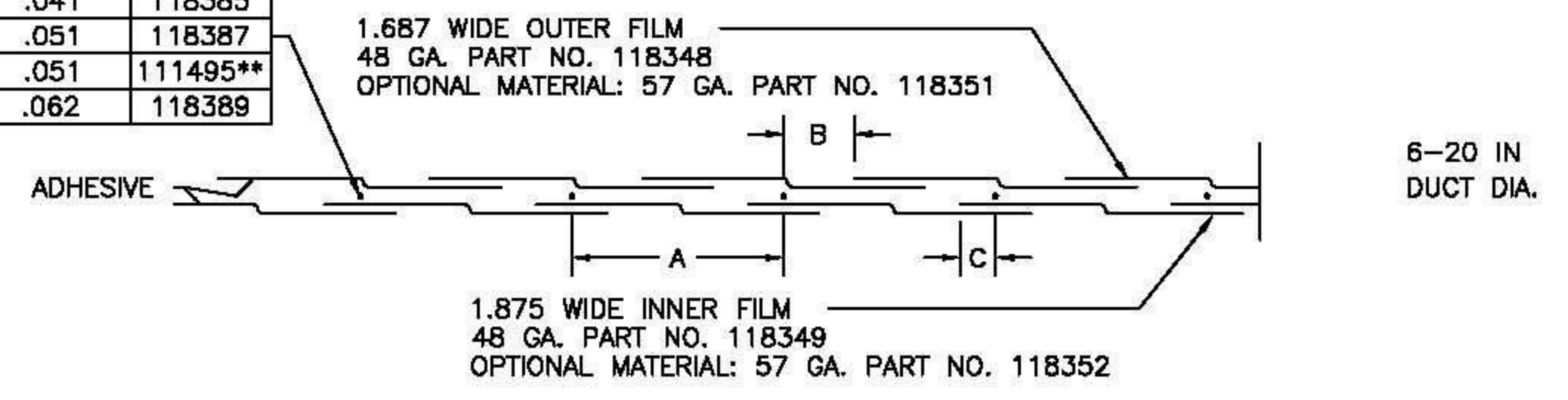


CORE SIZE (IN)	INNER DIAMETER (IN)	SUBASSY No LENGTH <sup>①</sup> (L)=10'2"	SUBASSY No LENGTH <sup>①</sup> (L)=14'2"	SUBASSY No LENGTH <sup>①</sup> (L)=16'2"	SUBASSY No LENGTH <sup>①</sup> (L)=18'2"	SUBASSY No LENGTH <sup>①</sup> (L)=20'2"	SUBASSY No LENGTH <sup>①</sup> (L)=22'2"	SUBASSY No LENGTH <sup>①</sup> (L)=25'2"	SUBASSY No LENGTH <sup>①</sup> (L)=30'2"	SUBASSY No LENGTH <sup>①</sup> (L)=50'2"
3	3.25							779568		
4	4.25							779500		779597
5	5.25	779640						779501		779538
6	6.25							779502		779520
7	7.25							779503		779539
8	8.25							779504		779521
9	9.25							779505		779540
10	10.25		779512	779514	779516	779518	779524	779506		779541
12	12.25	779641	779513	779515	779517	779519		779507	779523	779542
14	14.25					779642		779508		
16	16.25					779643		779509		
18	18.25					779644		779510		
20	20.25							779511		

DUCT DIA. (INCHES)	WIRE DIA. (INCHES)	PART NUMBER
*6	.045	118390*
7	.041	118385
8	.038	118384
9&10	.041	118385
12&14	.051	118387
**16	.051	111495**
18-20	.062	118389



\* NOTE: 6" CORE DIAMETER MAY USE 0.041 HIGH TENSILE WIRE (118386).  
 \*\* NOTE: 16" CORE DIAMETER MUST USE 0.051 BEAD WIRE (111495).  
 IF BRIGHT WIRE IS USED IT MUST BE 0.062 DIA. (118389)

① - TOLERANCE ON LENGTH: +2, -0 INCHES  
 SEE NOTE #3.

**NOTES:**

- ADHESIVE PART NUMBER: 118654  
 COATING WEIGHT: 0.10-0.30 GRAMS PER SQUARE FOOT (DRY) OF COATED FILM AREA, AS MEASURED IN ACCORDANCE WITH ADHESIVE APPLICATION RATE TEST AS SPECIFIED IN THE HART & COOLEY UL PROCEDURE, FILE MH-8673, VOLUME 5, APPENDIX D, PAGE 15  
 FORMULA: BLACK PIGMENT (H&C #118266) IS TO BE ADDED TO BASE ADHESIVE AT A LOADING OF 1.5% BY WET WEIGHT (ie 7.0 Lbs OF PIGMENT PER 460Lb DRUM OF ADHESIVE).  
 CROSSLINKER (H&C #118350) IS TO BE ADDED TO BASE ADHESIVE AT A LOADING OF 0.50% BY WET WEIGHT (ie 2.3 Lbs OF CROSSLINKER PER 460 Lb DRUM OF ADHESIVE)
- THE CORE INNER DIAMETER SHOULD BE MEASURED WITH SIZING GAGE. REFERENCE DRAWING 22837.
- THE FINISHED CORE LENGTH MUST BE MEASURED WHILE CORE IS SUBJECTED TO AN AXIAL FORCE OF 25 POUNDS.
- ADHESIVE IS NOT PERMITTED ON THE EXTERIOR OR INTERIOR OF THE FINISHED CORE.
- EXPOSED WIRE AT ENDS OF CORE MUST BE SECURED WITH 3 INCHES OF TAPE (PER END) TO PREVENT UNRAVELING. TAPE PART NUMBER 118366.
- THE WIRE IS TO BE TOTALLY ENCAPSULATED BETWEEN FILM LAYERS AND MUST NOT CUT THROUGH OR FRACTURE (WEAKEN) THE FILM.
- THE CORE MUST MEET OR EXCEED THE CLASS 1 REQUIREMENTS OF STANDARD UL-181, THE STANDARD OF SAFETY FOR FACTORY MADE AIR DUCTS AND AIR CONNECTORS, AND MUST ATTAIN THE FOLLOWING RATINGS:  
 MAXIMUM POSITIVE PRESSURE: 10 INCHES WATER COLUMN  
 MAXIMUM NEGATIVE PRESSURE: 0.5 INCHES WATER COLUMN.  
 MAXIMUM AIR VELOCITY: 4000 FEET PER MINUTE.
- SEE BOM FOR CORRECT FILM PART NUMBER TO BE USED.
- LARGER WIRE DIAMETERS MAY BE USED WITH THE PROPER APPROVALS.

CORE DIAMETERS				DESCRIPTION
DIM.	3-5 IN. (INCHES)	6-20 IN. (INCHES)	TOLERANCE (INCHES)	
A	1.00 TYP	1.50 TYP	+0.00 -0.06	WIRE SPACING, CENTER TO CENTER
B	.37 TYP	.65 TYP	±.06	OUTER FILM EDGE TO WIRE
C	.21 TYP	.19 TYP	±.06	INNER FILM EDGE TO WIRE

ITEM	QTY.	DESCRIPTION	PART NO.	DRAWING NO.
BILL OF MATERIALS				
TOLERANCES		CLASS FLEXIBLE DUCT		
FRACTION ± 1/64		NAME CORE-TWO PLY POLYESTER 3"-20" DIA		
DECIMALS:		MATERIAL AS SPECIFIED		
XX = ± .015		DATE		
XXX = ± .005		SCALE		
ANGLES = ± 1/2°		DRAWN PVM		
UNLESS OTHERWISE SPECIFIED		CHECKED		
NOTES:		APPROVED		
1. REMOVE ALL BURRS.		SHEET OF SHEETS		
2. DO NOT SCALE THIS DRAWING.		22691 - A		
AG CLARIFY WIRE USAGE ON 6, 8" SIZES 7070 RLV 9/23/09 AF 111495 WAS 118387 ON 779643, 779509 6158 RLV 9/22/06 AE CLARIFY INNER DIA. REQUIREMENT; ADD 779642-4 (EN5837) 5712 RLV RLV 1/26/06 AD DEL NOTE 10; 779504: 0.038 WAS 0.041, 118384 WAS 118385; CORRECT CROSSLINKER 0.5% WAS 0.23% 5186 RLV RLV 2/22/05 REVISIONS ECN BY CHK. DATE				

