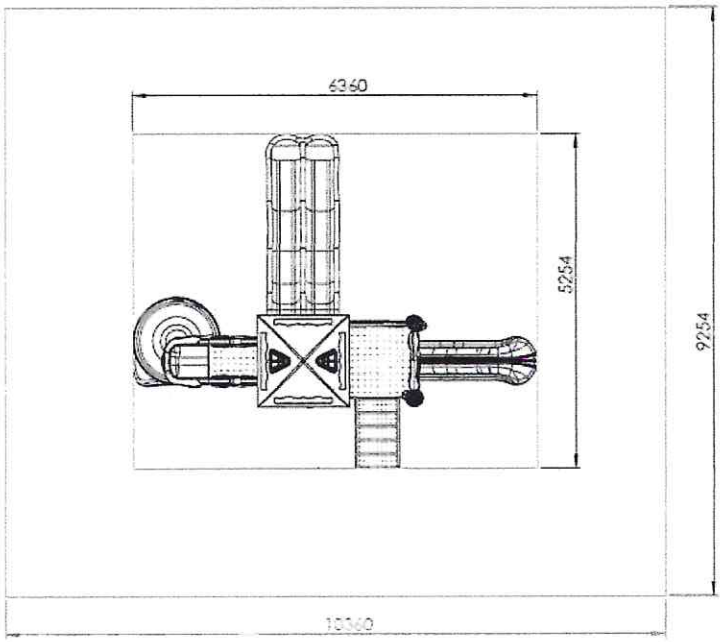
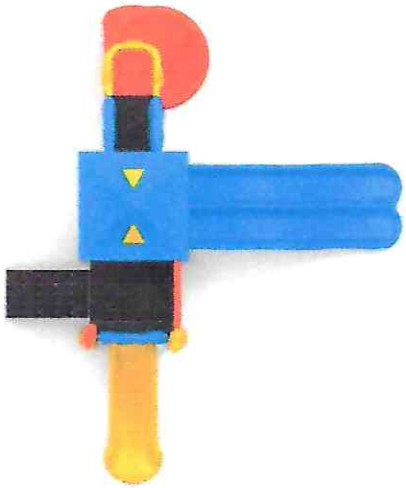
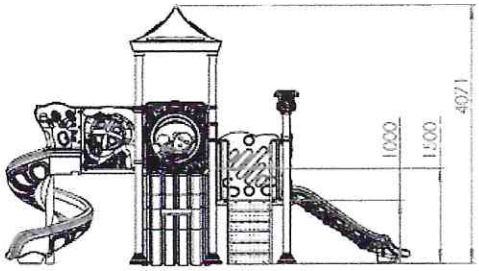
IP-301 TEKNİK ŞARTNAME





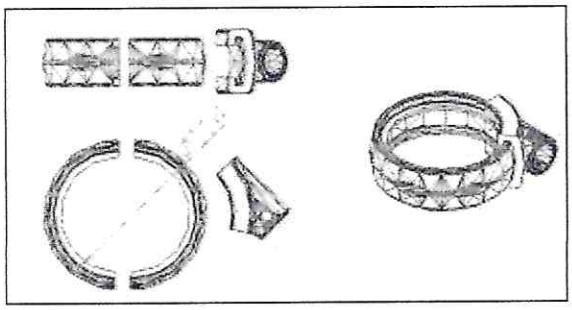


SUPPORTING STRUCTURE

It will be constructed from 114 mm diameter, 2.5 mm wall thickness SDM pipe. Horizontal and vertical pipes of 2500 mm and greater length will be connected to each other at right angles using a special interlocking system. The upper parts of these pipes will be sealed with injection-molded hemispherical plastic plugs, secured with a minimum of two aluminum rivets, to prevent water, moisture, and foreign matter from entering. The vertical and horizontal 114 mm diameter pipes will be connected to each other at right angles. The lower parts of the pipes forming the supporting structure will be joined with sheet metal flanges of minimum dimensions of 150x150x5mm using welding. The pipes will be subjected to sandblasting.

ELECTROSTATIC PAINTING

All metal parts that have been manufactured must be rinsed by immersion in a 5% concentration degreasing bath at 70° for 10 minutes. After rinsing, the metals, which are washed with a special alloy detergent solution with phosphate coating properties, should be subjected to SANDBLASTING, followed by a polyester-based static powder coating process and then baked in a 200°C oven for 20 minutes.



CONNECTING ELEMENTS

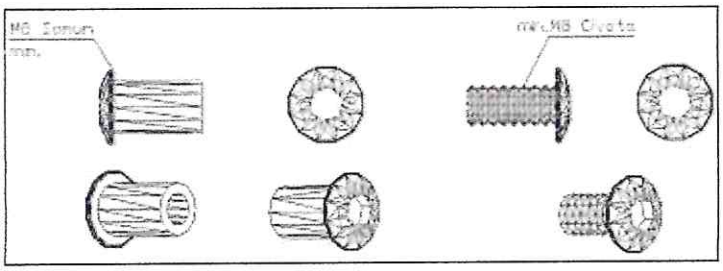
- Carrier clamps can be manufactured using injection molding from fiber-reinforced polyamide (nylon 66) or by directly attaching the platform to the carrier system. All connection elements must be demountable and removable.
-

- Barrier clamps must be made of polyamide using injection molding.

• Beam connections must be made of polyamide using the injection molding method. Connection diameters must be suitable for pipes with a minimum diameter of 27 mm.

• All nuts, bolts, and washers used in clamps must be of the minimum M8 nut and bolt configuration.

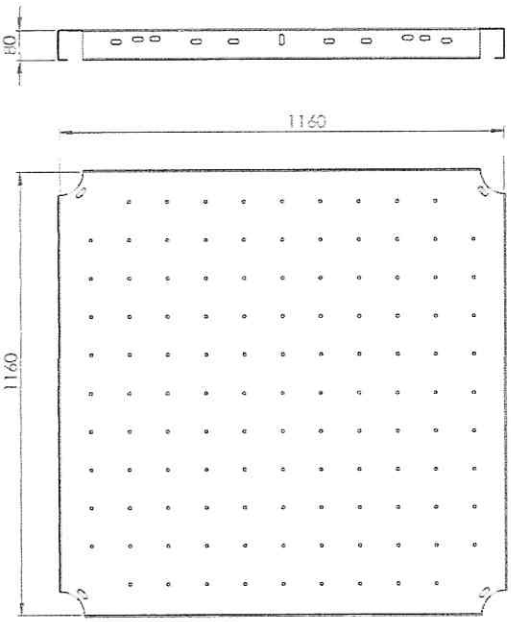
BOLTS, NUTS AND WASHERS



• The bolts, washers, and nuts used in the system must be coated. And they must absolutely not have any sharp protruding edges exceeding 3mm.

• All nuts must be made of fiber. This will eliminate the problem of nuts loosening and falling due to vibration. • Electro-galvanized bolts should only be used in areas covered with plastic caps. All bolts and nuts in exposed areas must be coated.

- **SQUARE PLATFORM**
- • The platform will be constructed from a frame made of minimum 20x40x1.5 mm box profiles, with 2 mm thick sheet metal fastened with tight spot welding. The platform will have dimensions of 116x116 cm. The mounting holes will be pre-drilled. There will be 6 supports under the platform, and the platform's front dimensions will be 8 cm.



- • The top surface of this platform will be coated with PVC (Plastisol) using the HOT-DIP METHOD, with an anti-static material mixture having a hardness of -60 ±5 shear A, a density of 1 gr/cm3, a minimum tensile strength of kg/cm2, elongation at break of 650-700%, and abrasion resistance of 100 m3 (maximum). The PVC thickness will be a minimum of 1 mm at every point.

- • These platforms will be attached to the pre-cut lugs (attached during manufacturing) on the supporting structure using galvanized bolts and nuts.

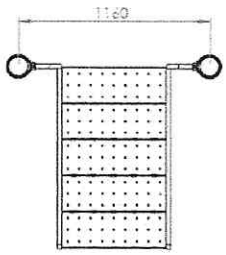
H100 STAIRCASE FROM GROUND TO TOWER

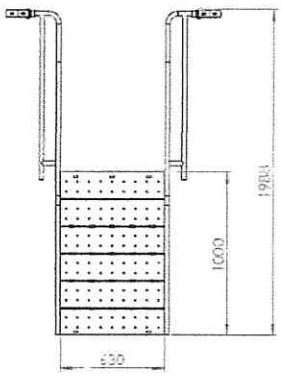
• The stairs will be manufactured as a single piece of 2 mm thick DKP sheet metal, allowing for a 100 cm height difference from the tower to the platform.

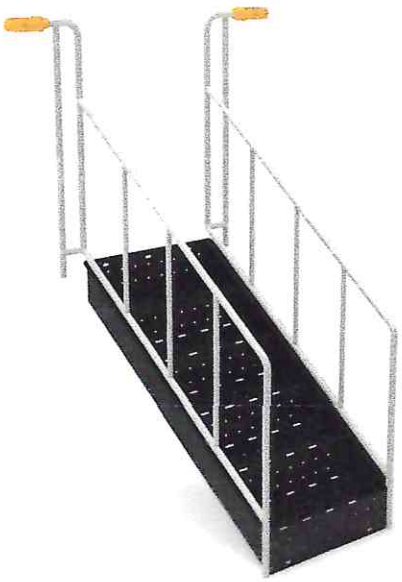
• The stair tread height will be a minimum of 13 cm and a maximum of 20 cm. Two stair railings will be manufactured for each stair group, with a minimum height of 70 cm and a maximum height of 85 cm.

• The stair treads will be coated with a mixed antistatic material with a hardness of -60±5 Shear A, a density of 1 gr/cm3, a minimum tensile strength of kg/cm2, an elongation at break of 650-700%, and abrasion resistance of 100 m3 (max) using the HOT-DIP METHOD PVC (Plastisol) coating. The PVC thickness will be a minimum of 1 mm at every point.

• The edges of the stair railing will be made of minimum 27x2 mm pipe, and the balustrades will be made of minimum 21x2 mm pipe. The distance between balustrades on the stair railing will be a maximum of 85 mm. • Stair railings will be painted with polyester-based electrostatic powder paint after sandblasting.







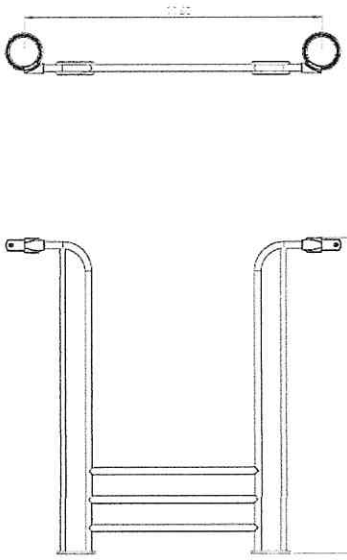
H50 INTERIOR STAIRCASE

- The main body and climbing tubes of the H:50 indoor staircase will be manufactured from 27x2 mm tubing.

- The clearances at the edges of the staircase will be a maximum of 89 mm.

- The H:50 cm indoor staircase will be painted with polyester-based electrostatic powder paint after sandblasting or degreasing.

- The H:50 indoor staircase must be manufactured in accordance with the technical drawing above. Matters not specifically mentioned in the specifications will be manufactured according to TSE EN 1176-1 standards.



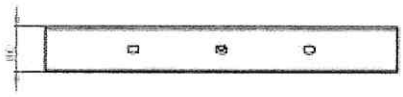
EXTENSION PLATFORM

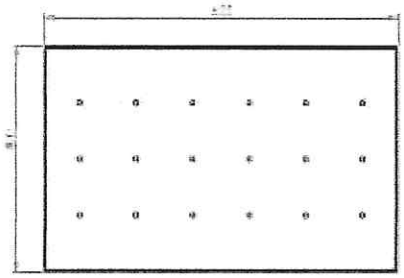
• The platform will be constructed from a frame made of box profiles with minimum dimensions of 20x40x1.5 mm, and will have dimensions of 90x60 cm, constructed by attaching 2 mm thick sheet metal with tight spot welding. The mounting holes for the platform will be pre-drilled. The platform's end dimensions will be 8 cm.

• The upper surface of this platform will be coated with PVC (Plastisol) using the HOT-DIP METHOD, a mixture of antistatic material with a hardness of -60 ±5 shear A, a density of 1 gr/cm3, a minimum tensile strength of kg/cm2, elongation at break of 650-700%, and abrasion resistance of 100 m3 (maximum)

. The PVC thickness will be a minimum of 1 mm at every point.

• These platforms will be attached to the pre-cut lugs (attached during manufacturing) on the supporting structure using galvanized bolts and nuts.





H150 Spiral Slide

• Spiral slides, connected to a 150 cm high platform, will be manufactured as double-walled, single-piece structures, with the exit designed to be 90° to the left of the entrance.

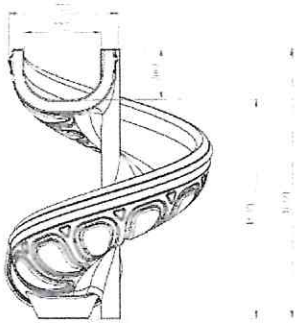
• The height (depth) of the side sections of the entrance will be at least 25 cm. The width of the sliding section will be at least 50 cm.

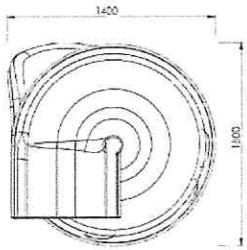
• Spiral slides will have an exit section (deceleration plane) to reduce sliding speed, and the length of the sliding section will be at least 55 cm, with a maximum slope of 10° and an exit radius of 50 mm.

• The exit section of the slide will be anchored to the ground and concreted. • The spiral section in the middle of the spiral slide will have a recess allowing for the insertion of a Ø89 pipe. • The slides will be manufactured using rotational molding technology from powdered, self-colored LLDPE raw material. The dyes used for coloring must be safe for children and comply with food regulations.

• The phrase "SPIRAL SLIDE" must be included within the scope of TS EN 1176-3/04.02.2010.

Weight: Min. 47 KG.





H150 DOUBLE WAVE SLIDES

• WAVE slides connected to a 150 cm high platform will be manufactured as double-walled, single-piece structures, with the sliding section's angle of inclination with the horizontal being a maximum of 40° when measured relative to the slide's longitudinal axis.

• The height of the side sections of the entrance of the WAVE slide will be at least 15 cm.

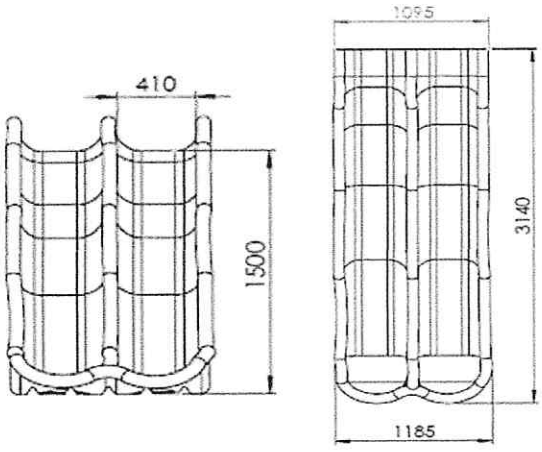
• The width of the sliding section of the WAVE slide will be at least 40 cm.

• The exit section of the slide will be at least 110 cm and will be anchored to the ground and concreted.

• The slides will have a polyethylene barrier that cuts off the entrance opening.

• The phrase "CURVED SLIDE" must be included within the scope of TS EN 1176-3 / 04.02.2010.

Weight: Min. 27 KG.



H100 STRAIGHT SLIDE

• For STRAIGHT slides connected to a 100 cm high platform, the sliding section will be manufactured as a double-walled, single-piece structure with a maximum angle of inclination of 40° relative to the horizontal axis of the slide.

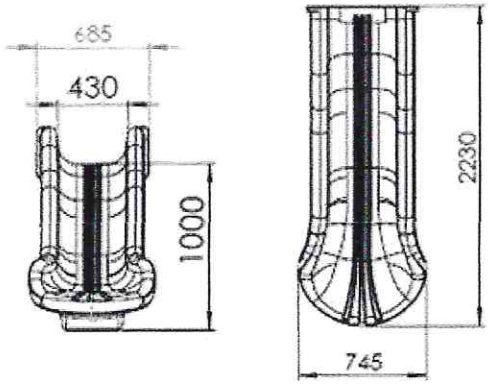
• The height of the side sections of the entrance of the Straight Slide will be at least 10 cm. The width of the sliding section of the Straight Slide will be at least 40 cm.

• The width of the exit section of the Straight Slide will be at least 70 cm, and the exit radius will be at least 50 mm. • The exit section of the slide will be anchored to the ground and concreted.

• The slides will be manufactured using rotational molding technology from powdered, self-colored LLDPE raw material. The dyes used for coloring will be compliant with child health and food regulations.

• The phrase 'STRAIGHT SLIDE' must be included within the scope of TS EN 1176-3 / 04.02.2010.

Weight: Min. 25 KG



SPIRAL SLIDE ENTRANCE PANEL POLYETHYLENE

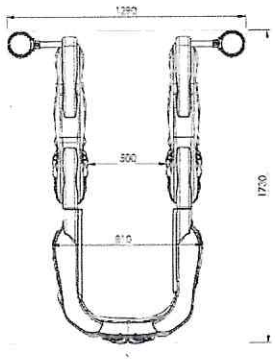
• These barriers, made of metal tubing or polyethylene, are designed to ensure safe access to the spiral slide used in the playground, provided that technical drawings, dimensions, and safety regulations are adhered to.

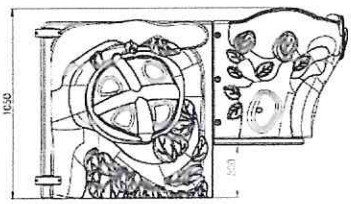
• When polyethylene is used as the entrance barrier, the installation will be completed with metal railings on both the right and left sides of the platform.

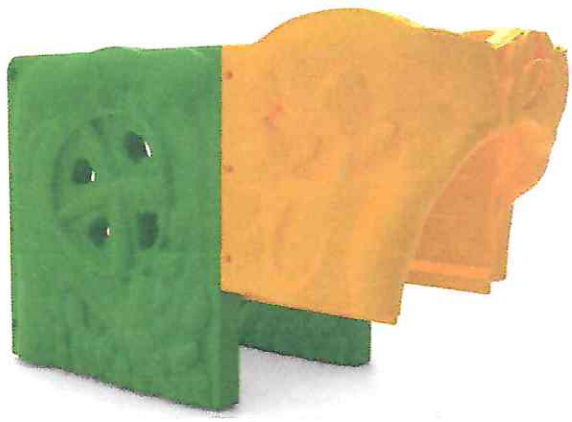
• The polyethylene product will be secured to the metal railings at the bottom of the platform using bolts and nuts, ensuring it fits the slide entrance section; connections without hidden details will be concealed with plastic caps.

• For spiral slides, the entire entrance and railings can also be made of polyethylene to ensure safe access. In this case, the polyethylene entrance barrier and railings will be manufactured from self-colored LLDPE raw material using rotational molding technology as a double-walled structure. The dyes used for coloring will be compliant with child health and food regulations. The entrance and railings must weigh a minimum of 21 kg.

Weight: Min. 21 KG.







DOUBLE STRAIGHT SLIDE ENTRANCE

• The double-walled straight slide entrance will be manufactured from a single piece of polyethylene, with the top and sides designed as a double wall to ensure safe passage for children to the slide.

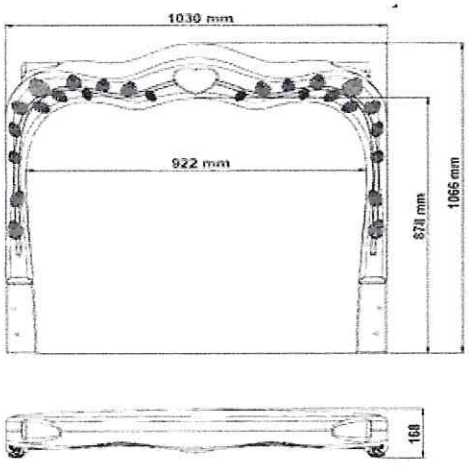
• The double-walled straight slide entrance will be designed and manufactured with dimensions of 103x106 cm, with a minimum entrance width of 92 cm.

• The top of the double-walled straight slide entrance will be secured to the main structure using a 100 cm galvanized pipe with a diameter of Ø27 mm and a wall thickness of 2 mm, and a clamp system.

The bottom will be secured to the platform with screws. The Ø27x2 mm galvanized pipe will be passed through the polyethylene entrances as a whole. Pipes shorter than 100 cm will not be used.

• At the connection points of the pipes with the slide entrance, injection-molded, polyamide-based, self-colored plastic clamps will be used, allowing the Ø27 mm diameter galvanized pipe to pass through.

Weight: Min. 6 KG



ENTRANCE TO THE FIGURED STRAIGHT SLIDE

• The figured straight slide entrance will be manufactured from double-walled polyethylene, with the top and both sides designed as a single piece to ensure safe passage for children to the slide.

• The figured straight slide entrance will be designed and manufactured with dimensions of 94x117 cm, with a minimum entrance width of 57 cm.

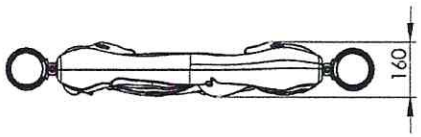
• The top of the figured straight slide entrance will be secured to the main structure using a 100 cm galvanized pipe with a diameter of Ø27 mm and a wall thickness of 2 mm, and a clamp system.

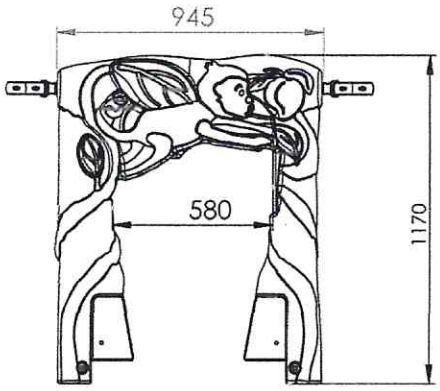
The bottom will be secured to the platform with screws. The Ø27x2 mm galvanized pipe will be passed through the polyethylene entrances as a whole.

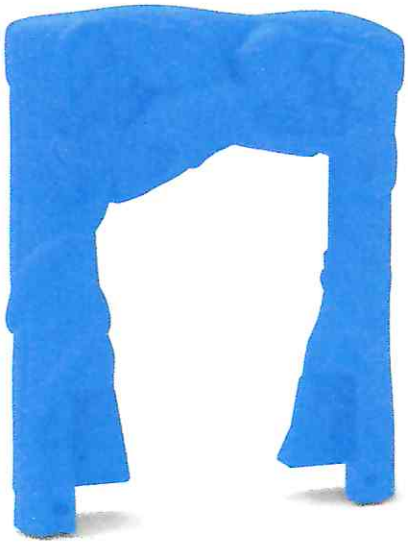
Pipes shorter than 100 cm will not be used.

• At the connection points of the pipes with the slide entrance, injection-molded, polyamide-based, self-colored plastic clamps will be used, allowing the Ø27 mm diameter galvanized pipe to pass through.

Weight: Min. 9 KG







DOG-THEMED WARNING SIGN

• Dog-shaped panels will be manufactured using rotational molding technology, double-walled, from powdered, self-colored LLDPE raw material. The dyes used will be compliant with child health and food regulations.

• Dog-shaped panels will be designed with minimum dimensions of 94x100 cm and manufactured in two parts: an outer body and an inner panel figure.

The inner panel figure will be mounted to the outer body.

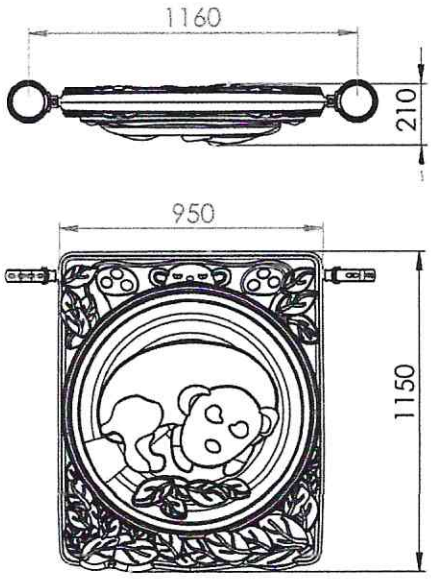
• Dog-shaped panels will be secured to the main structure from the top using a 100 cm galvanized pipe with a diameter of Ø 27 mm and a wall thickness of 2 mm, and a clamp system.

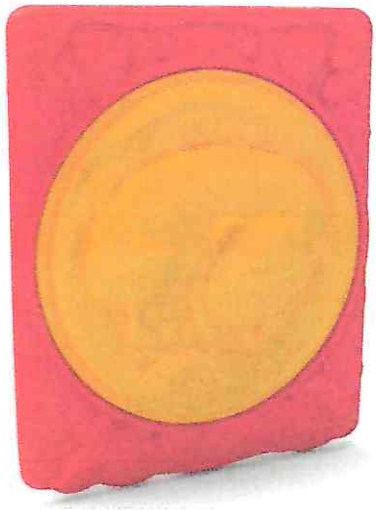
The bottom will be secured to the platform with screws. The Ø27x2 mm galvanized pipe will be passed through the polyethylene panels as a whole.

Pipes shorter than 100 cm will not be used.

• At the connection points between the pipes and the panel, injection-molded, polyamide-based, self-colored plastic clamps will be used, allowing the passage of a Ø27 mm diameter pipe.

Weight Min. 11 KG.





LINED BOARD

• The panels will be manufactured using rotational molding technology, double-walled, from powdered, self-colored LLDPE raw material. The dyes used will be compliant with child health and food regulations.

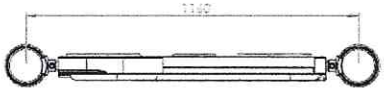
• The new generation striped panels will be designed with minimum dimensions of 93x110 cm and manufactured according to safety standards.

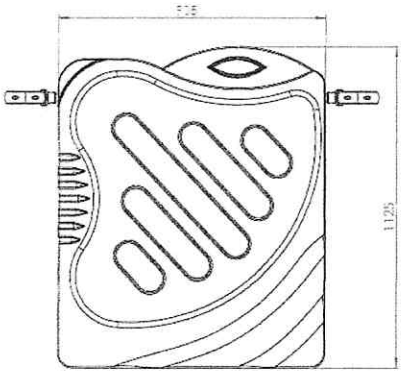
• The new generation striped panels will be secured to the main structure from the top using a 100 cm galvanized pipe with a diameter of Ø 27 mm and a wall thickness of 2 mm, and a clamp system, and to the platform from the bottom using screws.

The Ø27x2 mm galvanized pipe will be passed through the polyethylene panels as a whole. Pipes shorter than 100 cm will not be used.

• At the connection points of the pipes with the panel, injection-molded, polyamide-based, self-colored plastic clamps with a diameter of Ø27 mm will be used.

Weight: Min. 9 KG.





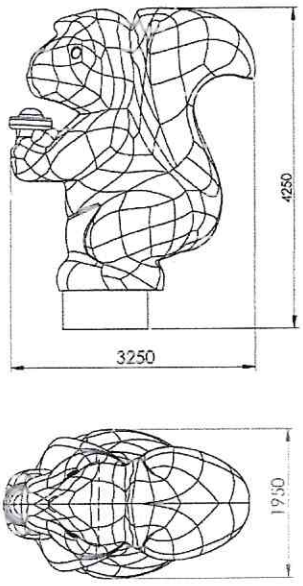
SQUIRREL FIGURE

• The squirrel figure will be secured to a Ø114 mm pipe by inserting 10 cm of it and attaching it with bolts and nuts. It will be manufactured from self-colored polyethylene, conforming to the specifications and designs, and will be positioned at a minimum height of 125 cm above the platform or standing level.

• The squirrel figure will be manufactured with a double-walled structure. • The figures will have the necessary strength and cross-sections to support the weight of children when hung from them.

• The squirrel figure will be manufactured from self-colored HDPE raw material using blow molding technology. The dyes used will be compliant with children's health and food regulations.

Weight: Min. 0.5 KG.



ECO ROOF

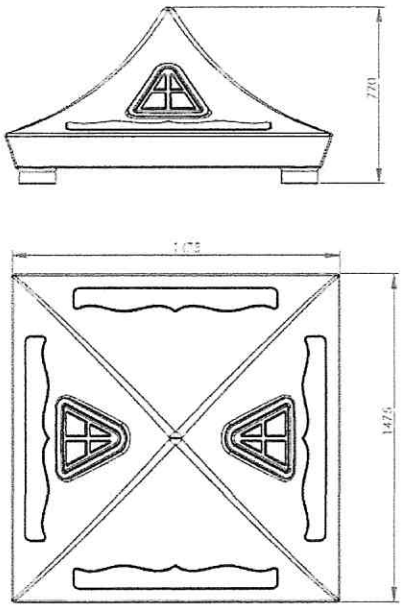
• The economical roof will have dimensions of 1475 x 1475 mm. It will be manufactured with a minimum height of 770 mm and will consist of 2 triangular sections.

• The economical roof must be directly attached to the Ø114 mm pipes that form the support pipes of the system. No separate connecting element should be used in between.

• The economical roof will be manufactured from powdered, self-colored LLDPE raw material using rotational molding technology.

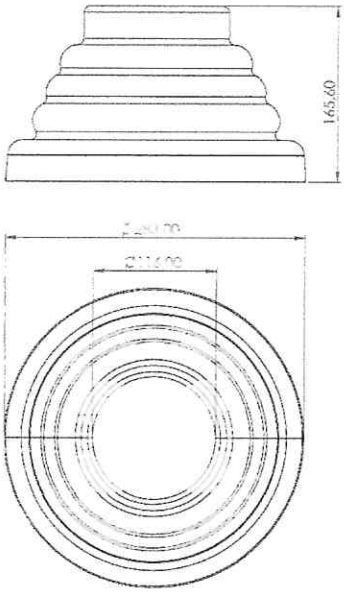
The dyes used for coloring will be suitable for children's health and comply with food regulations.

Weight: Min. 19 KG.



Ø114 MM ANCHOR COVER

• The bottom closure element, which will be produced from polyethylene material using the plastic injection method, will be made of two parts weighing a minimum of 2x300 gr. The caps have a design that completely grips the pipe, and the parts must be interlocked and assembled with connecting elements.



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IŞILTI ÇOCUK OYUN GRUPLARI PLASTİK SAN. TİC. A.Ş.
Büyükkayacıkoşb Mh. 416 Nolu Sk. No:1 Selçuklu/KONYA
Tel: +90 332 502 [illegible] E-mail: bilgi@isiltiplastik.com
Selçuk V.D. 468 058 7183 Ticaret Sicil No: 72098