



The **EDGE**™

Self-Sealing Round Duct System



Stamped Fittings
INCORPORATED

The **EDGE™** Submittal Sheet

MATERIAL:

- Galvanized steel
- Unless otherwise specified, all duct and fittings will be G-60 or better in accordance to ASTM standards; A-653 and A-924.

CONSTRUCTION (GAUGE):

- All duct and fittings are made per SMACNA's Duct Construction Standards (+10" W.G.).
- The following table shows diameter and gauges:

Diameter	Spiral Duct	Fittings
3" - 14"	26 ga.	24 ga.
16" - 26"	24 ga.	22 ga.
28" - 36"	22 ga.	20 ga.

CONSTRUCTION (PIPE):

- Spiral pipe
- Calibration of spiral is required by **The EDGE™ System** manufacturer, Stamped Fittings Inc.

CONSTRUCTION (FITTINGS):

All **EDGE™** fittings, 3" – 24", will have a factory installed gasket that is attached to the fitting with a 180° hemmed edge for strength, rigidity and maintaining proper tolerances. Fittings will be manufactured by one of the following processes:

- Elbows: 3" – 12" die stamped and stitch welded
- Elbows: 14" – 24" goreslit and gorelocked with standing seam
- Reducers: 4" – 24" spun and plasma butt welded, no seams
- Bellmouths: 4" – 12" stamped, no seams
- Bellmouths: 14" – 24" spun and plasma butt welded, no seams
- All other fittings: fabricated and stitch welded

CONSTRUCTION (GASKET):

- The EDGE™** gasket consists of a two-part EPDM rubber sealing material.
- The base EPDM (black material) is classified according to ASTM D2000-86 M3BA 810 B13 C12 F17.
- The sealing EPDM (grey material) is classified according to ASTM D2000-86 M8BA 507 B13 C12.
- The operating temperature is -20°F to 212°F.
- The smoke and flame spread is in accordance to ASTM E-84-91A.

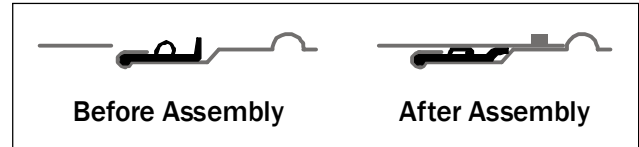
PRESSURE CLASS:

- The EDGE™ System** has been tested and meets the requirements of SMACNA's Leakage Class 3 as indicated not to exceed (-20 in. W.G.) or (+12 in. W.G.).

JOINT CONNECTIONS:

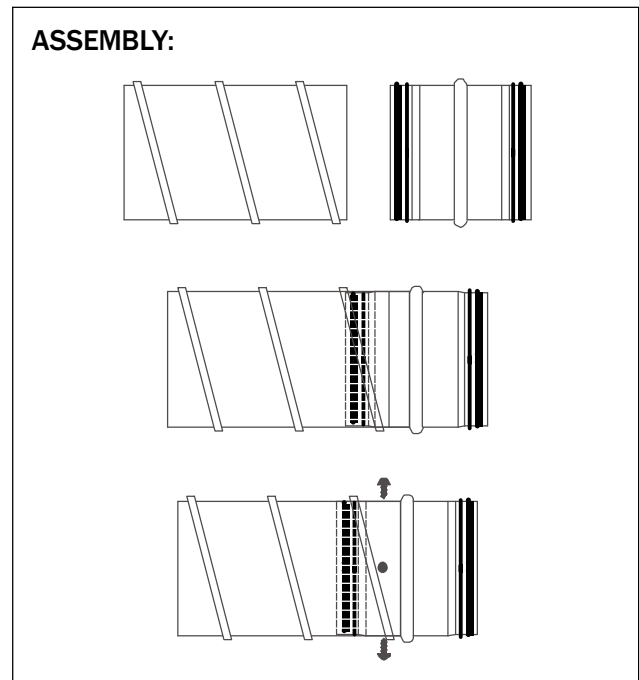
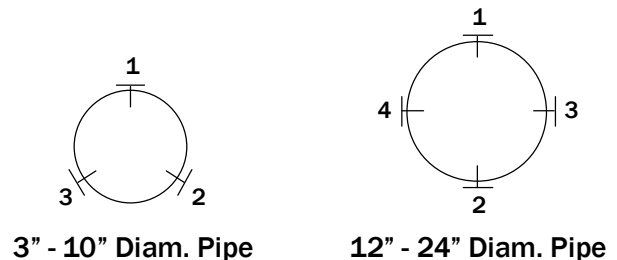
- All fittings are manufactured to slip fit into spiral duct. All fitting to fitting connections will use a fitting coupling.

The EDGE™ System fittings are made to fit tight, assuring a proper seal. Care should be taken when handling these fittings as damage could result in an improper fit and a difficult installation process.



WHEN INSTALLING:

- Place the hemmed EDGE of the fitting in the spiral pipe then apply pressure and the fitting will slip into place, stopping at the bead/pipe stop.
- Using self-tapping sheet metal screws, place the screws 3/4" from the bead/pipe stop. The gasket and fittings are designed to allow adequate room to secure the screws per SMACNA standards.



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