

# Pre-insulated round air duct system assembly instruction IF



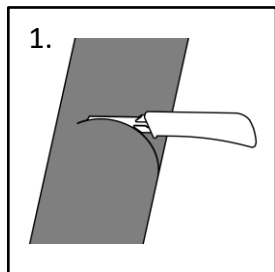
Before installation, carefully read an assembly instruction!

Wear protective gloves during assembly, possible sharp edges

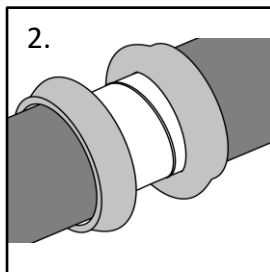
**Caution!**

Be careful with the insulation when transporting, during assembly and maintenance

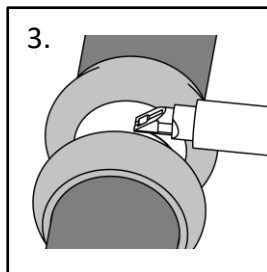
## Insulation cutting



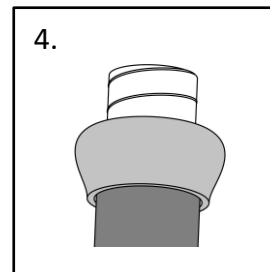
1. Cut the insulating material around the duct using a knife or other suitable tool. Make sure the insulation is cut all the way down to the air duct



2. Cutted insulation is folded back or pulled to the side so that it is not damaged during the cutting of the air duct

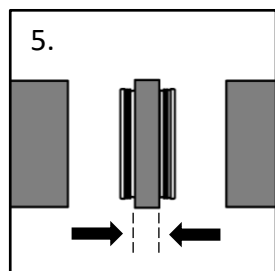


3. Cut the air duct using scissors or another suitable tool. While cutting, ensure that metal shavings do not damage the insulation

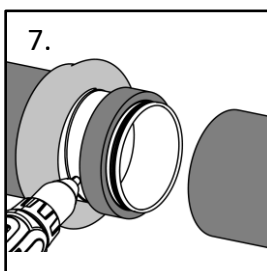
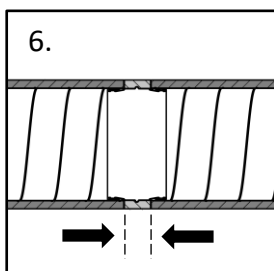


4. Ensure that the cut of the air duct is smooth, without sharp edges or burrs that could damage the insulation or the sealing gaskets of the connection

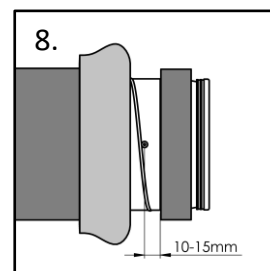
## Connecting parts



5. Air ducts, when connected to fittings, must be butted to ensure a seal. The insulation should not create gaps in the joints

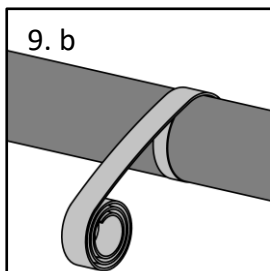
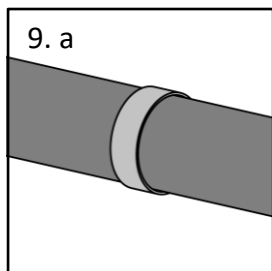


7. Use metal screws or rivets to attach the joint elements to the air duct. Refer to (Table 1.) for the recommended fastener sizes and amount



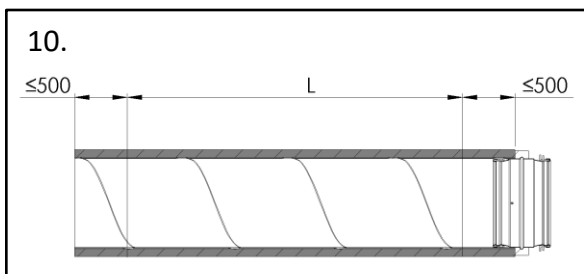
Air duct diameter [mm]	Screws		Rivets		Number of fasteners [pcs]
	Length [mm]	Diameter [mm]	Length [mm]	Diameter [mm]	
80 - 100	9,5	3,2	8	3,2	2
125 - 160	9,5	3,2	8	3,2	3
200 - 250	9,5	3,2	8	3,2	4
315	13	4,2	9,5	4	4

1. Table. Sizes and amount of fasteners

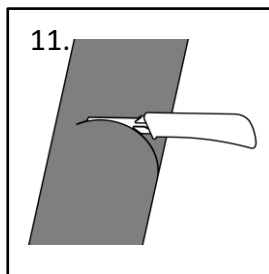


Joining points are covered with a sealing insulation ring gasket (im. 9. a) or self-adhesive insulating tape (im. 9. b)

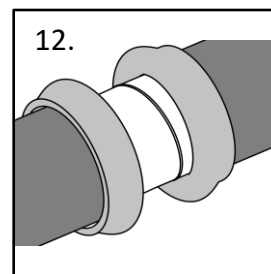
### Placement of air duct brackets



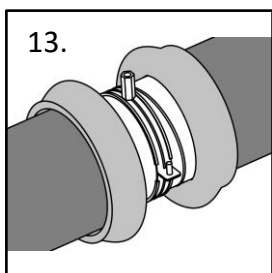
Install brackets in a straight line and as close as possible to each joint. The maximum distance (L) between brackets should not exceed 3 m



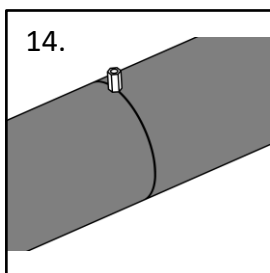
Cut the insulating material around the duct using a knife or other suitable tool. Make sure the insulation is cut all the way down to the air duct



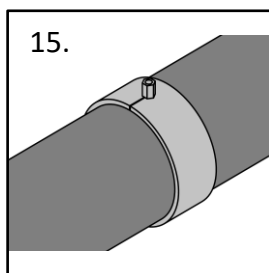
The cut insulation is folded or pulled to the sides so that it is not damaged during the installation of the holding brackets



Install brackets directly on the air duct



Flap the insulation in place to cover the mounting bracket. If necessary, make incisions in insulation



The joint of insulation are covered with a sealing insulation ring gasket or self-adhesive insulating tape. Incisions are made if necessary