

Installation Instructions

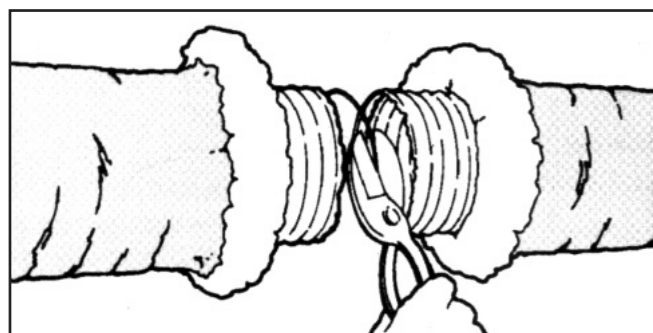
Air Ducts and Air Connectors Nonmetallic with Plain Ends



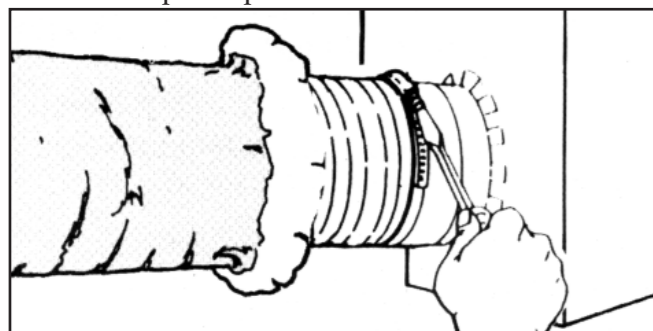
1000 E. Woodfield Road
Suite 102
Schaumburg, IL 60173-5921
www.flexibleduct.org

CONNECTIONS

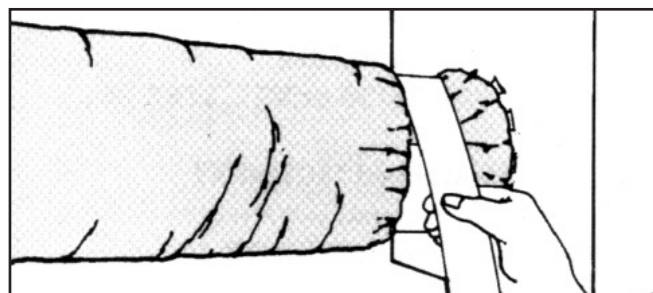
1. After desired length is determined, cut completely around or through duct with knife or scissors. Cut wire with wire cutters. Fold back jacket and insulation.



2. Slide at least 1" [25 mm] of core over fitting and past the bead. Seal core to collar with at least 2 wraps of duct tape. Secure connection with clamp placed over the core and tape and past the bead.

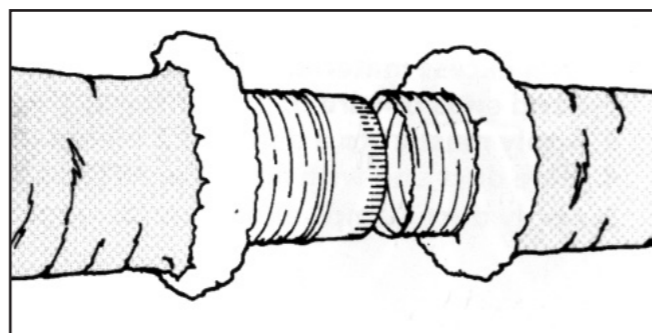


3. Pull jacket and insulation back over core. Tape jacket with at least 2 wraps of duct tape. A clamp may be used in place of or in combination with the duct tape.

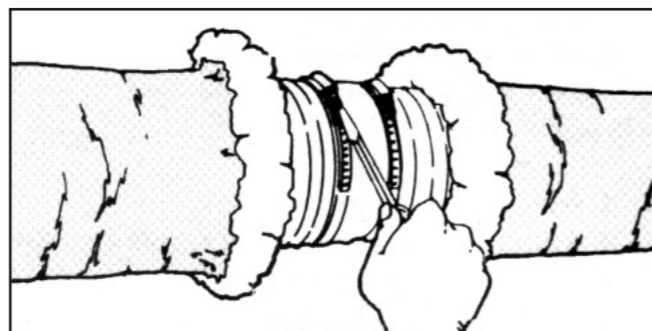


SPLICES

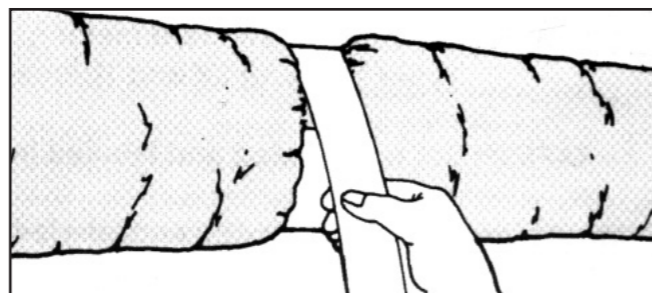
1. Fold back jacket and insulation from core. Butt 2 cores together on a standard 4" [100 mm] length metal sleeve.



2. Tape cores together with at least 2 wraps of duct tape. Secure connection with 2 clamps placed over the taped core ends and past the beads.



3. Pull jacket and insulation back over cores. Tape jackets together with at least 2 wraps of duct tape.



- NOTES:**
1. For uninsulated air ducts and air connectors, disregard references to insulation and jacket.
 2. Use beaded sheet metal fittings and sleeves.
 3. Use tapes listed and labeled in accordance with Standard UL 181B and marked "181B-FX".
 4. Nonmetallic clamps shall be listed and labeled in accordance with Standard UL 181B and marked "181B-C". Use of nonmetallic clamps shall be limited to 6 in. w.g. [1500 Pa] positive pressure.

Installation Instructions

Complies with UL-181 Requirements

Splicing Two Lengths of Thermaflex Insulated Ducts

1. Expose end of liner.
2. Trim excess material from liner.
3. Bend ends of wire to avoid snagging.
4. Screw liners on standard 4" metal sleeve to butt join and apply two wraps of duct tape*. Finish seal with clamp*.
5. Overlap insulation in smooth plies over spliced liners.
6. Overlap loose barrier seam in smooth plies over insulation.
7. Apply two wraps of duct tape*.

Splicing Two Lengths of Non-Insulated Ducts

1. Trim excess material from ducts.
2. Bend ends of wire to prevent snagging.
3. Apply mastic* to a depth of 2 inches (minimum) inside duct liner ends.
4. Slide duct end with adhesive to form butt joint on 4" metal sleeve.
5. Apply duct clamp* and allow joints to dry.

Connecting Insulated Duct to Fitting Medium to High Pressure

1. Cut duct to length.
2. Apply liner onto fitting.
3. Apply two wraps of duct tape* over liner to fitting seam.
4. When duct tape* is not used, apply mastic* to fitting and slide liner at least 2 inches. Apply clamp* and allow it to dry.
5. Pleat and seal barrier to fitting with two wraps of duct tape* and apply clamp* over the tape with tension tool.

Low Pressure Two Inches or Lower

1. Follow steps 1 and 2 above.
2. Apply two wraps of duct tape* and duct clamp* over lining to fitting seam connecting M-KC, M-KE, or G-KM duct having factory installed metal collars to fitting.
3. Pleat and seal barrier with two wraps of duct tape* or clamp* insulation and barrier to fitting in place of tape*.

See separate instruction sheet inside carton for factory installed duct assemblies.

Clamps*: Use non-metallic clamps listed and labeled in accordance with Standard UL 181B and marked "181B-C".

Tapes*: Use tapes listed and labeled in accordance with UL-181 marked "181B-FX."

Mastics*: Use mastics listed and labeled in accordance with UL-181 marked "181B-M."

NOTES

- a. Types S-LP, S-LD, MC and insulated Thermaflex connectors are not to be installed in lengths exceeding 14 feet (4.25 meters).
- b. Follow application rate of Mastics* according to manufacturer's recommendations.
- c. Look for separate installation instructions inside carton on short duct assemblies having factory installed collars.