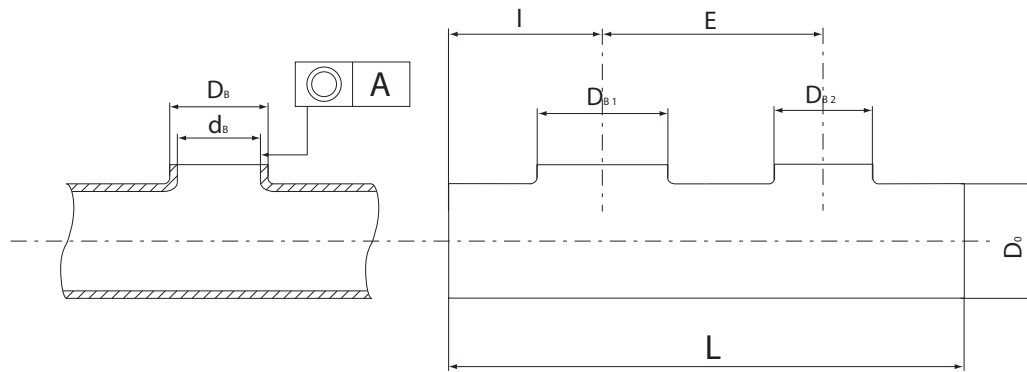


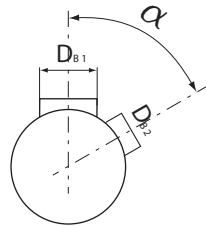
## SEC - 100 Collar positions



$$L_{\min} = 2 \times l_{\min} + (E_1 + E_2 + E_n)$$

$$\alpha_{\min} = \frac{1,6 \times D_{B1} + D_{B2}}{D_0} \times 60$$

( $D_{B1} > D_{B2}$ )



Maximum run pipe O.D. 219.1 mm ( Nominal pipe size 8 " )

Minimum run pipe O.D. 33.7 mm. ( Nominal pipe size 1 " )

Collar sizes:

Collar roundness  $A = 0.015 \times D_B$

Minimum distance from pipe end to collar =  $l_{\min}$  and minimum distance between collars =  $e_{\min}$  when using SEC -100 standard clamps.

Do l mm	$l_{\min}$ ln mm	$E_{\min}$ ln mm
30 - 35	75	$0.7 * D_{B1} + 75$
35.1 - 40	77.5	$0.7 * D_{B1} + 77.5$
40.1 - 45	80	$0.7 * D_{B1} + 80$
45.1 - 50	82.5	$0.7 * D_{B1} + 82.5$
50.1 - 55	85	$0.7 * D_{B1} + 85$
55.1 - 60	87.5	$0.7 * D_{B1} + 87.5$
60.1 - 65	90	$0.7 * D_{B1} + 90$
65.1 - 70	92.5	$0.7 * D_{B1} + 92.5$
70.1 - 75	95	$0.7 * D_{B1} + 95$
75.1 - 80	97.5	$0.7 * D_{B1} + 97.5$
80.1 - 85	100	$0.7 * D_{B1} + 100$
85.1 - 90	102.5	$0.7 * D_{B1} + 102.5$
90.1 - 95	105	$0.7 * D_{B1} + 105$
95.1 - 100	107.5	$0.7 * D_{B1} + 107.5$
100.1 - 105	110	$0.7 * D_{B1} + 110$
105.1 - 110	112.5	$0.7 * D_{B1} + 112.5$
110.1 - 219.1	115	$0.7 * D_{B1} + 115$

When  $D_B > 40$  mm and  $D_O \geq 0.9 * D_B$      $l_{\min} = 1.5 * D_B$