INSTALLATION INSTRUCTIONS

SEMCO's Velocity™ gasketed joint system will save you time and money when installing a duct system. SEMCO manufactures this product to very close tolerances to make sure the gasket blade seals securely. In order to maintain these tolerances and achieve the desired integrity of the joint, please follow these installation instructions carefully.

1. Inspect the product:

Carefully inspect to make sure that all ends are round (See **Figure 1**) and have not been damaged in shipment or handling.

FIGURE 1. Inspect the product

2. Straighten edges (if necessary):

Some minor deformation can occur during the shipping and handling process (See **Figure 2**). This minor deformation can be corrected in the field. It is important that the round shape of both spiral duct and fitting ends be maintained to ensure the proper sealing of the gasket ring. Check the spiral duct ends and remove any burrs and/or other sharp edges to avoid cutting the gasket ring.

FIGURE 2. Straighten edges

3. Installation:

Ensure gasket is in its groove approximately ½" from end of fitting. Orient the fitting in the position required for installation. The illustration to the right and the image (See **Figure 3**) show gasketed fitting aligned for assembly.

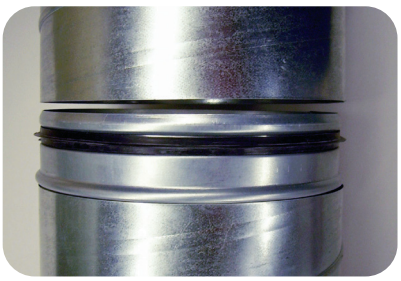


FIGURE 3. Aligned for assembly

4. Velocity Gasket:

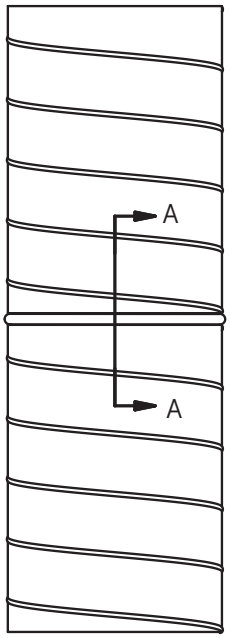
Just slide the joint together and the "T" shaped gasket will lay back in place (See **Figure 4**), sealing the fitting.

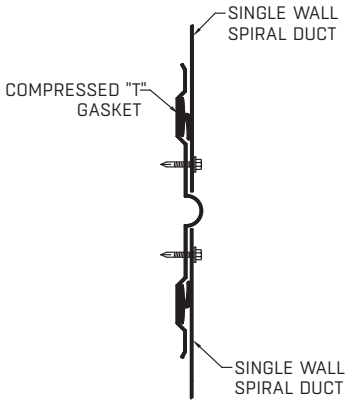
! Do not use of any type of oil to lubricate the gasket.

FIGURE 4. Gasket will lay back in place

5. Fully installed Velocity gasket:

Once the gasket is completely inserted into the duct end, slide the pieces together until the duct end contacts the fitting bead.





SECTION A-A
VELOCITY DUCT
GASKET CONNECTION

Cutaway image illustrates the gasket in its final position, sealing the fitting

6. Mechanically fasten:

Once the piece is in place, fasten the joint by placing tek screws or pop-rivets .5" to .75" from the bead (figure 6). This distance should be maintained to avoid placing a fastener through the gasket.

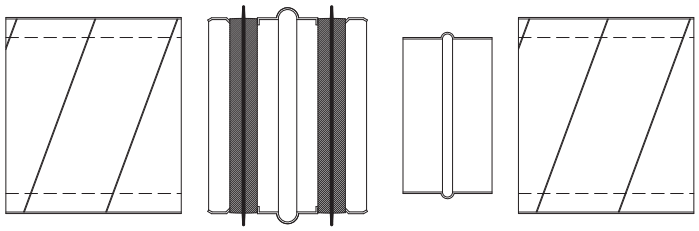
Recommended tek screw size is #10 x ¾, zinc plate. Note that even spacing of fasteners will equalize pressure on the gasket seal.

FIGURE 6.
Mechanically fasten

SMACNA recommends that screws be placed at uniform intervals (15" maximum) along the circumference of the duct joint. Minimum of 3 screws per joint.

Dual Wall Velocity

Dual wall Velocity assembles similar to the single wall product with the gasket installed on the OD (shell) only. For a duct-to-duct connection, insert inner coupling into duct first followed by the outer gasketed coupling. A duct-to-fitting connection is similarly installed by starting the leading edge of the inner liner first and following with alignment of the OD shell. A straight alignment of the two assemblies will allow the joint to slip together securely.



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