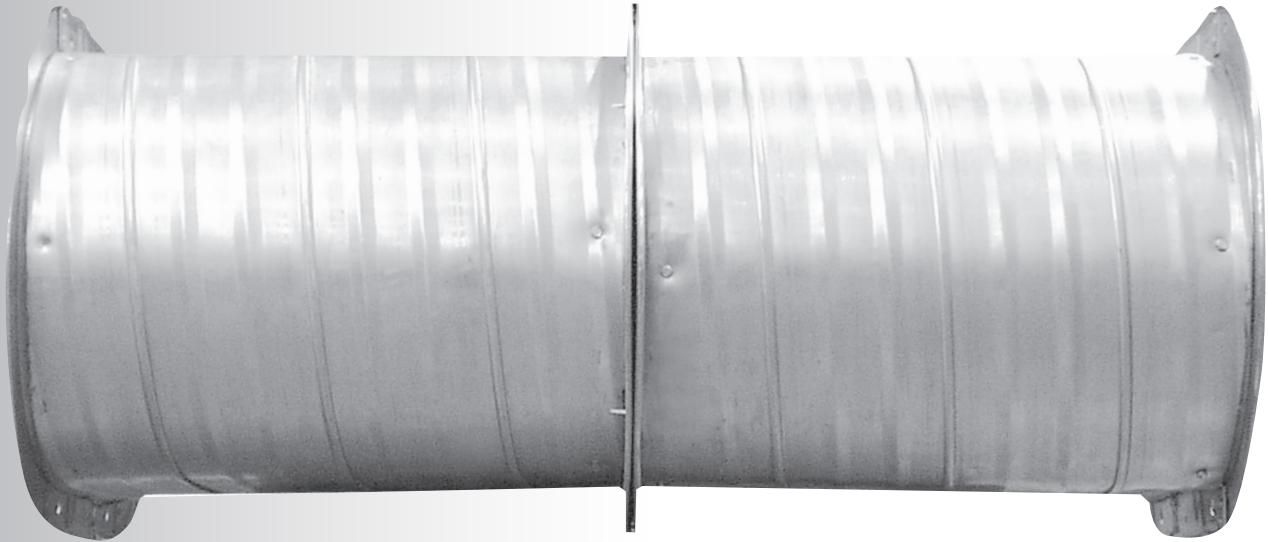


D U C T M A T E

ECONO *flange*™ OVAL



Oval Duct Connection System

Fast Screw Connection

- Simple Installation Process
- Can Be Installed On-Site
- No Special Tools Required
- Available In Sizes 8"-25" In Standard 2" Increments
- Available In Specialty Metals



ECONOflange™ Oval

Oval Duct Connection System

DESCRIPTION

Oval duct connection system.

BASIC USE

The ECONOflange Oval connection system was designed to be user friendly and provide exceptional performance, making it the most economical oval flange connection system on the market.

SPECIAL CHARACTERISTICS

Flange Construction:

16 Gauge 50" & Up; 18 Gauge 48" & below
Hot Dipped Galvanized Steel

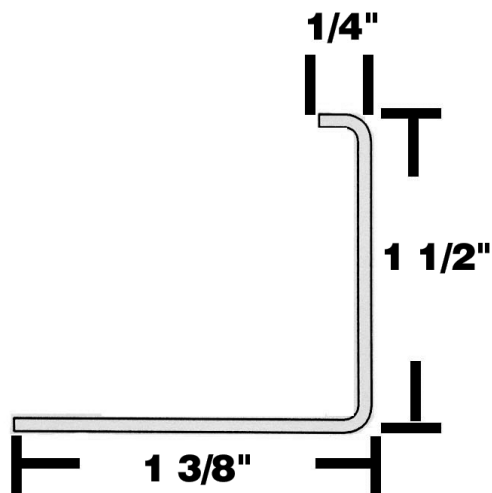
Gasket:

Ductmate® Neoprene

ECONOflange OVAL

8" - 56"

18 GAUGE STEEL 48" & below
16 GAUGE STEEL 50" & up
Cold-formed, hot-dipped galvanized
Pre-punched holes



PACKAGING INFORMATION

The ECONOflange Oval connection system consists of semi-circular end flange sections and straight flange. Straight flange is sold in 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

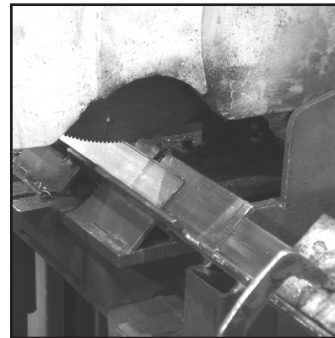
Duct Dimension 68" x 20"

Major Dimension	68"
(minus) Minor Dimension	-20"
(minus)	-7 1/4"

(equals) Straight Angle Length	40 3/4"
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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 frame.

Seating ECONOflange Oval Frame



3. Begin seating the ECONOflange Oval frame.

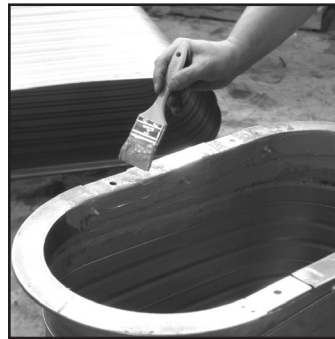
Note: Mark a common reference point on both ends of the duct. ECONOflange Oval frames must be centered properly in relation to the frame on the other side of the duct to eliminate racking and/or twisting.



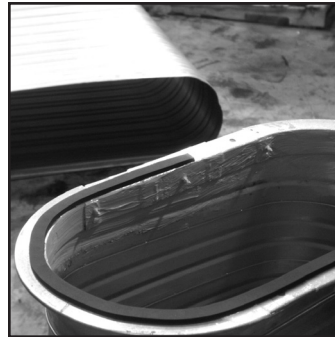
6. Seal the joint internally with PROseal® duct sealant. Brush the sealer into the joint and onto both the face and inside edge of the connector pieces to achieve a 100% seal.



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.

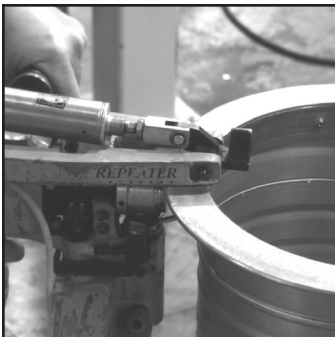


Note: Additional sealing at the connector pieces is required for ductwork over 6" positive pressure.

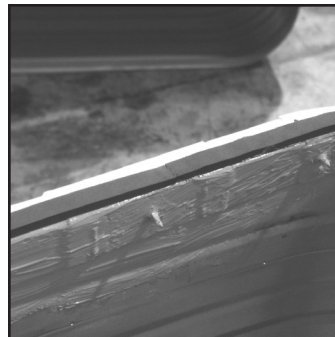


7. Apply Ductmate® Neoprene gasket 5/16" thick by 3/4" wide to the face of one of the ECONOflange Oval. The Neoprene should be positioned parallel to the inside edge of the ECONOflange. The Neoprene gasket ends must be butted up against each other. Do not overlap gasket ends

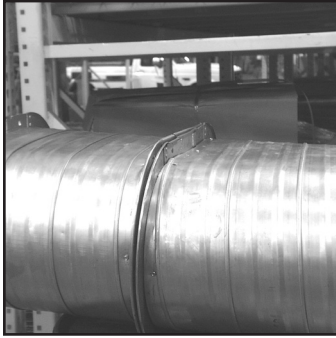
Fastening ECONOflange Oval Frame to Duct



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 self-drilling screws, spot welds, or rivets every 10" on Center.



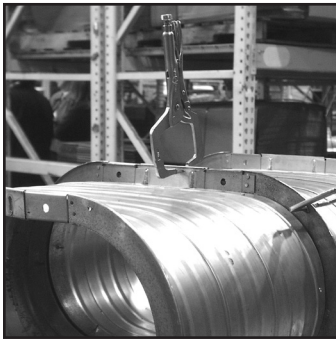
Connecting the Flat Oval Duct Sections



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



10. Fasten with 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.



9. 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.

LIMITED PRODUCT WARRANTY

Ductmate warrants that Econoflange Oval, 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 Oval, 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.



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