



AN ISO 9001: 2015 CERTIFIED COMPANY





SPIRAL DUCT CONSTRUCTION STANDARD (POSITIVE PRESSURE)										
DUCT DIAMETER					500 Pa. (2" W.G.) Positive Pressure		1000 Pa. (4" W.G.) Positive Pressure		2500 Pa. (10" W.G.) Positive Pressure	
					Spiral Seam Gauge	Longitudinal Seam Gauge	Spiral Seam Gauge	Longitudinal Seam Gauge	Spiral Seam Gauge	Longitudinal Seam Gauge
MM	INCH		INCH	MM	THICK	THICK	THICK	THICK	THICK	THICK
75	3	THRU	8	200	26(0.55)	26(0.55)	26(0.55)	26(0.55)	26(0.55)	24(0.70)
201	9	THRU	14	355	26(0.55)	26(0.55)	26(0.55)	26(0.55)	26(0.55)	24(0.70)
356	15	THRU	26	660	26(0.55)	24(0.70)	24(0.70)	22(0.80)	24(0.70)	22(0.80)
661	27	THRU	36	910	24(0.70)	22(0.80)	22(0.80)	20(1.00)	22(0.80)	20(1.00)
911	37	THRU	50	1270	22(0.80)	20(1.00)	20(1.00)	20(1.00)	20(1.00)	20(1.00)
1271	51	THRU	60	1520	20(1.00)	18(1.20)	18(1.20)	18(1.20)	18(1.20)	18(1.20)
1521	61	THRU	84	2130	18(1.20)	16(1.61)	18(1.20)	16(1.61)	18(1.20)	16(1.61)
2131	85	THRU	98	2500	18(1.20)	16(1.61)	16(1.61)	14(1.99)	16(1.40)	14(1.99)

Circular Ducts and Fittings shall have a wall thickness not less than that specified for longitudinal seam straight ducts in table.
 Corrugated Ducts are not reflected in the Table
 longitudinal Seam Ducts are continuously welded and supplied in 1 meter long.
 Above schedule meet the requirements of SMACNA HVAC Duct Construction Stds, Metals and Flexible Second Edition 1995

SPIRAL DUCT CONSTRUCTION STANDARD (NEGATIVE PRESSURE)										
DUCT DIAMETER					500 Pa. (2" W.G.) Negative Pressure		1000 Pa. (4" W.G.) Negative Pressure		2500 Pa. (10" W.G.) Negative Pressure	
					Spiral Seam Gauge	Longitudinal Seam Gauge	Spiral Seam Gauge	Longitudinal Seam Gauge	Spiral Seam Gauge	Longitudinal Seam Gauge
MM	INCH		INCH	MM	THICK	THICK	THICK	THICK	THICK	THICK
75	3	THRU	8	200	26(0.55)	26(0.55)	26(0.55)	26(0.55)	26(0.55)	24(0.70)
201	8	THRU	12	305	26(0.55)	26(0.55)	26(0.55)	24(0.70)	24(0.70)	22(0.80)
306	12	THRU	16	400	26(0.55)	24(0.70)	24(0.70)	22(0.80)	22(0.80)	20(1.00)
401	16	THRU	20	508	24(0.70)	22(0.80)	22(0.80)	20(1.00)	22(0.80)	18(1.20)
509	20	THRU	24	610	22(0.80)	20(1.00)	22(0.80)	18(1.20)	20(1.00)	16(1.61)
611	24	THRU	34	863	20(1.00)	18(1.20)	20(1.00)	16(1.61)	18(1.20)	16(1.61)
864	34	THRU	48	1219	20(1.00)	18(1.20)	18(1.20)	16(1.61)	18(1.20)	16(1.61)
1220	48	THRU	60	1524	18(1.20)	18(1.20)	18(1.20)	16(1.61)	18(1.20)	16(1.61)

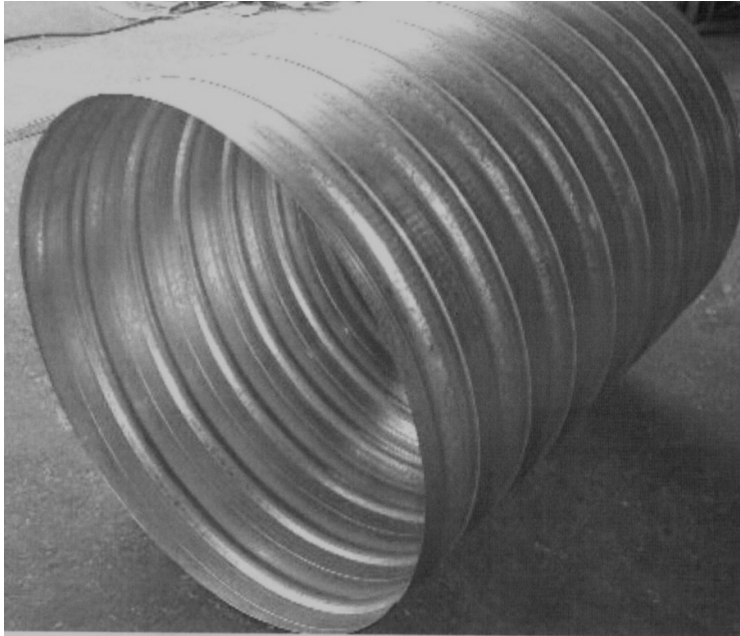
Circular Ducts and Fittings shall have a wall thickness not less than that specified for longitudinal seam straight ducts in table.
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SPIRAL DUCT



STANDARD SIZE FOR SPIRAL DUCT
100 mm Dia
150 mm Dia
200 mm Dia
250 mm Dia
300 mm Dia
355 mm Dia
400 mm Dia
450 mm Dia
500 mm Dia
560 mm Dia
600 mm Dia
650 mm Dia
710 mm Dia
750 mm Dia
800 mm Dia

SPIRAL DUCT

Designed for maximum strength to weight ratio

All round Spiral Duct and fittings shall be manufactured from G-90 galvanized steel, conforming to ASTM and SMACNA standards. Standard elbows will have 1.5 center line radius. Other radii and vaned elbows are available as needed. Elbows through 4" shall be, with stitch welded joints. Elbows 6" through 50" shall be gore-locked construction. All elbows above 51" shall also be gored, but with tack weld and sealed construction for use to 4" w.g., or solid welded for use to 10" w.g. Branch connections in medium pressure systems shall be conical for 90 degree taps, and straight for 45 degrees.

CORRUGATION DETAIL

15/1C 0.6-0.8 800

Corrugation depth 6-8mm



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SINGLE WALL ROUND DUCTS & FITTINGS

PROFILES TYPES & MATERIALS



SPIRAL DUCTS AND FITTINGS

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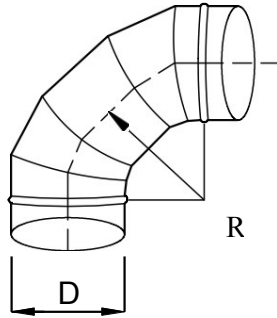




ELBOW 90°

$$R = 1.5d$$

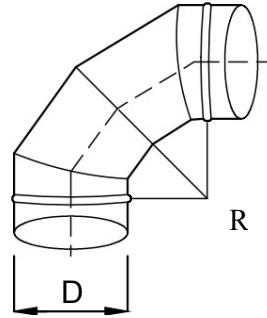
5-Gore Elbow (Segment as Standard)



TYPE - A

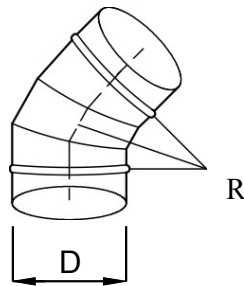
$$R = D$$

4- Gore Elbow



TYPE -B (4G)

ELBOW 45°

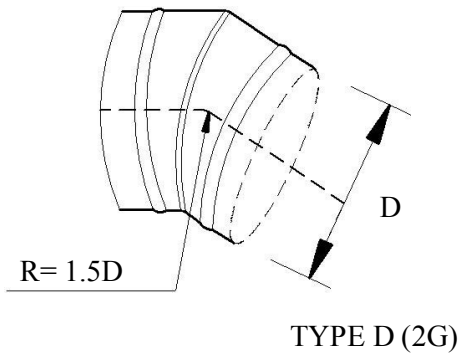


TYPE -C (3G)

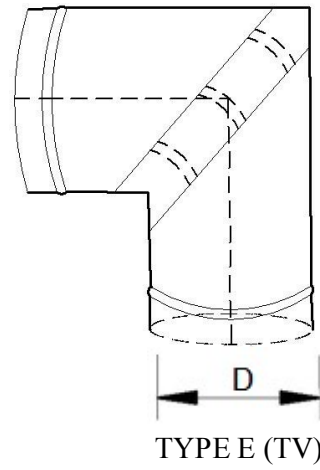
$$R = 1.5d$$

3- Gore Elbow (Segment as Standard)

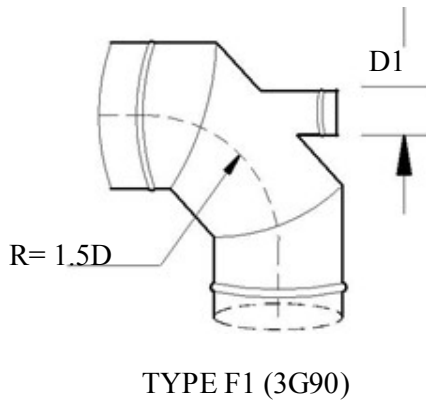
ELBOW 15°, 30°, 60°



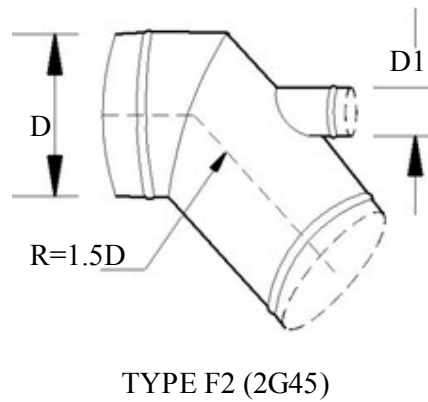
MITERED ELBOW 90° WITH TURNING VANES



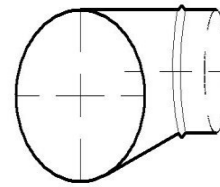
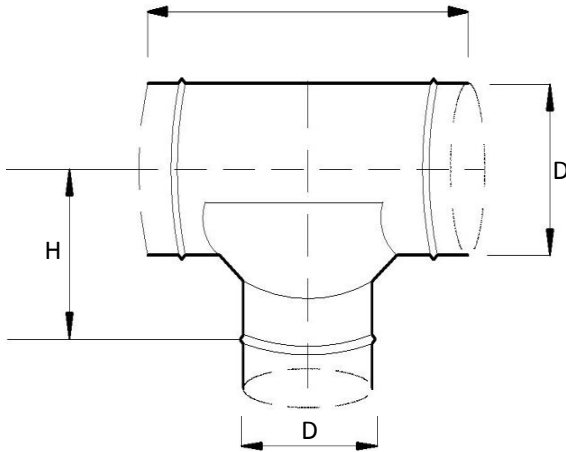
HELL TAPPED ELBOW 90°



HELL TAPPED ELBOW 45°



TEE (ECCENTRIC)



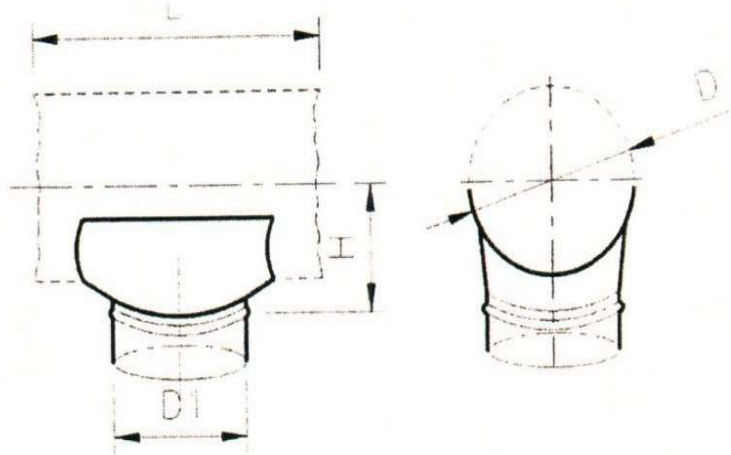
TYPE B (ECCENTRIC)

TYPE B (ECCENTRIC)

H (mm)	L (mm)	D/D1 (mm)
280	485	400/315
280	420	400/250
330	485	500/315
330	420	500/250
395	670	630/500
395	570	630/400
395	485	630/315
480	800	800/630
480	670	800/500
480	570	800/400
580	970	1000/800
580	800	1000/630
580	670	1000/500
730	1220	1250/1000
705	970	1250/800
705	800	1250/630



COLAR SADDLE



TYPE A

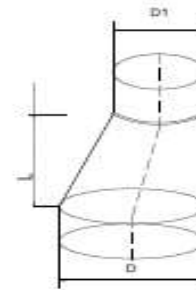
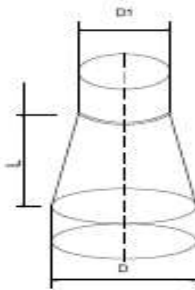
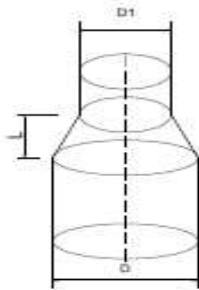
DD1 (mm)	L (mm)	H (mm)
63/63	183	110
80/63	183	120
100/63	183	130
80/80	200	120
100/80	200	130
125/80	200	140
160/80	200	160
200/80	200	180
250/80	200	205
100/100	220	130
125/100	220	140
160/100	220	160
200/100	220	180
250/100	220	205
315/100	220	237
125/125	245	140
160/125	245	160
200/125	245	180
250/125	245	205
315/125	245	237
400/125	245	280
160/160	280	160
200/160	280	180
250/160	280	205
315/160	280	237
400/160	280	280
500/160	280	330

D/D1 (mm)	L (mm)	H (mm)
355/125	245	257
355/160	280	257
355/200	320	257
500/200	320	330
630/200	320	395
250/250	370	205
315/250	370	237
355/250	370	257
400/250	370	280
500/250	370	330
630/250	370	395
800/250	370	480
315/315	435	237
355/315	435	257
400/315	435	280
500/315	435	330
630/315	435	395
800/315	435	480
1000/315	435	580
1250/315	435	705
355/355	475	257
400/355	475	280
500/355	475	330
630/355	475	395
800/355	475	480
1000/355	475	580
1250/355	475	705

DD1 (mm)	L (mm)	H (mm)
400 / 400	520	280
500 / 400	520	330
630 / 400	520	395
800 / 400	520	480
1000/400	520	580
1250/400	520	705
500 / 500	620	330
630 / 500	620	395
800 / 500	620	480
1000/500	620	580
1250/500	620	705
630 / 630	750	395
800 / 630	750	480
1 000 / 630	750	580
1250/360	750	580
800 / 800	920	480
1000/800	920	580
1250/800	920	705
1000/1000	1170	730
1250/1000	1170	730
1250/1250	1420	730



REDUCER



TYPE A (CONCENTRIC)

TYPE B (CONCENTRIC)

TYPE C (ECCENTRIC)

L (mm)	D/D1 (mm)
65	100/80
70	125/100
80	160/125
110	160/100
90	200/160
130	200/125
160	200/100
100	250/200
145	250/160
190	250/125
220	250/100
115	315/250
175	315/200
225	315/160
140	400/315
220	400/250
280	400/200
160	500/400
260	500/315
340	500/250
195	630/500
315	630/400
415	630/315
245	800/630
400	800/500
515	800/400
280	1000/800
480	1000/630
635	1000/500
340	1250/100
575	1250/800
780	1250/630

L (mm)	D/D1 (mm)
150	355/315
130	355/250
180	355/200
95	400/355
115	400/315
170	400/250
215	400/200
125	500/400
135	500/355
200	500/315
255	500/250
155	630/500
240	630/400
300	630/355
315	630/315
185	800/630
300	800/500
385	800/400
215	1000/800
475	1000/500
255	1250/100
430	1250/800
575	1250/630

L (mm)	D/D1 (mm)
18	80/63
20	100/80
31	100/63
22	125/100
35	125/80
39	160/125
43	160/100
45	160/80
32	200/160
52	200/125
65	200/100
39	250/200
61	250/160
80	250/125
96	250/100
44	315/250
72	315/200
95	315/160

