# Duct-Tite Instruction Sheet

Description:

Duct-Tite is a fibrous paste sealant used for sealing industrial ducting where high temperature and pressure resistance is needed. Applications include paint ovens, drying and curing ovens, flue stacks, heat exchangers, or any other high temperature ducting which may or may not see pressure.

During joint assembly, sealant will flow into rough or irregular surfaces to provide a durable seal. Duct-Tite expands under heat and cures to a leathery like consistency, and will not crack due to thermal cycling or vibration. Sealant will outlast silicone above 500°F and is inert to most industrial chemicals. Joint disassembly is easy as the sealant does not excessively harden which allows for quick separation. Duct-Tite is not classified as a hazardous material and is able to be shipped by any means worldwide.

Application Instructions:

Care should be taken not to contact bare skin with sealant. Gloves and long sleeve garment should be worn when applying this product.

Surface should be 120°F or less as sealant will spread more easily over a cooler surface. Remove debris and oils from the surface to be sealed. Apply Duct-Tite onto the joint face as evenly as possible using a spatula or putty knife, or by caulking a bead onto the surface. Assemble the joint and fasten clamp collars if necessary. ***Cure sealant prior to putting equipment into service if process pressure will be present within the ductwork***. If no pressure is present, sealant will cure during use. Duct-Tite cures with heat: 250°F for 4-6 hours or 400°F for 1-2 hours (longer for wider flange surfaces). Service heat from equipment can be used, but minimal pressure should be applied. Cure time can be reduced by utilizing X-1 Catalyst which cuts the curing time to 1 hour at 250°F or 20 minutes at 400°F. Uncured product cleans up easily with mineral spirits or isopropyl (rubbing) alcohol. Use a wire wheel or synthetic abrasive pad to clean up cured material.

Duct-Tite Tech Data:

Cured State: Rubbery to Leathery

Specific Gravity: 1.33

Max Temperature: to 800°F

Max Pressure: 500 PSI

Chemically Resists (when cured): Gasoline, Perchlorethylene, Methylethyl Ketone, Toluene, Toluol, Acetone, Mineral Spirits, Methanol, Hydrochloric Acid (<170°F)

Joint Compressibility: 0.002 inch min. to 0.020 inch max. gap (for higher pressures)
0.062 inch (for low to no pressure)

Shelf Life: 1 year bulk containers, 6 months cartridges

Packaging: Gallon Cans, 5 Gallon Pails, 10.3 oz. and 29 oz. Caulking Cartridges

*See MSDS information for precautions*