



**TECHNICAL  
INFORMATION**

PROJECT: \_\_\_\_\_  
 LOCATION: \_\_\_\_\_  
 ARCHITECT: \_\_\_\_\_  
 ENGINEER: \_\_\_\_\_  
 SALES ENGINEER: \_\_\_\_\_  
 DATE: \_\_\_\_\_



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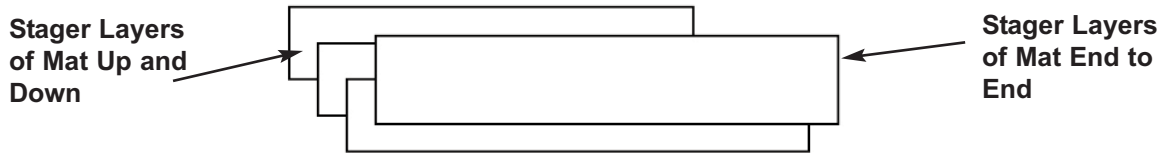
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**Joining Instructions for Wet Lay-Up General Information**

**Joining**

Coat all raw edges with resin mix, completely filling the joint and slightly squeezing the sections together. It is often preferable to add sufficient Cab-O Sil to resin for this step to produce a paste or light putty which will fill small voids and irregularities if there is not a good fit. It is often desirable to speed-up the hardening time for this step also by increasing the MEK catalyst required by 1 to 2 cc per pound. Insure that interior surface is relatively smooth but 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**

Duct Wall Thickness	Minimum Total Width of Overlays
1/8"	4"
3/16"	4"
1/4"	4"
5/16"	5"
3/8"	6"
7/16"	7"
1/2"	8"
9/16"	9"
5/8"	10"

**Table 2**

Duct Wall Thickness	# of Plies of Strapping & Sequence
1/8"	MRM
3/16"	MRM
1/4"	3(MR)M
5/16"	3(MR)M
3/8"	3(MR)MM
7/16"	3(MR)MM
1/2"	3(MR)M, MRM
9/16"	3(MR)M, 2(MR)M
5/8"	3(MR)M, 3(MR)M

M= 1 1/2 oz / ft<sup>2</sup>  
 R = 24 1/2 oz / ft<sup>2</sup>

NOTE: Table 1 & 2 should only be used as guides for the minimum total width of joint overlays and minimum joint thickness. Joint thickness should be at least as thick as the pipe to be joined.

\*ASTM C 582 Table 2 Type 2  
 \*ASTM D 3982 Table 2