STERLING THERMAL

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AIRLITE KD METHOD STATEMENT

FLANGED COMPONENTS

- Stipulate from the outset that all flanged components need to be "Mezz 40"
- Apply gasket to one of the flanged faces and line the component up and secure using 8mm bolts, washers & nuts. Use additional Mezz clamps on wider ducts as per DW144
- In the event that the bolt holes do not line up or the component has inadvertently been supplied with an incorrect flange then drill through the component's flange into the duct (flange) and secure with rivets or screws. Use additional Mezz clamps on wider ducts as per DW144
- The latter will probably be the only practical method with 33mm thick KoolDuct
- This method negates the possible reaction between dissimilar metals and keeps all duct sections uniform

FITTING ACCESS DOORS

- Use a standard galvanised insulated "tabbed" type access door
- Carefully cut a hole in the main duct to suit the external dimensions of the door using a craft knife
- Fit 19x19mm galvanised angle inside the hole (not front) and seal with tape so that both angle and foam are covered
- Socket door into hole & drill through tabs into angle and secure with rivets or screws.
- Ensure door gasket is well compressed to form seal

FITTING KOOLDUCT SHOES

- Shoe to be supplied with the bottom extension (of the leading edge) 22mm long and sealed with foil tape so foam is covered
- Carefully cut a hole in the main duct to suit the external dimensions of the shoe using a craft knife & seal with foil tape so foam is covered
- Socket shoe into hole & tape inside the duct and apply KoolDuct silicone on the face of the main duct around the shoe
- Larger shoes (over 500 wide) will need additional 19x19mm galvanised angle fitted inside the duct (not front) and fixed together using screws or rivets
- The branch duct must have a support as close to the shoe as possible as per DW144

FITTING GALVANISED SHOES

- Standard flat galvanised shoe required
- Carefully cut a hole in the main duct to suit the internal dimensions of the shoe & seal with foil tape so foam is covered
- Apply KoolDuct silicone to the back of the return edge of the shoe and fit it over the hole squashing the mastic between the return edge and the main duct, temporarily holding it into position with tape if need be.
- If a mechanical fixing is required place 19x19mm galvanised angle strips inside the duct top & bottom of the hole and drill through return edge through foam into the angle & use rivets or screws to fix
- Ensure KoolDuct silicone is smoothed around return edge and main duct to provide a seal
- Tape inside the flat shoe and the main duct to provide a seal (this method alone can be used instead of a mechanical fixing on smaller shoes providing a support is as close to the shoe as possible as per DW144)

SPIGOT COMPONENTS

- Apply gasket to the duct flange and socket the component into the end of the duct (duct = female component = male)
- Drill through the top of the duct flange into the component's spigot and secure with rivets or screws.
- As an alternative 19x19mm galvanised angle can be used in lieu of duct flange.

IMPORTANT !!

FOAM MUST NOT BE EXPOSED WITHIN THE AIRSTREAM

ONLY USE KOOLDUCT SILICONE