

AIR- DUCT MANUFACTURING

SPIRAL AIR DUCT & FITTINGS



AIR- DUCT MANUFACTURING

EXPERIENCE IN HVAC

Air-Duct Manufacturing has 40 years of experience in the HVAC industry providing its customers with fast, efficient service and the highest quality products. Our approach to manufacturing provides precision-fit duct and fittings for your entire project.

MANUFACTURER OF SPIRAL DUCT AND FITTINGS

Air-Duct Manufacturing's experience in this field allows us to serve all of your air distribution needs. We manufacture all types of ductwork including galvanized steel, paintable steel, aluminum, stainless steel and PVC-Coated steel spiral duct and fittings in either single or double wall in diameters of 3 inches through 60 inches in gauges 26 through 18. Air-Duct Manufacturing has the capability and the expertise to make any type of fitting you will ever need.

QUICK AND EFFICIENT PERSONAL SERVICE

Air-Duct Manufacturing will provide you with the quickest and most efficient service in the industry. We give price quotations in a timely manner. Our own manufacturing capabilities allow us to provide you with individualized service not available from larger companies where your order is just one of hundreds of other orders. Because Air-Duct manufactures its own products, we can easily insure your rush orders will be delivered when you want them. We know you will be pleased with our products.

QUALITY PRODUCTS

Air-Duct Manufacturing specializes in providing high quality oval and spiral duct products. Our machineries are state-of-the-art with computer-aided precision to provide top quality and reliable products. Air-Duct's machinists are skilled and experienced technicians who take pride in providing the best quality ductwork. Our goal is your complete satisfaction and a strong and long lasting business relationship.

THE VERSATILITY OF SPIRAL DUCT

Spiral duct is not only for high and low velocity ventilation projects. It has many other uses. In the construction industry spiral duct may be used for voids in concrete, caisson liners, concrete column forms and culverts. Spiral duct may be used in agriculture for drainage, irrigation pipe, augur housing and for grain aeration and handling. In factories spiral duct may be used for fume hood exhaust systems and dust removal applications. While in mining, spiral duct may be used in conveyors, drainage and ventilation.

AIR- DUCT MANUFACTURING

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AIR-DUCT MANUFACTURING



DIA. ROUND TUBE in.		MINOR AXIS inches								DUCT GA.	
		6	8	10	12	14	16	18	20		24
12		15	14								24 GA.
14		18	17	16							
16	M	22	21	19	18	17					
18	A	25	24	23	21	20					
20	J	28	27	26	25	23	22	21			
22	O	31	30	29	28	27	25	24	23		
24	R	34	33	32	31	30	29	27	26		22 GA.
26		37	36	35	34	33	32	31	29	27	
28	A	41	39	38	37	36	35	34	33	30	
30	X	44	43	41	40	39	38	37	36	33	
32	I	47	46	45	43	42	41	40	39	37	
34	S	50	49	48	47	45	44	43	42	40	
36		53	52	51	50	49	47	46	45	43	
38	i	56	55	54	53	52	51	50	48	46	
40	n	60	58	57	56	55	54	53	52	49	20 GA.
42	c	63	62	60	59	58	57	56	55	53	
44	h	66	65	64	62	61	60	59	58	55	
46	e	69	68	67	65	64	63	62	61	59	
48	s	72	71	70	69	67	66	65	64	62	
52		79	77	76	75	74	73	72	71	68	
56				83	81	80	79	78	77	74	18 GA.
60								84	83	81	

AIR- DUCT MANUFACTURING

PRODUCT SPECIFICATIONS

Single Wall Galvanized Steel (ASTM A-527) & Paintable Steel Duct & Fittings Gauges

Diameter	Maximum 2" W.G. Positive Pressure		Maximum 10" W.G. Positive Pressure		Maximum 2" W.G. Negative Pressure	
	Spiral Duct	Fittings	Spiral Duct	Fittings	Spiral Duct	Fittings
3" - 14"	26	24	26	24	26	24
15" - 26"	24	24	24	22	24	22
27" - 36"	22	22	22	20	22	20
38" - 50"	20	20	20	20	20	18
52" - 60"	18	18	18	18	18	16
62" - Up	18	16	18	16	16	14

Polyvinyl Coated (PVC Coated) Steel Duct & Fittings Gauges

Diameter	4 x 1 Underground	
	Spiral Duct	Fittings
3" - 8"	26	26
9" - 16"	24	24
17" - 24"	22	22
25" - 32"	20	20
34" - 50"	18	18

Diameter	4 x 4 or 4 x 1 Reverse Abovefloor	
	Spiral Duct	Fittings
3" - 12"	26	26
13" - 18"	24	24
19" - 26"	24	22
27" - 36"	22	20
38" - 50"	20	18

AIR- DUCT MANUFACTURING

PRODUCT SPECIFICATIONS

Double Wall Galvanized Steel (ASTM A-527) & Paintable Steel Duct & Fittings Gauges

Diameter	Maximum 2" W.G. Positive Pressure				Maximum 10" W.G. Positive Pressure			
	Spiral Duct		Fittings		Spiral Duct		Fittings	
	Outer Shell	Perforated Liner	Outer Shell	Perforated Liner	Outer Shell	Perforated Liner	Outer Shell	Perforated Liner
3" - 12"	26	24	24	24	26	24	24	24
13" - 24"	24	24	24	24	24	24	22	24
25" - 34"	22	22	22	22	22	22	20	22
36" - 48"	20	22	20	22	20	22	20	22
50" - 58"	18	22	18	22	18	22	18	22
60" - Up	18	22	16	22	18	22	16	22

Stainless Steel (Type 304 or 316) Duct & Fittings Gauges

Diameter	Maximum 2" W.G. Positive Pressure		Maximum 10" W.G. Positive Pressure		Maximum 2" W. G. Negative Pressure	
	Spiral Duct	Fittings	Spiral Duct	Fittings	Spiral Duct	Fittings
3" - 14"	26	26	26	24	26	24
15" - 26"	26	24	24	22	24	22
27" - 36"	24	22	22	20	22	20
38" - 50"	22	20	20	20	20	18
52" - 60"	20	18	18	18	18	16
62" - Up	18	16	18	16	16	14

AIR-DUCT MANUFACTURING

PRODUCT SPECIFICATIONS

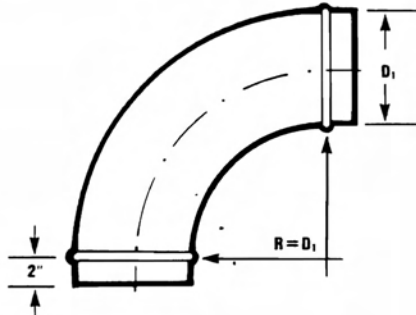
Aluminum (Type 3003) Duct & Fittings Gauges

Diameter	Maximum 2" W.G. Positive Pressure		Maximum 2" W.G. Negative Pressure	
	Spiral Duct	Fittings	Spiral Duct	Fittings
3" - 8"	22	20	22	18
9" - 14"	22	20	20	18
15" - 26"	20	18	18	16
27" - 36"	18	16	16	14
38" - 50"	16	14	14	12
52" - 60"	14	12	14	10

- Spiral duct is available in standard lengths of 10 feet. Other lengths can be supplied on request.
- All low pressure fittings are spot welded and sealed.
- All medium pressure fittings are either stitch welded or gore locked, spot welded and sealed.
- Other materials and gauges can be fabricated upon request.
- All Air-Duct Manufacturing products meet or exceed the latest SMACNA standards for the indicated pressure classification.

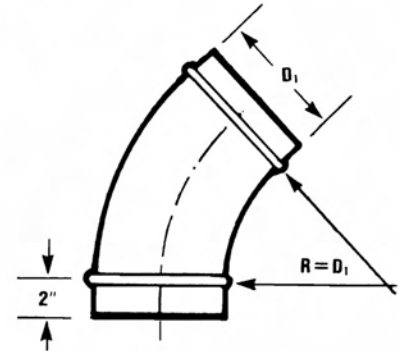
AIR-DUCT MANUFACTURING

SIZES 3"φ THRU 12"

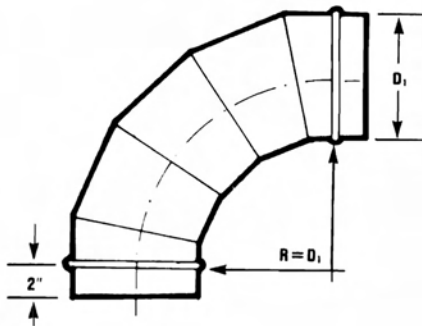


ED - 90
90° DIE STAMPED ELBOW
R = 1.5 X D

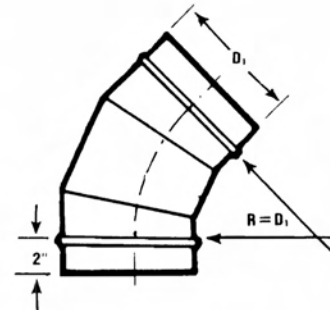
SIZES 3"φ THRU 12"



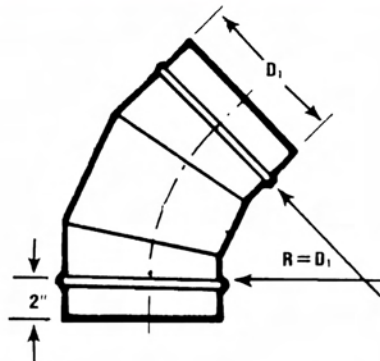
ED - 45
45° DIE STAMPED ELBOW
R = 1.5 X D



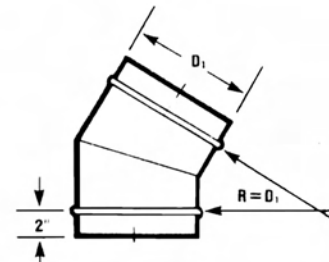
E5 - 90
90° 5-PIECE ELBOW
R = 1.5 X D



E3 - 45
45° 3-PIECE ELBOW
R = 1.5 X D

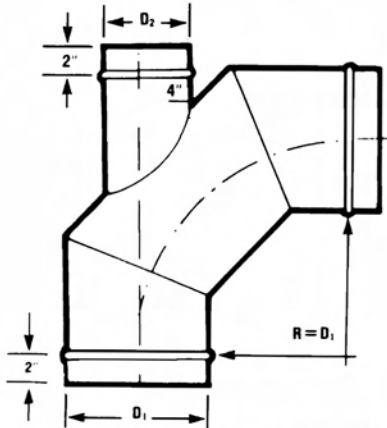


E3 - 60
60° 3-PIECE ELBOW
R = 1.5 X D



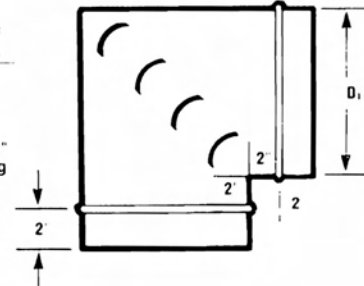
E2 - 30 OR E2 - 22½
30° OR 22½° 2-PIECE ELBOW
R = 1.5 X D

AIR-DUCT MANUFACTURING

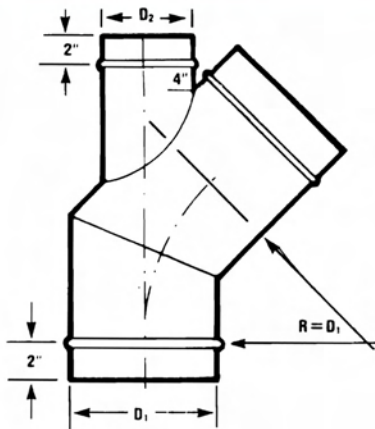


ET - 90
90° 3-PIECE ELBOW WITH TAKE-OFF
R = 1.5 X D

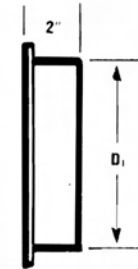
D1	No. of vanes
3-9	2
10-14	3
15-19	4
20-60	5
≥60	Max 12" spacing



EM - 90
90° 2-PIECE MITERED ELBOW
WITH OR WITHOUT TURNING VANES



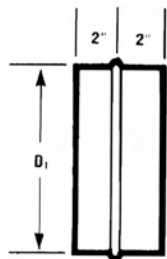
ET - 45
45° 2-PIECE ELBOW WITH TAKE-OFF
R = 1.5 X D



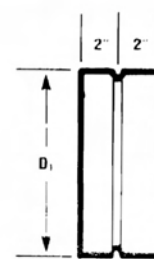
EC - P
END CAP
FOR PIPE

OR

EC - F
END CAP
FOR FITTING

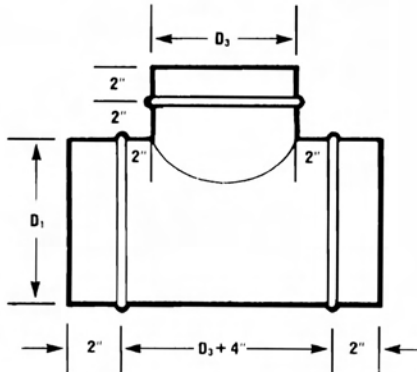


PC - P
COUPLING FOR PIPE



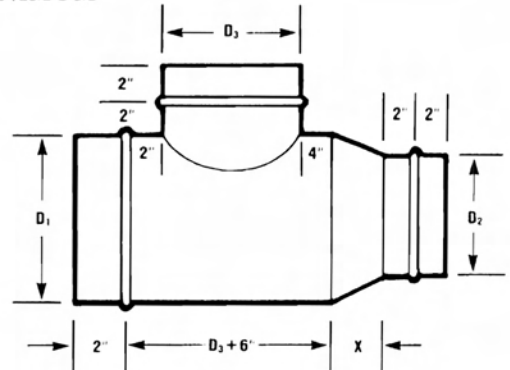
PC - F
COUPLING FOR FITTINGS

AIR-DUCT MANUFACTURING

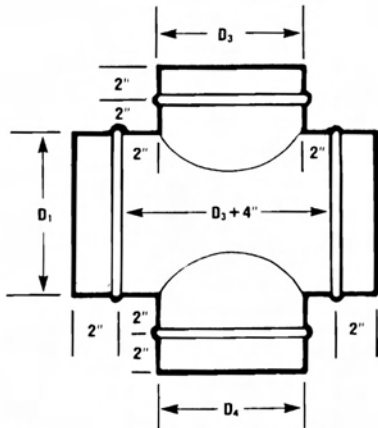


T - 90
90° TEE

X = 4" MINIMUM

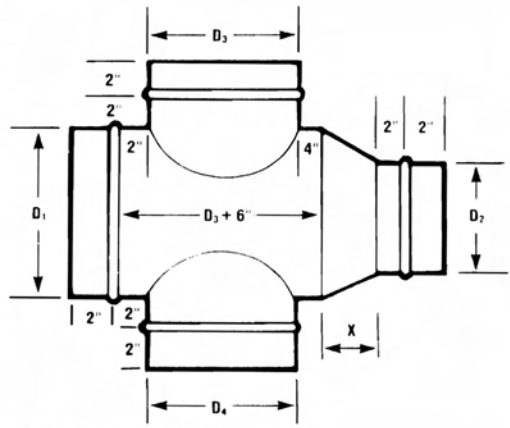


T - 90 R
90° REDUCING TEE



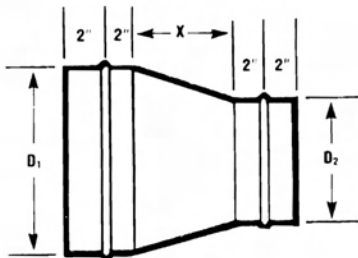
C - 180
180° CROSS

X = 4" MINIMUM



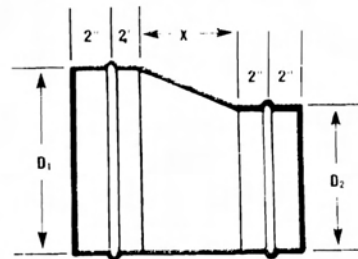
C - 180R
180° REDUCING CROSS

$$X = D_1 - D_2$$



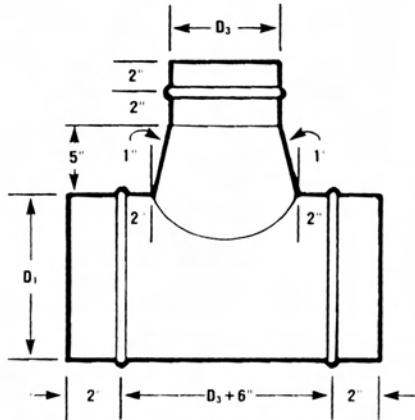
CR
CONCENTRIC REDUCER

$$X = 2 [D_1 - D_2]$$



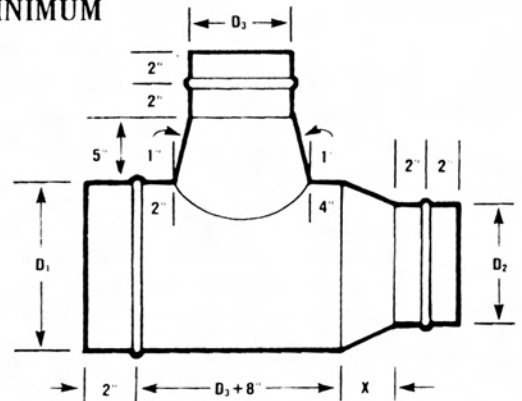
ER
ECCENTRIC REDUCER

AIR-DUCT MANUFACTURING

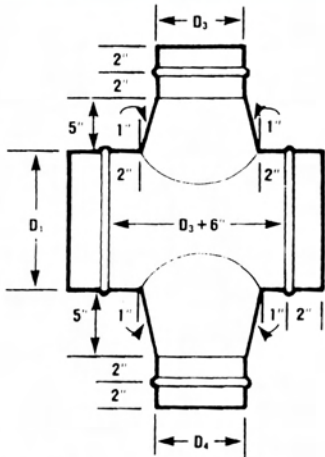


CT - 90
90° CONICAL TEE

X = 4" MINIMUM

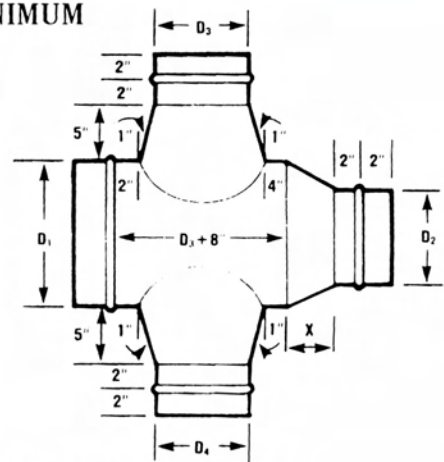


CT - 90 R
90° REDUCING CONICAL TEE

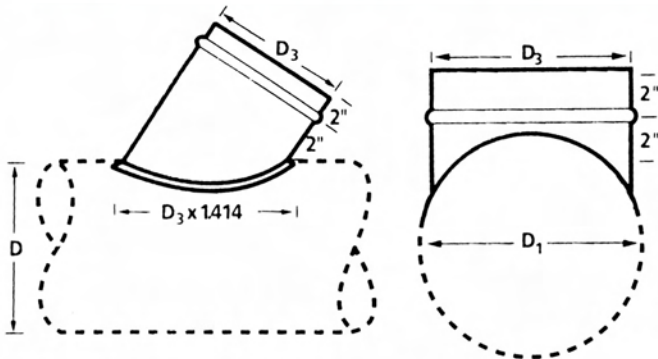


CC - 180
180° - CONICAL CROSS

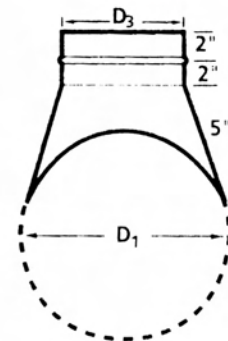
X = 4" MINIMUM



CC - 180R
180° CONICAL REDUCING CROSS

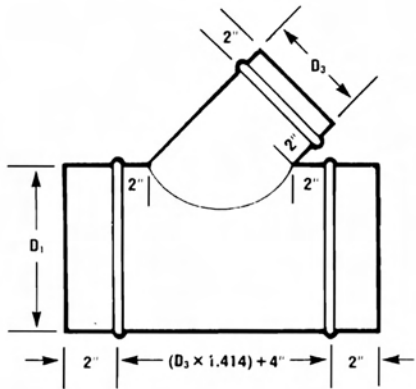


TAP
45° OR 90° TAP
SHOP OR FIELD INSTALLED



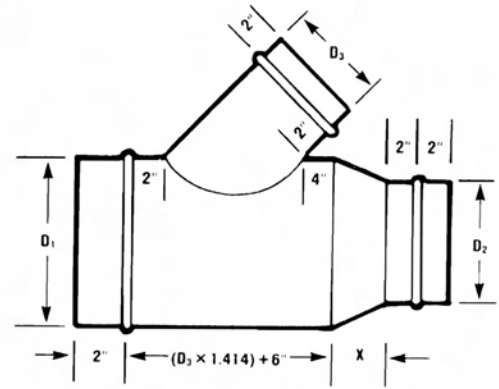
C - TAP
90° CONICAL TAP
SHOP OR FIELD INSTALLED

AIR-DUCT MANUFACTURING

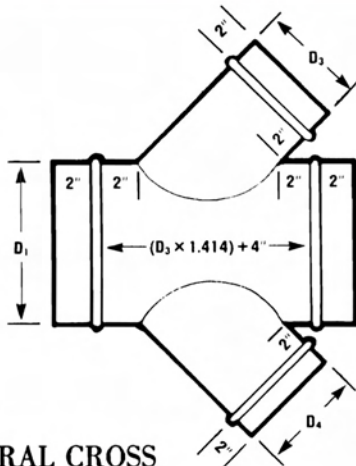


L - 45
45° LATERAL

X = 4" MINIMUM

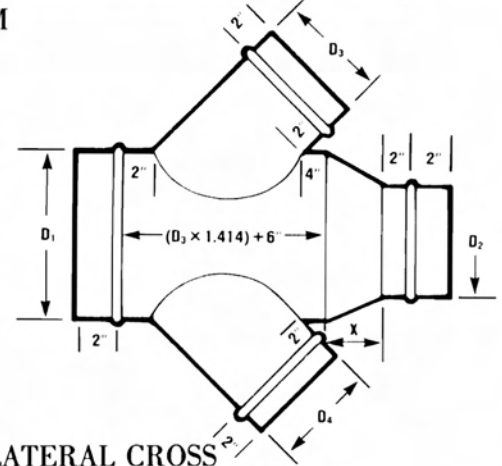


L - 45R
45° REDUCING LATERAL

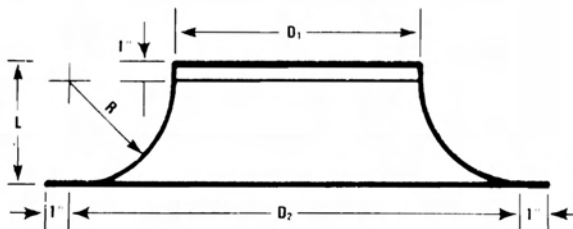


LC - 45
45° LATERAL CROSS

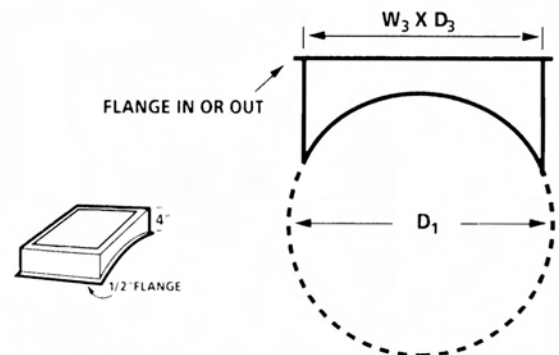
X = 4" MINIMUM



LC - 45R
45° REDUCING LATERAL CROSS

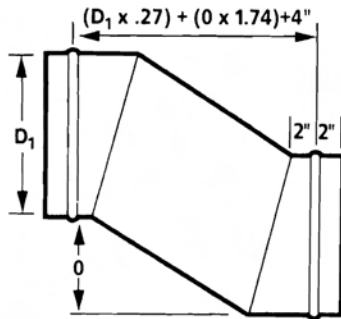


BELL
BELLMOUTH FITTING

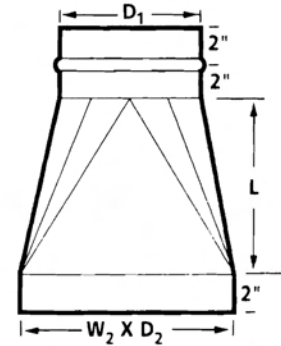


RF
REGISTER FRAMES
SHOP OR FIELD INSTALLED

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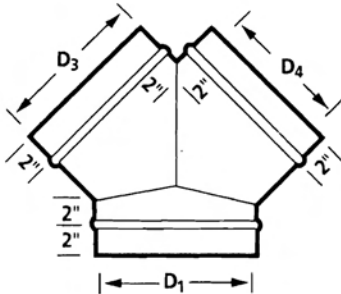


OFF
OFFSET

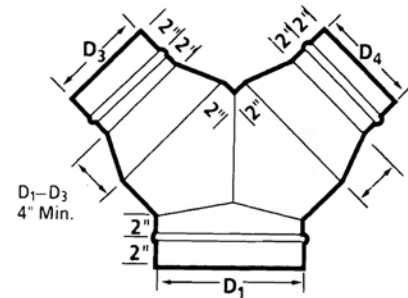


SQ - RD
SQUARE TO ROUND

X = 4" MINIMUM

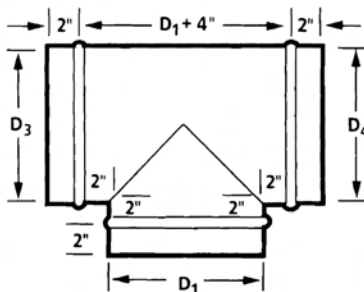


Y
Y-BRANCH



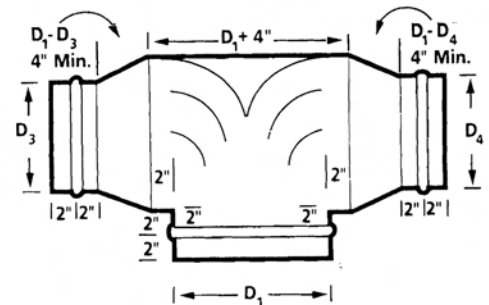
YR
REDUCING Y-BRANCH

D ₁	No. of Vanes
3-7	1
8-10	3
10-60	5
> 60	max spacing = 12"



BH
BULLHEAD TEE
WITH OR WITHOUT TURNING VANES

D ₁	No. of Vanes
3-7	1
8-10	3
10-60	5
> 60	max spacing = 12"



BH - R
REDUCING BULLHEAD TEE
WITH OR WITHOUT TURNING VANES