

10. Addenda

10.1 The distances between collars

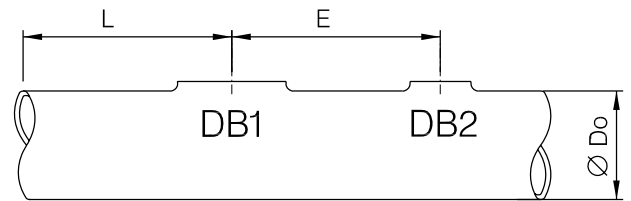
Distance from the pipe end Lmin:

$D_o \leq 40$
 $L_{min} = 32.5 \text{ mm}$

$41 \leq D_o \leq 88.9$
 $L_{min} = 125 \text{ mm}$

$88.9 < D_o < 168.3$
 $DB1 > 88.9$
When $DB1 \geq 0.8 \times D_o$
 $L_{min} = 1.5 \times DB1$, But not less than 125 mm

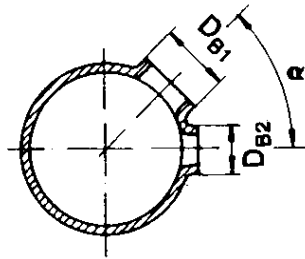
$D_o > 168.3$
 $DB1 > 88.9$
 $L_{min} = 1.5 \times DB1$
But not less than 160 mm



$\varnothing D_o$	L_{min}
<40	32.5
>40	125
>168	160

Minimum distance between collars e min:

$D_o \leq 40$ $E_{min} = 55 \text{ mm}$
 $41 \leq D_o < 168.3$ $E_{min} = 190 \text{ mm}$
 $D_o \geq 168.3$ $E_{min} = 0.5 \times (DB1 + DB2) + (0.3 \times DB1)$
 $\rightarrow E_{min}$ not less than 190mm

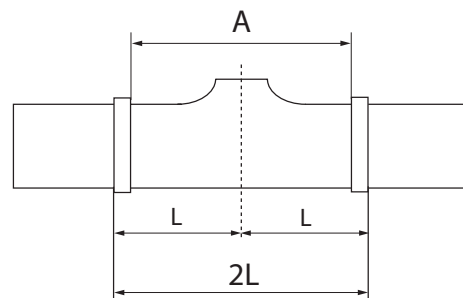


Calculation instruction for angular position:

$$\alpha \text{ min} = [(1.6 * DB1 + DB2) / D_O] * 60^\circ \quad (DB1 > DB2)$$

Minimum distance between clamps A:

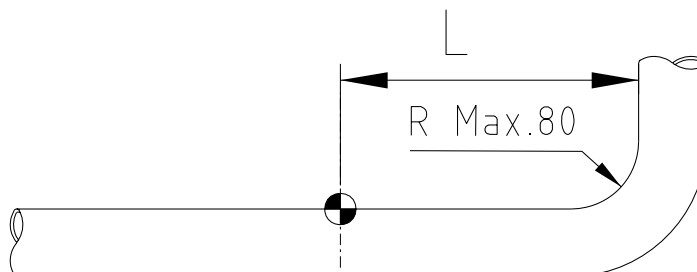
Ø	A	~2L
42	185	253
76	185	253
114	185	253
168	200	320



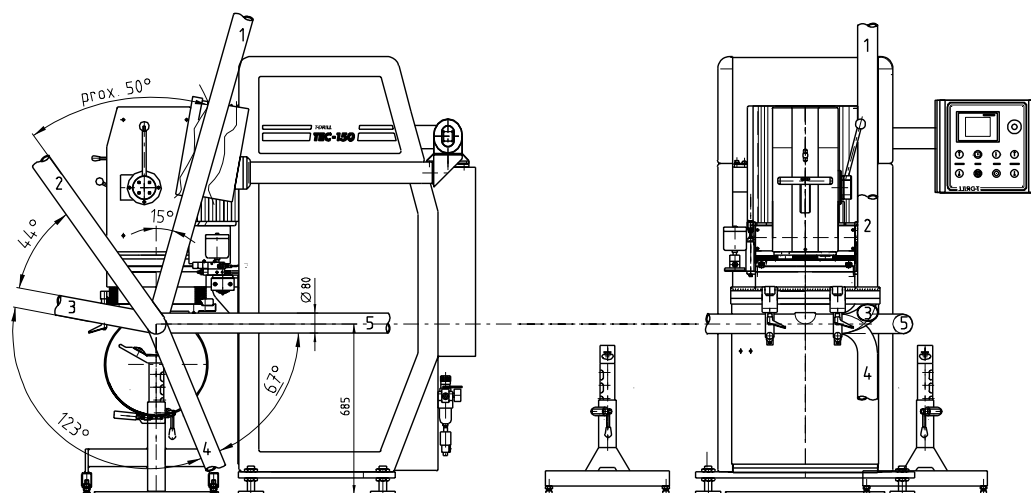
Roundness tolerance of collar (A)

When Ø of collar 21.3....114.3 mm $A = 0.010 \times \varnothing$
 141.3...168.3 mm $A = 0.015 \times \varnothing$

Minimum distance of collar in bent pipe



When $R > 80\text{mm}$, then $L + R - 80\text{mm}$ (When $R > 3,14''$ then $L + R - 3,14''$)



In cases 1 and 2 = 210mm / 8,27" in 50° sector

Between 2 and 3 = 310mm / 12,20"

In cases 3 and 4 = 210mm / 8,27", observe the length of bend tube

From 4 to 5 to 1 $L = 400\text{mm} / 15,70''$