

Laser welded and longitudinally lock formed ducts, galvanised

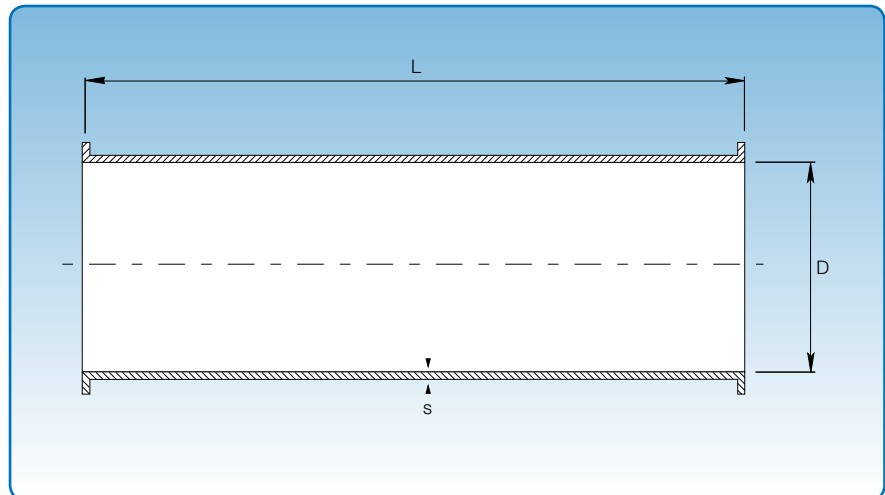
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Diameter: $\varnothing 80 - \varnothing 1000$ mm.

JKF's laser welded and longitudinally lock formed ducts are galvanised and made from 0,75 mm, 0,90 mm or 1,00 mm galvanised sheet (s).

The ducts are made to order in other qualities and dimensions.

Ducts with a diameter of up to $\varnothing 400$ mm are, as standard, supplied as laser welded ducts in lengths of 0,5 m, 1,0 m and 2,0 m. Ducts with a diameter of $\varnothing 450$ mm are supplied lock formed in standard lengths of 0,5 m, 1,0 m and 2,0 m. Ducts with dimensions other than those specified in the table are always supplied lock formed.

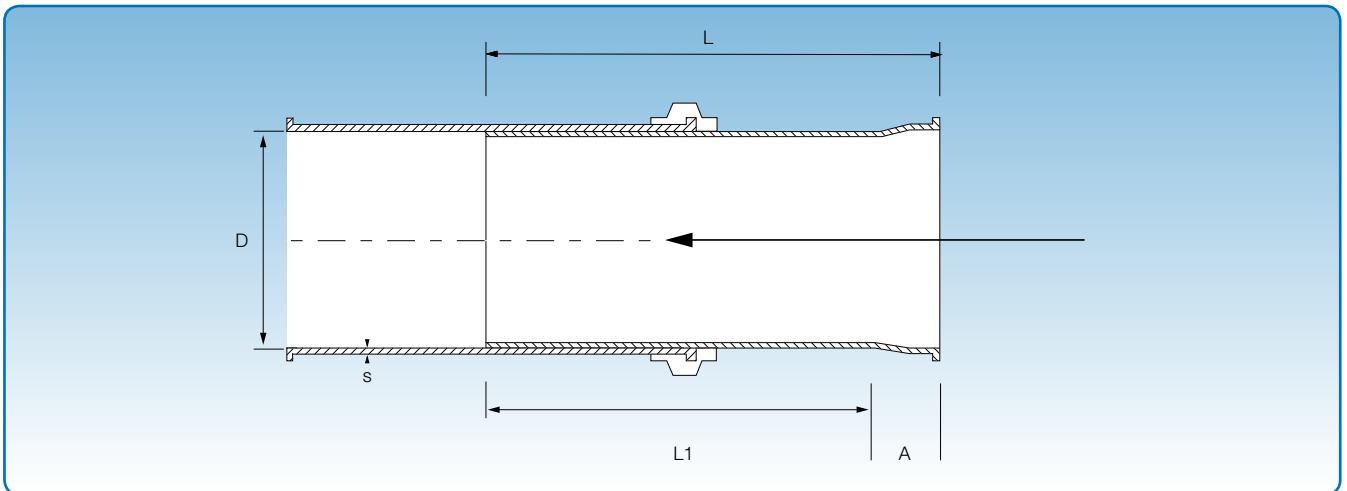


Dimensional specifications are given in the table below.

Dimensional specifications				
D mm	s mm	Weight L = 0,5 m kg	Weight L = 1,0 m kg	Weight L = 2,0 m kg
Laser welded				
80	0,75	0,80	1,60	3,20
100	0,75	1,00	2,00	4,00
120	0,75	1,20	2,40	4,80
125	0,75	1,25	2,50	5,00
140	0,75	1,40	2,80	5,60
150	0,75	1,50	3,00	6,00
160	0,75	1,60	3,20	6,40
180	0,75	1,75	3,50	7,00
200	0,75	2,00	4,00	8,00
225	0,75	2,25	4,50	9,00
250	0,75	2,50	5,00	10,00
275	0,75	2,75	5,50	11,00
300	0,75	2,85	5,70	11,40
315	0,75	3,00	6,00	12,00
350	0,75	3,25	6,50	13,00
400	0,90	4,50	9,00	18,00
Lock formed				
450	0,90	5,15	10,30	20,60
500	0,90	5,70	11,40	22,80
550	0,90	6,25	12,50	25,00
600	0,90	6,80	13,60	27,20
630	0,90	7,20	14,40	28,80
650	0,90	7,50	15,00	30,00
700	0,90	8,00	16,00	32,00
750	0,90	8,50	17,00	34,00
800	1,00	10,00	20,00	40,00
850	1,00	10,75	21,50	43,00
900	1,00	11,50	23,00	46,00
950	1,00	12,25	24,50	49,00
1000	1,00	13,00	26,00	52,00

Telescopic ducts, galvanised

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Dimensional specifications are given in the table below.

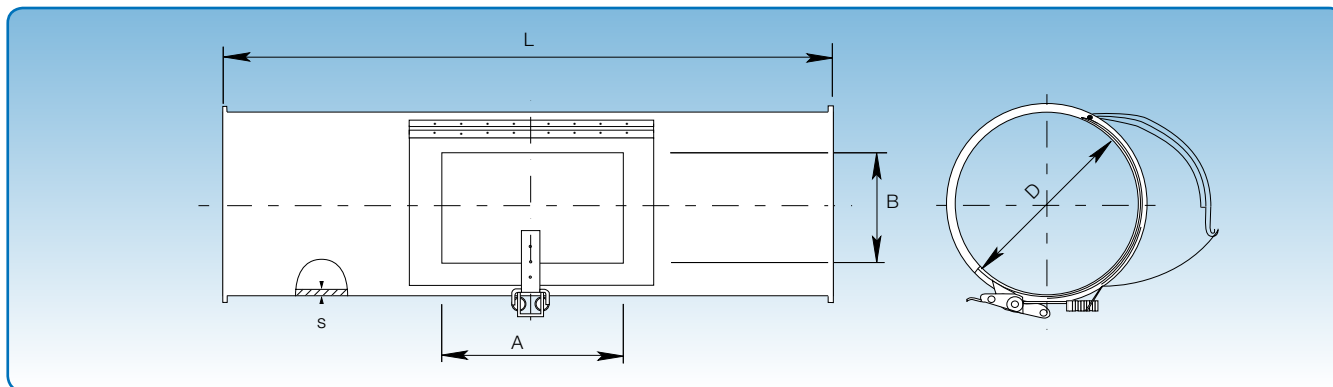
Diameter: $\varnothing 100 - \varnothing 300$ mm.

JKF's telescopic ducts are made from 0,90 mm galvanised sheet (s) and supplied with rapid lock pull rings with rubber insert.

Dimensional specifications						
D mm	s mm	L mm	A mm	L1 mm	Weight kg	
100	0,90	500	50	450	0,9	
120	0,90	500	50	450	1,1	
125	0,90	500	50	450	1,2	
140	0,90	500	50	450	1,3	
150	0,90	500	50	450	1,4	
160	0,90	500	50	450	1,5	
180	0,90	500	50	450	1,7	
200	0,90	500	50	450	1,9	
225	0,90	500	50	450	2,1	
250	0,90	500	50	450	2,3	
275	0,90	500	50	450	2,5	
300	0,90	500	50	450	2,8	

Ducts with access door, galvanised

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Dimensional specifications are given in the table below.

Diameter: $\varnothing 80 - \varnothing 1000$ mm.

JKF's standard programme comprises 0,90 mm and 1,00 mm galvanised ducts with access door.

The access door is made from 1,25 mm galvanised sheet so that the inner side is smooth and the door can be tightly closed.

Dimensional specifications				
D mm	s mm	L mm	B x A	Weight kg
80	0,90	500	80 x 150	0,80
100	0,90	500	100 x 150	1,00
120	0,90	500	100 x 150	1,20
125	0,90	500	100 x 150	1,25
140	0,90	500	100 x 150	1,40
150	0,90	500	100 x 150	1,50
160	0,90	500	100 x 150	1,60
180	0,90	500	100 x 150	1,75
200	0,90	500	100 x 150	2,00
225	0,90	500	100 x 150	2,25
250	0,90	500	100 x 150	2,50
300	0,90	500	100 x 150	2,85
315	0,90	500	100 x 150	3,00
350	0,90	500	150 x 200	3,25
400	0,90	500	150 x 200	4,50
450	0,90	500	150 x 200	5,15
500	0,90	500	150 x 200	5,70
550	0,90	500	150 x 200	6,25
600	0,90	500	150 x 200	6,80
630	0,90	500	150 x 200	7,20
650	0,90	500	150 x 200	7,50
700	0,90	500	150 x 200	8,00
750	0,90	500	150 x 200	8,50
800	1,00	500	150 x 200	10,00
850	1,00	500	150 x 200	10,75
900	1,00	500	150 x 200	11,50
950	1,00	500	150 x 200	12,25
1000	1,00	500	150 x 200	13,00

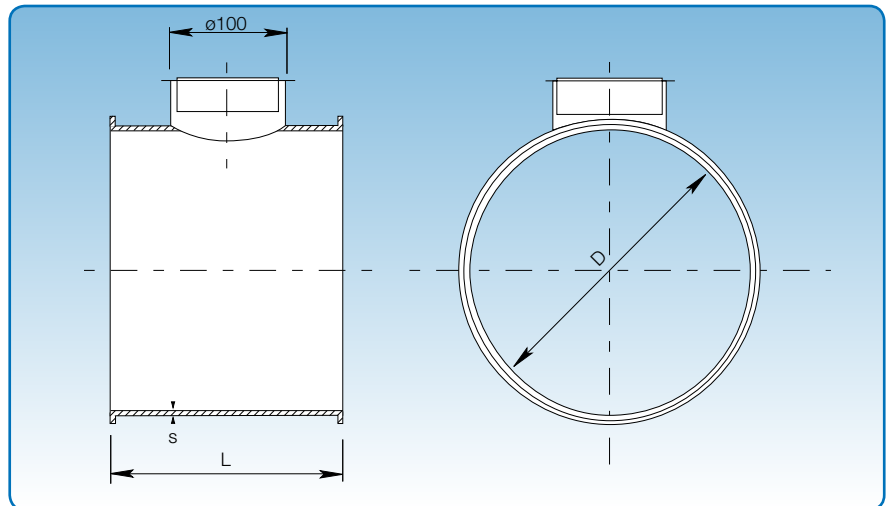
Ducts with cleaning spigot, galvanised

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Diameter: $\varnothing 100 - \varnothing 1000$ mm.

JKF's standard programme comprises 0,90 mm and 1,00 mm galvanised ducts with cleaning spigot.

The PVC cover is easily mounted and dis-mounted. All cleaning spigots are made with a $\varnothing 100$ mm opening.



Dimensional specifications are given in the table below.

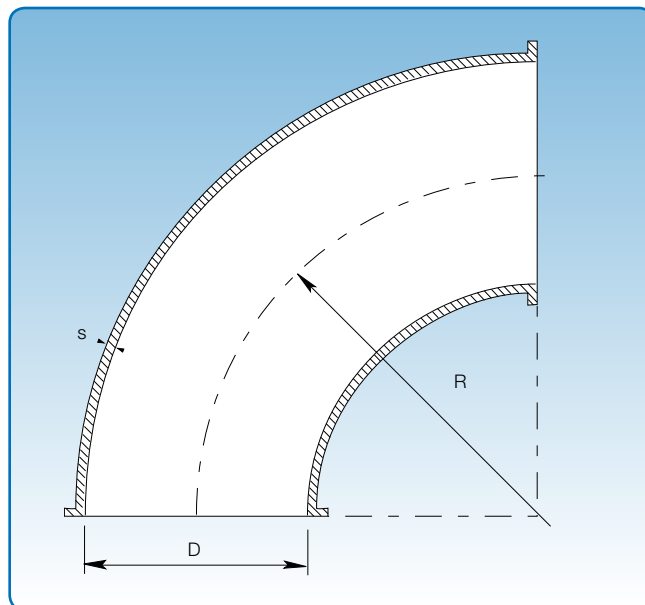
Dimensional specifications			
D mm	s mm	L mm	Weight kg
100	0,90	250	1,00
120	0,90	250	1,20
125	0,90	250	1,25
140	0,90	250	1,40
150	0,90	250	1,50
160	0,90	250	1,60
180	0,90	250	1,75
200	0,90	250	2,00
225	0,90	250	2,25
250	0,90	250	2,50
300	0,90	250	2,85
315	0,90	250	3,00
350	0,90	250	3,25
400	0,90	250	4,50
450	0,90	250	5,15
500	0,90	250	5,70
550	0,90	250	6,25
600	0,90	250	6,80
630	0,90	250	7,20
650	0,90	250	7,50
700	0,90	250	8,00
750	0,90	250	8,50
800	1,00	250	10,00
850	1,00	250	10,75
900	1,00	250	11,50
950	1,00	250	12,25
1000	1,00	250	13,00

Pressed bends, galvanised

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Diameter: $\varnothing 80 - \varnothing 400$ mm.

JKF's galvanised bends are pressed and made from 1,00 mm galvanised sheet (s). The pressed bend reduces both pressure loss and wear.



Dimensional specifications are given in the table below. Diameter = (D).
 Sheet thickness = (s). $R = 1,5 \times D$ for all dimensions.

Dimensional specifications							
D mm	s mm	Weight 90° kg	Weight 60° kg	Weight 45° kg	Weight 30° kg	Weight 15° kg	Weight 7,5° kg
80	1,00	0,40	0,30	0,20	0,15	0,08	0,05
100	1,00	0,50	0,40	0,25	0,20	0,10	0,08
120	1,00	0,80	0,60	0,40	0,30	0,15	0,10
125	1,00	0,90	0,65	0,45	0,35	0,17	0,12
140	1,00	1,10	0,80	0,55	0,40	0,20	0,15
150	1,00	1,20	0,90	0,60	0,50	0,25	0,20
160	1,00	1,50	1,20	0,75	0,60	0,30	0,25
180	1,00	2,00	1,50	1,00	0,80	0,40	0,30
200	1,00	2,50	1,85	1,25	1,00	0,50	0,35
225	1,00	3,20	2,40	1,60	1,20	0,60	0,37
250	1,00	4,00	3,00	2,00	1,50	0,75	0,40
275	1,00	4,80	3,60	2,40	1,80	0,90	0,43
300	1,00	5,50	4,10	2,75	2,05	1,00	0,50
315	1,00	5,90	4,50	2,95	2,25	1,12	0,55
350	1,00	6,80	5,10	3,40	2,55	1,30	0,65
400	1,00	9,50	7,10	4,75	3,60	1,80	0,90

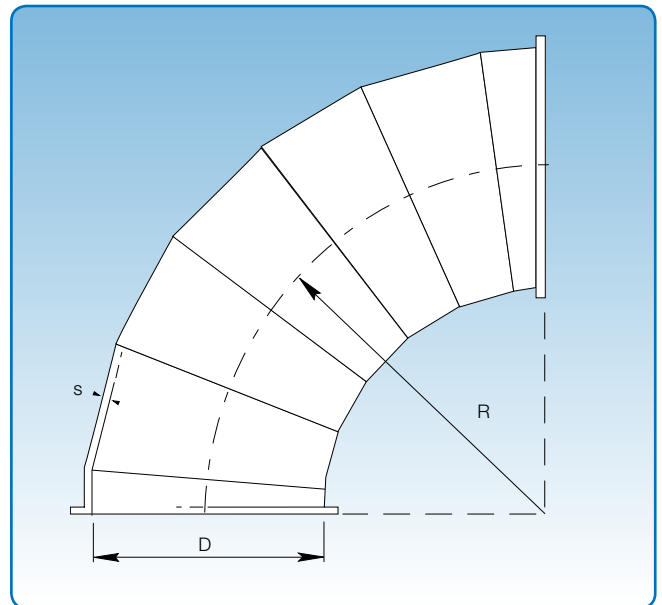
Segment bends, galvanised

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Diameter: $\varnothing 450 - \varnothing 1000$ mm.

JKF's galvanised segment bends are made from 0,90 mm and 1,00 mm galvanised sheet (s).

The segment bends are made to order in other radii and dimensions.



Dimensional specifications are given in the table below.
 $R = 1,5 \times D$ for all dimensions.

Dimensional specifications							
D mm	s mm	Weight 90° kg	Weight 60° kg	Weight 45° kg	Weight 30° kg	Weight 15° kg	Weight 7,5° kg
450	0,90	12,00	9,00	6,00	4,50	2,25	1,10
500	0,90	15,00	11,20	7,50	5,60	2,80	1,40
550	0,90	18,00	13,50	9,00	6,80	3,40	1,70
600	0,90	21,50	16,10	10,75	8,05	4,00	2,00
630	0,90	22,40	16,80	11,20	8,40	4,20	2,10
650	0,90	25,00	18,80	12,50	9,40	4,70	2,35
700	0,90	29,00	21,80	14,50	10,90	5,40	2,70
750	0,90	33,00	24,80	16,50	12,40	6,20	3,10
800	1,00	37,50	28,10	18,75	14,05	7,00	3,50
850	1,00	42,50	32,00	21,25	16,00	8,00	4,00
900	1,00	48,00	36,00	24,00	18,00	9,00	4,50
950	1,00	53,00	39,80	26,50	20,00	10,00	5,00
1000	1,00	59,00	44,00	29,50	22,00	11,00	5,50

30° straight branch pieces, galvanised

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

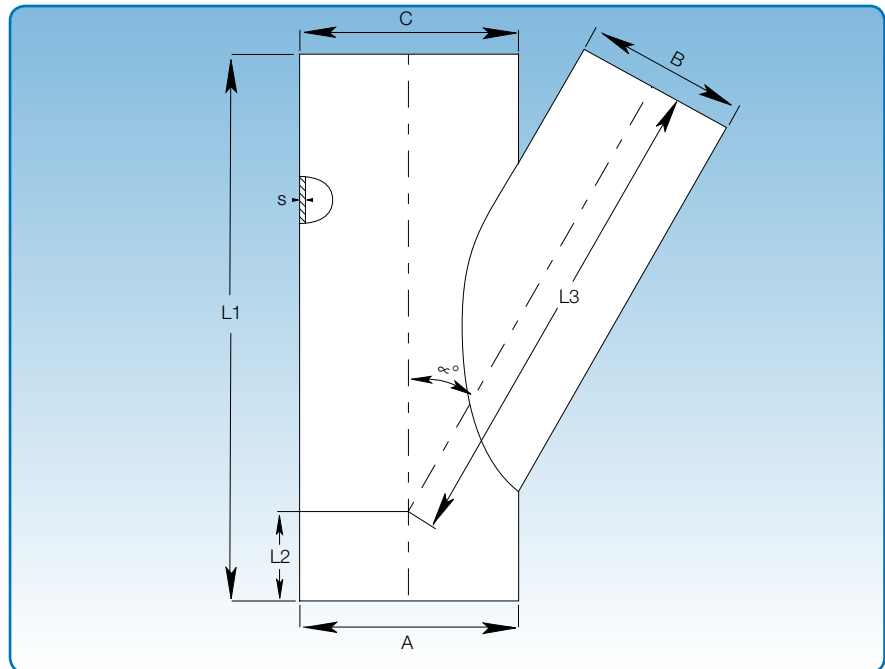
JKF's galvanised branch pieces are made from 0,90 mm galvanised sheet (s).

When assembling with loose flanges [f.b.m.fl] and with flanges [m.fl], L1 is increased by 2 x 50 mm.

When placing an order, the measurements for A, B and C must be stated. Please note that the options are restricted by the fact that A = C and A > B.

The branch determines the length L1.
 The branch pieces can only be fitted to straight ducts with the branch placed centrally.

L1, L2 and L3 can be calculated by means of the formulas below.



Calculation:

L1 = See table

$$L2 = \frac{1}{2} - \left(L1 - \frac{A}{\tan \alpha} \right)$$

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

Example:

A = 650, B = 650, C = 400

L1 = 1050 mm

$$L2 = 0,5 - \left(1050 - \frac{650}{\tan 29,7} \right) = 0,5 - (1050 - 1139,57)$$

L2 = 90,07 ~ 90 mm

$$L3 = \frac{1050 - 90}{\cos 29,7} - \left(\frac{650}{2} \times \tan 29,7 \right) = 1105,19 - 185,38$$

L3 = 919,81 ~ 920 mm

Dimensional specifications

A=C mm	B mm	L1 mm	L2 mm	L3 mm	α°	s mm
	80	350			28,0	0,90
	100	350			28,8	0,90
	120	350			28,8	0,90
	125	400			29,0	0,90
	140	450			29,1	0,90
	150	450			29,2	0,90
	160	450			29,2	0,90
	180	550			29,3	0,90
	200	550			29,3	0,90
	225	600			29,4	0,90
	250	750			29,5	0,90
	275	750			29,6	0,90
	300	750			29,6	0,90
	315	850			29,6	0,90
	350	950			29,6	0,90
	400	1050			29,7	0,90
	450	1250			29,7	0,90
	500	1250			29,7	0,90
	550	1250			29,8	0,90
	600	1450			29,8	0,90
	630	1650			29,8	0,90
	650	1650			29,8	0,90
	700	1650			29,8	0,90
	750	1850			29,9	0,90
	800	1850			29,9	0,90
	850	2050			29,9	0,90
	900	2050			29,9	0,90
Choose (100 - 1000)			Calculated	Calculated		

45° straight branch pieces, galvanised

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Diameter: ø100 – ø1000 mm.

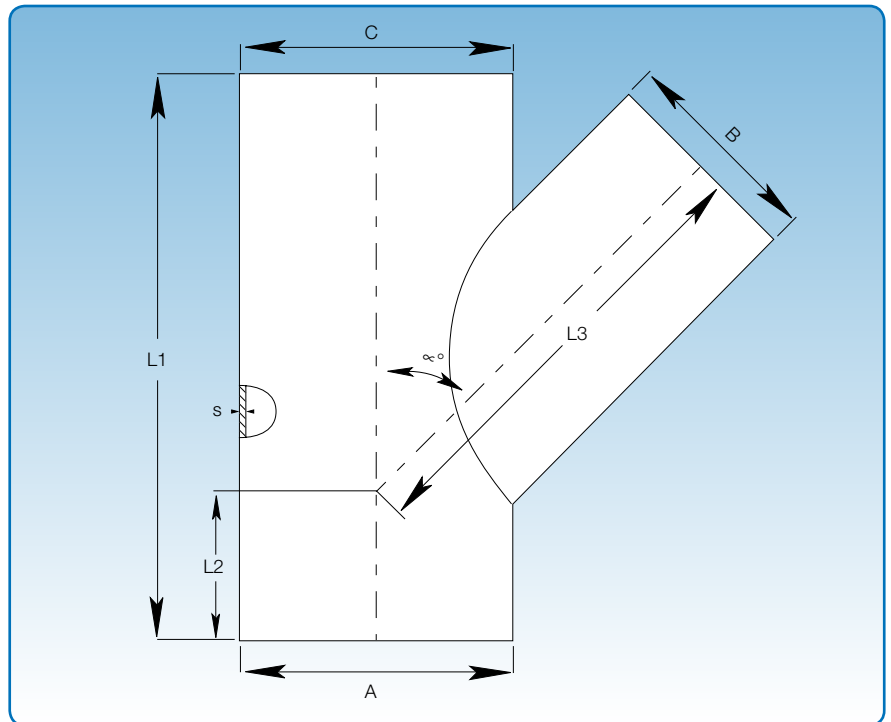
JKF's galvanised branch pieces are made from 0,90 mm galvanised sheet (s).

When assembling with loose flanges [f.b.m.fl] and with flanges [m.fl], L1 is increased by 2 x 50 mm.

When placing an order, the measurements for A, B and C must be stated. Please note that the options are restricted by the fact that A = C and A > B.

The branch determines the length L1.
 The branch pieces can only be fitted to straight ducts with the branch placed centrally.

L1, L2 and L3 can be calculated by means of the formulas below.



Calculation:

L1 = See table

$$L2 = \frac{1}{2} - \left(L1 - \frac{A}{\tan \alpha} \right)$$

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

Example:

A = 500, B = 500, C = 450

L1 = 950 mm

$$L2 = 0,5 - \left(950 - \frac{500}{\tan 44,7} \right) = 0,5 - (950 - 505,26)$$

L2 = -444,24 ~ -444 mm

$$L3 = \frac{950 + 444}{\cos 44,7} - \left(\frac{500}{2} \times \tan 44,7 \right) = 1961,17 - 247,40$$

L3 = 1713,77 ~ 1714 mm

Dimensional specifications

A=C mm	B mm	L1 mm	L2 mm	L3 mm	α°	s mm
	80	300			43,8	0,90
	100	300			43,8	0,90
	120	350			44,0	0,90
	125	350			44,0	0,90
	140	350			44,1	0,90
	150	400			44,2	0,90
	160	400			44,2	0,90
	180	400			44,3	0,90
	200	450			44,4	0,90
	225	500			44,5	0,90
	250	500			44,5	0,90
	275	600	Calculated	Calculated	44,6	0,90
Choose (100 - 1000)	300	600			44,6	0,90
	315	600			44,6	0,90
	350	700			44,7	0,90
	400	800			44,7	0,90
	450	950			44,7	0,90
	500	1050			44,8	0,90
	550	1150			44,8	0,90
	600	1150			44,8	0,90
	630	1150			44,8	0,90
	650	1150	44,8	0,90		
	700	1300	44,8	0,90		
	750	1300	44,8	0,90		
	800	1450	44,8	0,90		
	850	1450	44,9	0,90		
	900	1650	44,9	0,90		

30° conical branch pieces, galvanised

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Diameter A: $\varnothing 100 - \varnothing 1000$ mm.

JKF's galvanised branch pieces are made from 0,90 mm galvanised sheet (s).

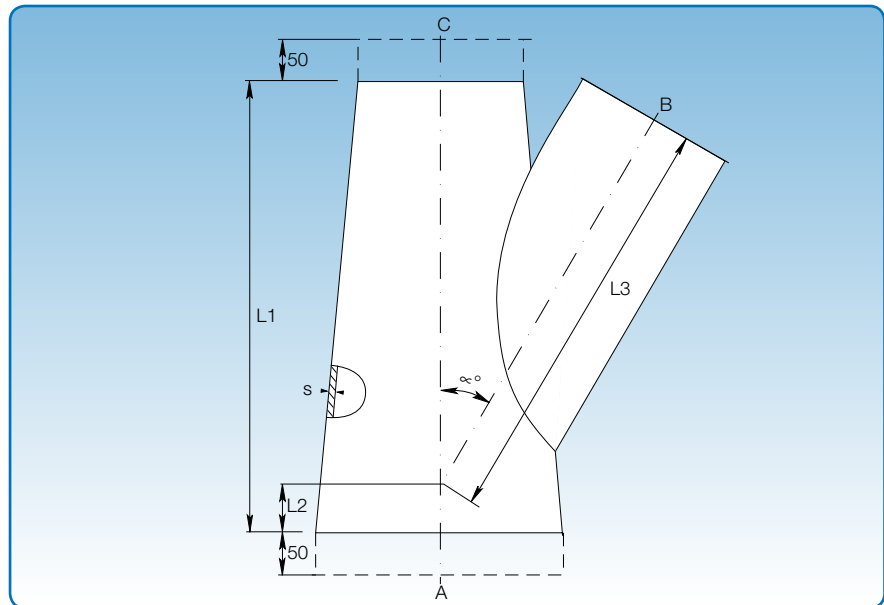
When the branch pieces are supplied with loose flanges [f.b.m.fl], L1 is increased by 2 x 50 mm as seen from the sketch opposite.

When the conical branch pieces (A - C) are ordered for assembly with rapid lock pull rings [f.lyn] and wide pull rings [f.bb], L1 is also increased by 2 x 50 mm.

When placing an order, the measurements for A, B and C must be stated. A, B and C are combined according to your requirements. The branch B, however, determines L1, as seen from the table below.

The maximum diameter reduction between A and C is 200 mm. B must, however, not be larger than or equal to (A+C)/2.

In the case of double branch pieces, the largest branch determines the length L1.



Calculation of L1, L2 and L3:

L1 = See table

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

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

Example:

A = 650, B = 500, C = 450

L1 = 1250 mm

$$L2 = \frac{1250}{2} - \left(\frac{650 + 450}{4 \times \tan 29,7} \right) = 625 - 482,13$$

L2 = 182,87 ~ 183 mm

$$L3 = \frac{1250 - 183}{\cos 29,7} - \left(\frac{500}{2} \times \tan 29,7 \right) = 1228,37 - 142,60$$

L3 = 1085,77 ~ 1086 mm

Dimensional specifications

A mm	B mm	C mm	L1 mm	L2 mm	L3 mm	α°	s mm
	80		350			28,0	0,90
	100		350			28,8	0,90
	120		350			28,8	0,90
	125		400			29,0	0,90
	140		450			29,1	0,90
	150		450			29,2	0,90
	160		450			29,2	0,90
	180		550			29,3	0,90
	200		550			29,3	0,90
Choose (100 - 1000)	225	Choose (100 - 1000)	600	Calculated	Calculated	29,4	0,90
	250		750			29,5	0,90
	275		750			29,6	0,90
	300		750			29,6	0,90
	315		850			29,6	0,90
	350		950			29,6	0,90
	400		1050			29,7	0,90
	450		1250			29,7	0,90
	500		1250			29,7	0,90
	550		1250			29,8	0,90
600	1450	29,8	0,90				
630	1650	29,8	0,90				
650	1650	29,8	0,90				
700	1650	29,8	0,90				
750	1850	29,9	0,90				
800	1850	29,9	0,90				
850	2050	29,9	0,90				
900	2050	29,9	0,90				

45° conical branch pieces, galvanised

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Diameter A: ø100 – ø1000 mm.

JKF's galvanised branch pieces are made from 0,90 mm galvanised sheet (s).

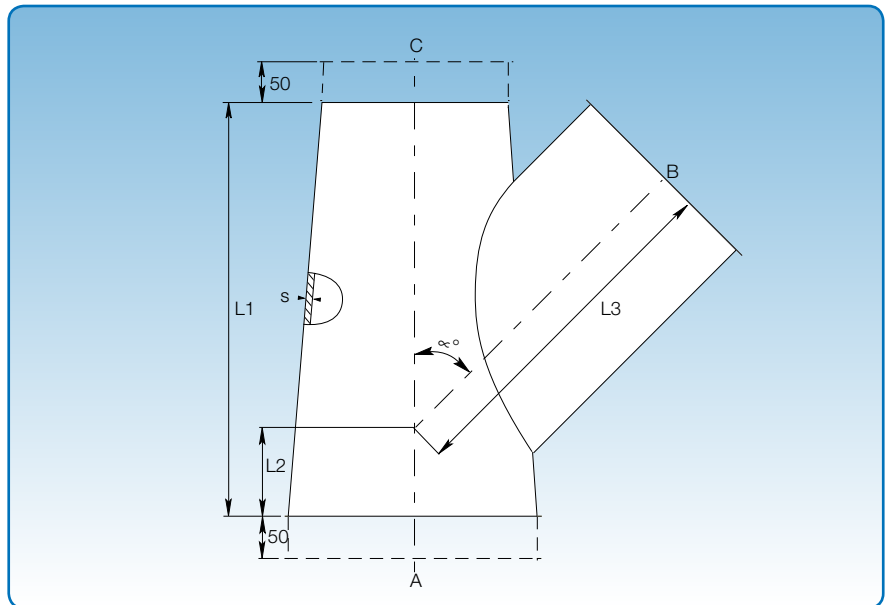
When the branch pieces are supplied with loose flanges [f.b.m.fl], L1 is increased by 2 x 50 mm as seen from the sketch opposite.

When the conical branch pieces (A – C) are ordered for assembly with rapid lock pull rings [f.lyn] and wide pull rings [f.bb], L1 is also increased by 2 x 50 mm.

When placing an order, the measurements for A, B and C must be stated. A, B and C are combined according to your requirements. The branch B, however, determines L1, as seen from the table below.

The maximum diameter reduction between A and C is 200 mm. B must, however, not be larger than or equal to (A+C)/2.

In the case of double branch pieces, the largest branch determines the length L1.



Dimensional specifications

A mm	B mm	C mm	L1 mm	L2 mm	L3 mm	α°	s mm
	80		300			43,8	0,90
	100		300			43,8	0,90
	120		350			44,0	0,90
	125		350			44,0	0,90
	140		350			44,1	0,90
	150		400			44,2	0,90
	160		400			44,2	0,90
	180		400			44,3	0,90
	200		450			44,4	0,90
Choose (100 - 1000)	225	Choose (100 - 1000)	500			44,5	0,90
	250		500			44,5	0,90
	275		600	Calculated	Calculated	44,6	0,90
	300		600			44,6	0,90
	315		600			44,6	0,90
	350		700			44,7	0,90
	400		800			44,7	0,90
	450		950			44,7	0,90
	500		1050			44,8	0,90
	550		1150			44,8	0,90
600	1150			44,8	0,90		
630	1150			44,8	0,90		
650	1150			44,8	0,90		
700	1300			44,8	0,90		
750	1300			44,8	0,90		
800	1450			44,9	0,90		
850	1450			44,9	0,90		
900	1650			44,9	0,90		

Calculation of L1, L2 and L3:

L1 = See table

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

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

Example:

A = 500, B = 300, C = 350

L1 = 600 mm

$$L2 = \frac{600}{2} - \left(\frac{500 + 350}{4 \times \text{tg } 44,6} \right) = 300 - 215,49$$

L2 = 84,51 ~ 85 mm

$$L3 = \frac{600 - 85}{\cos 44,6} - \left(\frac{300}{2} \times \text{tg } 44,6 \right) = 723,29 - 147,92$$

L3 = 575,37 ~ 575 mm

30° branch plates, galvanised

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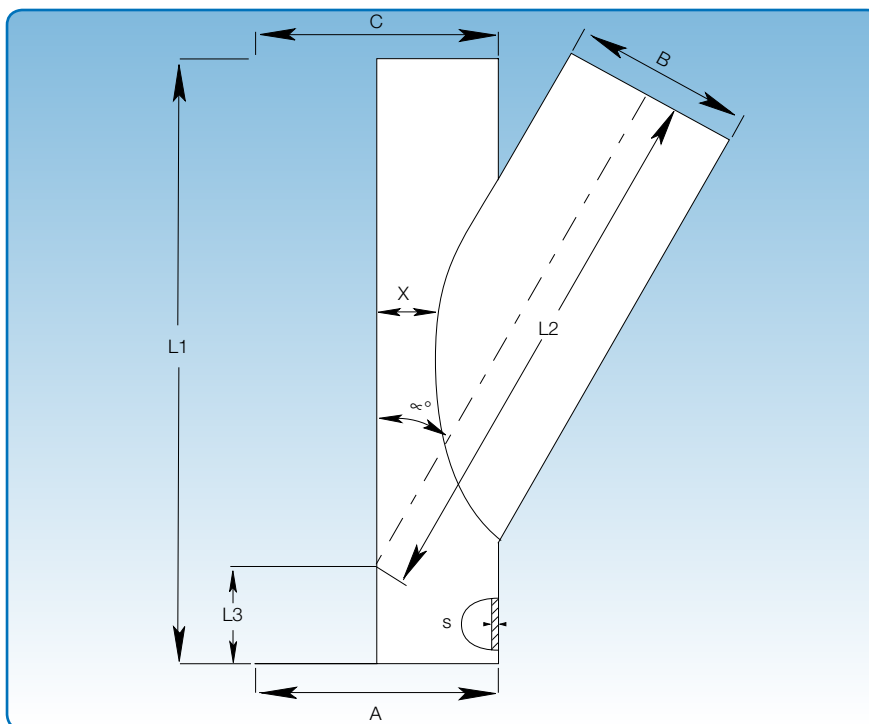
Diameter: ø80 – ø1000 mm.

JKF's galvanised branch plates are made from 0,90 mm galvanised sheet (s).

When placing an order, the measurements for A, B and C must be stated. Please note that the options are restricted by the fact that A = C and A > B.

The branch determines the length L1.
 The branch plates can only be fitted to straight ducts with the branch placed centrally on the plate.

If B < 300: X = 50 mm
 If B > 300: X = 100 mm



Calculation:

L1 = See table

$$L2 = \frac{1}{2} - \left(L1 - \frac{A}{\tan \alpha} \right)$$

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

Example:

A = 700, B = 350, C = 700

L1 = 950 mm

$$L2 = 0,5 - \left(950 - \frac{700}{\tan 29,6} \right) = 0,5 - (950 - 1332,22)$$

L2 = 382,72 ~ 383 mm

$$L3 = \frac{950 - 383}{\cos 29,6} - \left(\frac{350}{2} \times \tan 29,6 \right) = 652,10 - 99,41$$

L3 = 552,69 ~ 553 mm

Dimensional specifications

A mm	B mm	C mm	L1 mm	L2 mm	L3 mm	α°	s mm
	80		350			28,0	0,90
	100		350			28,8	0,90
	120		350			28,8	0,90
	125		400			29,0	0,90
	140		450			29,1	0,90
	150		450			29,2	0,90
	160		450			29,2	0,90
	180		550			29,3	0,90
	200		550			29,3	0,90
Choose (100 - 1000)	225	Choose (100 - 1000)	600	Calculated	Calculated	29,4	0,90
	250		750			29,5	0,90
	275		750			29,6	0,90
	300		750			29,6	0,90
	315		850			29,6	0,90
	350		950			29,6	0,90
	400		1050			29,7	0,90
	450		1250			29,7	0,90
	500		1250			29,7	0,90
	550		1250			29,8	0,90
600	1450	29,8	0,90				
650	1650	29,8	0,90				
700	1650	29,8	0,90				
750	1850	29,8	0,90				
800	1850	29,9	0,90				
850	2050	29,9	0,90				
900	2050	29,9	0,90				

45° branch plates, galvanised

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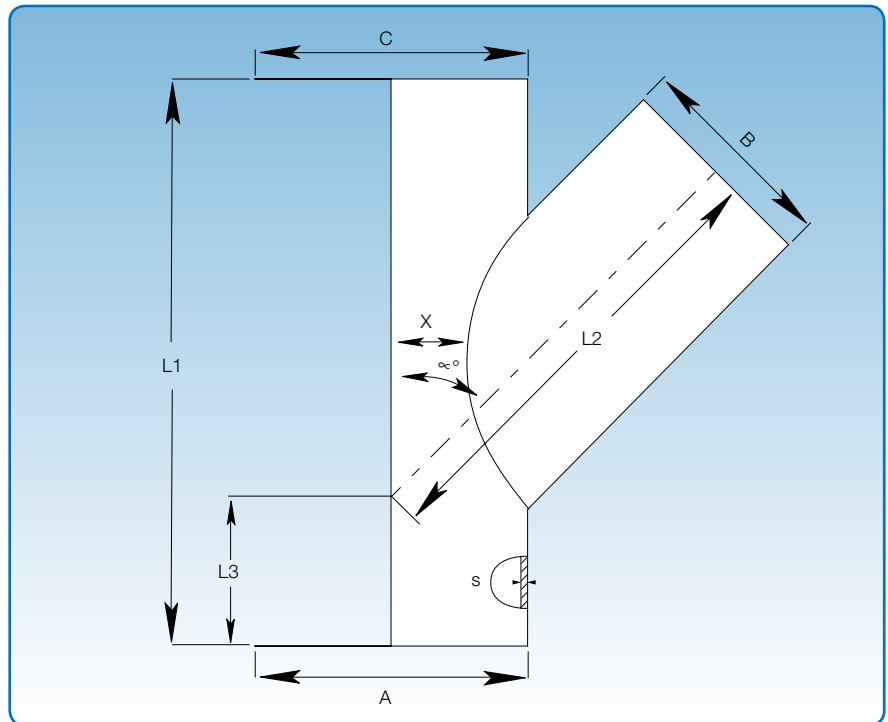
Diameter: ø80 – ø1000 mm.

JKF's galvanised branch plates are made from 0,90 mm galvanised sheet (s).

When placing an order, the measurements for A, B and C must be stated. Please note that the options are restricted by the fact that A = C and A = B.

The branch determines the length L1.
 The branch plates can only be fitted to straight ducts with the branch placed centrally on the plate.

If B < 300: X = 50 mm
 If B > 300: X = 100 mm



Calculation:

L1 = See table

$$L2 = \frac{1}{2} - \left(L1 - \frac{A}{\tan \alpha} \right)$$

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

Example:

A = 550, B = 500, C = 550

L1 = 1050 mm

$$L2 = 0,5 - \left(1050 - \frac{550}{\tan 44,8} \right) = 0,5 - (1050 - 553,85)$$

L2 = - 495,65 ~ - 496 mm

$$L3 = \frac{1050 - 496}{\cos 44,8} - \left(\frac{500}{2} \times \tan 44,8 \right) = 2178,78 - 248,26$$

L3 = 1930,78 ~ 1931 mm

Dimensional specifications

A mm	B mm	C mm	L1 mm	L2 mm	L3 mm	α°	s mm
	80		300			43,8	0,90
	100		300			43,8	0,90
	120		350			44,0	0,90
	125		350			44,0	0,90
	140		350			44,1	0,90
	150		400			44,2	0,90
	160		400			44,2	0,90
	180		400			44,3	0,90
	200		450			44,4	0,90
	225		500			44,5	0,90
	250		500			44,5	0,90
	275		600			44,6	0,90
	300		600	Calculated	Calculated	44,6	0,90
	315		600			44,6	0,90
	350		700			44,7	0,90
	400		800			44,7	0,90
	450		950			44,7	0,90
	500		1050			44,8	0,90
	550		1150			44,8	0,90
	600		1250			44,8	0,90
	650		1150			44,8	0,90
	700		1300			44,8	0,90
	750		1300	44,8	0,90		
	800		1450	44,8	0,90		
	850		1450	44,9	0,90		
	900		1650	44,9	0,90		

30° and 45° trouser pieces, galvanised

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 Revised: 01.01.2004

Diameter: $\varnothing 80 - \varnothing 1000$ mm.

JKF's galvanised trouser pieces are made from 0,90 mm galvanised sheet (s).

When placing an order, the measurements for A, B and C must be stated.

The legs of the trouser piece (B and C) are increased by 50 mm when assembling with wide pull rings [f.bb], rapid lock pull rings [f.lyn] and flanges [m.fl].

The trouser pieces are made to order in other degrees and qualities.

The following apply to galvanised trouser pieces:

$A > B$ and $A < C$. When C B it is the largest value of B and C that must be applied in the calculation.

Calculation of L1 and L2 for 2 × 30°:

$$L1 = (A \times 0,134) + 50$$

$$L2 = (B \times 0,866) + 100$$

Example:

$$A = B = C = 200$$

$$L1 = (200 \times 0,134) + 50 = 76,8$$

$$L2 = (200 \times 0,866) + 100 = 273,2$$

Calculation of L1 and L2 for 2 × 45°:

$$L1 = (A \times 0,207) + 50$$

$$L2 = (B \times 0,5) + 100$$

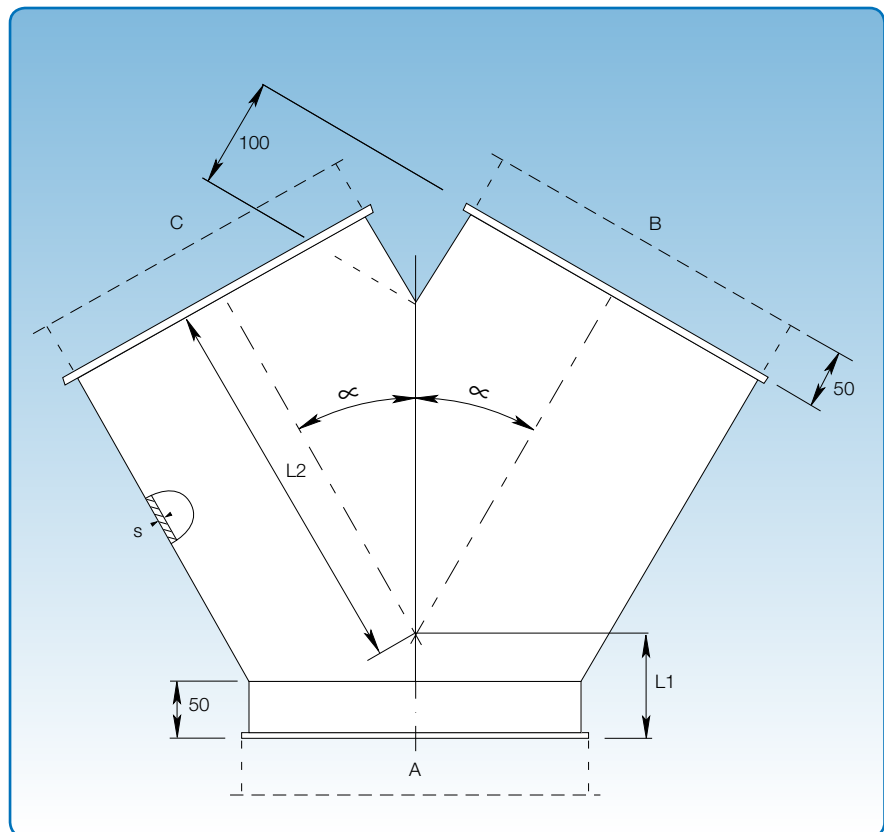
Example:

$$A = B = C = 200$$

$$L1 = (200 \times 0,207) + 50 = 91,4$$

$$L2 = (200 \times 0,5) + 100 = 200$$

With conical trouser pieces where $A > B$, $A < C$ and $B = C$, L1 and L2 must be stated.



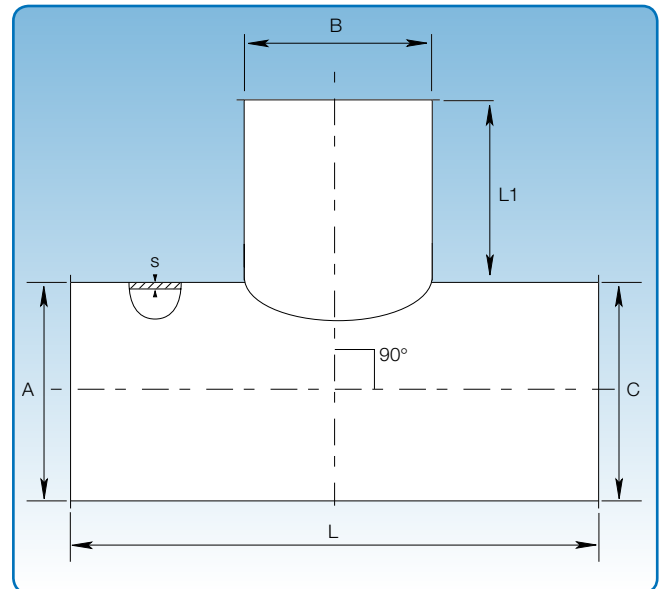
$\alpha = 30^\circ$ or 45°

90° T-pieces, galvanised

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 Section: 02
 Page: 14/16
 Revised: 01.01.2004

Diameter: $\varnothing 80 - \varnothing 1000$ mm.

JKF's galvanised T-pieces are made from 0,90 – 1,00 mm galvanised sheet (s).
 The following applies to the galvanised T-pieces: $A = C = B$.



Dimensional specifications are given in the table below.

Dimensional specifications			
B mm	s mm	L mm	L1 mm
80	0,90	230	75
100	0,90	250	75
120	0,90	270	75
125	0,90	275	75
140	0,90	290	75
150	0,90	300	75
160	0,90	310	75
180	0,90	330	75
200	0,90	350	75
225	0,90	425	100
250	0,90	450	100
275	0,90	475	100
300	0,90	500	100
315	0,90	515	100
350	0,90	550	100
400	0,90	600	100
450	0,90	750	150
500	0,90	800	150
550	0,90	850	150
600	0,90	900	150
630	0,90	930	150
650	0,90	950	150
700	0,90	1100	200
750	0,90	1150	200
800	1,00	1200	200
850	1,00	1250	200
900	1,00	1300	200
950	1,00	1350	200
1000	1,00	1400	200

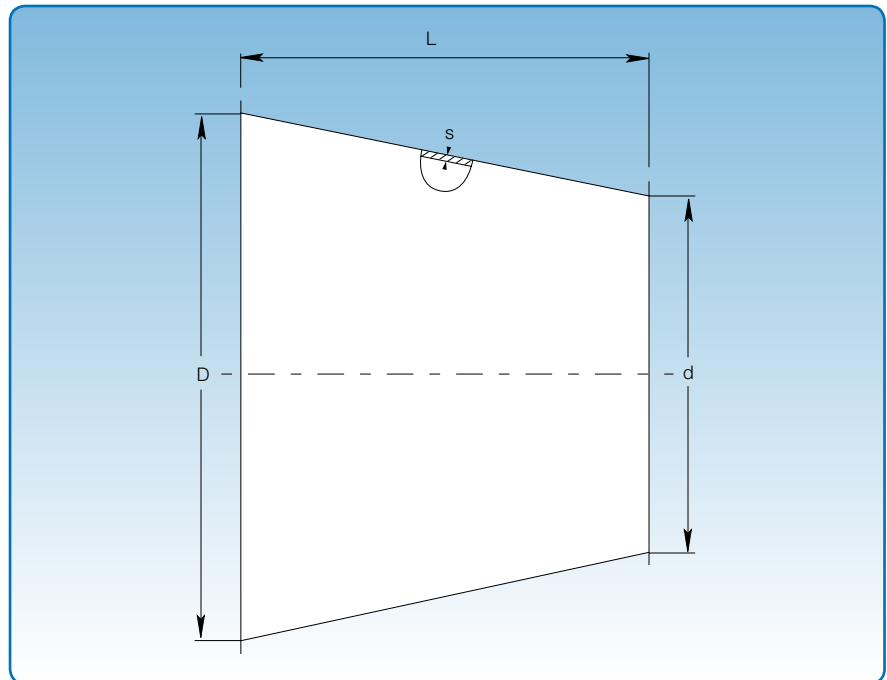
Tapers, galvanised

Technical catalogue: Duct systems
 Section: 01
 Page: 15/16
 Revised: 01.01.2004

Diameter: $\varnothing 80 - \varnothing 1000$ mm.

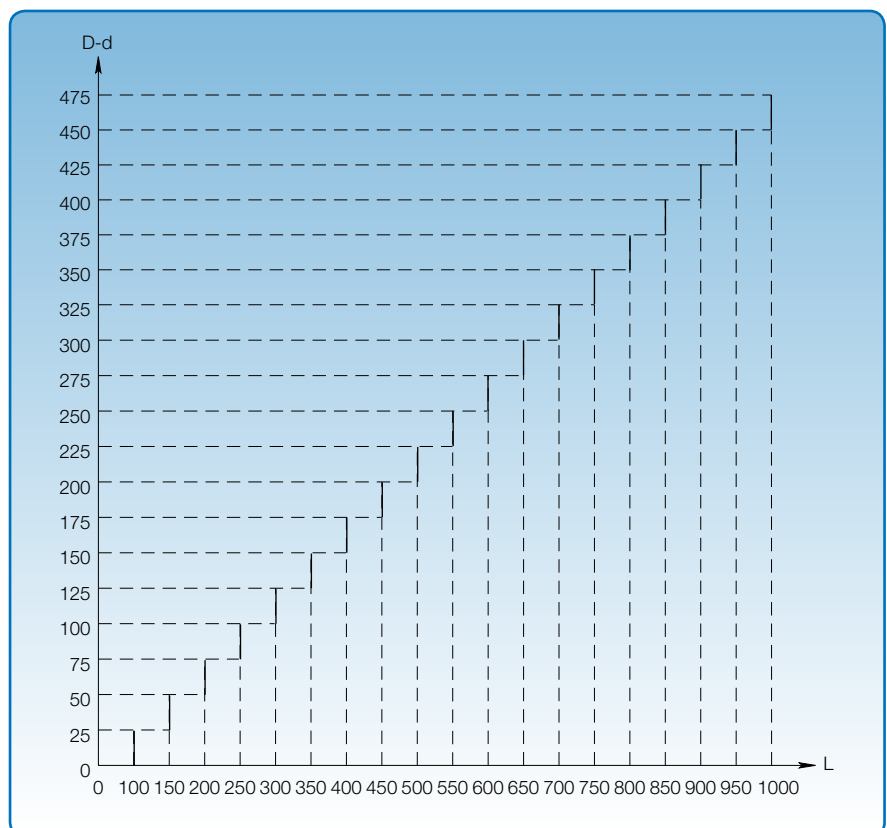
JKF's tapers are spot welded and made as standard from 0,90 mm galvanised sheet (s).

When mounting with wide pull rings [f.bb], rapid lock pull rings [f.lyn] and flanges [m.fl], the length L is increased by 2×50 mm.



Calculation of the length L of the taper:

The difference between the large and the small diameter ($D - d$) of the taper is plotted on the vertical axis (y) in the system of co-ordinates. By following the line from this point to the intersection, the length L is read in the corresponding point on the horizontal axis (x) in the system of co-ordinates.



Transition pieces, galvanised

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Diameter: $\varnothing 80 - \varnothing 1000$ mm.

JKF's transition pieces are spot welded and made from 0,90 mm galvanised sheet (s).

The following formula applies to all transition pieces.

Calculation of the length H:

$H = 250 + 0,5 \times (\text{maximum value of } LU - D) \text{ or } (BU - D).$

The transition pieces are made to order in other dimensions. The transition pieces can also be made asymmetrical.

