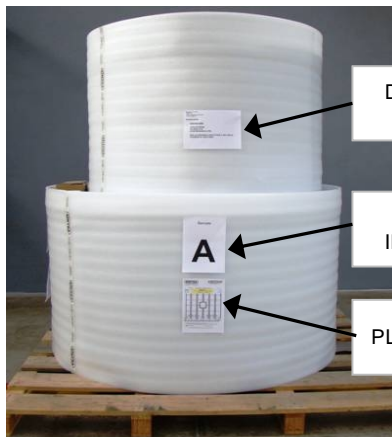


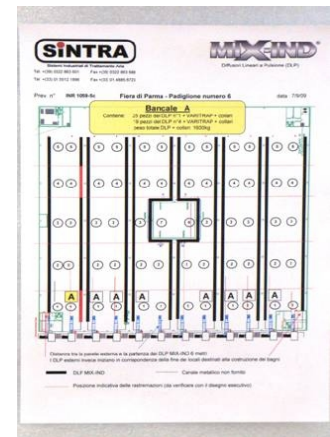
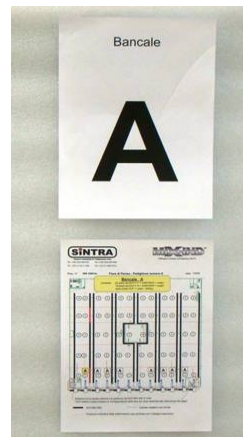
## Assembling instructions for metallic ducts (Pulsers® and DLD)



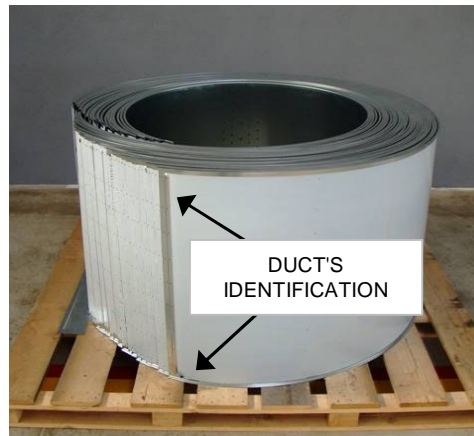
DESTINATION'S ADDRESS

PALLET IDENTIFICATION

PLANT'S DRAWING



- 1 Each pallets has, together with the destination address, an identification letter and a general drawing of the plant with the indication of the type and quantity of duct modules (Pulser® or DLD) carried on it.
- 2 On the layout sheet we indicate exactly where the pallet must be positioned in the building, in order to be exactly centred, underneath the area where the ducts have to be installed.



- 3 Once the external packaging has been removed, we can see the Pulsers® bundled together in their characteristic SPIROPACK™ shape. On top of the ducts you can find the collars and the accessories box.



- 4 Start from the first module on the outside, exploiting the elasticity of the sheet metal.
- 5 Please note that the edge next to the deep drawing is narrower on one side and wider on the other.
- 6 You must take the protective film off from the wider edge and the deep drawing before proceeding with the module's assembly.



- 7 We provide the fixing rivets, the blue gasket and, upon request, the air compressor with pneumatic riveting machine and a liquid mastic that expands for better hold.
- 8 You should put a thin layer of mastic at the base of the deep drawing (only next to the wide edge) which, when the two deep drawings will overlap, will be positioned on the inside of the duct.
- 9 You can now proceed with the closure of the duct, fixing the first rivet in the higher part of the deep drawing.



- 10 The second rivet will be fixed at the opposite extremity, the third one in the center and then you can fix the other rivets, for a total of nine rivets, positioned in the central part of the deep drawing.
- 11 In the case there is a high working pressure, there can be a second row of nine holes, parallel to the deep drawing's base.



- 12 The gasket (which has to be installed only on one edge for each module) has to be wedged in on the duct's edge, being careful NOT to start in correspondence of the deep drawing.
- 13 The gasket is then cut at a 45° angle leaving an overlap, in order to have a better hold when it is going to be compressed by the collar.





- 14 In order to tighten and to facilitate the manipulation of every single module on site, we give an extra collar that has to be positioned a few centimetres away from the lower part of the module, but NOT on the edge.
- 15 This collar is not used to join two modules together, but it serves as a reinforcement for the handling on site and can be removed at the end of the assembly.



- 16 The second collar is then mounted in correspondance of the edge with the gasket.
- 17 This is the collar that will be used to fix two modules together.



In an average time of 2-3 minutes of assembly, the duct is now ready to be mounted.

For the clamping there aren't any particular directions, it is therefore possible to follow any system that is normally used for spiral ducts.

**N.B.**

Should you have any doubt or need advice about the assembly, please call:

**TECHNICAL ASSISTANCE**

(+39) 0322 - 86 36 01