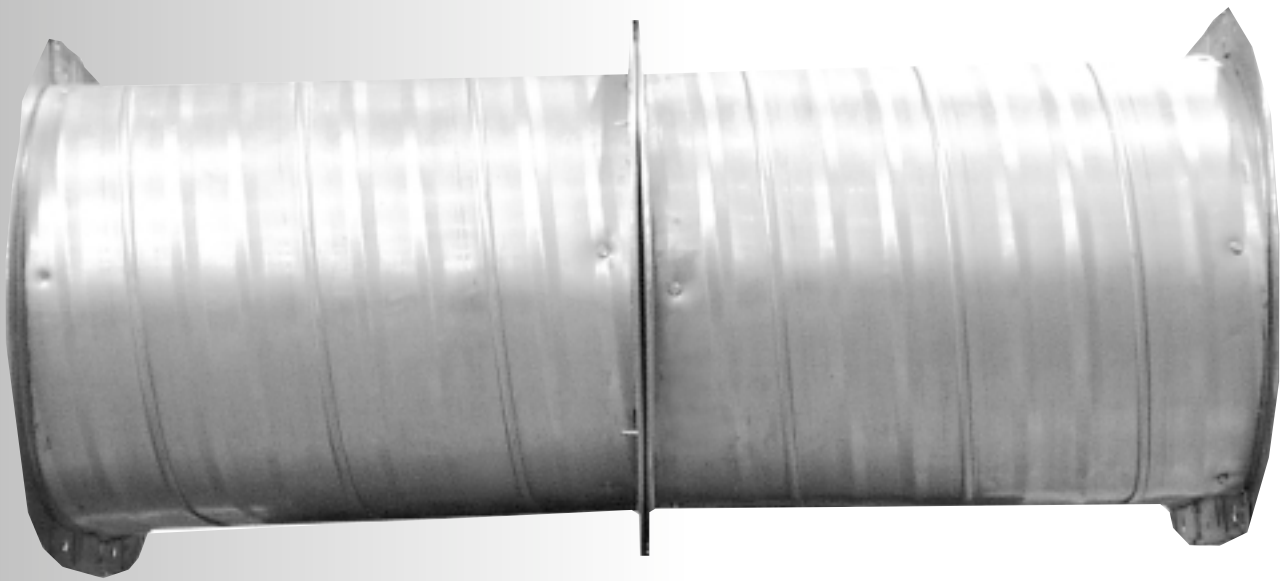


D U C T M A T E

ECONO *flange*™ OVAL



Oval
CONNECTION SYSTEMS



Oval Duct Connection System

Fast Screw Connection

- Simple installation process
- Can be installed on-site
- No special tools required
- Available in sizes 8" - 56" in standard 2" increments
- Available in specialty metals



DUCTMATE®

Industries, Inc.

ECONOflange

Oval Duct Connection System

DESCRIPTION

Oval duct connection system

BASIC USE

The ECONOflange Oval connection system was designed as an alternative oval duct connection for applications in which appearance and performance are not paramount.

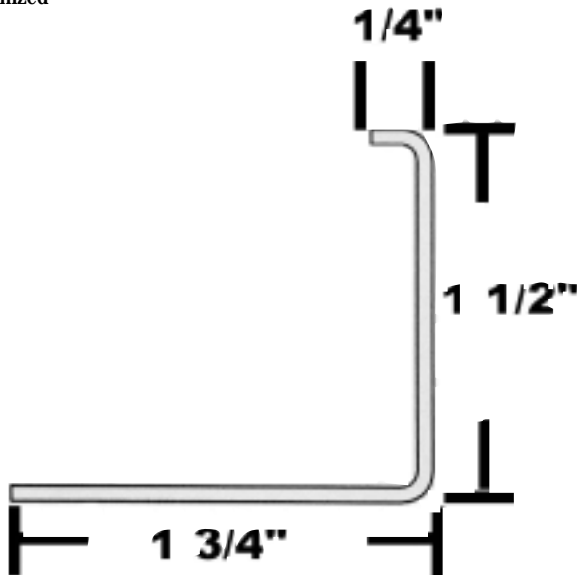
SPECIAL CHARACTERISTICS

Flange Construction:
16 Gauge
Hot Dipped Galvanized Steel

Gasket:
Ductmate Neoprene

ECONOflange OVAL 8" - 56"

16 GAUGE STEEL
Cold-formed, hot-dipped
galvanized



PRODUCT GUARANTEE

All component parts of ECONOflange Oval system are guaranteed against defective material.

PACKAGING INFORMATION

The ECONOflange Oval connection system consists of semi-circular end flange sections and straight flange. Straight flange is sold in 10' or 20' lengths. The semi-circular end pieces are sold individually with the connector pieces welded onto the ends. (One oval frame consists of two lengths of straight flange and two semi-circular end pieces.

INSTALLATION INSTRUCTIONS

Cut straight flange to length according to the following formula:

For Duct with 8" through 56" Minor Dimension

EXAMPLE

Duct Dimension 68" x 20"

Major Dimension	68"
(minus) Minor Dimension	-20"
(minus) 6 1/4"	-6 1/4"

(equals) Straight Ovalmate
Angle Length 41 3/4"

** Formula is based on exact dimensions. Measure your frame and check fit of completed frame.*

*** ECONOflange Oval is not recommended when formula calculates angle length at less than 4".*



1. Measure your preformed ductwork and cut the straight flanges for the ECONOflange Oval connection.



2. Weld the end sets flat to the straight flanges to form the completed flange.

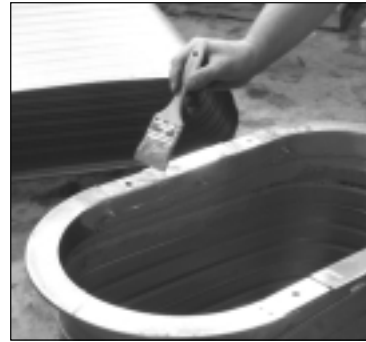


6. Seal the joint internally with PROseal duct sealant. Brush the sealer into the joint and onto both the face and inside edge of the connector pieces to achieve a 100% seal. Note: Additional sealing at the connector pieces is required for ductwork over 6 inches positive pressure.

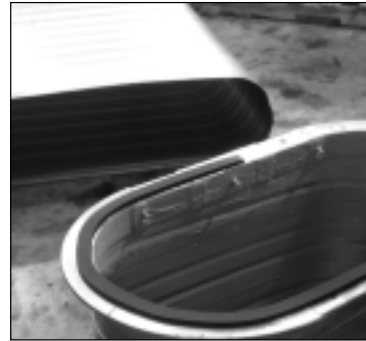
Seating ECONOflange Oval Frame



3. Begin seating the ECONOflange Oval frame.
Note: Mark a common reference point on both ends of the duct. ECONOflange Oval frames must be centered properly in relation to the frame on the other side of the duct to eliminate racking and/or twisting.



4. Seat ECONOflange Oval onto the duct so the flange is perpendicular to the ductwork. Do not hammer the center of the major axis. An inward curve could occur.

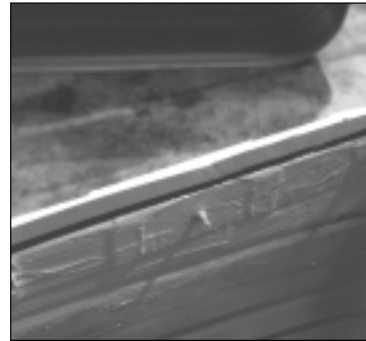


7. Apply Ductmate Neoprene gasket 5/16" thick by 3/4" wide to the face of one of the ECONOflange Oval. The Neoprene should be positioned parallel to the inside edge of the ECONOflange. The Neoprene gasket ends must be butted up against each other.

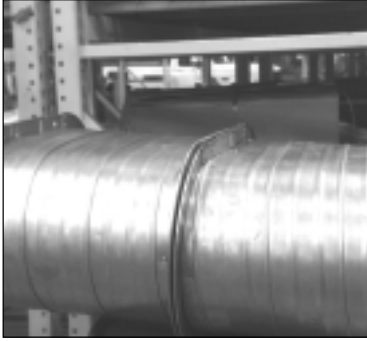
Fastening ECONOflange Oval Frame to Duct



5. Begin securing the leg of the ring to the duct section. Hold the flange in position by placing vise grips around the duct. Begin placing a self-drilling screws, spot welds, or rivets every 10" on Center.



Connecting the Flat Oval Duct Sections



8. Align mating frames by matching the ECONOflange Oval frames evenly around the ductwork.



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



8. Clamp the mating ECONOflange Oval frames compressing the gasket until the mating rings touch.

*** ECONOflange Oval can be installed on reducing fittings in the same manner as a small end collar. This eliminates the need for collars unlike other traditional connecting systems.*



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