

ECONO *flange*™



Round Duct Connection System

Solid and Adjustable Connection

- Simple installation process
- Can be installed on-site
- No special tools required
- Available in sizes 8" - 72" in standard 2" increments
- Available in specialty metals



DUCTMATE®
Industries
A DMI COMPANY

DESCRIPTION

Round duct connection system.

BASIC USE

The ECONOflange connection system was designed as an alternative to Ductmate's proprietary round self-sealing system; Spiralmate. The user friendly design paired with its excellent performance makes ECONOflange the most cost-effective round flange connection on the market.

SPECIAL CHARACTERISTICS

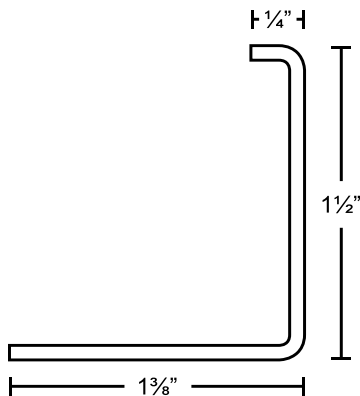
Sizes

18 gauge cold-formed, hot-dipped galvanized steel is available for sizes 8" - 48".

16 gauge cold-formed, hot-dipped galvanized steel is available for sizes 50" - 72".

Gasket:

Ductmate Neoprene 5/16"x3/4"



PACKAGING INFORMATION

Quick Ship Program

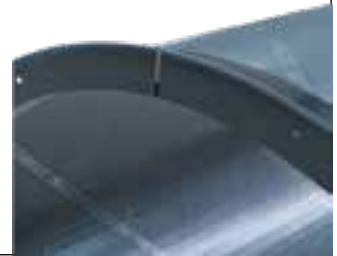
- 100 single wall pieces or less ships in 24 hrs, if entered before Noon
 - Sizes 8" - 40" **Galvanized and Even Sizes Only**
- 50 double wall pieces or less ships in 24 hrs, if entered before Noon
 - Sizes 10"/08" - 24"/22" **Galvanized and Even Sizes Only**
- If after Noon; ships in 48 hrs

PACKAGING INFORMATION

The ECONOflange connection system is sold in single rings.

INSTALLATION INSTRUCTIONS

1. ECONOflange is manufactured with a split in the ring to allow for minor deviations in the diameter of the pipe.



2. Start the ring by inserting the 1 3/8" leg inside the duct.



3. Seat the ring flush with the end of the duct and clamp the ring into position.



4. Begin securing the leg of the ring to the duct section at the split. Hold the flange in position by placing vise grips a few inches from the break. Begin placing a self drilling screw, spot weld, or line rivet 1/2" from the break.



INSTALLATION INSTRUCTIONS (Cont.)

5. Continue in one direction attaching the flange to the duct 1" from the face of the flange, 10" on center around the circumference of the duct. Optional stitch welding around ECONOflange to duct 10" center. Assure stitch welds cover 50% onto duct and 50% onto flange for strong weld.



6. Seal the joint internally with PROseal® duct sealant. Brush the sealer into the joint achieving a 100% seal.



7. The break in the flange will allow a portion of the leading edge of the duct to be visible. For a better seal on medium to high pressure jobs (4" and higher) it is preferred that a short piece of Ductmate 440 gasket be applied to the face of the flange to cover the leading edge on both mating flanges. (On low pressure jobs the 440, applied to the split, can be replaced by Ductmate Neoprene gasket.)



8. Apply Ductmate Neoprene gasket 5/16" by 3/4" wide to the face of one of the ECONOflange rings. The Neoprene should be positioned parallel to the inside edge of the ECONOflange. The Neoprene gasket ends must be butted against each other.



9. Align mating frames by matching the ECONOflange ring evenly around the circumference



10. Clamp the mating ECONOflange rings compressing the gasket until the mating rings touch.



11. Fasten self drilling screws 6" on center around the circumference of the flange face. In order to assure a proper closed joint, the rings should be clamped tightly together with the two faces touching each other prior to fastening the self drilling screw. Proper care should be taken in setting the clutch adjustment of your screw gun to assure your screws have 100% holding strength.



ECONOflange can be installed on reducing fitting in the same manner as a small end collar. This eliminates the need for collars unlike other traditional flange connection systems.

NOTE: For Double Wall applications see Inner Ring sections for installation instructions and specifications prior to moving on to Step 8.

Press-On Inner Rings

Patent 10,533,689

**Revolutionary Design For
Quick, Hassle-Free Installation**

DESCRIPTION

The Press-On Inner Ring was specifically designed to significantly reduce installation time and labor cost. This system uses a double-sided pressure sensitive adhesive to bond the outer flange and inner ring without the need for costly welding. There are also no issues with aligning the rings to fit around the insulation and inner diameter of the duct because the outer flange and Press-On Inner Ring are installed on the ductwork separately.

BASIC USE

Designed to protect insulation installed inside spiral duct from damage and prevent fibers from breaking away into the airstream. Installs with an easy to use peel and stick press-on gasket that quickly secures the cut edges of insulation to the duct wall.

SPECIAL CHARACTERISTICS

- Double Sided high strength PSA tape to adhere
- Simplifies installation of double wall duct
- Available in 1" and 2" rings
- Inner-ring adjusts to fit the variations in pipe diameter
- Tested to withstand 10" W.G. positive pressure
- Eliminates welding or fasteners
- Can be installed on-site

INSTALLATION INSTRUCTIONS

1. Remove backing from adhesive gasket and starting with the split in the Inner Ring apply on the opposite side of the Spiralmate flange split.
2. Working in one direction around the Inner Ring, apply pressure to the areas where the adhesive gasket makes contact with the flange face to attach.

PACKAGING

The Press-On Inner Rings are sold as single rings.

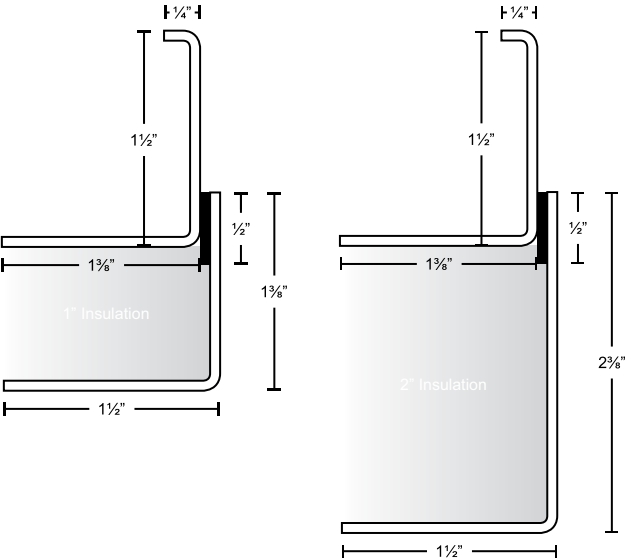
ORDERING INFORMATION

Part Number Example:
1IR*30GAPSA

Insulation Thickness	Product Type	Size of Inner Diameter		Alloy	Adhesive
1 = 1" 2 = 2"	IR = Inner Ring	†8 = 8"	40 = 40"	GA = Galvanized GN = Galvannealed AL = Aluminum AZ = Aluminized S4 = 304 Stainless Steel S6 = 316 Stainless Steel 1" Only PVC = PVC Coated	PSA = Pressure Sensitive Adhesive
		†10 = 10"	42 = 42"		
		12 = 12"	50 = 50"		
		14 = 14"	52 = 52"		
		16 = 16"	54 = 54"		
		18 = 18"	56 = 56"		
		20 = 20"	58 = 58"		
		22 = 22"	60 = 60"		
		24 = 24"	62 = 62"		
		26 = 26"	64 = 64"		
		28 = 28"	66 = 66"		
		30 = 30"	68 = 68"		
		32 = 32"	70 = 70"		
		34 = 34"	72 = 72"		
		36 = 36"			
		38 = 38"			

† Only available for 1" insulation

* Insert W for a welded split



Weld-On Inner Rings

Insulation Encapsulation For Spiral Duct

DESCRIPTION

Inner ring for double wall spiral pipe.

BASIC USE

Designed to protect insulation installed inside spiral duct from damage and prevent fibers from breaking away into the airstream. Installs with the use of a spot welder to the Ductmate EconoFlange.

SPECIAL CHARACTERISTICS

- Sizes
 - 18 gauge cold-formed, hot-dipped galvanized steel is available for sizes 8" - 48"
 - 16 gauge cold-formed, hot-dipped galvanized steel is available for sizes 50" - 72"
- Available with a split or welded seam.
- Available in 1" and 2" rings
- Split Inner-rings adjust to fit the variations in pipe diameter
- Tested to withstand 10" WG positive pressure

INSTALLATION INSTRUCTIONS

- Start with the split in the ring opposite of the split in the EconoFlange ring. If the Econoflange is welded, please start opposite of the weld.
- Slide inner ring into inner pipe and ensure inner leg is in contact with duct wall.
- Working in one direction, spot weld inner ring mating face to EconoFlange ring mating face.

PACKAGING

The Weld-On Inner Rings are sold as single rings.

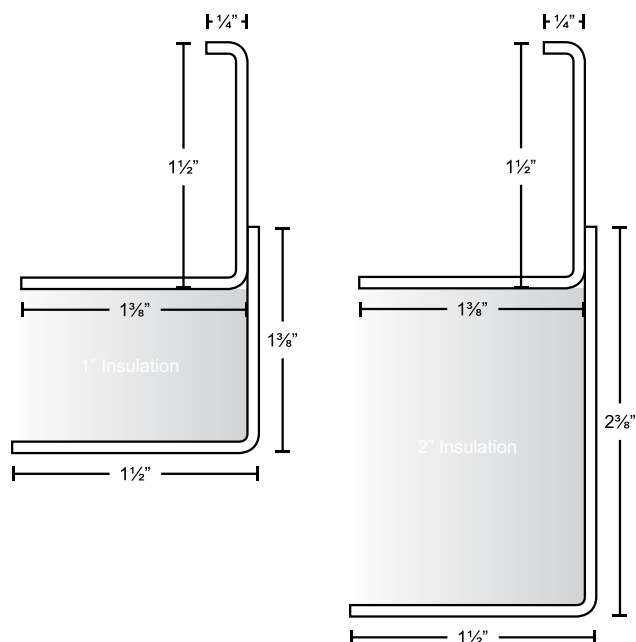
ORDERING INFORMATION

Part Number Example:
IIR*30GA

Insulation Thickness	Product Type	Size of Inner Diameter		Alloy
1 = 1" 2 = 2"	IR = Inner Ring	†8 = 8" †10 = 10" 12 = 12" 14 = 14" 16 = 16" 18 = 18" 20 = 20" 22 = 22" 24 = 24" 26 = 26" 28 = 28" 30 = 30" 32 = 32" 34 = 34" 36 = 36" 38 = 38"	40 = 40" 42 = 42" 50 = 50" 52 = 52" 54 = 54" 56 = 56" 58 = 58" 60 = 60" 62 = 62" 64 = 64" 66 = 66" 68 = 68" 70 = 70" 72 = 72"	GA = Galvanized GN = Galvannealed AL = Aluminum AZ = Aluminized S4 = 304 Stainless Steel S6 = 316 Stainless Steel 1" Only PVC = PVC Coated

† Only available for 1" insulation

* Insert W for a welded split



LIMITED PRODUCT WARRANTY

Ductmate warrants that ECONOflange™, when properly installed and maintained, will be free from defects in material and workmanship, and will comply with all written specifications made by Ductmate at the time of sale. Ductmate's warranty shall run for a period of one year from the date of manufacture.

Warranty Limitation

The warranty stated above is in lieu of all other warranties, express or implied, including but not limited to the implied warranties of MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. Although Ductmate may have suggested the product, or provided written or oral advice to the Purchaser, it is the Purchaser's responsibility to test and determine the suitability of ECONOflange™, for the intended use and purpose, and Purchaser and/or its customer assumes all risk and liability whatsoever regarding such suitability.

Limitation of Liability

In the event of a breach of the above warranty, Ductmate's sole obligation, and Purchaser's sole and exclusive remedy, shall be, at Ductmate's option, repair or replacement of any defective products, or refund of an applicable portion of the purchase price. Ductmate shall have no liability for costs of removal or reinstallation of the product. The Purchaser agrees that no other remedy, including but not limited to loss of profits, loss sales, injury to person or property, or any other special, incidental or consequential damages, shall be available to the Purchaser for any claim arising out of this Agreement, regardless of whether such claim is made in contract or in tort, including strict liability in tort. In no event will Ductmate be obligated to pay damages to the Purchaser in any amount exceeding the purchase price that the Purchaser paid to Ductmate for the allegedly defective product.



Charleroi, PA

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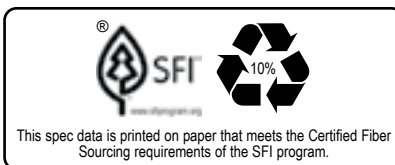
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*Additional Manufacturing and Warehousing in
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