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**Low Pressure Installation — Duct to Collar — Up to 3” W.G.**

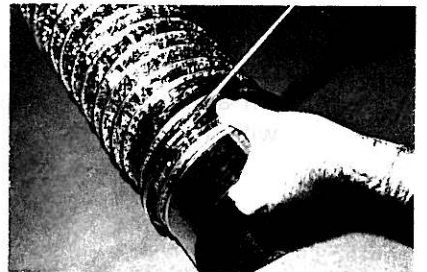
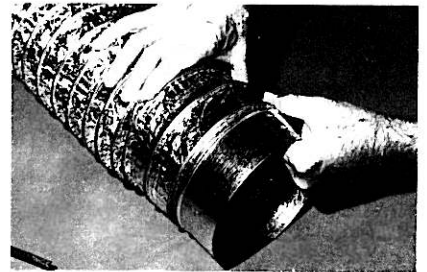
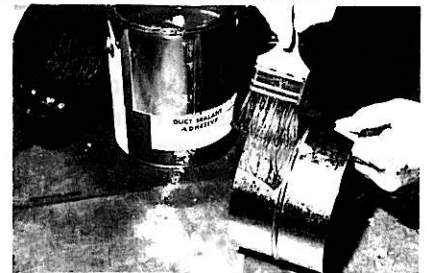
- 1) If duct is insulated, first peel back outer skin and insulation approximately 4” to expose core.
- 2) Slide core over collar.
- 3) For soft core flex — apply 2 wraps of tape then apply metal screw clamp or drawband over the tape.
- 4) For corrugated aluminum flex — apply 3 sheet metal screws to fasten core to collar then wrap joint with 2 wraps of tape to cover screw heads and to lap over the core collar joint to form a seal.
- 5) If insulated, pull insulation and outer jacket back into position. Tape over outer skin 2 wraps to seal insulation, or approved clamp may be used in place of or in combination with the duct tape.

FOR DUCT TO DUCT CONNECTIONS SEE INSTRUCTION “A” REVERSE SIDE.



**High Pressure Installations — Above 3” WG  
Duct to Collar or  
Duct to Duct using Internal Sleeve**

- 1) If duct is insulated first peel back outer jacket and insulation approx. 4” to expose duct.
- 2) Apply sealer to inside of duct and to outside of collar or in joining duct to duct, apply sealer to half length of sleeve on outside.
- 3) Slide duct over collar or half length of sleeve.
- 4) If joining duct to duct, repeat sealer application in second piece of duct and on exposed end of sleeve. Slide second piece of duct over exposed sleeve. Smooth out any surplus sealer.
- 5) Tape with 2 wraps around joint and apply clamps over outside of tape.
- 6) If insulated, pull insulation and outer jacket back into position. Tape over end of outer skin with 2 wraps to seal insulation, or approved clamp may be used in place of or in combination with the duct tape.



**Materials Required**

**Duct Tape** — Use tapes listed and labeled in accordance with standard UL 181B and marked “181B-FX”

**Drawbands** — Nonmetallic clamps shall be listed and labeled in accordance with Standard UL 181B and marked “181B-C” “Use of non-metallic clamps shall be limited to 6 in. w.g. (1500 Pa) positive pressure”.

**Sleeves** — 5” min. length

**Duct Sealer** — Use mastics listed and labeled to standard UL 181B and marked “181B-M” on container. (high pressure only)

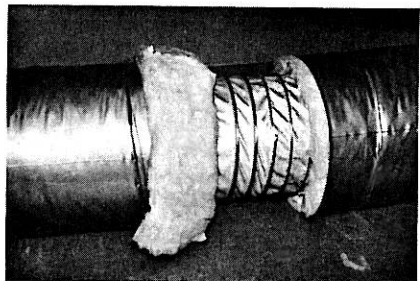
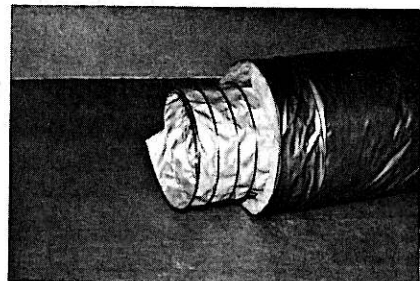
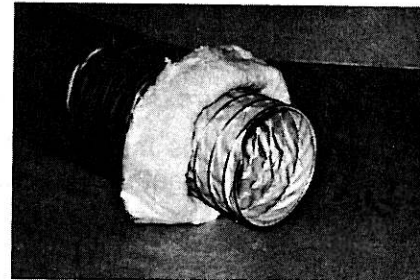
**Air Connectors are limited to 14’ lengths.**



## FLEXMASTER U.S.A., INC.

### LOW PRESSURE INSTALLATIONS – UP TO 3" WG INSTALLATION INSTRUCTIONS 'A'

- 1) Trim end of duct so vapor barrier insulation and core are flush. Trim fabric back to metal strip. Peel back vapor barrier and insulation four inches from end of core.
- 2) Trim second piece of duct. Peel vapor barrier only back four inches. Cut away exposed insulation, being careful not to cut either vapor barrier or core. Trim core material back to metal strip. Turn in end of metal approximately ¼ inch to prevent it snagging fabric.
- 3) Screw second core inside first three full turns. Check that helix of inside core tracks properly into helix of outside core without crossthreading. Pull joint lengthwise to take up slack. If insulations will not butt together, screw in further until insulations butt.
- 4) Peel back vapor barrier and insulation again approximately three inches each side of joint. Tape core with two wraps of tape, each wrap overlapping previous wrap at least 25% and following natural path of duct helix.
- 5) Fold insulation and vapor barrier back over core joint. Tape barrier with two wraps of duct tape lapped approximately 25%. An approved clamp may be used in place of or in combination with the duct tape.



#### Materials Required

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**Drawbands** – Nonmetallic clamps shall be listed and labeled in accordance with Standard UL 181B and marked "181B-C" "Use of non-metallic clamps shall be limited to 6 in. w.g. (1500 Pa) positive pressure".

**Air Connectors are limited to 14' lengths.**

**Sleeves** – 5" min. length

**Duct Sealer** – Use mastics listed and labeled to standard UL 181B and marked "181B-M" on container. (high pressure only)