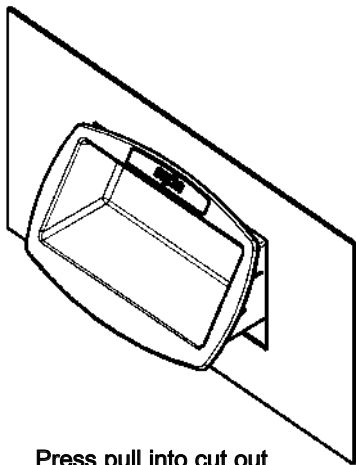
Assembling:

The pull is fitted with clips that automatically snap in behind the door part.

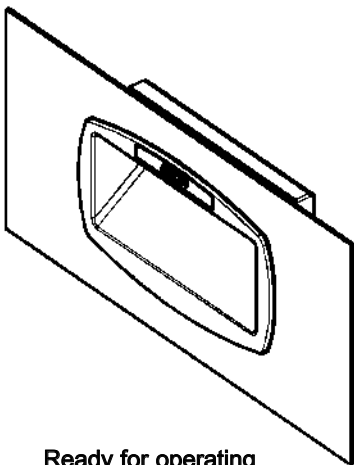
Pulls for other door thickness on request

Pull

PROGRAM 1091



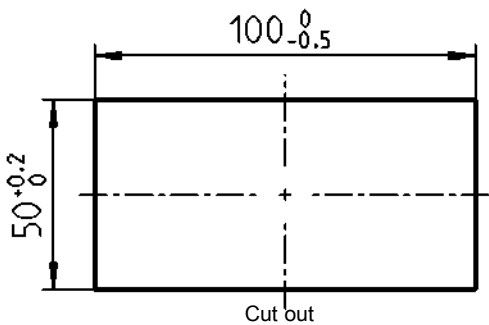
Press pull into cut out



Ready for operating

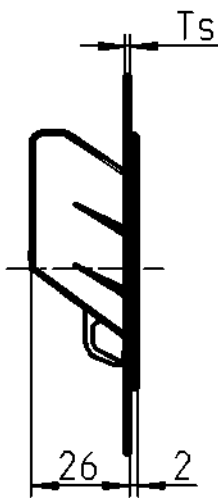
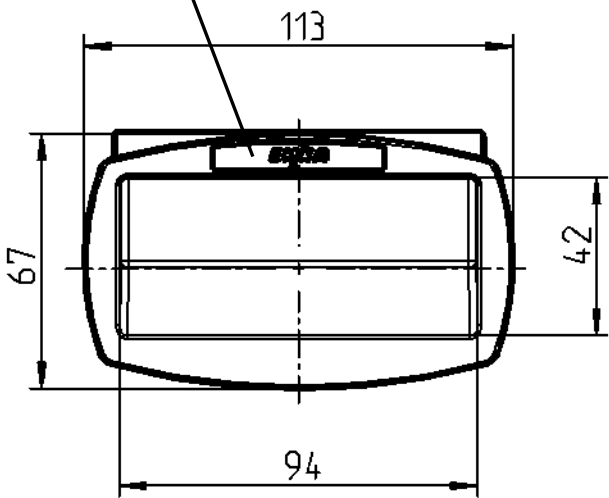


Assembling:
The pull is fitted with clips that automatically snap in behind the door part.



Cut out

* Logo field 50 x 8.5 mm (middel, outside 6.8) x 0.3
Pad Printing multicolour print possible



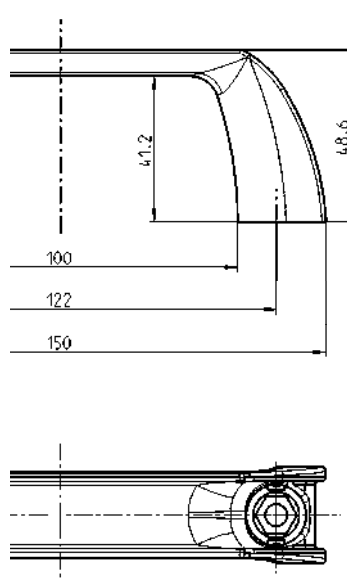
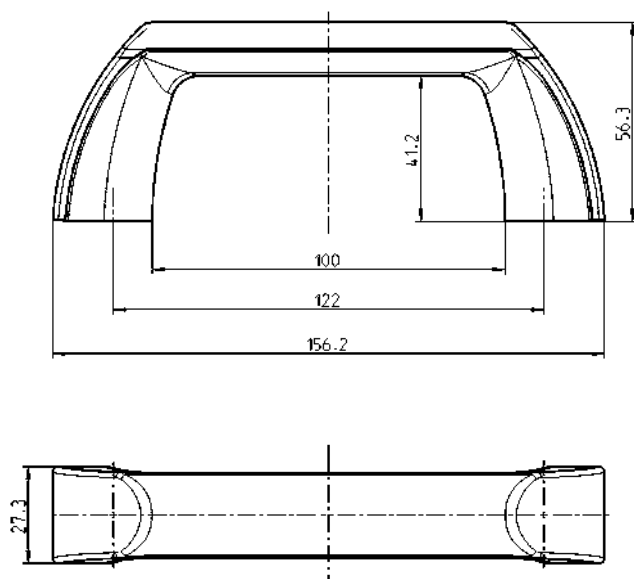
Pull Polyamide GF Black	
Ts 0,80 – 1,2 mm	1091-93
Ts 1.20 - 1.6 mm	1091-91
Ts 1,75 – 2,2 mm	1091-92

Bow-type handles

PROGRAM 1095

Bow-type handle with cover

Bow-type handle without cover



Bow-type handle polyamide GF black

Handle for hexagon or cylinder screw M6 acc. to DIN 4017/1207

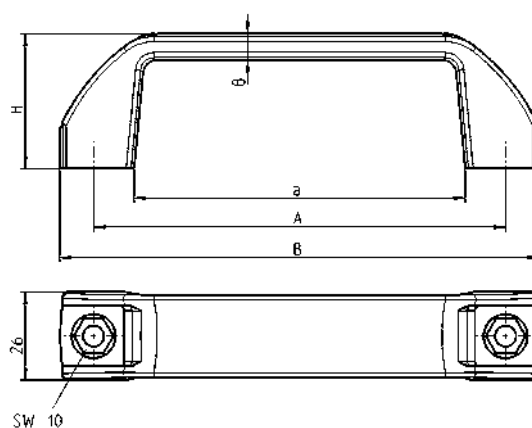
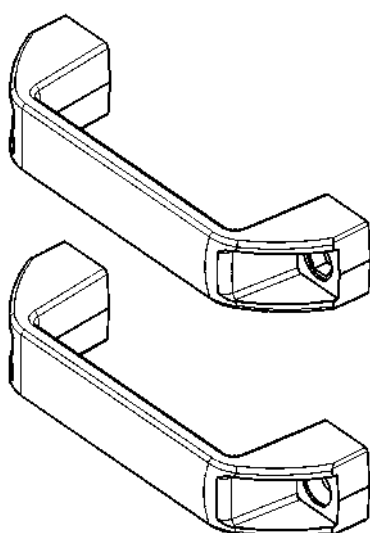
1095-35

Handle for countersunk screw small head M5 or rivet 4.8 mm dia

1095-36

Cover for bow-type handle polyamide GF black

1095-37



Version	a	A	B	H
1	98	122	142	40
2	118,5	152	167	53,5



Bow-type handle polyamide GF black

Handle for hexagon or cylinder screw M6 acc. to DIN 4017/1207

Version 1

Version 2

Handle for countersunk screw small head M5 or rivet 4.8 mm dia

1095-05

1095-19

1095-06

—

small head = DIN ISO 2009, 2010, 7046-1, 7046-2, 7047

Fastening material is not included in delivery.

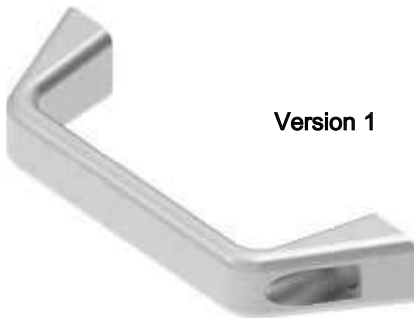
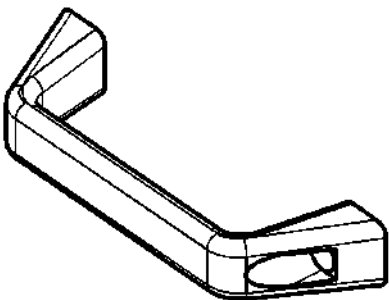
Info
1 Locks
2 Hinges
3 Gasketings
4 Accessories
Index

Bow-type handles

PROGRAM 1095

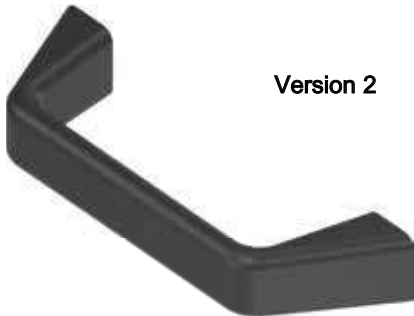
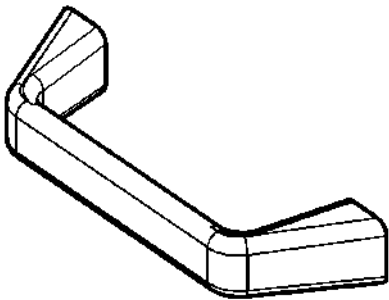


Version 1



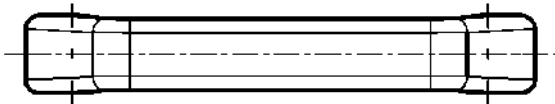
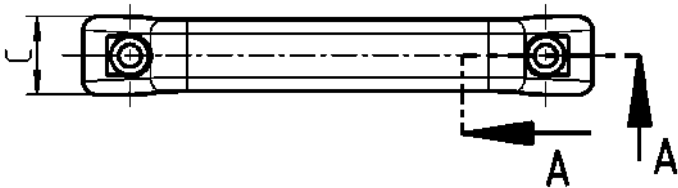
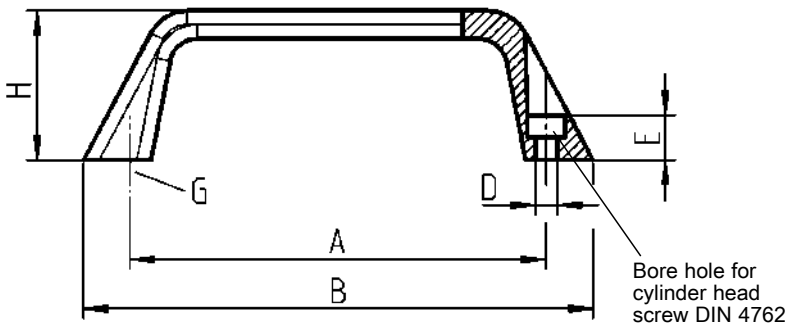
Version 1

Version 2



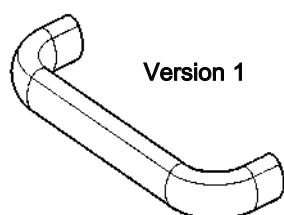
Version 2

A - A

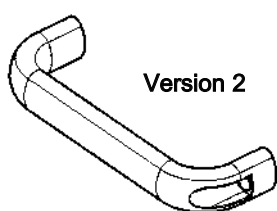


Bow-type handle aluminium GD-Al optionally raw or black plastic coated							
Version 1							
A	B	C	D	E	H	raw	black
120	147	22.5	6.4	13	43	1095-29-120KB	1095-29-120AA
180	215	27	8.4	16	48	1095-29-180KB	1095-29-180AA
Version 2							
A	B	C	G	H		raw	black
120	147	22.5	M6x10	43		1095-30-120KB	1095-30-120AA
180	215	27	M8x12	48		1095-30-180KB	1095-30-180AA

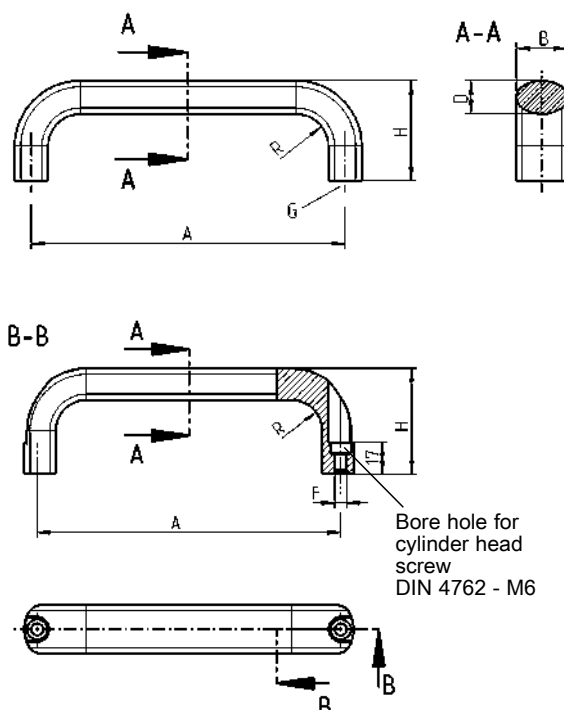
Fastening material is not included in delivery.



Version 1



Version 2



Version 1



Version 2



Bow-type handle, aluminium optionally raw, anodized black plastic coated or stainless steel AISI

Version 1

A	B	D	G	H	R	raw	anodized	black
100	20	13	M6x10	47	13	1095-26-100KB	1095-26-100NA	1095-26-100AA
112	20	13	M6x10	49	13	1095-26-112KB	1095-26-112NA	1095-26-112AA
112	26	17	M8x12	53	17	1095-27-112KB	1095-27-112NA	1095-27-112AA
128	20	13	M6x10	51	13	1095-26-128KB	1095-26-128NA	1095-26-128AA
128	26	17	M8x12	55	17	1095-27-128KB	1095-27-128NA	1095-27-128AA
160	20	13	M6x10	51	13	1095-26-160KB	1095-26-160NA	1095-26-160AA
160	26	17	M8x12	57	17	1095-27-160KB	1095-27-160NA	1095-27-160AA
192	26	17	M8x12	57	17	1095-26-192KB	1095-26-192NA	1095-26-192AA
300	26	17	M8x12	57	17	1095-26-300KB	1095-26-300NA	1095-26-300AA
400	26	17	M8x12	57	17	1095-26-400KB	1095-26-400NA	1095-26-400AA
500	26	17	M8x12	57	17	1095-26-500KB	1095-26-500NA	1095-26-500AA

Version 1

A	B	D	G	H	R			AISI 304
112	20	13	M6x10	49	13			1095-26-112PC
128	20	13	M6x10	51	13			1095-26-128PC

Bow-type handle, aluminium optionally raw, anodized, black plastic coated or stainless steel AISI

Version 2

A	B	D		H		raw	anodized	black
116	26	17		53		1095-28-116KB	1095-28-116NA	1095-28-116AA
132	26	17		55		1095-28-132KB	1095-28-132NA	1095-28-132AA
164	26	17		57		1095-28-164KB	1095-28-164NA	1095-28-164AA
196	26	17		57		1095-28-196KB	1095-28-196NA	1095-28-196AA

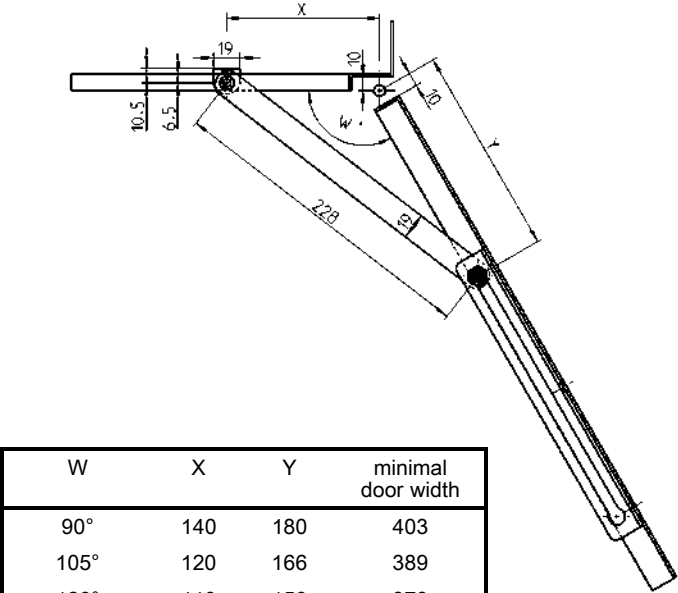
Version 2

A	B	D		H				AISI 316
116	26	17		53				1095-28-116PH

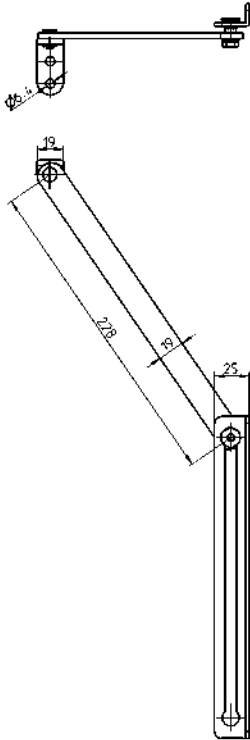
Fastening material is not included in delivery.

Door stop

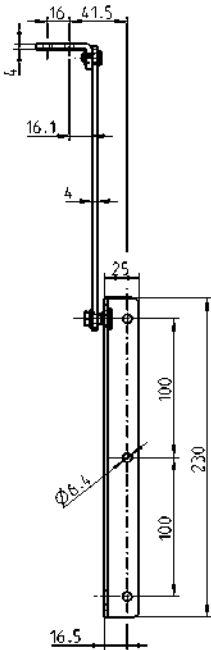
PROGRAM 1087



W	X	Y	minimal door width
90°	140	180	403
105°	120	166	389
120°	110	150	373
135°	100	146	369
in case of other variations $y = x + >40$			

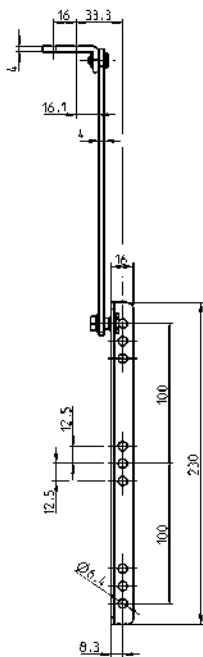


Version A



Version A

Version B



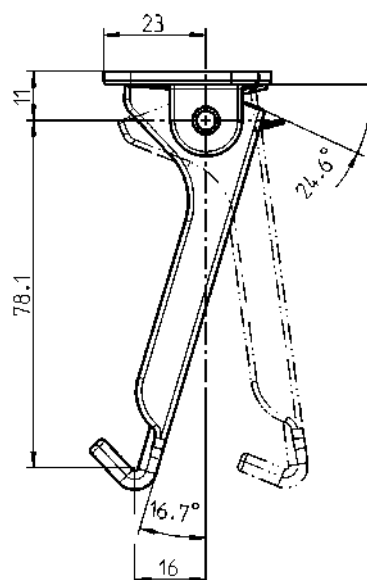
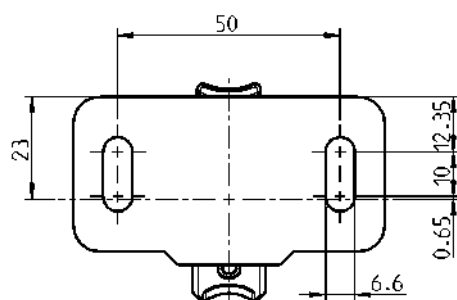
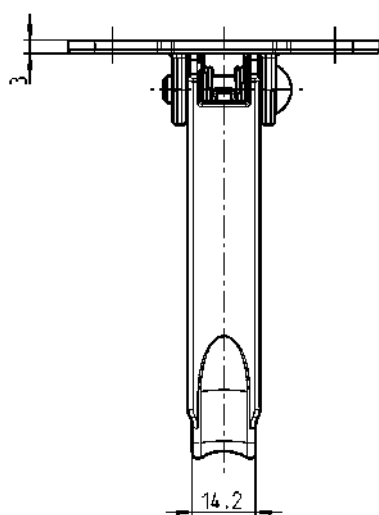
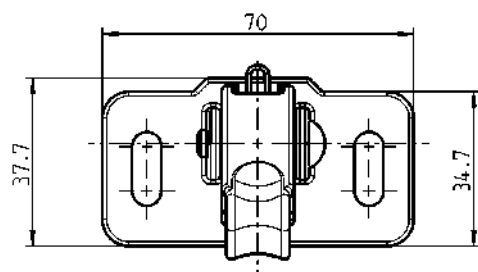
Version B

Door stop m.s. zinc plated	
Version A (2D-nut possible)	1087-U1
Version B (2D-nut possible)	1087-U4
Door stop AISI 304, locking bush and rivet AISI 303	
Version A (2D-nut possible)	1087-U1-PC

Further parts see page
– 2D-nut

K2-410

Tail hook PROGRAMM 5225



Tail hook AISI 316; spring and half-round rivet stainless steel

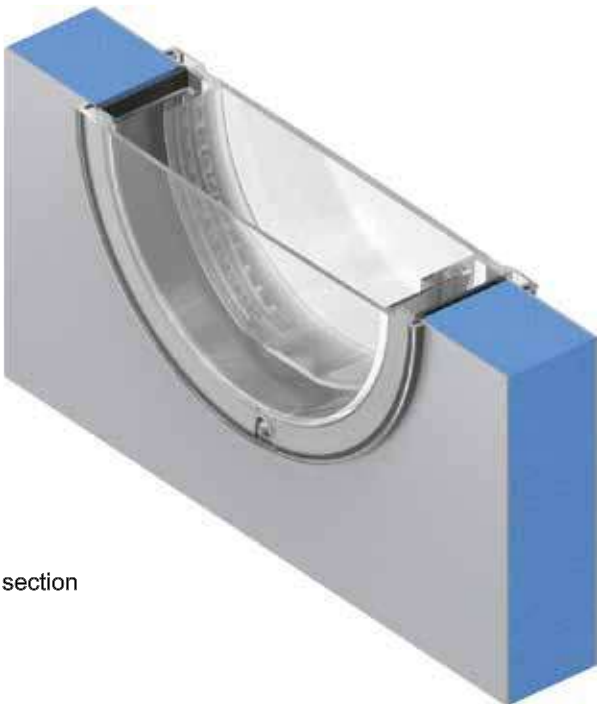
5225-U400

Window round

PROGRAM 1091



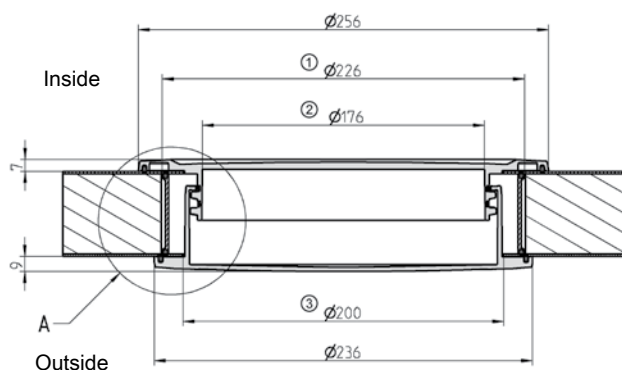
Interior view



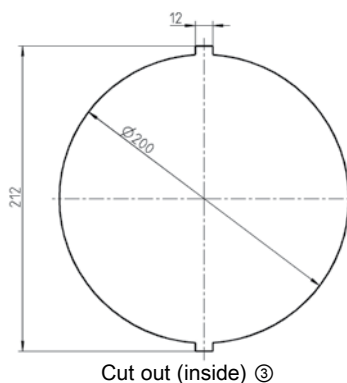
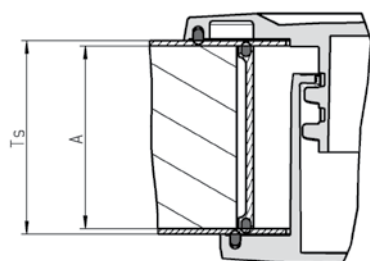
Interior view in cross section

Product benefits

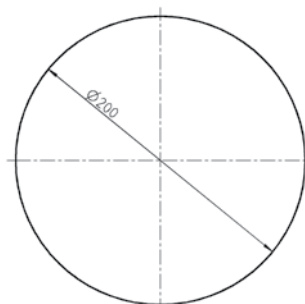
- Quick assembly by snap-in joint without mounting screws
- Inspection window halves with undetachable foamed seals
- Viewing area Ø 176 mm
- Suitable for systems with positive or negative pressure
- Inspection windows are available for door thicknesses of 30-34, 40-44, 50-54 and 60-64 mm
- Optionally, for sandwich doors with soft filling material, a one-piece support ring with circumferentially foamed seals in the sizes 30, 40, 50 and 60 mm can be ordered. This also serves as a visual barrier and allows a secure seal between insulating material and inspection window.
- Impact resistant, UV stabilized polycarbonate; approved according to VDI 6022



② = visible area



Cut out (inside) ③



Cut out (outside) ③



Window round polycarbonate glass clear, with gasketing

Ts = 30 - 34 and 40 - 44 mm

1091-U172-30

Ts = 50 - 54 and 60 - 64 mm

1091-U172-50

Support ring for window round polyamide black, with gasketing

① A = 30

1091-152-30G

① A = 40

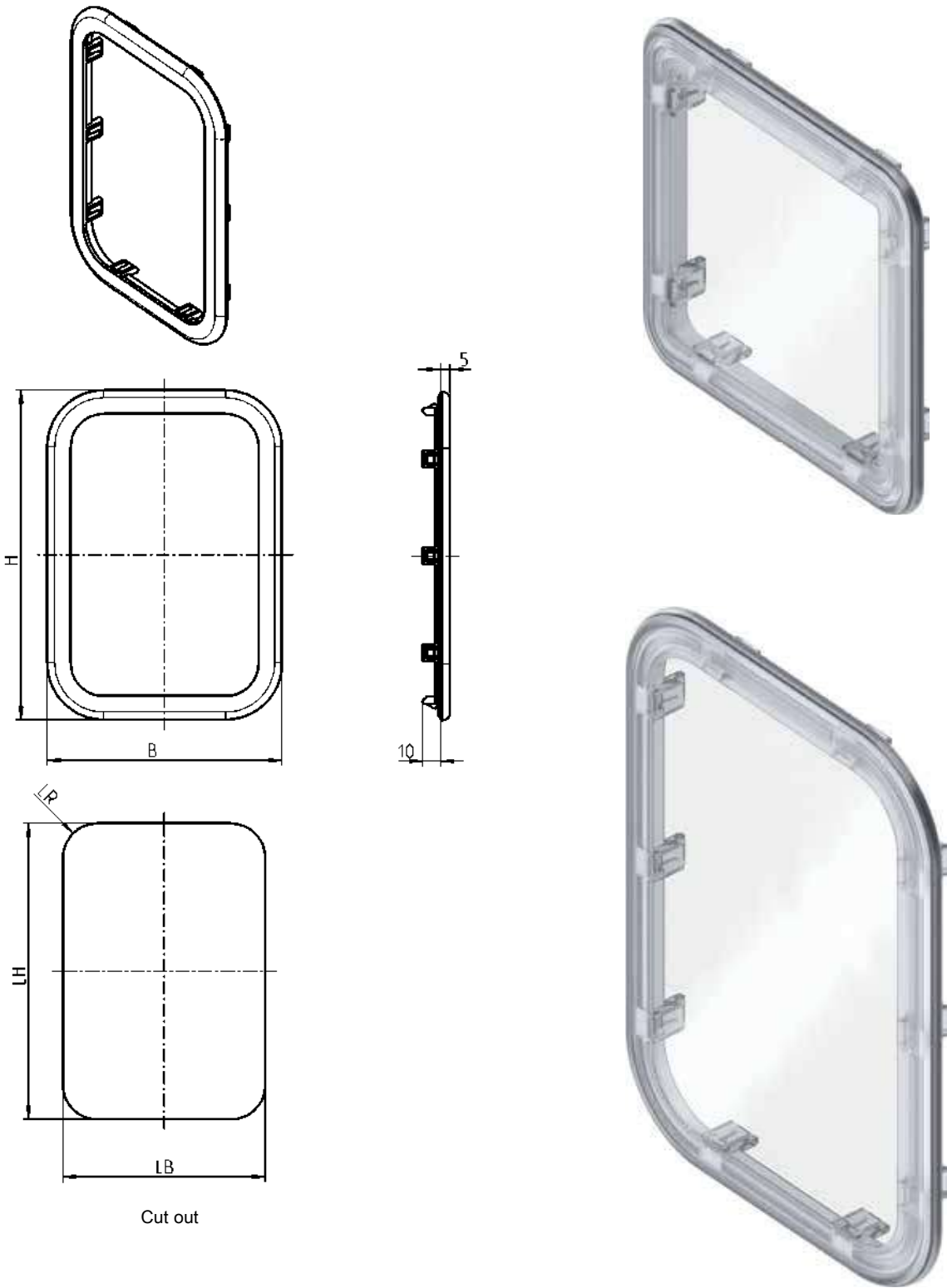
1091-152-40G

① A = 50

1091-152-50G

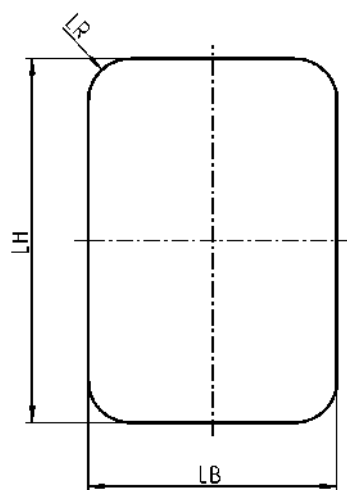
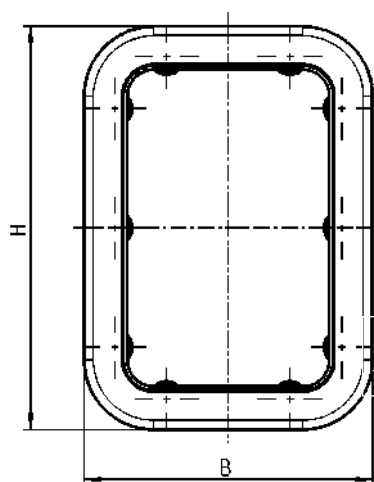
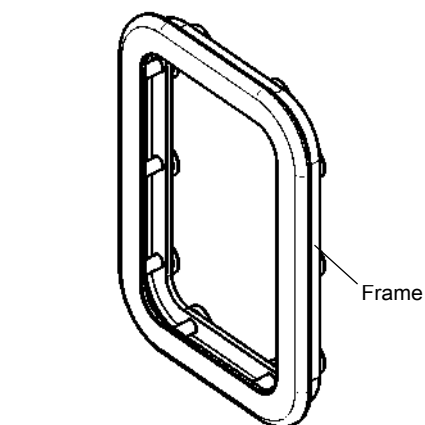
① A = 60

1091-152-60G

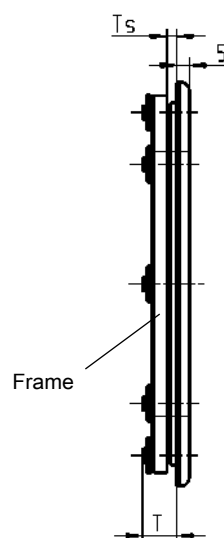


Clip-in window polycarbonate glass clear, with gasketing						
H	B	LH	LB	LR	Ts	
110	110	94,4	94,4	6	1,5	1250-U1
110	110	94,4	94,4	6	2	1250-U3
175	125	157,2	107,2	20	1,5	1250-U2

Other sizes on request



Cut out



Window polycarbonate glass clear, star lock washer m.s. zinc plated, with seal

H	B	T	LH	LB	LR	Ts	
Window without frame							
110	110	17	95,5	95,5	6	3 - 13	1250-U4
175	125	15	156,5	107	20	3 - 12	1250-U6
Window with frame polycarbonate							
110	110	17	95,5	95,5	6	< 5	1250-U5
175	125	15	156,5	107	20	< 6	1250-U7

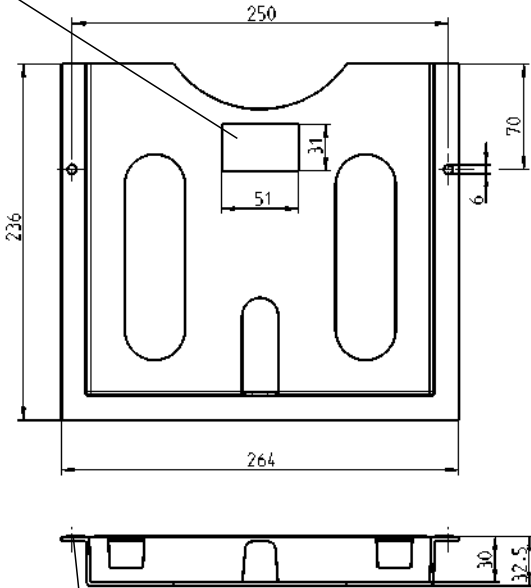
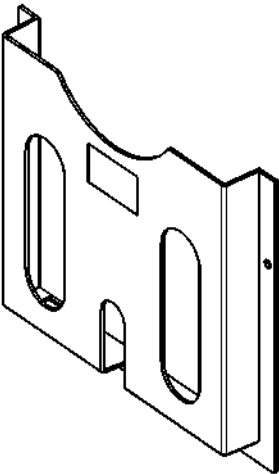
Other sizes on request

Drawing pocket

PROGRAM 1013



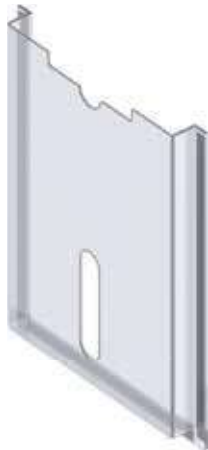
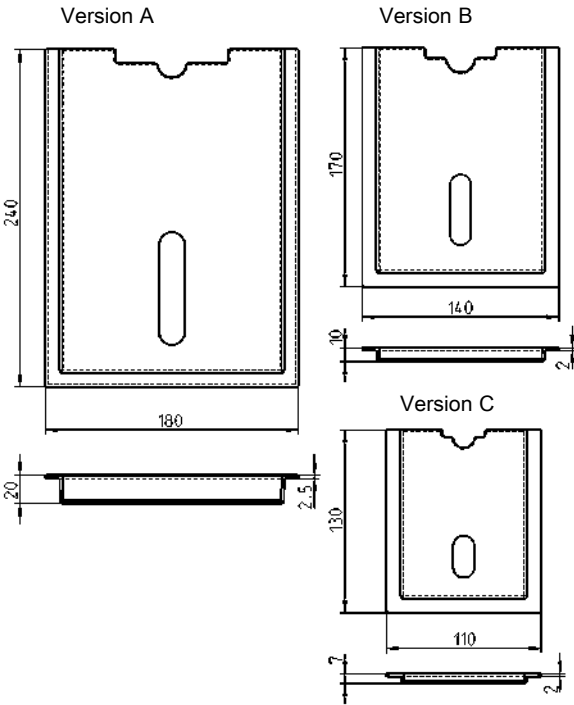
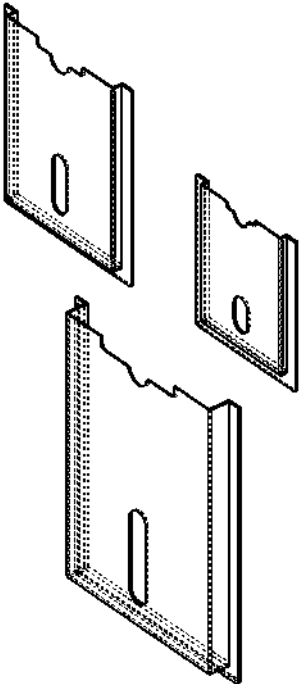
Logo recess: 51 x 31 x 0.2
Multicolour print possible



Self-adhesive, can be screwed on.
Size DIN A4



Drawing pocket PS impact proof, self-adhesive	
grey	1013-U1
orange	1013-U2



Drawing pocket SAN, transparent, self-adhesive	
Version A	1013-U5
Version B	1013-U4
Version C	1013-U3

Coordinated on special applications EMKA develops and produces e.g. corner pieces made of:

- Zinc die Casting
- Aluminium die casting
- Injection Moulding

Thereby the desired properties can be optimized:

- Strength
- Weight
- Avoiding a thermal bridge
- Surface



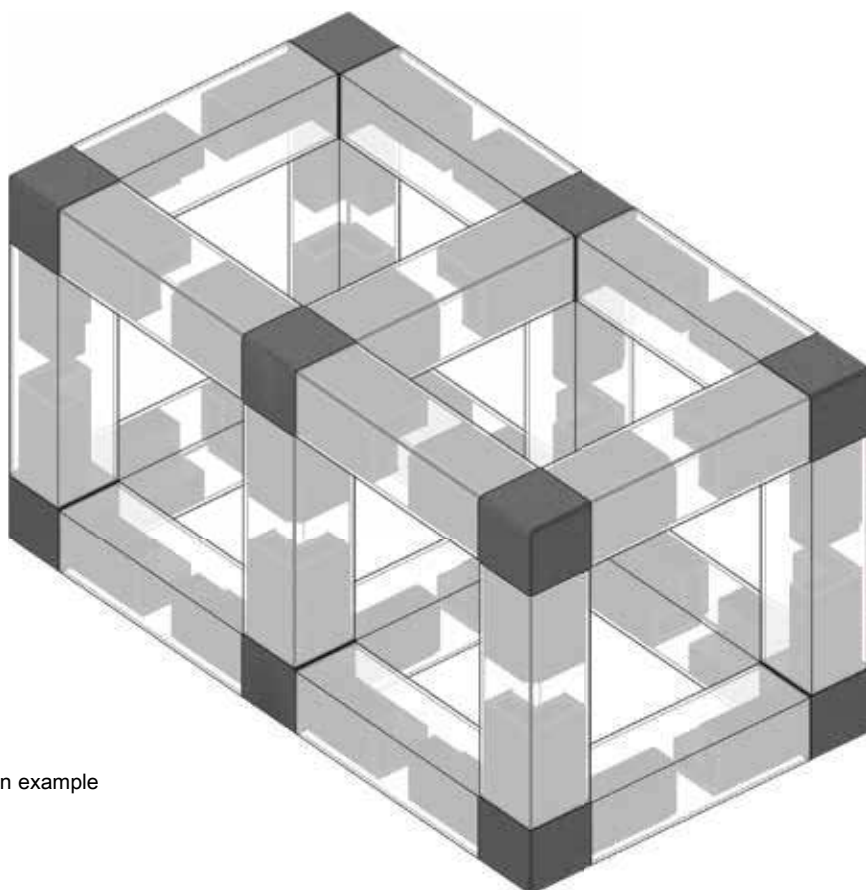
Geometry example

Production equipment zinc die casting:

- Zinc die casting machines 200 – 3,150 kN
- Part weight 0.1 up to 2.5 kg
- Automated mechanical post-processing
- Surface treatment / Finishing

Producing equipment plastic injection molding:

- Machines with 30 up to 250 t closing force
- Shot weight until 0.7 kg
- Processing of various thermoplastics



Design example



Application example
Zinc die Casting



Application example
Aluminium die casting



Application example
Injection Moulding

Index by Part Number



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