QFS Oil Mist & Cutting Fluid

Duct System Product Catalogue

15.1 English

NORDFAB Ducting

The world's fastest ducting™

Nordfab QFS Duct

Quick-Fit™ sealed ducting offers a complete range of diameters and accessories for easy-to-fix professional installations.

Manufactured from galvanised or stainless steel with welded seams, which have a smoother internal surface and provide greatly enhanced leak resistance, Nordfab ducting offers an unbeatable solution for oil mist and cutting fluid applications as well as all other general purpose dust extraction duties.

In addition to welded seams, bends, branches, reducers and all other components that have either a spot welded or peened joint are sealed using a 2-pac epoxy.

QFS components are easily clipped together and sealed using a Quick-Fit clip and additional sealing gasket held firmly in place by positive over-centre clamping action.

Oil Mist Health Hazards & Safety Risks

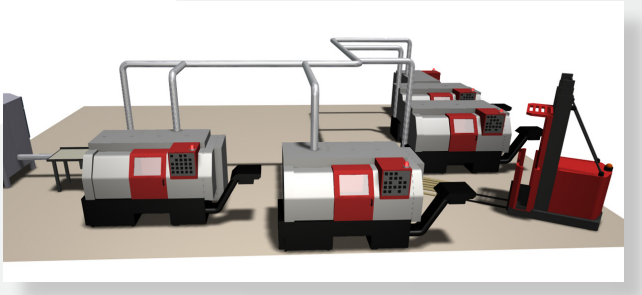
- Respiratory ailments
- Eczema and other skin conditions
- Increased risk of falls and related accidents
- Pollution of general ventilation system
- Damage to sensitive electronics
- Creates a dirty environment

Advantages

- QF Sealed Ducting for fast installation with no special tools, no painting and flexible working
- Easy to assemble installation components
- Neat slip duct connections to adapt and adjust ducting on site during installation
- Welded straight ducts for smoother surface and enhanced leak resistance
- Prevents leakage, reducing the likelihood of slips, trips and damage to machinery
- Easy to extend or take apart completely for cleaning, reconfiguring or relocation
- Full range of accessories and installation components
- Adapters available to connect to and extend all other duct systems
- All you need from one comprehensive, tried and tested range
- Stainless steel also available

Where is QFS Used?

- Steel mills
- Rolling mills
- Rubber and plastic industry
- Hardening and heat treating industry
- Metalwork and engineering industry when:
  - Turning
  - Cutting
  - Milling
  - Grinding
  - Drilling



Duct End Gasket

Used in conjunction with a QFS clip, Nordfab's duct end gasket provides dual protection against leakage.

1

Wipe rolled edge of duct with clean cloth. Then apply a high tack gasket adhesive per the manufacturer's instructions. High tack gasket adhesives can be purchased locally at industrial or automotive suppliers in either aerosol spray or brushable formulations.

2

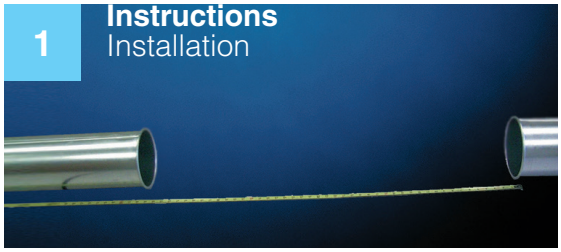
Carefully place the gasket along the rolled edge of the part, being careful to avoid kinks or voids. Only one gasket is needed per joint.

3

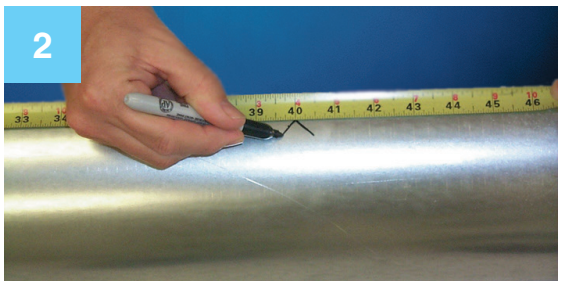
Join the gasketed end of the pipe to a non-gasketed end of the next part in the ducting run using a standard QF clamp.

Slip Duct for Oil Mist

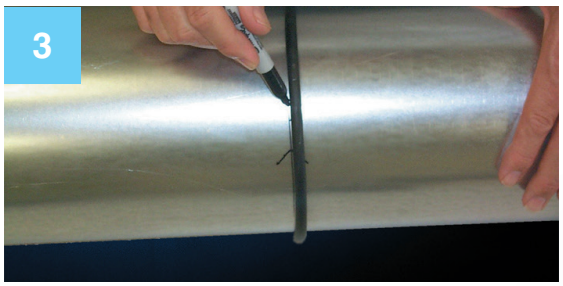
Nordfab's Slip Duct is an important component as it allows you to quickly adjust the length of your duct run.



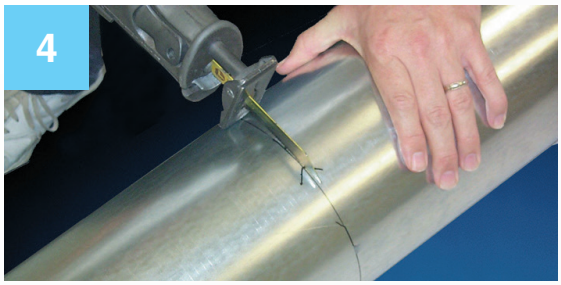
Measure distance to be spanned.



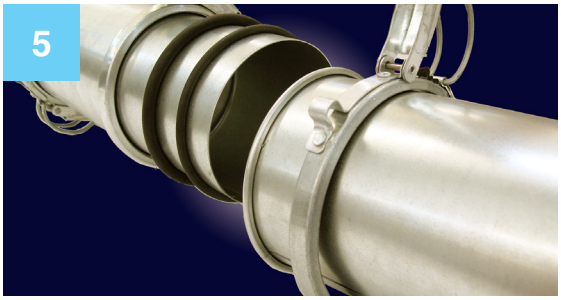
Mark distance to be spanned less 100 mm.



Use O-ring provided and mark for cut.

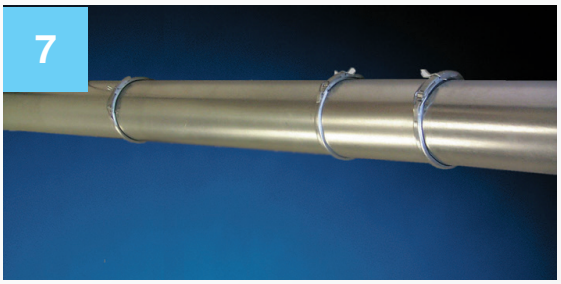


Cut the duct.



Put Slip Duct O-ring on the cut duct, add a smaller Oil Mist O-ring and slide a Slip Duct over the cut end. Seat the Oil Mist O-ring evenly and firmly against the rolled metal edge of the Slip Duct. Then position the Slip Duct O-ring firmly against the Oil Mist O-ring.

Snap QF clip over the two O-rings and one end of the slip duct.



Finished connection with the slip duct.

Installation Guidance

It is recommended that QFS ductwork is installed with a 1° to 3° slope angled back towards the point of extraction. Incorrectly installed ductwork may cause leakage on to the plant floor or equipment, creating hazards for workers or even damage to machinery. To reduce the possibility of leakage, consider using outside expertise when designing and balancing your duct system, ensuring that the duct is installed correctly and minimising risk.

Sizing Nordfab Ducting Systems

Nordfab offers assistance to customers who have never designed a ducting system. We can assist you with determining the correct duct size and configuration for optimal air flow. Please call your local representative for assistance.

Using the Air Volume Chart

A recomendation when conveying air contaminated with oil, oil mist or / and cutting fluids is to maintain a speed in the duct between 10-15 m/s.

Range of duct air flow volumes m^3/h

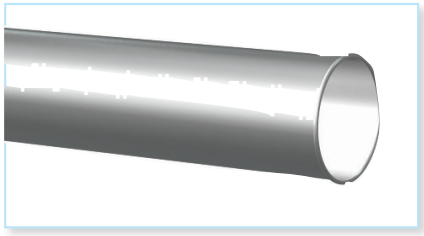
Ø mm	10 m/s	12 m/s	15 m/s	18 m/s	20 m/s	22 m/s	25 m/s	27 m/s	29 m/s	31 m/s
80	181	217	271	326	362	398	452	489	525	561
100	283	339	424	509	566	622	707	763	820	877
125	442	530	663	795	884	972	1105	1193	1281	1370
140	554	665	831	998	1108	1219	1385	1496	1607	1718
150	636	763	954	1145	1272	1400	1590	1718	1845	1972
160	724	869	1086	1303	1448	1592	1810	1954	2099	2244
180	916	1099	1374	1649	1832	2015	2290	2473	2657	2840
200	1131	1357	1697	2036	2262	2488	2827	3054	3280	3506
224	1419	1702	2128	2554	2837	3121	3547	3831	4114	4398
250	1767	2121	2651	3181	3534	3888	4418	4771	5125	5478
300	2545	3054	3817	4580	5089	5598	6362	6871	7380	7889
315	2806	3367	4208	5050	5611	5172	7014	7575	8136	8697
350	3464	4156	5195	6235	6927	7620	8659	9352	10045	10737
400	4524	5429	6786	8143	9048	9953	11310	12215	13119	14024

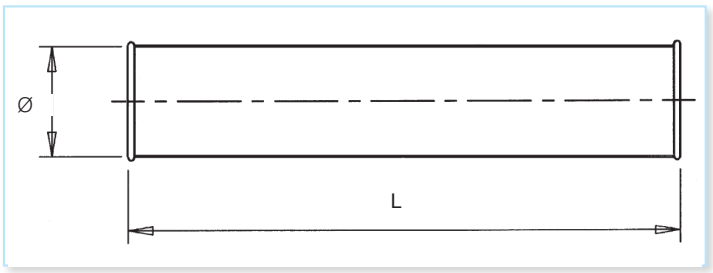
QFS System Components

- Welded straight duct
- Oil Mist Gaskets on duct ends where joined
- Sealed seams / joins on other components
- Oil Mist Slip Duct Kit where variable lengths needed
- Oil Mist Drain and / or Ball Joint where needed

QF Duct (welded seam)

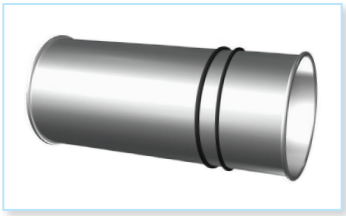
Ø mm	Item no.	L mm	Thickness mm	Weight kg
080	20915-080	1000	0.7	2.1
100	20915-100	1478	0.7	2.6
125	20915-125	1478	0.7	3.2
140	20915-140	1478	0.7	3.6
150	20915-150	1478	0.7	3.8
160	20915-160	1478	0.7	4.1
180	20915-180	1471	0.7	4.6
200	20915-200	1471	0.7	5.2
224	20915-224	1471	0.7	5.8
250	20915-250	1471	0.7	6.5
300	20915-300	1462	0.7	7.7
315	20915-315	1462	0.7	8.1
350	20915-350	1462	0.7	9.0
400	20915-400	1462	0.9	13.3

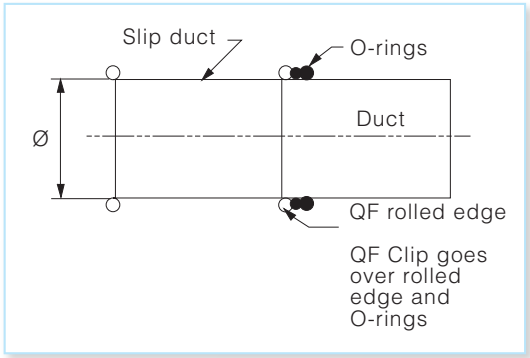




QFS Slip includes:

- 1 Slip Duct dim. Ø XXX
- 2 O-rings





QFS Slip Duct (welded seam)

Ø mm	Item no.	L mm	Thickness mm	Weight kg
080	LF20900-080	300	0.7	0.5
100	LF20900-100		0.7	0.6
125	LF20900-125		0.7	0.7
140	LF20900-140		0.7	0.8
150	LF20900-150		0.7	0.9
160	LF20900-160		0.7	0.9
180	LF20900-180		0.7	1.0
200	LF20900-200		0.7	1.2
224	LF20900-224		0.7	1.3
250	LF20900-250		0.7	1.4
300	LF20900-300		0.7	1.7
315	LF20900-315		0.7	1.8
350	LF20900-350		0.7	2.0
400	LF20900-400		0.9	2.9

QFS Clip and Duct End Gasket Set

Ø mm	Kit Item no.	Weight kg
80	30205-080	0.7
100	30205-100	0.8
125	30205-125	0.8
140	30205-140	0.9
150	30205-150	0.9
160	30205-160	1.4
180	30205-180	1.5
200	30205-200	1.6
224	30205-224	1.8
250	30205-250	1.9
300	30205-300	3.5
315	30200-315	3.7
350	30205-350	3.9
400	30205-400	4.3

QFS Set includes:

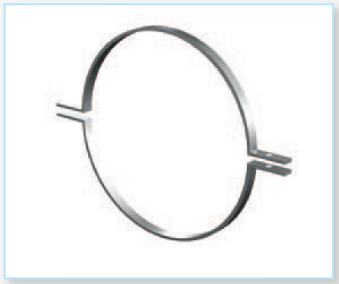
- 1 QFS Clip
- 1 Duct End Gasket

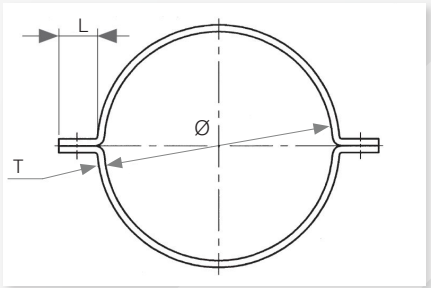
Duct End Gasket

Ø mm	Gasket Only Item no.	Weight kg
80	30201-080	0.7
100	30201-100	0.8
125	30201-125	0.8
140	30201-140	0.9
150	30201-150	0.9
160	30201-160	1.4
180	30201-180	1.5
200	30201-200	1.6
224	30201-224	1.8
250	30201-250	1.9
300	30201-300	3.5
315	30201-315	3.7
350	30201-350	3.9
400	30201-400	4.3

Technical Data

- General purpose oil resistant polymer
- Performs well with many oil, water and hydraulic fluid applications
- Good tear resistance
- Available in 80 - 710 mm diameter
- Should not be used with solvents such as acetone, MEK, ozone, chlorinated hydrocarbons, and nitro hydrocarbons
- Conducts electricity
- Classification:1. ASTM D-2000 M2BG510 A24 B34 EO14 EO34 EF11 EF21
- Temperature range: -34° C to +107°C /





Split Strap

Ø mm	Item no.	Thickness mm	L mm	$Ø_1$ mm	Bolts mm
80	30940-080	3	25	10	8x35
100	30940-100	3	25	10	8x35
125	30940-125	3	25	10	8x35
140	30940-140	3	25	10	8x35
150	30940-150	3	25	10	8x35
160	30940-160	3	25	10	8x35
180	30940-180	3	25	10	8x35
200	30940-200	3	25	10	8x35
224	30940-224	3	35	10	8x35
250	30940-250	3	35	10	8x35
300	30940-300	3	35	10	8x35
315	30940-315	3	40	12	10x40
350	30940-350	3	40	12	10x40
400	30940-400	3	40	12	10x40

QFS Pressed Bends

R=1.5 x diameter to centreline

To minimize leakage, joints are sealed using a 2-pac epoxy.

30° Pressed Bends

Ø mm	Item no.	R mm	Thickness mm	Weight kg
080	LF21913-080	120	0.9	0.2
100	LF21913-100	150		0.3
125	LF21913-125	190		0.3
140	LF21913-140	210		0.4
150	LF21913-150	225		0.5
160	LF21913-160	240		0.5
180	LF21913-180	270		0.7
200	LF21913-200	300		0.9
224	LF21913-224	337		1.3
250	LF21913-250	375		1.5
300	LF21913-300	450		2.2
315	LF21913-315	472		2.2

45° Pressed Bends

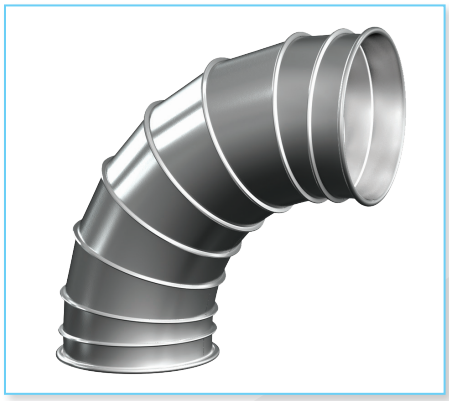
Ø mm	Item no.	R mm	Thickness mm	Weight kg
080	LF21914-080	120	0.9	0.2
100	LF21914-100	150		0.3
125	LF21914-125	190		0.4
140	LF21914-140	210		0.4
150	LF21914-150	225		0.5
160	LF21914-160	240		0.6
180	LF21914-180	270		0.9
200	LF21914-200	300		1.0
224	LF21914-224	337		1.6
250	LF21914-250	375		1.6
300	LF21914-300	450		2.3
315	LF21914-315	472		2.4

60° Pressed Bends

Ø mm	Item no.	R mm	Thickness mm	Weight kg
080	LF21916-080	120	0.9	0.3
100	LF21916-100	150		0.4
125	LF21916-125	190		0.6
140	LF21916-140	210		0.6
150	LF21916-150	225		0.7
160	LF21916-160	240		0.8
180	LF21916-180	270		1.2
200	LF21916-200	300		1.3
224	LF21916-224	337		1.7
250	LF21916-250	375		1.9
300	LF21916-300	450		2.4
315	LF21916-315	472		2.5

90° Pressed Bends

Ø mm	Item no.	R mm	Thickness mm	Weight kg
080	LF21919-080	120	0.9	0.4
100	LF21919-100	150		0.5
125	LF21919-125	190		0.8
140	LF21919-140	210		0.9
150	LF21919-150	225		1.1
160	LF21919-160	240		1.2
180	LF21919-180	270		1.6
200	LF21919-200	300		1.9
224	LF21919-224	337		2.4
250	LF21919-250	375		3.0
300	LF21919-300	450		3.2
315	LF21919-315	472		5.0



Custom radiuses available on request.

QFS Segmented Bends

R = 1.5 x diameter to centreline

To minimize leakage, joints are sealed using a 2-pac epoxy.

30° Segmented bends

Ø mm	Item no.	R mm	Thickness mm	Weight kg
200	LF21003-200	300	0.7	0.8
224	LF21003-224	336	0.7	1.0
250	LF21003-250	375	0.7	1.3
300	LF21003-300	450	0.7	1.4
315	LF21003-315	473	0.7	2.0
350	LF21003-350	525	0.7	2.9
400	LF21003-400	600	0.7	3.8

45° Segmented bends

Ø mm	Item no.	R mm	Thickness mm	Weight kg
200	LF21004-200	300	0.7	1.2
224	LF21004-224	336	0.7	1.5
250	LF21004-250	375	0.7	1.9
300	LF21004-300	450	0.7	2.0
315	LF21004-315	473	0.7	2.9
350	LF21004-350	525	0.7	3.8
400	LF21004-400	600	0.7	5.1

60° Segmented bends

Ø mm	Item no.	R mm	Thickness mm	Weight kg
200	LF21006-200	300	0.7	1.6
224	LF21006-224	336	0.7	2.0
250	LF21006-250	375	0.7	2.5
300	LF21006-300	450	0.7	2.7
315	LF21006-315	473	0.7	3.9
350	LF21006-350	525	0.7	4.8
400	LF21006-400	600	0.7	6.3

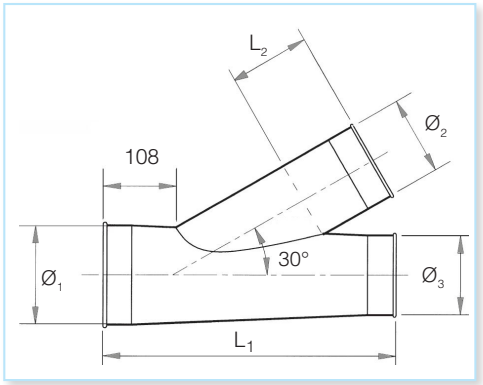
90° Segmented bends

Ø mm	Item no.	R mm	Thickness mm	Weight kg
200	LF21009-200	300	0.7	2.5
224	LF21009-224	336	0.7	3.1
250	LF21009-250	375	0.7	3.8
300	LF21009-300	450	0.7	4.1
315	LF21009-315	473	0.7	5.9
350	LF21009 -350	525	0.7	6.8
400	LF21009-400	600	0.7	8.8

QFS Branch

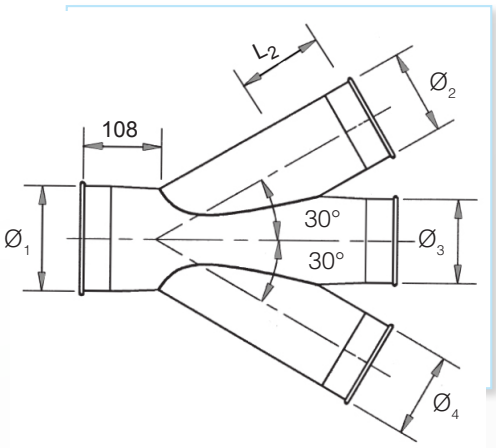
Ø mm	Item no.	Thickness mm
080	LFQG080XXXXXX	0.7
100	LFQG100XXXXXX	0.7
125	LFQG125XXXXXX	0.7
140	LFQG140XXXXXX	0.7
150	LFQG150XXXXXX	0.7
160	LFQG160XXXXXX	0.7
180	LFQG180XXXXXX	0.7
200	LFQG200XXXXXX	0.7
224	LFQG224XXXXXX	0.7
250	LFQG250XXXXXX	0.7
300	LFQG300XXXXXX	0.7
315	LFQG315XXXXXX	0.7
350	LFQG350XXXXXX	0.7
400	LFQG400XXXXXX	0.9

e.g.:
QG 315 250 250
$Ø_1$
$Ø_2$
$Ø_3$



$L_1 = (Ø_2 \times 2) + 236$
$L_2 = (Ø_2 / 2) + 58$
$Ø_3$ must be smaller than or equal to $Ø_1$
$Ø_2$ must be smaller than or equal to $Ø_3$

To minimize leakage, branch joints are sealed using a 2-pac epoxy.



$L_2 = (Ø_2 / 2) + 58$
$Ø_3$ must be smaller than or equal to $Ø_1$
$Ø_2$ must be smaller than or equal to $Ø_3$
$Ø_4$ must be smaller than or equal to $Ø_3$

e.g.:
QT 315 250 250 250
$Ø_1$
$Ø_2$
$Ø_3$
$Ø_4$

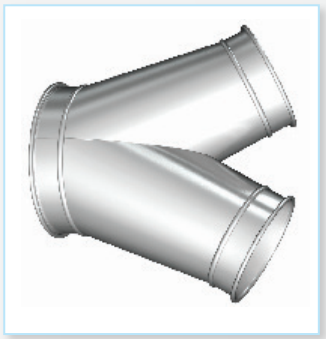
QFS Double Branch

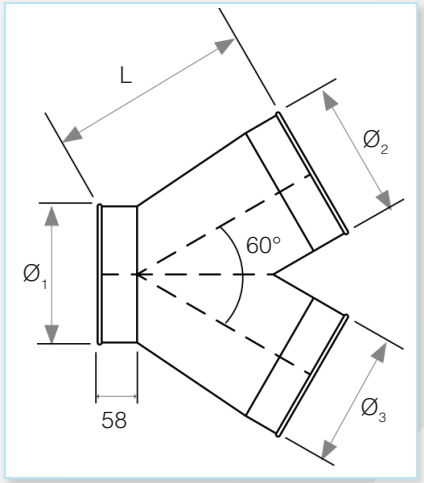
Ø mm	Item no.	Thickness mm
080	LFQT080XXXXXXXXX	0.7
100	LFQT100XXXXXXXXX	0.7
125	LFQT125XXXXXXXXX	0.7
140	LFQT140XXXXXXXXX	0.7
150	LFQT150XXXXXXXXX	0.7
160	LFQT160XXXXXXXXX	0.7
180	LFQT180XXXXXXXXX	0.7
200	LFQT200XXXXXXXXX	0.7
224	LFQT224XXXXXXXXX	0.7
250	LFQT250XXXXXXXXX	0.7
300	LFQT300XXXXXXXXX	0.7
315	LFQT315XXXXXXXXX	0.7
350	LFQT350XXXXXXXXX	0.7
400	LFQT400XXXXXXXXX	0.9

QFS Y-Branch

Ø mm	Item no.	Thickness mm
80	LFQB080XXXXXX	0.7
100	LFQB100XXXXXX	0.7
125	LFQB125XXXXXX	0.7
140	LFQB140XXXXXX	0.7
150	LFQB150XXXXXX	0.7
160	LFQB160XXXXXX	0.7
180	LFQB180XXXXXX	0.7
200	LFQB200XXXXXX	0.7
224	LFQB224XXXXXX	0.7
250	LFQB250XXXXXX	0.7
300	LFQB300XXXXXX	0.7
315	LFQB315XXXXXX	0.7
350	LFQB350XXXXXX	0.7
400	LFQB400XXXXXX	0.9

e.g.:
QB 315 250 250
$Ø_1$
$Ø_2$
$Ø_3$



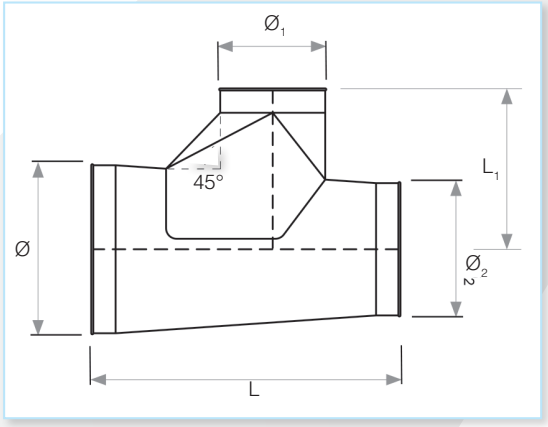


$L = Ø_1 + 100$
$Ø_2$ and $Ø_3$ must be smaller than or equal to $Ø_1$

QFS Boot Shoe

Ø mm	Item no.	Thickness mm
80	LFTBS080XXXXXX	0.7
100	LFTBS100XXXXXX	0.7
125	LFTBS125XXXXXX	0.7
140	LFTBS140XXXXXX	0.7
150	LFTBS150XXXXXX	0.7
160	LFTBS160XXXXXX	0.7
180	LFTBS180XXXXXX	0.7
200	LFTBS200XXXXXX	0.7
224	LFTBS224XXXXXX	0.7
250	LFTBS250XXXXXX	0.7
300	LFTBS300XXXXXX	0.7
315	LFTBS315XXXXXX	0.7
350	LFTBS350XXXXXX	0.7
400	LFTBS400XXXXXX	0.9

e.g.:
TBS 100 250 315
$Ø_1$
$Ø_2$
Ø

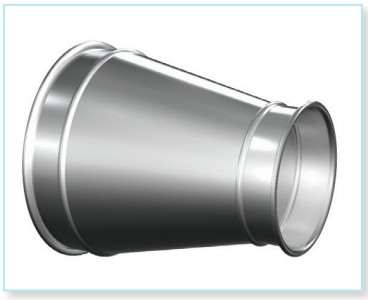


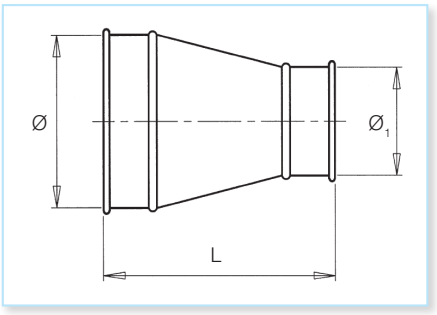
$L = Ø_1 \times 2 + 236$ mm
$L1 = (Ø_1 / 2) + (Ø_2 / 2 + 58$ mm)
The boot cut is always placed in the centre

QFS Reducer

Ø mm	Item no.	Thickness mm
80	LFQR080XXX	0.7
100	LFQR100XXX	0.7
125	LFQR125XXX	0.7
140	LFQR140XXX	0.7
150	LFQR150XXX	0.7
160	LFQR160XXX	0.7
180	LFQR180XXX	0.7
200	LFQR200XXX	0.7
224	LFQR224XXX	0.7
250	LFQR250XXX	0.7
300	LFQR300XXX	0.7
315	LFQR315XXX	0.7
350	LFQR350XXX	0.7
400	LFQR400XXX	0.9

e.g.:
QR 315 250
Ø
$Ø_1$



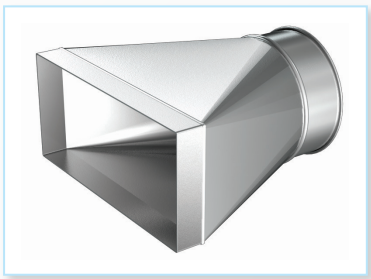


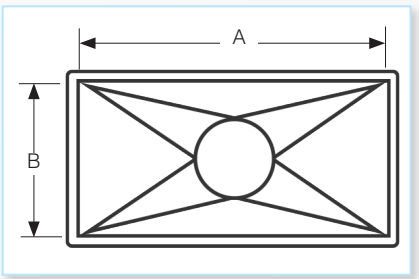
$L = (Ø - Ø_1) + 166mm$

QFS Transition from rectangular to round

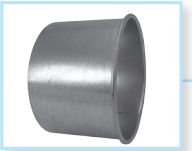
Ø mm	Item no.	Thickness mm
80	LF22035-080	0.9
100	LF22035-100	0.9
125	LF22035-125	0.9
140	LF22035-140	0.9
150	LF22035-150	0.9
160	LF22035-160	0.9
180	LF22035-180	0.9
200	LF22035-200	0.9
224	LF22035-224	0.9
250	LF22035-250	0.9
300	LF22035-300	0.9
315	LF22035-315	0.9
350	LF22035-350	0.9
400	LF22035-400	0.9

e.g.: LF23035 100 500 400
Type
Ø
A
B



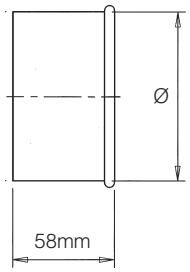


Please specify
- The actual A,B and Ø dimentions
- The positions of the connection spigot
- The type of connection spigot (QF, spiro or raw end)



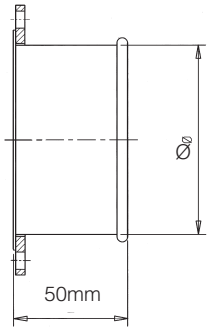
QF Smooth adapter
LF22010

Ø mm
080
100
125
140
150
160
180
200
224
250
300
315
350
400
450
500
560
630
710



Flanged adapter (QF)
LF22007

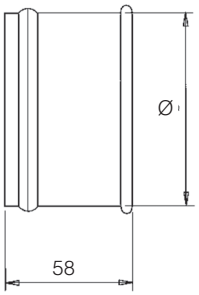
Ø mm
100
125
140
150
160
180
200
250
300
315
350
400
450
500
560
630
710



QF adapter with flange 30015

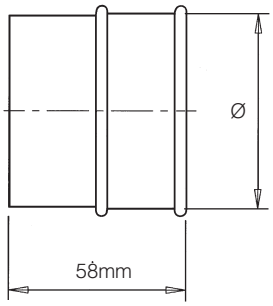
Hose adapter (QF)
LF22013

Ø mm
080
100
125
140
150
160
180
200
224
250
300
315
350
400
450
500
560
630
710



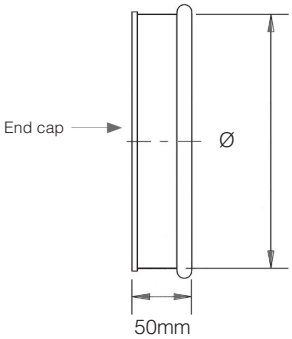
Spiro adapter (QF)
LF22014

Ø mm
080
100
125
140
150
160
180
200
224
250
300
315
350
400
450
500
560
630
710

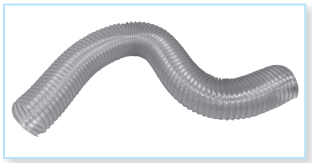


End Cap (QF)
LF22012

Ø mm
080
100
125
140
150
160
180
200
224
250
300
315
350
400
450
500
560
630
710



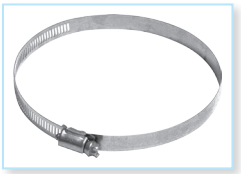
Flexible polyurethane hose



Ø mm	Item no.	Thickness mm	Weight gr/mtr
38	8604003038	0.5	166
51	8604003051	0.55	260
63	8604003063	0.55	320
76	8604003076	0.6	440
82	8604003082	0.6	490
89	8604003089	0.6	520
102	8604003102	0.65	660
127	8604003127	0.65	800
140	8604003140	0.65	900
152	8604003152	0.7	1100
160	8604003160	0.7	1160
180	8604003178	0.7	1300
203	8604003203	0.7	1440
229	8604003229	0.7	1580
254	8604003254	0.8	1880
305	8604003305	0.8	2250
315	8604003315	0.8	2390

Supplied in 1 meter increments

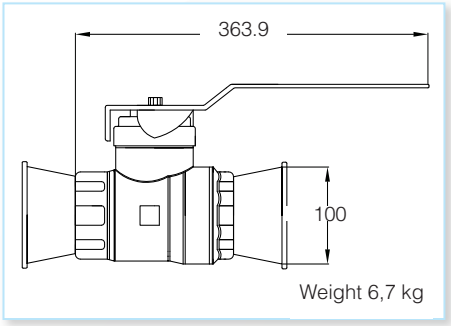
Flexible hose clamp

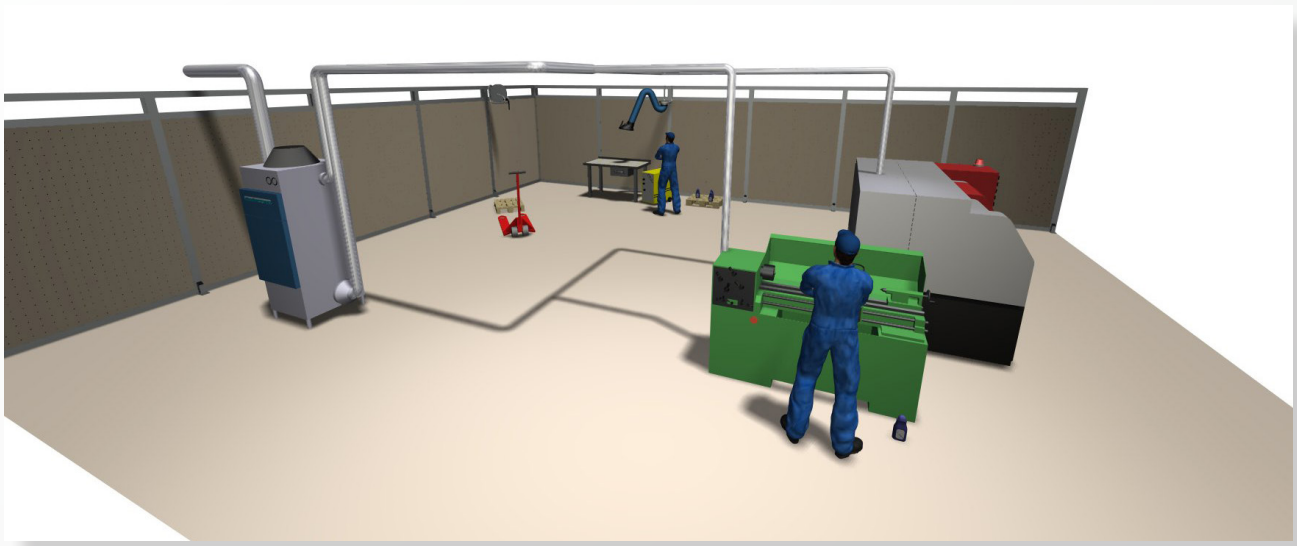


Ø mm	Item no.	Hose size*
32-50	8604004038	38
40-60	8604004051	51
60-80	8604004063	63
70-90	8604004076	76
70-90	8604004076	82
80-100	8604004089	89
90-110	8604004102	102
120-140	8604004127	127
130-150	8604004140	140
140-160	8604004152	152
150-170	8604004160	160
170-190	8604004180	180
200-220	8604004203	203
230-250	8604004229	229
260-280	8604004254	254
258-355	8604004305	305
258-355	8604004305	315

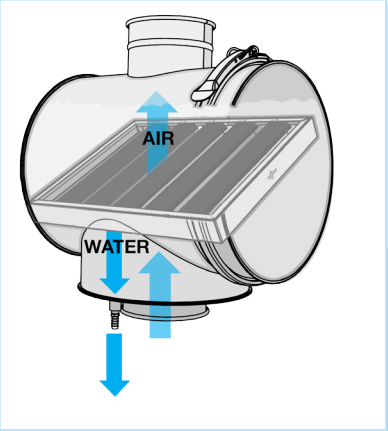
Ball Valve

Ø mm	Item no.	Thickness mm
100	23010-100	0.9





Oil Mist Drain



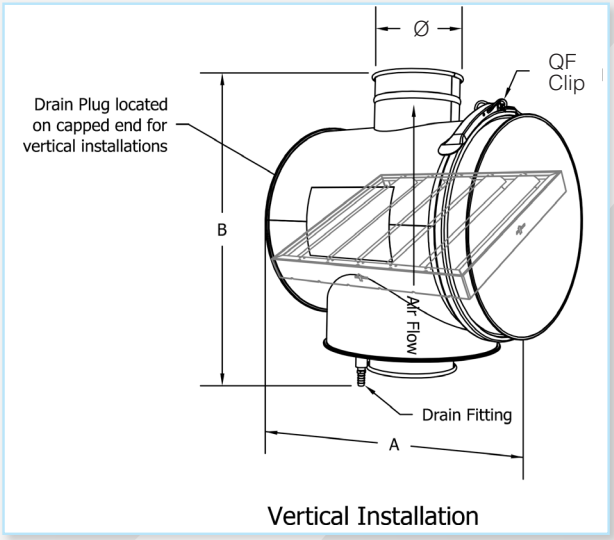
Benefits

- Simple design
- Reduces the likelihood of system leakage
- Helps to prolong the life of filter elements
- Easy to clean and maintain without tools
- Can be mounted horizontally or vertically
- Minimal pressure loss
- Installs in seconds using standard QF Clips
- Eliminates the need for specially fabricated baffles

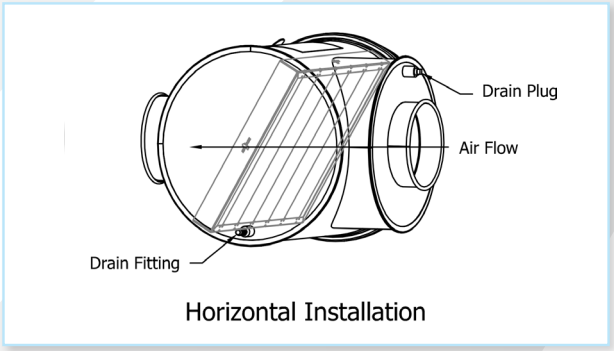
Nordfab's Oil Mist Drain is a pre-separator designed to minimise the amount of moisture present in the airstream. Ideally mounted close to the point of extraction, the drain houses a removable baffle which mechanically extracts excess mist from the system.

Liquid is collected into a sump and can be returned to the machine from which it came using the provided PVC pipe via one of two drain ports.

As standard, the oil mist drain is supplied with a drain fitting and plug enabling it to be mounted in either a horizontal or vertical position. Furthermore, the drain's simple canister-shaped design causes minimal pressure drop and impact on system performance.



Vertical Installation



Horizontal Installation

Ø mm	Item no.	A mm	B mm	Baffle Size mm	Thickness mm
080	23020-080	385	450	370 x 240	0.9
100	23020-100	385	450	370 x 240	0.9
125	23020-125	385	450	370 x 240	0.9
140	23020-140	385	450	370 x 240	0.9
150	23020-150	385	450	370 x 240	0.9
160	23020-160	525	600	513 x 385	0.9
180	23020-180	525	600	513 x 385	0.9
200	23020-200	525	600	513 x 385	0.9
224	23020-224	525	600	513 x 385	0.9
250	23020-250	525	600	513 x 385	0.9
300	23020-300	635	700	625 x 488	0.9
315	23020-315	635	700	625 x 488	0.9
350	23020-350	635	700	625 x 488	0.9
400	23020-400	635	700	625 x 488	0.9

NORDFAB Ducting

General Conditions of Sale

Shipping and Packaging

An additional charge for shipping and packaging may be applied.

Delivery Times

Three days on stocked parts.
For components that are made to order, delivery times may vary.

Upon Receipt of Delivery

Please check the number of packages and that all components are intact before signing the delivery note.
If you are not completely satisfied with your order, please contact us.

Phone: +44 (0) 1132 739 400

Email: sales@nordfab.co.uk

Conditions for Returning Goods

Please contact us before returning goods.
email sales@nordfab.co.uk or phone +44 (0) 1132 739 400.
When returning goods, please enclose a copy of the original invoice or delivery note. Returns without agreement and/or attached documents will not be credited.
Un-damaged standard items should be returned in original packaging. 25% re-stocking charge applies.
Delivery charges for returned items are to be paid by the customer.

Price, reservation and technological changes

We reserve the right to change our prices at any time. To ensure you have the latest prices, please check our website www.nordfabducting.co.uk.

Product Documentation

For product documentation eg. operating and maintenance documents, please visit our website: www.nordfabducting.co.uk.

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