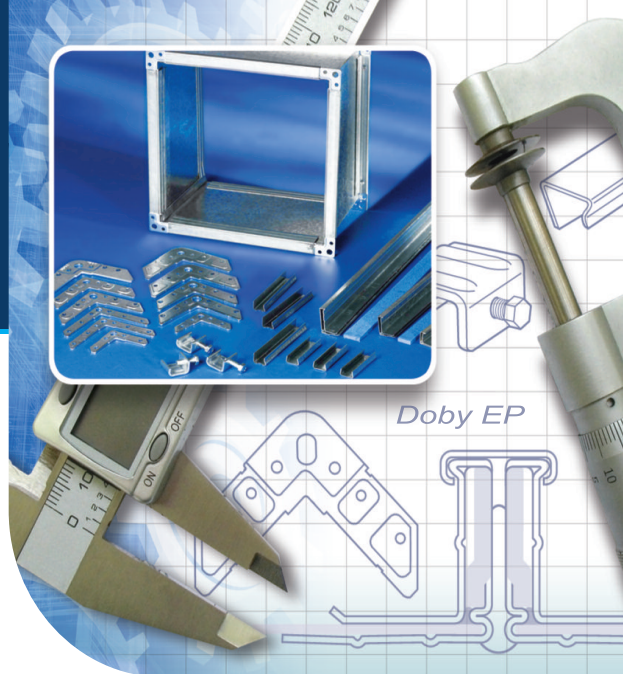


## Ductwork Components

# Doby Ductwork Jointing System

## Slide on Flange Details & Specifications

- Provides for rapid assembly of cross joints.
- Integral pocket with permanently flexible non-toxic sealant.
- Available in standard Euro sizes of 20mm, 30mm and 40mm.
- Fully conforms to UK, B&ES Specification DW/144 (2013).
- Awarded Quality Assurance Certification BS EN ISO 9001.
- Full range of accessories to suit all sizes of flange.
- Tested & certified by BSRIA in accordance with the B&ES (formally HVCA) test procedures DW/TM1.
- Suitable for B&ES specification DW/144 for Joint Ratings up to J6 and pressure classes A, B, C & D.



## Design Specification

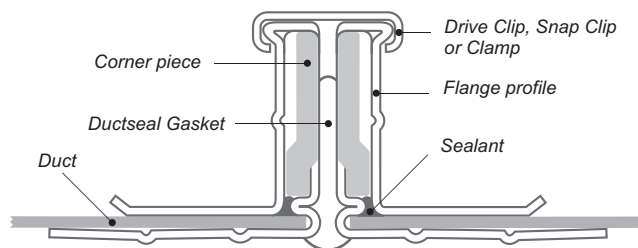
During the manufacturing process the sealant pocket is rolled into the profile and airtightness is ensured by the inclusion of a non-toxic sealant.

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 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 Profile - Cross Section



## DW/TM1 Test Results

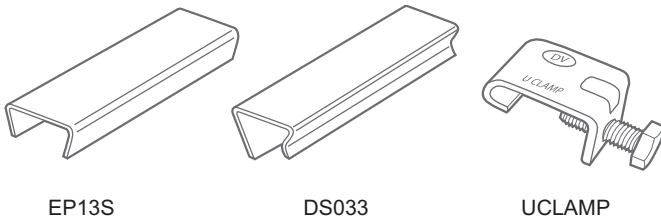
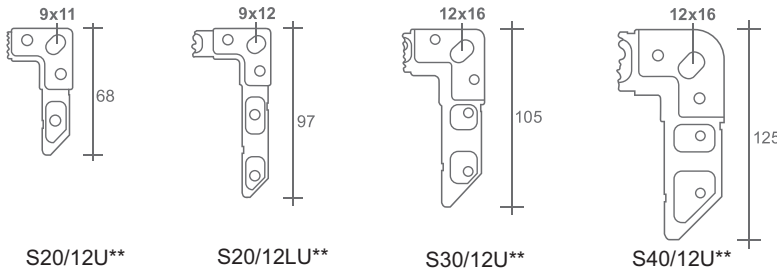
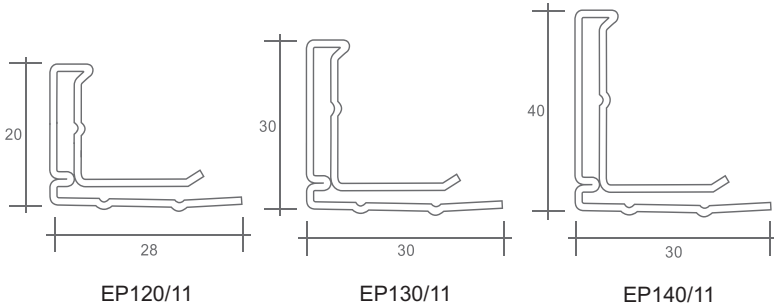
Profile	Joint Rating	Pressure Class			
		A	B	C	D
EP120/11	J2	✓	✓	✓	✓
EP130/11	J3	✓	✓	✓	✓
EP130/11	J4	✓	✓	✓	✓
EP140/11	J4	✓	✓	✓	✓
EP130/11 <sup>(1)</sup>	J5	✓	✓	✓	✓
EP140/11 <sup>(1)</sup>	J5	✓	✓	✓	✓
EP140/11 <sup>(1)</sup>	J6	✓	✓	✓	✓

As tested by BSRIA in accordance with HVCA specification DW/TM1 test procedures March 1996.

(1) When used with central Tie Bar as tested by BSRIA in accordance with HVCA specification DW/TM1 test procedures.



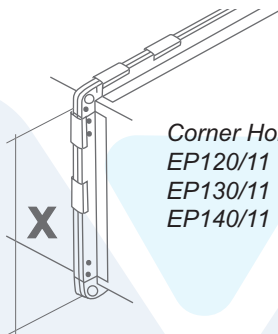
## Product Details & Specifications



## Ductseal Gasket

A cross linked closed cell polythene foam combined with a high grab sensitive adhesive to give good all round sealing properties. Temperature range  $-70^{\circ}\text{C}$  to  $+95^{\circ}\text{C}$ . We recommend the use of the appropriate 'DUCTSEAL' gasket to ensure performance in accordance with our DW/TM1 test results. Supplied in blue for easy identification.

## Corner Hole Centering



Corner Holes Centres (X)  
 EP120/11 Ductsize plus 20 nom  
 EP130/11 Ductsize plus 30 nom  
 EP140/11 Ductsize plus 40 nom

## Flange Profiles

	gauge(mm)	weight(kg)
EP120/11	0.8	0.590/m
EP130/11	1.0	0.869/m
EP140/11	1.25	1.234/m

Steel grade and surface coating BS EN 10346:2015 DX51D +Z275 MAC. Integral sealant, Evode Glasticon 126 solvent free permanently non-setting mastic.

## Corner Pieces

	gauge(mm)	weight(kg)
S20/12U	2.3	7.2/200
S20/12LU	2.3	9.4/200
S30/12U	2.3	7.6/100
S40/12U	3.0	7.4/50

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.

## Clips and Clamp

	gauge(mm)	weight(kg)
EP13S	0.8	5.4/200
DS033	0.8	8.2/200
UCLAMP	3.0	14.0/300

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.

## Packing details

### Profiles

Bundles of 250m,  
 5000mm standard length, 3000mm to order.

### Corner Pieces

S20/ in boxes of 200  
 S30/ in boxes of 100  
 S40/ in boxes of 50

### Clips

EP13S in boxes of 200  
 DS033 in boxes of 200

### Clamps

UCLAMP in boxes of 300

### Gasket

DS120 in cartons of 510m (34 rolls)  
 DS130 in cartons of 300m (20 rolls)  
 DS140 in cartons of 300m (20 rolls)

### Corner Nuts and Set Screws

DS160 - DS163 in boxes of 250

\*\*Corners are available with a standard round hole if required, please refer to sales office.