



**TECHNICAL
INFORMATION**

PROJECT: _____
 LOCATION: _____
 ARCHITECT: _____
 ENGINEER: _____
 SALES ENGINEER: _____
 DATE: _____



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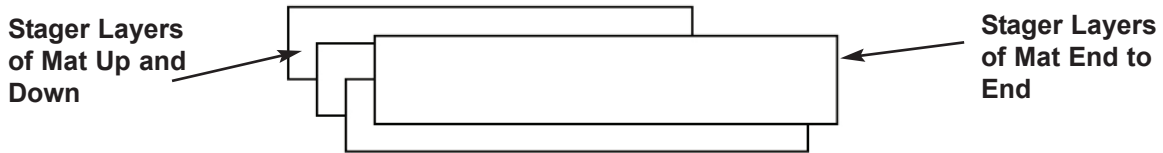
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Joining Instructions for Wet Lay-Up General Information

Joining

Coat all raw edges with resin mix; slightly squeezing the sections together. It is often desirable to speed-up the hardening time for this step by increasing the catalyst (MEK) required by 1 to 2 cc per pound. Insure that interior surface is relatively smooth, however a light "bead" on the interior is desirable and acceptable.

Butted sections may be "hot patched" to hold the alignment until the complete joint can be made. A tab consists of 2-3" square of glass mat saturated with resin mix. Place prepared hot patch across joint to be made to form "tack weld." Three are usually sufficient. For this step, it is often desirable to speed-up the hardening time of the resin by increasing the MEK catalyst by 1 to 2 cc per pound.



Preparation

Prepare fiberglass mat (and woven roving, where required) according to the vendor's specifications or cut sufficient quantity according to size and ply requirements.

Table 1

Inside Duct Diameter	# of Layers Mat			Woven Roving	# of Layers Mat		Inside #	
	2" wide	4" wide	6" wide		8" wide	10" wide	10" wide	Surface Veil
4" to 6"	1	2	0	0	0	0	0	0
8" to 12"	0	1	2	0	0	0	0	0
14" to 20"	0	1	1	0	1	0	0	0
22" to 36"	0	1	1	0	2	0	2	1
38" to 60"	0	1	2	1	2	0	2	1

Table 2

4" to 6"	3m
8" to 12"	3m
14" to 20"	3m
22" to 36"	4m, v
38" to 60"	3m; 1wr; 2m; v

m= 1.5oz/ft²
 wr=24.5oz/ft²
 v=Surfacing Veil

* Joint thickness should be as least as thick as the pipe to be joined