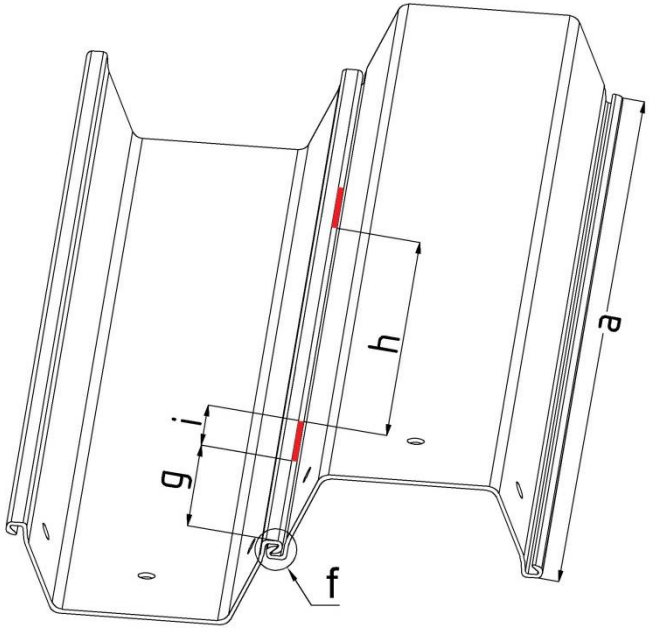
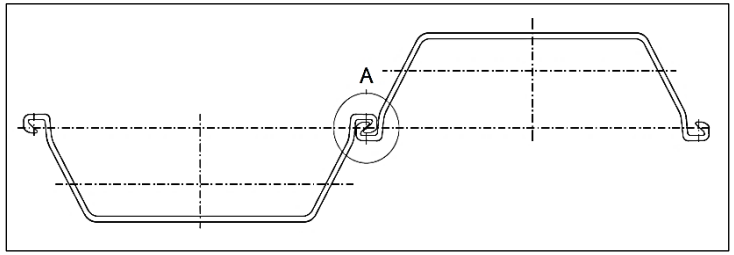
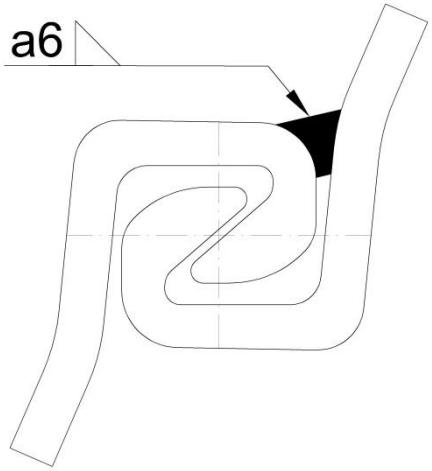
Info sheet No.	VL IS 04	Date of revision	2/9/2025
Type	*VL 504 – VL 507 (all modifications)* *VL 601 – VL 607 (all modifications)*	Form (Pairing)	DOUBLE / “S” or “Z” WELDED

BOTTOM

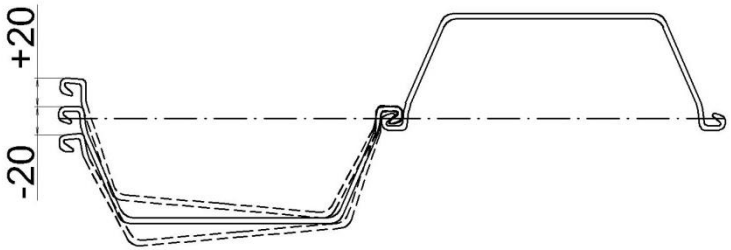


Parameter Označení	Description Popis	Param. value Hodnota (mm)	Tolerances (+/-) Tolerance (+/-)
g	***Distance from both sides of sheetpile and weld start (top and bottom welded on both sides, welds between them only one side welds)*** *Vzdálenost mezi horní hranou štětovnice a začátkem svaru (svary na koncích štětovnic oboustranné, svary po délce štětovnice jen jednostranné)*	**100**	+50/-100 mm
h	***Distance / spacing between welds*** *Vzdálenost / rozteč mezi svary*	**1000**	+0/-100 mm
i	***Dimension / weld length*** *Rozměr / délka svaru*	**50**	+15/-0 mm
f	***Top edge alignment*** *Zarovnání horní hrany*	**0**	+20/-0 mm





TOP



Welders qualified acc. to	**EN ISO 5817; EN ISO 14732; EN ISO 9606-1**
Welding procedure spec. acc. to	**EN ISO 15609-1; EN ISO 15614-1**
Requirements for welding supervisory staff	**EN ISO 14731**
Welding requirements. acc. to	**EN12063**