

Specifications

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MATERIAL (*) not available in pressed construction

- Galvanized steel conforming to ASTM standards A653 and A924
- Stainless steel type 304L conforming to ASTM standard A240*
- Stainless steel type 316L conforming to ASTM standard A240*
- Aluminum T3003*

SURFACE FINISH

- Galvanized steel (galvanized in accordance with latest SMACNA HVAC Duct Construction Standards).
- Stainless steel type 304L - Mill Finish
- Stainless steel type 316L - 2B Mill Finish
- Coated with an average thickness of 4 mils (0.004 inch) inside and out. Coating to meet or exceed 1,000 hour Salt Spray Test per ASTM B117-97.
 - PVC coating (duct only)
 - Epoxy coating (duct and/or fittings)
- Antimicrobial - Coating containing antimicrobial compound complies with UL standard - not to exceed flame or smoke developed ratings of 25/50 and is EPA listed.

THICKNESS

Material thickness constructed from galvanized steel in accordance with the latest SMACNA's HVAC Duct Construction Standards for +10" water gauge pressure.

CONSTRUCTION

- A. Duct is of spiral lock seam construction with a mechanically formed seam locking indentation evenly spaced along the spiral seam. All spiral duct 8" diameter and larger shall incorporate multiple corrugations between spiral seams.
- B. Fittings shall be manufactured using one or more of the following construction methods:
 - Overlapped edges stitch welded along the entire length of the fitting
 - Standing seam gore locked and internally sealed
 - Button punched and internally sealed
 - Elbows 3" through 12" diameter will be die stamped and continuously stitch welded.

CONNECTIONS

Fitting ends shall be sized to slip-fit into spiral duct of the same nominal size. Fitting to fitting connections shall be made by use of duct size "MF" couplings. Duct to duct connections require fitting size "NP" couplings.

JOINT SEALING

Fitting ends are equipped with factory installed, double-lipped, U-profile gaskets. When installed in spiral duct per manufacturer's installation instructions, the gasket creates a seal against the interior of the spiral duct. The system tightness shall be factory warranted to meet SMACNA's Leakage Class 3 performance.

If no gasket is used, all joints must be sealed by the installer during the installation process. The type of sealant used as well as the method and level of application should be as directed by the specification and in accordance with the sealant manufacturer's published installation instructions.

GASKET

The gasket shall be EPDM rubber. The gasket is located in a groove at the end of the fitting and securely fastened by means of a stainless steel band. In order to achieve optimum sealing for all diameters, different size gaskets shall be used. The gasket shall be classified by Underwriters Laboratories for flame spread and smoke developed in accordance with ASTM E84-91a. A silicone gasket meeting the same performance may be offered by duct manufacturer for special applications.

NOTE: For systems under negative pressure, please refer to the Industrial Catalog or a Linx representative.

