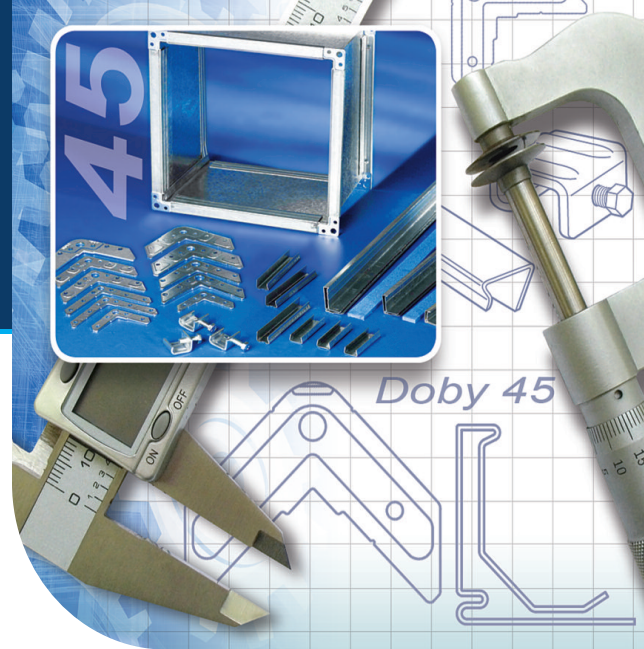


## Ductwork Components

# Doby 45 Ductwork Jointing Profile

## Slide on Flange Details & Specifications

- Provides for rapid assembly of cross joints.
- Integral pocket with permanently flexible non-toxic sealant.
- Height nominal 45mm.
- Fully conforms to UK, BESA Specification DW/144 (2013).
- Awarded Quality Assurance Certification BS EN ISO 9001.
- Full range of accessories to suit flange profile.
- Tested & certified by BSRIA in accordance with the BESA (formally HVCA) test procedures DW/TM1.
- Joint rating is J5 for all pressure classes and J6 for low pressure. When using a centrally fitting tie bar the Doby 45 profile increases to J6 for medium and high pressure.



## Doby 45 Flange Profile

New from Doby Verrolec is the Doby 45 flange profile. The 45 is suitable for applications with duct gauges that are no greater than 2mm thick or lighter than 0.2mm. J ratings up to J6 in all four pressure classes (with a central tie bar for B,C & D classes).

## Design Specification

During the manufacturing process the sealant pocket is rolled into the profile and airtightness is ensured by the inclusion of a non-toxic sealant. The corner is formed to enable the duct to pass into the integral sealant during fabrication.

All rectangular ductwork cross joints shall be the Doby slide on flange type complete with captive sealant pocket with integral permanently flexible non-toxic sealant, consisting of

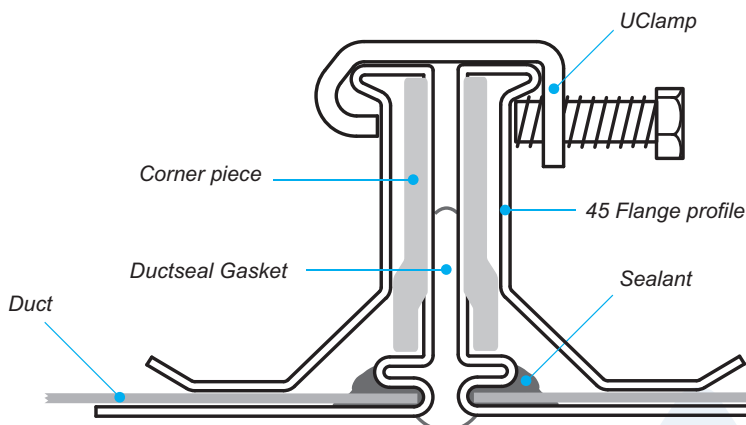
## Joint Ratings & Pressure Classes

Doby DV45 J Ratings				
Joint rating	Pressure Class			
	A	B	C	D
J4	✓	✓	✓	✓
J5	✓	✓	✓	✓
J6	✓	✓*	✓*	✓*

\* With central tie bar

a Galvanised MS Profile and EZP Corner Pieces. The appropriate size of flange shall be fitted to the ductwork as covered by the construction tables 2 to 4 of specification DW144, shall be independently tested to the procedures of BSRIA in accordance with HVCA specification DW/TM1 and as manufactured by Doby Verrolec. The flanges shall be fitted to the ductwork and assembled on site with the appropriate gasket all to the manufacturers instructions.

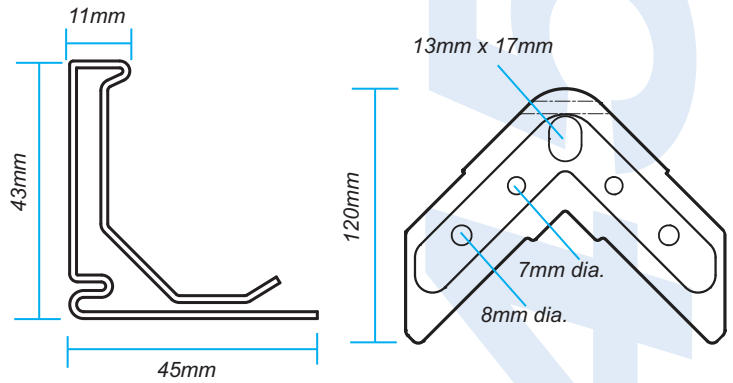
## Doby 45 Profile - Cross Section



## Product Details and Specification

### DV45 Profile, Corners & Clamps

	Gauge (mm)	Weight (Kg)
DV45 Flange Profile	1.2	1.58 (per M)
DV45C Corner Piece	3.0	7.3 / 50
UClamp (Universal)	3.0	9.2 / 200



## Ductseal Gasket

A cross linked Medium Density P.V.C. closed cell foam combined with a high grab sensitive adhesive to give good all round sealing properties. Temperature range  $-40^{\circ}\text{C}$  to  $+70^{\circ}\text{C}$ . We recommend the use of the appropriate gasket to ensure performance in accordance with our DW/TM1 test results, where application allows. Supplied in green for easy identification.

## Steel & Coatings

### Profiles

British Standard BS EN 10142:2000 steel grade & coating. Specification EN 10142 DX51D +Z275-N-A-C Integral sealant, Evode Glasticon 126 solvent free permanently non-setting mastic.

### Corners

Hot rolled steel to BS EN 10111:1998.

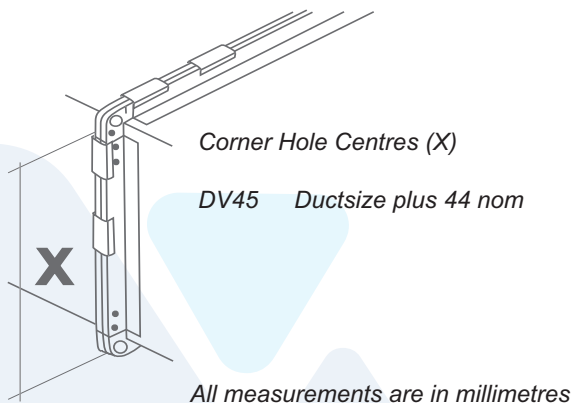
Steel grade EN 10111 - DD11 Pickled & Oiled finish - Zinc and clear passivate to BS EN 12329 - Fe/Zn5/A.

### Clamps

Steel Grade EN 10111:1998-DD11 Pickled & Oiled Finish - Zinc and clear passivate to BS EN 12329-Fe/Zn5/A.

Doby profiles conforming to DW/TM1 are also available in lighter gauges.

## Corner Hole Centring



## Packing details

### DV45 Profile

Bundles of 250m,  
5000mm standard length.

### Corner Pieces

DV45C in boxes of 50.

### Clamps

UCLAMP in boxes of 200.

### Gasket

572A Gasket in cartons 20 rolls x 15m.

## Clamp Spacing

Clamps should be equally spaced with a maximum 600mm centres. Doby Verrolec recommend fitting the clamps 50mm in from the corner for minimal air leakage.

