

SUBMITTAL RECORD \_\_\_\_\_  
JOB \_\_\_\_\_  
LOCATION \_\_\_\_\_  
SUBMITTED TO \_\_\_\_\_  
SUBMITTAL PREPARED BY \_\_\_\_\_  
APPROVED BY \_\_\_\_\_  
DATE \_\_\_\_\_



# Specification Form PAC40 Portable Adhesive Canister-Clear

## DESCRIPTION

Duct liner is typically attached to duct walls by two fastening methods; one with mechanical fasteners and the other with adhesive. Mechanical fasteners are utilized to prevent delamination of the liner while adhesives bond the liner to the metal ensuring that air flow can not intrude between the two materials. The choice of an adhesive is affected by several factors some of which are; the method of application, acceptable dry time, solvent type.

Duro Dyne PAC40 is a web type, high solids, general purpose adhesive that bonds well to a wide variety of substrates, with one side or two side application. It has a quick tack, is flexible, non-wrinkling and water proof. Use on a variety of surfaces including insulation, plastic, wood, ABS, FRP, foam, carpet, wall coverings, fiberglass, packaging, labeling and more.

## FEATURES

- Wide pad nozzle
- Low VOC Organic Compound
- No Methylene Chloride
- High Solids & High Strength
- Flexible Non Wrinkling
- Very Fast Tacking
- WaterProof

## TYPICAL PROPERTIES

**Type:** Synthetic Polymer  
**Color:** Clear  
**Odor:** Mild Solvent/wet, none/dry  
**VOC:** <80 gms./ltr.  
**Viscosity:** Not Applicable  
**Flammability:** Flammable  
**Effect of Freezing:** None  
**Storage Life:** 15 months  
**Clean With:** Mineral Spirits/Citrus Cleaner  
**Application Temperature:** 65° F - 95° F  
**Maximum Service Temperature:** 150° F  
**Estimated Coverage:** 2250-2700 Sq Ft @2.5-3 gm/Sq Ft  
**Method of Application:** Attach spray hose and spray gun then fully open valve on canister. Hold spray gun tip 6 to 10 inches from surface to be covered, always at a 90° angle to surface. Apply even coats. Do not allow it to concentrate or puddle in one area. For best performance, use this product at room temperature.



## RELATED SMACNA RECOMMENDATIONS\*

### 7.4 Installation Standards For Rectangular Ducts Using Flexible Liner

S2.3 Each layer of duct liner shall be attached with 90 percent coverage of adhesive at the liner contact surface area.

S2.4 All transversely oriented edges of liner not receiving metal nosing shall be coated with adhesive. Liner shall be neatly butted without gaps at transverse joints and shall be coated with adhesive at such joints before butting.

S2.6 Ducts with interior widths of 8 in. (203 mm) or less do not require mechanical fasteners in addition to adhesive.

*\*From SMACNA HVAC Duct Construction Standards Metal and Flexible • Third Edition • 2005*

PAC complies with the South Coast Air Quality Management (SCAQMD) Rule #1168 and VOC (Volatile Organic Compound) standards and thus can be used for **IEQ Credit 4.1: Low Emitting Materials: Adhesives & Sealants** when used for field installation on the building interior and applied on-site.

ITEM#	CODE	DESCRIPTION
5094	PAC40	Portable Adhesive Canister-Clear

## SUGGESTED SPECIFICATIONS

All metal duct shall be lined according to SMACNA HVAC Duct Construction Standards. Each layer of duct liner shall be attached with 90% coverage of adhesive at the liner contact surface area. Adhesive shall be a non-chlorinated solvent based adhesive. Adhesive shall be supplied in a Portable Adhesive Canister-Clear, code PAC40, as supplied by Duro Dyne Corporation.

Duro Dyne East Division, Bay Shore, NY	631-249-9000	Fax: 631-249-8346
Duro Dyne Midwest Division, Fairfield, OH	513-870-6000	Fax: 513-870-6005
Duro Dyne West Division, Santa Fe Springs, CA	562-926-1774	Fax: 562-926-5778
Duro Dyne Canada, Lachine, Quebec, Canada	514-422-9760	Fax: 514-636-0328
www.durodyne.com E-mail: durodyne@durodyne.com		

©2012 DURO DYNE CORP.  
Printed in the USA 8/12  
BO005418

