



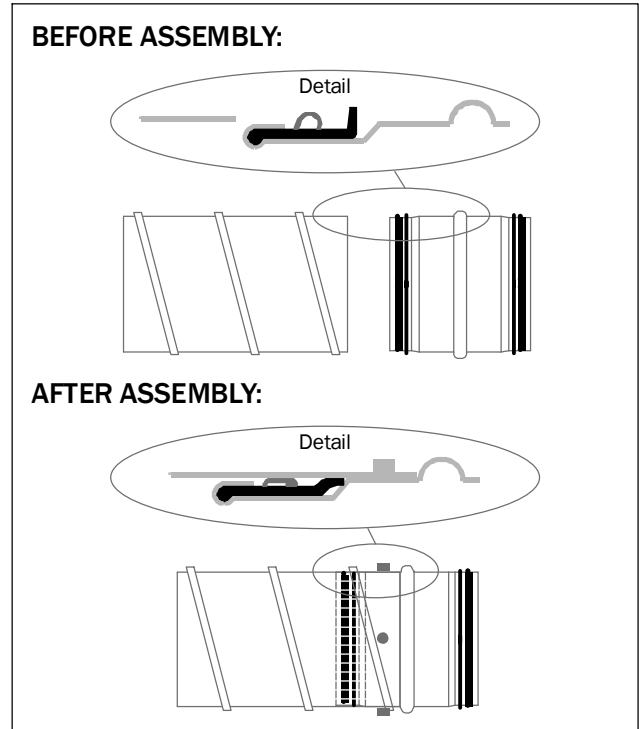
The **EDGE**[™]
Self-Sealing Round Duct System



The **EDGE™ System** will eliminate the sealing of all connections in your spiral pipe system. This system will not only provide a labor savings for the installer, it is also great for exposed systems.

FEATURES

- All fittings will have a factory installed EPDM gasket, which has an operating temperature rating of -20°F to 212°F.
- The smoke and flame spread rating is 0/0.
- The gasket construction is of a black EPDM base with a wiper for machine application and a gray EPDM hollow seal that will act as the sealing section.
- The gasket is attached to the fitting with a 180° hemmed edge that will hold the gasket in place, as shown in the diagrams to the right.
- The connections are secured with self-tapping sheet metal screws per SMACNA standards.
- **The EDGE™ System** allows for substantial space for insertion of the screws, because the gasket is located on the leading EDGE of the fitting.
- **The EDGE™ System** has been tested in accordance to SMACNA's Air Duct Leakage Test Manual (1st Edition - 1985, printing #7 - 2003) and meets SMACNA Class 3 leakage standards.



BENEFITS

- Stronger fitting
- Eliminates sharp edge
- Consistent diameter
- Factory installed resulting in a cost savings

The **EDGE™** – Fittings & Materials

Fittings: 4"-36" diameter (nominal)

Materials: Galvanized steel; Unless otherwise specified, all duct and fittings will be G-60 or better in accordance to ASTM standards; A-653 and A-924.

Elbows	4"-12" stamped, stitch welded and gasketed 14"-36" gorelocked and gasketed
Reducers	4"-36" spun/fabricated and gasketed
Bellmouths	4"-12" stamped and gasketed 14"-36" spun and gasketed
90° Tee/90° Tap	4"-36" fabricated body with stamped/fabricated tap and gasketed saddle OR 4"-12" stamped and gasketed tap (will need to be sealed when field installed) 14"-36" fabricated and gasketed tap (will need to be sealed when field installed)
All Other Fittings	Any fitting can be fabricated with gasket attached. All products will be fabricated per SMACNA standards and gauges. All fabricated fittings conform to SPIDA dimensional data.

CONSTRUCTION (GAUGE):

- All duct and fittings are made per SMACNA's Duct Construction Standards (+10" W.G.).
- The following table shows diameter and gauges:

Diameter	Spiral Duct	Fittings
4" - 14"	26 ga.	24 ga.
16" - 26"	24 ga.	22 ga.
28" - 36"	22 ga.	20 ga.

CONSTRUCTION (PIPE):

- Spiral pipe
- Calibration of spiral is required by **The EDGE™ System** manufacturer, Stamped Fittings Inc.

CONSTRUCTION (FITTINGS):

All **EDGE™** fittings, 4" – 36", will have a factory installed gasket that is attached to the fitting with a 180° hemmed edge for strength, rigidity and maintaining proper tolerances.

CONSTRUCTION (GASKET):

- **The EDGE™** gasket consists of a two-part EPDM rubber sealing material.
- The base EPDM (black material) is classified according to ASTM D2000-86 M3BA 810 B13 C12 F17.
- The sealing EPDM (grey material) is classified according to ASTM D2000-86 M8BA 507 B13 C12.
- The operating temperature is -20°F to 212°F.
- The smoke and flame spread is in accordance to ASTM E-84-91A.

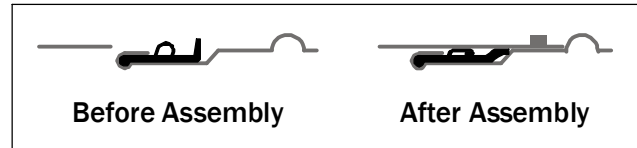
PRESSURE CLASS:

- **The EDGE™ System** has been tested and meets the requirements of SMACNA's Leakage Class 3 as indicated not to exceed (-20 in. W.G.) or (+12 in. W.G.).

JOINT CONNECTIONS:

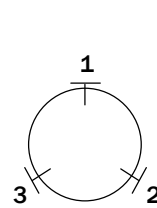
- All fittings are manufactured to slip fit into spiral duct. All fitting to fitting connections will use a fitting coupling.

The EDGE™ System fittings are made to fit tight, assuring a proper seal. Care should be taken when handling these fittings as damage could result in an improper fit and a difficult installation process.

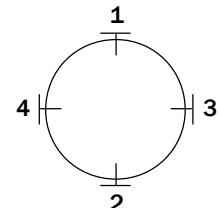


WHEN INSTALLING:

1. Place the hemmed **EDGE** of the fitting in the spiral pipe then apply pressure and the fitting will slip into place, stopping at the bead/pipe stop.
2. Using self-tapping sheet metal screws, place the screws 3/4" from the bead/pipe stop. The gasket and fittings are designed to allow adequate room to secure the screws per SMACNA standards.

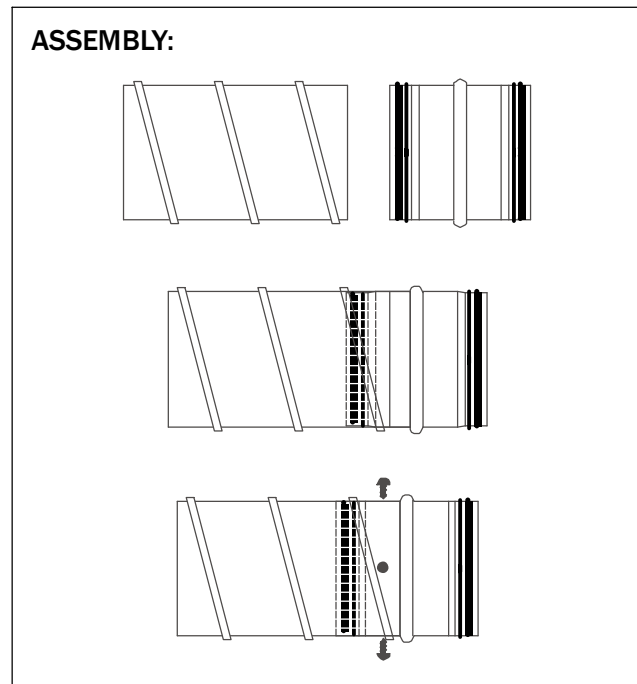


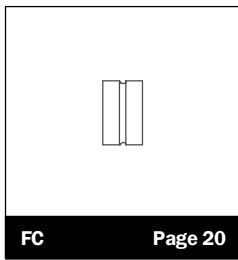
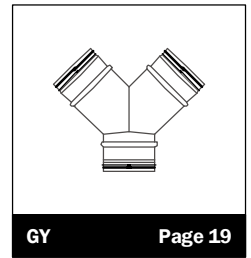
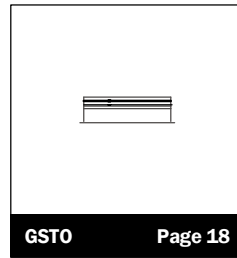
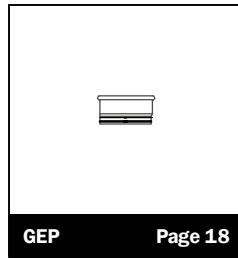
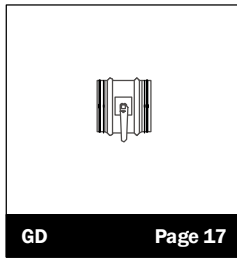
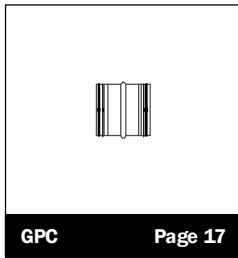
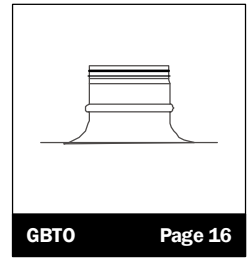
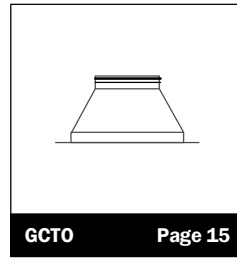
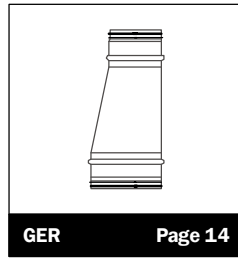
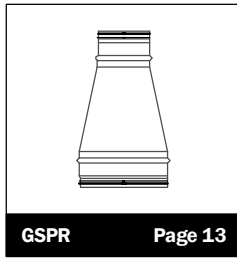
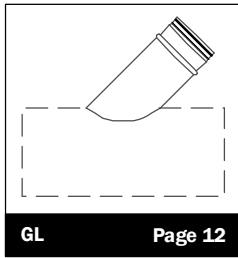
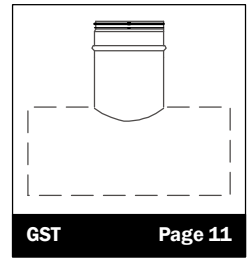
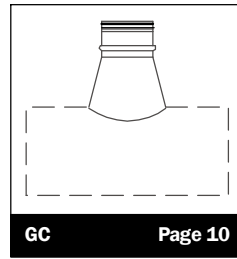
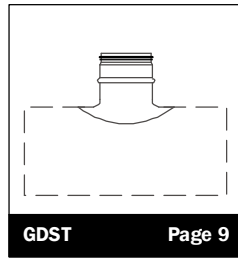
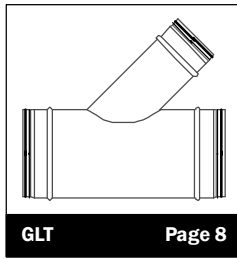
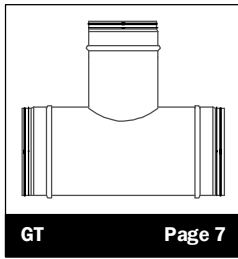
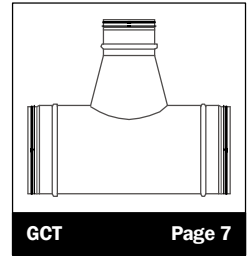
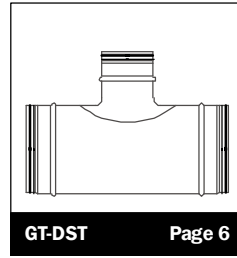
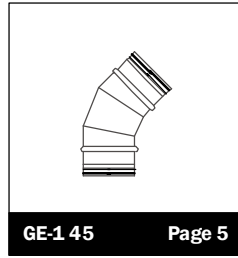
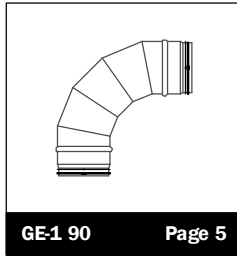
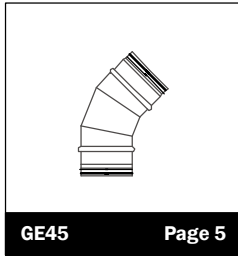
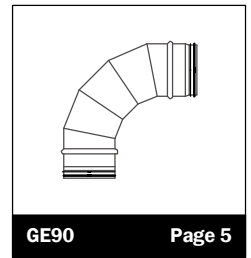
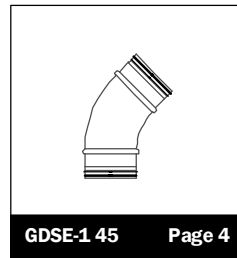
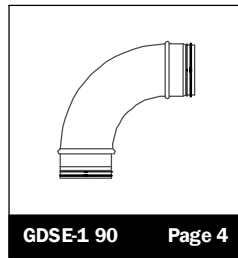
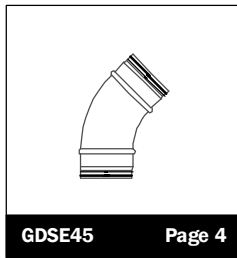
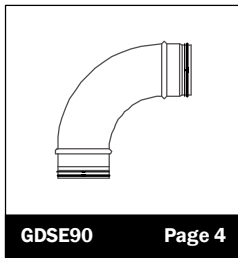
4" - 10" Diam. Pipe



12" - 36" Diam. Pipe

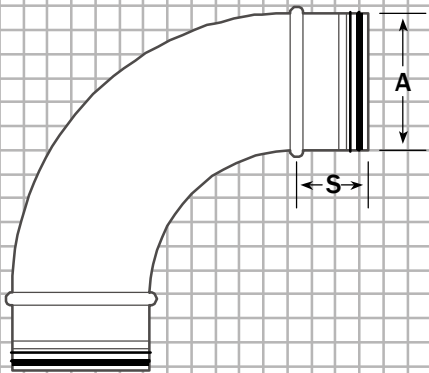
ASSEMBLY:



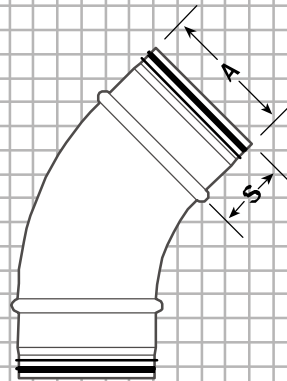


All of The EDGE™ products in this catalog are manufactured & distributed by: Stamped Fittings Incorporated.

**Gasket 90° Die Stamped 1.5
CLR Elbow (GDSE90)**

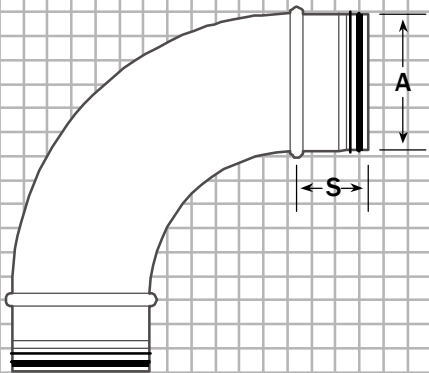


**Gasket 45° Die Stamped 1.5
CLR Elbow (GDSE45)**

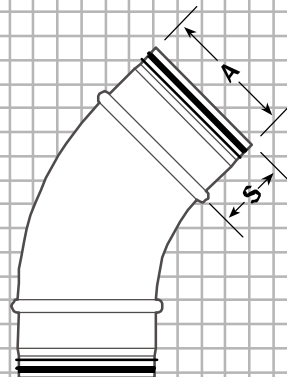


A	S
4"	2"
5"	2"
6"	2"
7"	2"
8"	2"
9"	2"
10"	2"
12"	2"

**Gasket 90° Die Stamped 1.0
CLR Elbow (GDSE-1 90)**

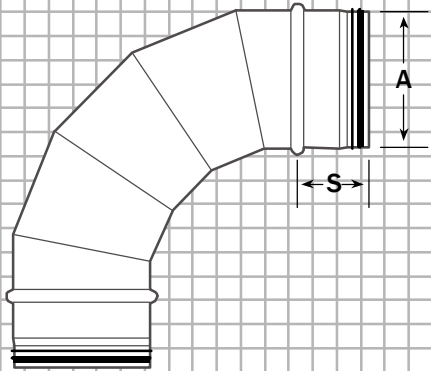


**Gasket 45° Die Stamped 1.0
CLR Elbow (GDSE-1 45)**

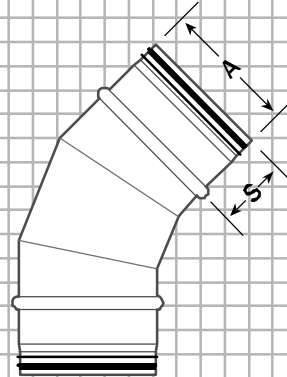


A	S
4"	2"
5"	2"
6"	2"
7"	2"
8"	2"
10"	2"

Gasket 90° 5-Piece 1.5 CLR Elbow (GE90)

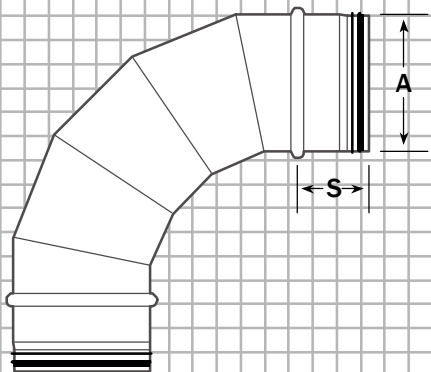


Gasket 45° 3-Piece 1.5 CLR Elbow (GE45)

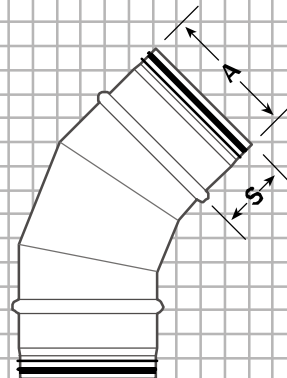


A	S
14"	2"
16"	2"
18"	2"
20"	2"
22"	2"
24"	2"
26"	2"
28"	2"
30"	2"
32"	2"
34"	2"
36"	2"

Gasket 90° 1.0 CLR Elbow (GE-1 90)

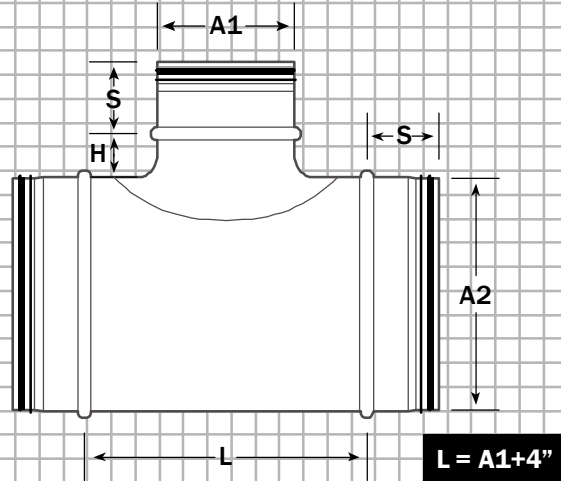


Gasket 45° 1.0 CLR Elbow (GE-1 45)



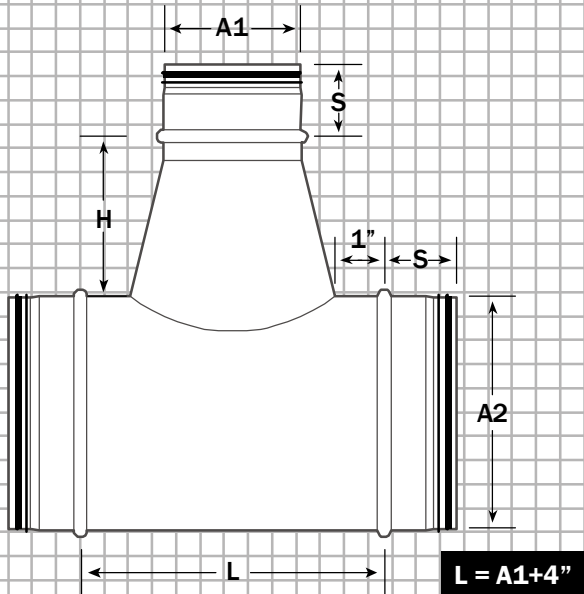
A	S
9"	2"
12"	2"
14"	2"
16"	2"
18"	2"
20"	2"
22"	2"
24"	2"
26"	2"
28"	2"
30"	2"
32"	2"
34"	2"
36"	2"

Gasket 90° Tee with Die Stamped Tap (GT-DST)



A1	A2	S	H	A1	A2	S	H	A1	A2	S	H
4"	4"	2"	3/4"	5"	14"	2"	3/4"	8"	14"	2"	1"
4"	5"	2"	3/4"	5"	16"	2"	3/4"	8"	16"	2"	1"
4"	6"	2"	3/4"	5"	18"	2"	3/4"	8"	18"	2"	1"
4"	7"	2"	3/4"	5"	20"	2"	3/4"	8"	20"	2"	1"
4"	8"	2"	3/4"	5"	22"	2"	3/4"	8"	22"	2"	1"
4"	9"	2"	3/4"	5"	24"	2"	3/4"	8"	24"	2"	1"
4"	10"	2"	3/4"	6"	6"	2"	3/4"	10"	10"	2"	1"
4"	12"	2"	3/4"	6"	7"	2"	3/4"	10"	12"	2"	1"
4"	14"	2"	3/4"	6"	8"	2"	3/4"	10"	14"	2"	1"
4"	16"	2"	3/4"	6"	9"	2"	3/4"	10"	16"	2"	1"
4"	18"	2"	3/4"	6"	10"	2"	3/4"	10"	18"	2"	1"
4"	20"	2"	3/4"	6"	12"	2"	3/4"	10"	20"	2"	1"
4"	22"	2"	3/4"	6"	14"	2"	3/4"	10"	22"	2"	1"
4"	24"	2"	3/4"	6"	16"	2"	3/4"	10"	24"	2"	1"
5"	5"	2"	3/4"	6"	18"	2"	3/4"	12"	12"	2"	1"
5"	6"	2"	3/4"	6"	20"	2"	3/4"	12"	14"	2"	1"
5"	7"	2"	3/4"	6"	22"	2"	3/4"	12"	16"	2"	1"
5"	8"	2"	3/4"	6"	24"	2"	3/4"	12"	18"	2"	1"
5"	9"	2"	3/4"	8"	8"	2"	1"	12"	20"	2"	1"
5"	10"	2"	3/4"	8"	9"	2"	1"	12"	22"	2"	1"
5"	12"	2"	3/4"	8"	10"	2"	1"	12"	24"	2"	1"
				8"	12"	2"	1"				

Gasket 90° Conical Tee (GCT)

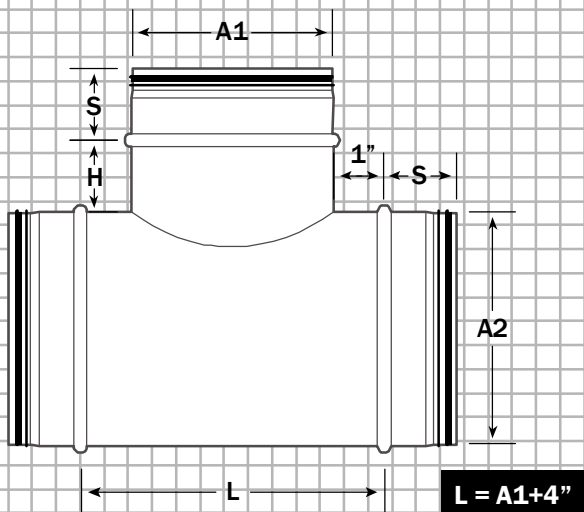


A1	S	H
4"	2"	5-1/4"
5"	2"	5-1/4"
6"	2"	5-1/4"
7"	2"	5-1/4"
8"	2"	5-1/4"
9"	2"	5-1/4"
10"	2"	5-1/4"
12"	2"	5-1/4"
14"	2"	5-1/4"
16"	2"	5-1/4"

A1	S	H
18"	2"	5-1/4"
20"	2"	5-1/4"
22"	2"	5-1/4"
24"	2"	5-1/4"
26"	2"	5-1/4"
28"	2"	5-1/4"
30"	2"	5-1/4"
32"	2"	5-1/4"
34"	2"	5-1/4"
36"	2"	5-1/4"

(Specify A2 dimension when ordering)

Gasket 90° Tee (GT)

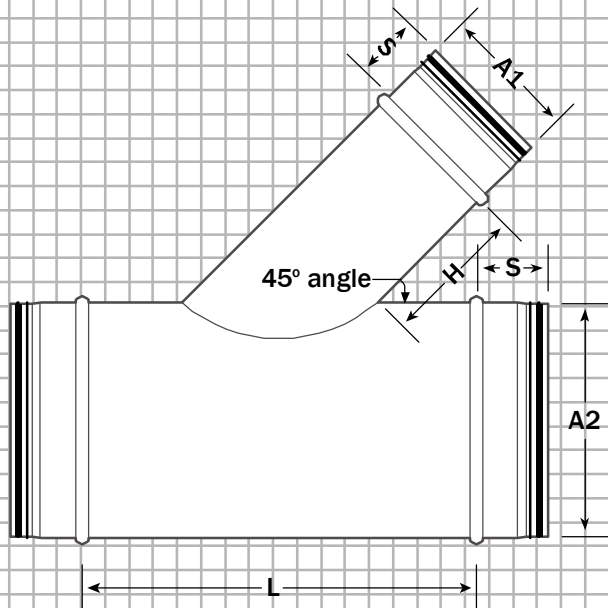


A1	S	H
4"	2"	2"
5"	2"	2"
6"	2"	2"
7"	2"	2"
8"	2"	2"
9"	2"	2"
10"	2"	2"
12"	2"	2"
14"	2"	2"
16"	2"	2"

A1	S	H
18"	2"	2"
20"	2"	2"
22"	2"	2"
24"	2"	2"
26"	2"	2"
28"	2"	2"
30"	2"	2"
32"	2"	2"
34"	2"	2"
36"	2"	2"

(Specify A2 dimension when ordering)

Gasket 45° Lateral Tee (GLT)

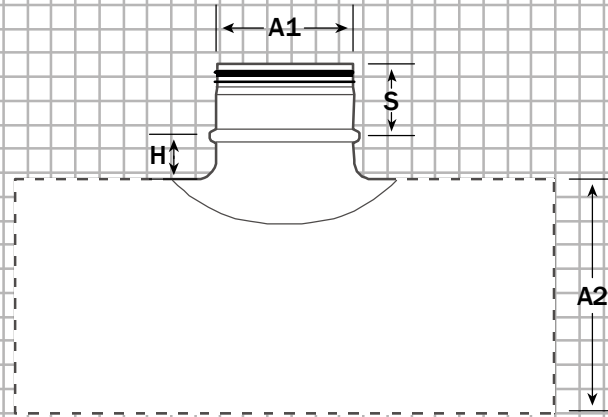


$L = A1 + 4"$

A1	S	H
4"	2"	4"
5"	2"	4"
6"	2"	4"
7"	2"	4"
8"	2"	4"
9"	2"	4"
10"	2"	4"
12"	2"	4"
14"	2"	4"
16"	2"	4"
18"	2"	4"
20"	2"	4"
22"	2"	4"
24"	2"	4"
26"	2"	4"
28"	2"	4"
30"	2"	4"
32"	2"	4"
34"	2"	4"
36"	2"	4"

(Specify A2 dimension when ordering)

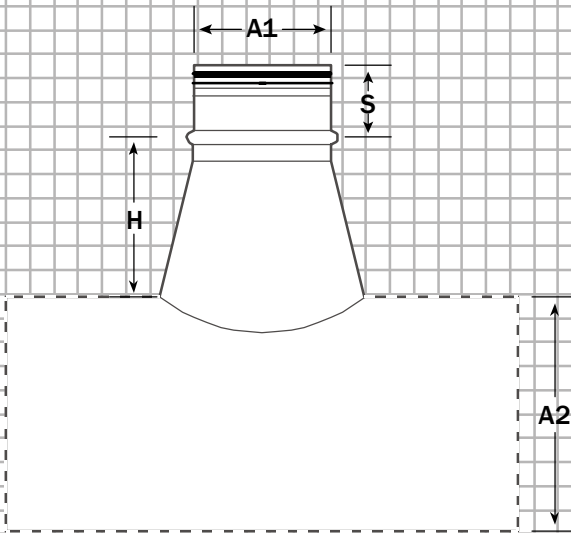
Gasket 90° Die Stamped Saddle Tap (GDST)



* Field installed fitting

A1	A2	S	H	A1	A2	S	H	A1	A2	S	H
4"	4"	2"	3/4"	5"	14"	2"	3/4"	8"	14"	2"	1"
4"	5"	2"	3/4"	5"	16"	2"	3/4"	8"	16"	2"	1"
4"	6"	2"	3/4"	5"	18"	2"	3/4"	8"	18"	2"	1"
4"	7"	2"	3/4"	5"	20"	2"	3/4"	8"	20"	2"	1"
4"	8"	2"	3/4"	5"	22"	2"	3/4"	8"	22"	2"	1"
4"	9"	2"	3/4"	5"	24"	2"	3/4"	8"	24"	2"	1"
4"	10"	2"	3/4"	6"	6"	2"	3/4"	10"	10"	2"	1"
4"	12"	2"	3/4"	6"	7"	2"	3/4"	10"	12"	2"	1"
4"	14"	2"	3/4"	6"	8"	2"	3/4"	10"	14"	2"	1"
4"	16"	2"	3/4"	6"	9"	2"	3/4"	10"	16"	2"	1"
4"	18"	2"	3/4"	6"	10"	2"	3/4"	10"	18"	2"	1"
4"	20"	2"	3/4"	6"	12"	2"	3/4"	10"	20"	2"	1"
4"	22"	2"	3/4"	6"	14"	2"	3/4"	10"	22"	2"	1"
4"	24"	2"	3/4"	6"	16"	2"	3/4"	10"	24"	2"	1"
5"	5"	2"	3/4"	6"	18"	2"	3/4"	12"	12"	2"	1"
5"	6"	2"	3/4"	6"	20"	2"	3/4"	12"	14"	2"	1"
5"	7"	2"	3/4"	6"	22"	2"	3/4"	12"	16"	2"	1"
5"	8"	2"	3/4"	6"	24"	2"	3/4"	12"	18"	2"	1"
5"	9"	2"	3/4"	8"	8"	2"	1"	12"	20"	2"	1"
5"	10"	2"	3/4"	8"	9"	2"	1"	12"	22"	2"	1"
5"	12"	2"	3/4"	8"	10"	2"	1"	12"	24"	2"	1"
				8"	12"	2"	1"				

Gasket 90° Conical (GC)

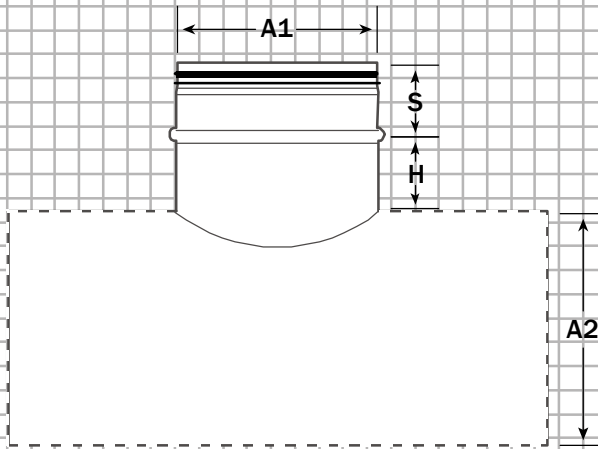


* Field installed fitting

A1	S	H
4"	2"	5-1/4"
5"	2"	5-1/4"
6"	2"	5-1/4"
7"	2"	5-1/4"
8"	2"	5-1/4"
9"	2"	5-1/4"
10"	2"	5-1/4"
12"	2"	5-1/4"
14"	2"	5-1/4"
16"	2"	5-1/4"
18"	2"	5-1/4"
20"	2"	5-1/4"
22"	2"	5-1/4"
24"	2"	5-1/4"
26"	2"	5-1/4"
28"	2"	5-1/4"
30"	2"	5-1/4"
32"	2"	5-1/4"
34"	2"	5-1/4"
36"	2"	5-1/4"

(Specify A2 dimension when ordering)

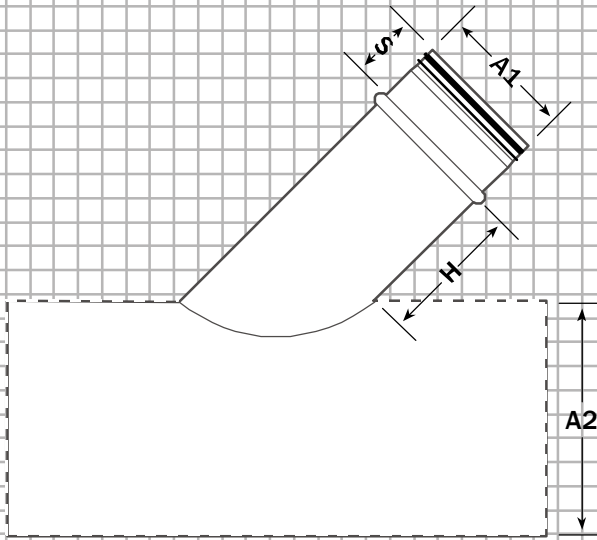
Gasket Straight Tap (GST)



* Field installed fitting

A1	A2	S	H
4"	4"	2"	2"
5"	5"	2"	2"
6"	6"	2"	2"
7"	7"	2"	2"
8"	8"	2"	2"
9"	9"	2"	2"
10"	10"	2"	2"
12"	12"	2"	2"
14"	14"	2"	2"
16"	16"	2"	2"
18"	18"	2"	2"
20"	20"	2"	2"
22"	22"	2"	2"
24"	24"	2"	2"
26"	26"	2"	2"
28"	28"	2"	2"
30"	30"	2"	2"
32"	32"	2"	2"
34"	34"	2"	2"
36"	36"	2"	2"

Gasket 45° Lateral (GL)

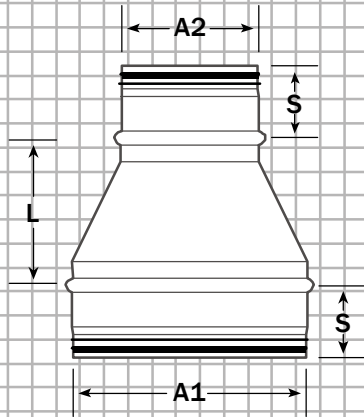


*Field installed fitting

A1	S	H
4"	2"	4"
5"	2"	4"
6"	2"	4"
7"	2"	4"
8"	2"	4"
9"	2"	4"
10"	2"	4"
12"	2"	4"
14"	2"	4"
16"	2"	4"
18"	2"	4"
20"	2"	4"
22"	2"	4"
24"	2"	4"
26"	2"	4"
28"	2"	4"
30"	2"	4"
32"	2"	4"
34"	2"	4"
36"	2"	4"

(Specify A2 dimension when ordering)

Gasket Spun Reducer-Concentric (GSPR)

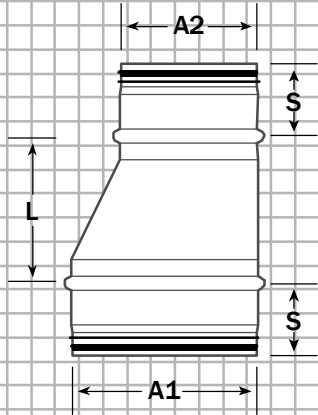


A1	A2	S	L
18"	12"	2"	4"
18"	14"	2"	4"
18"	16"	2"	4"
20"	14"	2"	4"
20"	16"	2"	4"
20"	18"	2"	4"
22"	16"	2"	4"
22"	18"	2"	4"
22"	20"	2"	4"
24"	18"	2"	4"
24"	20"	2"	4"
24"	22"	2"	4"
26"	20"	2"	4"
26"	22"	2"	4"
26"	24"	2"	4"
28"	22"	2"	4"
28"	24"	2"	4"
28"	26"	2"	4"
30"	24"	2"	4"
30"	26"	2"	4"
30"	28"	2"	4"
32"	26"	2"	4"
32"	28"	2"	4"
32"	30"	2"	4"
34"	28"	2"	4"
34"	30"	2"	4"
34"	32"	2"	4"
36"	30"	2"	4"
36"	32"	2"	4"
36"	34"	2"	4"

A1	A2	S	L
4"	3"	2"	4"
5"	3"	2"	4"
5"	4"	2"	4"
6"	4"	2"	4"
6"	5"	2"	4"
7"	3"	2"	4"
7"	4"	2"	4"
7"	5"	2"	4"
7"	6"	2"	4"
8"	4"	2"	4"
8"	5"	2"	4"
8"	6"	2"	4"
8"	7"	2"	4"
9"	5"	2"	4"
9"	6"	2"	4"
9"	7"	2"	4"
9"	8"	2"	4"

A1	A2	S	L
10"	5"	2"	4"
10"	6"	2"	4"
10"	7"	2"	4"
10"	8"	2"	4"
10"	9"	2"	4"
12"	6"	2"	4"
12"	7"	2"	4"
12"	8"	2"	4"
12"	9"	2"	4"
12"	10"	2"	4"
14"	8"	2"	4"
14"	9"	2"	4"
14"	10"	2"	4"
14"	12"	2"	4"
16"	10"	2"	4"
16"	12"	2"	4"
16"	14"	2"	4"

Gasket Eccentric Reducer (GER)

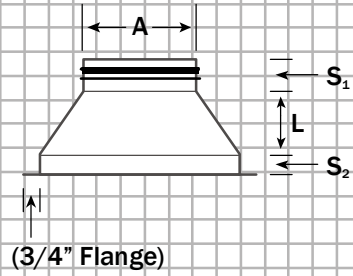


A1	A2	S	L
18"	12"	2"	4"
18"	14"	2"	4"
18"	16"	2"	4"
20"	14"	2"	4"
20"	16"	2"	4"
20"	18"	2"	4"
22"	16"	2"	4"
22"	18"	2"	4"
22"	20"	2"	4"
24"	18"	2"	4"
24"	20"	2"	4"
24"	22"	2"	4"
26"	20"	2"	4"
26"	22"	2"	4"
26"	24"	2"	4"
28"	22"	2"	4"
28"	24"	2"	4"
28"	26"	2"	4"
30"	24"	2"	4"
30"	26"	2"	4"
30"	28"	2"	4"
32"	26"	2"	4"
32"	28"	2"	4"
32"	30"	2"	4"
34"	28"	2"	4"
34"	30"	2"	4"
34"	32"	2"	4"
36"	30"	2"	4"
36"	32"	2"	4"
36"	34"	2"	4"

A1	A2	S	L
4"	3"	2"	4"
5"	3"	2"	4"
5"	4"	2"	4"
6"	4"	2"	4"
6"	5"	2"	4"
7"	3"	2"	4"
7"	4"	2"	4"
7"	5"	2"	4"
7"	6"	2"	4"
8"	4"	2"	4"
8"	5"	2"	4"
8"	6"	2"	4"
8"	7"	2"	4"
9"	5"	2"	4"
9"	6"	2"	4"
9"	7"	2"	4"
9"	8"	2"	4"

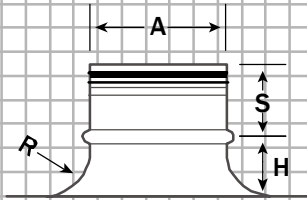
A1	A2	S	L
10"	5"	2"	4"
10"	6"	2"	4"
10"	7"	2"	4"
10"	8"	2"	4"
10"	9"	2"	4"
12"	6"	2"	4"
12"	7"	2"	4"
12"	8"	2"	4"
12"	9"	2"	4"
12"	10"	2"	4"
14"	8"	2"	4"
14"	9"	2"	4"
14"	10"	2"	4"
14"	12"	2"	4"
16"	10"	2"	4"
16"	12"	2"	4"
16"	14"	2"	4"

Gasket Conical Take-off (GCTO)



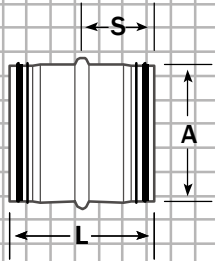
A	S ₁	S ₂	L
4"	2"	1- 1/4"	4"
5"	2"	1- 1/4"	4"
6"	2"	1- 1/4"	4"
7"	2"	1- 1/4"	4"
8"	2"	1- 1/4"	4"
9"	2"	1- 1/4"	4"
10"	2"	1- 1/4"	4"
12"	2"	1- 1/4"	4"
14"	2"	1- 1/4"	4"
16"	2"	1- 1/4"	4"
18"	2"	1- 1/4"	4"
20"	2"	1- 1/4"	4"
22"	2"	1- 1/4"	4"
24"	2"	1- 1/4"	4"
26"	2"	1- 1/4"	4"
28"	2"	1- 1/4"	4"
30"	2"	1- 1/4"	4"
32"	2"	1- 1/4"	4"
34"	2"	1- 1/4"	4"
36"	2"	1- 1/4"	4"

Gasket Bellmouth Take-off (GBTO)

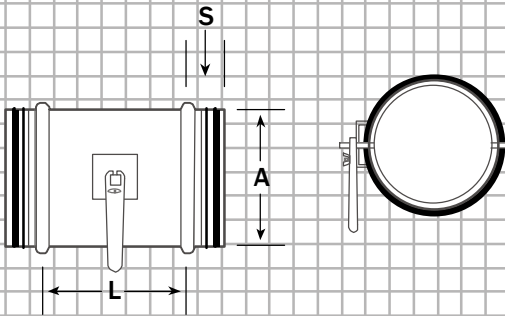


A	S	R	H
4"	2"	.394"	1- 1/2"
5"	2"	.472"	1- 1/2"
6"	2"	.787"	1- 1/2"
7"	2"	1.0"	1- 1/2"
8"	2"	1.0"	1- 1/2"
9"	2"	1.0"	1- 1/2"
10"	2"	1.0"	1- 1/2"
12"	2"	1.0"	1- 1/2"
14"	2"	2.0"	1- 1/2"
16"	2"	2.0"	1- 1/2"
18"	2"	2.0"	1- 1/2"
20"	2"	2.0"	1- 1/2"
22"	2"	2.0"	1- 1/2"
24"	2"	2.0"	1- 1/2"
26"	2"	2.0"	1- 1/2"
28"	2"	2.0"	1- 1/2"
30"	2"	2.0"	1- 1/2"
32"	2"	2.0"	1- 1/2"
34"	2"	2.0"	1- 1/2"
36"	2"	2.0"	1- 1/2"

Gasket Pipe Coupling (GPC)

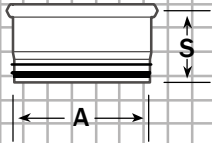


Gasket Damper (GD)

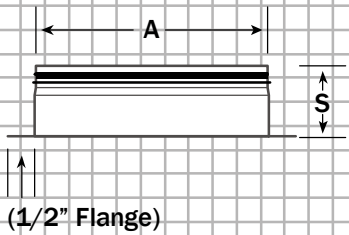


A	S	L
4"	2"	4"
5"	2"	4"
6"	2"	4"
7"	2"	4"
8"	2"	4"
9"	2"	4"
10"	2"	4"
12"	2"	4"
14"	2"	4"
16"	2"	4"
18"	2"	4"
20"	2"	4"
22"	2"	4"
24"	2"	4"
26"	2"	4"
28"	2"	4"
30"	2"	4"
32"	2"	4"
34"	2"	4"
36"	2"	4"

Gasket End Plug (GEP)

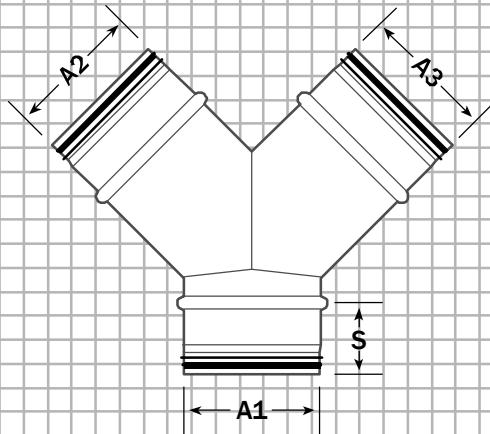


Gasket Straight Take-off (GSTO)



A	S
4"	2"
5"	2"
6"	2"
7"	2"
8"	2"
9"	2"
10"	2"
12"	2"
14"	2"
16"	2"
18"	2"
20"	2"
22"	2"
24"	2"
26"	2"
28"	2"
30"	2"
32"	2"
34"	2"
36"	2"

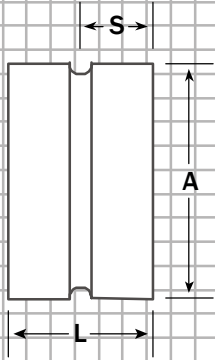
Gasket Y Branch (GY)



A1	S
4"	2"
5"	2"
6"	2"
7"	2"
8"	2"
9"	2"
10"	2"
12"	2"
14"	2"
16"	2"
18"	2"
20"	2"
22"	2"
24"	2"
26"	2"
28"	2"
30"	2"
32"	2"
34"	2"
36"	2"

(Specify A2 and A3 dimension when ordering)

Fitting Coupling (FC)



A	S	L
4"	2"	4"
5"	2"	4"
6"	2"	4"
7"	2"	4"
8"	2"	4"
9"	2"	4"
10"	2"	4"
12"	2"	4"
14"	2"	4"
16"	2"	4"
18"	2"	4"
20"	2"	4"
22"	2"	4"
24"	2"	4"
26"	2"	4"
28"	2"	4"
30"	2"	4"
32"	2"	4"
34"	2"	4"
36"	2"	4"