

# INSTRUCTIONS FOR ATTACHING THE DUCTMATE INNER RING FOR DOUBLE WALL DUCTWORK



1. Using the instruction provided with your Spiralmate system, attach the Spiralmate flanges to the sections of round ductwork.  
*Note: Depending upon the pressure class a bead of sealant must be applied to the split in the Spiralmate flange prior to installation of the inner ring.*



7. Welds may need to be ground down before proceeding with the application of the Neoprene gasket. No fasteners with a head larger than 1/16" in height may be incorporated when attaching the Ductmate Inner Ring to the Spiralmate flange.



2. Check the alignment of the liner to assure even spacing of the liner in comparison to the outer wall of the ductwork.



8. Begin applying Ductmate Neoprene gasket at the seam of the ring favoring the outside edge of the connection. The neoprene gasket must be applied to the outside edge of the Ductmate Inner Ring, allowing it to adhere to both the ring and the Spiralmate flange.



3. Slide the Ductmate Inner Ring over the inner wall of the ductwork. Seat the ring firmly against the edge of the Spiralmate flange.



9. Complete the gasket application by installing Ductmate Neoprene gasket on the face of the flange around the entire circumference of one of the mating flanges. The end of the gasket should butt up to the beginning.



4. With the Ductmate Inner Ring firmly pressed against the edge of the ductwork, start attaching the ring to the inner liner starting at the split and working in one direction. Make sure the ring is properly seated as you attach it to the liner.



10. Finish the connection by slipping the outer closure ring over the end of the duct. Align the flanges using the Spiralmate alignment grips.



5. The Ductmate Inner Ring should be attached using rivets, screws, stitch welds or tack welds every 12" to 18" on center. The Inner Ring was designed to incorporate a minor gap at the split. This gap will not affect the performance of the finished system. An overlap is not recommended as it may hinder the installation of the Closure ring.



11. Slide the closure ring over the mating flanges and insert the bolt.



6. Begin attaching the outer leg of the ring to the face of the Spiralmate flange. Using stitch welds, tack welds or rivets, secure the outer leg to the flange every 12" to 18" on center making sure to keep the inner ring centered with the outer wall of the duct.



12. Tighten the bolt on the closure ring until it makes even contact around the circumference of the duct sections. Tap around the joint with a hammer if necessary to seat the flange while tightening the bolt.

