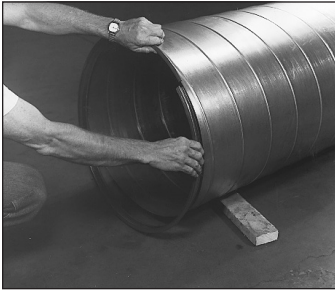


Spiralmate Installation Instructions

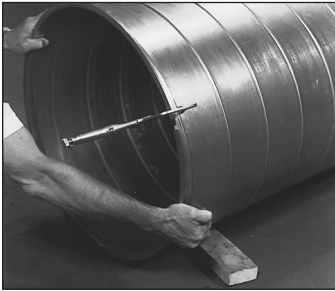
INSTALLATION INSTRUCTIONS



1. Start duct flange by inserting duct end into flange pocket at the break in the ring.

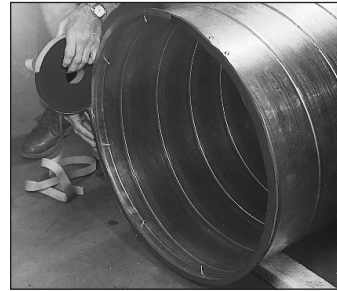


5. The break in the flange will allow a portion of the leading edge of the duct to be visible. Apply a short piece of Ductmate 440 gasket to the flange face over this visible leading edge on **both** mating flanges.*

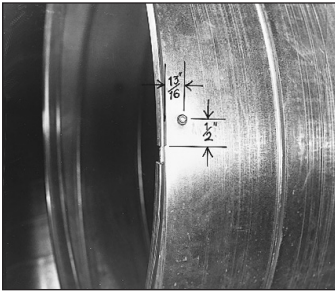


2. Seat flange permanently by pressing it so the leading edge of the duct is seated in the pocket of the flange and penetrates the sealant.

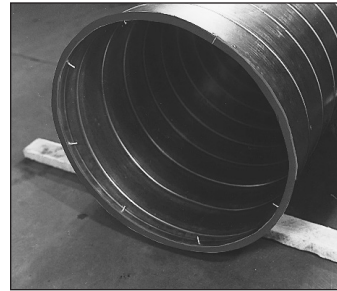
Hold flange in position with vise-grip a few inches from the break.



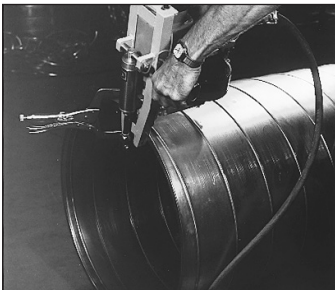
6. Complete the gasket application by installing Ductmate Neoprene gasket on the face of the flange around the entire circumference of one of the mating flanges.



3. Begin securing the leg of the flange to the duct section by placing a pop rivet, screw, or spot weld within 1/2" of the end of the flange break. The fastener should be placed no closer than 3/4" or further than 1" from the face of the flange.

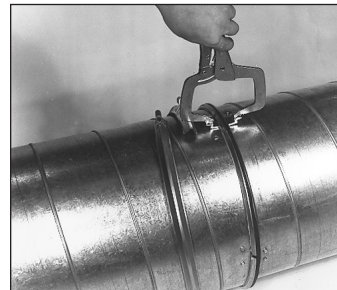


7. The end of the gasket should butt up to the beginning.



4. Continue in the same direction around the duct at evenly spaced intervals, as noted below left. Place the last fastener within 1/2" of the end of the duct flange.

Using the Ductmater or Repeater Pro is optional but can save time and increase product consistency.

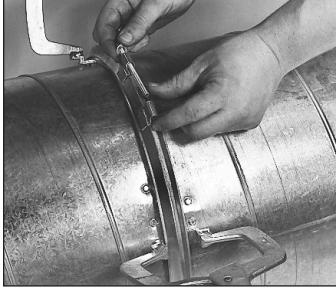


8. Slip outer closure ring over end of duct. Align flanges using Spiralmate alignment grips.

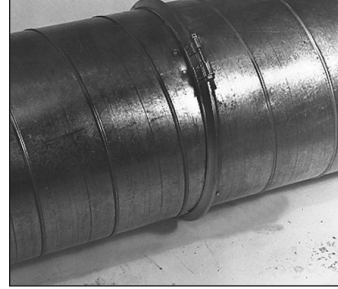
8" - 18" duct - 8" on center
 20" - 28" duct - 12" on center
 30" and larger duct - 18" on center

* Because most spiral duct is not true to size it may be necessary to cut a larger gap in the flange at the break. There **must be** a gap at the break.

INSTALLATION INSTRUCTIONS



9. Slide closure ring over mating flanges and insert bolt.



11. A completed, air-tight, round transverse duct joint. Fast, neat and clean.



10. Tighten the bolt on the closure ring until it makes even contact around the circumference of the duct sections. Tap around joint with hammer if necessary to seat flange while tightening.

IMPORTANT:

On duct sizes 72" and larger consult factory for additional assembly and installation information.

SPECIAL TOOLS



Spiralmate Alignment Grips

These modified Alignment Grips help you quickly align your Spiralmate flanges, further reducing your labor time and costs.

Part Number:
AG2001



Spiralmate Nut Runners

Custom deep dish sockets designed to open and close the Spiralmate Closure Band. Available in two sizes 7/16" small and 9/16" large.

Part Numbers:
NUTRUNS/NUTRUNL

Frequently a contractor installing a high velocity duct system will employ a duct joint with which either he or his work force have no experience. In such a case, it is strongly recommended that the contractor promptly test the initial 100 to 300 feet of duct before installing any more duct. This test will quickly reveal whether or not the workmen can make this joint air-tight in an economical manner.

Reprinted from SMACNA High Pressure Manual.