

## Non-Corrugated Duct Assembly Instructions

### How to Assemble and Install a Caldwell Aeration System:

Read all directions and study illustrations carefully before starting to assemble and install the Caldwell Aeration Duct. Refer to Bulletin #167-A, Part #719419, for more detailed instructions.

### Shipping:

The Aeration Duct is shipped unassembled and nested together.

### Assembly:

Step 1. Make seam connection on Aeration Duct.

The two parts to be assembled are the solid and perforated duct. Place the aeration duct on a horizontal surface and hook the two lock seams together. Once seams have been locked together, the duct will be formed. (See Figure 1).

Step 2. Place reinforcement rings on duct.

The reinforcement rings are placed around the aeration duct to lock the connection seam in place and retain the duct in its cylindrical shape. The duct is tapered slightly, thus producing a male and female end. The male end is marked by the word "male" stamped on the duct. The reinforcement rings must be slipped into position by starting them over the smaller male (M) end. For the correct location of the reinforcement rings, refer to Figure 2 for 12" duct work, or Figure 3 for 18" duct work.

**IMPORTANT: Place rings for 18" duct in color sequence shown.**

### Installing Aeration System:

Step 1. Install Inlet Adaptor

Select desired location where the aeration duct is to go through the wall. Cut a hole through the wall just large enough to allow the inlet adaptor tube to be inserted through it. Keeping the end of the tube marked "inside" to the inside of the wall, the inlet adaptor may be placed through the opening so that the flange is either on the outside or inside of the wall. The adaptor flange can be either bolted or welded to the wall and sealed with a sealing compound.

Step 2. Layout Aeration Duct

The assembled duct are connected together by slipping the male end of one duct into the female end of another as shown in Figure 4. Using this procedure, start at the inlet adaptor and place the required number of plain duct and follow with the required number of perforated duct. Refer to Figure 5 for a simple method of locking duct joints together. To complete installation, place the plain and perforated end caps on duct layout as shown on Figure 4.

## DUCT LAYOUT

Figure 1: Seam Connection

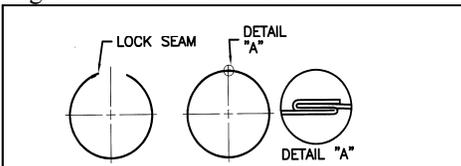


Figure 2: Reinforcement Ring Placement for 12" Duct

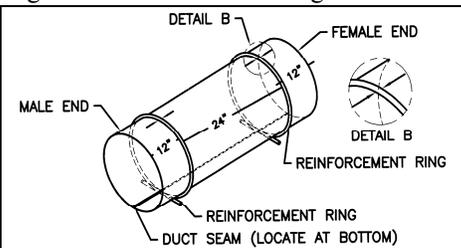


Figure 3: Reinforcement Ring Placement for 18" Duct

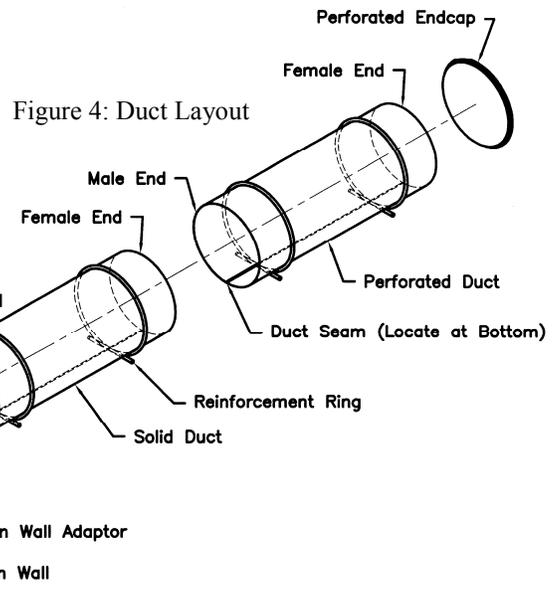
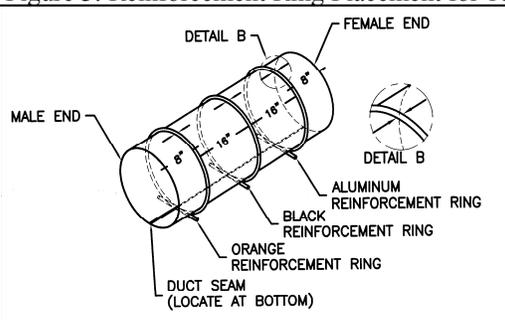


Figure 5: Locking duct joints together

