



Refrigerating and Air
Conditioning Plants

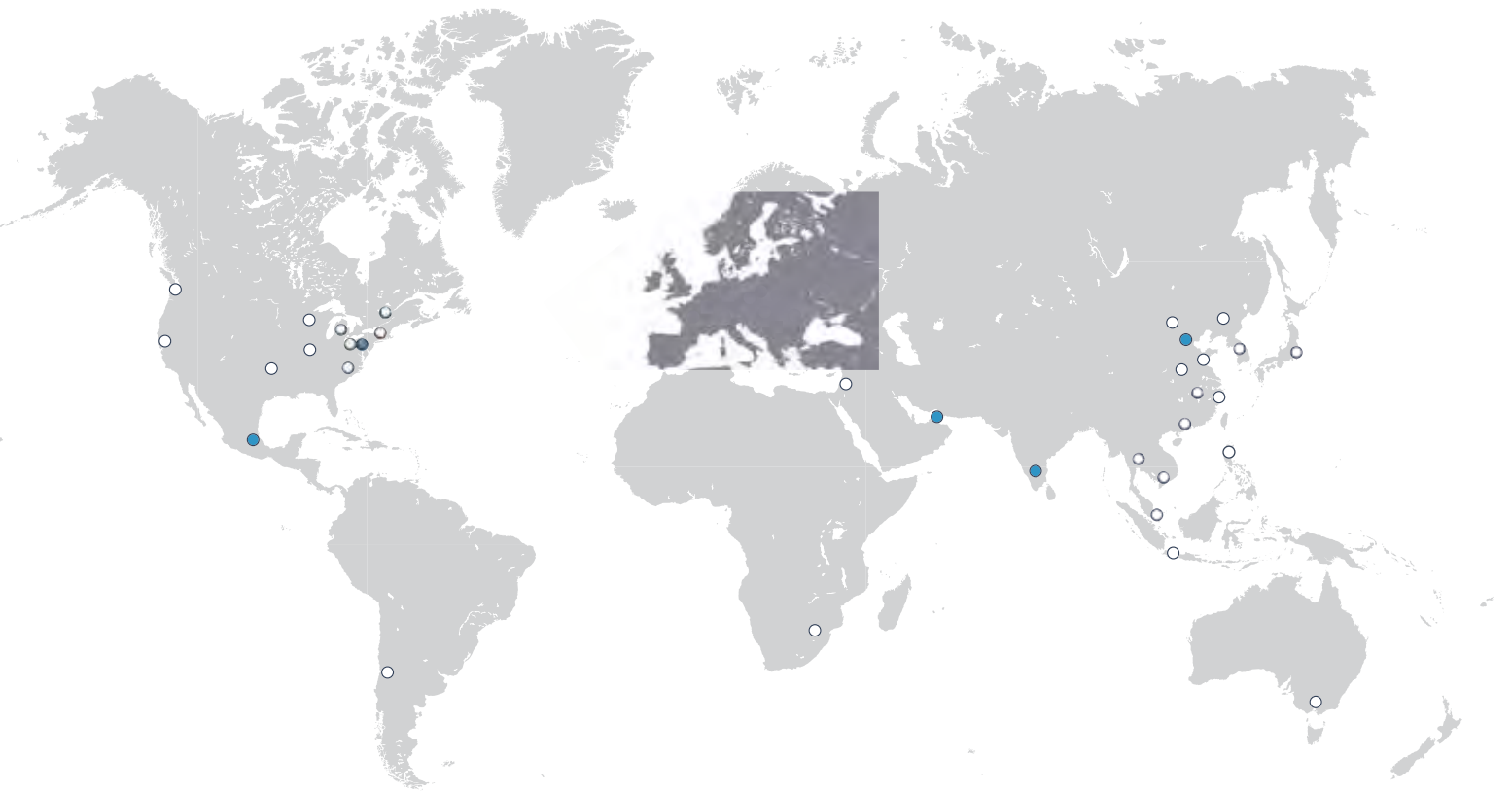


Ventilations Systems

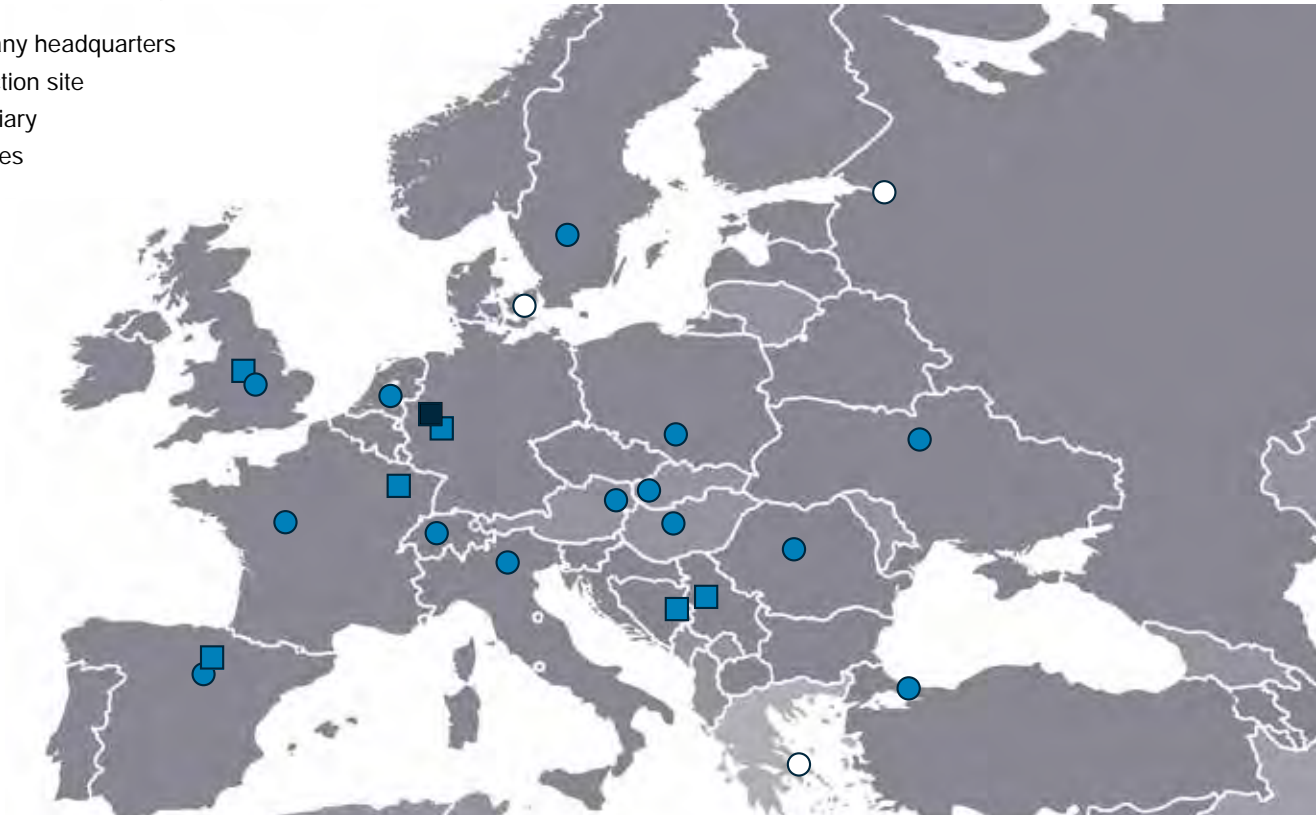


Heat Plants

Ingenious locking technology for
HVACR systems according to VDI 6022



- Company headquarters
- Production site
- Subsidiary
- Agencies



EMKA worldwide

Production in Europe



Company headquarters Velbert, Germany



Wuppertal, Germany



Henriville, France



Arnedo, Spain



Birmingham, UK



Goražde (Plant 1), Bosnia and Herzegovina



Goražde (Plant 2), Bosnia and Herzegovina



Mionica, Serbia



Pastrengo, Italy

Sales Worldwide



Kiltsee, Austria



Interlaken, Switzerland



Bourré, France



Veghel, Netherlands



Bedzin (Katowice), Poland



Pastrengo, Italy



Arnedo, Spain



Coventry, UK



Jönköping, Sweden



Sibiu, Romania



Middletown, USA



Çerkesli-Dilovşi (Istanbul), Turkey



Tjanjin, China



Bangalore, India



Kiev, Ukraine

The EMKA GROUP is the world market leader for locking systems, hinges and gasketing that are used in switch and control cabinets. In the sectors HVACR, food technology and transport EMKA ranks among the leading manufacturers of locking technology.

The total range of products comprises 15,000 items that are developed, manufactured, finished and assembled at nine production sites in Germany, France, England, Spain, Italy, Bosnia and Serbia.

With 1,600 employees we serve over 30,000 customers in 52 countries worldwide.

Locking Systems



Locks



Hinges



Gasketing

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 excellent manufacturing know-how and by the certified process control according to ISO 9001 and DIN EN ISO 14001.



Industry

Transport

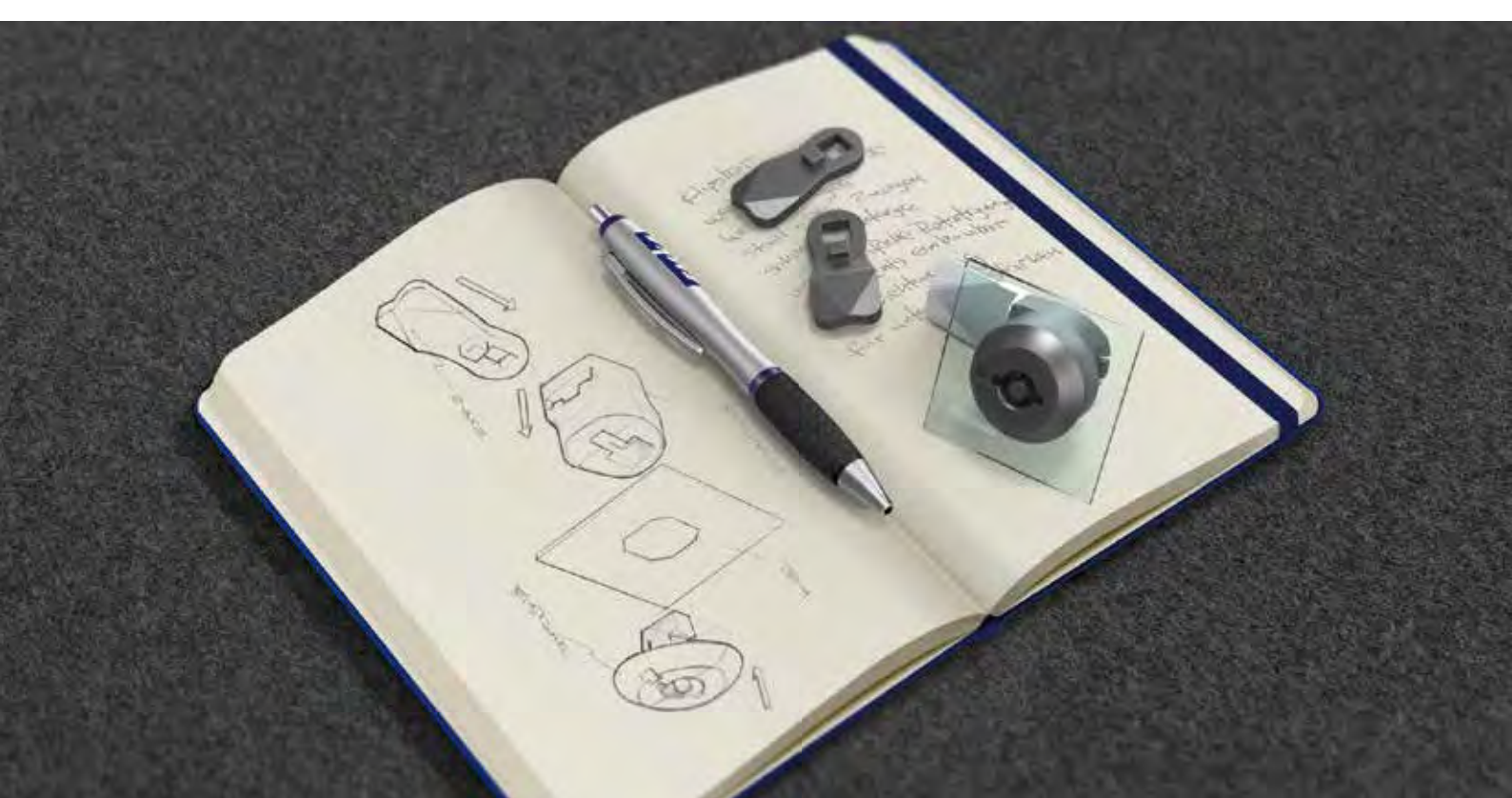
Electronics

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

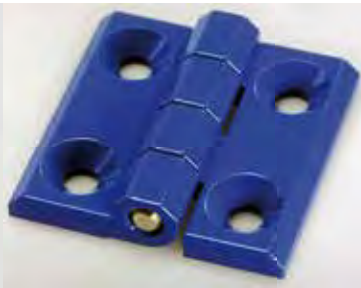


SST Precision Casting

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.

Latch-Hinge

- When the door is closed, the latch is adjustable (3 mm) to achieve perfect alignment
- Compression (5 mm) with low opening and closing force
- Door or panel can be removed by unlatching the handles on both sides
- 3D Adjustable
- Right or left hinged
- Hinge 180° opening angle
- Available with or without Pressure Relief
- Patent submitted



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, countersunk 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 also without cover used
- Protected design



L-Handle

- Surface mounted lifthandle with led-through spindle
- Suitable for doors opening inwards and outwards
- Roller Cam with Adjustable Clamping Load
- Variety of locking options
- Various cam types
- Air Tightness class L1-L3 possible
- Modular Design
- Protected design



Door lock

- Compression up to 10 mm by the integrated stepped cam
- No thermal bridge between interior and exterior of the plant due to surface mounting
- Wide range of inserts and L-Handles and T-Handles can be used
- Lockable version possible
- Housing available in plastic and zinc die
- Pressureside version possible



L-Handle

- Modular locking system
- Flush-mounted L-Handle with onepiece steel shaft
- Wide range of handle and bezel types
- Inside handle possible
- Lockable version possible
- Various cam types



3D hinge Plus

- Opening angle up to 180°
- 3D adjustment
 - X-axis ± 2 mm
 - Y-axis ± 2 mm
 - Z-axis ± 1.5 mm
- Center piece additionally adjustable by the shaft ± 2.75 mm



HVACR-Solutions from
one single source

3D hinge

- Opening angle up to 180°
- Easy adjustment of the hinges through slots
- Recesses for panhead rivet nuts type M6
- 3D adjustment
X-axis ±2 mm,
Y-axis ±2 mm,
Z-axis +2 mm



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



2D hinge

- Opening angle up to 180°
- 2D adjustment
X-axis ±1.5mm,
Y-axis ±1.5mm



Insert profile according to hygiene standard VDI 6022

- Gasket does not provide any breeding ground for micro-organisms
- They can be cleaned easily
- Moisture repellent
- Odorless



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
- Including connecting shaft
- Industry standard mounting dimensions
- Covering cap optionally available



Corner piece

- EMKA makes corner pieces and constructional elements for ventilation and air conditioning plants developed according to customer specifications made of:
Injection Moulding
Zinc die Casting
Aluminium die casting



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.



For doors opening inwards (in-swing)



For doors opening outwards (out-swing)

HVACR Handle-System

- New modular handle with an innovative design
- Suitable for doors opening inwards and outwards
- Suitable for various door thicknesses
- **Fits 3 standard cut outs (24mm, 19 mm, 13 mm)**
- Variety of locking options (blind plug, round cylinder, square insert, further inserts on request)
- 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

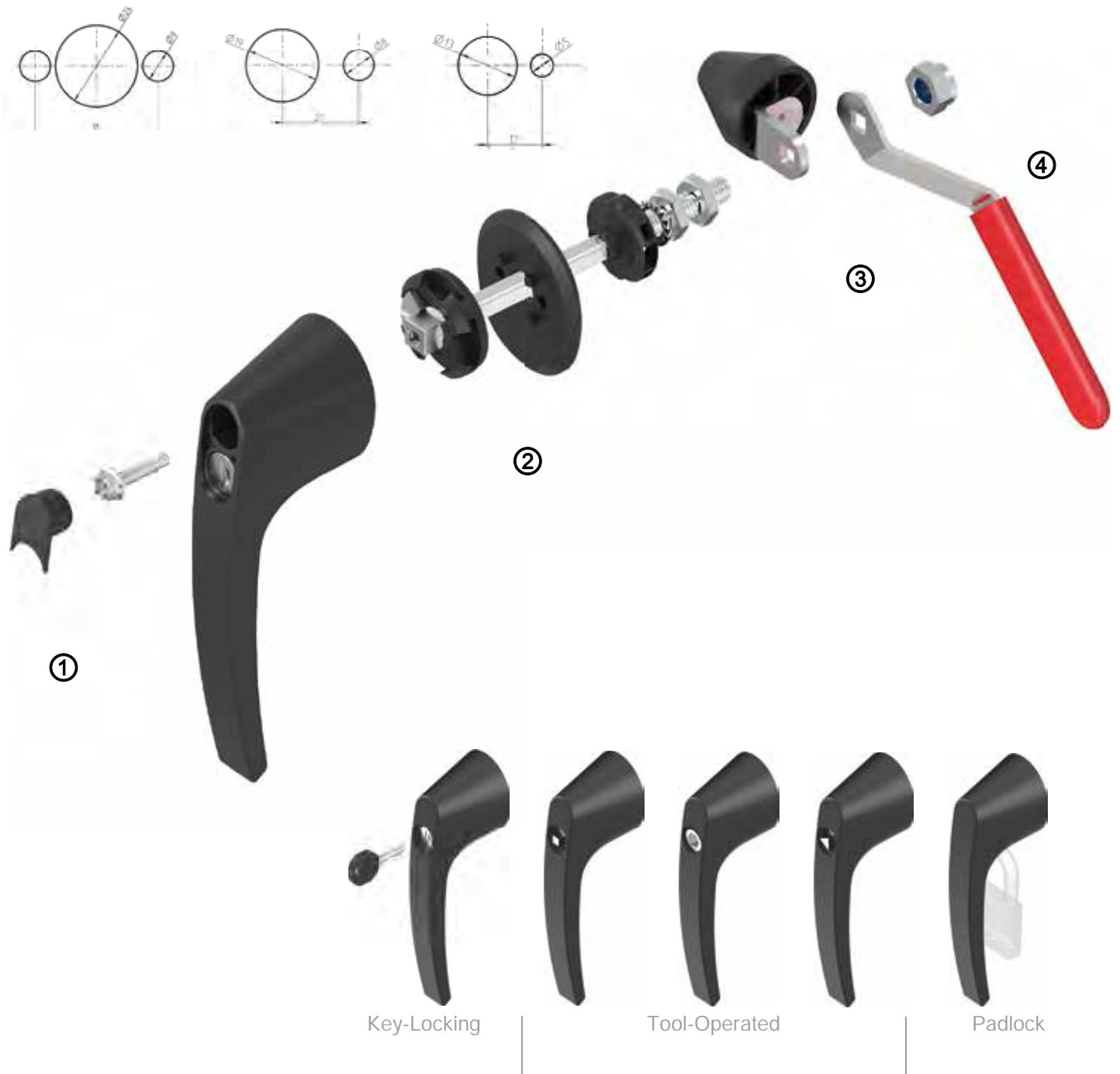
for cut out A

or

cut out B

or

cut out C



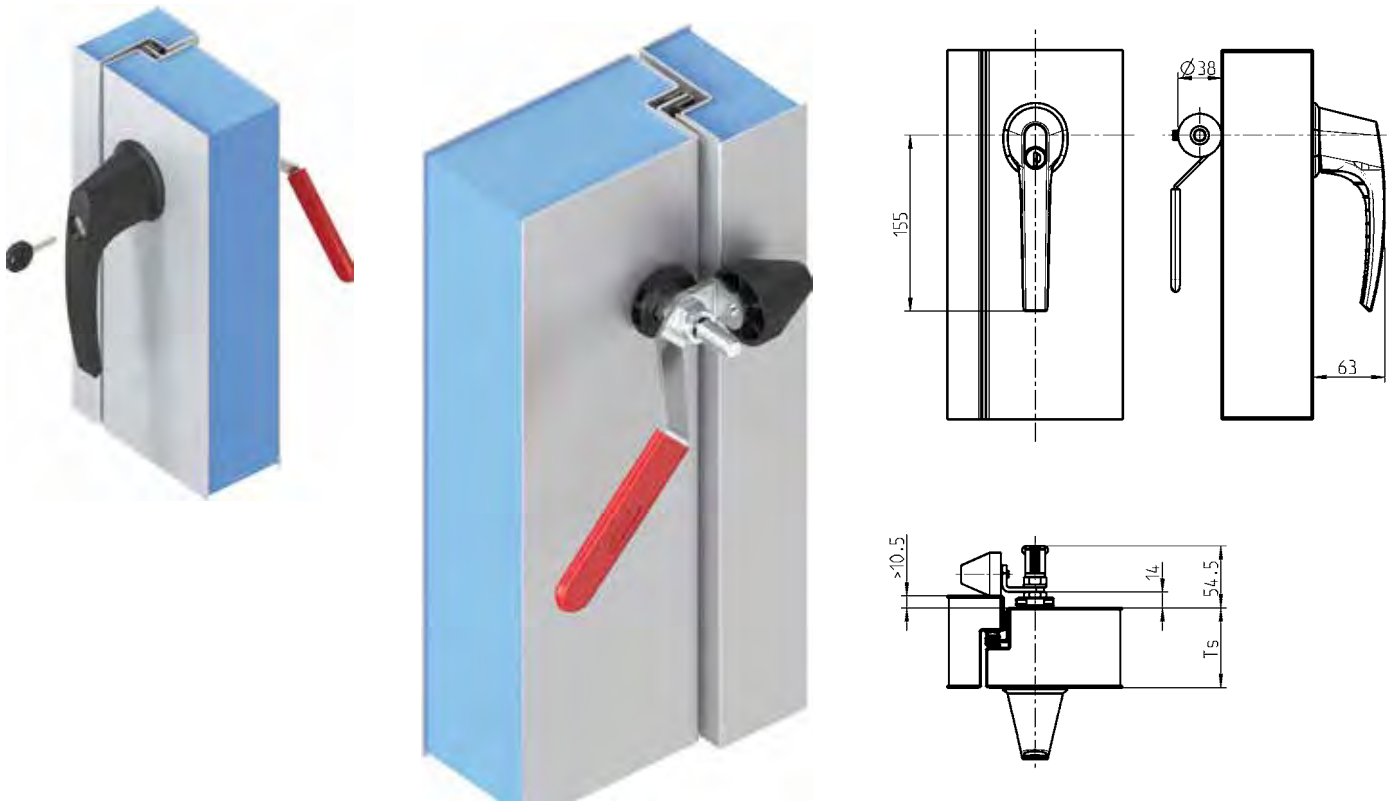
Product Features

- 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.
- 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 overpressure installations. The comprehensive choice of hinges and gaskets completes the range.

Modular HVACR Handle-System

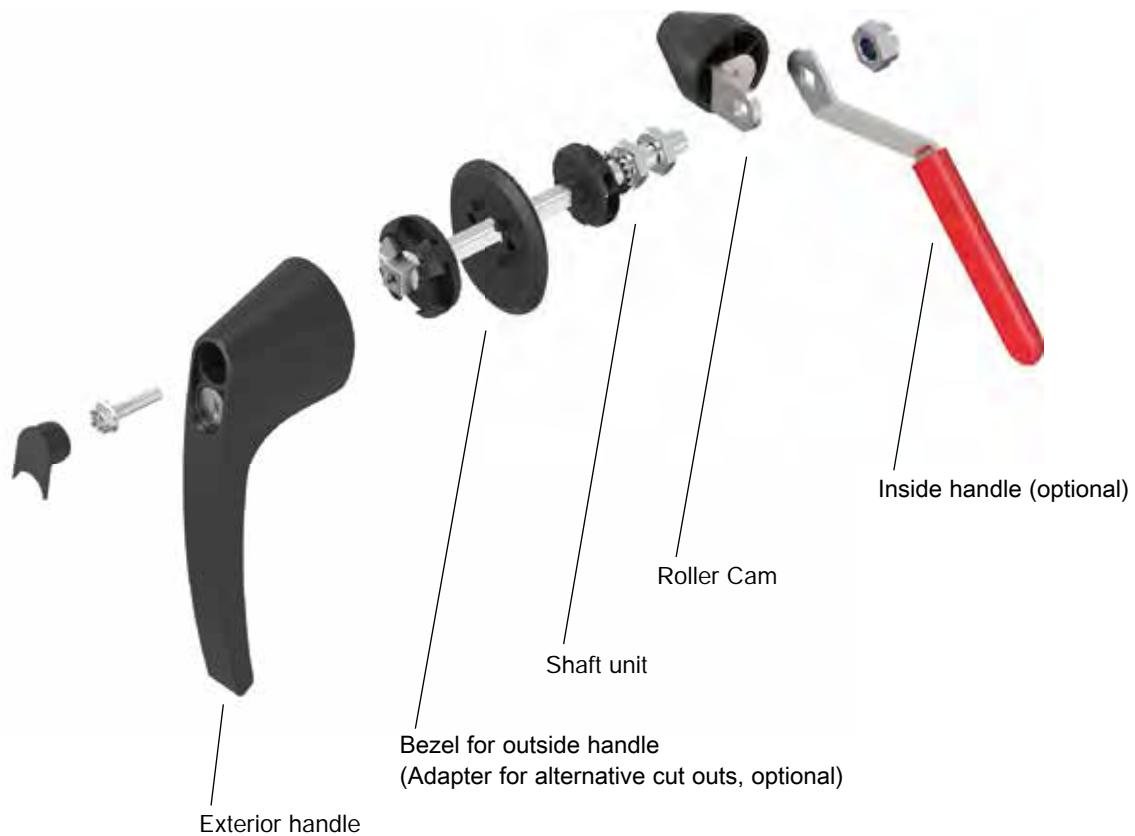
PROGRAM 1091

Suitable for doors opening inwards (Out-Swing)



Example for arrangement:

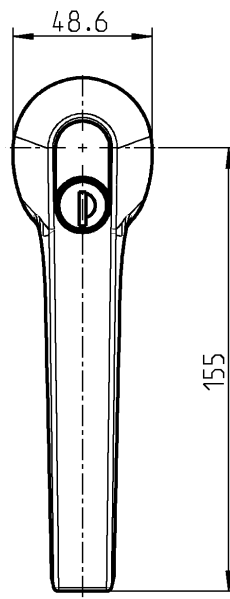
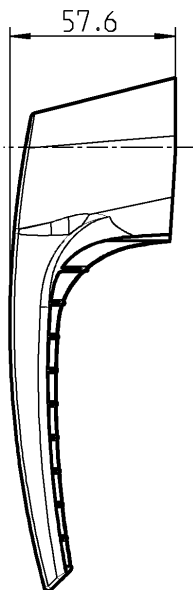
Example for arrangement:



Exterior handle

PROGRAM 1091

External handle for outward opening doors (Out-Swing)



Handle polyamide GF black
screw m.s. zinc plated; cover cap polyethylene black

non locking

1091-U159

with insert zinc die chrom plated;
locking cam and countersunk screw m.s. zinc plated;
spacer ring brass, with o-ring

Double bit 5

1091-U160

with round cylinder zinc die with stainless steel cap and dust cap;
locking cam m.s. zinc plated; adapter AISI 316; countersunk screw m.s. zinc plated.
Each round cylinder has one silver steel key with polyamide grip GF black.

Keyed EK 333

1091-U161

Keyed different

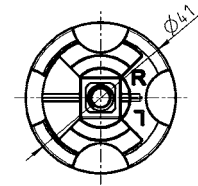
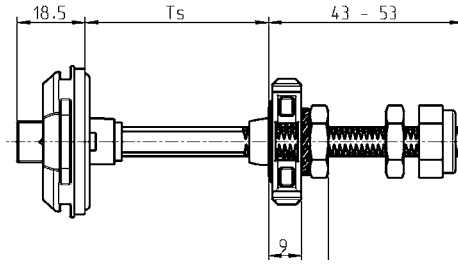
on request

Further parts see page

- Overview Page 14
- Roller Cam Page 17
- Bezel Page 26
- Shaft unit Page 16
- Inside handle Page 17



Shaft unit (RH and LH applicable)



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



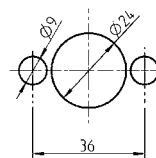
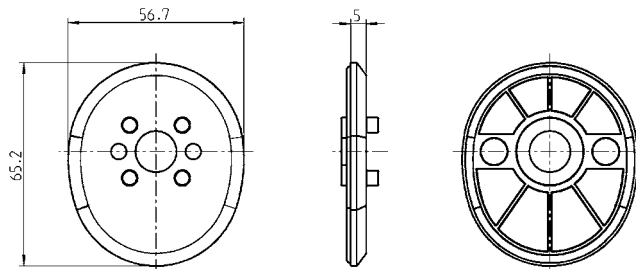
Cut out for door stop right. For door stop on the left mirror image.



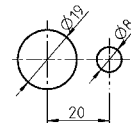
Shaft unit:
Mild steel shaft with 90° stop zinc die in assembly zinc plated;
bezel outside zinc die black powder coated;
bezel inside polyamide GF black;
nut and counter nut m.s. zinc plated, with seal

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

Bezel for outside handle for adaption of diverse cut out



Cut out; Version 1



Cut out; Version 2



Further parts see page

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- Exterior handle Page 15
- Roller Cam Page 17
- Inside handle Page 17

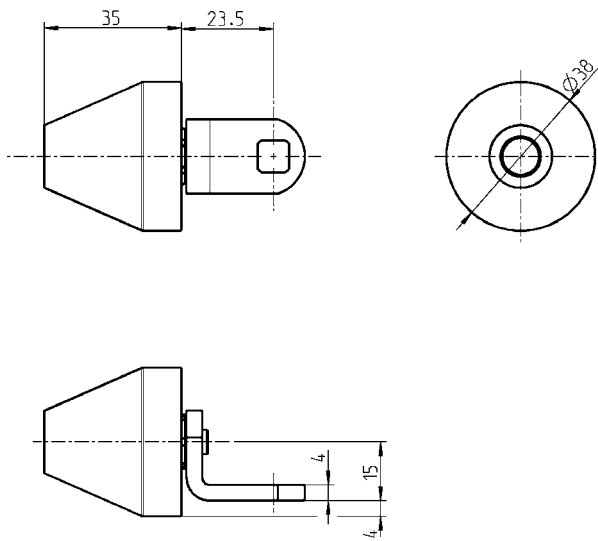
Bezel for exterior handle zinc die black powder coated, with seal

Version 1	1091-132-01G
Version 2	1091-132-02G

Conical Roller Cam; Inside Handle

PROGRAM 1000, 1091

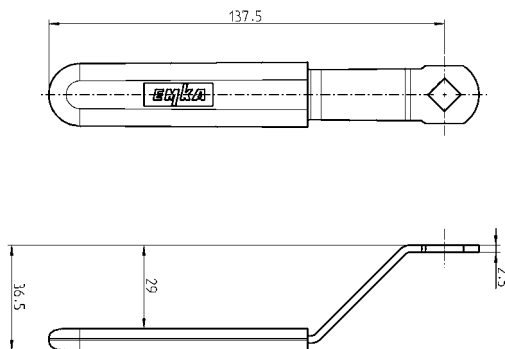
Conical roller cam big for inside the door



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

1000-U897

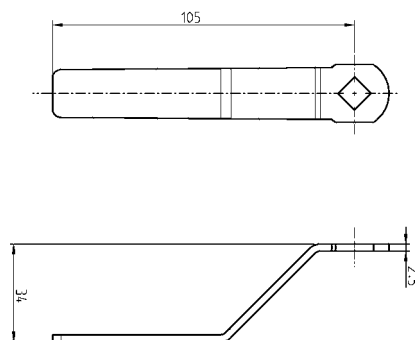
Inside handle



Inside handle m.s. zinc plated;
end stay polyamide GF red

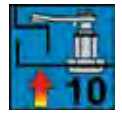
1091-133

Inside handle



Inside handle m.s. zinc plated

1091-29C

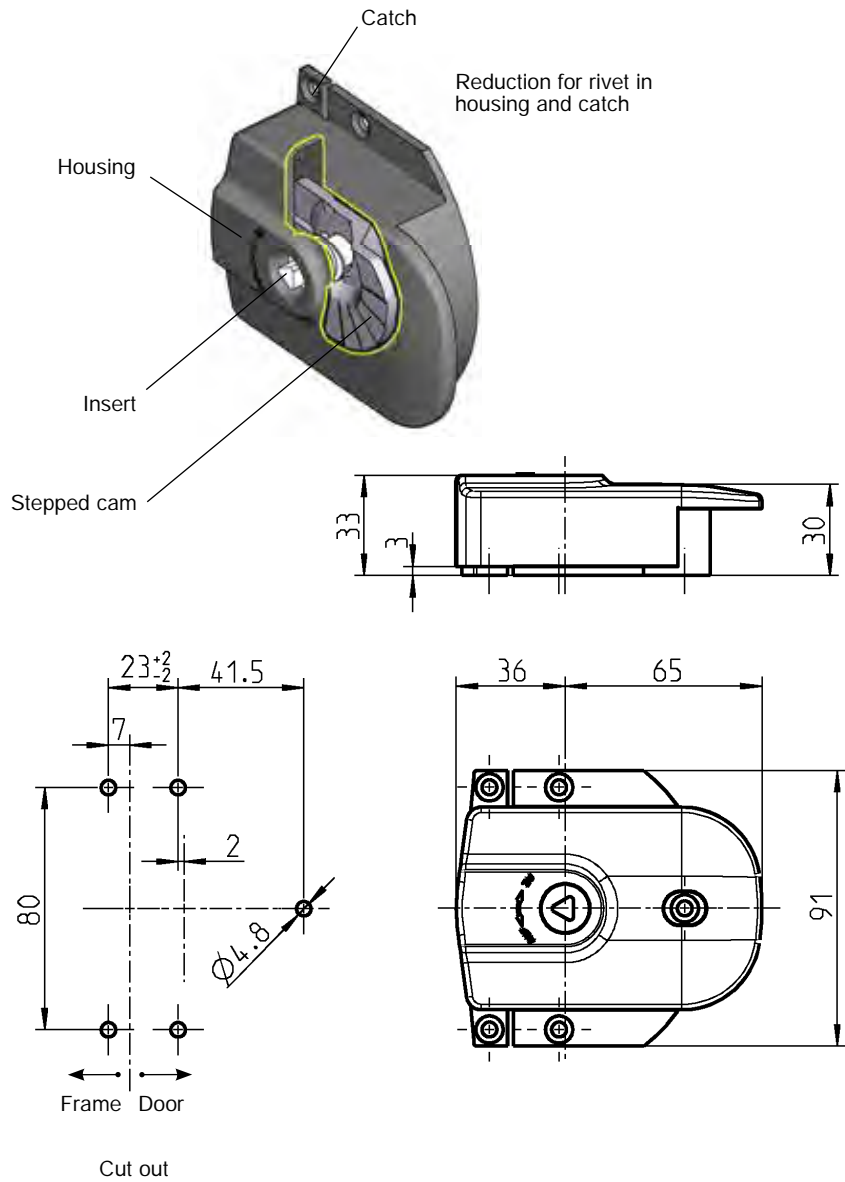


Further parts see page

- Overview Page 14
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- Bezel Page 16
- Shaft unit Page 16



Catch



Surface mounted door lock black powder coated zinc die, stepped cam zinc die raw; screw m.s. zinc plated

without insert

1000-U779

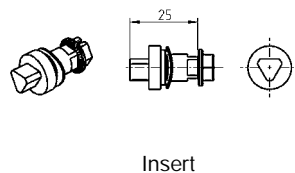
Catch zinc die black powder coated

1000-488

Attention:
Insert not included

Catch to be ordered separately

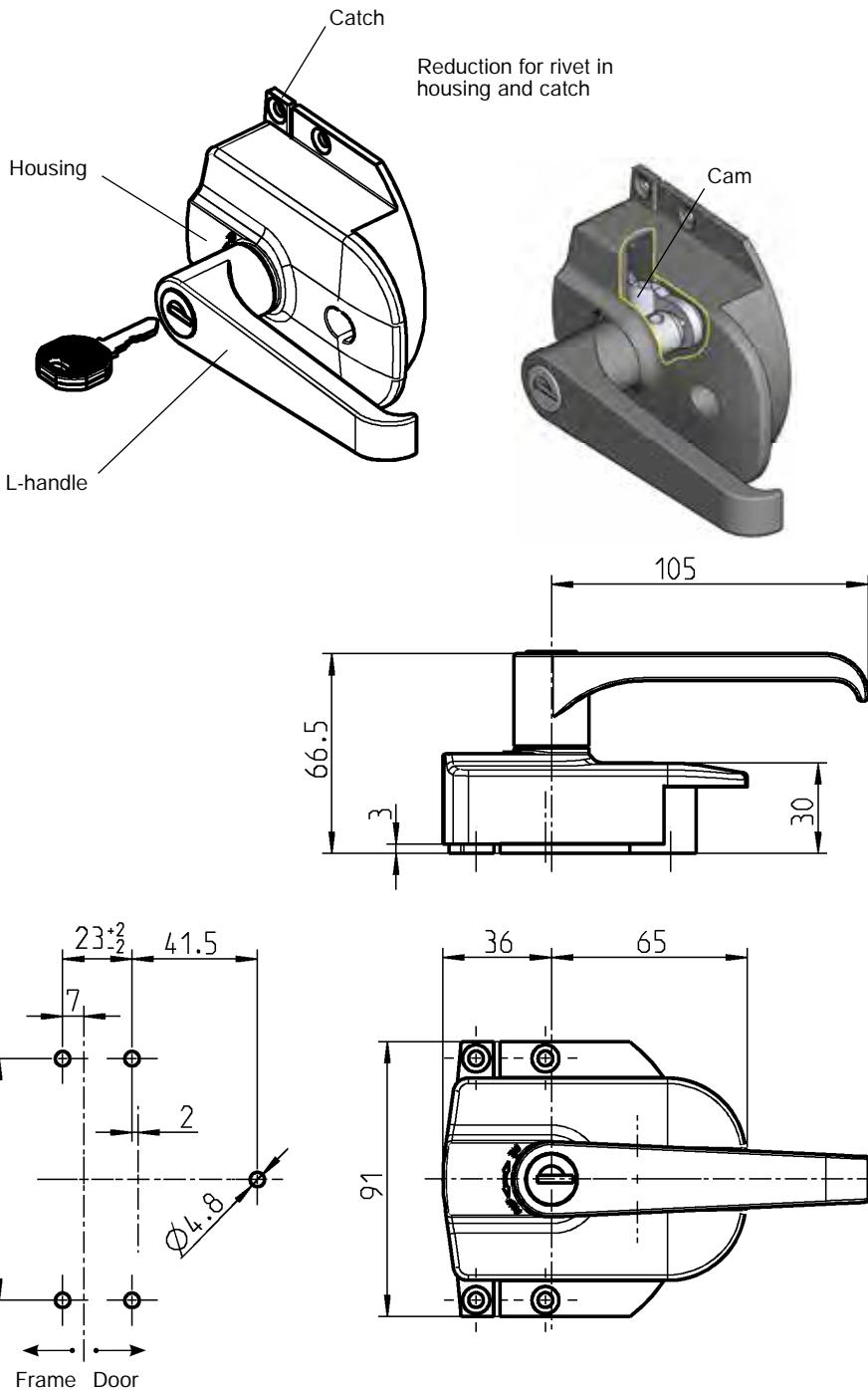
Housing and catch with long slots on request!



Insert zinc die surfaces on choice; fixing material m.s. zinc plated	Zinc die chrome plated	Zinc die black
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 2x4	1000-U142	1000-U329
Slot 2 x 4 coinproof	1000-U738	1000-U739

Door lock prominent

PROGRAM 1000



Surface mounted door lock zinc die black powder coated; L-handle polyamide GF black; stepped cam zinc die raw; screw m.s. zinc plated	
non locking	1000-U780
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	
Keyed EK 333	1000-U781
Keyed different	1000-U781-V
Catch zinc die black powder coated	
	1000-488

Catch to be ordered separately

90° locking stroke with lockable handles

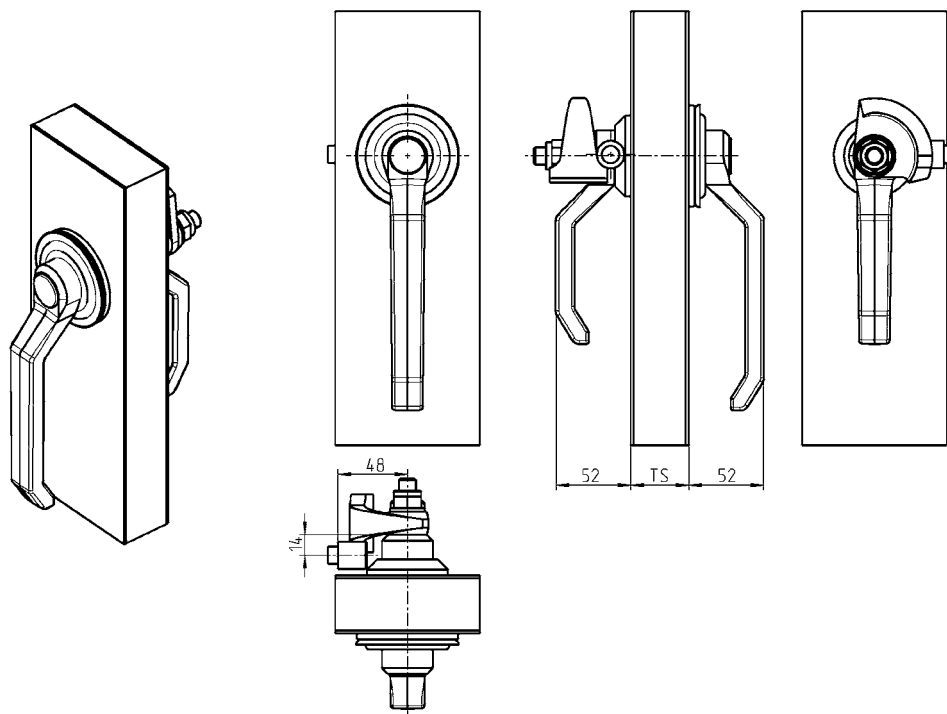
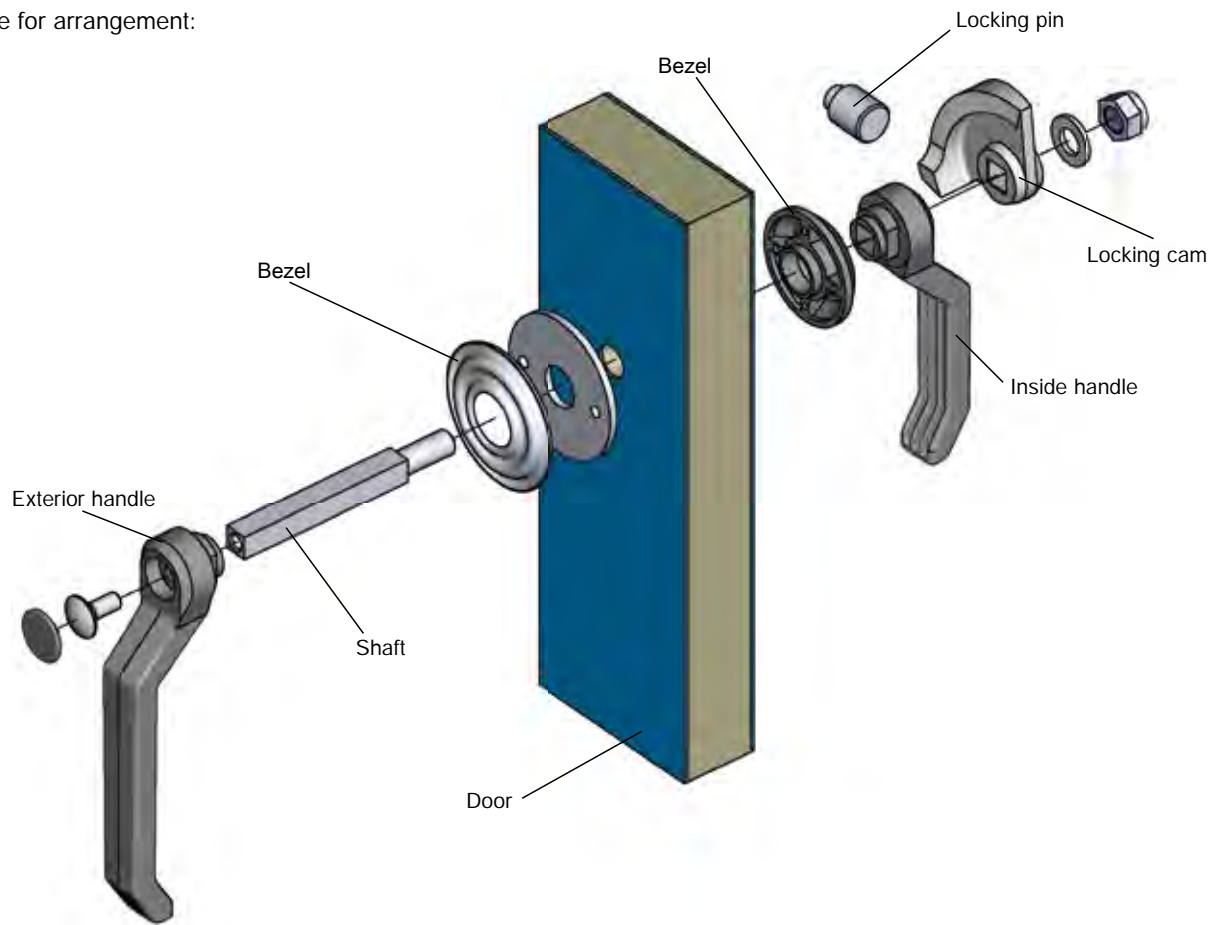
Housing and catch with long slots on request!

Suitable lockable or non lockable T-handles on request!

Heavy duty latch with m.s. shaft

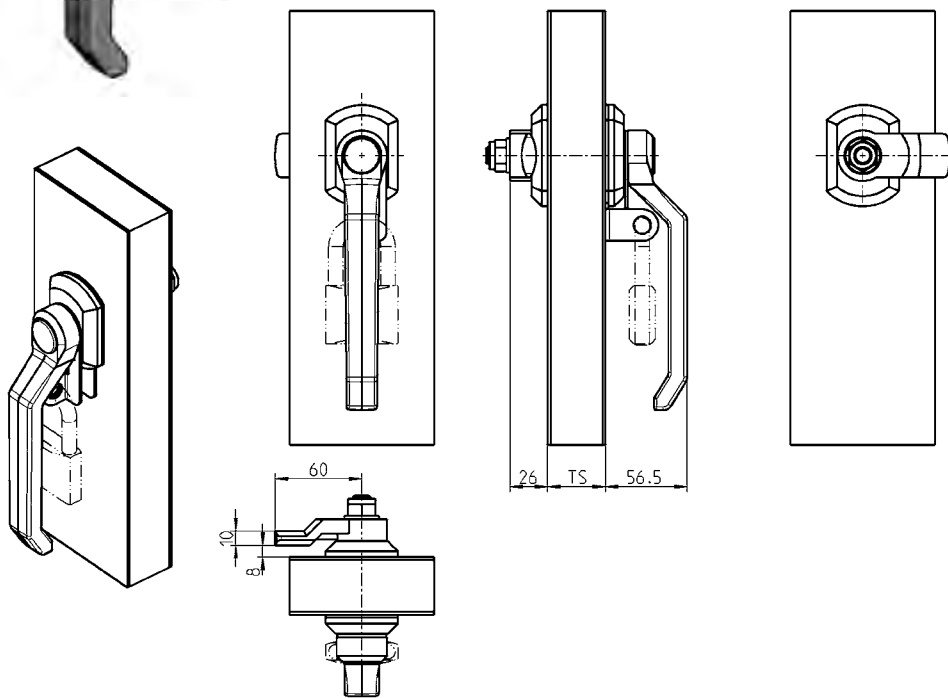
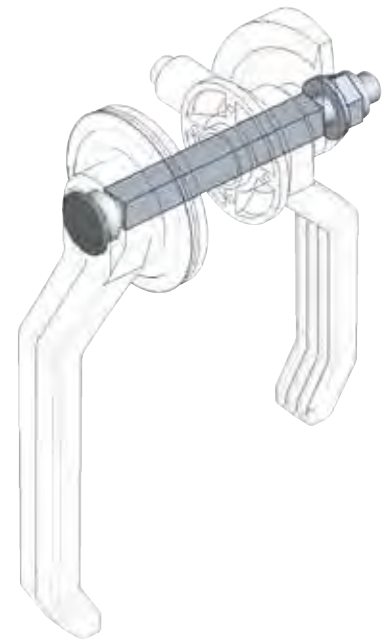
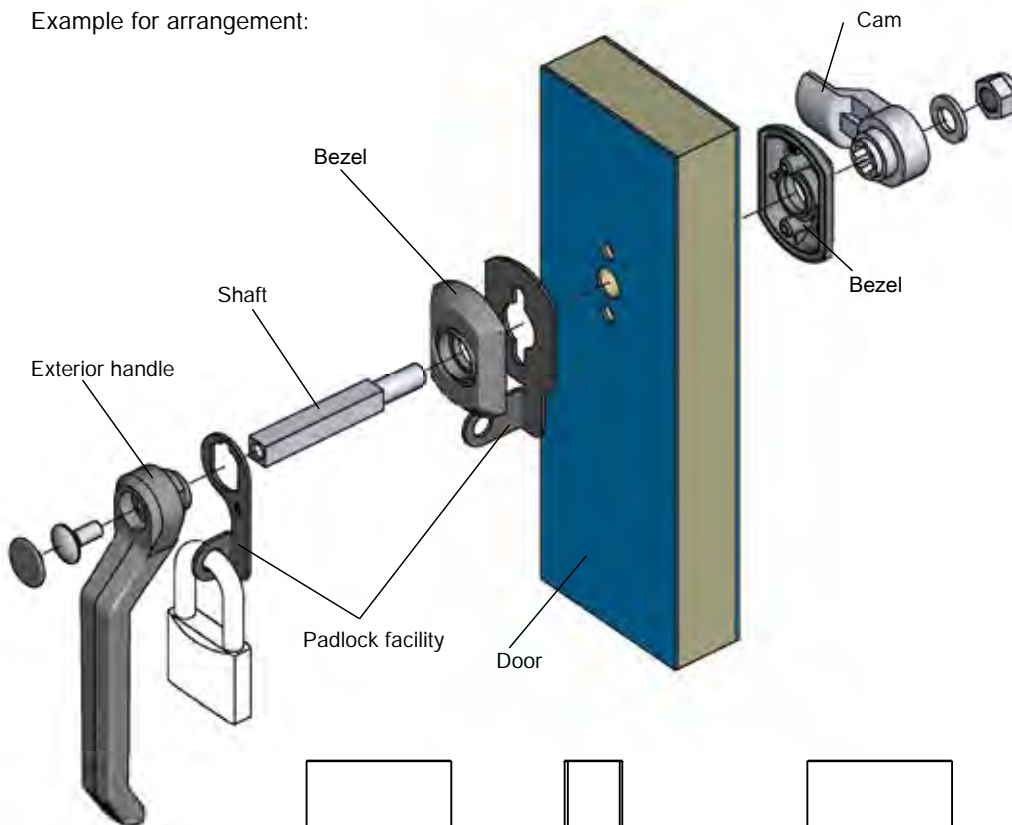
PROGRAM 1091

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
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for cam and inner handle

1091-U8	1091-U9	1091-U10	1091-U11	1091-U12	1091-U13	1091-U14	± 5
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for cam without inner handle

1091-U6	1091-U7	1091-U8	1091-U9	1091-U10	1091-U12	1091-U13	± 10
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for inside handle, or spacer and locking cam

1091-U8	1091-U9	1091-U10	1091-U11	1091-U12	1091-U13	1091-U14	± 5
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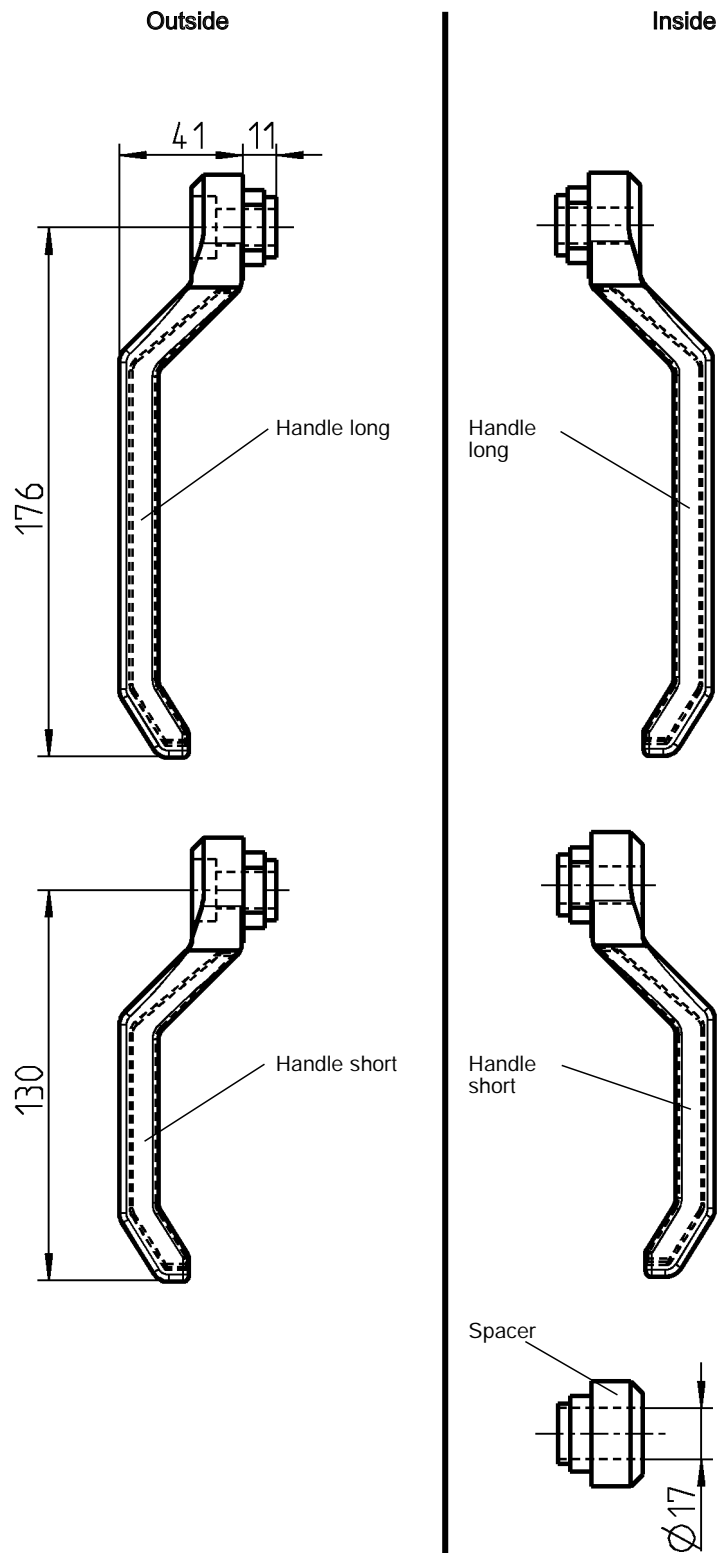
Further parts see page

- Handle	Page 22
- Locking cam	Page 23
- Cam	Page 23
- Bezel	Page 24 - 25
- Padlock facility	Page 25

RL



Handles



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

Further parts see page
 - Heavy duty latch Page 20
 - Heavy duty latch, outside the door Page 29

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

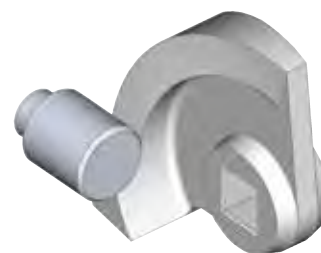
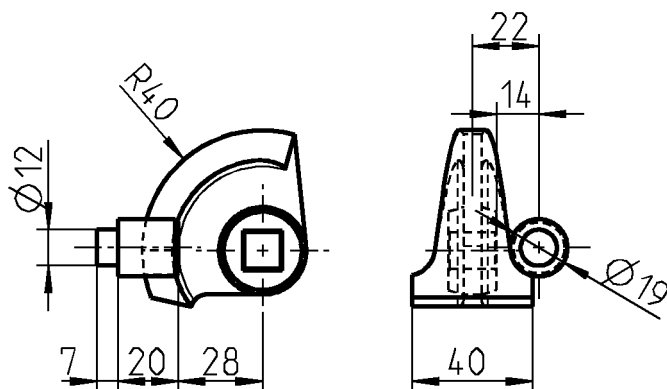
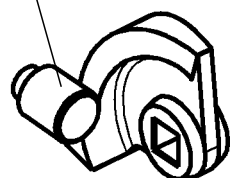
Accessories for heavy duty latch

PROGRAM 1091

Locking cam



Locking pin



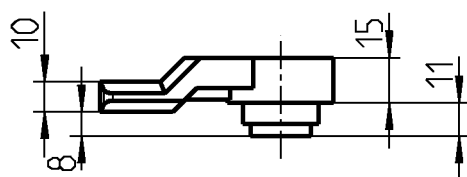
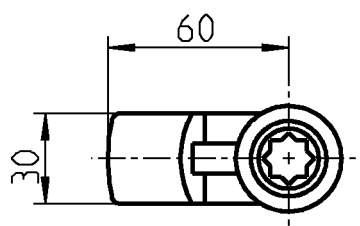
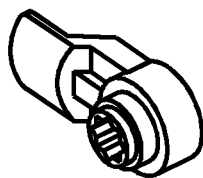
Locking cam zinc die raw

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

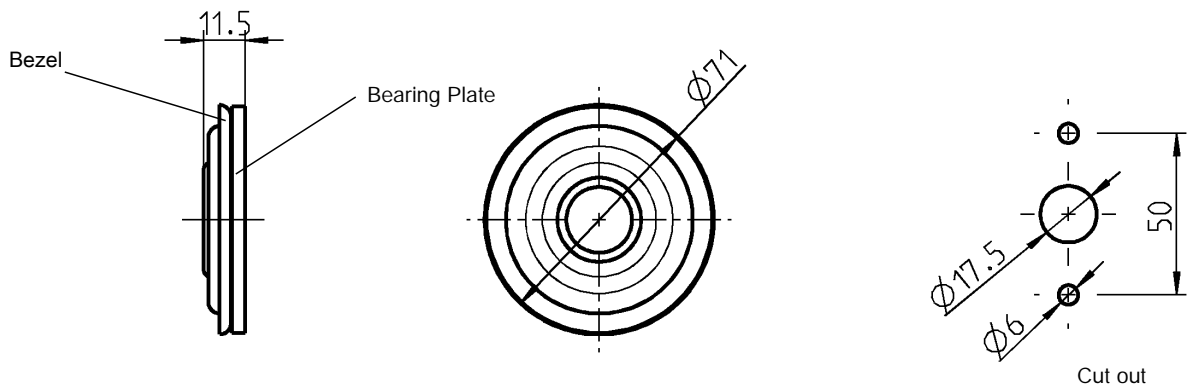
Further parts see page

– Heavy duty latch Page 20

– Heavy duty latch, outside the door (Cam) Page 29

Accessories for heavy duty latch

PROGRAM 1091

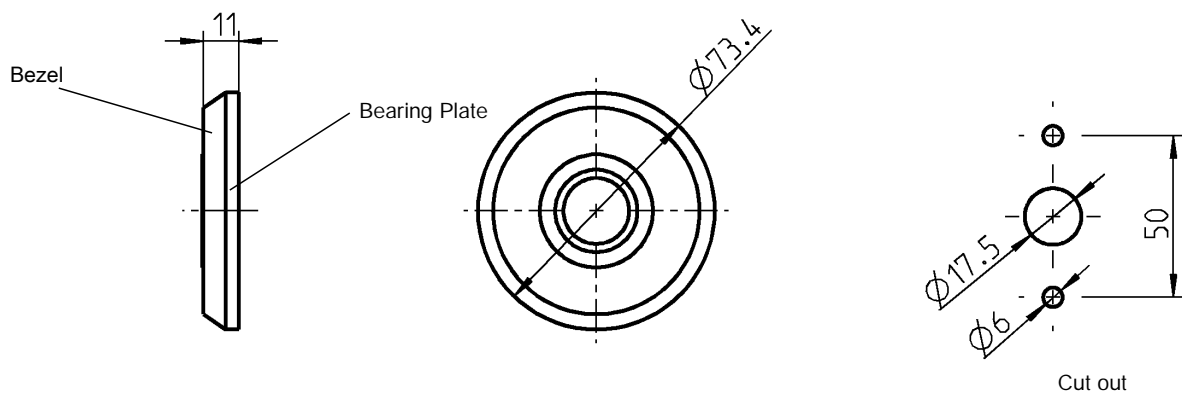


Bezel, m.s. zinc plated

1091-07

Bearing plate, m.s. zinc plated

1091-06

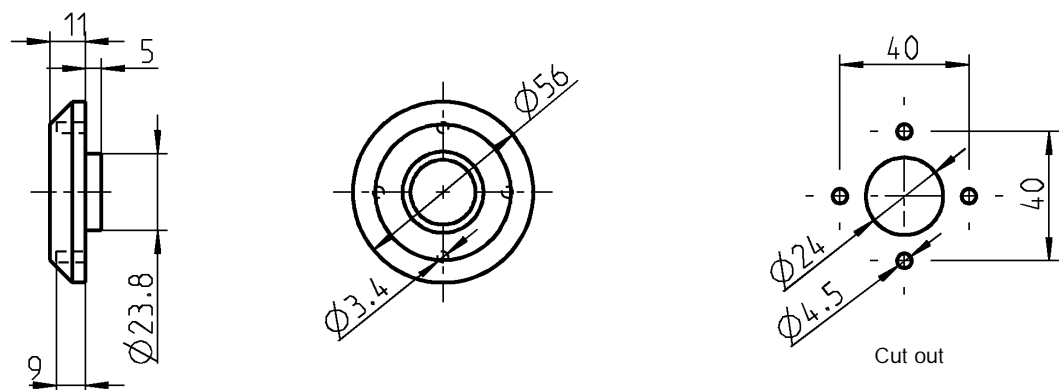


Bezel, polyamide GF black

1091-31

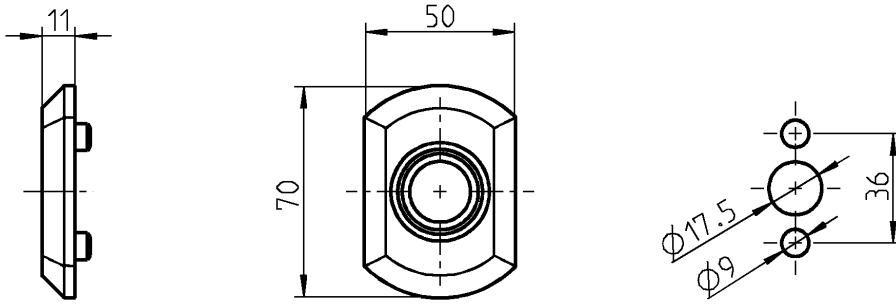
Bearing plate, m.s. zinc plated

1091-06



Bezel, polyamide GF black

1091-30



Cut out

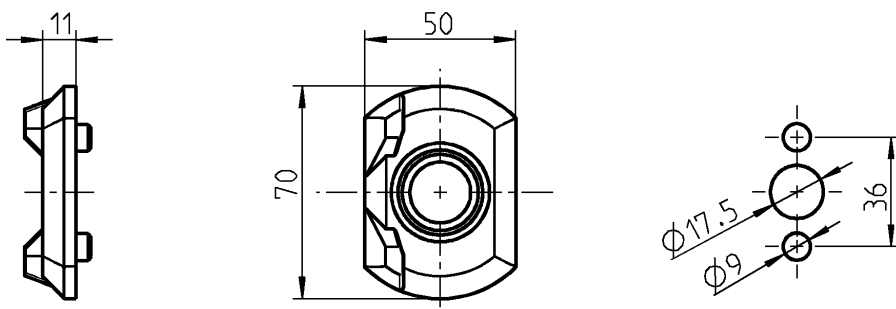
Bezel, polyamide GF black, with foamed seal

1091-17-G

IP 65 achieved by:

set of O-rings

1091-U90



Cut out

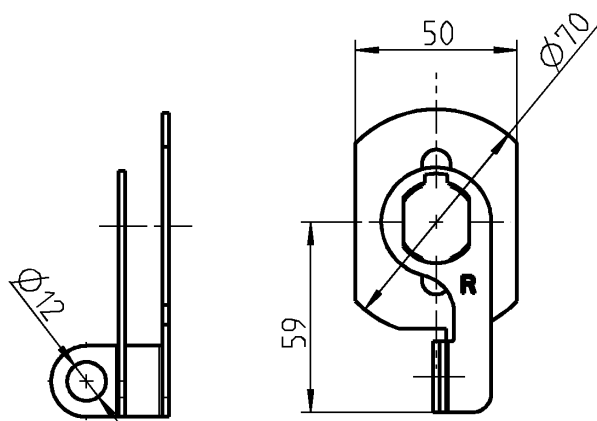
Bezel with stop dogs, polyamide GF black, with foamed seal

1091-17-01G

IP 65 achieved by:

set of O-rings

1091-U90



Padlock facility, m.s. black powder coated

Right hand version

1091-U86

Left hand version

1091-U87

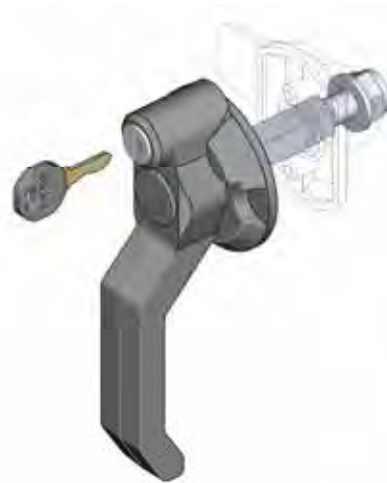
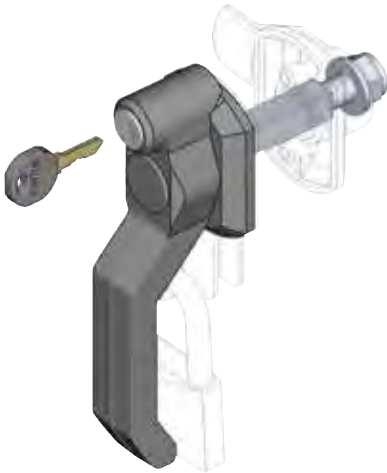
Further parts see page

– Heavy duty latch

– Bezel

Page 20

Page 26

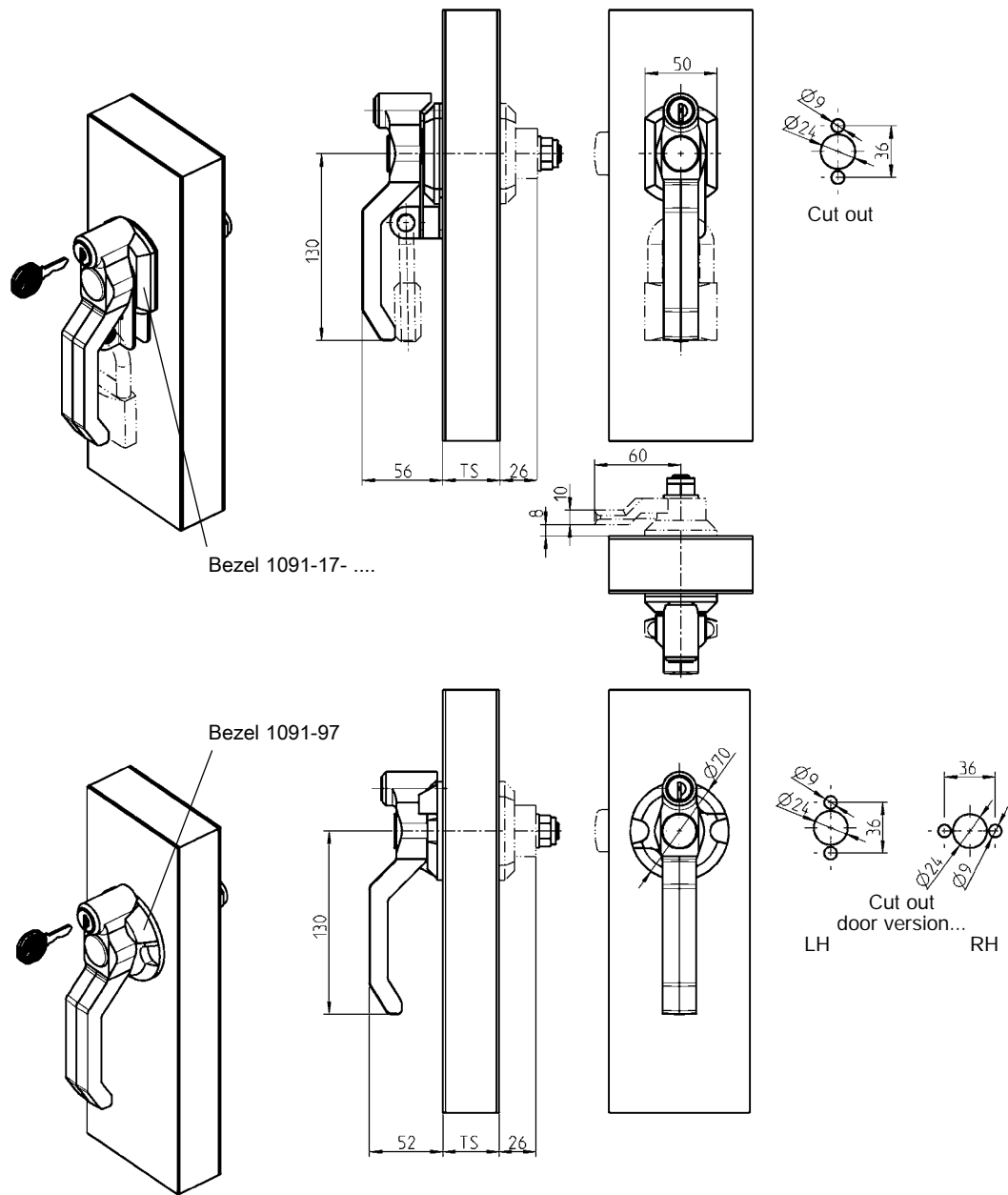


Round bezel with 90°-stopper 1091-97 also suitable for non-locking handles.

Other inserts available on request

Further parts see page

- Spacer Page 20
- Cam Page 23
- Locking cam Page 23
- Padlock facility Page 25
- Key 12B-120
- Spare key 12B-140



**Handle polyamide GF black for m.s. shaft;
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 2x4	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

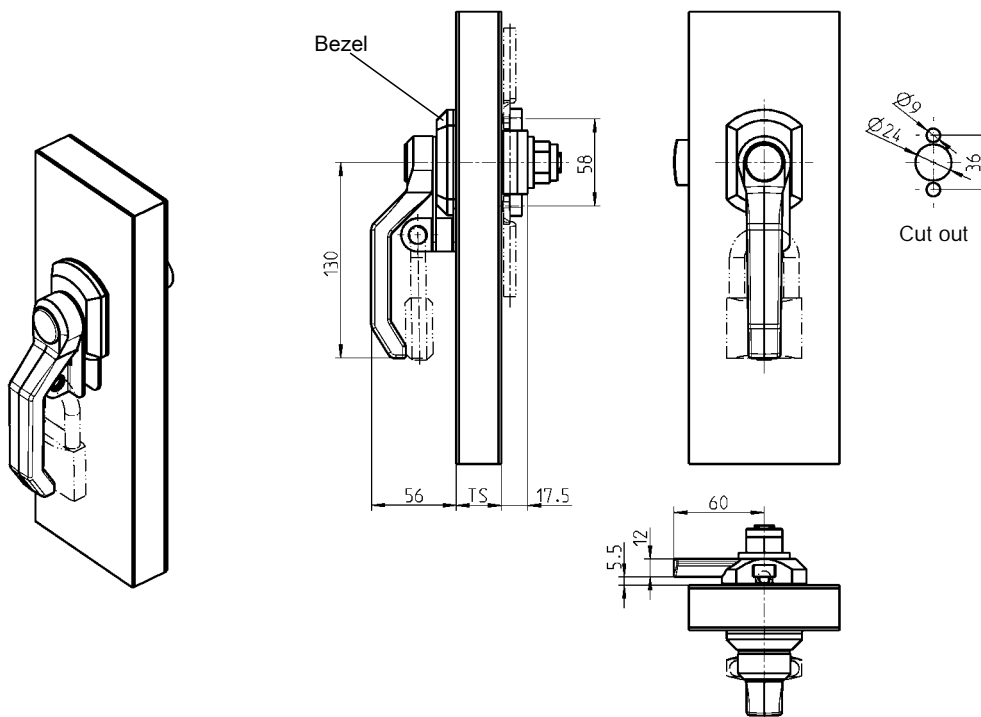
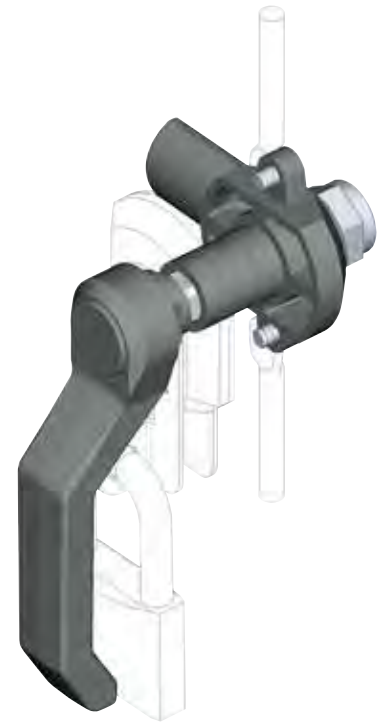
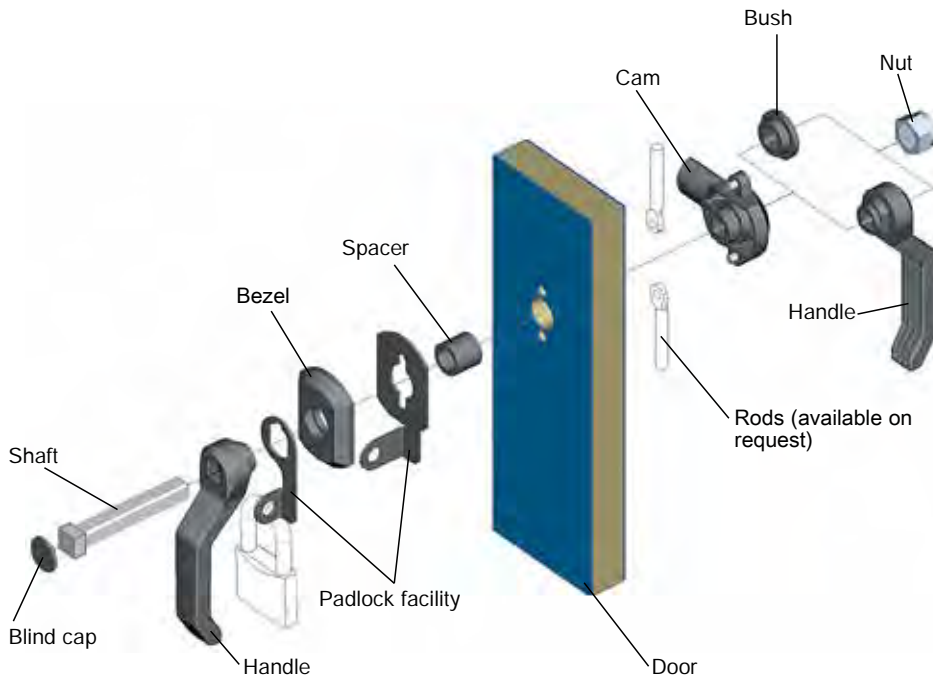
**Shaft m.s., screw, nut M12 and washer A13 m.s. zinc plated;
blind plug polyamide GF black**

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

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

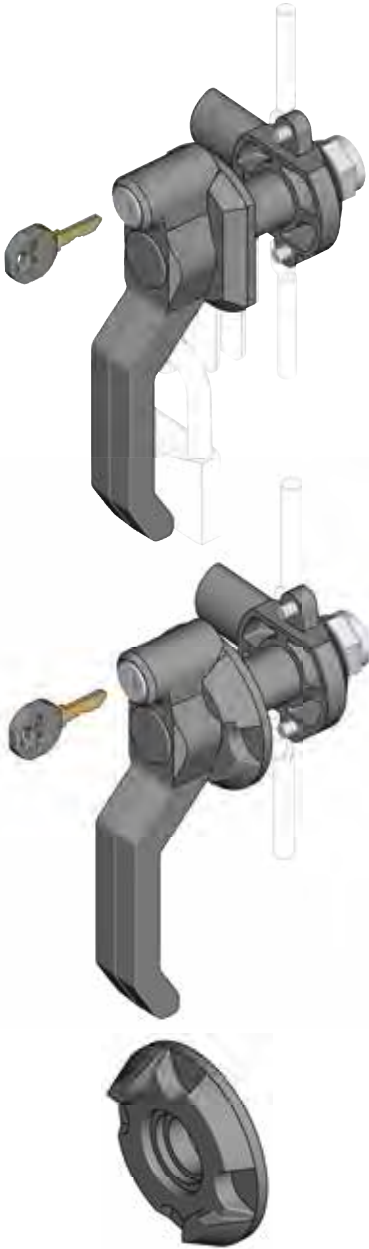
Ts	10 – 30	31 – 50	51 – 70
without 2-point rod control	1091-U80	1091-U81	1091-U82
with 3-point cam	1091-U83	1091-U84	1091-U85

Attention:

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

Further parts see page

- Bezel Page 24 - 25
- Padlock facility Page 25
- Connecting rod on request

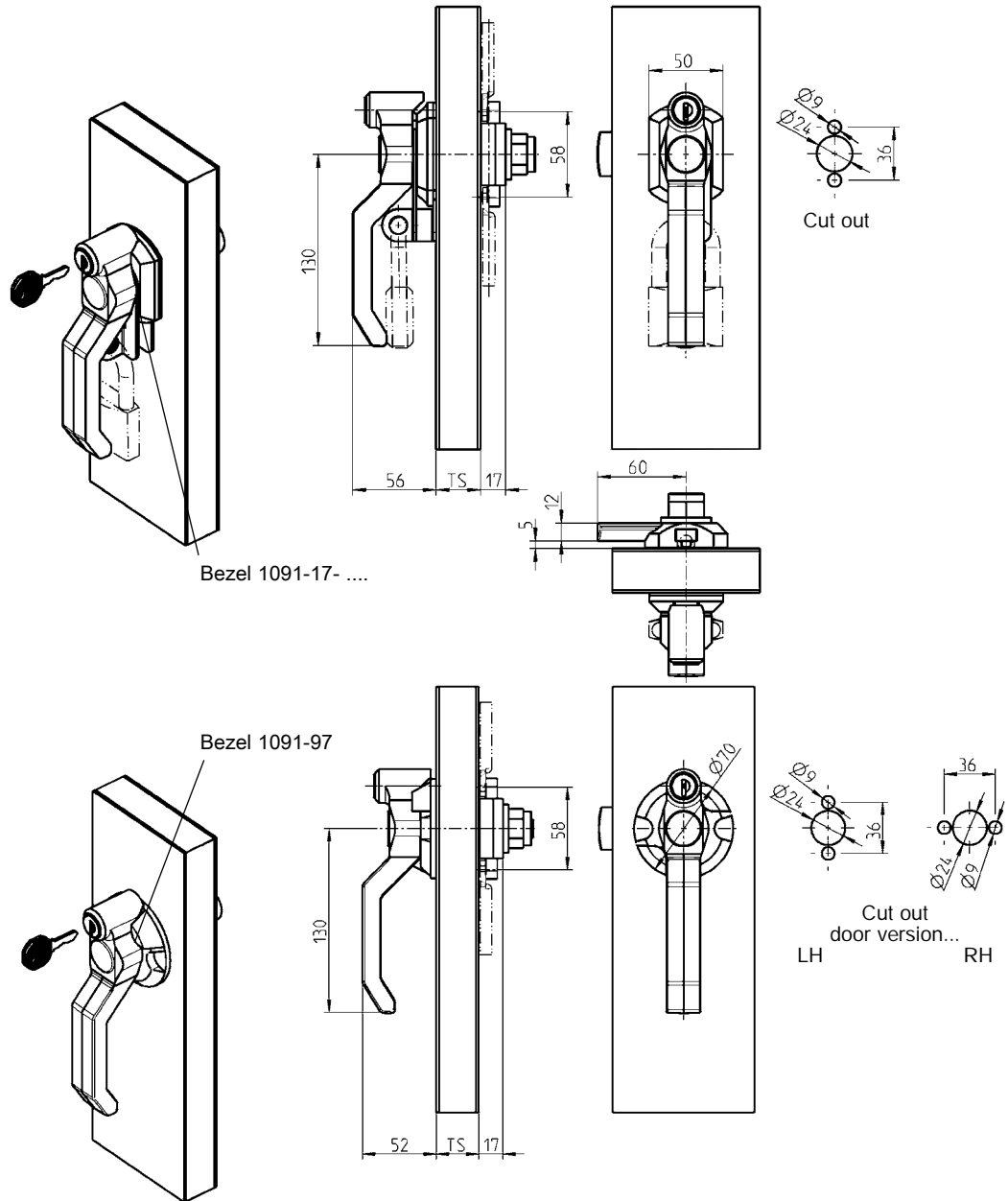


Round bezel with 90°-stopper 1091-97 also suitable for non-locking handles.

Other inserts available on request

Further parts see page

- Padlock facility Page 25
- Key 12B-120
- Connecting rod on request
- Spare key 12B-140



Handle polyamide GF black for zinc die shaft, 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 2x4	1091-U79

(order separately)
Bezel polyamide GF black for lockable handle

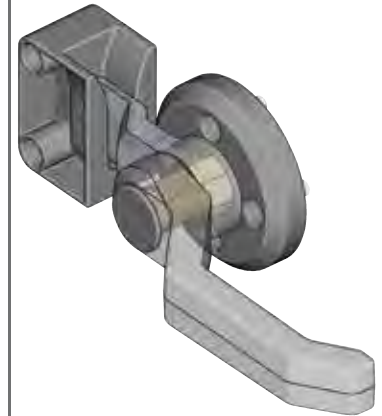
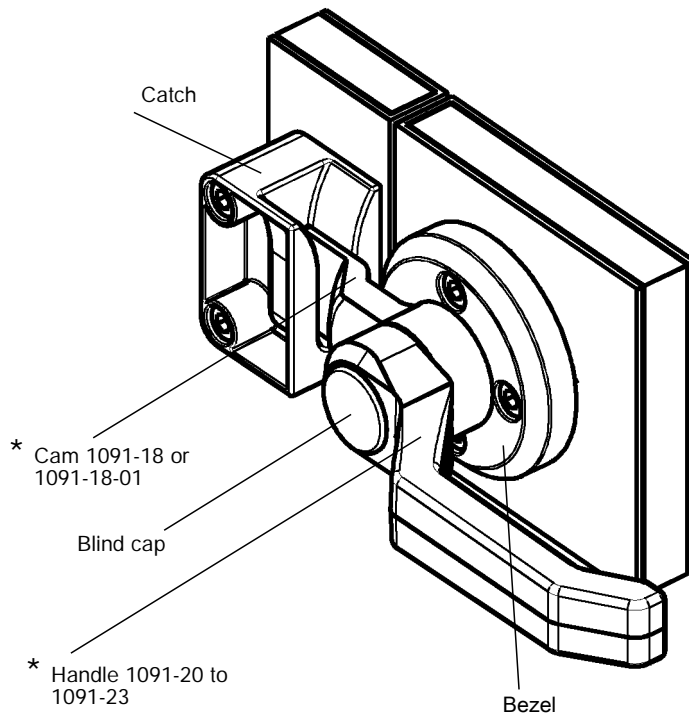
180°-stopper	1091-17-03	90°-stopper, LH	1091-17-04
90°-stopper, RH	1091-17-05	90°-stopper, round bezel	1091-97

Shaft zinc die; nut M12 m.s.; cam, spacer, bush and blind plug polyamide GF black

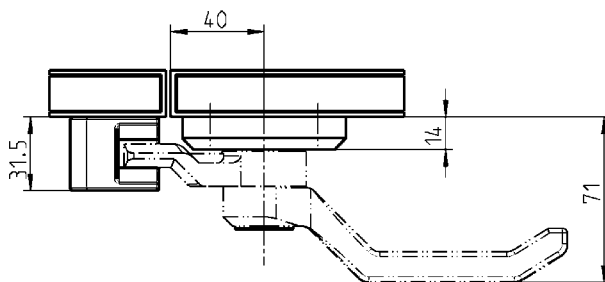
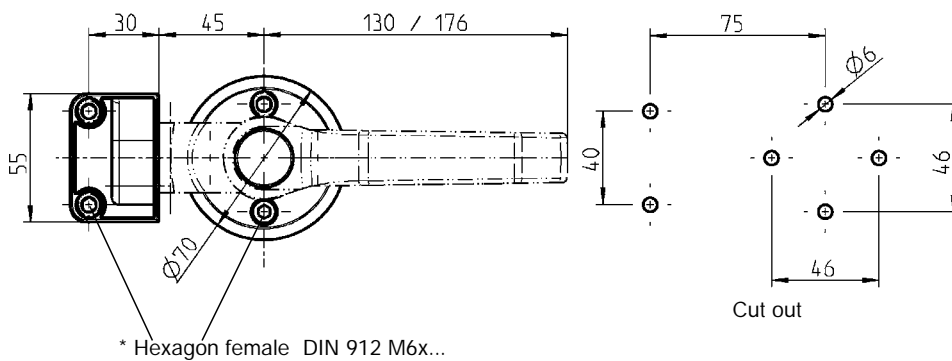
Ts	10 – 30	31 – 50	51 – 70
without 2-point rod control	1091-U80	1091-U81	1091-U82
with 3-point cam	1091-U83	1091-U84	1091-U85

Heavy duty latch, outside the door

PROGRAM 1091



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



* must order separately

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

1091-U121

Catch polyamide GF black

1091-96

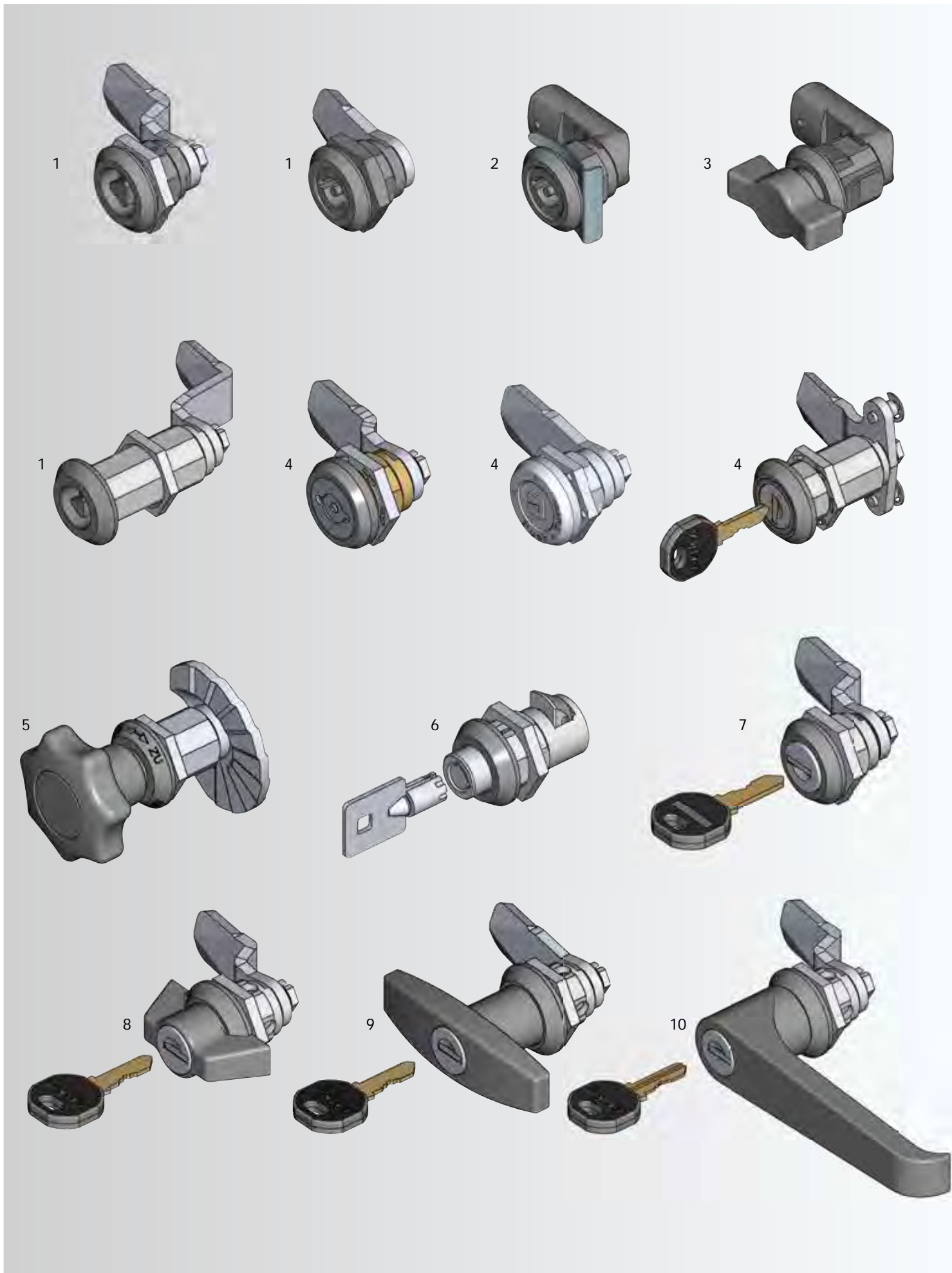
Further parts see page

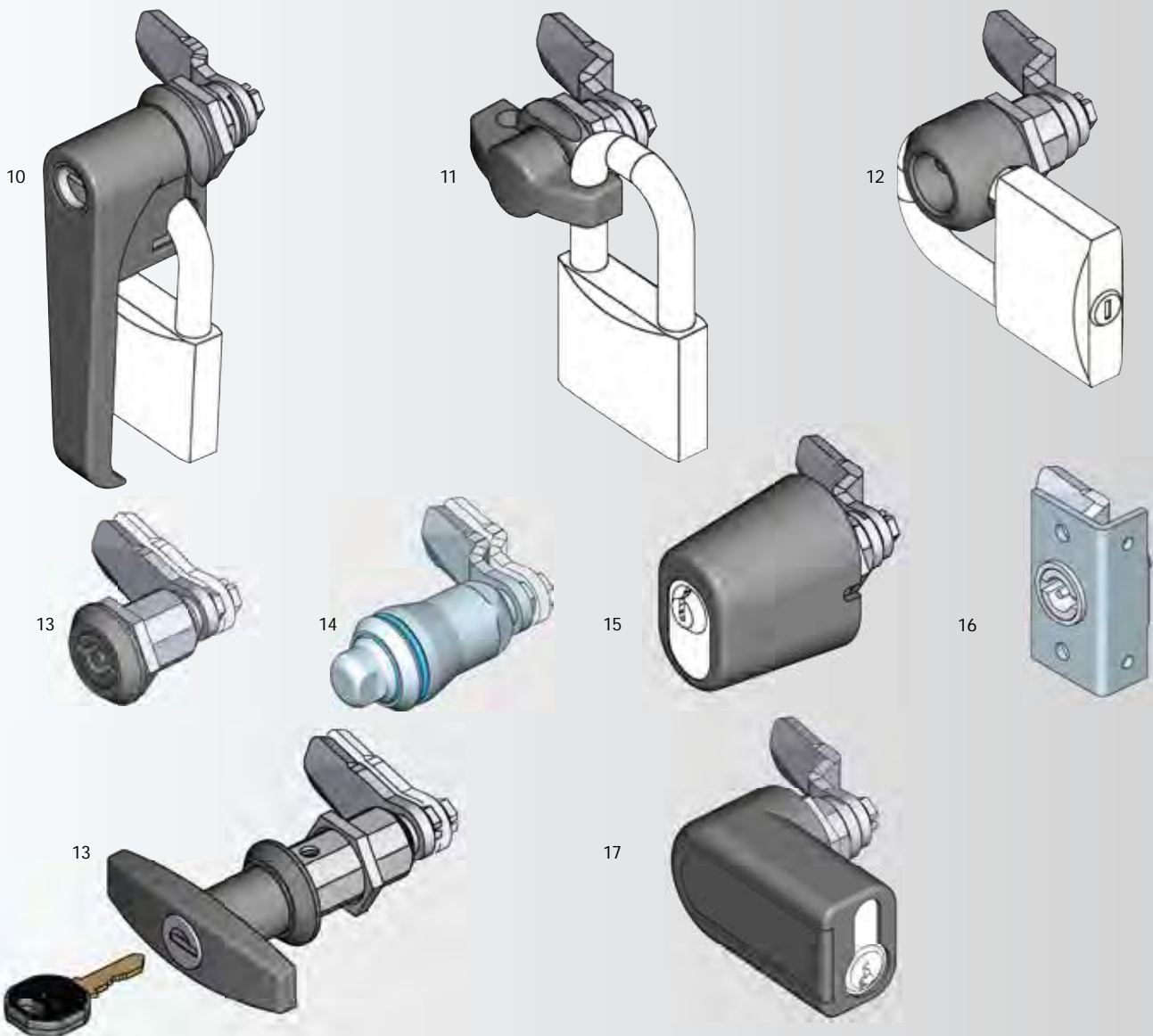
– Outside handle
– Cam

Page 22
Page 23

Quarter turn standard version

PROGRAM 1000



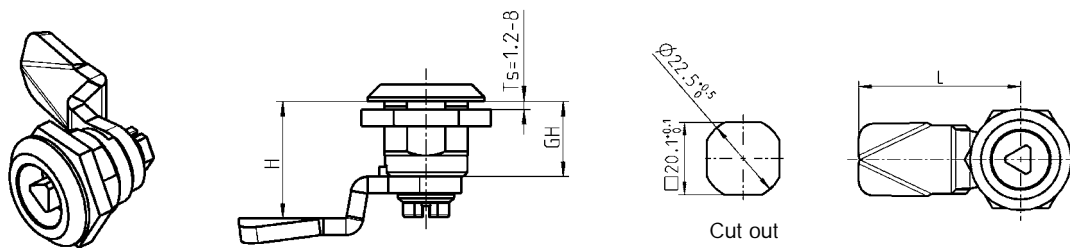


- | | | |
|----|--|---|
| 1 | Quarter turn screw-on e.g. with insert | Page 32 - 33;
1B-120 up to 1B-360, 1B-680 up to 1B-860 |
| 2 | Quarter turn with spring fixing e.g. with insert | 1B-160 |
| 3 | Clip-in quarter turn e.g. with wing knob | 1B-160, 1B-760 |
| 4 | Safety quarter turn | 1B-320 up to 1B-360 |
| 5 | Quarter turn with stepped cam e.g. with star handle | 1B-240 |
| 6 | Radial pin-push cylinder | 1B-380 |
| 7 | Quarter turn with cylinder | 1B-420 |
| 8 | Wing knob quarter turn | 1B-540 |
| 9 | T-handle quarter turn | 1B-520, 1B-560 |
| 10 | L-Handle | 1B-580 up to 1B-640 |
| 11 | Quarter turn for padlock | 1B-680 |
| 12 | Quarter turn with padlockable housing | 1B-680 |
| 13 | Compression latch | 1B-220 up to 1B-235 |
| 14 | Stainless steel compression latch for hygienic areas | 1B-837 |
| 15 | Wing knob for ASSA-cylinder | 1B-835 |
| 16 | Quarter turn screw-on or weld-on | 1B-840 |
| 17 | Quarter turn for profile half cylinder | 1B-820 |



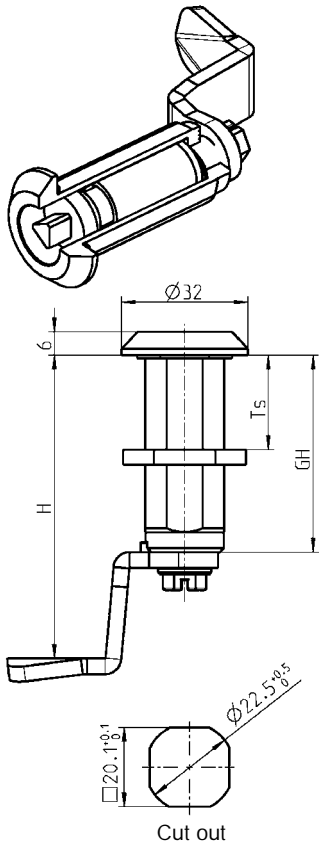
Quarter turn; Housing GH = 18 and 30 - 60; Insert; Seal

PROGRAM 1000



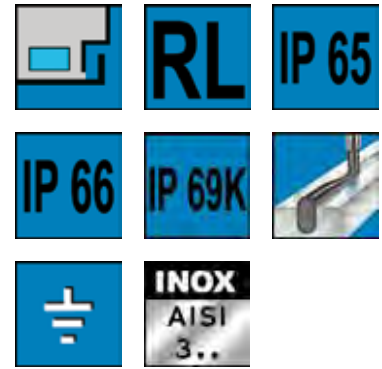
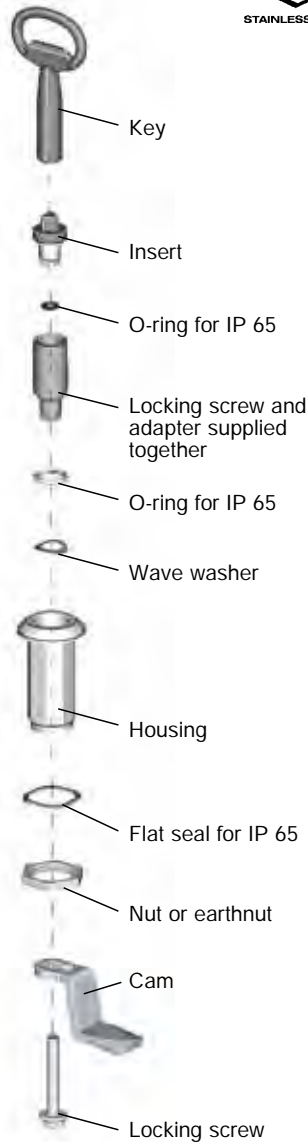
Housing with nut or earthnut m.s.zinc plated								
Head diameter								
GH = 18 mm	4		4		6		4	
Head height	Nut	Earth nut	Nut	Earth nut	Nut	Earth nut	Nut	Earth nut
Zinc die chrome plated	1000-U45	1000-U56	1000-U47	1000-U55	1000-U7	1000-U54	1000-U330	1000-U332
Zinc die chrome plated (with foamed seal)	1000-U45-G	1000-U56-G	1000-U47-G	1000-U55-G	1000-U7-G	1000-U54-G	-	-
Zinc die black powder-coated	1000-U223	1000-U224	1000-U221	1000-U222	1000-U219	1000-U220	1000-U331	1000-U333
Zinc die black powder-coated (with foamed seal)	1000-U223-G	1000-U224-G	1000-U221-G	1000-U222-G	1000-U219-G	1000-U220-G	-	-
Polyamide GF V0 black	1000-U155	-	-	-	1000-U46	-	-	-
Polyamide GF V0 black (with foamed seal)	1000-U155-G	-	-	-	on request	-	-	-
Stainless steel AISI 303 (with foamed seal)	1000-U134	-	-	-	-	-	-	-
Stainless steel AISI 316 (with foamed seal)	1000-U530	-	-	-	-	-	-	-

Insert zinc die, polyamide or stainless steel; Fixing material m.s. zinc plated or stainless steel; with seal (only for stainless steel version)	Zinc die chrome plated	Zinc die black	Polyamide 66 GF 50 black	Stainl.steel AISI 304	Stainl.steel AISI 316
		1000-U17	1000-U322	-	1000-U351
	1000-U1	1000-U323	1000-U184-N	1000-U135	1000-U531
	1000-U2	1000-U324	1000-U185-N	1000-U136	1000-U532
	1000-U18	-	-	1000-U352	-
	1000-U197	-	-	-	-
	1000-U3	1000-U325	-	1000-U334	1000-U536
	1000-U4	1000-U326	1000-U186-N	1000-U335	1000-U537
	1000-U194	-	-	-	-
	1000-U249	-	-	-	-
	1000-U5	1000-U327	1000-U187-N	1000-U183	1000-U533
	1000-U6	1000-U328	1000-U188-N	1000-U137	1000-U534
	1000-U96	-	-	-	-
	1000-U168	-	-	-	-
	1000-U182	-	-	-	-
	1000-U169	-	-	-	-
	1000-U20	-	-	-	-
	1000-U195	-	-	-	-
	1000-U142	1000-U329	1000-U196-N	1000-U630	1000-U631
	1000-U738	1000-U739	-	-	-
	1000-U336	-	-	-	-
	1000-U509	-	-	1000-U729	-
	1000-U757	-	-	1000-U757-01	-
			Zinc die/ polyamide black	Polyamide GF black / AISI 304	
	-	-	1000-U13	1000-U138	-
	-	-	1000-U78	1000-U510	-



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

Assembling instruction



IP 65 achieved by:	
** flat seal	1000-23
** O-ring	1000-24
IP 66 achieved with:	
Seal set	1000-U769
IP 69K achieved by:	
* Seal set	1000-U841
Assembly on request:	
without O-ring	1000-990
with O-ring	1000-991

** included in case of stainless steel version

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

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	AISI 316
	Nut	Earthnut	Nut	Earthnut	Nut	Nut
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					-

Note

Quarter turn assembly 1B-105

Further parts see page

- Housing	1B-760 1B-680 1B-820
- Quarter turn with stepped cam	1B-240
- cam with catch	Page 34 - 35 1C-120 to 1C-180
- Accessories	from 1C-170
- Insert with wing knob	1B-720
- Escutcheon	3B-140
- Door lock prominent	
- Key	12A-220 12B-120

Cam with catch

Cam without catch

PROGRAM 1000

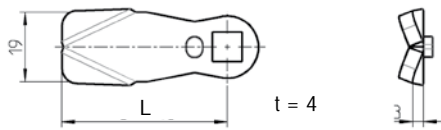


Cam with catch

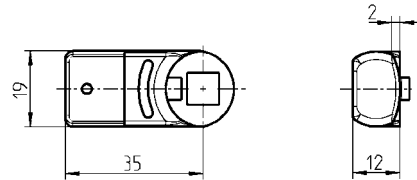


Cams without catch on request.

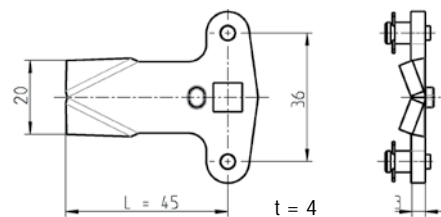
Version 1
Cam



Version 2
Cam

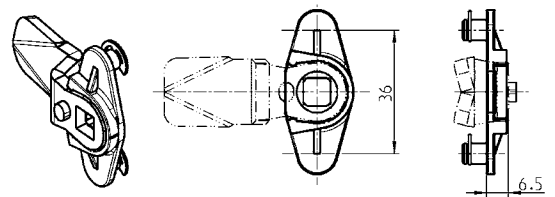


***Version 3**
Cam with rod control



***Version 4**

Rod control for steel cam or stainless steel cam



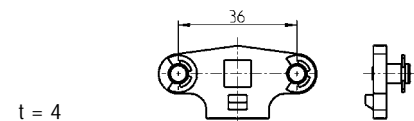
Rod control zinc die, zinc plated,
circlip m.s. zinc plated

1000-U776

Rod control AISI 316, circlip stainless steel

1000-U776-PH

***Version 5**
Rod control



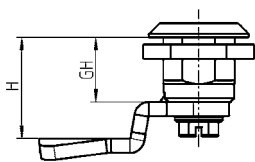
2-point rod control m.s. zinc plated

1000-U167

Cam with catch material as requested

H dimensions for GH ≙

18	22	28	30	31	32	36	39	40	42	43	45	50	60	Version 1	
														L ≙ 45	
														m.s. zinc pl.	
4	8	14	16	17	18	22	25	26	28	29	31	36	46	1000-112	
6	10	16	18	19	20	24	27	28	30	31	33	38	48	1000-22	
8	12	18	20	21	22	26	29	30	32	33	35	40	50	1000-113	
10	14	20	22	23	24	28	31	32	34	35	37	42	52	1000-21	
13	17	23	25	26	27	31	34	35	37	38	40	45	55	1000-20	
14	18	24	26	27	28	32	35	36	38	39	41	46	56	1000-19	
15	19	25	27	28	29	33	36	37	39	40	42	47	57	-	
16	20	26	28	29	30	34	37	38	40	41	43	48	58	1000-18	
18	22	28	30	31	32	36	39	40	42	43	45	50	60	1000-17	
20	24	30	32	33	34	38	41	42	44	45	47	52	62	1000-16	
22	26	32	34	35	36	40	43	44	46	47	49	54	64	1000-15	
24	28	34	36	37	38	42	45	46	48	49	51	56	66	1000-14	
25	29	35	37	38	39	43	46	47	49	50	52	57	67	1000-27	
26	30	36	38	39	40	44	47	48	50	51	53	58	68	1000-50	
28	32	38	40	41	42	46	49	50	52	53	55	60	70	1000-13	
30	34	40	42	43	44	48	51	52	54	55	57	62	72	1000-28	
32	36	42	44	45	46	50	53	54	56	57	59	64	74	1000-26	
34	38	44	46	46	48	52	55	56	58	59	61	66	76	1000-12	
35	39	45	47	48	49	53	56	57	59	60	62	67	77	1000-11	
36	40	46	48	49	50	54	57	58	60	61	63	68	78	1000-51	
38	42	48	50	51	52	56	59	60	62	63	65	70	80	1000-52	
40	44	50	52	53	54	58	61	62	64	65	67	72	82	1000-25	
42	46	52	54	55	56	60	63	64	66	67	69	74	84	1000-53	
44	48	54	56	57	58	62	65	66	68	69	71	76	86	1000-54	
45	49	55	57	58	59	63	66	67	69	70	72	77	87	1000-10	
47	51	57	59	60	61	65	68	69	71	72	74	79	89	1000-55	
50	54	60	62	63	64	68	71	72	74	75	78	82	92	1000-56	

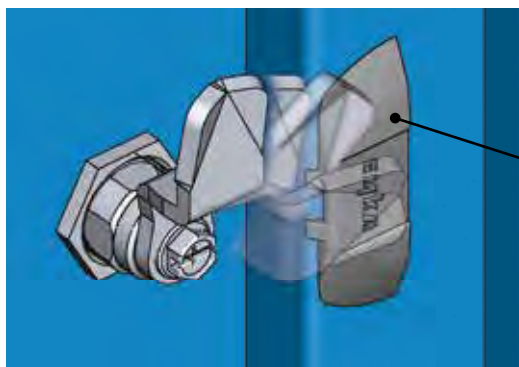


minus offset

↑
straight version

↓
plus offset

* When using cams for rod operation you must be aware that the rods travel in an axial direction.



The leading ramp increases the compression by 4 mm.
see catalogue page 1C-170



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 GF black ①	Polyamide GF 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

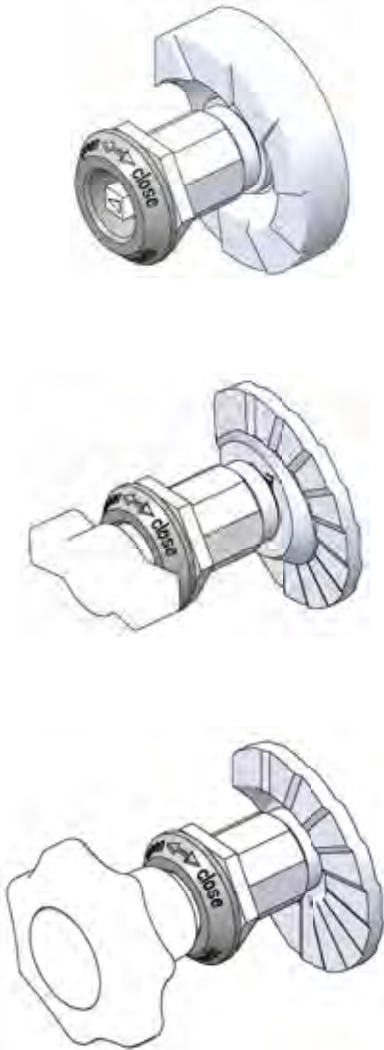
Note

The H dimension of the cam increases by 4mm when using the leading ramp (see page 1C-170)

The H dimension will be reduced by 2 mm when used with the finger pull (see page 1C-320)

Further parts see page

- Leading ramp 1C-170
- Connecting rod 1C-620
- Quarter turn Page 32 - 33
- 1B-120
- 1B-140
- for quick mounting 1B-180
- 1B-220
- 1B-230
- 1B-320
- to 1B-335
- 1B-360
- to 1B-760
- 1B-835
- to 1B-860
- 1C-170
- Inside handle
- Swinghandle 1152 with compression 3C-540
- Swing handle 3N-120
- Heavy duty latch 10A-620
- 10A-640

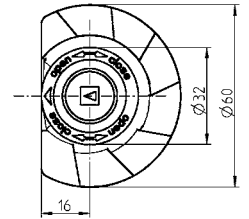
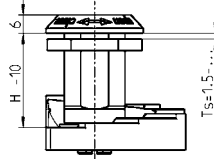
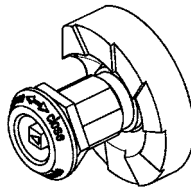


Housing with 270° stop

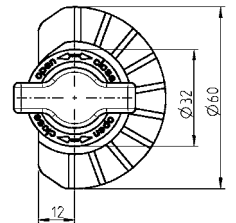
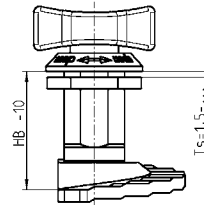
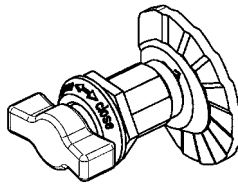
Advice:
Quarter turn-Assembling 1B-105

Further parts see page
 - Insert 1B-140
 - IP 65 or IP 66 1B-140
 - Accessories from 1C-320
 - Escutcheon 3B-140
 - Key 12B-120

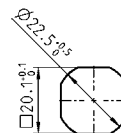
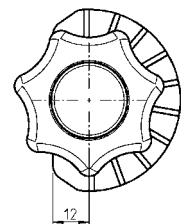
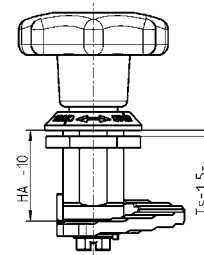
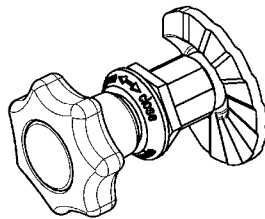
Version A



Version B



Version B



Cut out

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 (Flush mounted insert)	Spacer, zinc alloy for 5 mm tolerance and screw zinc plated
				chrome plated	black p.c.		
1.5 -							
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

Compression latch

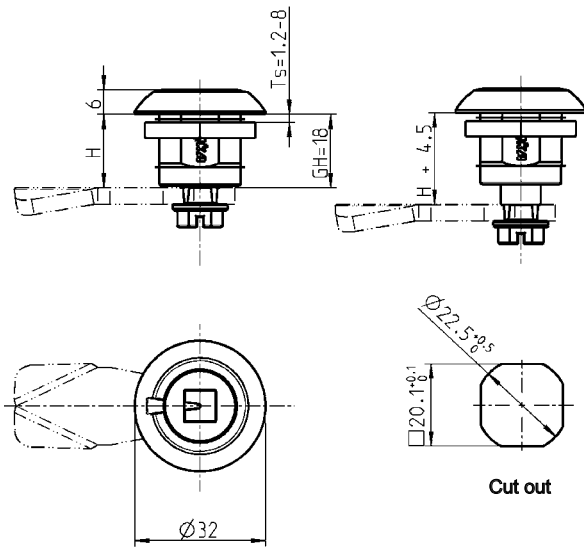
PROGRAM 1000

Tamper and vibration proof

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



for stainless steel version

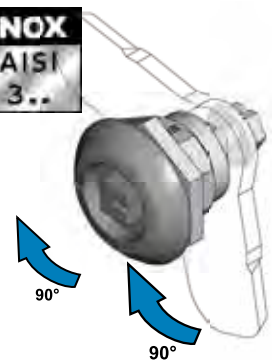


Product benefits

- 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

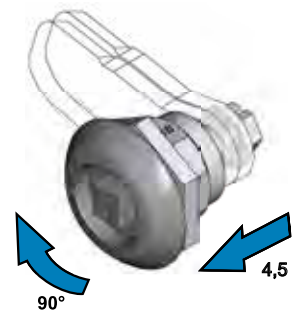
Housing and insert material of your choice; nut and screw m.s. zinc plated or stainless steel; with spring and seal

	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
Male hexagon 11.1mm with indicator	on request	on request	on request
Hexagon female 8	on request	on request	on request
Hexagon female 8mm with pin	on request	on request	on request
Hexagon female 10mm	on request	on request	on request
Square female 6mm	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 2x4	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



Open

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



Closed

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



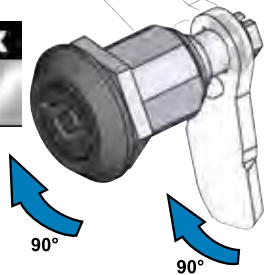
Compressed

Open:
Reversed motion

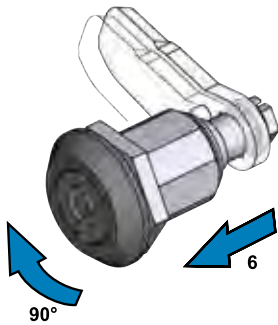
Further parts see page

- Cam without catch from 34
- (not for cam with rod control)
- Accessories from 1C-320
- Escutcheon 3B-140
- Key 12B-120

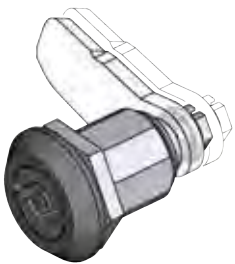
Compression latch PROGRAM 1000



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 from 34
(not for cam with rod control)
– Accessories from 1C-320
– Escutcheon 3B-140
– Key 12B-120

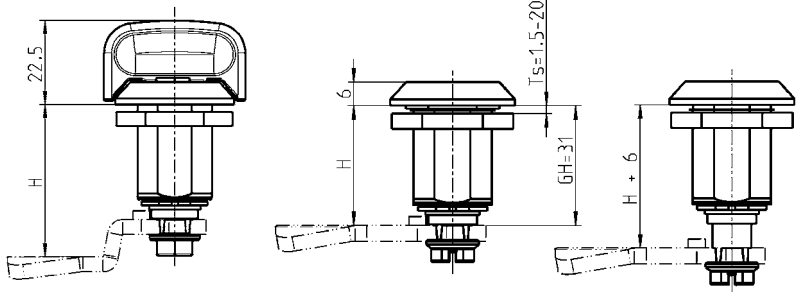


Tamper and vibration proof

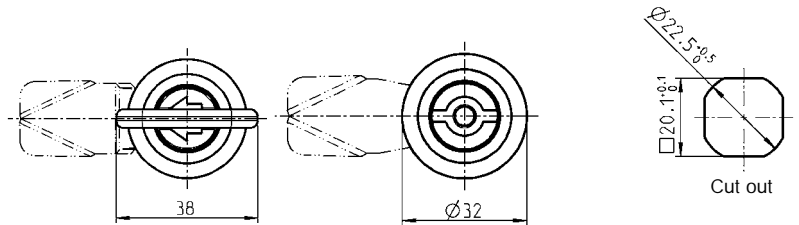
The compression latch is designed to be vibration-proof as such. Depending on the installation location and the operational conditions, specific tests and/or supplementary measures of fastening are necessary.



for stainless steel version



Housing with indicator on request



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

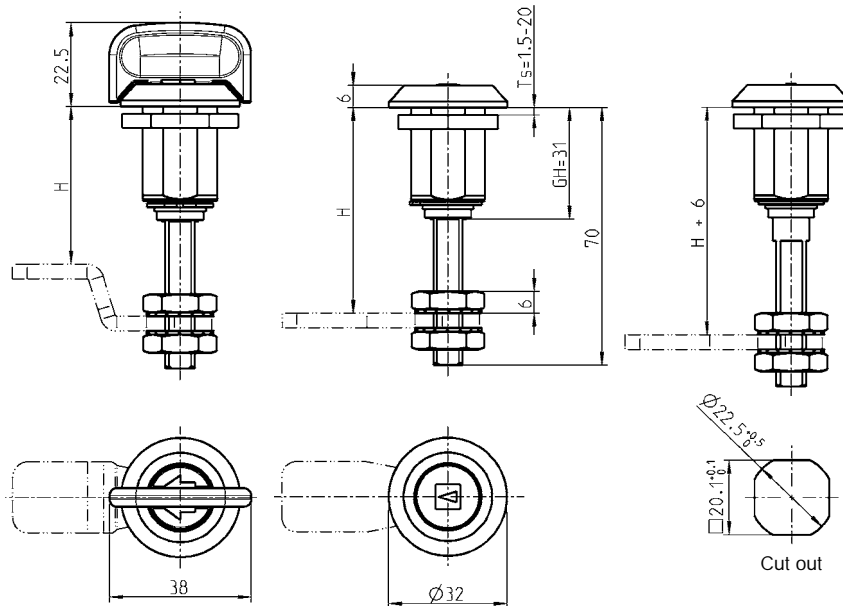
	Zinc die black powder-coated	AISI 316
Square 6 with arrow	on request	on request
Square 7 with arrow	1000-U796	on request
Square 8 with arrow	1000-U798	on request
Square 8 with indicator	on request	1000-U755-01
Triangular 6.5 CNOMO	on request	on request
Triangular 7	1000-U795	on request
Triangular 8	1000-U783	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 female 8	1000-U807	on request
Hexagon female 8mm with pin	1000-U805	on request
Hexagon female 10mm	1000-U809	on request
Square female 6mm	on request	on request
Square female 7mm	on request	on request
Square female 8	1000-U811	on request
Daimler Benz	on request	on request
Slot 1.2 x 3	on request	on request
Slot 2x4	1000-U777	1000-U777-01
Slot 2 x 4 coinproof	on request	on request
Crown type	on request	on request
Federal Railway	1000-U831	1000-U831-01
Tube with indicator	on request	on request
Wing knob	1000-U882	on request

Compression latch with adjustable cam

PROGRAM 1000

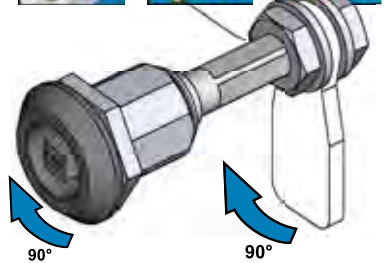
Tamper and vibration proof

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

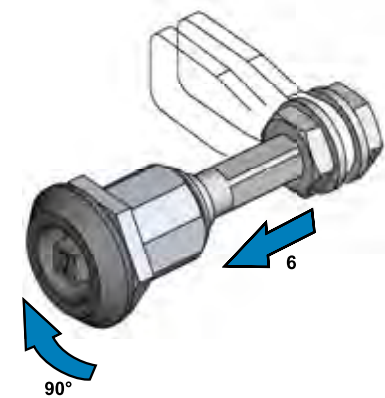


Housing and insert zinc die black powder-coated; shaft zinc die or m.s. zinc plated; nut and washer m.s. zinc plated, with spring and gasket

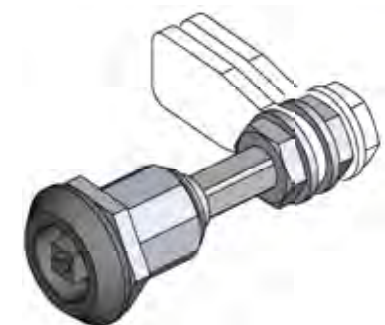
	shaft zinc die	shaft m.s. zinc plated
Square 6 with arrow	on request	on request
Square 7 with arrow	1000-U786	1000-SU720
Square 8 with arrow	1000-U799	1000-SU861
Triangular 6.5 CNOMO	on request	on request
Triangular 7	1000-U794	1000-SU724
Triangular 8	1000-U802	1000-SU725
Triangular 9	on request	on request
Triangular 10	on request	on request
Double bit 3	1000-U803	1000-SU730
Double bit 5	1000-U804	1000-SU752
Hexagon male SW 11.1 with marking	1000-U816	1000-SU324
Hexagon female 8	1000-U808	1000-SU735
Hexagon female 8mm with pin	on request	1000-SU733
Hexagon female 10mm	on request	on request
Square female 6mm	on request	on request
Square female 7mm	on request	on request
Square female 8	1000-U812	on request
Daimler Benz	on request	on request
Slot 1.2 x 3	on request	on request
Slot 2x4	1000-U813	on request
Slot 2 x 4 coinproof	on request	on request
Crown type	on request	on request
Federal Railway	on request	on request
Tube with indicator	1000-U830	1000-SU736
Wing knob	1000-U880	on request



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

Note
Only cams without a stop can be used

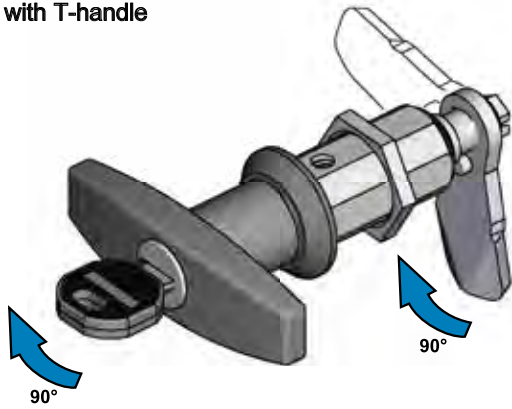
Further parts see page

- Stainless steel version 8A-232
- Cam (GH = 31) 1C-137
- Accessories from 1C-320
- Escutcheon 3B-140
- Key 12B-120

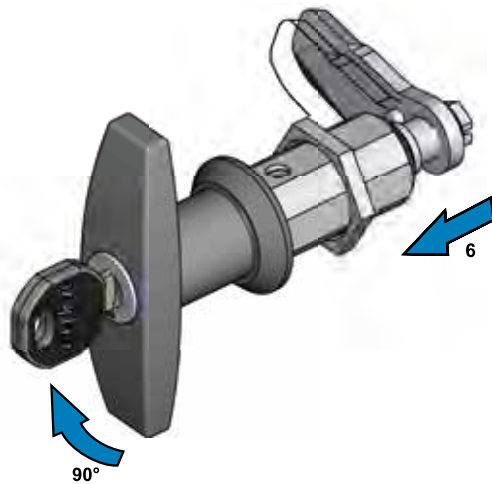
Compression latch with handle and fixed or adjustable cam height

PROGRAM 1000

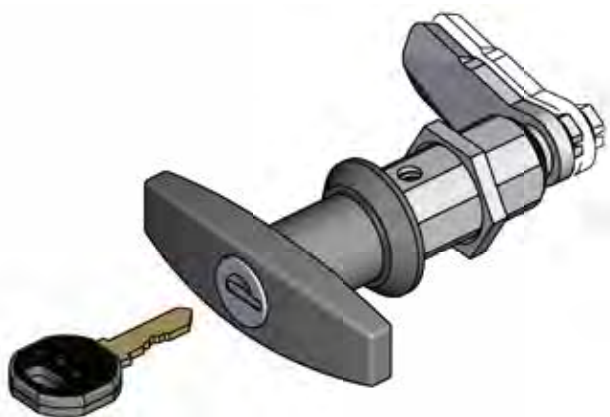
Example:
compression latch
with T-handle



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

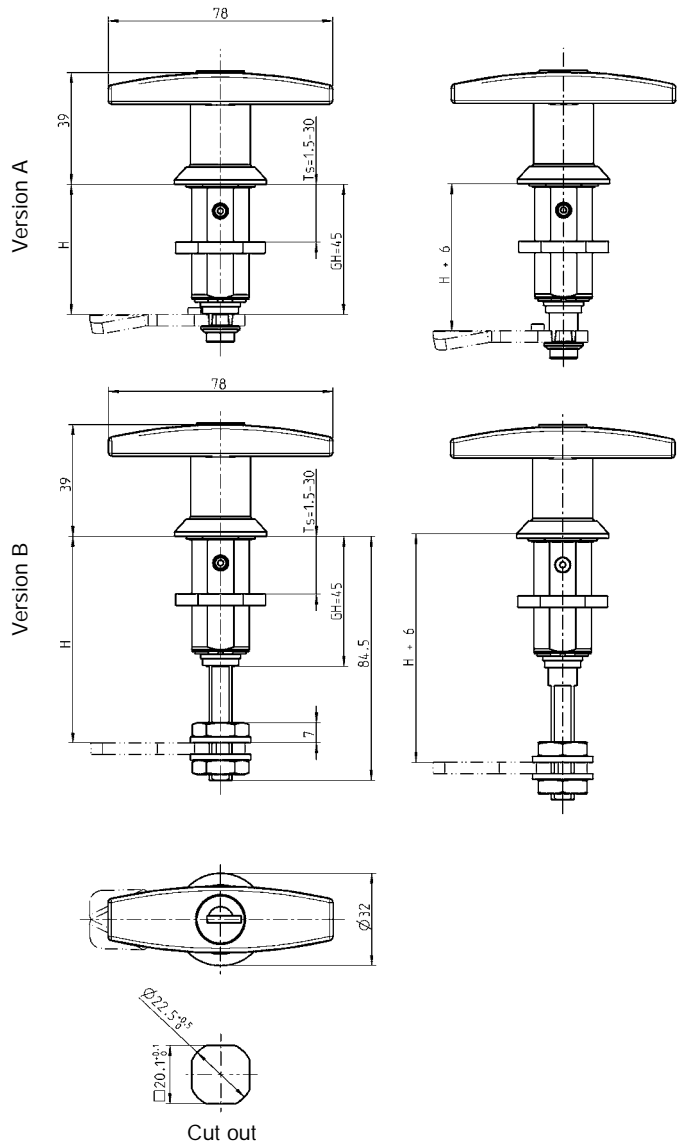


Closed
The second 90° of rotation
draws the cam 6mm axially
towards the door.



Compressed
Key removable
Open:
Reversed motion

Compression latch with T-handle



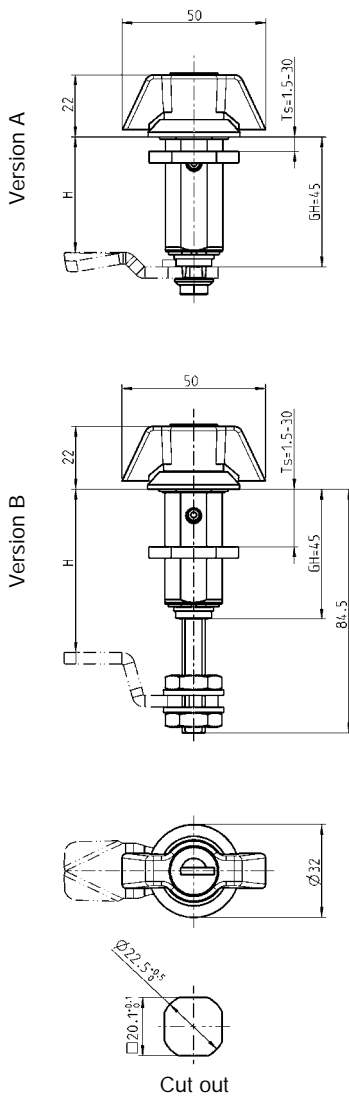
Note:

For version B only cams without catch can be used!

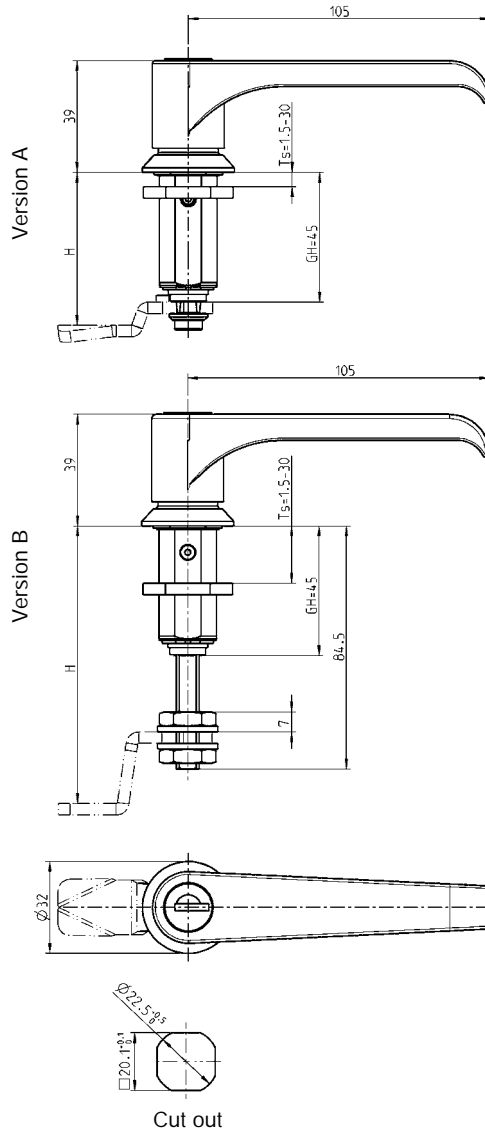
Tamper and vibration proof

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

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 from 34
 (not for cam with rod control)
 for adjustable cam level
 – Cam (GH = 45) 1C-137
 for both versions
 – Dust cap for T-handle 1C-340
 – Spare key 12B-140

HVACR Compression Latch-Hinge large with or without pressure relief

PROGRAM 1091



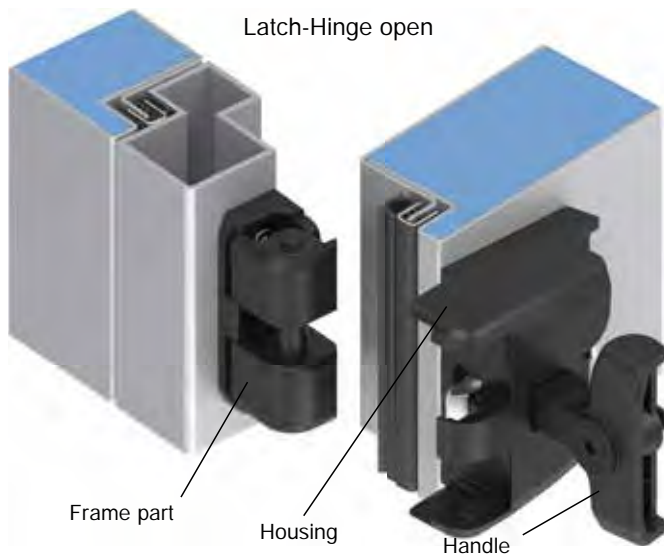
Compression Latch-Hinge locked



Compression adjustable on the frame part



Latch-Hinge with pressure relief, handle unlocked



Latch-Hinge open

Frame part

Housing

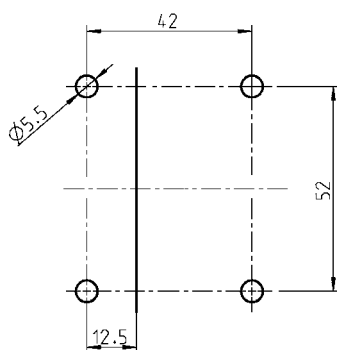
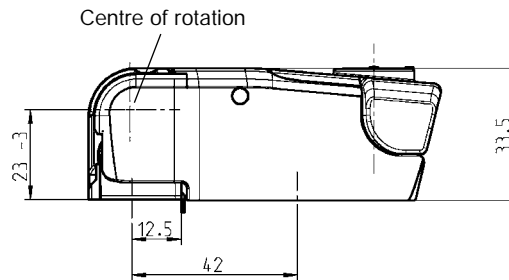
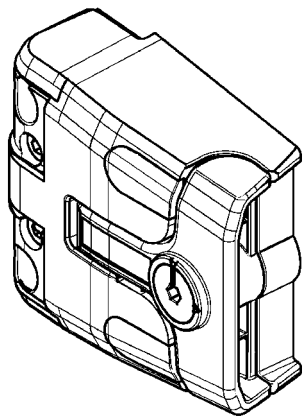
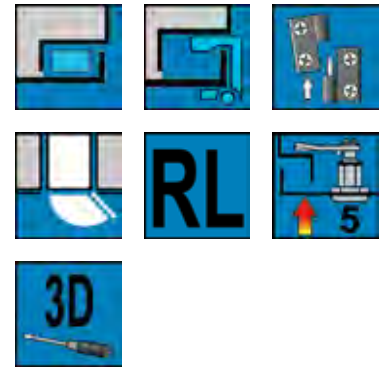
Handle

Hinge 180° opening angle

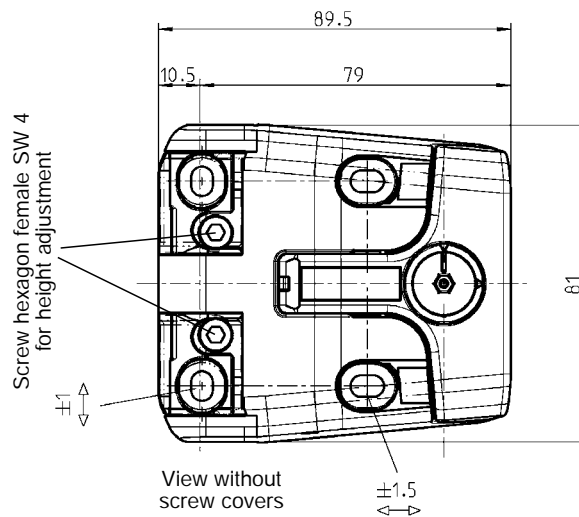


Product benefits

- When the door is closed, the latch is adjustable (3 mm) to achieve perfect alignment
- Compression (5 mm) with low opening & closing force
- Door or panel can be removed by unlatching the handles on both sides
- 3D Adjustable
- Latch-Hinge can be mounted as one piece with the door in place
- Right or left hinged
- Hinge 180° opening angle
- Available with or without pressure relief
- Patent submitted
- ATEX compliant explosion protection version available on request



Frame part Housing
Cut out



View without
screw covers

HVACR 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; 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	Keyed different
without pressure relief	1091-U146	on request	on request
with pressure relief	1091-U147	on request	on request

HVACR Compression Latch-Hinge small with or without pressure relief

PROGRAM 1091



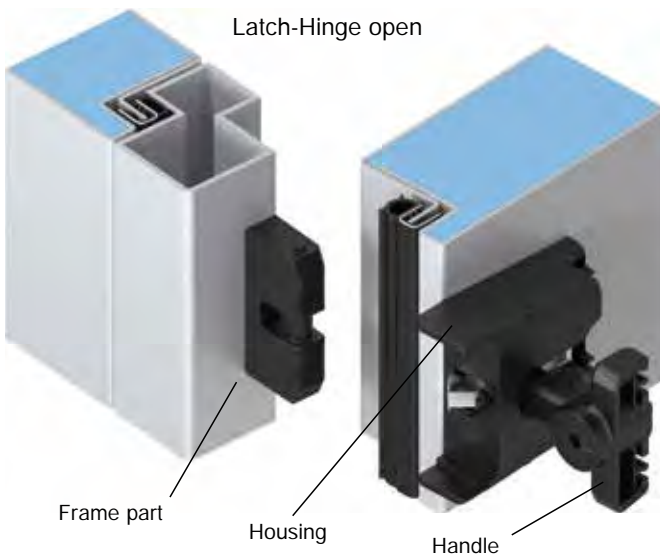
Compression Latch-Hinge locked



Latch-Hinge with pressure relief, handle unlocked

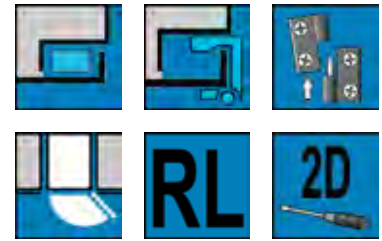


Latch-Hinge open



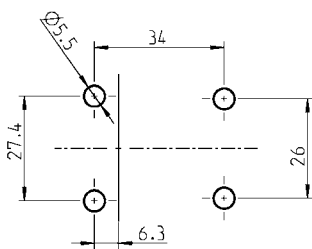
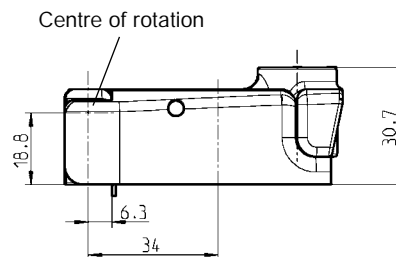
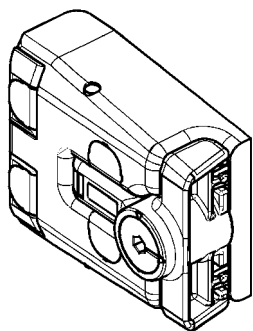
Hinge 180° opening angle



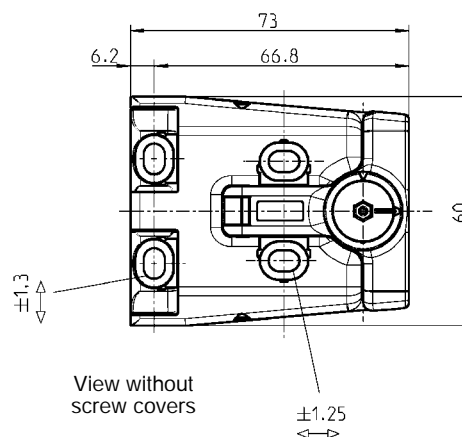


Product benefits

- The favorable 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
- 2D Adjustable (tolerance compensation)
- Latch-Hinge can be mounted as one piece with the door in place
- Right or left hinged
- Hinge 180° opening angle
- Available with or without pressure relief
- Patent submitted
- ATEX compliant explosion protection version available on request



Frame part Housing
Cut out



View without
screw covers



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

① insert hexagon female BS 4 polyamide GF black

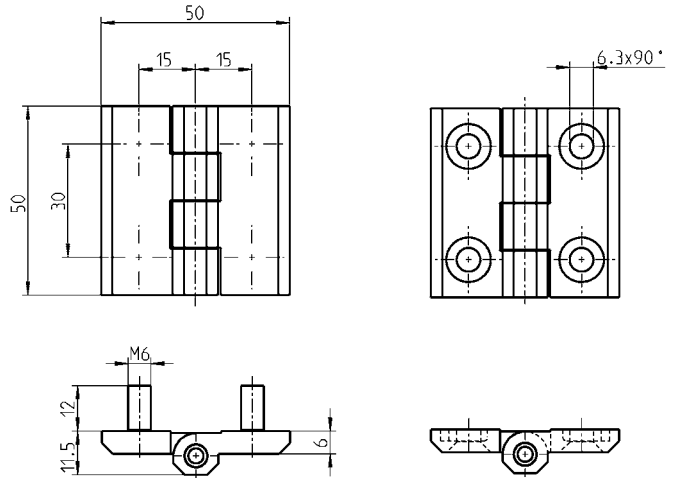
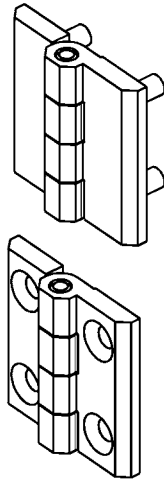
② Round cylinder Series 9000 zinc die with stainless steel cap and dust cap.
Each round cylinder has two silver steel nickel plated reversible keys at a ring.

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



180° screw-on hinge

STAINLESS STEEL



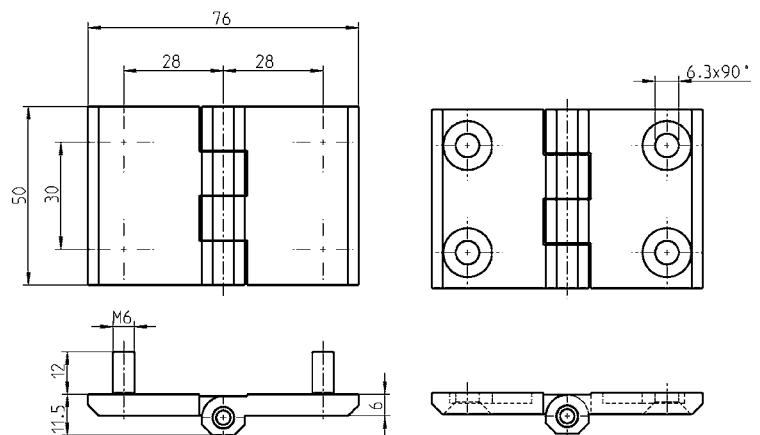
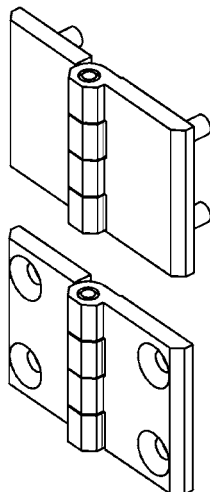
Screw-on hinge zinc die, polyamide black or stainless steel; grub screw M6 stainless steel

	Pin	threaded pin M6	for countersunk screw M6 (2D-nut possible)
zinc die black p.c.	Stainl. steel	1056-U7	1056-U9
zinc die black p.c.	Stainl. steel	1056-U8	1056-U10
polyamide GF black	Stainl. steel	-	1056-U31
polyamide GF black	Polyamide	-	1056-U42
AISI 316	Stainl. steel	-	1056-U9-PH



270° screw-on hinge

STAINLESS STEEL



Screw-on hinge zinc die or stainless steel, threaded studs M6 stainless steel

	Pin	threaded pin M6	for countersunk screw M6 (2D-nut possible)
zinc die black p.c.	Stainl. steel	1056-U15	1056-U17
zinc die black	Stainl. steel	1056-U16	1056-U18
AISI 316	Stainl. steel	-	1056-U17-PH

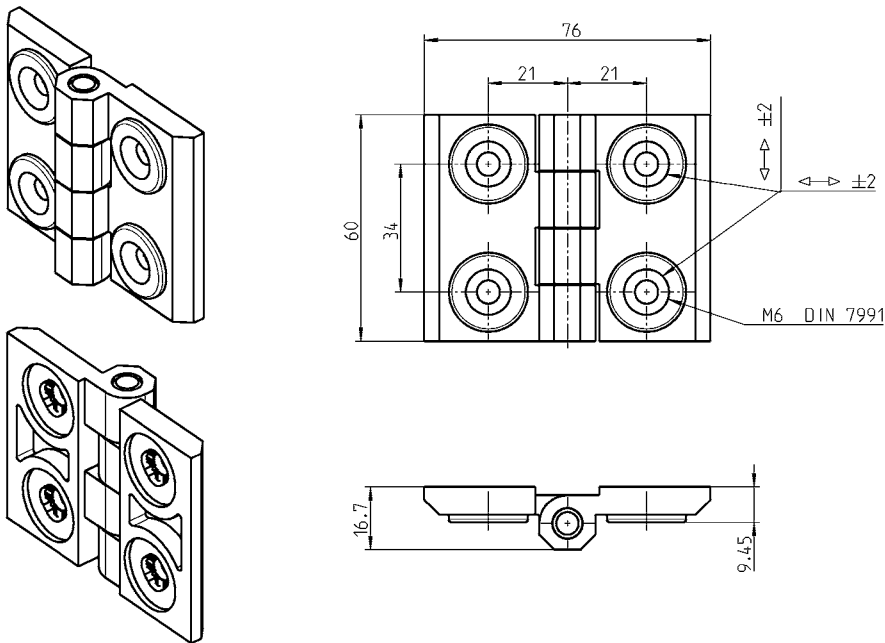
Further parts see page
- 2D-nut

12E-120

180° screw-on hinge

PROGRAM 1056

180° 2D-screw-on hinge

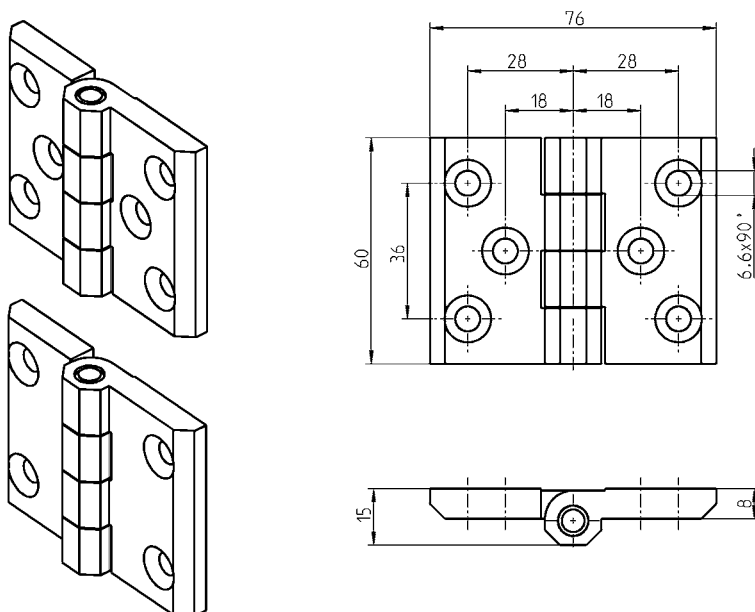


Recess for rivet nut M6 customary in trade

2D screw-on hinge zinc die black powder coated; pin stainless steel

1056-U27

180° screw-on hinge



Screw-on hinge zinc-die black powder-coated; pin stainless steel

with 4 countersunk holes (2D-nut possible)

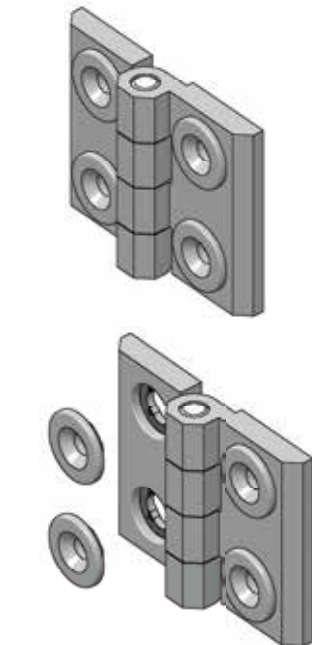
1056-U29

with 6 countersunk holes (2D-nut possible)

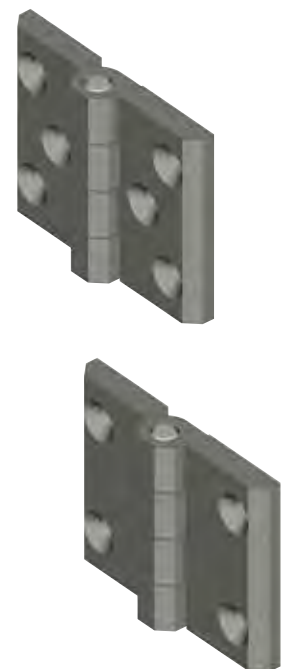
1056-U28



RL



Adjustable ± 2 mm
in the horizontal
and vertical direction



Further parts see page
– 2D-nut

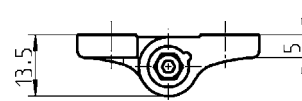
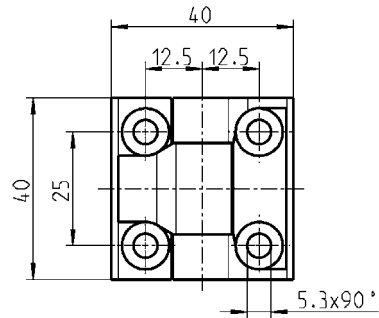
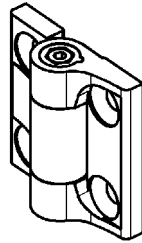
12E-120

180° screw-on torque hinge with adjustment function

PROGRAM 1056

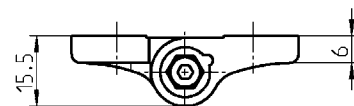
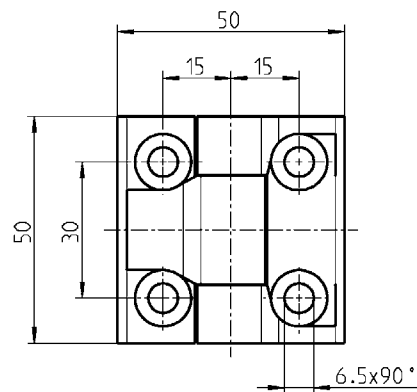
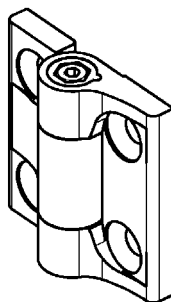
Product benefits

- 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



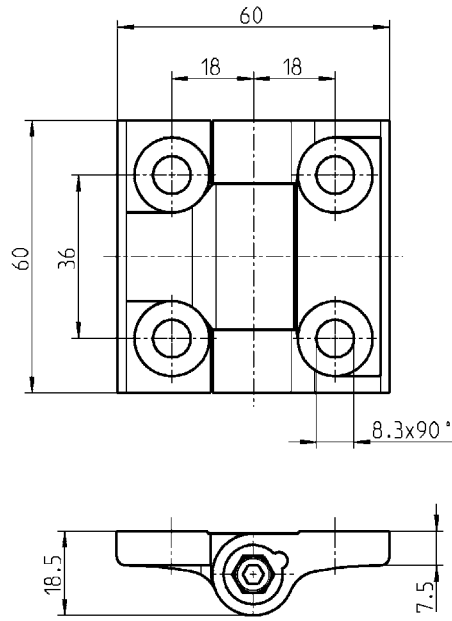
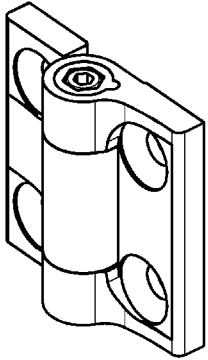
180° screw-on torque hinge zinc-die black powder-coated for countersunk screw M5; friction cone polyacetal POM; screw and nut m.s. zinc-plated

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

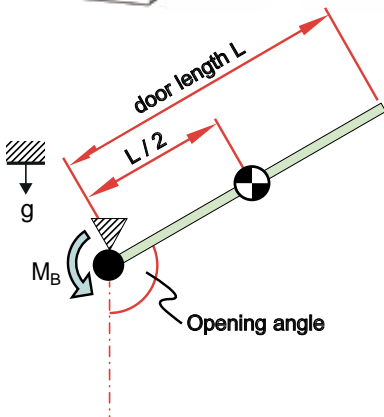
Opening angle $\alpha = 120^\circ$
 Door length: $L = 0,8 \text{ m}$
 Door mass: $m = 3,5 \text{ kg}$
 Gravitational pull: $g = 9,81 \text{ m/s}^2$
 Torque hinge: $M = 6,5 \text{ Nm}$
 Number of hinges: $n = ?$

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.

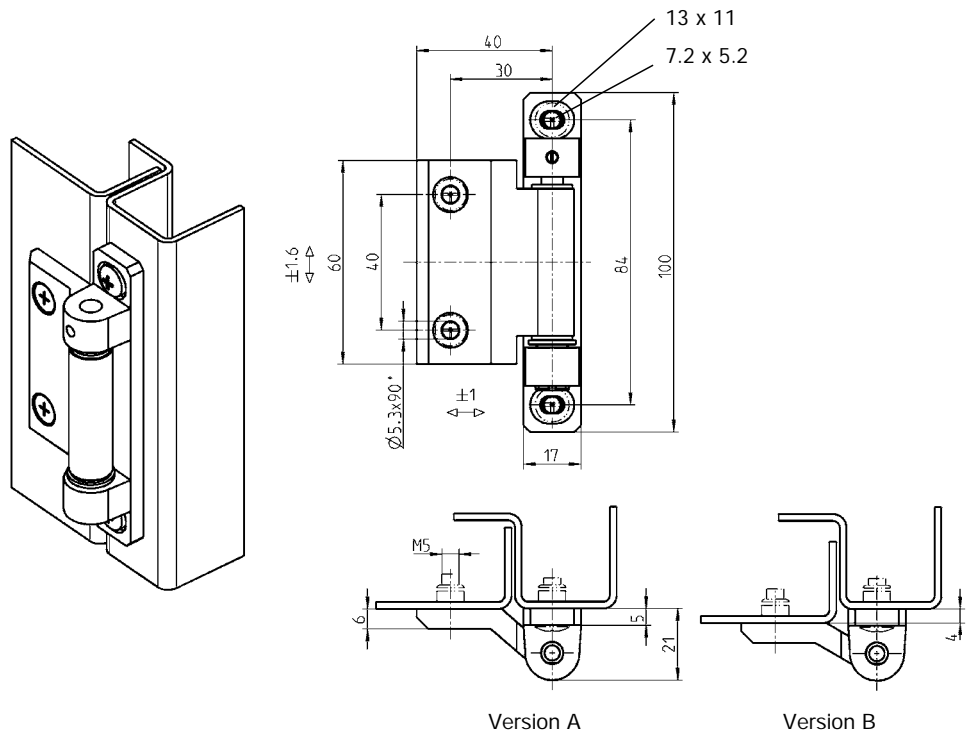
Further parts see page

– 2D-nut 12E-120
 (only for 1056-U10-01)

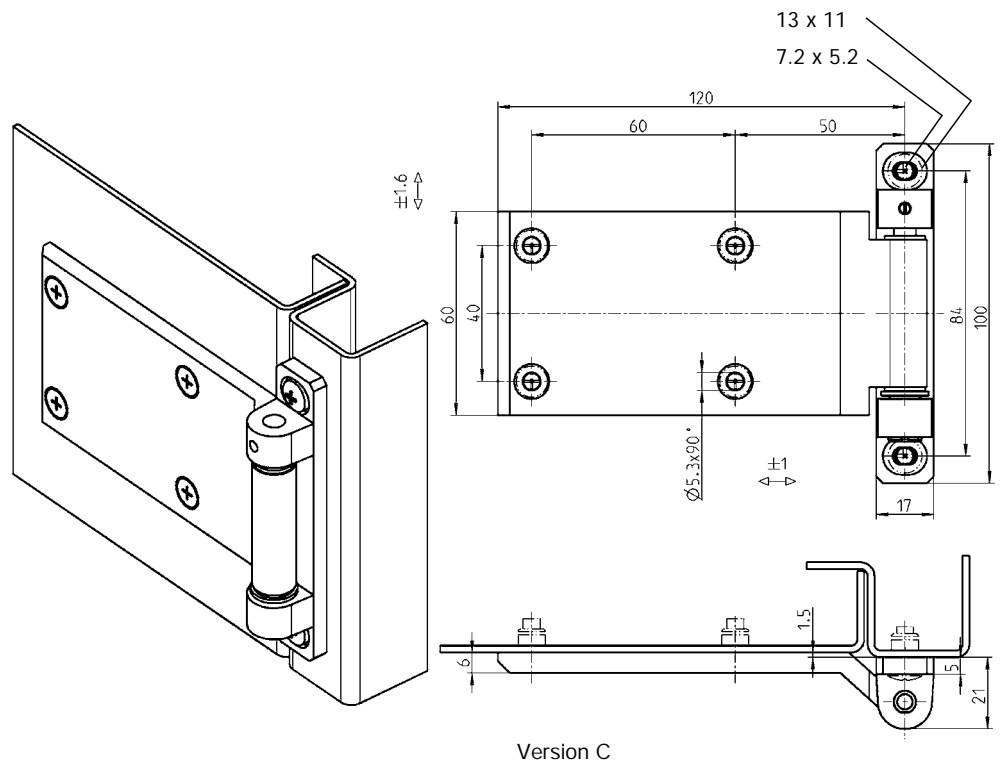


RH or LH version by turning around the door part

Hinge pin is self-gripping



Counterbores for small head countersunk screw M5x . .

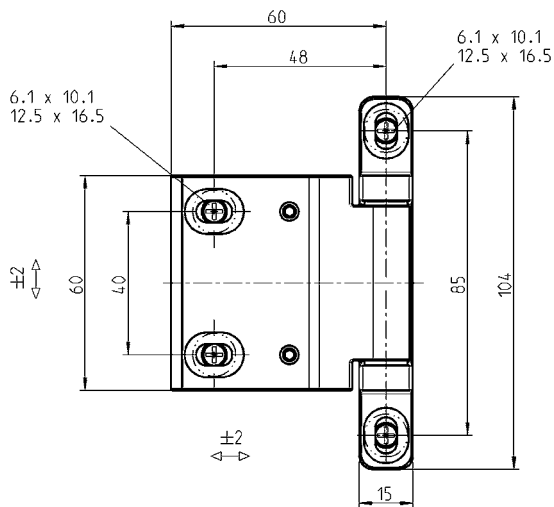
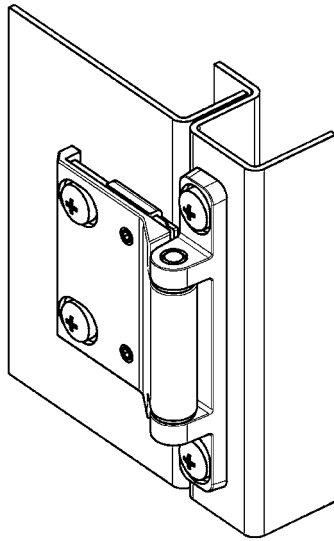


2D-screw-on hinge zinc die, axle brass nickel plated;
washer m.s. zinc plated and bush polyamide

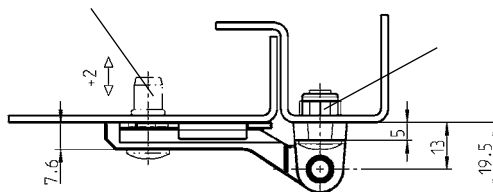
small head ≙ DIN ISO 2009,
2010, 7046-1, 7046-2, 7047

	Version A	Version B	Version C
black powder-coated	1054-U33-01	1054-U34-01	1054-U35-01
raw	1054-U33-02	1054-U34-02	1054-U35-02

180° 3D-screw-on hinge PROGRAM 1054



Centre part prepared for pan head rivet nut M6



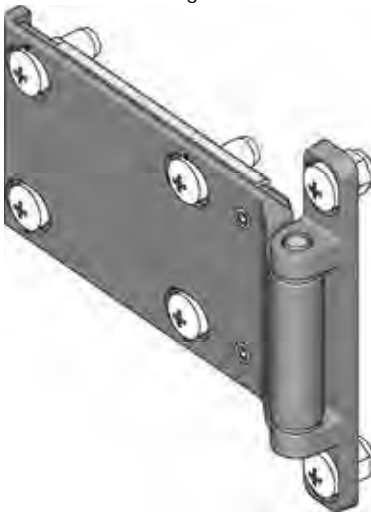
3D screw-on hinge Door part and centre part zinc-die black powder-coated;
axle, pin and washers stainless steel; bushes plastic

1054-U42-01

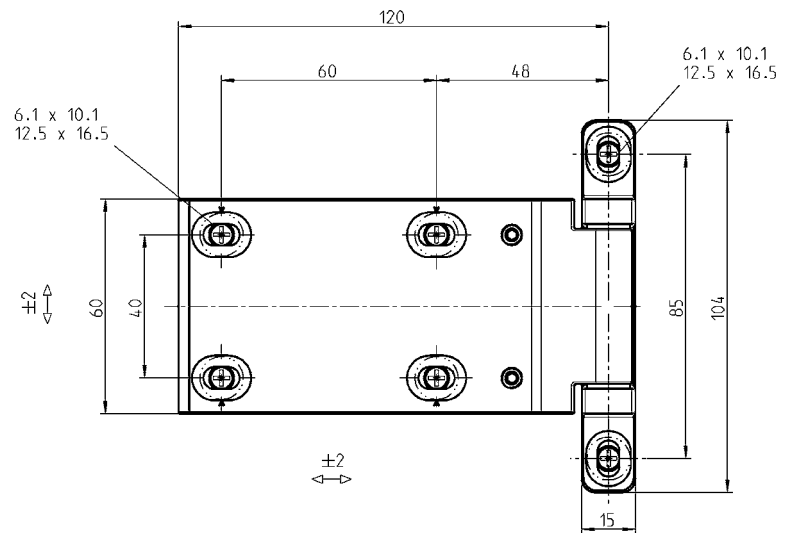
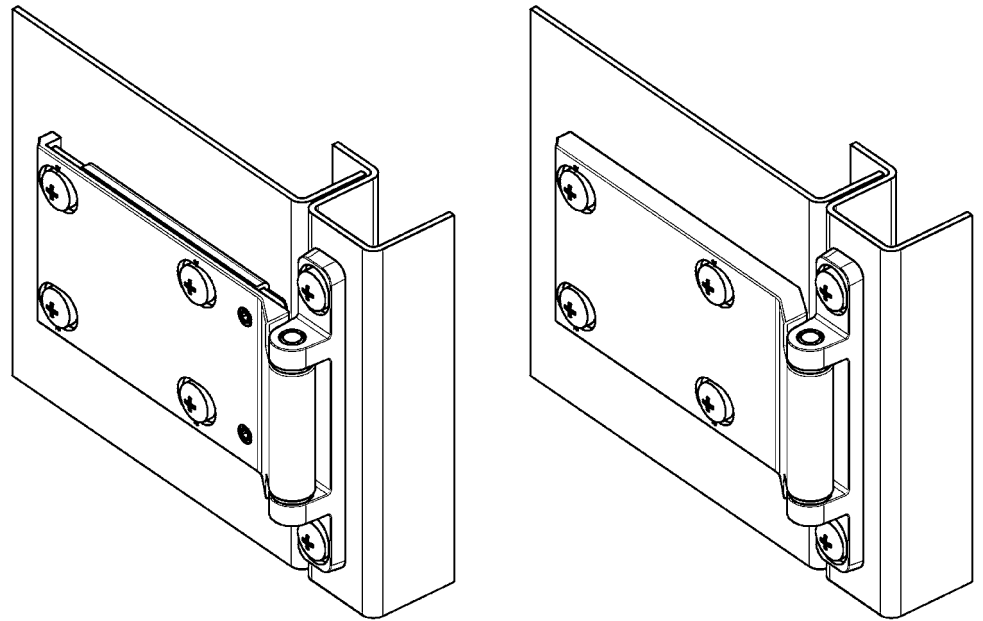
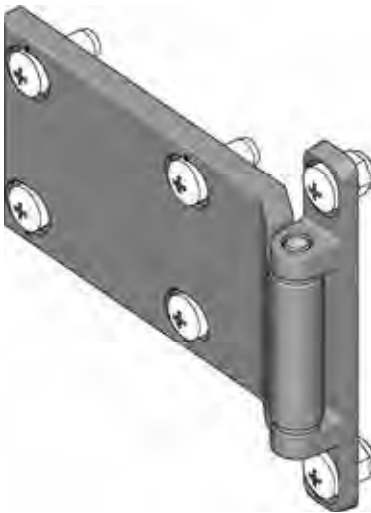
* Oval head screw DIN ISO
7380 M6x...
not included in
the scope of supply



3D-screw-on hinge

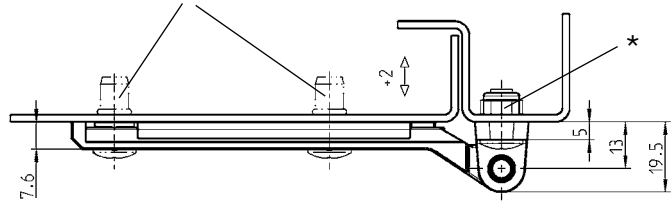


2D-screw-on hinge



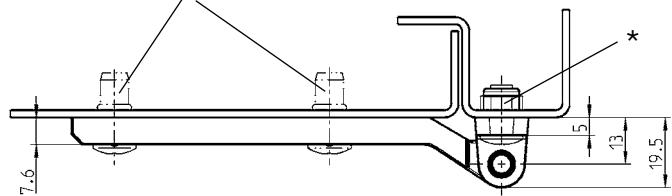
* Centre part prepared for pan head rivet nut M6

3D-screw-on hinge



* Centre part prepared for pan head rivet nut M6

2D-screw-on hinge



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

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

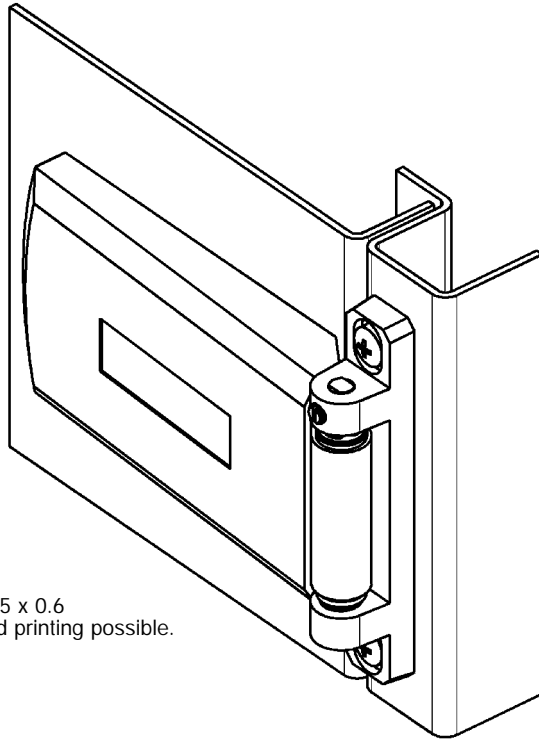
1054-U43-01

2D-screw-on hinge door part and centre part zinc die black powder-coated; axle stainless steel; bushes plastic

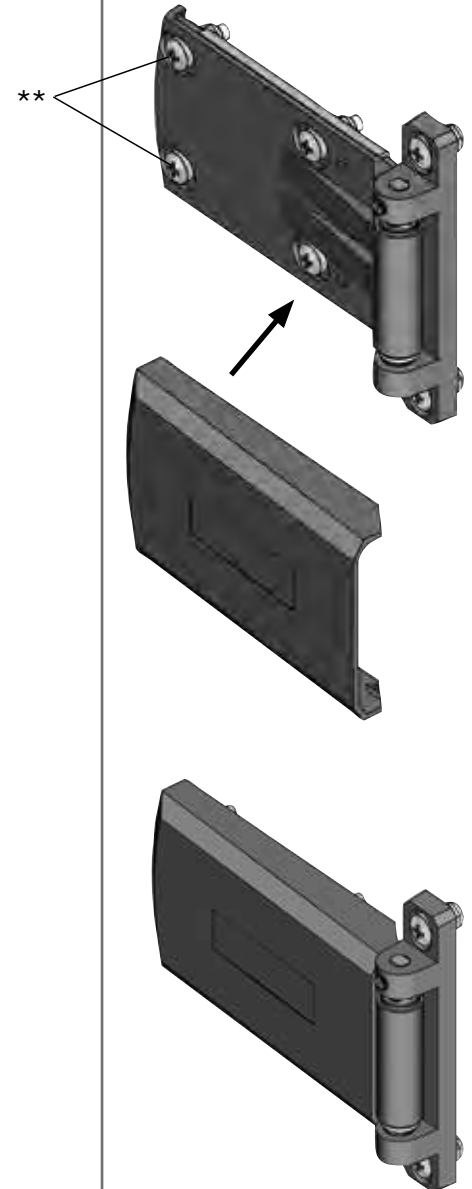
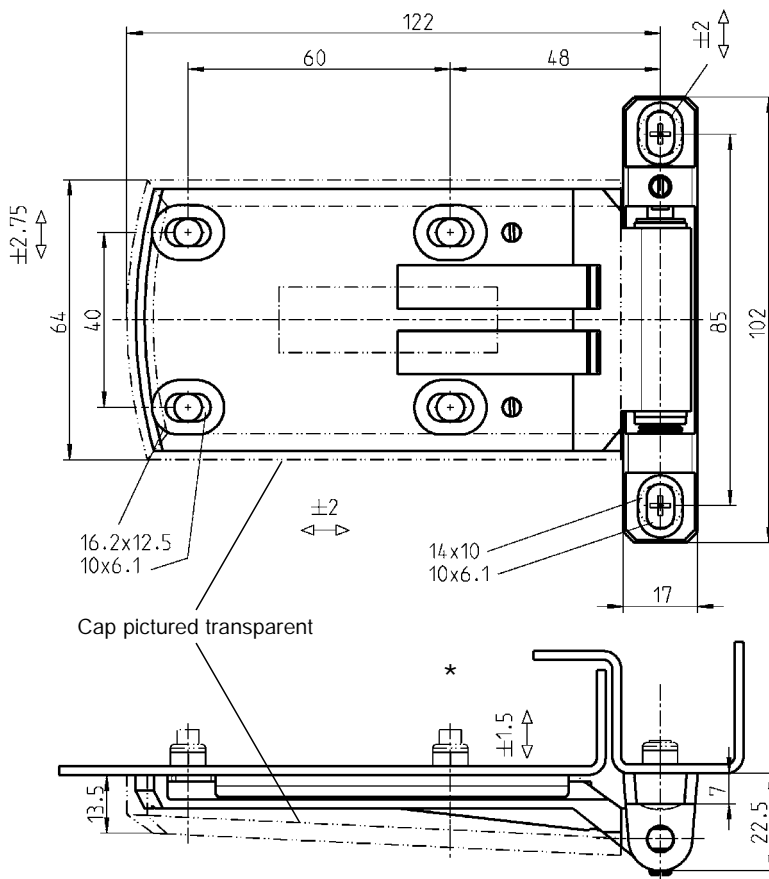
1054-U44-01

180° 3D-screw-on hinge

PROGRAM 1054



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



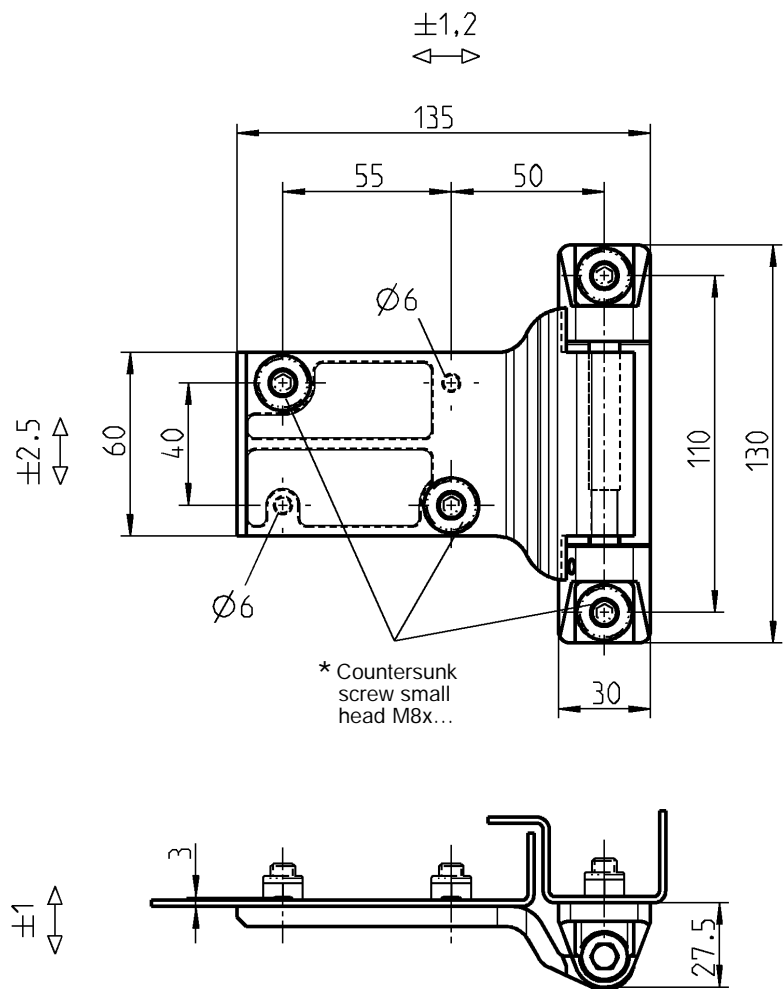
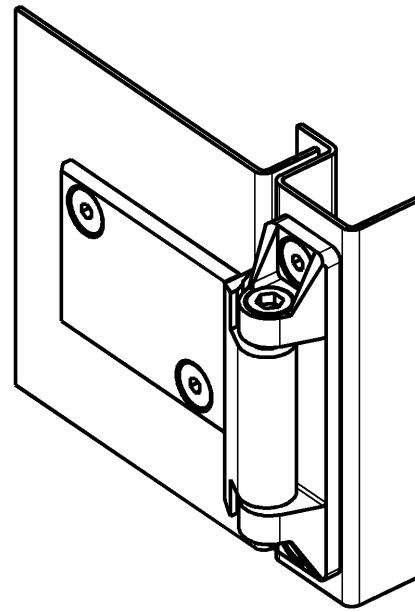
* must order separately

** Only screws with flat head or with max. head height 5 mm can be used

RH or LH version by turning around the door part

3D-screw-on hinge door part and centre part zinc die black powder-coated;
axle stainless steel; pin and washer steel zinc plate;
cap and bush polyamide black

RH version	1054-U36-RE
Left hand version	1054-U36-LI



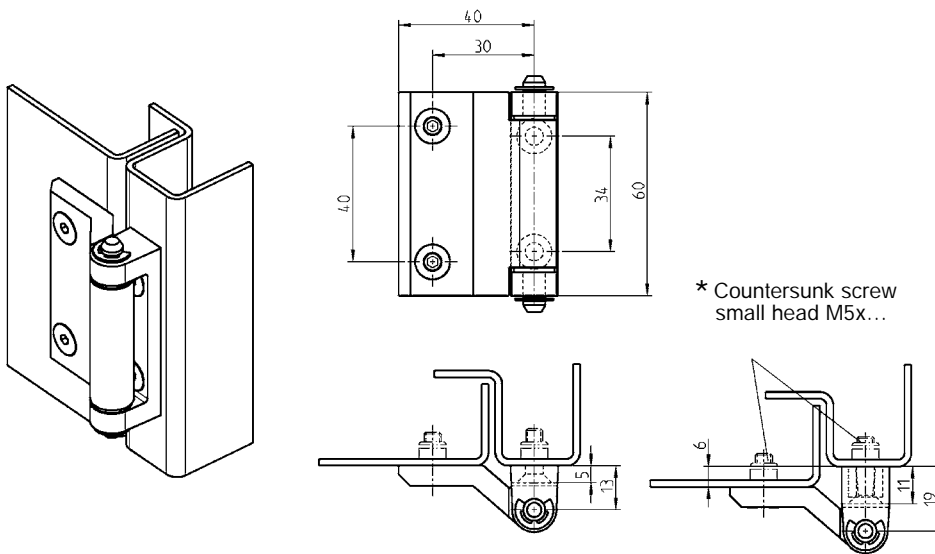
* must order separately

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

3D-screw-on hinge zinc die, shaft and grub screw stainless steel

	Left hand version	Right hand version
black powder-coated	1054-U32	1054-U31
raw	1054-U32-01	1054-U31-01

180° screw-on hinge PROGRAM 1054



* Countersunk screw
small head M5x...



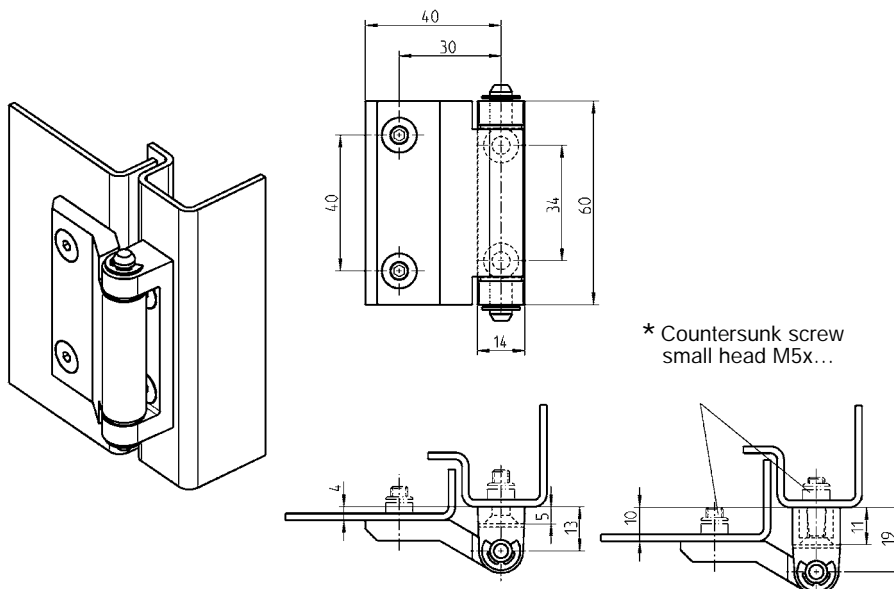
Frame part

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

	level	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.

The frame part can be changed
with the frame part from the page
57.



* Countersunk screw
small head M5x...



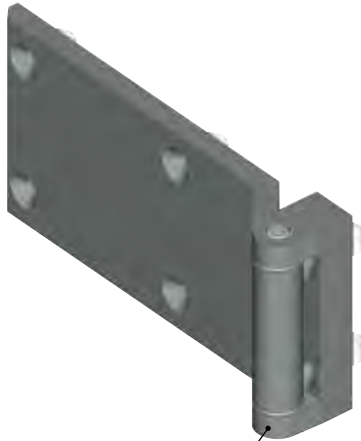
Screw-on hinge zinc die, pin and washer m.s. zinc plated and bush polyamide

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

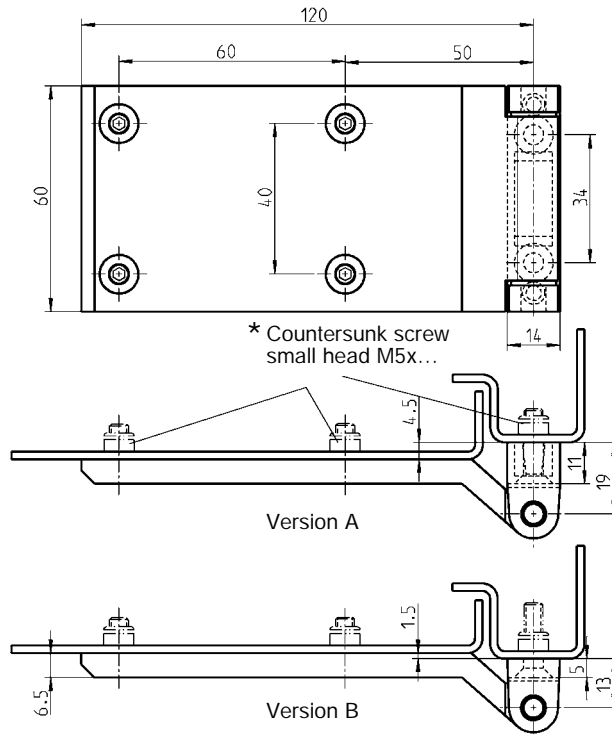
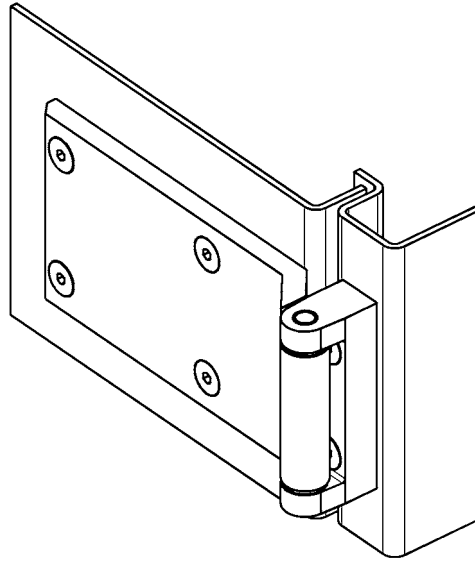
** = Minimum order quantity 1000 pcs.

* must order separately

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



Frame part



* must order separately

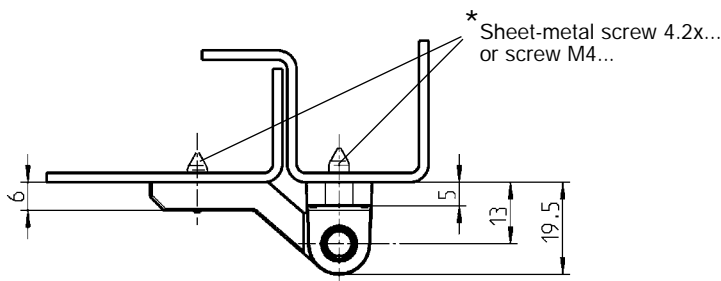
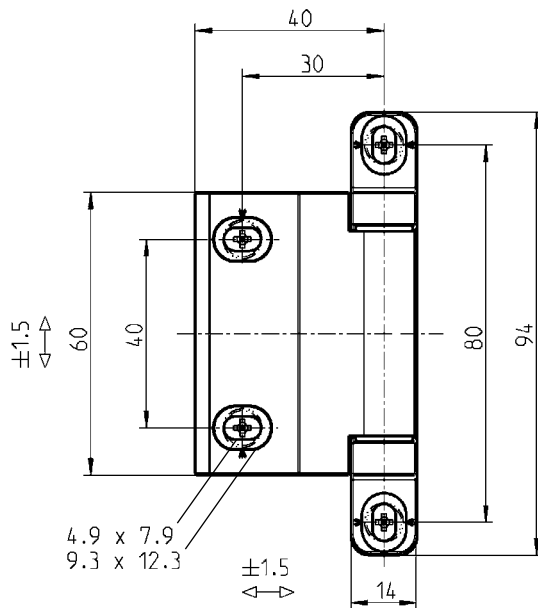
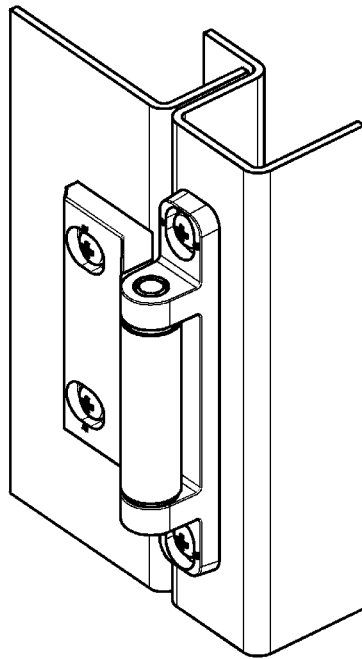
small head ≙ DIN ISO 2009, 2010, 7046-1, 7046-2, 7047

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.

180° 2D hinge
PROGRAM 1054



Frame part

The frame part can be changed with the frame part from the page 55 and 56.

* must order separately

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

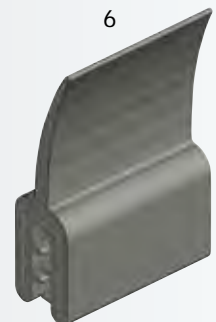
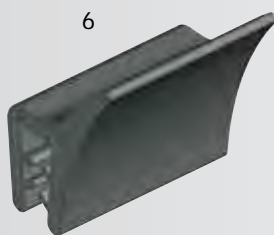
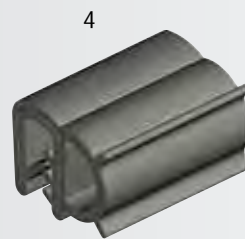
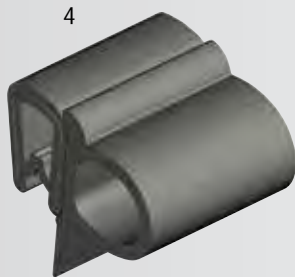
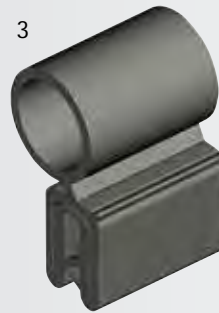
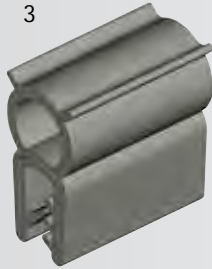
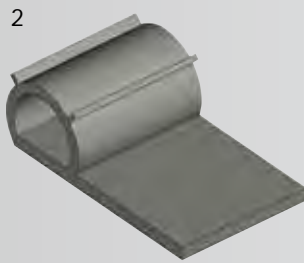
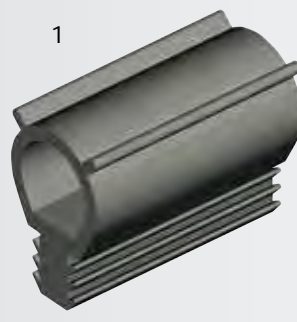
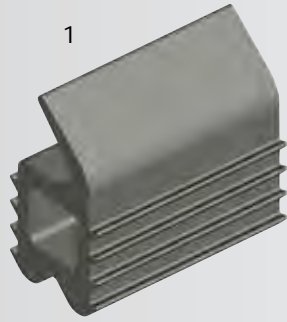
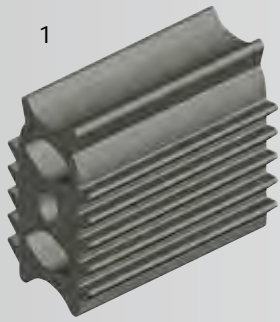
Film vulcanising is a permanent and durable process. A foil of the same material is inserted between the profile ends that are to be vulcanised.

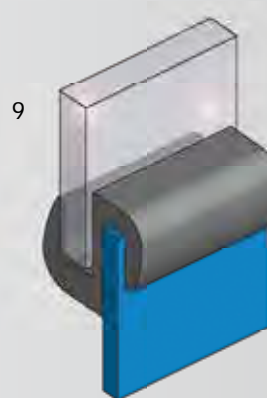
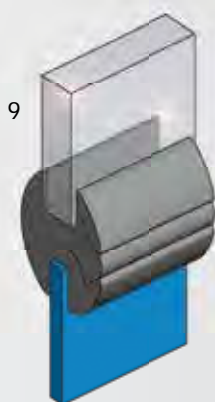
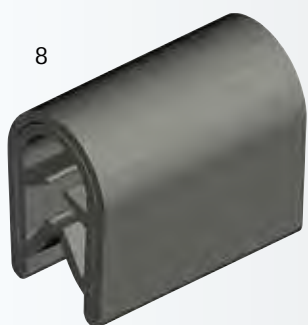
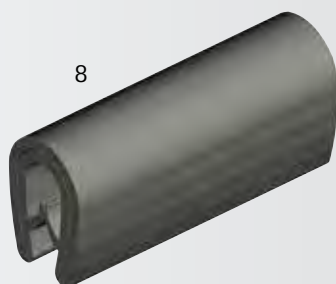
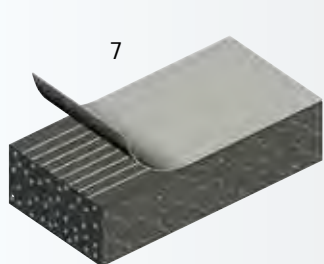


Injection moulding

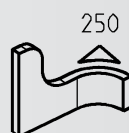
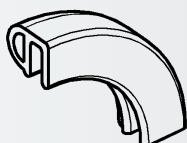
Injection moulding means formed corners and end injection moulding. Injection moulding is e.g. a process to produce special corners for frame. The example next shows ① a rounded frame, while the clamping range ② is produced rectangular. This option is not possible for vulcanising gasket ends with mitre joint ①.







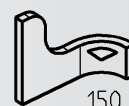
Minimum bending radius



Minimum bending radius



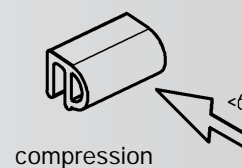
Minimum bending radius



Minimum bending radius

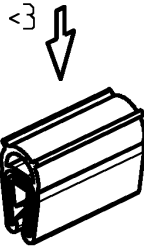


- | | | |
|---|--|---------------------|
| 1 | Gasketing secured in a U-section | 5A-120 up to 5A-160 |
| 2 | Gasketing | 5A-140, 5A-160 |
| 3 | Self-clamping gasketing | 5A-220, 5A-240 |
| 4 | Self-clamping gasketing | 5A-240 up to 5A-300 |
| 5 | Self-clamping gasketing | 5A-300, 5A-320 |
| 6 | Self-clamping gasketing | 5A-320 up to 5A-360 |
| 7 | Cell sponge rubber, with stretch eliminating self-adhesive backing | 5A-440 |
| 8 | Edge protection | 5A-520 up to 5A-560 |
| 9 | Clamping profile and window rubber profile | 5A-620, 5A-640 |

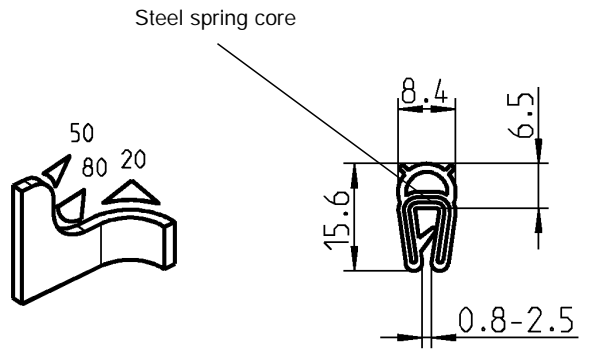


Gaskets self-gripping PROGRAM 1011

According to VDI 6022



compressible



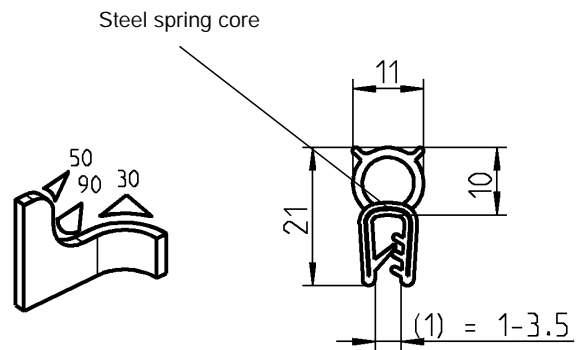
Hollow chamber (EPDM) black $45^\circ \pm 5$ Shore A
Clamping profile (EPDM) black $60^\circ \pm 5$ Shore A

1011-10-09

According to VDI 6022



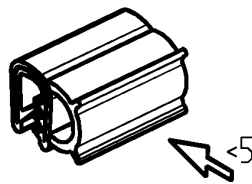
compressible



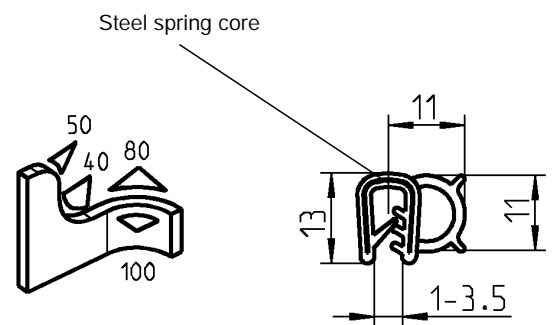
Hollow chamber (EPDM) black $45^\circ \pm 5$ Shore A
Clamping profile (EPDM) black $60^\circ \pm 5$ Shore A

1011-05-09

According to VDI 6022



compressible



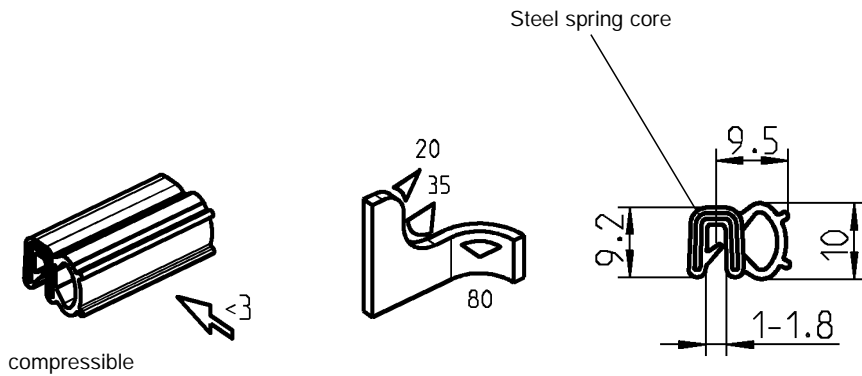
Hollow chamber (EPDM) black $45^\circ \pm 5$ Shore A
Clamping profile (EPDM) black $60^\circ \pm 5$ Shore A

1011-06-09

Gaskets self-gripping

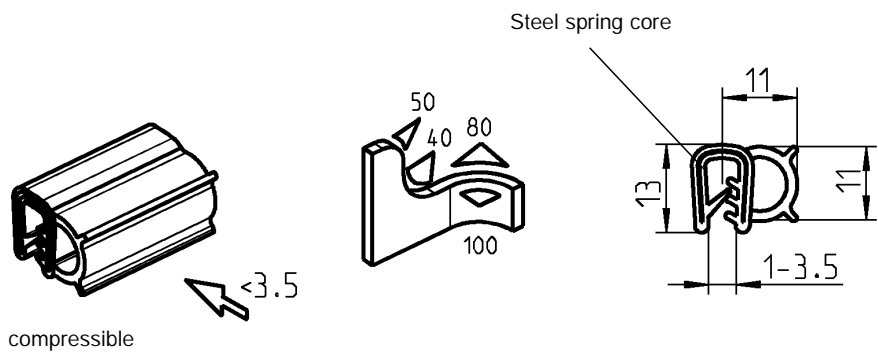
PROGRAM 1011

According to VDI 6022



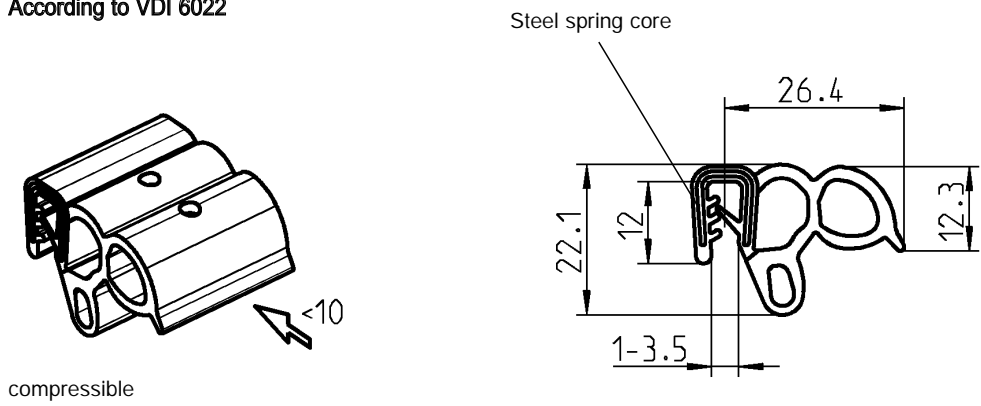
Sponge-rubber (EPDM) black (gasket EPDM 64° ± 5 Shore A)	1011-S102
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According to VDI 6022



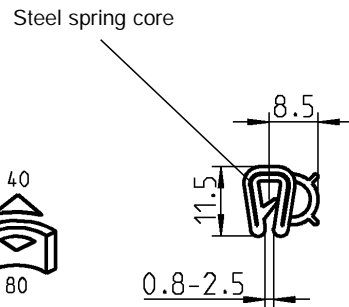
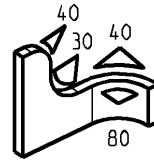
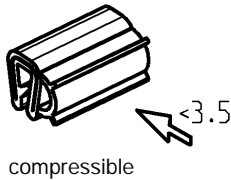
Sponge-rubber (EPDM) black (gasket EPDM 64° ± 5 Shore A)	1011-S122
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According to VDI 6022



Sponge-rubber (EPDM) black (gasket EPDM 64° ± 5 Shore A)	1011-S154
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According to VDI 6022

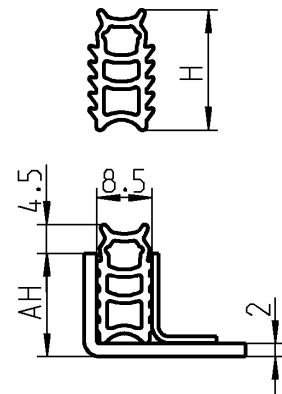
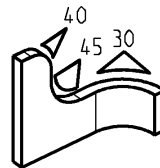
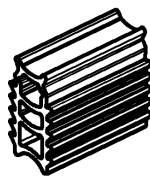


Hollow chamber (EPDM) black $45^\circ \pm 5$ Shore A
Clamping profile (EPDM) black $60^\circ \pm 5$ Shore A

1011-09-09



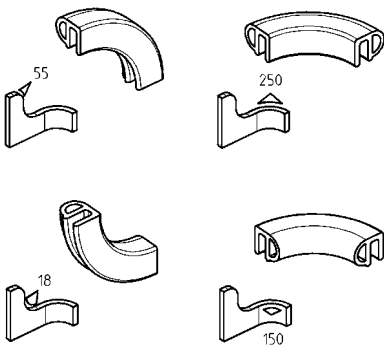
According to VDI 6022



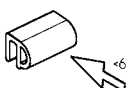
4 lip gasket (EPDM) black $45^\circ \pm 5$ Shore A

AH	Height H	
16	18,5	1003-11-N9
18	20,5	1003-12-N9

Minimum bending radius



compression



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 air-conditioning 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).

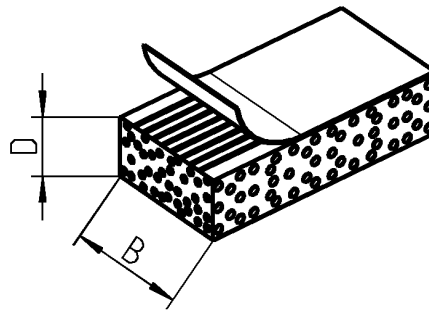
In line with the latest technical development and scientific knowledge, this guideline is intended to guarantee a precise operation and condition of ventilation and air-conditioning systems by means of preventive technical provisions.

Cell sponge rubber

PROGRAM 1016

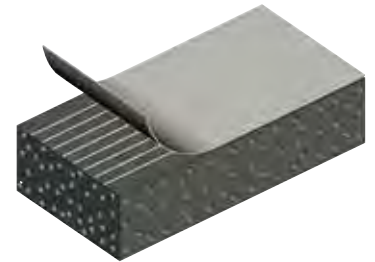
Coil length:

- For depths 3 - 7 = the coil length a 10 m
- For depths 8 - 10 = the coil length a 5 m
- For depths 11 = in strip a 1 m

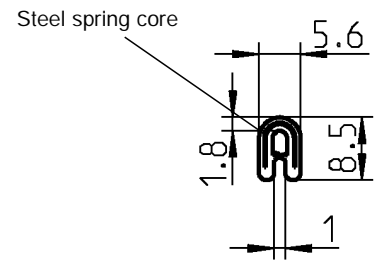
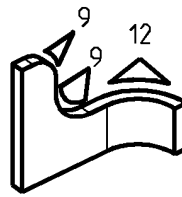
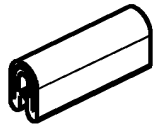


These items can be delivered from stock.
All others will have a lead time of 2 - 3 weeks.

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



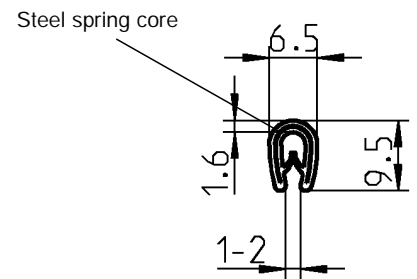
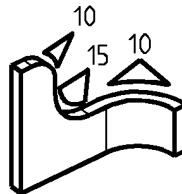
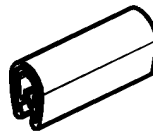
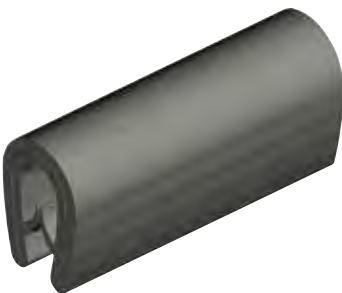
Cell sponge rubber, material on choice, black, with stretch eliminating self-adhesive backing							
Measurement				Measurement			
Width	Depth	EPDM	CR	Width	Depth	EPDM	CR
10	3	1016-13	1016-61	30	10	1016-123	1016-159
	4	1016-14	1016-62		12	1016-124	1016-160
	5	1016-15	1016-63		15	1016-125	1016-161
10	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
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 PVC 70° ± 5 Shore A colour as requested

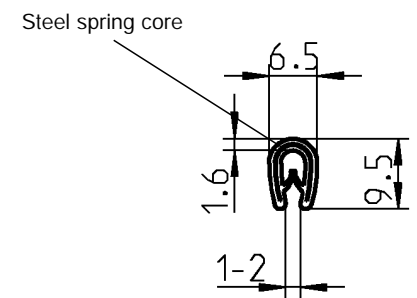
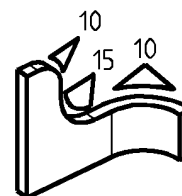
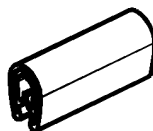
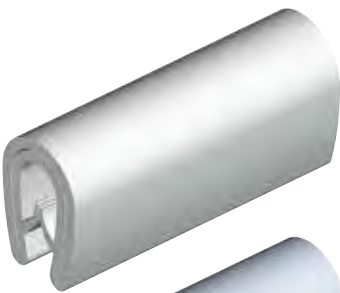
black	1010-03
light grey	1010-03-01

Temperature stability = -40°C bis 90°C



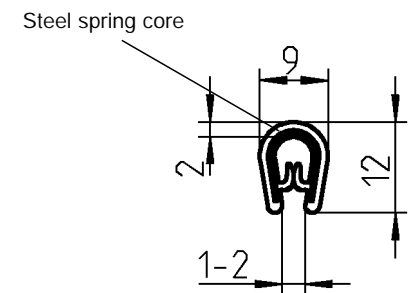
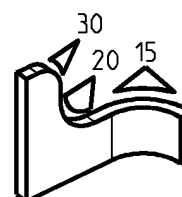
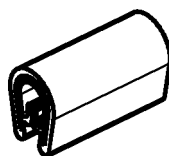
Edge protection PVC 70° ± 5 Shore A black

1010-02



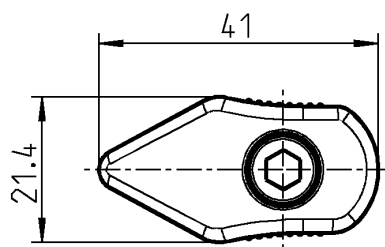
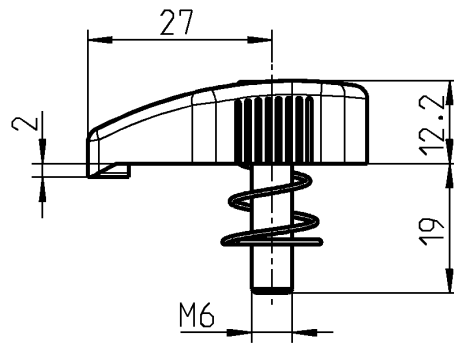
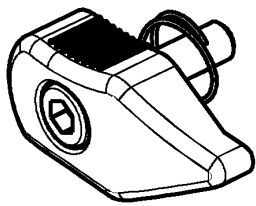
Edge protection PVC 70° ± 5 Shore A colour as requested

white	1010-04-01
silver	1010-04-02



Edge protection PVC 70° ± 5 Shore A black

1010-10

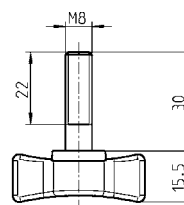
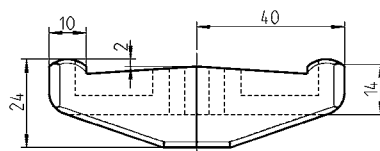
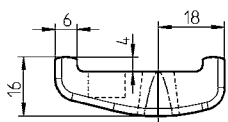
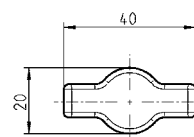
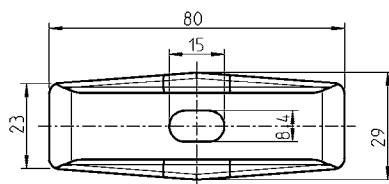
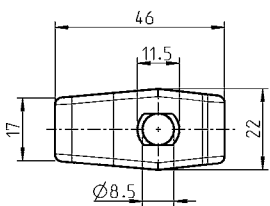


Bridge clamp polyamide GF black;
socket head screw m.s. zinc plated;
with spring

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

3D-unit connector

PROGRAM 1076

RL

3D



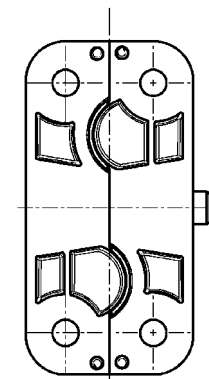
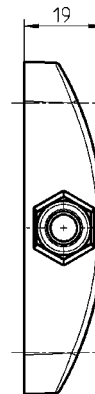
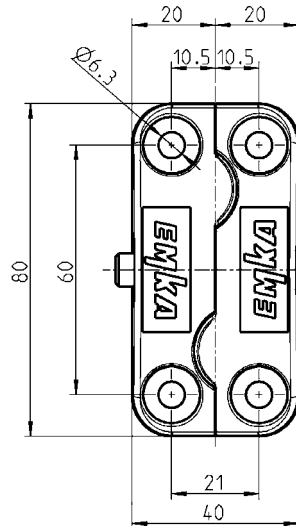
Note
3D-unit connector
without fixing material

NEW



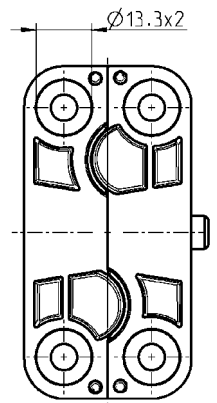
3D-unit connector

- 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

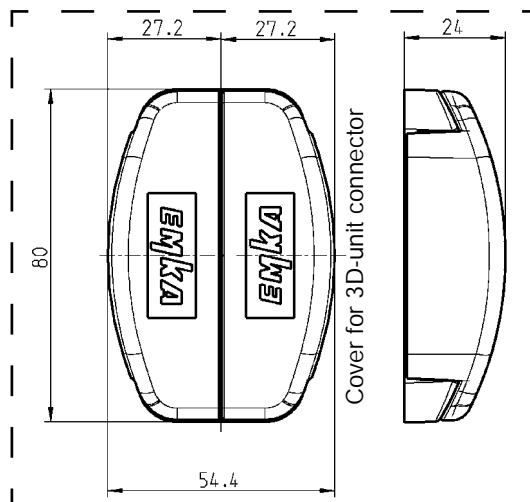


- without recess

Pan head rivet nut M6



with recess for
rivet nut M6 cus-
tomary in trade



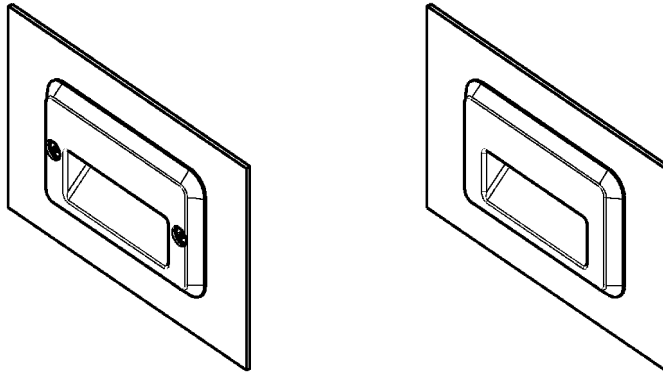
Cover for 3D-unit connector

spherical shaping allows
3D positioning

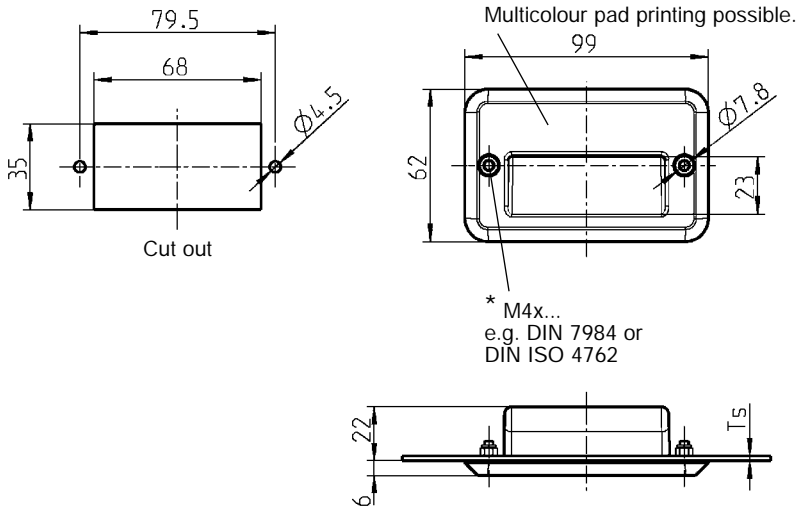
lateral offset 7 mm
vertical offset 5 mm
depth offset 3 mm

**3D-unit connector polyamide 66 GF 50 black;
safety nut M8 and socket head screw M8x35 m.s. zinc plated**

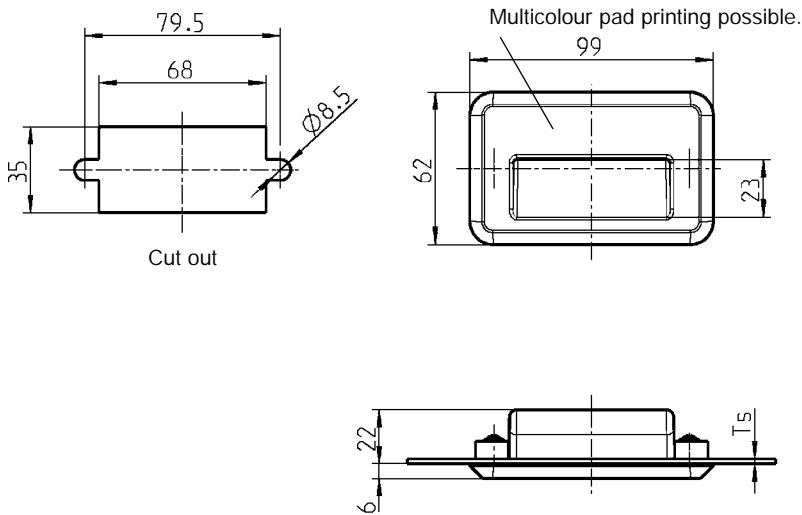
- without recess	1076-U14
- with recess	1076-U15
Cover polyamide black for 3D-unit connector	
2-part	1076-U16



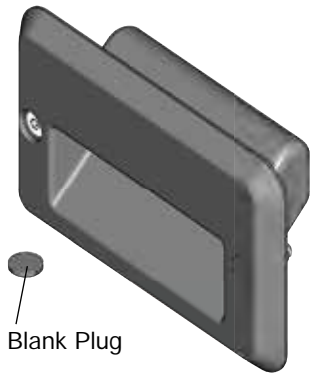
Version A



Version B

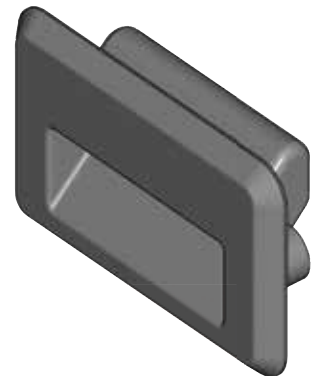


Version A



Blank Plug

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
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* must order separately

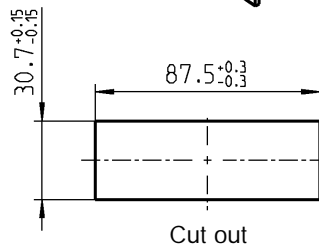
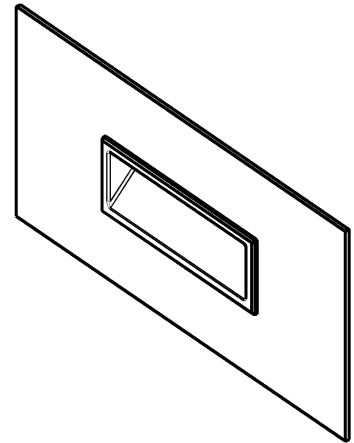
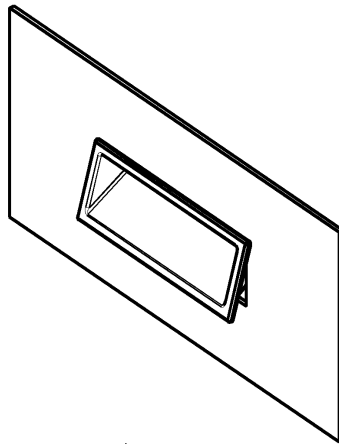
** Other door gauges on request

RL

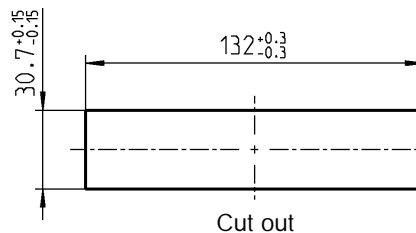
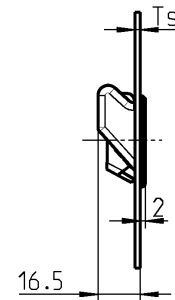
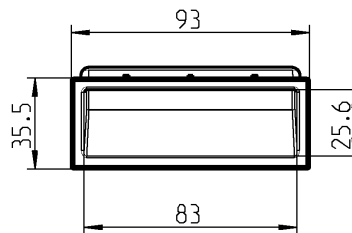


Press pull into cut out

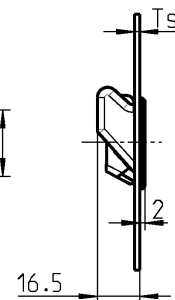
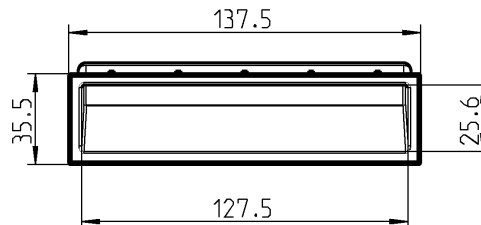
Ready for operating



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

Assembly

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

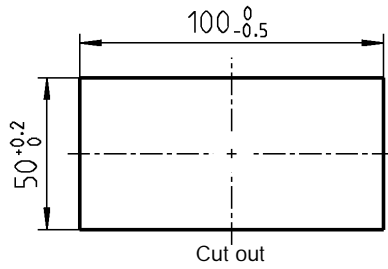
Pulls for other door thickness on request

Pull Polyamide GF Black

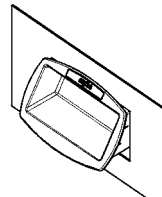
	Version A	Version B
Ts 0.8 - 1.2 mm	1091-103-01	1091-109-01
Ts 1.2 - 1.6 mm	1091-103-02	1091-109-02
Ts 1.75 - 2.2 mm	1091-103-03	1091-109-03

Pull; Door stop

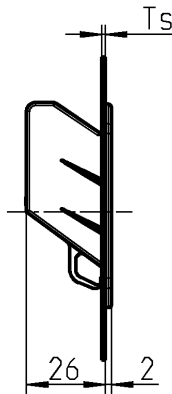
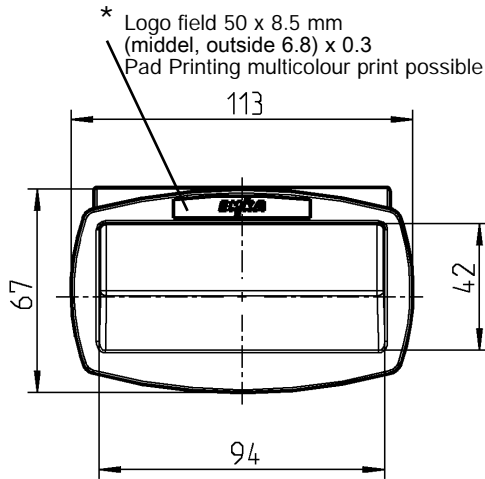
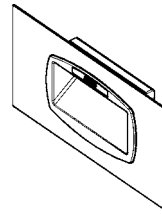
PROGRAM 1091, 1087



Press pull into cut out



Ready for operating

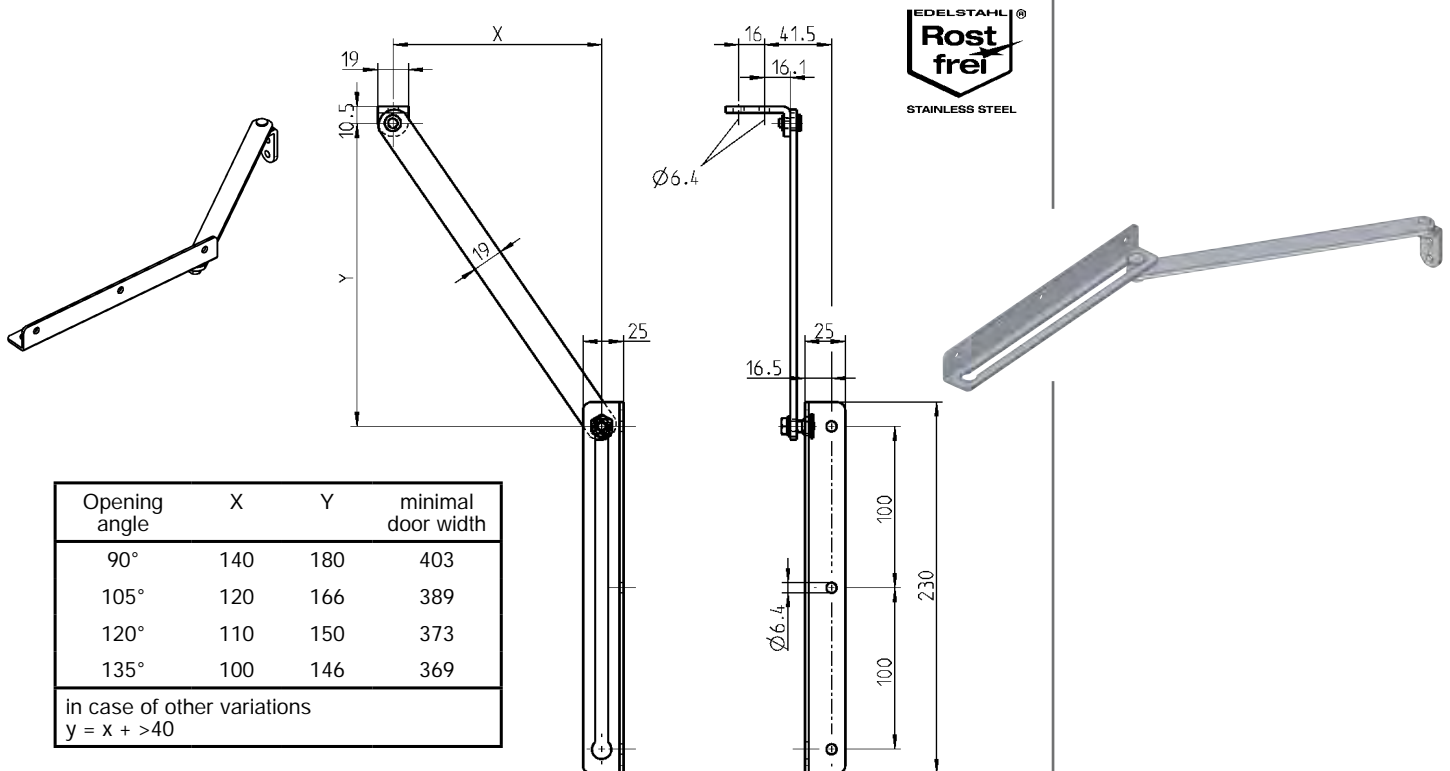


Assembly

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

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



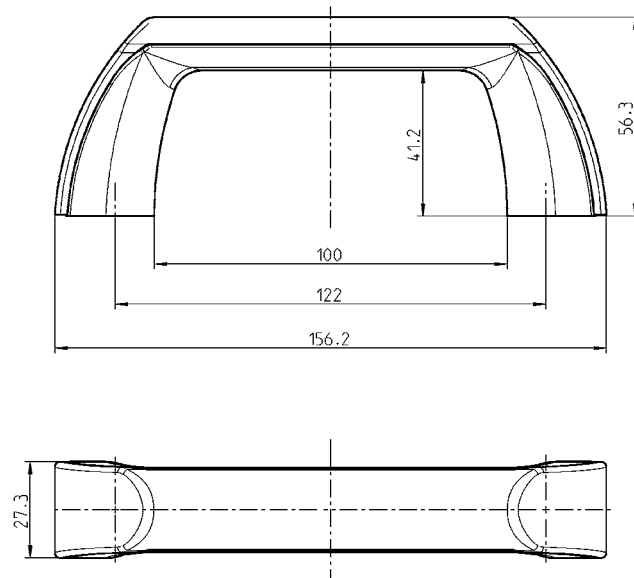
Opening angle	X	Y	minimal door width
90°	140	180	403
105°	120	166	389
120°	110	150	373
135°	100	146	369
in case of other variations $y = x + >40$			

Door stop

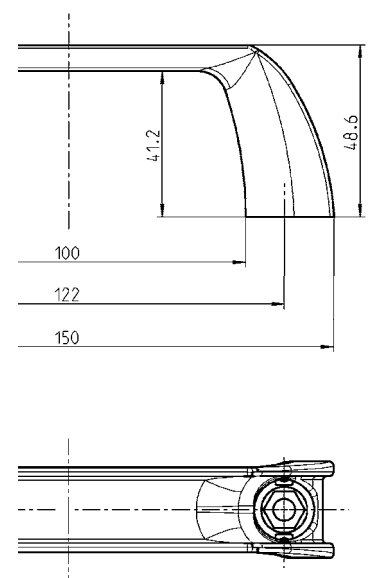
m.s. zinc plated	1087-U1
AISI 304	1087-U1-PC



Bow-type handle with cover



Bow-type handle without cover



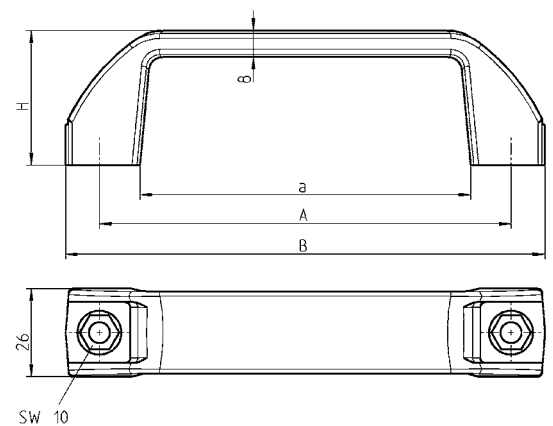
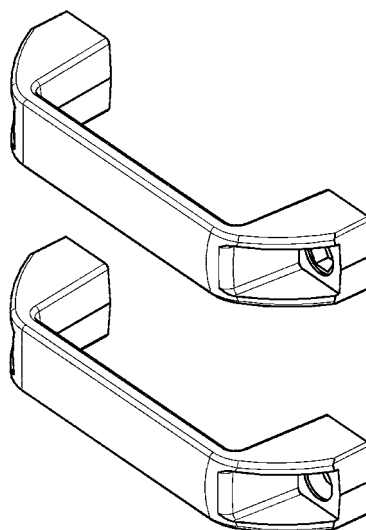
Bow-type handle polyamide GF black

Handle for hexagon or cylinder screw M6 acc. to DIN 4017/1207	1095-35
Handle for countersunk screw M5 or rivet 4.8 mm dia	1095-36

Cover for bow-type handle polyamide GF black

1095-37

Polyamide handle



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

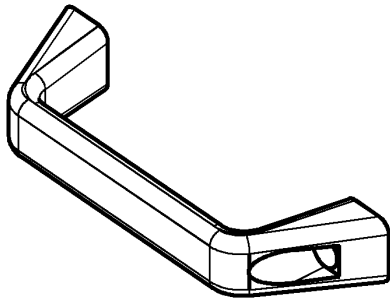
small head = DIN ISO 2009, 2010, 7046-1, 7046-2, 7047

Fastening material is not included in delivery.

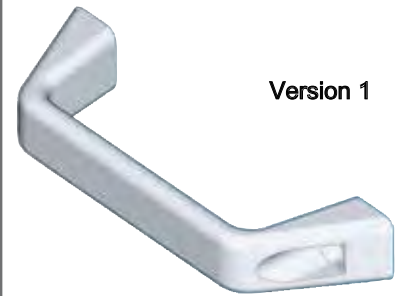
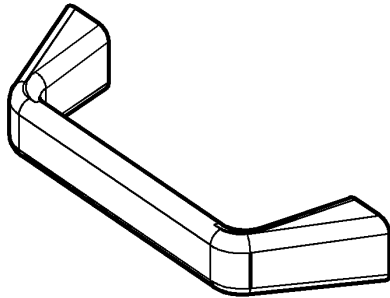
Bow-type handle polyamide GF black

	Version 1	Version 2
Handle for hexagon or cylinder screw M6 acc. to DIN 4017/1207	1095-05	1095-19
Handle for countersunk screw M5 or rivet 4.8 mm dia	1095-06	-

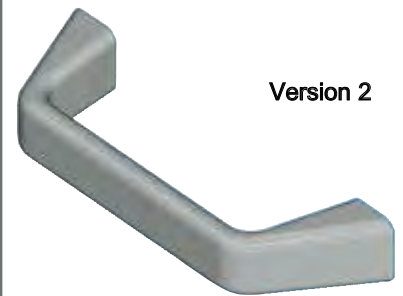
Version 1



Version 2

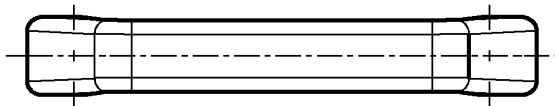
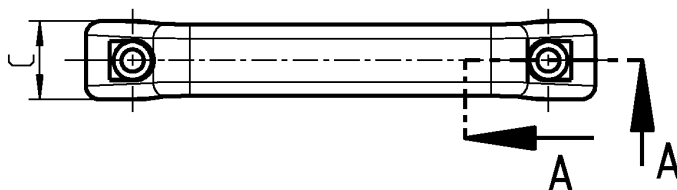
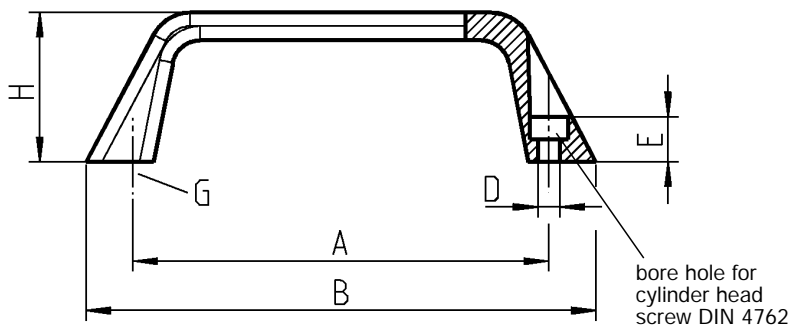


Version 1



Version 2

A-A



Bow-type handle aluminium GD-AI 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

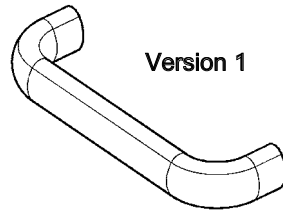
Version 2

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

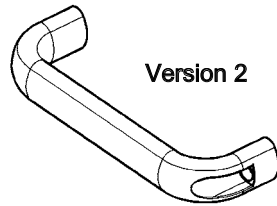
Fastening material is not included in delivery.



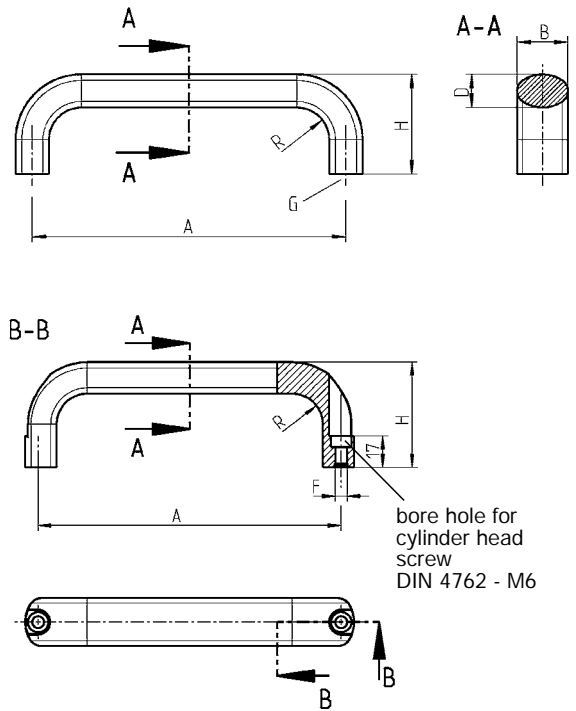
Version 1



Version 1



Version 2



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

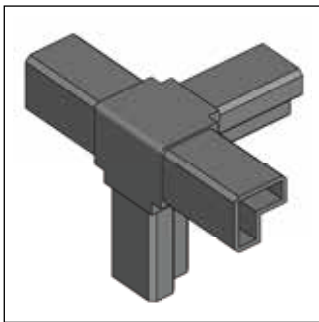
Fastening material is not included in delivery.

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



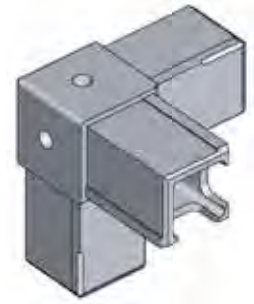
Geometry example

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:

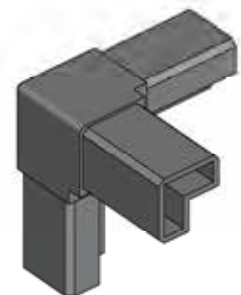
- Machines with 30 up to 250 t closing force
- Shot weight until 0.7 kg
- Processing of various thermoplastics



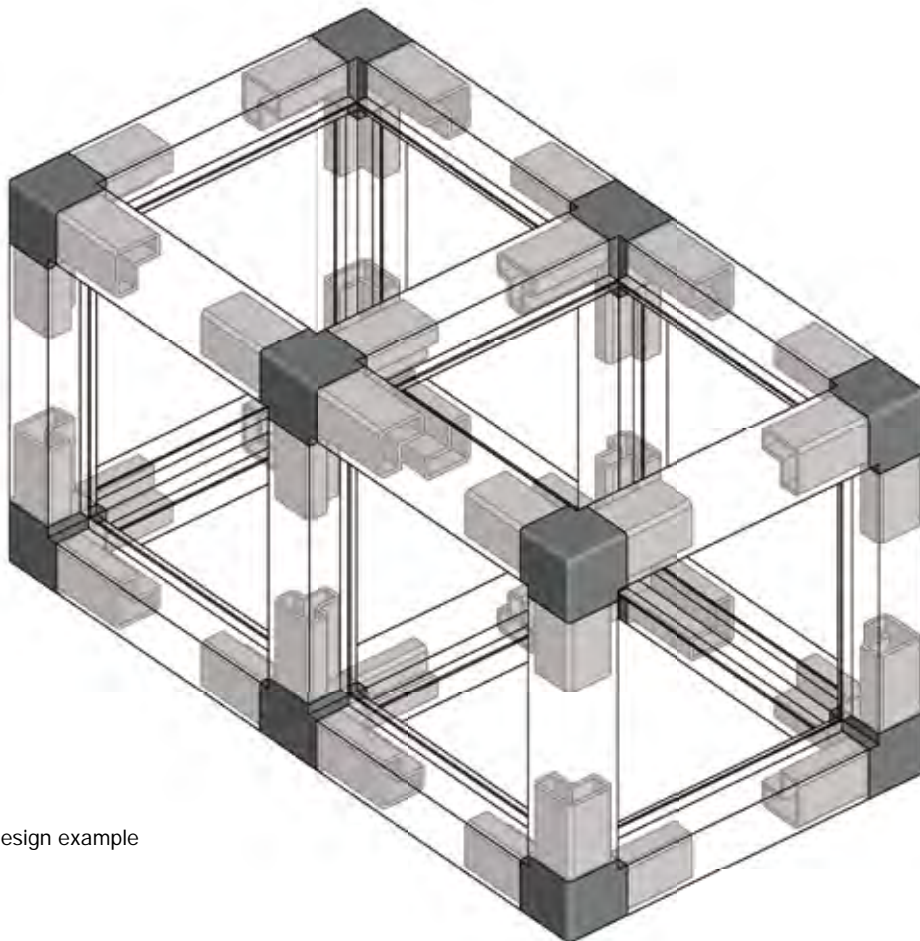
Application example
Zinc die Casting



Application example
Aluminium die casting



Application example
Injection Moulding



Design example

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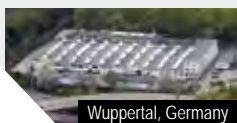
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Goražde (Plant 2), Bosnia and Herzegovina



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Henriville, France



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