

Transfer System Specification

Material shall be one of the following:

- A. Galvanized steel conforming to ASTM standards A653 and A924
 - B. Stainless steel type 304L conforming to ASTM standard A240*
 - C. Stainless steel type 316L conforming to ASTM standard A240*
- Note (*) die-stamped (pressed) fitting construction not available

Surface finish shall be one of the following:

- A. G-60 galvanized steel (standard)
- B. G-90 galvanized steel
- C. Stainless steel type 304L 2B finish
- D. Stainless steel type 316L 2B finish

Material thickness shall be one of the following:

- A. 22 gauge except pressed elbows shall be 24 gauge
- B. Other gauges and/or external reinforcement (consult the factory)

Construction

- A. Spiral Duct shall be:
 - 1. Non-corrugated spiral lock seam construction
 - 2. Mechanically formed seam locking indentation evenly spaced along the spiral seam
 - 3. Factory formed 300° rolled edge transfer beaded end stubs swaged on at each end
 - 4. Length – 12 inch minimum and 10 feet maximum (factory cut to specified length)
- B. Fittings:
 - 1. Laterals shall be 30 degree (other options are available)
 - 2. Elbows shall be 1.5 centerline radius (other options are available)
 - 3. All connections shall have factory formed 300° rolled edge transfer bead
 - 4. 90 degree elbows shall have 5 gores (other options are available)
- C. Fittings shall be manufactured shall be one or more of the following construction methods:
 - 5. Overlapped edges stitch welded along the entire length of the fitting
 - 6. Standing seam gore locked and internally sealed
 - 7. Button punched and internally sealed
 - 8. Elbows 3" through 12" diameter will be die stamped and continuously stitch welded
- D. Sealant shall be one or more of the following:
 - 1. Water based acrylic dispersion (Sikacryl-Vent manufactured by Sika Sverige)
 - 2. Water based synthetic latex (DP-1020 manufactured by Design Polymerics)
 - 3. Other sealants or fully welded construction (consult the factory)
- E. Pressure rating shall be:
 - 1. Negative pressure rating (consult the factory)
 - 2. Positive pressure rating +10 inch water gauge
 - 3. Also available from -30 inch water gauge to +50 inch water gauge (consult the factory)
- F. Shall be available in 3" diameter through 20" diameter



Connections / Joint sealing

- A. All duct and fitting ends shall be joined externally by means of an integral latching/locking barrel clamp with factory installed custom form fitting EPDM sealing gasket to ensure no duct penetrations or protrusions into the airstream
- B. Temperature rating for the EPDM rubber gasket shall be -22°F to +167 °F continuous and -40°F to 185 °F intermittent
- C. The clip handle shall be secured against inadvertent opening by means of a lock pin (supplied by others)
- A. No additional field sealant shall be necessary