



The **EDGE**[®]

Self-Sealing Round Duct System



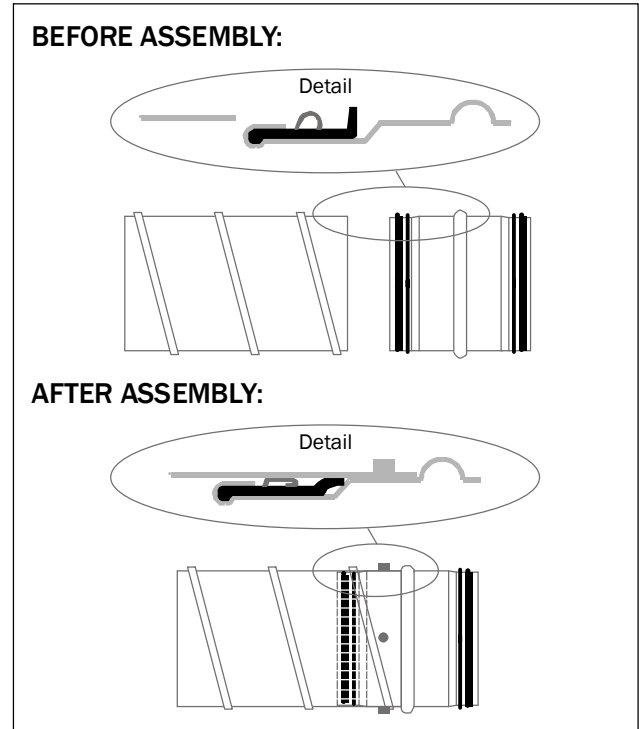
Stamped Fittings
INCORPORATED

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 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 of a black EPDM base with a wiper for machine application and a gray EPDM hollow seal that will act as the sealing section.
- 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 screws 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.
- The **EDGE**[®] System has been tested in accordance to SMACNA's Air Duct Leakage Test Manual (1st Edition - 1985, printing #7 - 2003) and meets SMACNA Class 3 leakage standards.



BENEFITS

- Stronger fitting
- Eliminates sharp edge
- Consistent diameter
- Factory installed resulting in a cost savings

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

Fittings: 4"-10" (all sizes), 12"-36" (even sizes only)

Materials: Galvanized, Galvaneal, Stainless Steel Type 304 & 316, Aluminum.

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

| | |
|-------------------|--|
| Elbows | 4"-12" = Stamped/Stitch Welded |
| Reducers | 4" - 36" = Spun (where reduction is 6" or less) |
| 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 & Installation Instructions

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 | Fabricated Fittings |
|-----------|-------------|---------------------|
| 4" - 14" | 26 ga. | 24 ga. |
| 16" - 26" | 24 ga. | 22 ga. |
| 28" - 36" | 22 ga. | 20 ga. |

(Stamped Fittings are all 22 Gauge. Spun Fittings are all 20 Gauge.)

CONSTRUCTION (PIPE):

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

CONSTRUCTION (FITTINGS):

All **EDGE**® fittings, 4" – 36", 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 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.

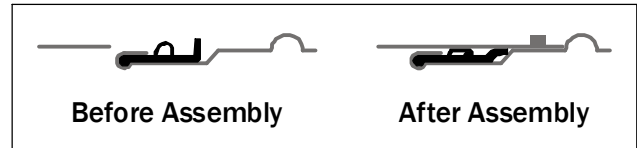
PRESSURE CLASS:

- **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:

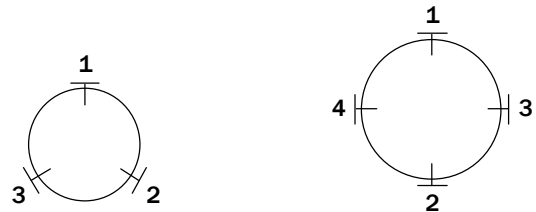
- All fittings are manufactured to slip fit into spiral duct.
- All fitting to fitting connections will use a fitting coupling.

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:

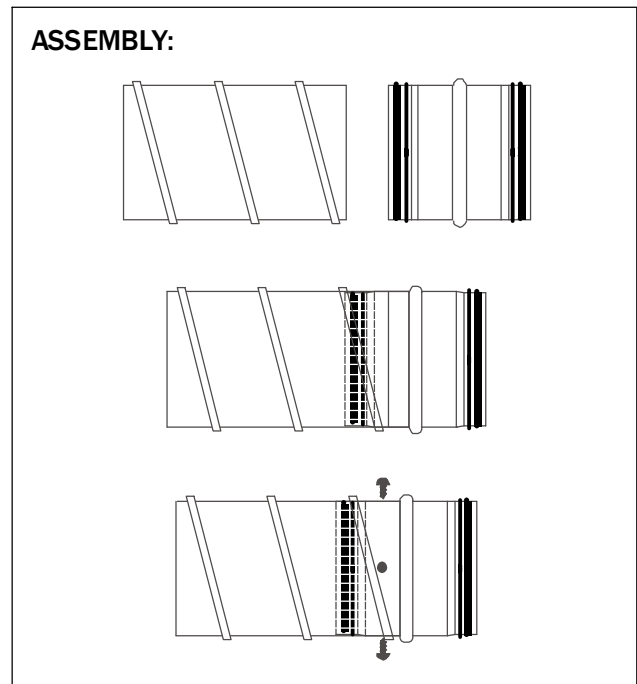
1. Place the hemmed **EDGE** of the fitting in the spiral pipe then apply pressure and the fitting will slip into place, stopping at the bead/pipe stop.
2. Using self-tapping sheet metal screws, place the screws 3/4" from the bead/pipe stop. The gasket and fittings are designed to allow adequate room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



4" - 10" Diam. Pipe

12" - 36" Diam. Pipe

ASSEMBLY:



Patent Pending US 2006-0006610A1

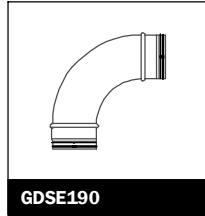
The **EDGE**[®] – Products



GDSE90



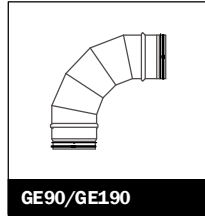
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GDSE190



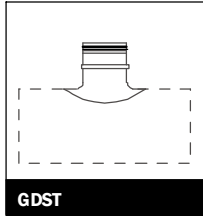
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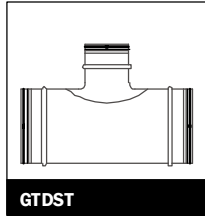
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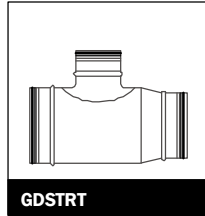
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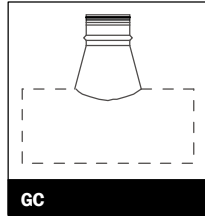
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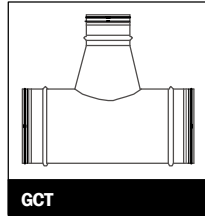
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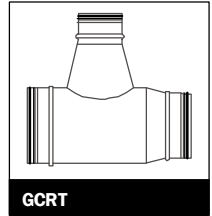
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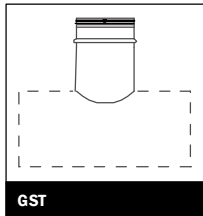
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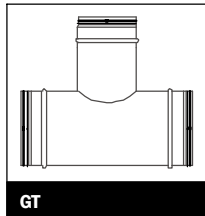
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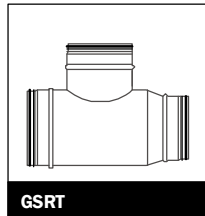
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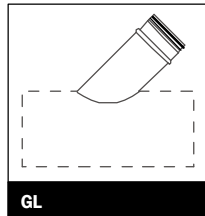
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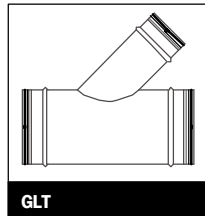
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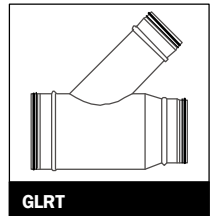
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GL



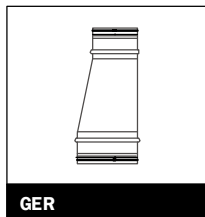
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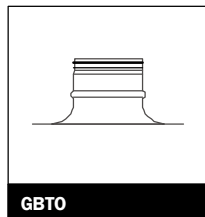
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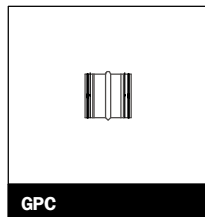
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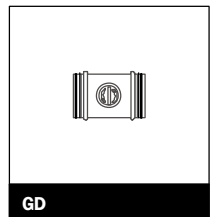
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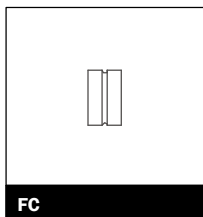
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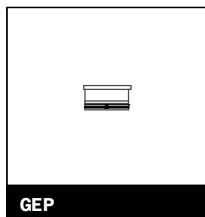
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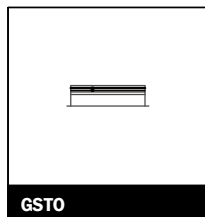
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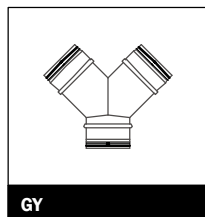
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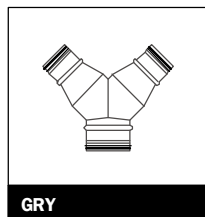
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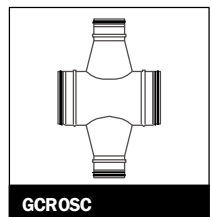
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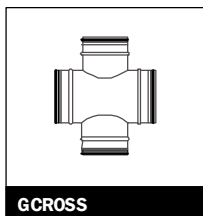
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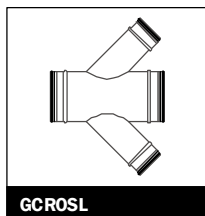
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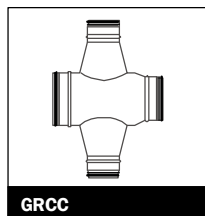
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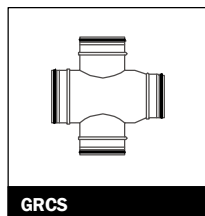
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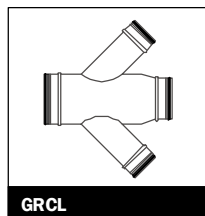
GCROSL



GRCC



GRCS



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

Revised January 2010