



TECHNICAL INFORMATION

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



www.underduct.com

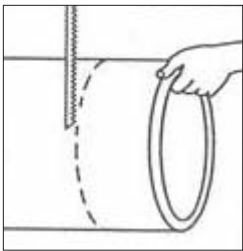
info@monoxivent.com

309-794-1000

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Joining Procedures for Wet Lay-Up



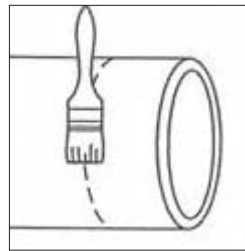
1. Firmly support duct sections. Square the ends to be welded using a saw.



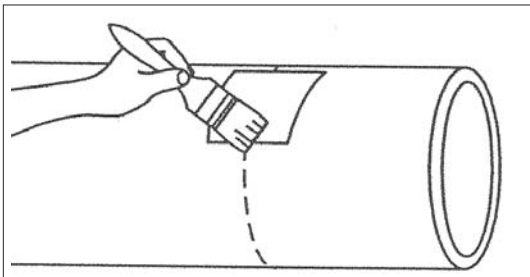
2. Rough the outer surfaces with sander approximately 1" farther from the ends than the finished weld surface. Where inside welds are possible, interior surfaces should be sanded prior to assembly. See Table 2 on previous page.



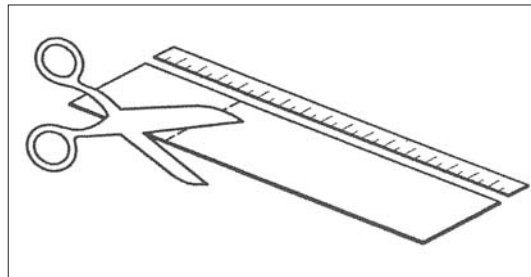
3. Coat roughened end edges of duct with small amount of catalyzed resins. Any large voids may be filled with a silica-filled resin putty.



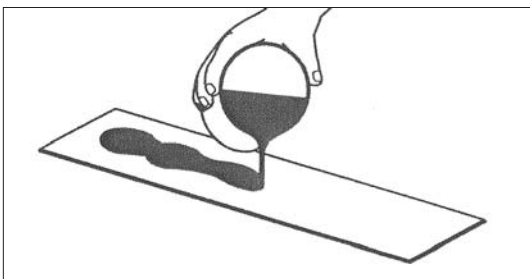
4. Support components in joint position so that no movement occurs while making the joint. Fill joint with resin.



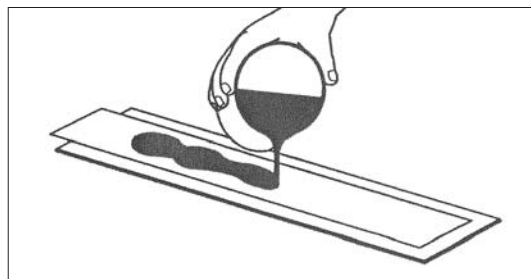
5. A "Hot Patch" technique may help prevent movement of duct during the weld-cure period. Wet 2" squares of mat with a small amount of resin using three times normal amount of catalyst. Apply "Hot Patches" at intervals around joint. Curing or hardening in a matter of minutes, they secure duct sections in proper alignment. Mix resin and catalyst for "Hot Patches" in a small paper cup and discard immediately after use to avoid contaminating welding resin.



6. Lay out fiberglass mat strips on work table. Length of each strip should be 2" longer than circumference of duct. Strips longer than 36" may be cut in half to simplify application. Mix prescribed amount of catalyst with required amount of resin in a separate clean container. Prepare only the amount of resin which can be used immediately (about 1 qt. per 6 sq. ft. of mat). The resin will harden in roughly 20-30 minutes.



7. After mixing in the catalyst thoroughly, pour the resin onto the widest mat first. Spread it over the entire mat strip, working it into the mat fibers manually. (Neoprene gloves are recommended)



8. Place the next widest strip onto the first strip by staggering away from the first to produce a smooth weld strip joint. Add more resin and work into second strip.