



The **EDGE**[®]

Self-Sealing Round Duct System



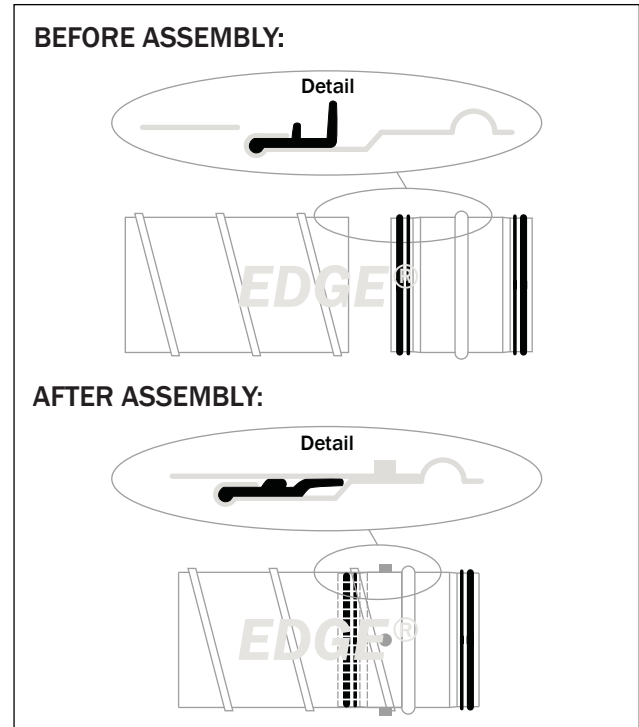
Stamped Fittings
LLC

The **EDGE**[®] – Features, Benefits & Materials

The **EDGE**[®] System will eliminate the sealing of all connections in your spiral pipe system. This system will not only provide a labor savings for the installer, it is a high efficient duct system and also great for exposed systems.

FEATURES

- All fittings will have a factory installed EPDM gasket, which has an operating temperature rating of -20°F to 212°F.
- The smoke and flame spread rating is 0/0.
- The gasket construction is a black EPDM two-wiper profile.
- The gasket is attached to the fitting with a 180° hemmed edge that will hold the gasket in place, as shown in the diagrams to the right.
- The connections are secured with self-tapping sheet metal crews per SMACNA standards.
- The **EDGE**[®] System allows for substantial space for insertion of the screws, because the gasket is located on the leading EDGE of the fitting. (NOTE: The use of sheet metal screws with a rubber gasket would insure that all screw holes are sealed as well.)
- The **EDGE**[®] System has been tested in accordance to SMACNA's Air Duct Leakage Test Manual and meets SMACNA Class 3 leakage standards.



BENEFITS

- Stronger fitting
- Eliminates sharp edge
- Consistent diameter
- Factory installed resulting in a cost savings
- The **EDGE**[®] gasket is treated with anti-friction coating for easy installation.

The **EDGE**[®] – Fittings & Materials

Fittings: 4" - 10" (all sizes), 12" - 60" (even sizes only)

Materials:

- Galvanized G60. Other materials available by request.
- Galvanized G90 also available by request (Fabricated only).

All fittings will be fabricated, except for Galvanized Stamped Fittings[®] listed below:

Elbows	4" - 12" = Stamped/Stitch Welded
Bellmouths	4" - 12" = Stamped 14" - 36" = Spun
90° Tee	4" - 12" = Fabricated body with Stamped Saddle Tap
90° Tap	4" - 12" = Stamped
All Other Fittings	Any fitting can be fabricated with gasket attached. All products will be fabricated per SMACNA standards and gauges. All fabricated fittings conform to SPIDA dimensional data.

The **EDGE**[®] – Construction

CONSTRUCTION (GAUGE):

- All duct and fittings are made per SMACNA's Duct Construction Standards (-2" W.G./+10" W.G.).
- Stamped Fittings are all 22 or 24 gauge.
- The following table shows diameter and gauges:

Diameter	Spiral Duct	Fabricated Fittings
4" - 24"	26 ga.	24 ga.
26" - 36"	24 ga.	22 ga.
38" - 60"	22 ga.	Max 20 ga.

Stamped Fittings [®]	4"	5"	6"	7"	8"	9"	10"	12"
GDSE	24 ga.	22 ga.	22 ga.	22 ga.	22 ga.	22 ga.	22 ga.	22 ga.
GDSE1	24 ga.	24 ga.	24 ga.	24 ga.	24 ga.	24 ga.	24 ga.	N/A
GDST	24 ga.	24 ga.	24 ga.	24 ga.	24 ga.	24 ga.	24 ga.	24 ga.
GBTO	24 ga.	24 ga.	24 ga.	24 ga.	24 ga.	24 ga.	24 ga.	24 ga.

CONSTRUCTION (PIPE):

- Spiral pipe
- Calibration of spiral is required by **The EDGE[®] System** manufacturer, Stamped Fittings

CONSTRUCTION (FITTINGS):

All **EDGE**[®] fittings, 4" – 60", will have a factory installed gasket that is attached to the fitting with a 180° hemmed edge for strength, rigidity and maintaining proper tolerances.

CONSTRUCTION (GASKET):

- **The EDGE**[®] gasket consists of a black EPDM rubber sealing material.
- The base and the sealing EPDM is classified according to ASTM D2000-86 M3BA 810 B13 C12 F17.
- The operating temperature is -20°F to 212°F.
- The smoke and flame spread is in accordance to ASTM 84-91A.

PRESSURE CLASS:

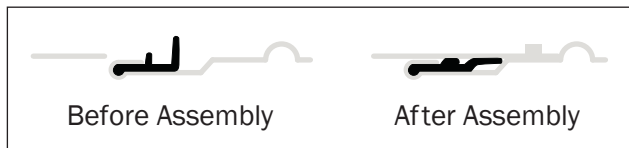
- **The EDGE[®] System** has been tested and meets the requirements of SMACNA's Leakage Class 3.

JOINT CONNECTIONS:

- All fittings are manufactured to slip fit into spiral duct. Any fitting to fitting connection can use a fitting coupling.

The **EDGE**[®] – Installation Instructions

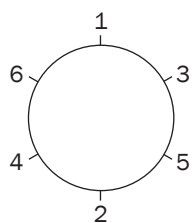
The **EDGE**[®] System fittings are made to fit tight, assuring a proper seal. Care should be taken when handling these fittings as damage could result in an improper fit and a difficult installation process.



WHEN INSTALLING:

1. 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.
2. Placement of the fastening screws should be opposite from one another, evenly spaced around the circumference (see diagram). Screws should be placed approximately 1/2" from the bead in order to avoid damaging The EDGE[®] gasket. In the event of incorrect installation, holes caused by the screws must be sealed before reassembly.

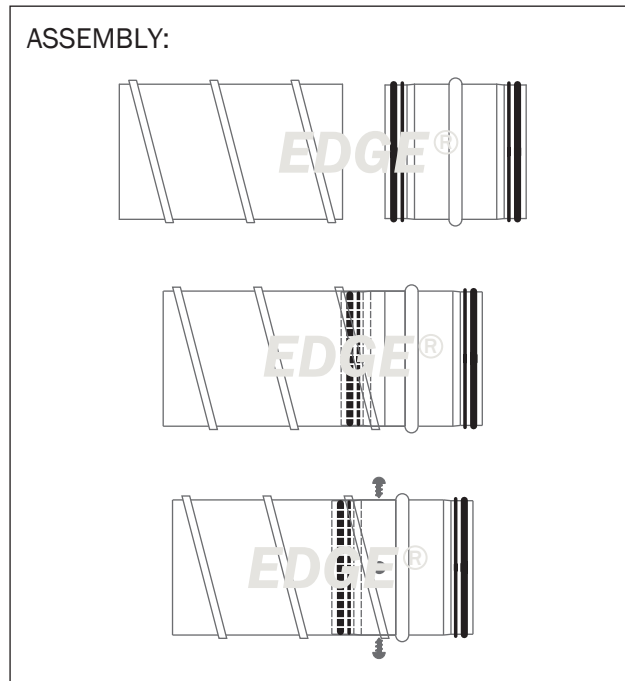
3. Quantities and sizes to be used are listed in the table below.



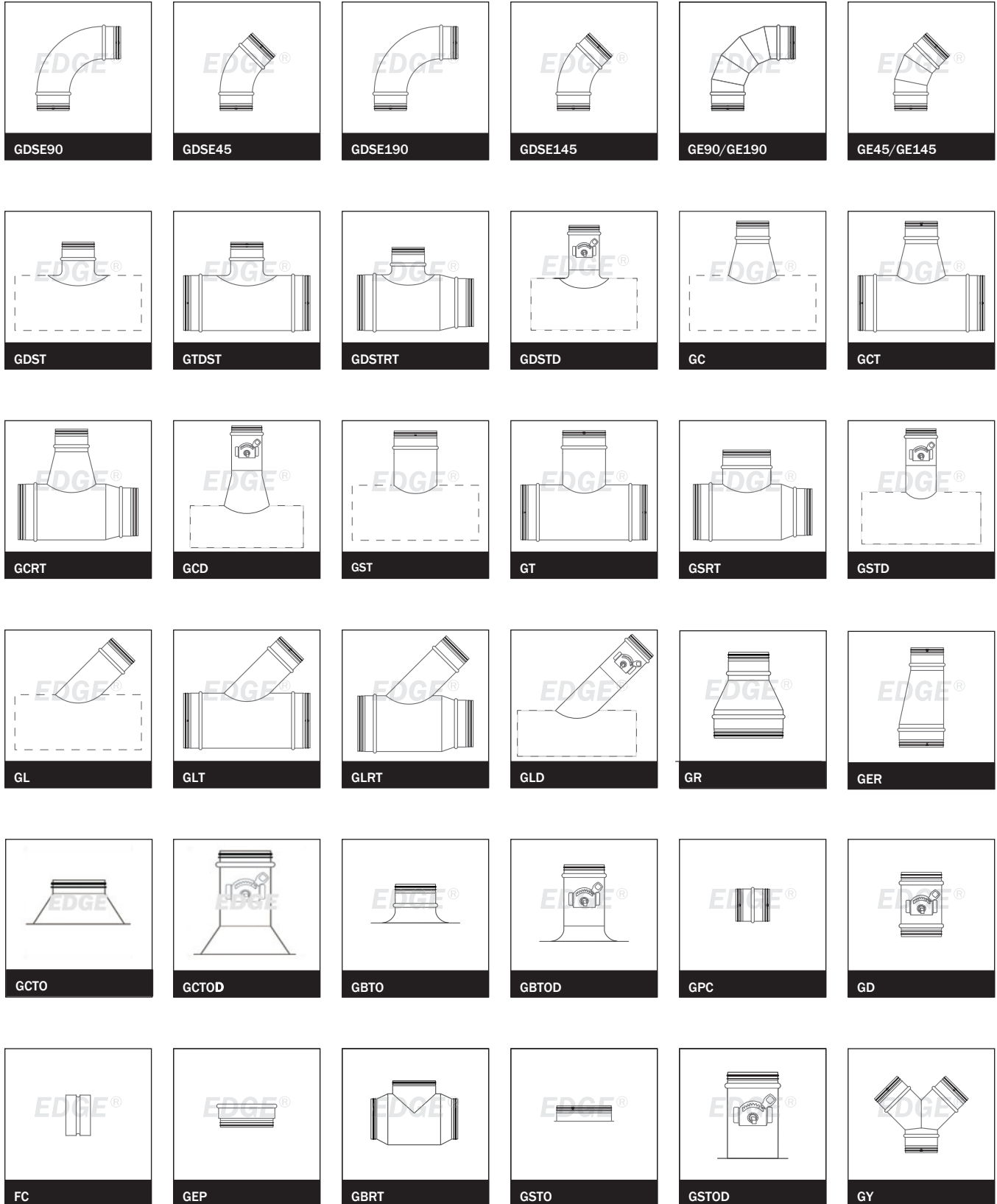
Spiral Duct Diameter	Screw Diameter	Quantity
3" - 5"	1/8"	2
6" - 10"	1/8"	3
12" - 24"	1/8"	4
26" - 36"	1/8"	6

4. Always start the first fastener at the largest radial gap between fitting and duct. Be sure to achieve even distribution around the circumference.

ASSEMBLY:



The EDGE® – Products



All of **The EDGE® System** products in this catalog are manufactured & distributed by **Stamped Fittings®**

The EDGE® – Products

