



# The Kingspan **KoolDuct**<sup>®</sup> System

## A SPECIFIER'S GUIDE



**Fibre-free**  
 **Core**

  
**Kingspan**<sup>®</sup>  
*Low Energy –  
Low Carbon Buildings*

# Contents

|  | Page |
|--|------|
| Introduction   | 3    |
| Overview   | 3    |
| What is The <i>Kingspan KoolDuct</i> ® System?                     | 4    |
| History  | 5    |
| What is Different about The <i>Kingspan KoolDuct</i> ® System?     | 6    |
| Applications   | 7    |
| Benefits   | 8    |
| UL Listing   | 8    |
| Fire and Smoke Performance   | 8    |
| Space  | 9    |
| Weight   | 9    |
| Installation Speed   | 10   |
| Hanging  | 11   |
| Connecting Ductwork  | 11   |
| Component Connection   | 11   |
| Frictional Resistance, Air-leakage, Energy Usage and Running Costs | 12   |
| Modifications and Repairs  | 13   |
| Maintenance and Cleaning   | 14   |
| Durability and Lifespan  | 14   |
| Whole Life Cost  | 15   |
| Indoor Air Quality (IAQ)   | 15   |
| Environmental Impact   | 16   |
| Management Systems' Standards                                      | 17   |
| Sustainability & Responsibility                                    | 17   |
| LEED & BREEAM  | 17   |
| Product Specification  | 18   |
| General Physical Properties  | 18   |
| National Construction Code   | 19   |
| Test Certificates  | 20   |
| Prestige Projects  | 22   |

# Introduction

## Overview

The heating, ventilation and air-conditioning (HVAC) industry is in the midst of a dynamic era. However, air-distribution ductwork, a critical component of HVAC systems, has remained virtually unchanged since the early 1900s.

Several factors have introduced the need to revolutionise HVAC ductwork. Energy use has continued to escalate, and thus the demand for energy reducing solutions has intensified. Requirements for clean air are becoming increasingly prevalent. Speed of construction has become a valuable asset. Floor space and headroom are under constant pressure.



Traditionally, HVAC ductwork is constructed from galvanised sheet steel, which is installed first and then insulated separately as a second operation. The *Kingspan KoolDuct* System however, is an advanced and innovative pre-insulated rectangular HVAC ductwork system, which is installed in a single-fix.



The *Kingspan KoolDuct* System eliminates virtually all of the problems associated with galvanised sheet steel, mineral fibre duct board and pre-insulated rigid polyisocyanurate (PIR) ductwork systems whilst, at the same time, offering additional advantages to the specifying engineer, the architect, the M&E contractor, the fabricator, the facilities manager, the property developer and the building owner.

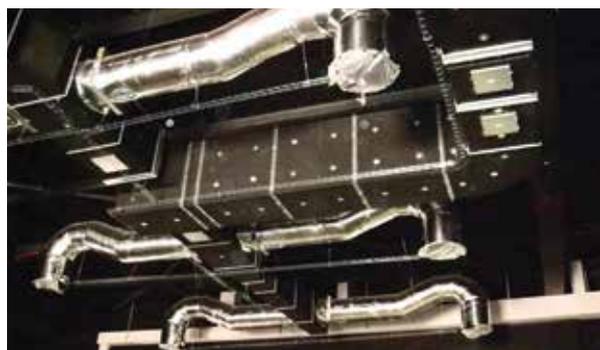


Ductwork fabricated from The *Kingspan KoolDuct* System, is the only premium performance pre-insulated ductwork in the world to be UL Listed as a Class 1 Air Duct, to Standard for Safety UL 181 (Underwriters Laboratories: Factory Made Air Ducts & Air Connectors), when fabricated to a specification clearly defined by UL.



In addition, ductwork fabricated from The *Kingspan KoolDuct* System can reduce air-leakage rates to a fraction of those typical of rectangular sheet metal ductwork. This cutting edge System thus offers the triple benefits of cutting energy use, cutting operational carbon dioxide (CO<sub>2</sub>) emissions and cutting costs.

As a result, The *Kingspan KoolDuct* System should be considered the ductwork system of choice, where low embodied environmental and low operational environmental impacts are key requirements.



# Introduction

## What is The *Kingspan KoolDuct*<sup>®</sup> System?

The *Kingspan KoolDuct*<sup>®</sup> System comprises premium performance *Kingspan KoolDuct*<sup>®</sup> panels, fabrication methods, coupling systems and a complete line of accessories to produce pre-insulated rectangular ductwork in sections up to 3.93 m long.

*Kingspan KoolDuct*<sup>®</sup> panels are available in the following thicknesses and corresponding installed R-values<sup>\*</sup>:

- 22 mm = R0.92;
- 30 mm = R1.35;
- 46 mm = R2.0

<sup>\*</sup>Minimum order quantities apply

<sup>^</sup>All R-values tested at 23°C and declared in accordance with AS/NZS 4859.1:2018

This allows ductwork to be fabricated with different wall thicknesses to suit different performance specifications. *Kingspan KoolDuct*<sup>®</sup> panels comprise a fibre-free rigid thermoset phenolic



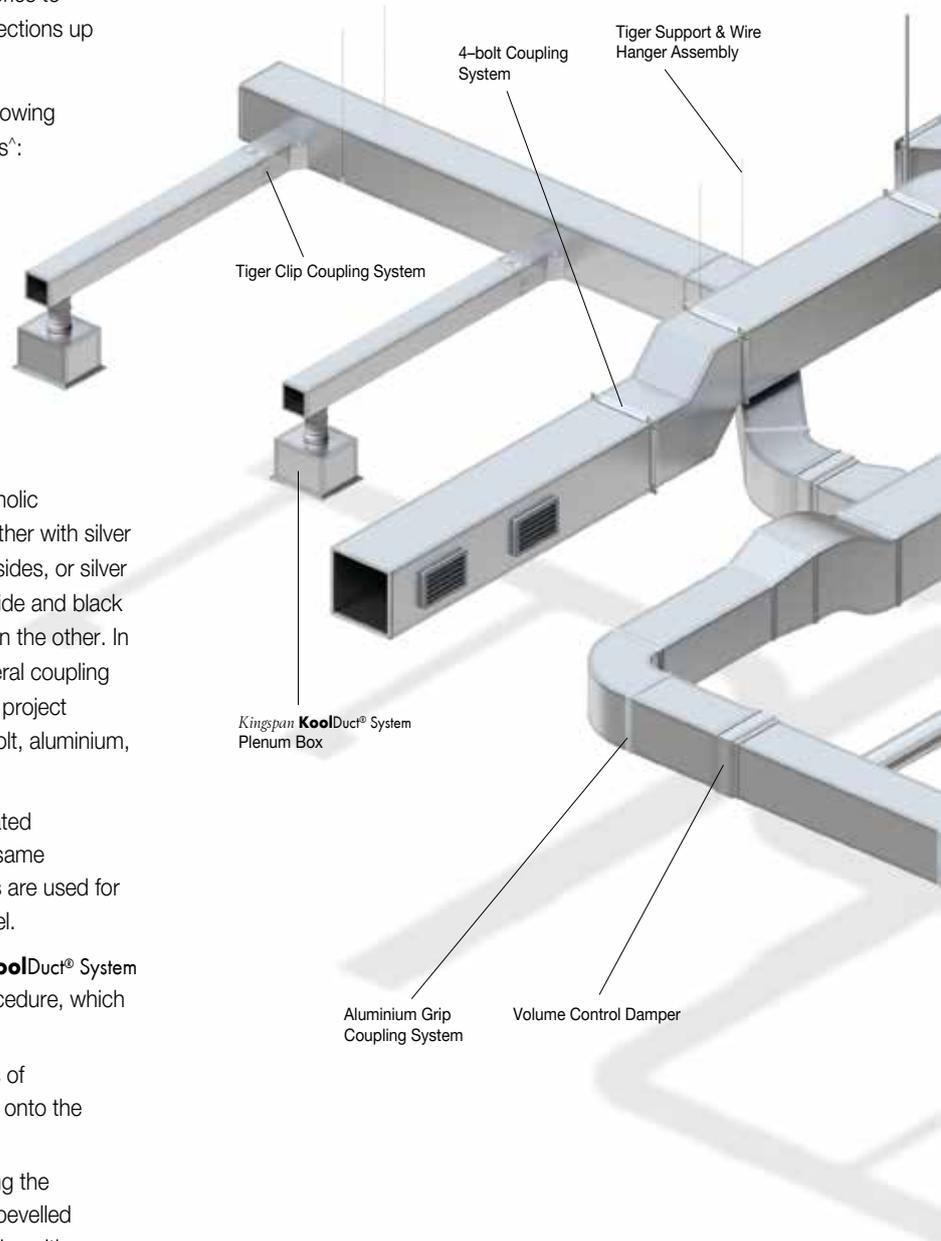
insulation core faced either with silver aluminium foil on both sides, or silver aluminium foil on one side and black coated aluminium foil on the other. In addition, there are several coupling

systems available to suit different installation and project specification requirements. They include the 4-bolt, aluminium, tropical and Tiger Clip systems.

The design of ductwork, including fittings, fabricated from The *Kingspan KoolDuct*<sup>®</sup> System, follows the same calculation principles and duct sizing methods as are used for ductwork constructed from galvanised sheet steel.

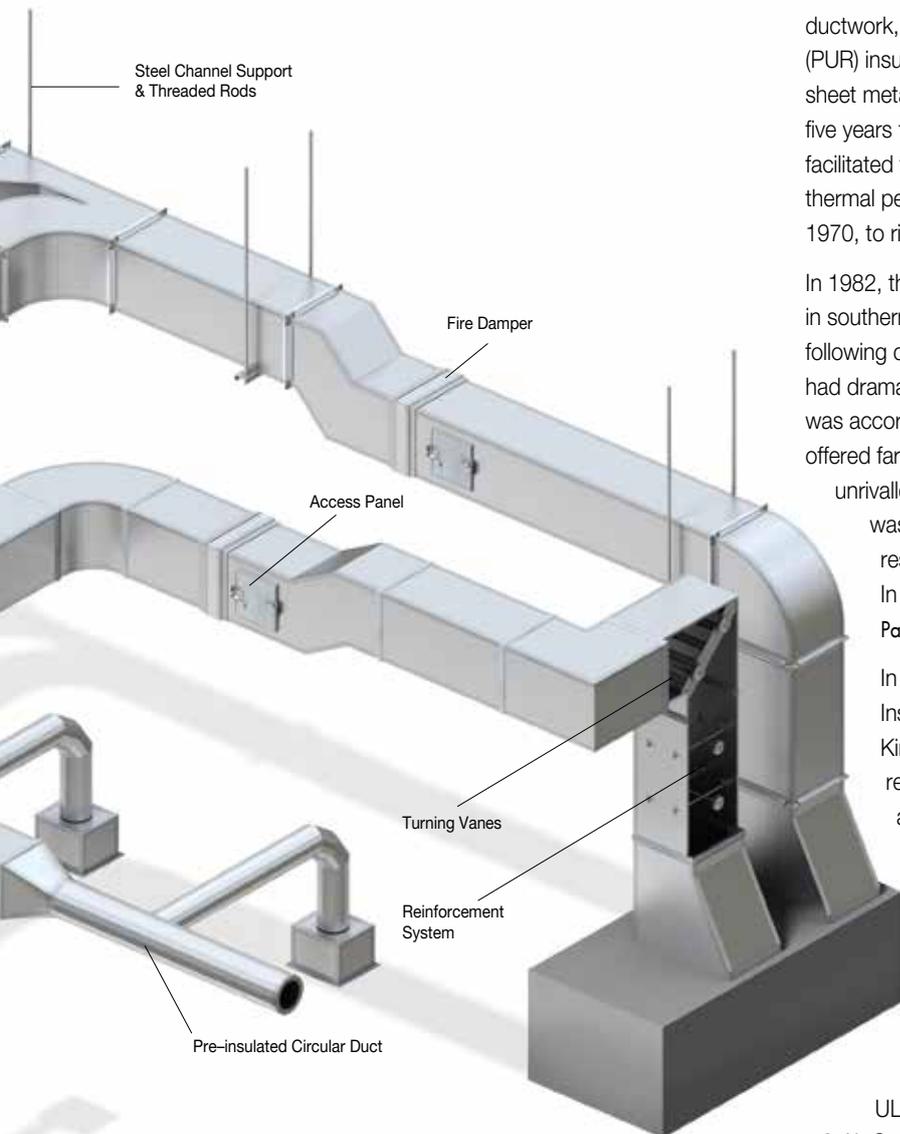
The fabrication of ductwork from The *Kingspan KoolDuct*<sup>®</sup> System is accomplished by following a standardised procedure, which incorporates the following processes:

- manually tracing / digitally nesting the outlines of ductwork sections, fittings and plenum boxes onto the internal surface of *Kingspan KoolDuct*<sup>®</sup> panels;
- cutting bevelled edges at different angles along the outlines to form folded or butted mitre joints, bevelled male-female joints and non-bevelled joints using either hand tools for manual fabrication, or CNC blade / router machinery for automated fabrication;
- assembling the cut pieces into the desired shape and securing into place with *Kingspan KoolDuct*<sup>®</sup> System Adhesive or Tiger Clips;
- taping joints and exposed insulation edges with a protective and durable aluminium foil vapour barrier tape;
- reinforcing ductwork sections and fittings, if required;



- sealing the internal side of all mitre joints with *Kingspan KoolDuct*<sup>®</sup> System High Performance Silicone Sealant;
- coupling ductwork sections and fittings; and
- inspecting finished ductwork to ensure that it is fit for the purpose intended.

Kingspan Insulation offers a complete product line, providing all materials, tools and accessories necessary for the effective fabrication of ductwork from The *Kingspan KoolDuct*<sup>®</sup> System. For further details please contact Kingspan Insulation.



Accurate fabrication and best practice installation are crucial in ensuring compliance with legislation, delivering required thermal performance levels and reducing air-leakage rates to a minimum. As a result, ductwork from The *Kingspan KoolDuct*<sup>®</sup> System is only fabricated by specially trained fabricators who have completed The *Kingspan KoolDuct*<sup>®</sup> System Training Course, and whose competencies are regularly reviewed. The required standards of fabrication are detailed in The *Kingspan KoolDuct*<sup>®</sup> System Fabrication Manual series of publications.

## History

The history of The *Kingspan KoolDuct*<sup>®</sup> System dates back to 1965 when the world's first system of pre-insulated HVAC ductwork, which used aluminium faced rigid polyurethane (PUR) insulation boards in place of mineral fibre insulated sheet metal, was established by Claudio Ferraro of Pall. In the five years that followed, innovations in materials science had facilitated the development of insulants with improved fire and thermal performance. As a result, the insulant was changed, in 1970, to rigid polyisocyanurate (PIR).

In 1982, the System went global, having proved its success in southern European markets. However, by the end of the following decade, legislation governing fire safety in buildings had dramatically increased in stringency. In 1992, the insulant was accordingly upgraded to a new material that not only offered far superior fire and smoke performance, but also an unrivalled thermal performance. This cutting edge material was a premium performance rigid thermoset modified resin insulant, developed by **Kooltherm**<sup>®</sup> Insulation Ltd. In that same year, the System was re-launched as The **Pal KoolDuct**<sup>®</sup> System.

In 1996, Kingspan Group plc acquired **Kooltherm**<sup>®</sup> Insulation Ltd and eventually assimilated it into Kingspan Insulation Ltd, which subsequently became responsible for marketing the System in the UK and Ireland as The *Kingspan KoolDuct*<sup>®</sup> System.

Responsibility in all other geographical regions was maintained by Pal International Srl, which continued to purchase the premium performance insulant from Kingspan Industrial Insulation Ltd.

Four years later, ductwork fabricated from the System became UL Listed to Standard for Safety UL 181 (United Laboratories: Factory Made Air Ducts & Air Connectors). Today, it remains the only one of its kind in the world to be so, when fabricated to a specification clearly defined by UL.

In 2007, Kingspan Insulation Ltd acquired the rights from Pal International Srl for the marketing and development of the System in all geographical regions, except for the USA and Canada. This swiftly changed in 2009, when Kingspan Insulation Ltd expanded its operations across these two countries, subsequently assuming full global responsibility for the System.

In 2010, the premium performance pre-insulated rectangular HVAC ductwork system was relaunched as The *Kingspan KoolDuct*<sup>®</sup> System, in all geographical regions.

# Introduction

## What is Different about The *Kingspan* **KoolDuct®** System?

The *Kingspan KoolDuct®* System offers numerous benefits in comparison with insulated galvanised sheet steel, mineral fibre duct board and pre-insulated rigid polyisocyanurate (PIR) ductwork systems. Benefits include, but are not limited to, the following:

- **UL Listed** – UL Listed as a Class 1 Air Duct, to Standard for Safety UL 181 (Underwriters Laboratories: Factory Made Air Ducts & Air Connectors), when fabricated to a specification clearly defined by UL;
- **low weight** – weighs up to 75% less than ductwork constructed from galvanised sheet steel and insulated with mineral fibre – this makes it ideal for refurbishment projects, where existing building structures have insufficient load capacities for new service loads;
- **faster installation speeds** – low weight ductwork fabricated in sections up to 3.93 m long, single-fix installation and no need to install insulation as a second operation, reduces project scheduling periods for insulated ductwork;
- **space saving** – typically saves up to 150–200 mm in a single dimension, since the space required to manually install a separate layer of insulation around the ductwork is eliminated – this allows ductwork to be installed flush to ceilings, walls and floors, as well as to surfaces within confined enclosures;



- **installed cost savings** – reduced labour and materials, including fixings and first level support members, can provide an ideal value engineered ductwork solution without compromising performance;
- **low air-leakage** – rates can be reduced to a fraction of those typical of rectangular sheet metal ductwork;
- **reduced energy usage and running costs** – low ductwork air-leakage can yield significant electrical consumption savings because of reduced heating and cooling loads, and fan energy usage;
- **flexibility** – ductwork configurations can be easily modified and adapted onsite to deal with unexpected changes to the design, which may be required to circumvent unforeseen obstructions and other building design issues;
- **whole life cost saving** – up to 20% over 30 years, compared with ductwork constructed from galvanised sheet steel and insulated with mineral fibre;
- **low embodied environmental impact** – up to 65% less than that of rock mineral fibre insulated galvanised sheet steel ductwork;
- **reduced operational carbon dioxide (CO<sub>2</sub>) emissions** – as a result of low ductwork air-leakage, and the subsequent reduction in operational energy use;
- **reduced workshop-generated waste** – computer aided fabrication can greatly reduce the volume of waste, compared with manual fabrication; and
- **a fibre-free rigid insulation core** – minimises the risk of loose fibres entering the airstream through the ductwork, since distributed air does not come into contact with an insulation material that produces loose fibres.

Further information on each of the above can be found in the Benefits section of this document.

## Applications

### Suitability

The *Kingspan KoolDuct®* System is designed for use in building services / HVAC applications. It is suitable for both new build and refurbishment projects in the residential, commercial, public, light industrial and leisure sectors. Moreover, it is especially suitable for use in non-ferrous applications such as MRI scanning units in hospitals, and on other high specification projects where insulants with a fibre-free core may be preferred, for instance, in:

- the food, beverage and pharmaceutical industries;
- clean air and hygiene controlled environments;
- high relative humidity environments;
- swimming pools\*; and
- sterile areas in medical research and healthcare facilities and communication / server rooms in data centres.

*\* For swimming pools, non-standard applications and project specific advice, please contact Kingspan Insulation.*



Ductwork fabricated from The *Kingspan KoolDuct®* System can be installed indoors, outdoors, visibly mounted, concealed above false ceilings, concealed below raised floors or within confined enclosures such as pre-fabricated modules. Furthermore, its versatility enables individual system components, such as plenum boxes, risers and straight sections, to be integrated with sheet metal ductwork, whilst larger sized ducts, with a cross-sectional dimension greater than 2 m, are easily fabricated.

Ductwork fabricated from The *Kingspan KoolDuct®* System has an intrinsic aesthetically pleasing appearance, which makes it particularly attractive for open-to-view applications. The availability of *Kingspan KoolDuct®* panels with a black coated facing makes them ideal for use in the fabrication of pre-insulated plenum boxes, as well as for projects that require an unobtrusive air-distribution solution without the added expense of a cosmetic surface finish e.g. theatres, cinemas and nightclubs.

### Operating Recommendations & Limitations

It is recommended that ductwork fabricated from The *Kingspan KoolDuct®* System is used for operation as supply, return, fresh and exhaust air ductwork for heating, ventilation and air-conditioning systems within the following limits:

|                          |   |
|--------------------------|---|
| Mean Air Velocity (Max.) | 25.4 m/s  |
| Design Pressure (Max.)*  | Positive: 1000 Pa<br>Negative: 750 Pa   |
| Temperature              | Internal air temperature of<br>-26°C to +85°C<br>during continuous operation.   |
| Size                     | Unlimited (provided that <i>Kingspan KoolDuct®</i> System fabrication techniques and procedures are strictly observed). |

Table 1: Operating Limits for Ductwork Fabricated from the *Kingspan KoolDuct®* System

*\*These are maximum values and vary depending upon both the coupling system and the size of the ductwork. Refer to The *Kingspan KoolDuct®* System Fabrication Manual series of publications for details.*

*NB 'Mean Air Velocity' refers to the design air flow rate related to the cross-sectional area of the ductwork. 'Design Pressure' relates to the actual total pressure of the relevant section of ductwork and not the fan static pressure. 'Total Pressure' is a combination of both static and dynamic pressures.*

Ductwork fabricated from The *Kingspan KoolDuct®* System should not be used in the following applications:

- conveyance of solids;
- fire resistant ductwork;
- kitchen / grease hood exhaust systems;
- chemical, fume or smoke exhaust systems;
- where combustible matter readily collects inside the ductwork;
- adjacent to any mechanical / electrical sources of extreme heat;
- outdoor / underground use without mechanical and / or weather protection;
- where the failure of automatic control equipment may give rise to extreme temperatures; and
- with equipment of any type that does not include automatic maximum temperature controls.



# Benefits

## UL Listing

Ductwork fabricated from The *Kingspan KoolDuct®* System is UL Listed as a Class 1 Air Duct, to Standard for Safety UL 181 (Underwriters Laboratories: Factory Made Air Ducts & Air Connectors). The UL Listing requires that ductwork is fabricated using:



- *Kingspan KoolDuct®* panels, faced with silver aluminium foil autohesively bonded to the insulation core, on both sides, during their manufacture at Kingspan Insulation's Somerton, VIC, manufacturing facility;
- either, or a combination of, the 4-bolt, the aluminium grip and / or Tiger Clip coupling systems;
- an aluminium foil vapour barrier tape that is UL Listed A-P to Standard for Safety UL 181 A (Underwriters Laboratories: Standard for Closure Systems for use with Rigid Air Ducts); and
- Kingspan High Performance Silicone Sealant / Caulk.

To meet UL Class 1 Air Duct requirements, ductwork fabricated from The *Kingspan KoolDuct®* System and / or the individual components from which it is fabricated, must withstand the stringent conditions to which they are subjected in a series of rigorous physical tests. They include: surface burning characteristics; burning; flame penetration; mould growth and humidity; puncture; pressure; corrosion; erosion; static load; impact; collapse; air-leakage; and low and high temperatures.

The results of the UL Fire Test Standards achieved by *Kingspan KoolDuct®* panels, faced with silver aluminium foil on both sides, are shown in Table 2.

| Standard   | Result  |
|--|---|
| UL 723<br>(Test for Surface Burning Characteristics of Building Materials) | Flame spread / smoke developed indices:<br>< 25/50  |
| UL 181<br>(Factory Made Air Ducts & Air Connectors)                        | Burning (as part of fabricated duct section):<br>Pass<br><br>Flame penetration:<br>30 Minutes |

Table 2: Results of UL Fire Test Standards Achieved by *Kingspan KoolDuct®* Panels Faced with Silver Aluminium Foil on Both Sides

UL Listed ductwork, fabricated from The *Kingspan KoolDuct®* System, satisfies the requirements for:

- pre-insulated HVAC ductwork, as approved by the UAE Ministry of Interior Dubai Civil Defense, and the State of Qatar Ministry of Interior General Admin of Civil Defense.
- Non-metallic Ducts and Factory Made Ducts, as defined by the International Mechanical Codes (IMC) and International Residential Codes (IRC), respectively, of the International Code Council (ICC); and

- Class 1 Rigid Air Ducts, as defined by the National Fire Protection Assembly (NFPA) Standards for the Installation of Air-conditioning & Ventilating Systems (90A), and the Installation of Warm Air Heating & Air-conditioning Systems (90B).

To maintain the UL Listing for ductwork fabricated from The *Kingspan KoolDuct®* System, Kingspan Insulation must: deliver a programme of production control; regularly provide samples for audit testing; and allow unannounced periodic inspections of the manufacturing facility that produces *Kingspan KoolDuct®* panels, by UL representatives.

Further details of the UL Listing for ductwork fabricated from The *Kingspan KoolDuct®* System are published at: [www.ul.com](http://www.ul.com) in the 'Online Certifications Directory'. To view the listing, type 'Kingspan Insulation' under the search parameter 'Company Name', followed by 'MH25124' under the search parameter 'UL File Number'.

## Fire Performance

### Properties

The insulation core of *Kingspan KoolDuct®* panels is a rigid thermoset material and, unlike thermoplastic materials, it does not melt, drip or produce flaming droplets. Its intricately cross-linked structure makes it difficult to ignite and, when subjected to fire, its outer surface forms a strong carbonaceous layer that limits heat generation and retards further flame spread. Moreover, there is an almost complete absence of smoke, when subjected to a flame source.

In addition, the insulation core has a resistance to burning and spread of flame far superior to that of flexible elastomeric foam (FEF), rigid polyurethane foam (PUR) and rigid polyisocyanurate foam (PIR) insulants.

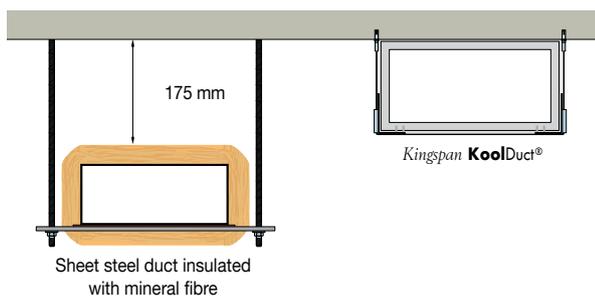


### Classifications & Compliance

*Kingspan KoolDuct®* panels, faced with silver aluminium foil on both sides, satisfy the requirements for the surface burning characteristics of foam plastic insulation, as defined by the International Building Codes (IBC) and the International Residential Codes (IRC) of the International Code Council (ICC).

## Space

Ductwork fabricated from The *Kingspan KoolDuct®* System is space saving by virtue of eliminating the space required to manually install a separate layer of insulation around the ductwork. Moreover, ductwork fabricated from The *Kingspan KoolDuct®* System can be installed flush to ceilings, walls and floors, as well as to surfaces within confined enclosures. This can typically save 150–200 mm of valuable space, making it ideal for use in service runs, raised floors and pre-fabricated modules.



Thinner insulation, as a result of the insulating efficiency of *Kingspan KoolDuct®* panels, further contributes to space savings. The aged thermal conductivity (k-value / I-value) of *Kingspan KoolDuct®* panels is as low as 0.023 W/m·K at 23°C mean (ASTM C 518 – Standard Test Method for Steady-State Thermal Transmission Properties by Means of the Heat Flow Meter Apparatus). This makes *Kingspan KoolDuct®* panels the most thermally efficient, and hence the thinnest, insulation product commonly used for pre-insulated HVAC ductwork.

| Thickness | Installed R-value |
|-----------|-------------------|
| 22 mm     | R0.92             |
| 30 mm     | R1.35             |
| 46 mm     | R2.0              |

Table 3: Installed Material Thermal Resistances of *Kingspan KoolDuct®* Panels

A cost analysis of the benefits that the aforementioned space saving ability has on floor-to-floor dimensions, in UK multi-storey buildings, was performed by independent consultants Rider Levett Bucknall. The results of the analysis showed that, if floor-to-floor heights can be reduced to take advantage of these space saving abilities, the use of ductwork fabricated from The *Kingspan KoolDuct®* System, as part of a variable air volume (VAV) air-conditioning system, can save 1–2% in overall project construction cost. This saving comes predominantly from reduced structure, cladding and internal wall, and wall finishing costs.

In addition, ductwork fabricated from The *Kingspan KoolDuct®* System can be supplied in flat form, ready for assembly onsite. Consequently, the load space required for the transportation of pre-assembled ductwork from the workshop to site, as well as the number of vehicles, could be reduced. This could provide a further benefit where the space and access required for the off-loading of goods from large vehicles may be restricted.

## Weight

Ductwork fabricated from The *Kingspan KoolDuct®* System can weigh up to 75% less than ductwork constructed from galvanised sheet steel and insulated with mineral fibre.

The low weight of ductwork fabricated from The *Kingspan KoolDuct®* System can enable easier installation and much lower handling costs, since fewer people are required to install a ductwork section. Two individuals can quickly and easily install large ductwork sections.

Most 3.93 m long sections of ductwork fabricated from The *Kingspan KoolDuct®* System, regardless of the choice of coupling system, weigh 23 kg or less. This is below the maximum manual handling and lifting weight limits for an individual in the workplace, as recommended by many health and safety regulatory authorities.



For instance, a 3.93 m long ductwork section, fabricated to meet the requirements for a 500 Pa low pressure HVAC system and having an internal perimeter of 800 mm, a wall thickness of 22 mm and using either the 4-bolt or aluminium grip coupling system, weighs less than 7.5 kg.

A larger sized section, having an internal perimeter of 2800 mm and using the Tiger Clip coupling system, but otherwise the same as the aforementioned specification, can weigh less than 23 kg.

Tables of weights for ductwork sections fabricated from The *Kingspan KoolDuct®* System, of various dimensions and with the different coupling systems, are contained in The *Kingspan KoolDuct®* System Fabrication Manual series of publications.

# Benefits



The low weight of ductwork fabricated from The *Kingspan KoolDuct*<sup>®</sup> System makes it especially suitable for use in pre-fabricated modules, which may have to be transported long distances to site. Moreover, the requirement for specialised heavy-duty mechanical handling and lifting equipment can be reduced, which makes ductwork fabricated from The *Kingspan KoolDuct*<sup>®</sup> System particularly favourable for riser sections that span multiple storeys in high-rise buildings.

Many older buildings undergoing refurbishment may not be designed to support the additional weight of retrospectively installed sheet steel ductwork and its insulation. In such circumstances, ductwork fabricated from The *Kingspan KoolDuct*<sup>®</sup> System can generally alleviate the requirement for additional structural support.

Research, conducted in the UK by independent consultants Rider Levett Bucknall, into a number of refurbishment projects in which ductwork fabricated from The *Kingspan KoolDuct*<sup>®</sup> System, comprising 22 mm *Kingspan KoolDuct*<sup>®</sup> panels and the aluminium grip coupling system, was installed, has shown that the main reason for its specification was that it could overcome severe constraints on structural loadings.

## Installation Speed

Ductwork fabricated from The *Kingspan KoolDuct*<sup>®</sup> System has a single-fix installation and eliminates the need to install insulation as a second operation, thus reducing time onsite and contractor management through faster installation speeds.

The ability to fabricate ductwork from The *Kingspan KoolDuct*<sup>®</sup> System in up to 3.93 m long sections, rather than the standard 1.2 m or 1.5 m lengths, as is the case with sheet steel ductwork, means fewer sections and less handling. This, combined with the low weight of ductwork fabricated from The *Kingspan KoolDuct*<sup>®</sup> System, the requirement for fewer supports and ease of handling, results in a fast-track installation.



Research, conducted in the UK by independent consultants Rider Levett Bucknall, into a number of refurbishment projects in which ductwork fabricated from The *Kingspan KoolDuct*<sup>®</sup> System, comprising 22 mm *Kingspan KoolDuct*<sup>®</sup> panels and the aluminium grip coupling system, was installed, has shown that the main reason for its selection was that it could be installed up to three times faster than sheet steel ductwork – without even taking into account the time required to install insulation separately as a second operation. Rider Levett Bucknall also concluded that panel thickness has no effect on the speed of installing ductwork fabricated from The *Kingspan KoolDuct*<sup>®</sup> System. Faster installation obviously means lower costs and less disruption for other trades onsite.

In addition to a reduction in the risk of incurring penalties for late completion of the insulated ductwork contract on some projects (in addition to an increase in the possibility of attaining rewards for early completion), faster installation obviously means lower costs and less disruption for other trades onsite.

## Hanging

The light weight of ductwork fabricated from The *Kingspan KoolDuct®* System can enable fewer hanging supports to be used, resulting in a quicker install and reduced install costs.

The *Kingspan KoolDuct®* System can be installed using all common ductwork hanging systems, including:

- Metal channel and threaded rod
- Wire rope hanging system
- *Kingspan KoolDuct®* Tiger hangers.

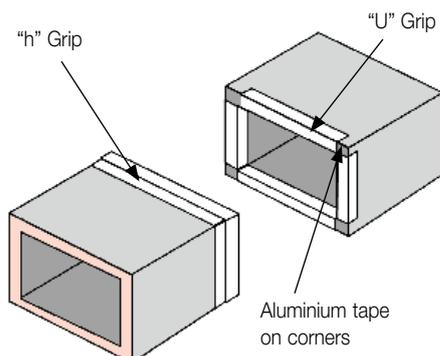
Ductwork fabricated from The *Kingspan KoolDuct®* System can be easily supported by lightweight wire systems or low gauge metal hangers and supports. Furthermore, supports can be installed at larger centres than with ductwork constructed from galvanised sheet steel. The UL Listing for ductwork fabricated from The *Kingspan KoolDuct®* System allows for a maximum spacing of 3.96 m centres for supports. Galvanised sheet steel ductwork, on the other hand, often requires heavier and more robust support systems e.g. uses rolled steel channel, angle or profile bearer sections with drop rod, studding or stirrup hangers, installed at smaller centres.



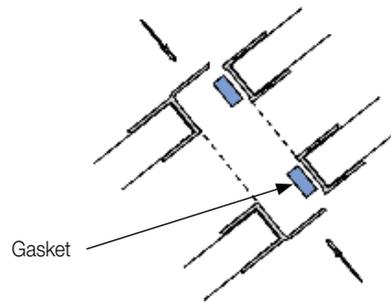
## Connecting Ductwork

The *Kingspan KoolDuct®* System includes a number of different connecting systems, depending on application, climate zone, system design and building constraints. They include:

- Tiger Clips, for smaller ductwork and lower pressure systems
- Aluminium connectors, for space sensitive applications
- 4-bolt flange, for general application, including larger ductwork and medium pressure applications
- Tropical flange, for humid climate conditions.



Example of a tropical flange

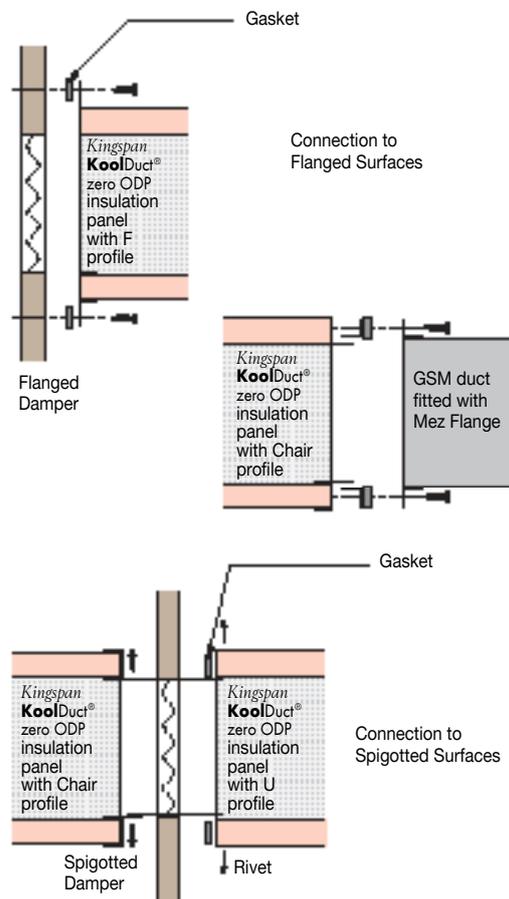


## Component Connection

The *Kingspan KoolDuct®* System is completely compatible with all standard duct system components including fans, air handling units, volume control dampers, fire dampers, access panels, flexible duct, and even galvanised sheet metal ductwork.

A full range of profiles is offered which enables connection to virtually any type of surface. All components typically either have a flanged connection or a spigotted connection. Note that gasket is always used in the joint.

Finally, flexible joints are easily accommodated and should always be used for connection to fans.



# Benefits

## Frictional Resistance, Air-leakage, Energy Usage & Running Costs

The frictional resistance of ductwork fabricated from The *Kingspan KoolDuct® System* is comparable with that of galvanised sheet steel ductwork. Testing, conducted in the UK by independent testing and research organisation BSRIA, on ductwork sections of different sizes with a range of fittings, has shown that at velocities of 2–20 m/s, the resistance to airflow is almost identical.

As a result, frictional pressure drop data for galvanised sheet steel ductwork may also be used when designing ductwork systems fabricated from The *Kingspan KoolDuct® System*.

Furthermore, The *Kingspan KoolDuct® System* produces pre-insulated ductwork where the air-leakage rate can be reduced to a fraction of that typical of sheet metal ductwork. A low air-leakage rate can yield significant electrical consumption savings, because of reduced heating and cooling loads, and reduced fan energy usage.

For ductwork systems designed to withstand a maximum static pressure of 1000 Pa, ductwork fabricated from The *Kingspan KoolDuct® System*, with different coupling systems, can easily achieve the air-leakage classes shown in Table 6. Standard construction sheet metal ductwork, however, may find it difficult to achieve the same air-leakage classes.

| Air-leakage Standard | Air-leakage Classes Achievable with Different Coupling Systems |                |            |
|----------------------|--|----------------|------------|
|                      | 4-bolt   | Aluminium Grip | Tiger Clip |
| BS EN 1507: 2006     | Class D  | Class C        | Class D    |
| BS EN 13403: 2003    | Class C  | Class C        | Class C    |
| SMACNA               | Class 3  | Class 3        | Class 3    |
| B&ES (HVCA) DW/144   | Class C  | Class C        | Class D    |

*BS EN 1507: 2006 (Ventilation for buildings. Sheet metal air ducts with rectangular section. Requirements for strength and leakage).*

*BS EN 13403: 2003 (Ventilation for buildings. Non-metallic ducts. Ductwork made from insulation ductboards).*

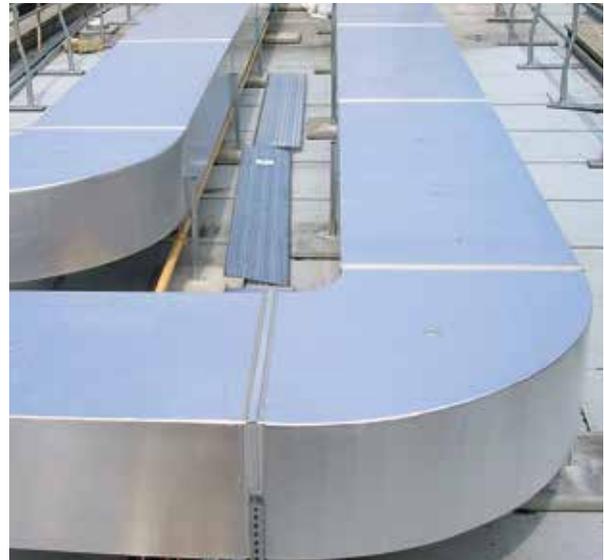
*SMACNA (Sheet Metal and Air Conditioning Contractors' National Association – HVAC Air Duct Leakage Test Manual, 1985 Edition).*

*B&ES (HVCA) DW/144 (Building & Engineering Services Association – formerly known as the Heating & Ventilation Contractors Association' – Specification for Sheet Metal Ductwork, 1998 Edition).*

Table 6: Air-leakage Classes easily Achievable by Ductwork Fabricated from The *Kingspan KoolDuct® System*

Specifying the best ductwork air-leakage standards possible can be a relatively simple, yet inexpensive, step to take toward reducing the overall operational energy use of a building.

In order to illustrate this point, Kingspan Insulation commissioned a review, by independent testing and research organisation BSRIA, of the implication of ductwork specification and different ductwork air-leakage rates on energy consumption.



The methodology given in BSRIA's report was used to compare a 100 m long run of ductwork fabricated from The *Kingspan KoolDuct® System*, with a 100 m long run of galvanised sheet steel ductwork. Both runs had cross-sectional internal dimensions of 600 x 600 mm.

BSRIA's methodology demonstrated that ductwork fabricated from The *Kingspan KoolDuct® System* can save 31% of the energy, and thus cost, required to run a fan, in a HVAC system with a typical design flow rate of 7.5 m/s. This saving can be even greater for lower design flow rates.

Kingspan Insulation commissioned a review by independent consultants, Rider Levett Bucknall, of the implications of reduced fan power on actual energy usage. Rider Levett Bucknall concluded that for a 100 m long run of ductwork, with cross-sectional internal dimensions of 600 x 600 mm and an air velocity of 7.5 m/s, ductwork fabricated from The *Kingspan KoolDuct® System* could save 3100 kW·h per annum.

This energy saving equates to a saving of 1.3 metric tons of CO<sub>2</sub> equivalent emissions per annum, or 39 metric tons over 30 years.

Rider Levett Bucknall carried out a further review of the implications of reduced fan power, this time on fan size and capital cost. The conclusion was that an 11.6% reduction in the size of the fan could be achieved, yielding a 10% capital cost saving.

Separate research, conducted in the US by mechanical and electrical engineering services firm, MDA Engineering Inc., under the auspices of Luther Home of Mercy, has also shown that HVAC system running costs can be dramatically reduced as a result of the low air-leakage rate of ductwork fabricated from The *Kingspan KoolDuct®* System.

The research utilised empirical data derived from the independent testing of two HVAC installations in two separate new construction buildings belonging to Luther Home of Mercy. Both buildings had a ground floor area of 650 m<sup>2</sup> and were identical in design. It compared an installation using ductwork fabricated from The *Kingspan KoolDuct®* System, comprising 22 mm *Kingspan KoolDuct®* panels and the Tiger Clip coupling system, with an installation using galvanised sheet steel ductwork insulated with 51 mm thick glass fibre duct wrap. The ductwork and HVAC system design, layout and performance specification were identical.

The recorded air-leakage rate of the HVAC installation using ductwork fabricated from The *Kingspan KoolDuct®* System was 79% less than that using glass fibre insulated galvanised sheet steel ductwork. Furthermore, the former exceeded the requirements of SMACNA (Sheet Metal & Air Conditioning Contractors' National Association) Air-leakage Class 24, with a leakage rate 64% of the maximum allowable. In contrast, the latter failed to meet the requirements with a leakage rate more than 3 times that allowable.

An analysis of the results showed that the substantial reduction in HVAC system air-leakage, achieved by the ductwork fabricated from The *Kingspan KoolDuct®* System, yielded a correspondingly significant 70% reduction in projected first year running costs relating to energy use – predicting that it would save 7120 kWh per annum, or 213,600 kWh over 30 years.

This substantial saving in energy equates to a CO<sub>2</sub> emissions saving of 5.7 metric tons per annum, or 170 metric tons over 30 years.

As a result, it is estimated that the ductwork fabricated from The *Kingspan KoolDuct®* System would reduce CO<sub>2</sub> emissions by 8.74 kg/m<sup>2</sup> of building floor area.

## Modifications & Repairs

Ductwork fabricated from The *Kingspan KoolDuct®* System can be easily modified and adapted. For this reason, it is ideal for instances when the configuration of a HVAC system needs to be altered onsite e.g. to accommodate changes to the design of a building during the construction period.

Furthermore, the ability to modify and adapt ductwork fabricated from The *Kingspan KoolDuct®* System with ease, makes it especially suitable for buildings undergoing refurbishment e.g. where space to manoeuvre is restricted, or unforeseen obstacles, discovered only after the works have started or after the building structure has been fully exposed, could cause delays and subsequent increases in associated project costs.

In addition, its low weight, flexibility and ability to be fabricated both onsite and offsite, allows modifications to be carried out quickly and with minimal disruption to business. This can be particularly important in the retail, manufacturing and light industrial processing sectors where disturbances can result in unnecessary expense.

Research, conducted in the UK by independent consultants Cyril Sweett, has shown that ductwork fabricated from The *Kingspan KoolDuct®* System is subject to minimal damage, thus requiring minimal repairs, particularly where ductwork is installed within a ceiling void.

Nevertheless, localised damage to ductwork fabricated from the *Kingspan KoolDuct®* System can be repaired in-situ, in an efficient and economical manner. This is opposed to replacing an entire ductwork section, which could be the case with some other ductwork systems and which could prove to be costly.



# Benefits

## Maintenance & Cleaning

It is generally deemed good practice for mechanical ventilation systems, including ductwork, to be maintained in an efficient state, in efficient working order and in good repair. This includes being cleaned, as appropriate.

Poorly maintained and dirty ducts could contribute to increased costs. For instance, the accumulation of dust and debris could negatively affect the volume of airflow at registers or diffusers, subsequently increasing HVAC system energy usage, and therefore operating costs.

Ductwork fabricated from The *Kingspan KoolDuct®* System can be easily and economically cleaned to industry standards, as required by BS EN 15780: 2011, BS EN 13403: 2003, NADCA ACR: 2006 and B&ES (HVCA) TR/19 (refer to Table 7 for full titles), using many of the dry and non-abrasive cleaning methods offered through professional HVAC ductwork cleaning specialists.

| Standard          | Title   |
|-------------------|---|
| BS EN 15780: 2011 | Ventilation for buildings – Ductwork – Cleanliness of ventilation   |
| BS EN 13403: 2003 | Ventilation for Buildings. Non-metallic ducts. Ductwork made from insulation duct boards  |
| NADCA ACR: 2006   | National Air Duct Cleaners Association: Assessment, Cleaning & Restoration of HVAC Systems  |
| B&ES (HVCA) TR/19 | Building & Engineering Services Association (formerly known as the Heating and Ventilation Contractors' Association) – Guide to Good Practice – Internal Cleanliness of Ventilation Systems, 2013 Edition |

Table 7: Ductwork Cleaning Standards

Suitable cleaning methods include the following:

- an air nozzle, comprising a perforated plastic ball placed on the end of a flexible hose, which uses low or high volume compressed air;
- an air lance, which directs low volume compressed air locally through an airgun with a trigger;
- mechanical brushing with a soft and non-abrasive rotary brush to brush the surface of the ductwork;
- hand wiping and manual brushing with soft and non-abrasive materials; and
- electric / manual vacuuming to gently remove dust and debris through suction.

Other methods, depending upon the nature of the deposit to be removed, may be also suitable. For verification of cleaning methods not listed above, please contact Kingspan Insulation prior to usage.

*NB Ductwork fabricated from The Kingspan KoolDuct® System is unsuitable for wet cleaning methods and any techniques considered as being abrasive e.g. hard brushing, scraping or compressed air systems using metal balls. Dust, debris and particulates should be collected using an air movement and containment device with appropriate filtration for contaminants.*

## Durability & Lifespan

Ductwork fabricated from The *Kingspan KoolDuct®* System is rigid, strong and self-supporting. When *Kingspan KoolDuct®* panels are permanently formed to the desired shape, they have sufficient strength to maintain that shape. This has been demonstrated in the field, and in the following tests within Standard for Safety UL 181 (Underwriters Laboratories: Factory Made Air Ducts & Air Connectors):

- **puncture** – the walls of ductwork sections preventing complete penetration of a 0.9 kg free-falling steel plunger;
- **pressure & collapse** – coupled ductwork sections resisting rupture and excessive deformation when subjected to positive and negative pressures 2 ½ times their maximum rating;
- **erosion** – the ductwork, and its individual components, showing no sign of cracking, flaking, peeling or delamination, when tested with an air velocity of 63.5 m/s (mean) – 2 ½ times its maximum rating;
- **static load** – coupled ductwork sections not sagging, permanently deforming or being damaged, with joints and seams remaining intact and not fracturing, as a result of withstanding the applied static loadings; and
- **impact** – coupled ductwork sections maintaining their integrity when subjected to impact from a 6.8 kg sandbag.



Notwithstanding the above, the integrity, and thus the lifespan and associated costs, of the ductwork are dependent upon it:

- continuing to operate within its original design parameters;
- not being subjected to external influences that may cause damage; and
- being subject to a regular maintenance programme.

## Whole Life Cost

'Whole life costing' takes account of the total cost of an item over its life including, but not limited to, capital, operating and maintenance costs. Kingspan Insulation commissioned two separate analyses of the whole life costs of differing HVAC systems.

One analysis, performed by independent consultants Cyril Sweett, utilised a combination of empirical and published data based upon a commercial building in the UK. It compared ductwork fabricated from The *Kingspan KoolDuct® System*, comprising 22 mm *Kingspan KoolDuct®* panels and the aluminium grip coupling system, with ductwork constructed from galvanised sheet steel and insulated with 40 mm thick mineral fibre. Both ductwork specifications were designed to meet the same performance standards.

The other analysis was performed by mechanical and electrical engineering services firm, MDA Engineering Inc., under the auspices of Luther Home of Mercy, in the US. The analysis utilised empirical data derived from the independent testing of two HVAC installations, in two separate buildings of identical design. It compared an installation using ductwork fabricated from The *Kingspan KoolDuct® System*, comprising 22 mm *Kingspan KoolDuct®* panels and the Tiger Clip coupling system, with an installation using galvanised sheet steel ductwork insulated with 51 mm thick glass fibre duct wrap. The ductwork and HVAC system design, layout and performance specification were identical.

The analysis of the UK ductwork specifications showed that, over 30 years, ductwork fabricated from The *Kingspan KoolDuct® System* can provide a whole life cost saving of over 20%.



Likewise, the analysis of the US ductwork installations showed that, also over 30 years, ductwork fabricated from The *Kingspan KoolDuct® System* is predicted to save an estimated 14% on whole life cost.

## Indoor Air Quality (IAQ)

*Kingspan KoolDuct®* panels have a fibre-free insulation core and are odourless, non-tainting, non-deleterious, and chemically inert and safe to use. They will also resist attack from mould and microbial growth. Similarly, *Kingspan KoolDuct® System* High Performance Silicone Sealant is resistant to mould growth. At the end of the test period in the mould growth and humidity test within Standard for Safety UL 181 (Underwriters Laboratories: Factory Made Air Ducts & Air Connectors), ductwork fabricated from The *Kingspan KoolDuct® System* showed no visible signs of mould growth beyond the areas of inoculation.



In addition, ductwork fabricated from The *Kingspan KoolDuct® System* has been tested in the US by independent testing and research organisation Air Quality Sciences Inc. The results have shown that emissions of volatile organic compounds (VOCs), formaldehyde, total aldehydes and total phthalates are negligible, and well below the maximum allowable limits deemed safe for schools in the US.

Furthermore, air distributed through ductwork fabricated from The *Kingspan KoolDuct® System* does not come into contact with an insulation material that produces loose fibres. When sheet metal ductwork that is insulated with mineral fibre leaks air, loose fibres could get blown off the duct into the general environment, and then into recirculation systems and back into the air-handling system. Similarly, for ductwork operating at negative static pressures, the loose fibres could potentially get drawn into the airstream flowing inside the duct, by entering through the seams.

Nevertheless, it is best practice to ensure that ductwork, and all parts of a HVAC system, meet specified levels of cleanliness. This includes newly installed ductwork prior to commissioning and / or handover, such that any surplus material remaining from the fabrication and installation process is fully removed. This is particularly important for applications in sensitive areas, where a hygiene-controlled environment is required e.g. in clean rooms, operating theatres, hospitals, food processing facilities and pharmaceutical manufacturing plants.

# Benefits

## Environmental Impact & Responsible Sourcing

### Ozone Depletion Potential (ODP) & Global Warming Potential (GWP)

The insulation core of *Kingspan KoolDuct*<sup>®</sup> panels is manufactured with a CFC/HCFC-free blowing agent that has zero Ozone Depletion Potential (ODP) and low Global Warming Potential (GWP).

### Waste

Computer aided fabrication of ductwork from The *Kingspan KoolDuct*<sup>®</sup> System can enable a sizeable reduction in the volume of workshop-generated waste, compared with manual fabrication. Furthermore, the ability to pre-fabricate ductwork sections and fittings in the workshop, to be supplied in flat form ready for assembly onsite, minimises site-generated waste.

### Green Guide Rating

An Ecoprofile, certified by BRE (Building Research Establishment) Certification to the 2008 BRE Environmental Profiles Methodology, has been created for *Kingspan KoolDuct*<sup>®</sup> panels produced at Kingspan Insulation's Pembrige, UK, manufacturing facility. Independent building research organisation, BRE, has assigned the panels a 2008 Green Guide Summary Rating of A.

Green Guide Summary Ratings are used to make contributions toward the achievement of credits in many of the schemes within the building rating system, BREEAM (Building Research Establishment Environmental Assessment Method), which is owned and operated by BRE, and widely used throughout the Middle East, UK and Europe.

The methodology provides comparable environmental information about competing building materials. It takes into consideration a range of environmental impacts across their entire lifecycle, from cradle to grave, over a 60 year period, including disposal at end of life. It does not consider operational environmental impacts or benefits.

The resultant data, presented in the form of 'Ecopoints', is used by the 2008 Green Guide Rating system to classify the performance of a product in a number of key areas. Using a weighting process, it awards a Summary Rating on a scale from E (worst) up to A+ (best).

### Embodied Environmental Impact Comparison

In comparing the embodied environmental impact of building products, the concept of a functional unit must be taken into account. If a comparison is to be made between ductwork fabricated from The *Kingspan KoolDuct*<sup>®</sup> System, and ductwork constructed from galvanised sheet steel and insulated with mineral fibre, then the functional unit must not only include the insulation, but also the sheet steel, which is absent from ductwork fabricated from The *Kingspan KoolDuct*<sup>®</sup> System.



Kingspan Insulation commissioned independent building research organisation, BRE, to carry out an embodied environmental impact assessment of two differing HVAC ductwork specifications, both designed to meet the same performance standards.

BRE used its 2008 Environmental Profiles Methodology to compare the overall embodied environmental impact of ductwork fabricated from The *Kingspan KoolDuct*<sup>®</sup> System, comprising 30 mm *Kingspan KoolDuct*<sup>®</sup> panels and the 4-bolt coupling system, with that of ductwork constructed from galvanised sheet steel and insulated with 50 mm thick rock mineral fibre.

The findings, presented in the form of 'Ecopoints', show that the embodied environmental impact of ductwork fabricated from The *Kingspan KoolDuct*<sup>®</sup> System can be 65% lower than that of rock mineral fibre insulated galvanised sheet steel.

Furthermore, 86% of the impact of the rock mineral fibre insulated galvanised sheet steel ductwork, is accounted for by the galvanised sheet steel alone.

### **Operational Environmental Impact & Associated Carbon Dioxide (CO<sub>2</sub>) Emissions**

For buildings designed to today's energy use standards, the embodied environmental impacts of all of the materials and labour used to construct a building are insignificant in comparison with the lifetime operational environmental impacts of that building, and are thus of very limited importance.

In the case of insulated HVAC ductwork, saving energy, by specifying the best ductwork air-leakage and heat loss / gain standards possible, is the most environmentally sustainable action to take when specifying ductwork and its insulation, since it is operational energy use that creates the vast majority of operational environmental impact.

Low ductwork air-leakage is known to have a beneficial impact on the energy consumption of the fan delivering the air into the ductwork system, and therefore on HVAC system energy usage and associated operational CO<sub>2</sub> emissions. This relates not only to the air-distribution HVAC system, but also to the building in which it is installed.

The significance of a low ductwork air-leakage rate in cutting operational energy use, and thus associated CO<sub>2</sub> emissions, is clearly demonstrated by the findings from both the UK and US research programs described in the Frictional Resistance, Air-Leakage, Energy Usage & Running Costs section of this document. For details, refer to page 12.

### **Management Systems' Standards**

*Kingspan KoolDuct*<sup>®</sup> panels are manufactured to the highest standards under a management system certified to ISO 9001: 2015 (Quality management systems), ISO 14001: 2015 (Environmental Management Systems) and BS OHSAS 18001: 2007 (Health & Safety Management Systems), ISO 45001:2018 (Occupational Health & Safety Management Systems) and ISO 50001:2018 (Energy Management Systems).

### **Sustainability & Responsibility**

Kingspan Insulation has a long-term commitment to sustainability and responsibility: as a manufacturer and supplier of insulation products; as an employer; as a substantial landholder; and as a key member of its neighbouring communities.

### **LEED<sup>®</sup> & BREEAM**

*Kingspan KoolDuct*<sup>®</sup> panels and / or ductwork fabricated from The *Kingspan KoolDuct*<sup>®</sup> System can contribute points towards achieving credits, including pilot credits, in many of the LEED<sup>®</sup> (Leadership in Energy & Environmental Design) rating systems, developed by the US GBC (United States Green Building Council).

In addition, contributions can be made toward the achievement of credits in the schemes within the building rating system, BREEAM (Building Research Establishment Environmental Assessment Method), owned and operated by BRE (Building Research Establishment).

For further information on how *Kingspan KoolDuct*<sup>®</sup> panels and ductwork fabricated from the *Kingspan KoolDuct*<sup>®</sup> System can contribute towards the achievement of credits in the LEED<sup>®</sup> and BREEAM rating systems, please contact Kingspan Insulation.

### **Sustainability & Responsibility**

Kingspan Insulation has a long-term commitment to sustainability and responsibility: as a manufacturer and supplier of insulation products; and as an employer.

### **Management Systems' Standards**

*Kingspan KoolDuct*<sup>®</sup> panels are manufactured to the highest standards under a management system certified to ISO 9001: 2015 (Quality management systems), ISO 14001: 2015 (Environmental management systems), ISO 45001:2018 (Occupational health & safety management systems) and ISO 50001:2018 (Energy Management Systems).



# Product Specification

## General Physical Properties (Rigid Phenolic Insulation Core)

| Property                                     | Test Method                  | Typical Value           |
|--|------------------------------|-------------------------|
| Minimum Closed Cell Content                  | (BS EN ISO 4590: 2003)       | ≥ 90%                   |
| Nominal Density Range                        |                              | 55-60 kg/m <sup>3</sup> |
| Compressive Strength at 10% Compression      | (BS EN 826: 1996)            | 200 kPa                 |
| Thermal Conductivity (23°C mean)             | (ASTM C 518: 2004)           | as low as 0.023 W/m·K   |
| Material R-value                             |                              |                         |
| 22 mm  |                              | R0.92                   |
| 30 mm  |                              | R1.35                   |
| 46 mm  |                              | R2.0                    |
| Water Vapour Resistance, Z (23°C and 50% RH) | (BS EN 12086: 1997) Method A | 617 MN-s/g              |
| Operating Temperature Limits                 |                              | -26°C to +85°C          |

## General Physical Properties (Aluminium Foil Vapour Barrier Facing)

| Property                  |                  | Typical Value       |
|---------------------------|------------------|---------------------|
| Composition               | Coated Aluminium | 25 microns          |
|                           | Glass Scrim      | 5 mm x 5 mm         |
|                           | Glass Mat        | 49 g/m <sup>2</sup> |
| Water Vapour Transmission |                  | 1.15 ng/N-s         |

## Fire & Smoke Test Classifications (Rigid Phenolic Insulation Core and Aluminium Foil Vapour Barrier Facing)

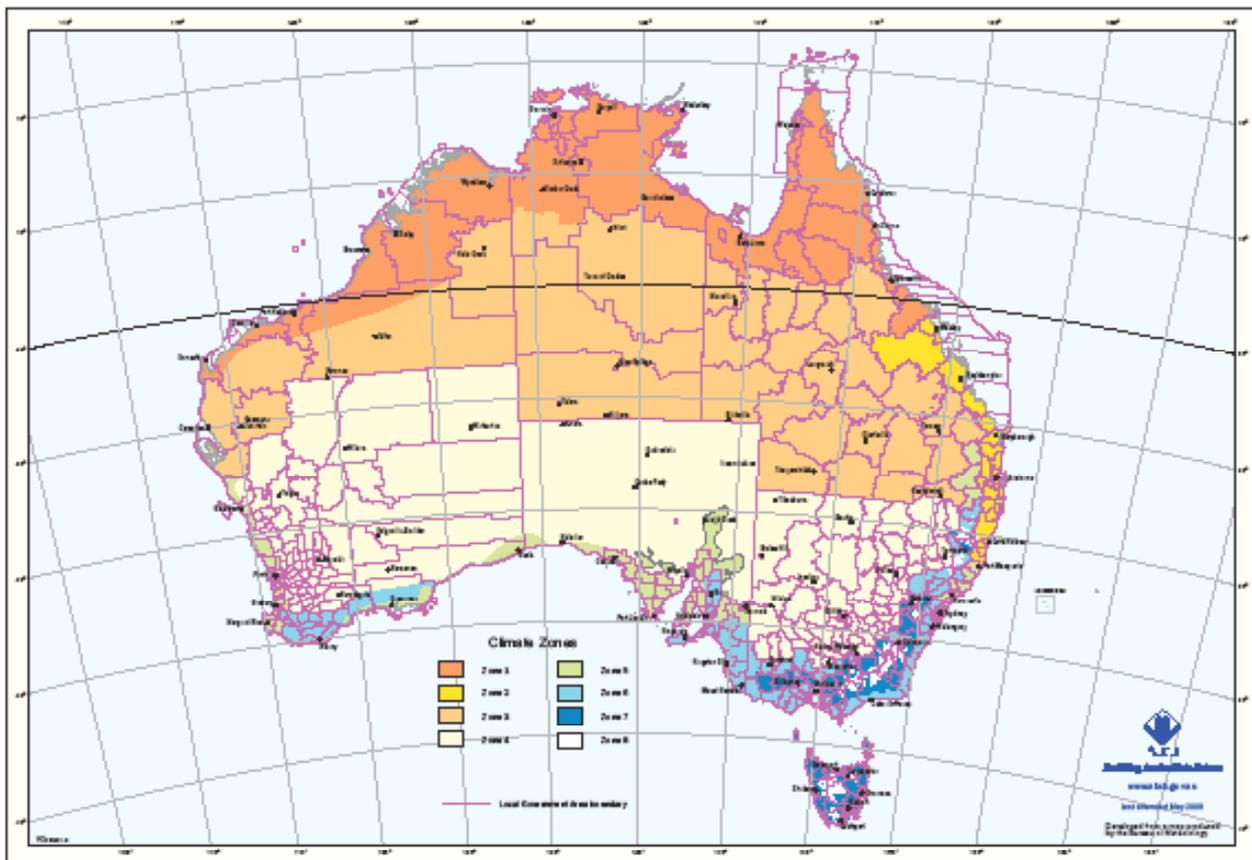
| Test                            | Test Method            | Result  |
|---------------------------------|------------------------|---|
| Early Fire Hazard               | AS 1530.3: 1999        | Ignitability Index: 0*<br>Flame Spread Index: 0*<br>Heat Developed Index: 0*<br>Smoke Developed Index: 0-1* |
| Surface Burning Characteristics | UL 723 / ASTM E 84-08a | < 25/50   |
| Burning                         | UL 181                 | Pass*   |

*\*Kingspan KoolDuct® rigid phenolic insulation panels as part of an assembled system, will achieve these results which enables them to comply with the National Construction Code (NCC), Vol. 1, 2019, Specification C1.10-5.*

# National Construction Code, Vol. 1: Building Code of Australia

## Minimum Material R-value for Ductwork and Fittings

| Location of Ductwork and Fittings | Climate Zone  |            |     |
|-----------------------------------|---------------|------------|-----|
|                                   | 1, 2, 3 and 5 | 4, 6 and 7 | 8   |
| Within a Conditioned Space        | 1.2           | 1.2        | 2.0 |
| Where Exposed to Direct Sunlight  | 3.0           | 3.0        | 3.0 |
| All Other Locations               | 2.0           | 2.0        | 3.0 |



# BRANZ APPRAISALS

## *Kingspan Insulation Pty Limited*

are the Australasian Marketer of the

### *Kingspan KoolDuct® System for Pre-Insulated Ductwork*

*Pre-insulated ductwork for heating, ventilation and air-conditioning (HVAC) ducting applications.*

which is covered by BRANZ Appraisal

No. 771 (2012)

Issue Date: 19 April 2012



**BRANZ**

BRANZ Limited

Moonshine Road, Judgeford, Porirua

Tel: +64 4 237 1170, Fax: +64 4 237 1171

[www.branz.co.nz](http://www.branz.co.nz)



*P Burghout  
Chief Executive*

Validity of the Appraisal can be checked by referring to the Valid Appraisals listing on the BRANZ website, or by contacting BRANZ.

# CERTIFICATE OF COMPLIANCE

**Certificate Number** 20170420 – MH25124  
**Report Reference** MH25124 – 20111213  
**Issue Date** 2017-APRIL-20

**Issued to:** KINGSPAN INSULATION LTD  
**Applicant Company:** PEMBRIDGE  
LEOMINSTER  
HEREFORDSHIRE, HR6 9LA UNITED KINGDOM

**Manufacturer Company:** KINGSPAN INSULATION PTY LTD  
25 OHERNS RD, SOMERTON  
VICTORIA 3062, AUSTRALIA

**This is to certify that  
representative samples of**

Air Ducts

Class 1 Air duct consisting of rigid thermoset phenolic insulation foam core (mauve/grey or pink color) with a closed cell structure, faced on both sides. The product is identified as Kingspan KoolDuct NT branded as Kingspan KoolDuct®. The product is made in nominal 20 mm through 45 mm with manufacturing tolerances as stated within.

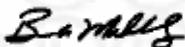
Have been investigated by UL in accordance with the Standard(s) indicated on this Certificate.

**Standard(s) for Safety:** ANSI/UL 181, "Factory-Made Air Ducts and Air Connectors."

**Additional Information:** See the UL Online Certifications Directory at [www.ul.com/database](http://www.ul.com/database) for additional information

Only those products bearing the UL Certification Mark should be considered as being covered by UL's Certification and Follow-Up Service.

Look for the UL Certification Mark on the product.



Bruce Mahrenholz, Assistant Chief Engineer, Global Inspection and Field Services

UL LLC

Any information and documentation involving UL Mark services are provided on behalf of UL LLC (UL) or any authorized licensee of UL. For questions, please contact a local UL Customer Service Representative at [www.ul.com/contactus](http://www.ul.com/contactus)



# Prestige Projects

Project Name: Luther Home of Mercy  
Location: Ohio, USA  
Building Use: Residential Care – Rehabilitation Cottages  
Client: Mercy Outreach Ministries II  
Architect: Normand Associates, Inc.  
M&E Engineer: MDA Engineering, Inc.  
Ductwork Contractor: Commercial Comfort Systems (CCS), Inc.  
Delivery Partner: Delta Air Systems LLC



Project Name: Icehouse  
Location: Philadelphia, USA  
Building Use: Multi-Family Low-Rise Residential Complex  
Client / Developer: EnVision Realty Group LLC  
Consulting Engineer: Wachter & Associates  
Architect: Continuum Architecture & Design, Inc.  
Ductwork Contractor: RP Rex Heating & Cooling  
Delivery Partner: PTM Manufacturing LLC



Project Name: Atlantis, The Palm, Dubai  
Location: Dubai, UAE  
Building Use: Leisure – Resort Hotel  
Architect / M&E Consulting Engineer: NORR Group Consultants International Ltd  
M&E Contractor: BK Gulf LLC / Rotary HUMM Services LLC  
Ductwork Contractor: Seagull HVAC Industry LLC

# Prestige Projects



Project Name: Four Seasons Hotel  
Location: Doha, Qatar  
Building Use: Leisure – Hotel  
Architect: Smallwood, Reynolds, Stewart, Stewart, Inc.  
MEP Engineers: Drake & Scull  
Main Contractor: Construction Development Company (CDC)  
Delivery Partner: Qatari Industrial Equipment (QIE) WLL



Project Name: Marina Bay Sands Hotels  
Location: Singapore  
Building Use: Leisure – Resort Hotel  
Delivery Partner: Industrial Links

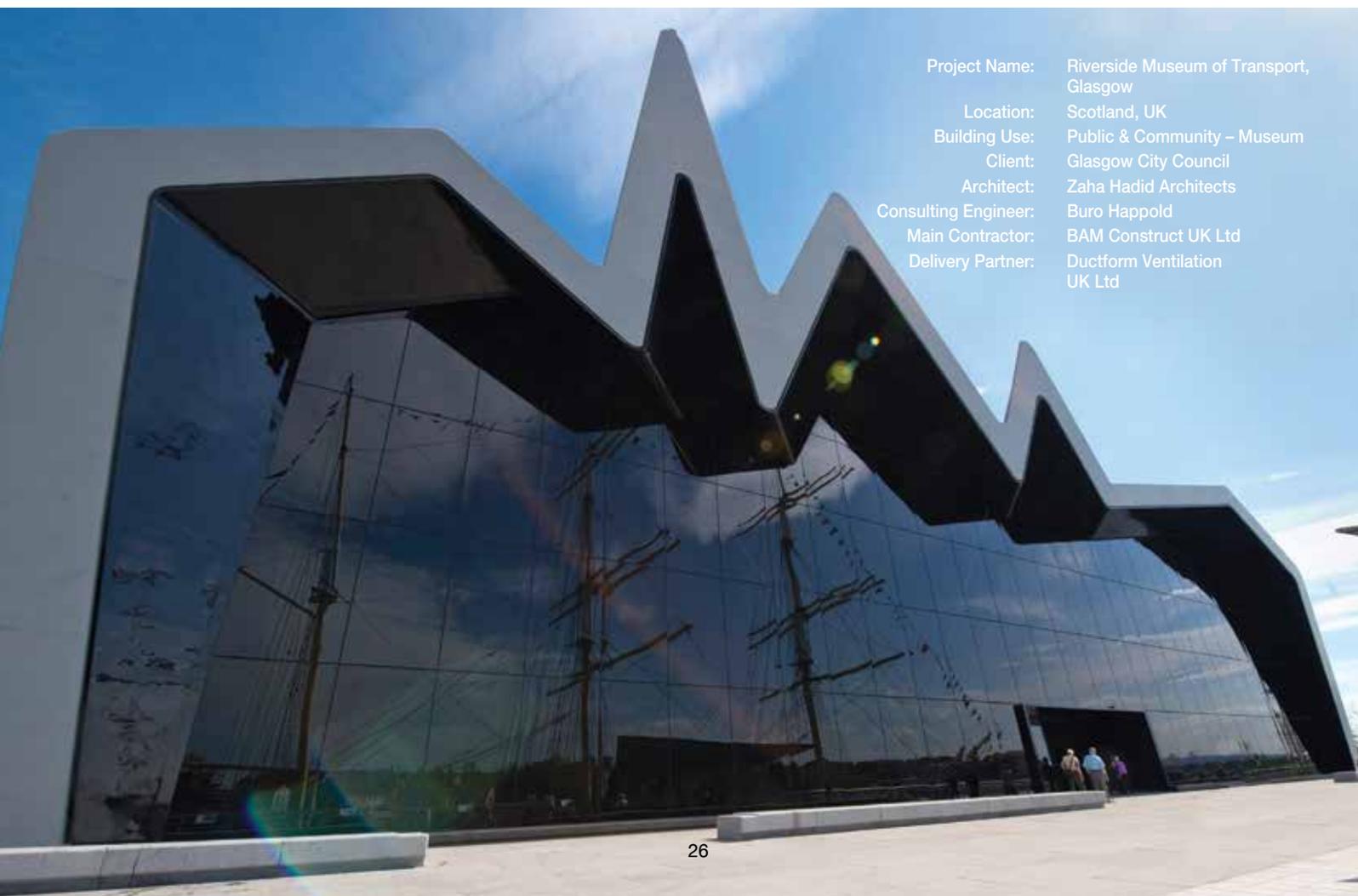
Project Name: Cadogan Hall  
Location: London, UK  
Building Use: Leisure – Music, Concert Hall  
Client: Cadogan Estates  
Architect: Paul Davis Partners  
M&E Consulting Engineer: Voce Case  
M&E Contractor: Gratte Manly  
Delivery Partner: Sterling Thermal



# Prestige Projects



Project Name: Alfardan Towers  
Location: Doha, Qatar  
Client: Alfardan Real Estate Company  
Building Use: Residential – High Rise  
Architect: Arab Engineering Bureau (AEB)  
Consulting Engineer: Shaker Consulting Group  
Main Contractor: Construction Development Company (CDC)  
Delivery Partner: Qatari industrial Equipment (QIE) WLL



Project Name: Riverside Museum of Transport, Glasgow  
Location: Scotland, UK  
Building Use: Public & Community – Museum  
Client: Glasgow City Council  
Architect: Zaha Hadid Architects  
Consulting Engineer: Buro Happold  
Main Contractor: BAM Construct UK Ltd  
Delivery Partner: Ductform Ventilation UK Ltd



Project Name: Angsana Hotel & Suites  
(The Damas Towers)

Location: Dubai, UAE

Building Use: Residential & Leisure –  
Hotel & High-Rise  
Apartments

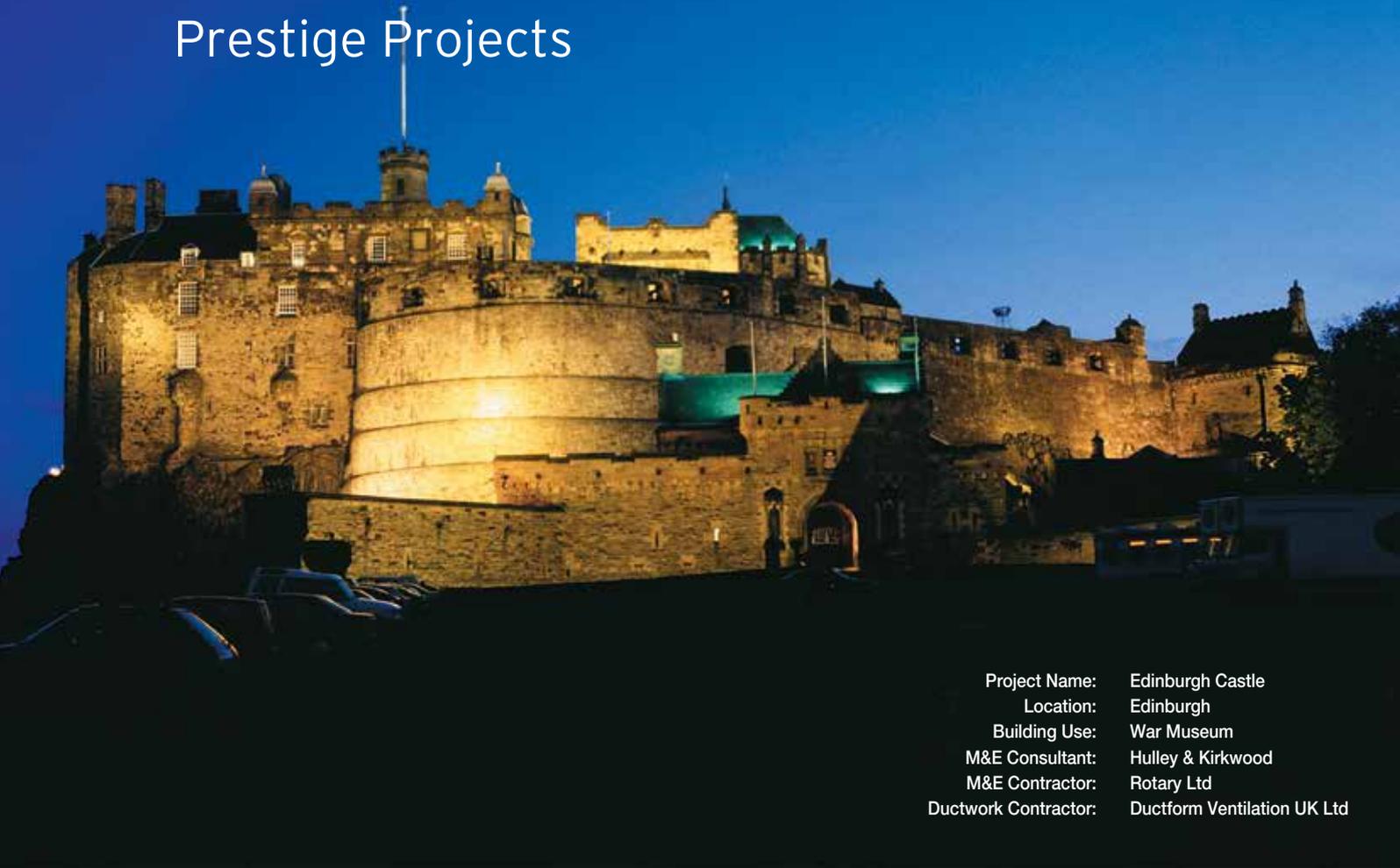
Architect / Consulting  
& M&E Engineer:

Eng. Adnan Saffarini

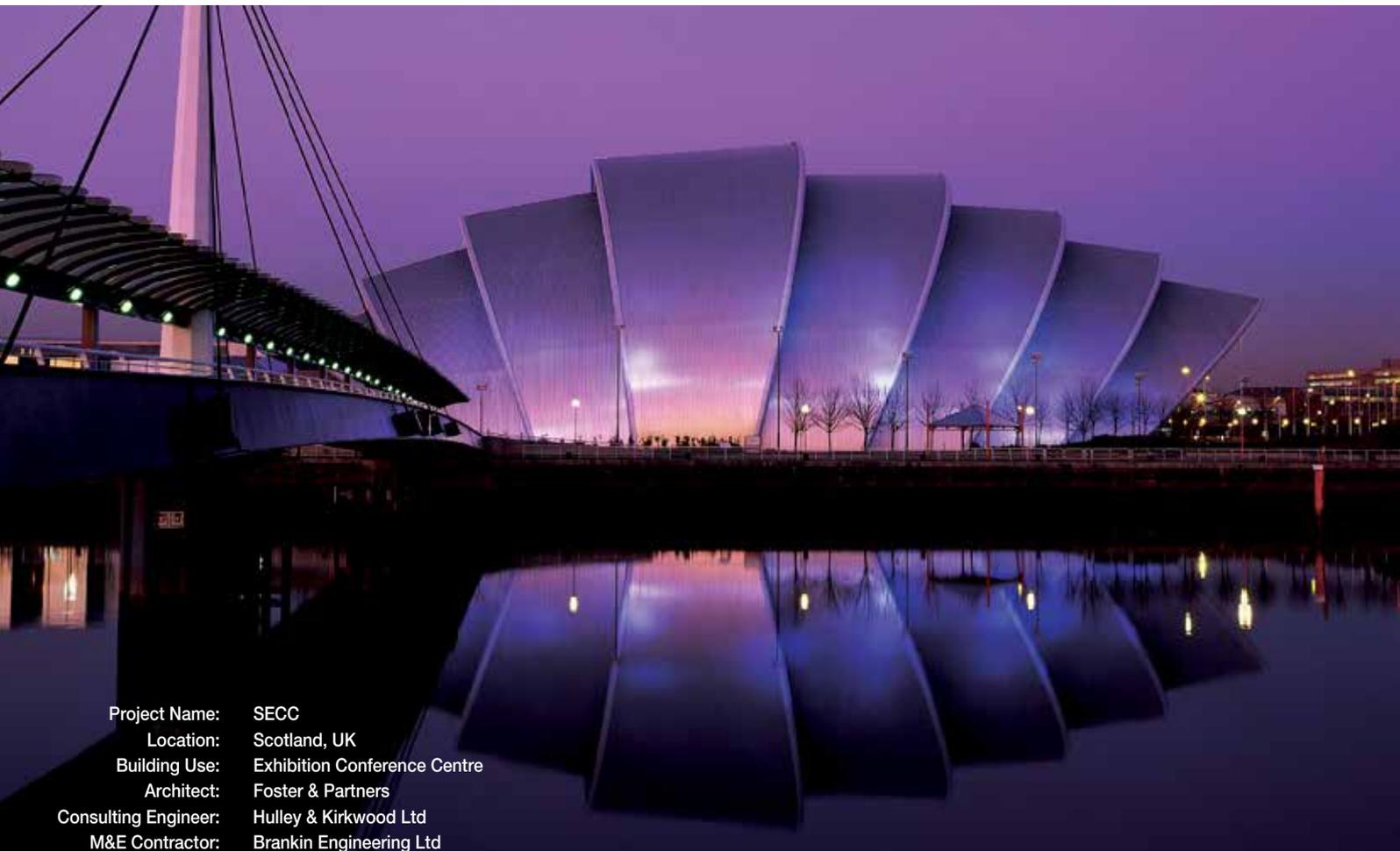
Main Contractor:

Bin Zayed Contracting

# Prestige Projects



Project Name: Edinburgh Castle  
Location: Edinburgh  
Building Use: War Museum  
M&E Consultant: Hulley & Kirkwood  
M&E Contractor: Rotary Ltd  
Ductwork Contractor: Ductform Ventilation UK Ltd



Project Name: SECC  
Location: Scotland, UK  
Building Use: Exhibition Conference Centre  
Architect: Foster & Partners  
Consulting Engineer: Hulley & Kirkwood Ltd  
M&E Contractor: Brankin Engineering Ltd

Project Name: Shangri-La Hotel  
Location: Dubai, UAE  
Building Use: Leisure – Hotel  
Main Contractor: Al Habtoor Engineering Ltd / Murray & Roberts  
Architect / M&E  
Consulting Engineer: NORR Group Consultants International Ltd  
M&E Contractor: Sensaire Services LLC  
Ductwork Contractor: Seagull HVAC Industry LLC



# Prestige Projects

Project name: Fanar, Qatar Islamic Cultural Center  
Location: Doha, Qatar  
Building Use: Public & Community – Arts, Culture, Education & Religion  
Delivery Partner: Qatari Industrial Equipment (QIE) WLL



Project Name: BBC Glasgow  
Location: Scotland, UK  
Building Use: Commercial – Broadcast Centre & Offices  
Architect: David Chipperfield Architects Ltd  
Consulting Engineer: Arup  
M&E Contractor: Balfour Beatty Engineering Services Ltd (formerly Balfour Kilpatrick)  
Delivery Partner: Ductform Ventilation UK Ltd





Project Name: One New York Street  
Location: Manchester, UK  
Building Use: Commercial & Retail – Offices & Shops  
Client: Bruntwood  
Architect: Denton Corker Marshall  
Consulting Engineer: Buro Happold  
Ductwork Contractor: Cranworth Engineering Ltd

# Contact Details

## General Enquiries

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