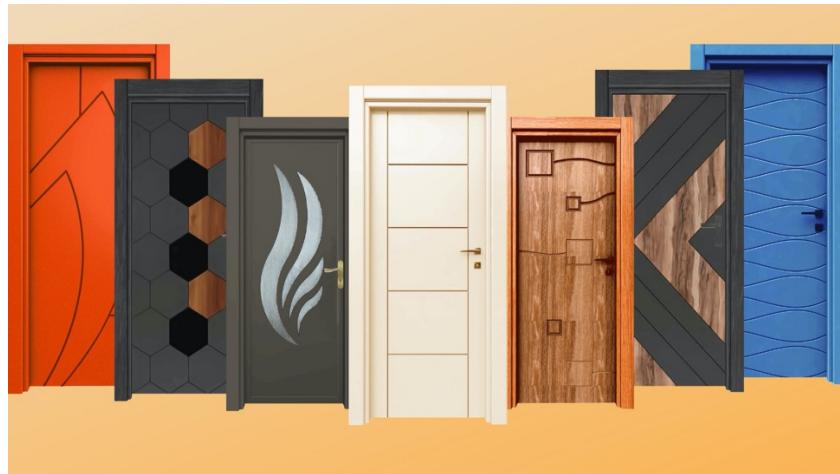


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## TECHNICAL SPECIFICATION

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« OKPS , Your door's manufacturer »

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JANUARY 1, 2023  
HILDOOR  
Konya Turkey

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## Introduction

Lacquer doors are room door models produced with high quality lacquer paint on mdf material.. The reason for using mdf instead of normal wood is that durable material and mdf are suitable for smooth production..

These doors, which are frequently used in modern home decorations today, are the most preferred doors in white color..

These doors, which are more expensive than other types of doors in terms of door prices, are doors with almost limitless designs, modeled with cnc with the most modern designs.. While there is no yellowing on quality lacquered doors, yellowing is experienced in simple products such as American door paint..

There is almost no model limit on these doors. Lacquer door models totally depends on your budget and the possibilities of the cnc machine. They can be produced with all kinds of cnc engraving as well as all kinds of relief work.. They can be produced with all kinds of cnc engraving as well as all kinds of relief work.. In addition, both techniques are used, and different door models can be obtained..

*Door modeling, besides the door surface, there can be differences in the models by embroidering the door sills.. As Okps DOOR, differences can be created in the door models by gold leaf painting in the door crown or paint..*

## Giriş

Lake kapılar mdf malzeme üzerine kaliteli lake boyası ile üretilmiş oda kapısı modelleridir..

Normal ahşap yerine mdf kullanılmasının sebebi dayanıklı malzeme ve mdf'nin sorunsuz üretime uygun olmasıdır..

Günümüzde modern ev dekorasyonlarında sıkılıkla kullanılan bu kapılar beyaz rengi ile en çok tercih edilen kapılardır.

Kapı fiyatları açısından diğer kapı çeşitlerine göre daha pahalı olan bu kapılar, en modern tasarımlarla cnc ile modellenen, neredeyse sınırsız tasarıma sahip kapılardır. amerikan kapı boyası gibi ürünler...

Bu kapılarda model sınırlaması neredeyse yoktur. Lake kapı modelleri tamamen bütçenize ve cnc makinesinin imkanlarına bağlıdır. Her türlü cnc işleme ile üretilen gibi her türlü rölyef çalışması ile de üretilebilirler.. Her türlü cnc işleme ile üretilen gibi her türlü rölyef çalışması ile de üretilebilirler.. Ayrıca her iki teknik de kullanılmaktadır ve birbirinden farklı kapı modelleri temin edilebilir..

Kapı modellemesi, kapı yüzeyinin yanı sıra kapı eşiklerine işlenerek modellerde farklılıklar olabilmektedir.. Okps KAPI olarak kapı taşlarına altın varak boyama veya boyası ile kapı modellerinde farklılıklar oluşturulabilmektedir..

## مقدمة

أبواب الطلاء هي نماذج لأبواب الغرف تم إنتاجها بدهان ورنيش عالي الجودة على مادة mdf .. مناسبة للإنتاج السلس بدلاً من الخشب العادي هو أن المواد المتينة و mdf والسبب في استخدام .. هذه الأبواب التي تُستخدم بكثرة في ديكورات المنزل الحديثة اليوم ، هي أكثر الأبواب تفضيلاً باللون الأبيض هذه الأبواب ، التي تعتبر أغلى من الأنواع الأخرى من الأبواب من حيث أسعار الأبواب ، هي أبواب ذات تصميمات بأحدث التصميمات .. بينما لا يوجد اصفارار على الأبواب المطلية عالية الجودة ، فإن CNC حدود لها تقريباً ، على غرار .. الاصفارار يكون من ذوي الخبرة في البساطة منتجات مثل دهان الأبواب الأمريكي لا يوجد حد نموذجي تقريباً على هذه الأبواب. تعتمد نماذج أبواب الطلاء بالكامل على ميزانيتك وإمكانيات آلة التصنيع باستخدام الحاسب الآلي. يمكن إنتاجها بجميع أنواع النقش باستخدام الحاسب الآلي وكذلك جميع أنواع أعمال الإغاثة .. يمكن إنتاجها بجميع أنواع النقش باستخدام الحاسب الآلي وكذلك جميع أنواع أعمال الإغاثة .. بالإضافة إلى ذلك ، يتم استخدام كلتا الطريقتين ، ومختلفة يمكن الحصول على نماذج الباب نماذجة الباب ، إلى جانب سطح الباب ، يمكن أن تكون هناك اختلافات في النماذج من خلال تطريز عتبات الأبواب .. مثل Okps DOOR ، يمكن إنشاء اختلافات في نماذج الأبواب من خلال طلاء أوراق الذهب في تاج الباب أو الطلاء

## Introduction

Les portes laquées sont des modèles de porte de chambre fabriqués avec une peinture laquée de haute qualité sur un matériau mdf.

Ces portes, qui sont fréquemment utilisées dans les décorations de maison modernes aujourd'hui, sont les portes les plus préférées en couleur blanche.

Ces portes, qui sont plus chères que d'autres types de portes en termes de prix de portes, sont des portes aux designs presque illimités, modélisées avec cnc avec les designs les plus modernes. Bien qu'il n'y ait pas de jaunissement sur les portes laquées de qualité, le jaunissement est ressenti dans de simples produits tels que la peinture de porte américaine.

Il n'y a presque aucune limite de modèle sur ces portes. Les modèles de portes en laque dépendent totalement de votre budget et des possibilités de la machine cnc. Ils peuvent être produits avec toutes sortes de gravures cnc ainsi que toutes sortes de travaux en relief. Ils peuvent être produits avec toutes sortes de gravures cnc ainsi que toutes sortes de travaux en relief. De plus, les deux techniques sont utilisées, et différentes des modèles de porte peuvent être obtenus.

Modélisation de la porte, outre la surface de la porte, il peut y avoir des différences dans les modèles en brodant les seuils de porte.. Comme OKPS DOOR, des différences peuvent être créées dans les modèles de porte par la peinture à la feuille d'or dans la couronne de la porte ou la peinture..

## General description of the model/ Modelin genel açıklaması



Figür 1: Lake Kapı



Figür 2 : Laminated door

### Basic Info.

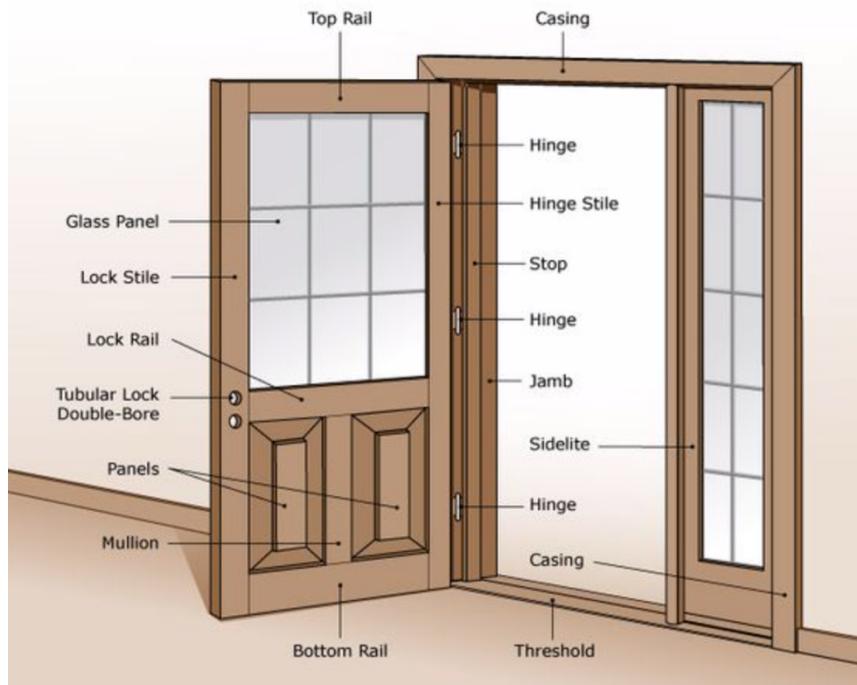
Opening Direction Inwards/Outwards  
8mm MDF \*2  
Option: Lake (peinted)  
Color Different Choices  
Special Function Security  
Surface Finishing Finished  
Handle Position Right/Left  
Position Room  
Infilling 2cm Mdf wood  
Transport Package Carton  
Standard Specification 2100 x 900 x 40 or customised  
Trademark Treezo  
Origin Turkiye/konya  
HS Code 4418200090  
Production Capacity 30 000 Sets Per Month

### Temel bilgi.

Açılma Yönü İçe/Dışa  
8mm MDF \*2  
Seçenek: Lake (boyalı)  
Renk Farklı Seçenekleri  
Özel Fonksiyon Güvenliği  
Yüzey İşlem Bitti  
Kol Konumu Sağ/Sol  
Pozisyon Odası  
Dolgu Mdf  
Nakliye Paket Karton  
Standart Özellik 2100 x 900 x 40 veya özelleştirilmiş  
Ticari marka Treezo  
Menşei Türkiye/konya  
GTİP Kodu 4418200090  
Üretim Kapasitesi Ayda 30 000 Takım

## General presentation / Genel sunum/ عرض / Présentation générale

Technical terms/Teknik terimler



<b>Hinge</b> = <b>Jamb</b> = <b>Stile</b> = <b>Thershold</b> = <b>Sill</b> = <b>Bottom Rail</b> <b>Stile</b> <b>Mullion</b> <b>Glas panel</b>	<b>menteşe</b> = <b>Söve</b> = <b>Stil</b> = <b>eşik</b> = <b>eşik</b> = <b>Alt Demiryolu</b> <b>stil</b> <b>orta kayıt</b> <b>Cam panel</b>	<b>المفصلة</b> = <b>عضاة</b> = <b>ستايل</b> = <b>عتبة</b> = <b>عتبة</b> = <b>السکك الحديدية</b> <b>القاع</b> <b>العصادة</b> <b>موليون</b> <b>لوحة من الزجاج</b>	<b>Glaass panel</b> <b>Lock Stile</b> <b>Lock Rail</b> <b>Tunbular Loc double bore</b> <b>Panels</b> <b>Bottons Rails</b> <b>Thersholt</b> <b>Casing</b> <b>Sidelite</b>	<b>Cam panel</b> <b>Kilit Stili</b> <b>Kilit Ray</b> <b>Tunbular Loc çift geçişli</b> <b>Paneller</b> <b>Düğmeler Raylar</b> <b>Eşik</b> <b>kasa</b> <b>yan taş</b>	<b>لوحة من الزجاج</b> <b>نقط القفل</b> <b>قفل السكك الحديدية</b> <b>التجويف المزدوج</b> <b>اللوحات</b> <b>أزرار القصبان</b> <b>عتبة</b> <b>غلاف</b> <b>Sidelite</b>
---	--	--	--	---	---

### Lake Model



#### Basic Info.

The model are disigned according to the customers demand  
The interior of lead door will be like in the image

Model bilgi.

Model müşteri talebine göre tasarlanmaktadır.  
Kurşun kapının içi görseldeki gibi olacaktır.

Informations de base.

Le modèle est conçu selon la demande des clients  
L'intérieur de la porte en plomb sera comme sur l'image

معلومات أساسية.

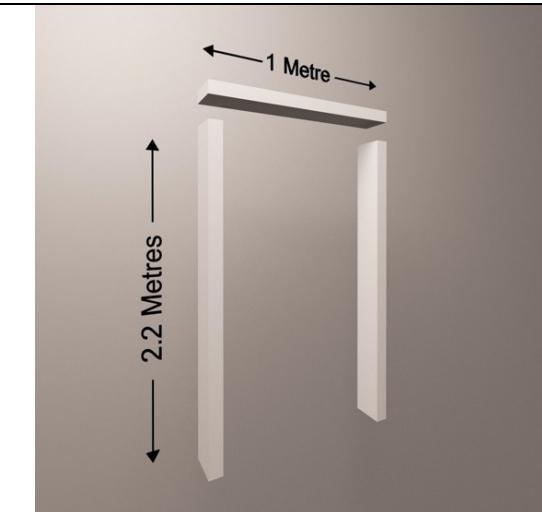
يتم إلغاء تصميم النموذج وفقاً لطلب العميل  
سيكون الجزء الداخلي للباب الرصاصي كما في الصورة



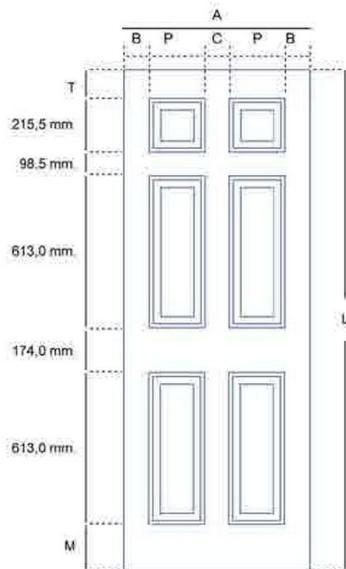
Figure 3 Customer choice

Dimensions/ boyutlar/ حجم

Type 1/Tip 1 : 210x100x28cm



Figür 4: for the frame

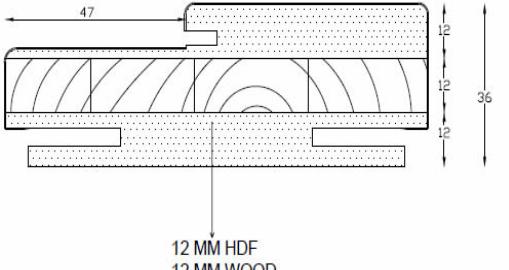
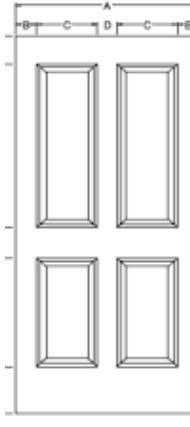


Figür 5 : Laminated door

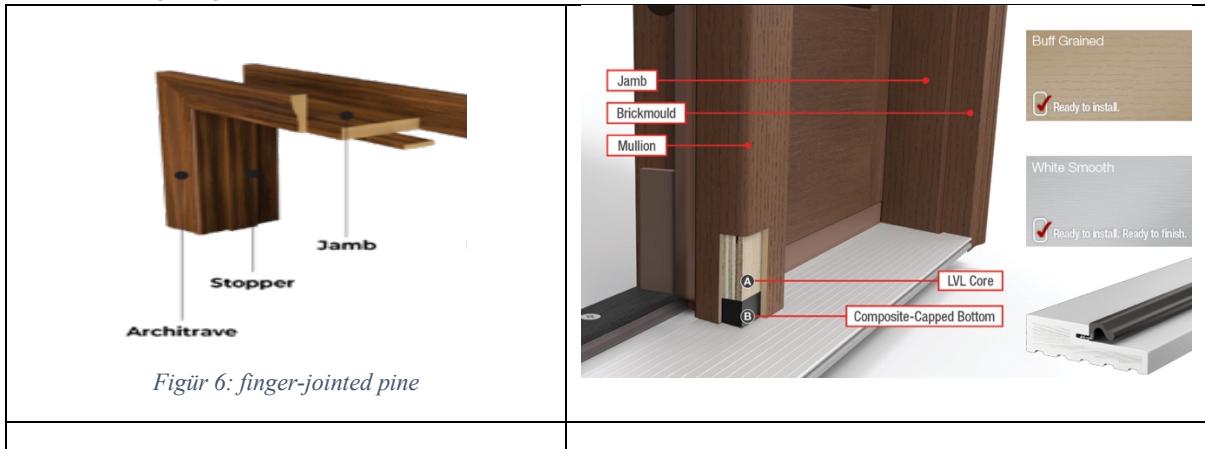
**28cm + 4,5X10cm**

**Lake Kapi. 8mm Mdf \* 2 + Mdf Lake frame**

Type 2/Tip 2 : 210x140x28cm

 <p>12 MM HDF 12 MM WOOD 12 MM HDF</p>	
<p><b>28cm + 4,5X10cm</b></p>	<p><b>2kapi , Lake Kapi. 8mm Mdf * 2 + Mdf Lake frame ve Lake Kapi. 8mm Mdf * 2 + Mdf Lake frame</b></p>

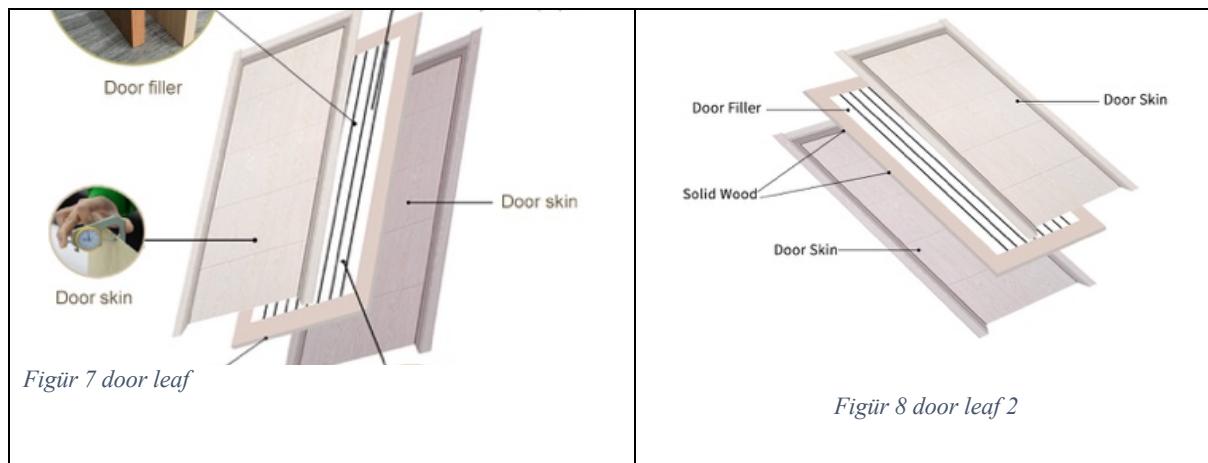
## Frame / Çerçeve



**Frame structure:**  
**In Mdf and protected by lake**  
**Dimensions will be: 28cm + 4,5X10cmm**

## ورقة الباب / Kapı kanadı

Exterior



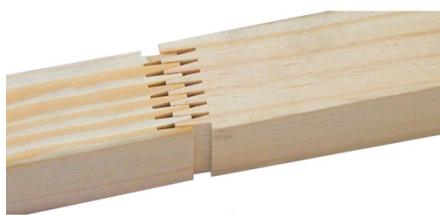
Interior :

 <p>Internal globle structure of the doors: 2cm Mdf wood every 10cm</p> <p>Product Description</p> <ol style="list-style-type: none"> <li>1. Simple and fashionable design of European style.</li> <li>2. 3D visual effect makes design and function focused together perfectly and sharp color contrast for high visional impact.</li> <li>3. Different filling such as MDF strips,</li> <li>4. 80 dmm thicker Lake banding prevents the door edge from being degumming.</li> <li>5. The moisture content of wood is 10-12% that keep the door stable.</li> </ol>	 <p>Kapıların iç küresel yapısı: 10cm de bir 2cm Mdf ahşap</p> <p>Ürün Açıklaması</p> <ol style="list-style-type: none"> <li>1. Avrupa tarzının basit ve şık tasarımını.</li> <li>2. 3D görsel efekt, tasarım ve işlevin birlikte mükemmel bir şekilde odaklanmasını ve yüksek görsel etki için keskin renk kontrastını sağlar.</li> <li>3. MDF şeritleri gibi farklı dolgular.</li> <li>4. 80 dmm daha kalın Lake bant, kapı kenarının zamkının giderilmesini engeller.</li> <li>5. Ahşabin nem içeriği kapıyı sabit tutan %10-12'dir.</li> </ol>
--	--

Raw material used/ kullanılan hammadde/ المواد الخام المستخدمة / Matière

première utilisé

finger-jointed pine/ parmak eklemlı pinef/ خشب الصنوبر



Figür 9: finger-jointed pine

#### Specification

Timber Type : New Zealand Radiate pine

Glue: E1/E2

Size: 42X32mm or 42X34 as requested

Thickness: 32mm or 34mm

Usage: Door's frame

Face & Back : Plain/high glossy uv painted

Grade: AA

MOQ: 1\*20GP

Moisture: 12%

Density: 450kg/m<sup>3</sup>

Place of Origin: Turkiye

#### Şartname

Kereste Türü: Yeni Zelanda Yayılan çam

Yapıştırıcı: E1/E2

Boyut: İsteğe göre 42X32mm veya 42X34

Kalınlık: 32mm veya 34mm

Kullanım: Kapı çerçevesi

Ön ve Arka: Düz/çok parlak uv boyalı

Adedi: 1\*20GP

Nem: %12

Yoğunluk: 450kg/m<sup>3</sup>

Menşe Yeri: Turkiye

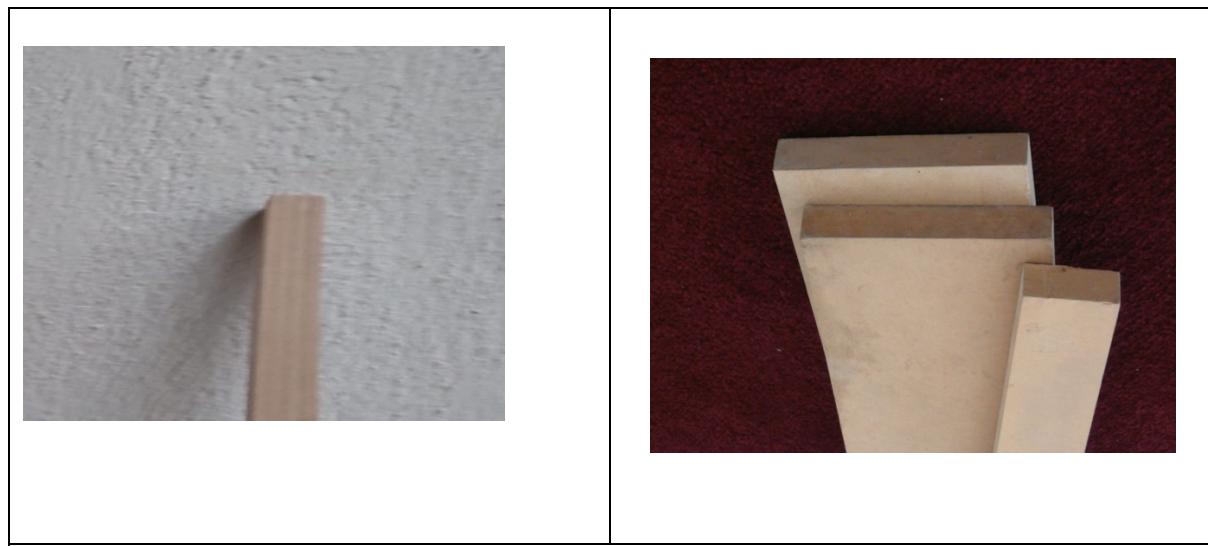
### Mdf (Medium -density fibreboard)



#### Specification

Glue: E1,E2 and E0  
Density: 650-800/kgs  
Size: 1220x2440mm  
MDF

### 2cm Mdf (Medium – density fibreboard)



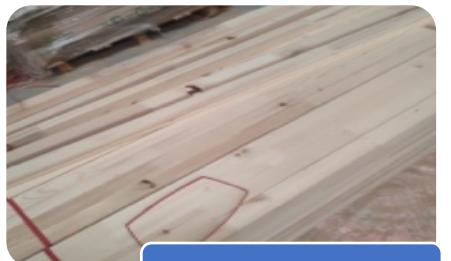
#### Specification

Glue: E1,E2 and E0  
Density: 650-800/kgs  
Size: 1220x2440mm  
MDF

Glue / Zamk/ صنع /Cole

 <p>Figür 12: finger-jointed pine</p>	
 <p><b>Specification</b></p> <p>Name: Pine Integration Timber</p> <p>Timber Type : New Zealand Radiate pine</p> <p>Glue: E1/E2</p> <p>Size: 42X32mm or 42X34 as requested</p> <p>Thickness: 32mm or 34mm</p> <p>Usage: Door's frame</p> <p>Face &amp; Back : Plain/high glossy uv painted</p> <p>Grade: AA</p> <p>MOQ: 1*20GP</p> <p>Moisture: 12%</p> <p>Density: 450kg/m<sup>3</sup></p> <p>Place of Origin: China</p>	<p>Usage : used for door's frame ,and mullion</p>

## Manufacturing process/ Üretim süreci/ إجراءات البناء/Procedure fabric Interior The framework/iç Çerçeve/



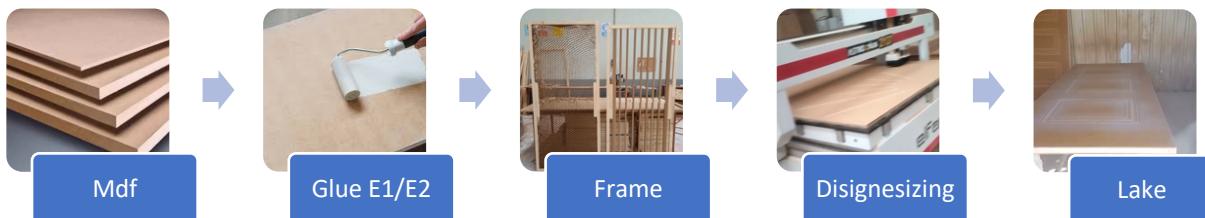
finger wood



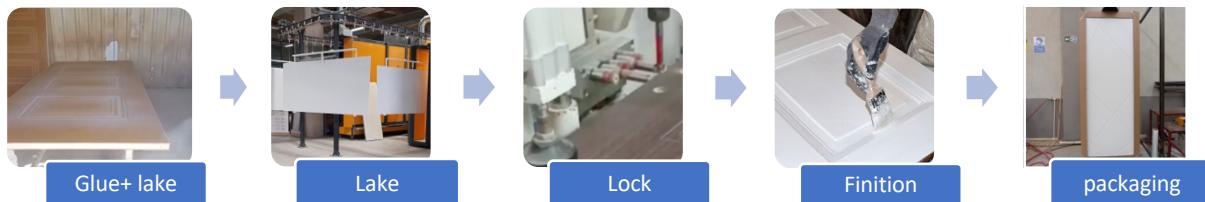
Interior choice

الإطار

### Leaf Manufacturing



### Lake

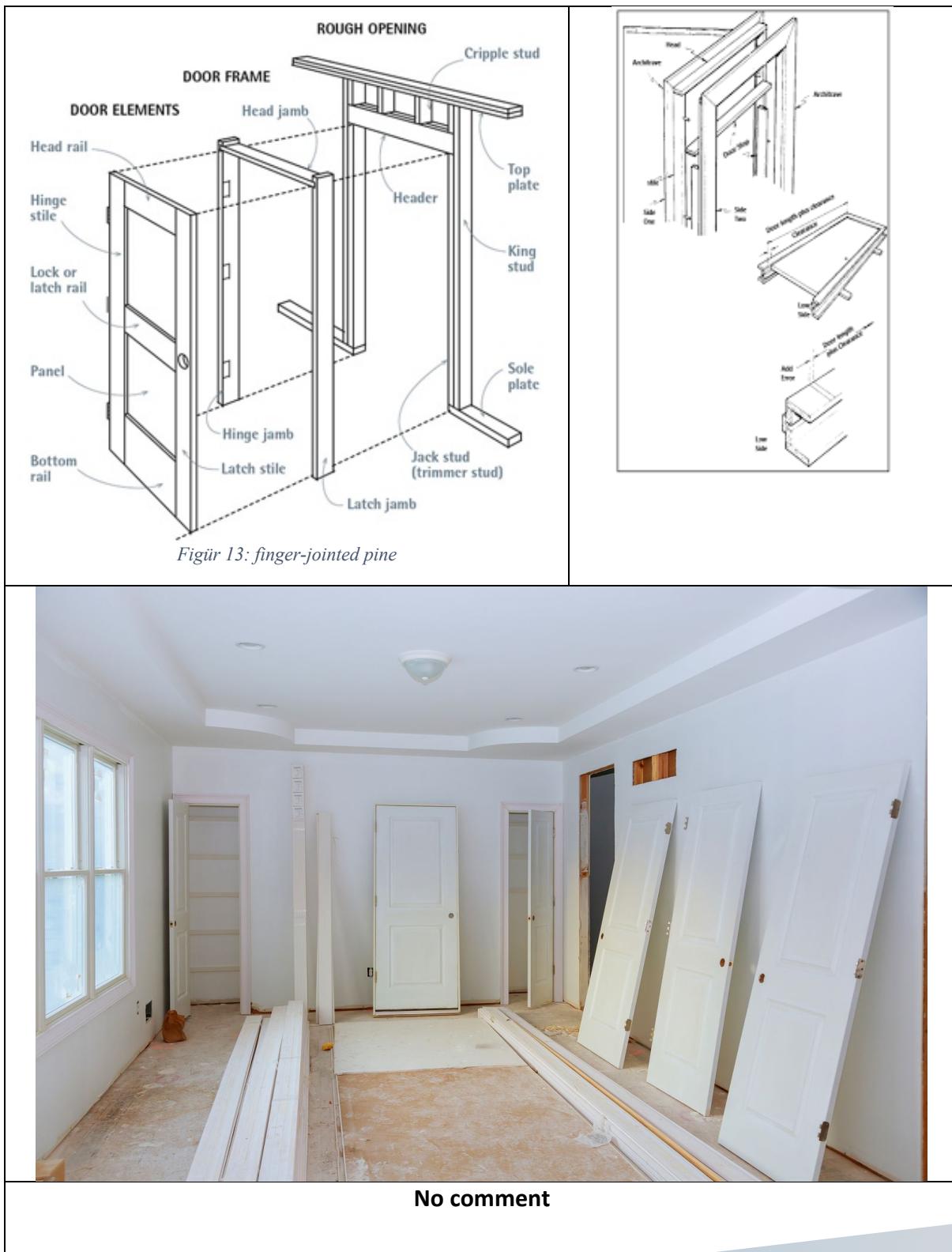


### Frame + Packaging



## Installing the door/ Kapının takılması/ تركيب الباب

### Installing the Frame/ Çerçeveyi Takma



تركيب أوراق الباب/ kapı kanadı montajı



No comment

## Specification of HS : 441820

Name	Description.	Model
DOOR WITH Lake SURFACE	<ul style="list-style-type: none"> <li>• It is 4cm thick. (4cm Thickness)</li> <li>• Total door thickness is 42 mm.</li> <li>• There is a kiln-dried wooden frame.</li> <li>• It is painted, not scratched.</li> <li>• Priced according to color and model.</li> <li>• Its standard size is 90*210 (</li> <li>• Frame dimensions are 10-15 or 20 cm.</li> <li>• The sill is 7-28*10 cm. (Sill dimensions are 7-10*10 cm)</li> <li>• Two different colors can be applied.</li> <li>• It is 23kg. (for standard dimension)</li> <li>• Frame can be composit or wood</li> </ul>	

### Note

Lake MDF Doors are coated under high pressure with Lake sheets using a temperature-vacuum method. Lake is a very durable film that can imitate any wood pattern. Lake can be both white and multi-colored, with any pattern.

Advantages of the laminate: ease of maintenance, high shock resistance, long service life.

MDF is an abbreviation for medium-density fibreboard: a type of board made from very small pieces of wood that have been pressed and stuck together. MDF is the preferred material, due to its structure, uniformity, standard dimensions; MDF material is great for engraving on CNC machines and it holds screws perfectly.

### Door Leaf

Solid materials door stile (internal frame) used for making doors.

The optimal humidity rate is %12 consisted of the coniferous tree which was dried privately.

After it was purified from the snags, it is combined with finger-jointed, destroyed the deformation, and increased the resistance.

The size of the stiles' section is 28\*42

There are air space grooves that have 6\*3mm measures inside the stiles.

There will be a double stile on the sub of the door leaf.

The door leaf is made up of 6 mm MDF covered by HPL (High-Pressure Laminate)

The lock housing is drilled for a 40 mm oval lock. Hinge housing and lock striker are drilled if there is a special request.

There will be used honeycomb which has resin-based, 120 ton resistance and comply with TSEK in the framework.

General principles as mentioned above are the same for producing glazed doors. While the carcass process there will be a solid stile on the housing of glass opening that will be drilled in the middle of the door leaf.

#### Test

All the interior doors are produced to TSE (TS 1905) standards.

The press doors are installed as a set (frame + door leaf) and they are tested in the bootstrap machines.

We rigidly and routinely test selected products with drilling methods and record the results.

These include:

Horizontal resistance test

Vertical resistance – hanging test

Heavy/soft impact test

Light/hard impact test



