



30° straight branch pieces, 2 and 3 mm

Diameter for 2 mm: $\phi 100 - \phi 1000$ mm.

Diameter for 3 mm: $\phi 150 - \phi 1000$ mm.

Straight branch pieces are welded and made of 2.00 and 3.00 mm sheet metal (s). Straight branch pieces with $A = C \leq 600$ mm are supplied for assembly with pull rings [f.b] and for $A = C \geq 630$ mm with flanges [m.fl].

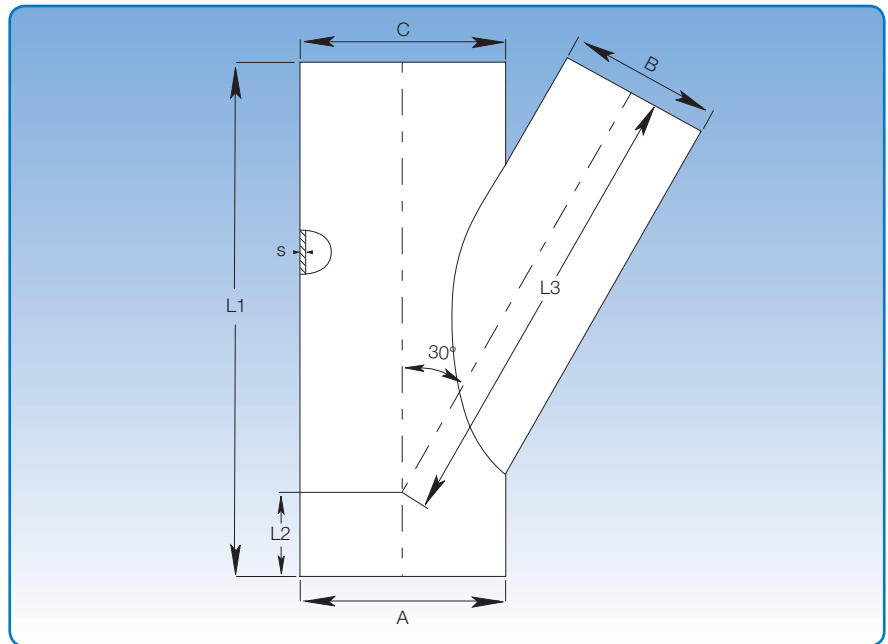
When assembled with loose flanges, [f.b.m.fl], and flanges [m.fl] L1 is extended by 2×50 mm.

State A-, B- and C dimensions when ordering. Options are limited by $A = C$, and $A \geq B$.

The branch determines the length of L1. Branch pieces are always straight with the branch centrally located.

L1, L2 and L3 can be calculated using the stated formulas.

For double branch pieces, the highest value of dim. B determines L1 on the common branch. L2 and L3 can then be calculated for both branches. Normally, the branches are opposite each other.



Calculating L2 and L3:

L1 = see table

$$L2 = \frac{L1}{2} - \left(\frac{A}{2 \times \tan 30^\circ} \right)$$

$$L3 = \frac{L1 - L2}{\cos 30^\circ} - \left(\frac{B}{2} \times \tan 30^\circ \right)$$

Example:

$A = B = C = 450$

$L1 = 1250$ mm

$$L2 = \frac{1250}{2} - \left(\frac{450}{\tan 30^\circ} \right) = 625 - 389,71$$

$L2 = 235,29 \sim 235$ mm

$$L3 = \frac{1250 - 235}{\cos 30^\circ} - \left(\frac{450}{2} \times \tan 30^\circ \right) = 1172,06 - 129,92$$

$L3 = 1042,14 \sim 1042$ mm

Dimensions				
A = C mm	B mm	L1 mm	L2 mm	L3 mm
Select (100 - 1000)	80	350	Calculate	Calculate
	100	350		
	120	350		
	125	400		
	140	450		
	150	450		
	160	450		
	180	550		
	200	550		
	225	600		
	250	750		
	275	750		
	300	750		
	315	850		
	350	950		
	400	1050		
	450	1250		
	500	1250		
	550	1450		
	600	1450		
650	1650			
700	1650			
750	1850			
800	1850			
850	2050			
900	2050			



30° conical branch pieces, 2 and 3 mm

Diameter A for 2 mm: $\phi 120 - \phi 1000$ mm.
Diameter A for 3 mm: $\phi 150 - \phi 1000$ mm.

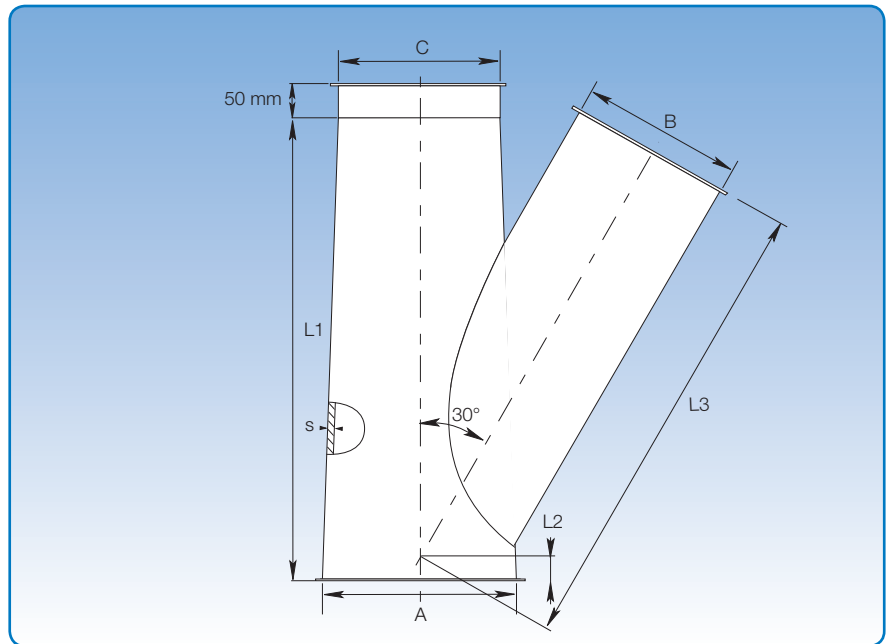
Conical branch pieces are welded and made of 2.00 and 3.00 mm sheet metal (s). Conical branch pieces with $A \leq 600$ mm are supplied for assembly with pull rings [f.b] and for $A \geq 630$ mm with flanges [m.fl].

L1 is extended by a 50 mm welding end at dimension C if the branch piece is supplied with flanges [m.fl], loose flanges [f.b.m.fl] or rapid lock pull rings [f.lyn].

State branch piece A-, B- and C dimensions when ordering. A, B and C can be combined to order; although branch B determines length L1 as stated in the table.

Maximum difference between diameter A and C is 100 mm. For B applies:
 $B < (A+C)/2$.

The highest value of dimension B determines L1 on the common stem for double branch pieces. L2 and L3 can then be calculated for both branches. Normally, the branches are opposite each other.



Calculating L2 and L3:

L1 = See table

$$L2 = \left(\frac{L1}{2} \right) - \left(\frac{A+C}{4 \times \tan 30^\circ} \right)$$

$$L3 = \left(\frac{L1-L2}{\cos 30^\circ} \right) - \left(\frac{B}{2} \times \tan 30^\circ \right)$$

Example:

A = 500, B = 300, C = 400

L1 = 750 mm

$$L2 = \frac{750}{2} - \frac{500+400}{4 \times \tan 30^\circ} = 375 - 389,71$$

L2 = -14,71 ~ -15 mm

$$L3 = \frac{750 - 15}{\cos 30^\circ} - \left(\frac{300}{2} \times \tan 30^\circ \right) = 848,70 - 86,61$$

L3 = 762,1 ~ 762 mm

Dimensions					
A mm	B mm	C mm	L1 mm	L2 mm	L3 mm
Select (100 - 1000)	80	Select (100 - 1000)	350	Calculate	Calculate
	100		350		
	120		350		
	125		400		
	140		450		
	150		450		
	160		450		
	180		550		
	200		550		
	225		600		
	250		750		
	275		750		
	300		750		
	315		850		
	350		950		
	400		1050		
	450		1250		
	500		1250		
	550		1250		
	600		1450		
650	1650				
700	1650				
750	1850				
800	1850				
850	2050				
900	2050				