

DUST DUCT CONFIGURATIONS NOTES:

KICE WHITE PAINT IS STANDARD FOR ALL CARBON STEEL

"-NP" PART NUMBER SUFFIX INDICATES NO PAINT

"-P" PART NUMBER SUFFIX INDICATES KICE WHITE PAINT (RAL-9002)

"-SP" PART NUMBER SUFFIX INDICATES SPECIAL PAINT

"-SBP" PART NUMBER SUFFIX INDICATES SANGATI BERGA PAINT (RAL-9003)

SEE STANDARD DRAWINGS FOR FLANGE INFORMATION

"-X" PART NUMBER SUFFIX, SEE EPICOR COMMENTS FOR FLANGE HOLE PATTERNS

SEE SPEED SPOUT MANUAL FOR SMALLER DIAMETERS

CONTACT KICE SALES OR QUICKSHIP FOR SPECIAL ITEMS NOT LISTED

GEN. NOTES:

1. COLLARS FOR DUST DUCT ARE DESIGNED TO BE CONNECTED BY DRAW-TYPE COUPLING.
2. FOR FLANGES, REFERENCE ESS-4501.
3. FOR SFS FLANGES; REFERENCE DWG FLG-1001.
4. SQUARE FLANGES; HOLES ON VERTICAL AND HORIZONTAL CENTERLINES.
5. SQUARE FLANGES; ALWAYS CENTER ONE HOLE IN EACH CORNER.
6. SQUARE FLANGES; BOLT HOLE IN CORNER; FIRST BOLT HOLE FROM CORNER TO BE NO LESS THAN 3", NO GREATER THAN 6" - REMAINING BOLT HOLES ON 6" SPACING.
7. UNLESS OTHERWISE NOTED, ALL DIMENSIONS MEASURE FROM CENTER TO CENTER.
8. UNLESS OTHERWISE NOTED, DUST DUCT COMPONENTS ARE CONSTRUCTED OF 14 GA. CARBON STEEL.
9. STAINLESS STEEL DUCTING IS PER KICE STANDARD FINISH WITHOUT GLASS BEAD BLASTING. ONLY EXTERIOR WELDS WILL BE CONTINUOUS. INTERIOR JOINTS WELDED ONLY AS REQUIRED TO MAINTAIN EQUIPMENT INTEGRITY. WELD SPLATTER, SMOKE AND DISCOLORATION REMOVED, BUT THE WELD SURFACE WILL RETAIN ITS GENERAL BEAD CHARACTERISTICS AND PROFILE.
10. FOR TOLERANCES REFER TO ESS-9900

REVISIONS			
REV	DESCRIPTION	REV BY	DATE
1-0	NEW RELEASE	TJU	07-01-16
2-0	REVISED DIAMETER NOTE ON PG. 3 AND REVISED LENGTH NOTE ON PG. 8 TO CLARIFY SS PART NUMBERING SCOPE	TJU	08-15-16
3-0	E.C.N. #18-023-RO	MRM	08-24-18
4-0	E.C.N. #19-078-R0	MRM	02-20-19
5-0	E.C.N. #21-003-R0	JBR	08-20-21
6-0	E.C.N. #22-003-R1	JBR	08-04-22
7-0	E.C.N. #22-004-R0	JBR	10-19-22
8-0	ECO-100-016-820	JBR	05-02-24
9-0	ADDED ESS-9900	NDB	05-22-25

DUST DUCT CATALOG

DESCRIPTION:



KICE INDUSTRIES, INC.

5500 MILL HEIGHTS DR. WICHITA, KANSAS 67219
PH: (316) 744-7151 FAX: (316) 744- 7355

SHEET 1 OF 14

REV 8-0

TJU
DWN:

07-01-16
DATE:

DUC-5001
DWG. NO.

KICE DUCT ELBOWS - ER & EL

ER - B14 - 16 - 90 - SFS - NF

TYPE

ER - SHORT RADIUS
EL - LONG RADIUS
ERV - SHORT RADIUS WITH TURNING VANES
ELV - LONG RADIUS WITH TURNING VANES

MATERIAL

B - CARBON STEEL
S - 304L STAINLESS STEEL
S6 - 316L STAINLESS STEEL
A - ALUMINUM

MATERIAL GAUGE

CARBON STEEL
14 GAUGE (STANDARD)
12 GAUGE
STAINLESS STEEL
14 GAUGE (STANDARD)
12 GAUGE
ALUMINUM
14 GAUGE (STANDARD)
12 GAUGE

DIAMETER (A)

Ø 9" - Ø 40"
REFERENCE "EG" ELBOW FOR ≤ Ø 8"

ANGLE

45° - 90°

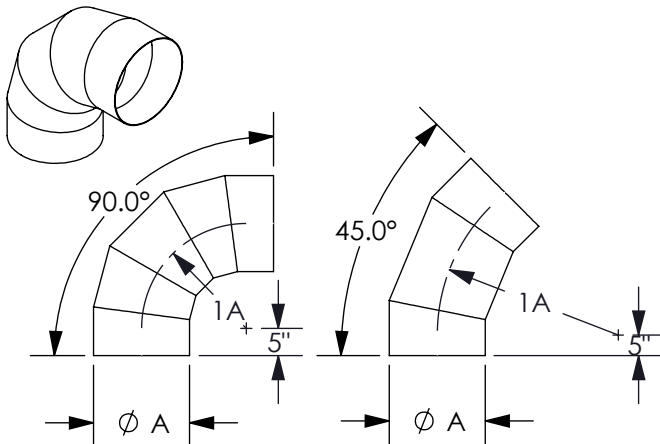
CONNECTION TYPE ON END #1

SFS - SLOTTED HOLE FLANGE
SFA - LOOSE ANGLE RING FLANGE
NF - NO FLANGE
KICE STANDARD: NO FLANGES ≤ Ø 12", FLANGES ≥ Ø 13"

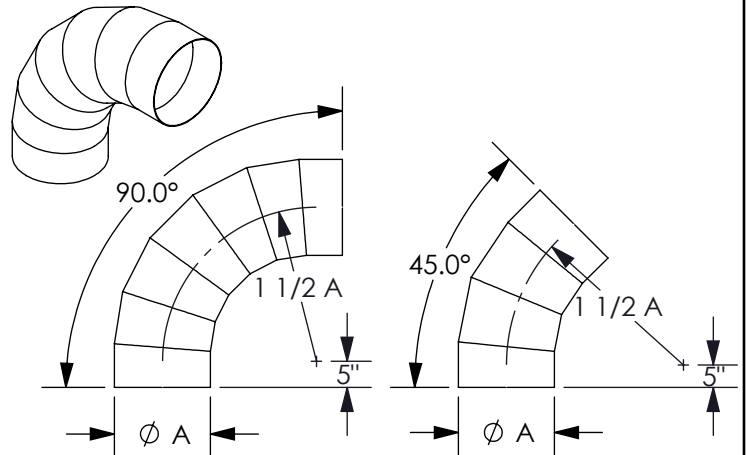
CONNECTION TYPE ON END #2

SFS - SLOTTED HOLE FLANGE
SFA - LOOSE ANGLE RING FLANGE
NF - NO FLANGE
KICE STANDARD: NO FLANGES ≤ Ø 12", FLANGES ≥ Ø 13"

ER FITTING



EL FITTING



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DWN:

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KICE DUST DUCT BRANCH FITTINGS - BS, BD, YP, YA

BS - B14 - 16SFS - 15SFS - 13SFS - 12NF

TYPE

BS - SINGLE BRANCH
BD - DOUBLE BRANCH
YP - INLINE BRANCH
YA - ANGLE BRANCH

MATERIAL

B - CARBON STEEL
S - 304L STAINLESS STEEL
S6 - 316L STAINLESS STEEL
A - ALUMINUM

MATERIAL GAUGE

CARBON STEEL
14 GAUGE (STANDARD)
12 GAUGE
STAINLESS STEEL
14 GAUGE (STANDARD)
12 GAUGE
ALUMINUM
14 GAUGE (STANDARD)
12 GAUGE

DIAMETER (A)

Ø 3" - Ø 40"

DIAMETER (B)

Ø 3" - Ø 40"

DIAMETER (C)

Ø 3" - Ø 40"

DIAMETER (D)

Ø 9" - Ø 40"

CONNECTION TYPE ON A, B, C & D ENDS

SFS - SLOTTED HOLE FLANGE
SFA - LOOSE ANGLE RING FLANGE
NF - NO FLANGE
KICE STANDARD: NO FLANGES $\leq \phi 12"$, FLANGES $\geq \phi 13"$
NO VAN STONE OPTION ON BRANCH FITTINGS

DUST DUCT CATALOG

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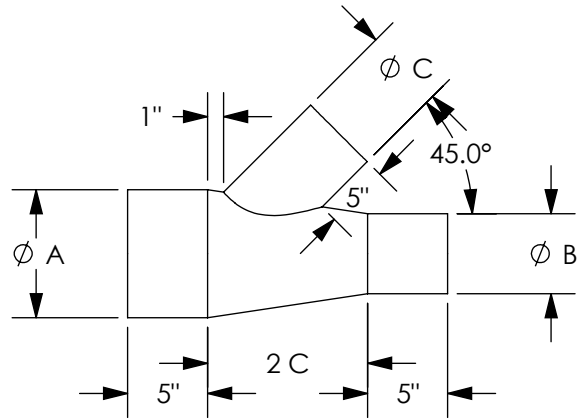
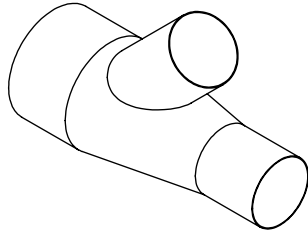
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DATE:

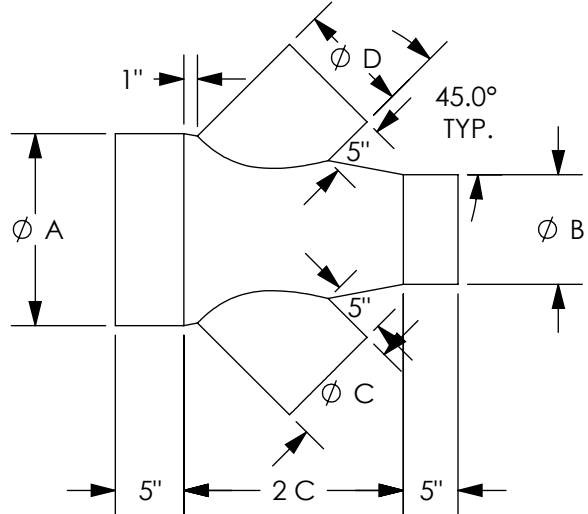
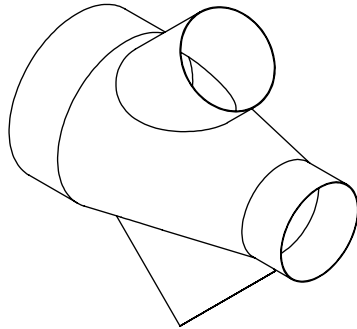
DWG. NO.

KICE DUST DUCT BRANCH FITTINGS - BS, BD, YP, YA

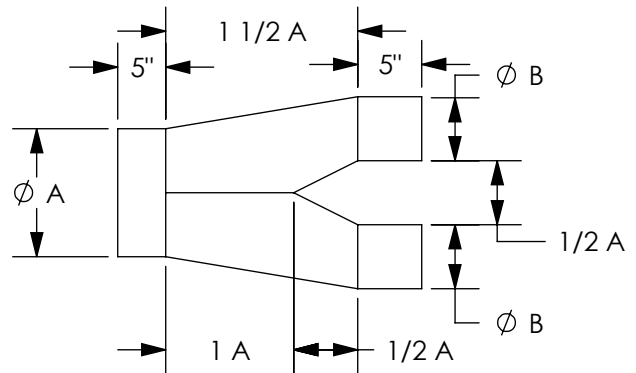
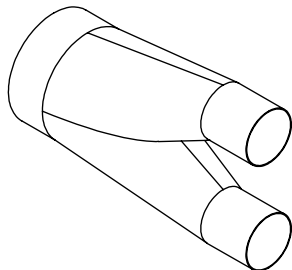
BS FITTING



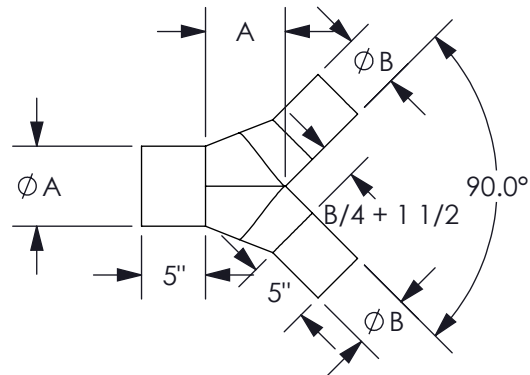
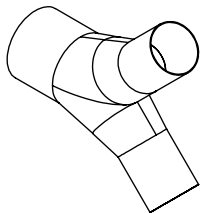
BD FITTING



YP FITTING



YA FITTING



DUST DUCT CATALOG

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DWN:

DATE:

DWG. NO.

KICE DUST DUCT SECTION TAPER - ST

ST - B14 - 13SFS - 15SFS - 16

TYPE _____
ST - REDUCER (STRAIGHT)

MATERIAL _____
B - CARBON STEEL
S - 304L STAINLESS STEEL
S6 - 316L STAINLESS STEEL
A - ALUMINUM

MATERIAL GAUGE _____
CARBON STEEL
14 GAUGE (STANDARD)
12 GAUGE
STAINLESS STEEL
14 GAUGE (STANDARD)
12 GAUGE
ALUMINUM
14 GAUGE (STANDARD)
12 GAUGE

DIAMETER (A) _____
 $\phi 7'' - \phi 36''$

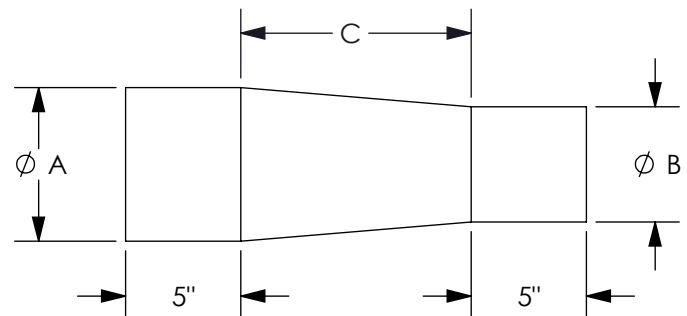
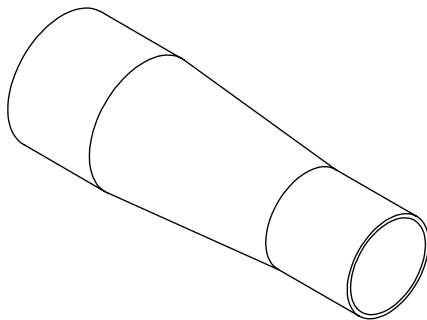
DIAMETER (B) _____
 $\phi 7'' - \phi 36''$

CONNECTION TYPE ON END A & B _____
SFS - SLOTTED HOLE FLANGE
SFA - LOOSE ANGLE RING FLANGE
NF - NO FLANGE
KICE STANDARD: NO FLANGES $\leq \phi 12''$, FLANGES $\geq \phi 13''$

TOTAL LENGTH _____
DIMENSION C + 10"

ST FITTING

	DIA. DIFF.	C
A - B	1 - 5"	6"
	6 - 10"	12"
	11 - 15"	18"



DUST DUCT CATALOG
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TJU
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KICE DUST DUCT ROUND TRANSITION - RN, RS

RN - B14 - B SFS - A - C - D

TYPE

RN - CENTER DISCHARGE
RS - OFFSET DISCHARGE

MATERIAL

B - CARBON STEEL
S - 304L STAINLESS STEEL
S6 - 316L STAINLESS STEEL
A - ALUMINUM

MATERIAL GAUGE

CARBON STEEL
14 GAUGE (STANDARD)
12 GAUGE
STAINLESS STEEL
14 GAUGE (STANDARD)
12 GAUGE
ALUMINUM
14 GAUGE (STANDARD)
12 GAUGE

DIAMETER (B)

$\phi 3"$ - $\phi 40"$

CONNECTION TYPE ON END

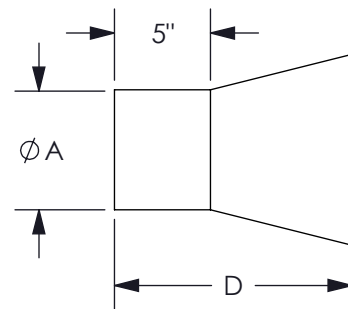
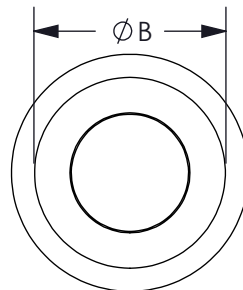
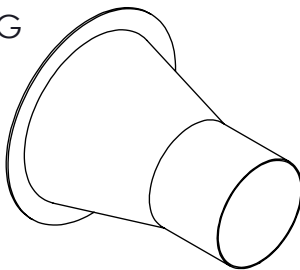
SFS - SLOTTED HOLE FLANGE
SFA - LOOSE ANGLE RING FLANGE
NF - NO FLANGE
KICE STANDARD: NO FLANGES $\leq \phi 12"$, FLANGES $\geq \phi 13"$

OTHER SUPPLIED DIMENSIONS (A & C)

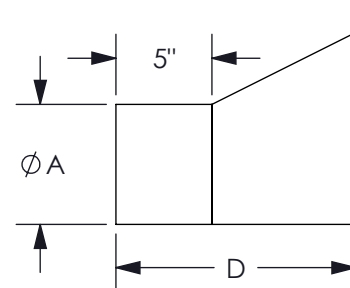
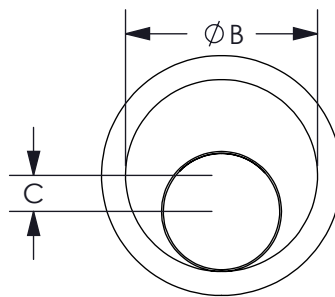
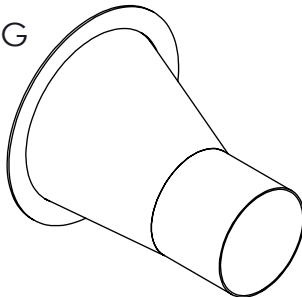
HOLE (D)

SH - STANDARD HOLE
NH - NO HOLE
AP - AIRLOCK HOLE PATTERN

RN FITTING



RS FITTING



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KICE DUST DUCT TRANSITION - TN, TS, TC

TN - B14 - A SFS - B - C - D - E

TYPE

TC - CORNER OFFSET DISCHARGE
TN - CENTER DISCHARGE
TS - OFFSET DISCHARGE

MATERIAL

B - CARBON STEEL
S - 304L STAINLESS STEEL
S6 - 316L STAINLESS STEEL
A - ALUMINUM

MATERIAL GAUGE

CARBON STEEL
14 GAUGE (STANDARD)
12 GAUGE
STAINLESS STEEL
14 GAUGE (STANDARD)
12 GAUGE
ALUMINUM
14 GAUGE (STANDARD)
12 GAUGE

DIAMETER (A)

Ø 3" - Ø 40"

CONNECTION TYPE ON END

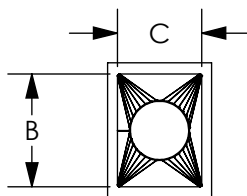
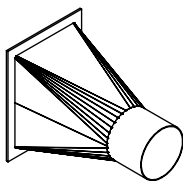
SFS - SLOTTED HOLE FLANGE
SFA - LOOSE ANGLE RING FLANGE
NF - NO FLANGE
KICE STANDARD: NO FLANGES ≤ Ø 12", FLANGES ≥ Ø 13"

OTHER SUPPLIED DIMENSIONS (B, C, & D)

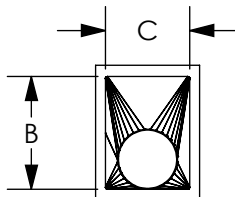
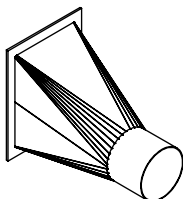
HOLE (E)

SH - STANDARD HOLE (6" SPACING)
NH - NO HOLE
AP - AIRLOCK HOLE PATTERN

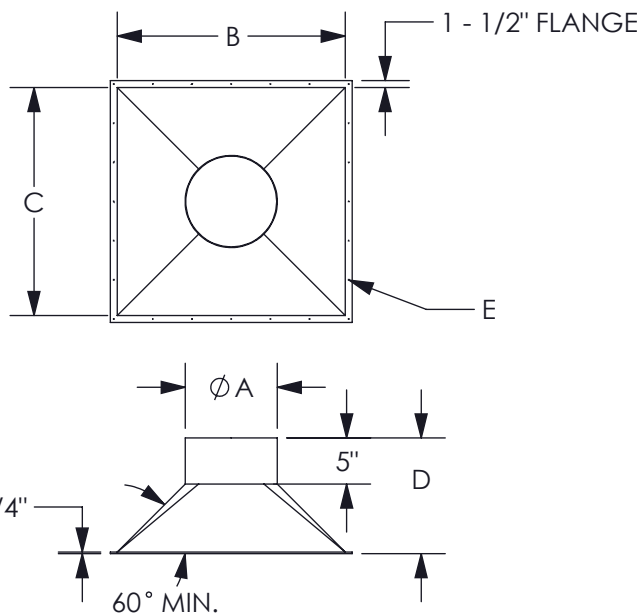
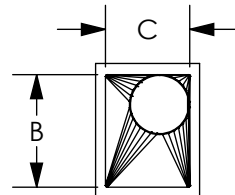
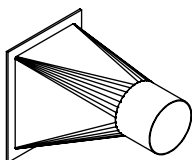
TN FITTING



TS FITTING



TC FITTING



DUST DUCT CATALOG

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DWN:

07-01-16
DATE:

DUC-5001
DWG. NO.

KICE DUST DUCT STRAIGHT SECTION - SS

SS - B14 - 12 - 60 - SFS - SFA

TYPE _____

SS - STRAIGHT SECTION

MATERIAL _____

B - CARBON STEEL
S - 304L STAINLESS STEEL
S6 - 316L STAINLESS STEEL
A - ALUMINUM

MATERIAL GAUGE _____

CARBON STEEL
14 GAUGE (STANDARD)
12 GAUGE
STAINLESS STEEL
14 GAUGE (STANDARD)
12 GAUGE
ALUMINUM
14 GAUGE (STANDARD)
12 GAUGE

DIAMETER (A) _____

$\phi 9"$, $\phi 11"$, $\phi 13 - 40"$
REFER TO THE PRICE BOOK FOR OTHER DIAMETERS
NOTE: $\phi 10"$ AND $\phi 12"$ PURCHASED TUBING USES PART NUMBER
FORMAT LISTED ABOVE. $\phi 0 - 8"$ PURCHASED SPEED SPOUT
TUBING USES PURCHASE PART NUMBER

LENGTH (B) _____

$\phi 9"$, $\geq \phi 11"$ - 120" LENGTH
 $\phi 9"$, $\geq \phi 11"$ - 60" LENGTH
 $> \phi 40"$ - 60" LENGTH
NOTE: 10" AND 12" PURCHASED TUBING USES THE PART NUMBER FORMAT
LISTED ABOVE. 0 - 8" PURCHASED SPEED SPOUT TUBING USES
NUMBER (20' LENGTH DEFAULT) IF LENGTH IS LESS THAN 20', SPECIFY
LENGTH IN INCHES (ex. TUBERD14x5x27.75" CS)

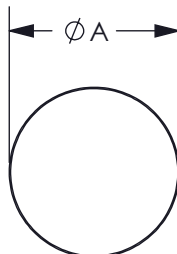
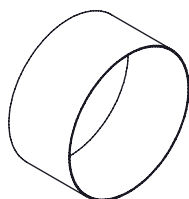
CONNECTION TYPE ON END #1 _____

SFS - SLOTTED HOLE FLANGE
SFA - LOOSE ANGLE RING FLANGE
NF - NO FLANGE
KICE STANDARD: NO FLANGES $\phi 0" - 10"$, FLANGES $> \phi 10"$

CONNECTION TYPE ON END #2 _____

SFS - SLOTTED HOLE FLANGE
SFA - LOOSE ANGLE RING FLANGE
NF - NO FLANGE
KICE STANDARD: NO FLANGES $\phi 0" - 10"$, FLANGES $> \phi 10"$

SS FITTING



DUST DUCT CATALOG

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DWN:

DATE:

DWG. NO.

KICE DUST DUCT SUPPORT RING - CR

CR - B - 8 - C

TYPE

CR - SUPPORT RING

MATERIAL

B - CARBON STEEL

S - 304L STAINLESS STEEL

S6 - 316L STAINLESS STEEL

A - ALUMINUM

DIAMETER (A)

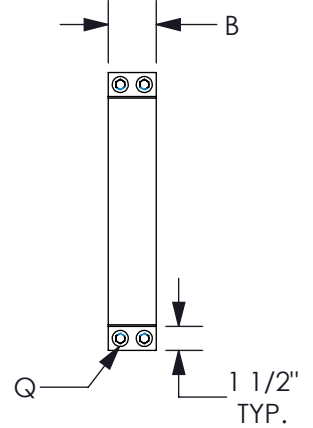
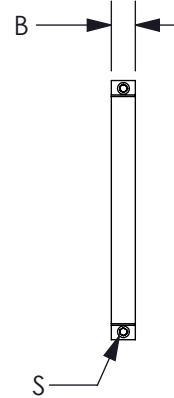
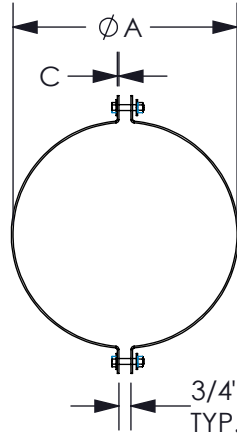
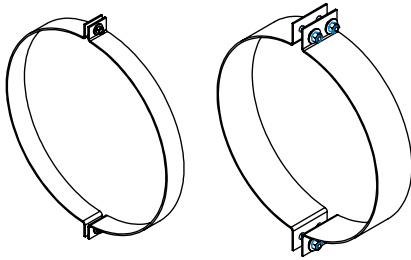
> $\phi 3"$

COUPLING NUT INTERNAL USE ONLY

3/8" - 16 x 1-3/4" LENGTH

A	B	C	Q	S
3" - 12"	2"	14 GA.	2	3/8-16
13" - 24"	3"	12 GA.	4	3/8-16
25" - 36"	3"	10 GA.	4	1/2-13
>37"	4"	3/16"	4	1/2-13

CR FITTING



KICE DUST DUCT FREE AIR INLET & CAP - CI, CP

CI - B - 12NF

TYPE

CI - FREE AIR INLET

CP - CAP

MATERIAL

B - CARBON STEEL

S - 304L STAINLESS STEEL

S6 - 316L STAINLESS STEEL

A - ALUMINUM

DIAMETER (A)

$\phi 6" - \phi 20"$

CONNECTION TYPE ON END

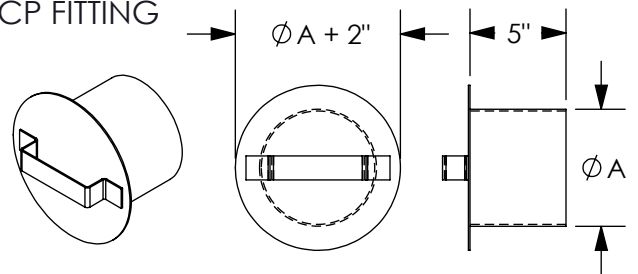
SFS - SLOTTED HOLE FLANGE

SFA - LOOSE ANGLE RING FLANGE

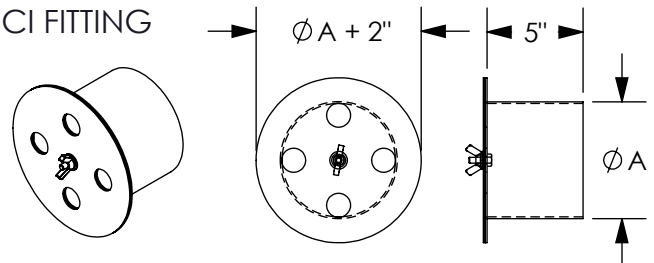
NF - NO FLANGE (COUPLING REQUIRED)

KICE STANDARD: NO FLANGES $\leq \phi 12"$, FLANGES $\geq \phi 13"$

CP FITTING



CI FITTING



DUST DUCT CATALOG

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DWN:

DATE:

DWG. NO.

KICE DUST DUCT ADAPTER - SA

SA - B14 - 12SFS

TYPE

SA - STRAIGHT SECTION ADAPTER

MATERIAL

B - CARBON STEEL

S - 304L STAINLESS STEEL

S6 - 316L STAINLESS STEEL

A - ALUMINUM

MATERIAL GAUGE

CARBON STEEL

14 GAUGE (STANDARD)

12 GAUGE

STAINLESS STEEL

14 GAUGE (STANDARD)

12 GAUGE

ALUMINUM

14 GAUGE (STANDARD)

12 GAUGE

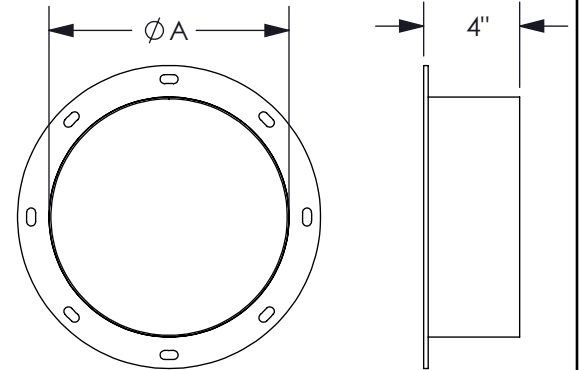
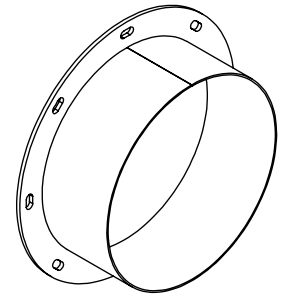
DIAMETER (A)

> ϕ 6"

CONNECTION TYPE ON END

SFS - SLOTTED HOLE FLANGE

SA FITTING



SEE FLANGE SPECIFICATION
TABLE ON SHEET 1

KICE DUST DUCT COUPLING - CC

CC - B - 11

TYPE

CC - COUPLING

MATERIAL

B - CARBON STEEL

S - 304L STAINLESS STEEL

S6 - 316L STAINLESS STEEL

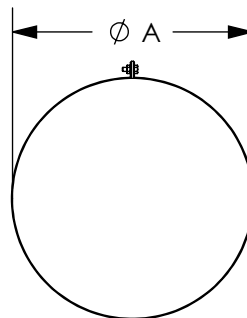
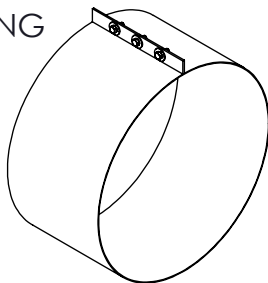
DIAMETER (A)

ϕ 13" - ϕ 39"

LENGTH (B)

9.5" (STANDARD FOR $\geq \phi$ 13")

CC FITTING



DUST DUCT CATALOG

DESCRIPTION:



KICE INDUSTRIES, INC.

5500 MILL HEIGHTS DR. WICHITA, KANSAS 67219
PH: (316) 744-7151 FAX: (316) 744- 7355

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KICE DUST DUCT INSPECTION DOOR - CD

CD - B - 11

TYPE _____

CD - DOOR (DOOR ONLY, NO TUBE SECTION)

MATERIAL _____

B - CARBON STEEL
S - 304L STAINLESS STEEL
S6 - 316L STAINLESS STEEL
A - ALUMINUM

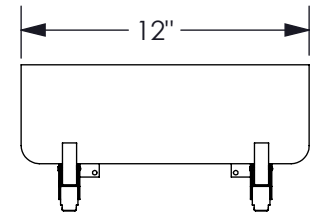
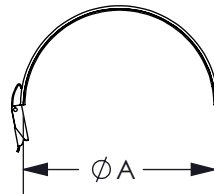
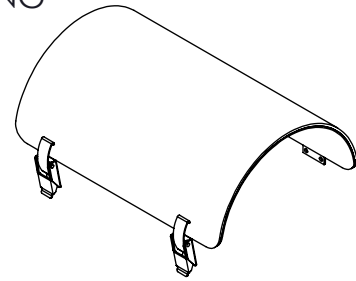
DIAMETER (A) _____

Ø 9" - Ø 40"

GEN NOTES:

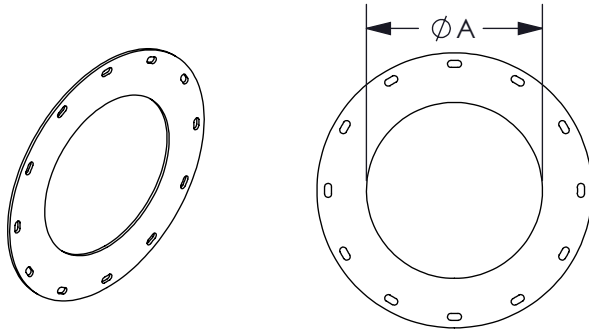
1. MATERIAL CONSTRUCTION 14 GAUGE.
2. INCLUDES FOOD GRADE RATED GASKET.
3. FOR DIAMETERS LESS THAN 9"; SEE 76 SERIES SPEED SPOUT.

CD FITTING

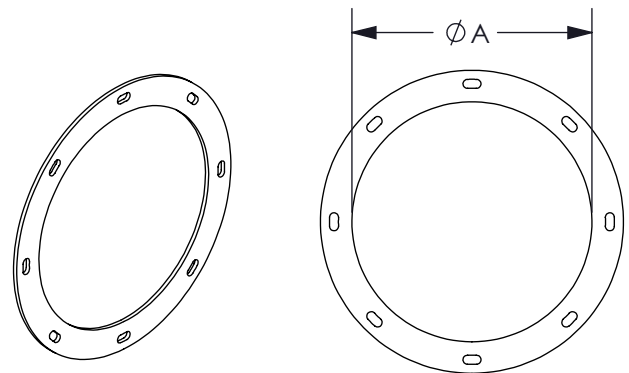


KICE 'NON-CONFIGURED' DUST DUCT ITEMS

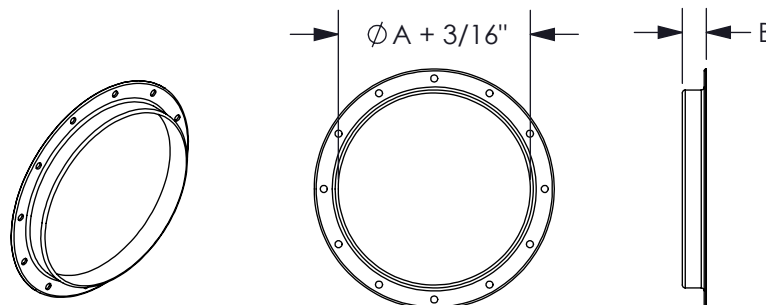
SFSI - SLOTTED HOLE FLANGE
FOR INSULATION



SFS - SLOTTED HOLE FLANGE



SFA - ANGLE RING FLANGE



DUST DUCT CATALOG

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KICE DUST DUCT DOOR SECTION - DS

DS - B14 - 12 - SFS - SFA

TYPE _____
DS - DOOR SECTION

MATERIAL _____
B - CARBON STEEL
S - 304L STAINLESS STEEL
S6 - 316L STAINLESS STEEL
A - ALUMINUM

MATERIAL GAUGE _____
CARBON STEEL
14 GAUGE (STANDARD)
12 GAUGE
STAINLESS STEEL
14 GAUGE (STANDARD)
12 GAUGE
ALUMINUM
14 GAUGE (STANDARD)
12 GAUGE

DIAMETER (A) _____
Ø 9" - Ø 40"

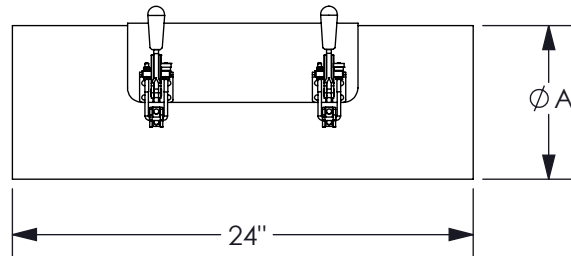
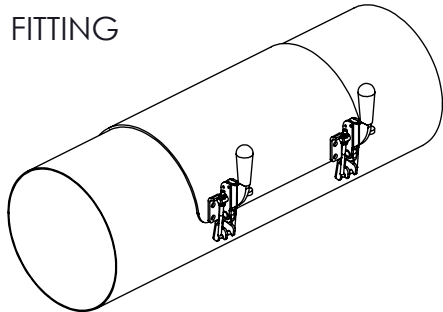
CONNECTION TYPE ON END #1 _____
SFS - SLOTTED HOLE FLANGE
SFA - LOOSE ANGLE RING FLANGE
NF - NO FLANGE
NO FLANGES ≤ Ø 10", FLANGES ≥ Ø 11"

CONNECTION TYPE ON END #2 _____
SFS - SLOTTED HOLE FLANGE
SFA - LOOSE ANGLE RING FLANGE
NF - NO FLANGE
NO FLANGES ≤ Ø 10", FLANGES ≥ Ø 11"

GEN. NOTES:

1. DS FITTING CANNOT BE INSTALLED BETWEEN A FILTER OR CYCLONE AND AN EXPLOSION ISOLATION DEVICE.
2. INCLUDES FOOD GRADE RATED GASKET.
3. DOOR ATTACHED WITH FULL LENGTH PIANO STYLE HINGE.
4. INSIDE OF DOOR INCLUDES LAMINATE WITH SAME THICKNESS AND MATERIAL OF DUCT.
5. INCLUDES 2 DESTACO TYPE LATCHES THAT CAN BE ADJUSTED FOR SECURE CLOSURE.
6. FOR DIAMETERS LESS THAN 9"; SEE 75 SERIES SPEED SPOUT.

DS FITTING



DUST DUCT CATALOG

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KICE DUCT ELBOW - EG

EG - B14 - 4 - 90 - SFS - NF

TYPE

EG - SHORT RADIUS

EGV - SHORT RADIUS WITH TURNING VANES

MATERIAL

B - CARBON STEEL

S - 304L STAINLESS STEEL

S6 - 316L STAINLESS STEEL

A - ALUMINUM

MATERIAL GAUGE

CARBON STEEL

14 GAUGE (STANDARD)

12 GAUGE

STAINLESS STEEL

14 GAUGE (STANDARD)

12 GAUGE

ALUMINUM

14 GAUGE (STANDARD)

12 GAUGE

DIAMETER (A)

$\phi 2\text{-}1/2"$, $\phi 3"$, $\phi 4"$, $\phi 4\text{-}1/2"$, $\phi 5"$, $\phi 5\text{-}1/2"$, $\phi 6"$, $\phi 7"$, $\phi 8"$

REFERENCE "ER" OR "EL" ELBOWS FOR $\geq \phi 9"$

ANGLE

45° - 90°

CONNECTION TYPE ON END #1

SFS - SLOTTED HOLE FLANGE

SFA - LOOSE ANGLE RING FLANGE

NF - NO FLANGE

KICE STANDARD: NO FLANGES $\leq \phi 12"$

CONNECTION TYPE ON END #2

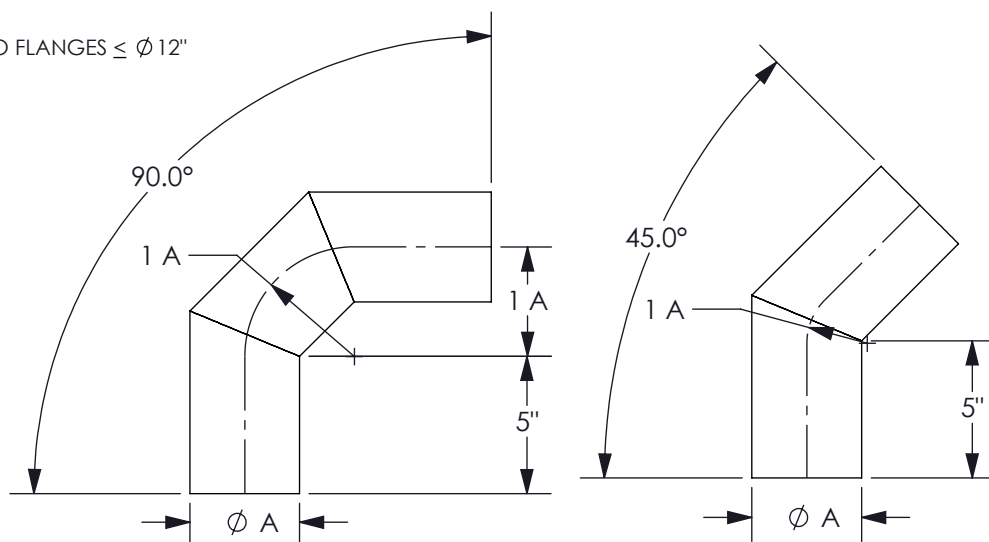
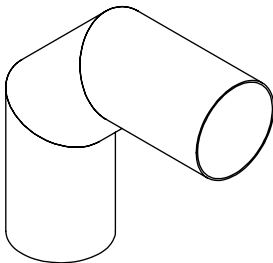
SFS - SLOTTED HOLE FLANGE

SFA - LOOSE ANGLE RING FLANGE

NF - NO FLANGE

KICE STANDARD: NO FLANGES $\leq \phi 12"$

EG FITTING



DUST DUCT CATALOG

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ESS-9900 Dimensions and Tolerances

1. SCOPE

This specification provides Kice standards for dimensions and tolerances.

2. DRAWING SUPERIORITY

A. If there is a conflict between the specifications on a drawing and this specification, the information on the drawing supersedes this document.

B. If the drawing does not specify a dimension, the nominal dimension between any two points of the model shall fall within the tolerances specified in this specification.

3. KICE STANDARD UNITS

A. Kice standard units are inches, decimal degrees, pounds, and seconds. If another standard of measurement needs to be used, a note will be placed on the drawing or dimension to specify.

4. KICE STANDARD TOLERANCES

A. Adapted from ISO 2678

Piece Parts			Weldments			Bolted Assembly		
Normal size			Normal size			Normal size		
From (not inclusive)	To (inclusive)	Standard Tolerance	From (not inclusive)	To (inclusive)	Standard Tolerance	From (not inclusive)	To (inclusive)	Standard Tolerance
0	0.125	0.008	0	5	1/32	0	40	3/16
0.125	0.25	0.012	5	16	1/16	40	78	1/4
0.25	1.25	0.02	16	40	3/32	78	120	3/8
1.25	5	1/32	40	78	1/8	120	+	1/2
5	78	1/16	78	120	3/16			
78	160	3/32	120	+	1/4			

5. ANGULAR DIMENSIONS

A. All Right angles are assumed to be 90°.

B. Formed dimensions are to be $\pm 1^\circ$.

C. All other dimensions are to be $\pm 0.1^\circ$.

6. FLATNESS AND STRAIGHTNESS

A. Standard flatness and straightness tolerances are $\pm 1/8"$ per 12"

DUST DUCT CATALOG

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