

QF Press Formed Elbows, Sizes 3" - 7"

3210

ID In.	Bend Degrees Available	CLR (Center Line Radius)	Tangents		Std Weight 30° Lbs	Std Weight 45° Lbs	Std Weight 60° Lbs	Std Weight 90° Lbs	Galvanized Steel	304SS (or 316SS)	
			Galvanized	SS						24ga	14ga
3	15°	1.0 Optional - 1.5	2.00	2.00	0.38	0.90	0.65	0.90	Std	Tubed	
4	30°		1.32	2.00	0.45	1.00	0.80	1.00			
5	45°		1.32	2.00	0.65	0.70	1.15	1.20			
6	60°		1.32	2.00	0.85	1.05	1.35	1.50			
7	90°		1.32	2.25	1.20	1.30	1.65	2.20			



Construction:

Standard galvanized steel 3" to 7" elbows are press formed. Press formed halves are stitch welded together with rolled ends. Stainless steel 3" to 6" elbows are tubed. **Press formed halves are stitch welded together with rolled ends.**

Ends: Standard QF end can be changed to Raw ID (RAWID), Raw OD (RAWOD), No Fitting (NF), Hose Adapter (RAWFLEX), Flat Flange (FFL), Angle Flange (ANGFL), or Van Stone (VANSTONE).

Collars: If End type other than QF is needed or if Epoxy caulking is needed, a collar is located on the exterior side of each port and considered as air flow non-directional. Collars have a laser welded longitudinal seam. If air flow directional product is required, it must be stated on the PO and additional cost may be incurred. A raised lap seam and spot weld are used for attaching the collar to the body and no caulking is used. If caulking is required, additional cost is incurred.

Notes:

Long Radius Elbows available with 1.5 CLR.

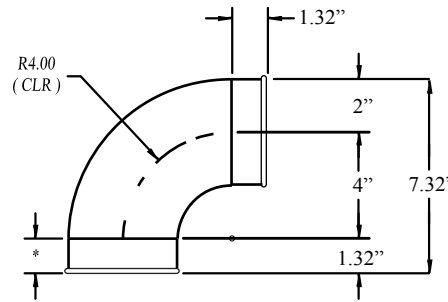
Size 8" to 24" elbows are gored - see 3210 Gored Elbow Technical Data sheet.

Reference Nordfab's QF Machine Adapter Technical Data sheet for actual ID and OD dimensions.

Height of 90° elbows can be calculated:

(Elbow diameter X CLR) + length of one tangent + 1/2 diameter

Example: (4" X 1.0) + 1.32 + 2 = 7.32



Example shown: 4" 90° Elbow 1.0 CLR = 4"

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Temperature Rating of Product Components					
° F	QF Press Formed Elbows	Sealants			
1100°	Galvanized Steel	Optional - 304SS	3M Scotch Seal Metal Sealant 2084	Optional - Rock River Silicone Sealant	Optional - Red Devil HVAC/R High Temperature Silicone Sealant
500°					
400°					
390°					
250°					
194°					
0°					
-40°					
-60°					

Additional Notes
At temperatures ranging between 390° F and 480° F, the zinc-iron alloy layers in galvanized steel will continue to provide a high level of protection from corrosion. However, there may be some peeling, changes in mechanical properties, and reduction in the corrosion protection. Recommended max. service temperature is 390° F.
Rock River Silicone Sealant and Red Devil HVAC/R High Temperature Silicone Sealant are not paintable
304SS: • bluing may occur at 800° F and above

Compliance / Rating of Product Components		
Product	Material	Compliance / Rating
QF Press Formed Elbows	Galvanized	ASTM A653 with a G-90 rating
	304SS	Finish meets ASTM A240
	316SS	Finish meets ASTM A240
3M Scotch Seal Metal Sealant 2084	Acetone blend	AAMA Specification 801.1
Rock River Sealant	100% Silicone	ASTM C920 Class 25, TT-S-00230C Class A and TT-S-001543A, FDA No 421 CFR 117.2600, conforms to FDA requirements
Red Devil HVAC/R High Temperature Sealant	Silicone	ASTM C920 Class 25, TT-S-00230C Class A and TT-S-001543A, CEBTP 432.6 140-2, Mil Spec 46106A, CGSB 19C9-9B, DIN 18540 Part 2, OREX 150031-2