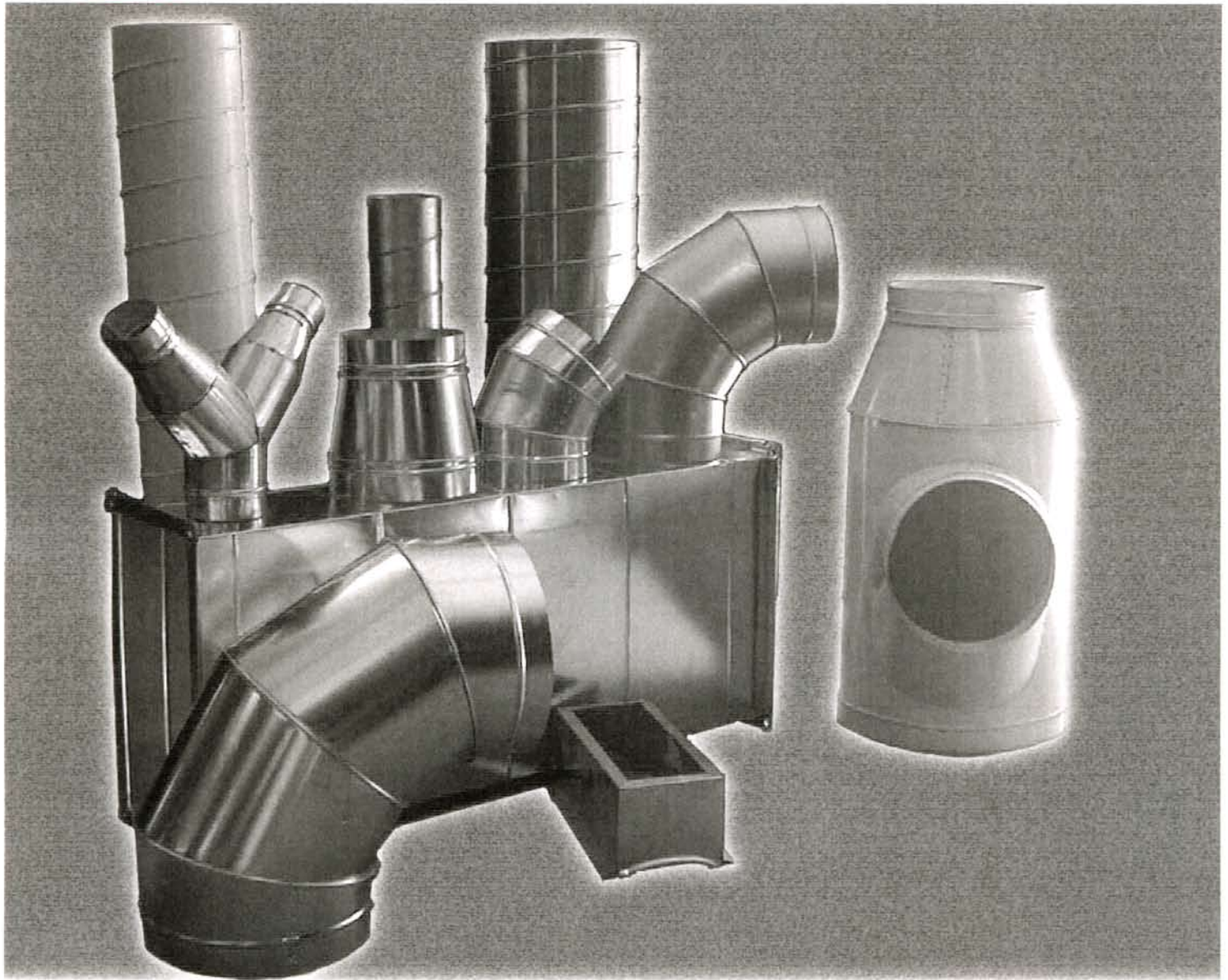




Spiral Air

MANUFACTURING INC



3 Crane Way
Hooksett, New Hampshire 03106



Phone 603-624-6647 ☎ Fax 603-624-7418 ☎ Toll Free 1-888-5SPIRAL



LOW PRESSURE GALVANIZED FITTINGS

Fittings are fabricated from hot-dipped galvanized steel in gauges that equal or exceed SMACNA standards (see table at right).

DIAMETER	FITTINGS MINIMUM GAUGE
3" THRU 14"	26
15" THRU 26"	24
28" THRU 36"	22
38" THRU 50"	20
52" THRU 60"	18

KEY TO DIMENSIONS

A - Main Inlet Diameter
B - Main Outlet Diameter
C, D - Branch Outlet Diameters
LR - Installed Length of Reducer

NOTE "A"

The barrel for a reducing tee or lateral will be made of one piece where dimensions permit. Where "C" or "D" is greater than "B" a straight barrel and reducer will be supplied.

HIGH PRESSURE FITTINGS

Fittings are made of hot-dipped galvanized steel. Joints may be solid welded or spot welded and bonded. All welded joints will be coated with a protective paint, inside and out, to prevent damage to the galvanized surface. Spot-welded fittings will have all joints sealed with a UL-Classified zero flame spread and zero smoke developed cement specially formulated for bonding metal-to-metal joints

DIAMETER	FITTINGS MINIMUM GAUGE
3" THRU 14"	22
15" THRU 36"	20
37" THRU 60"	18

AVAILABLE OPTIONS

PCD (Polyvinyl Coated Ducts)
4x1 / 4x4 / 4x1 Reveise
Stainless Steel
Aluminum
Galvneal (Paint Grip)
Dual Wall Insulated
Dust Collection
Welded Pipe
Black Iron

CONSULT FACTORY

Angle Rings
Ductmate Rings
Access Doors
Vanstone (Factory Installed Rings)
Factory Mounted Saddle Taps



Spiral Air

MANUFACTURING INC

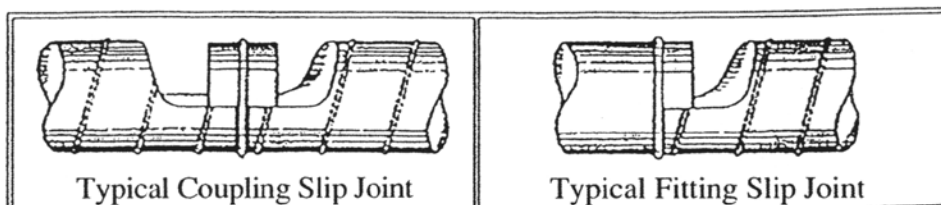
WEIGHT AND GAUGE CHART

DIAM	26 GAUGE LBS/FT	24 GAUGE LBS/FT	22 GAUGE LBS/FT	20 GAUGE LBS/FT	18 GAUGE LBS/FT
3"	.8	1.1	1.3	1.5	2.0
4"	1.1	1.4	1.7	2.0	2.6
5"	1.4	1.7	2.1	2.5	3.2
6"	1.6	2.0	2.5	3.0	3.9
7"	1.9	2.4	2.9	3.4	4.6
8"	2.1	2.8	3.3	3.9	5.2
9"	2.4	3.1	3.8	4.4	5.9
10"	2.6	3.4	4.2	4.9	6.5
11"	2.9	3.8	4.6	5.4	7.1
12"	3.2	4.1	5.0	5.9	7.8
13"	3.4	4.5	5.4	6.4	8.5
14"	3.7	4.8	5.8	6.9	9.1
15"	4.0	5.1	6.2	7.4	9.8
16"	4.3	5.5	6.6	7.8	10.4
17"	4.6	5.8	7.1	8.3	11.1
18"	4.9	6.1	7.5	8.8	11.7
19"	5.0	6.4	7.9	9.3	12.3
20"	5.2	6.8	8.3	9.8	13.0

DIAM	24 GAUGE LBS/FT	22 GAUGE LBS/FT	20 GAUGE LBS/FT	18 GAUGE LBS/FT
22"	7.5	9.1	10.8	14.3
24"	8.2	9.9	11.7	15.6
26"	8.9	10.8	12.7	16.9
28"	9.5	11.6	13.7	18.2
30"	10.2	12.4	14.6	19.5
32"	10.9	13.3	15.6	20.8
34"	11.6	14.1	16.6	22.0
36"	12.3	14.9	17.6	23.3
38"		15.7	18.5	24.6
40"		16.5	19.5	25.9
42"		17.4	20.5	27.2
44"		18.2	21.5	28.5
46"		19.0	22.5	29.8
48"		19.9	23.4	31.1
50"		20.7	24.5	32.4
52"		21.5	25.4	33.7
56"		23.1	27.3	36.3
60"		24.8	29.2	38.9

A complete line of slip-joint fittings, designed especially for use with spiral pipe, includes many types of elbows, crosses, tees, laterals, reducers and various accessories.

Spiral pipe is joined by means of couplings and sealed with duct sealer. Sheet metal screws or pop rivets are used at maximum 15" intervals, with a minimum of three fasteners per joint. These hold the fittings and joints in place while the sealant cures.



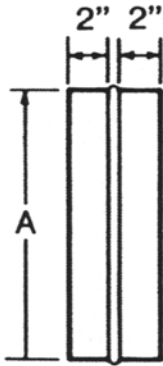
Standard SMACNA gauges (grey areas) will be supplied unless ordered otherwise. Standard lengths are 10 ft. Shorter and longer lengths can be made to order at extra cost.





Spiral Air

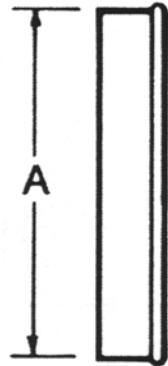
MANUFACTURING INC



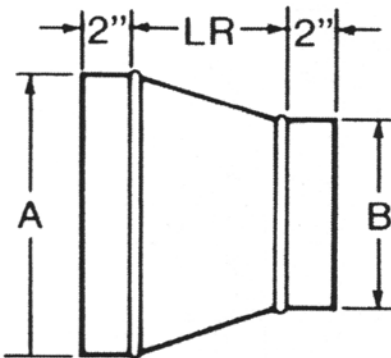
(SPC) COUPLING - MALE
FITS INTO PIPE



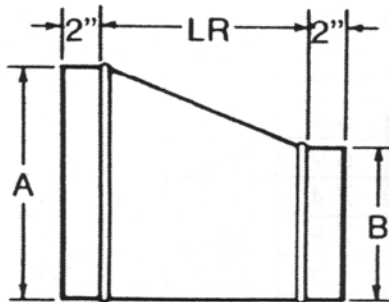
(SPCF) COUPLING - FEMALE
PIPE SIZE



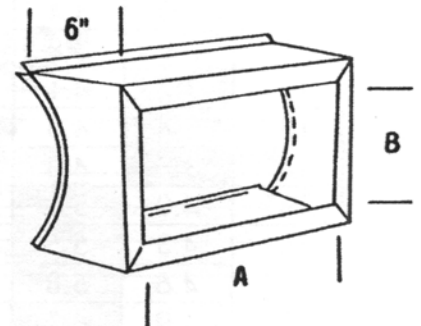
(EC) END CAP - MALE
FITS INTO PIPE



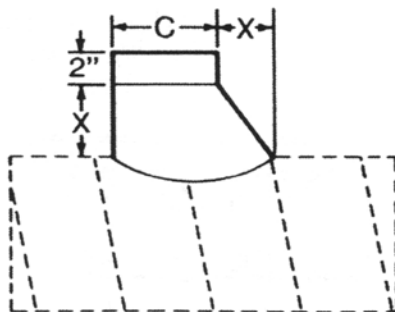
(RED) REDUCER
(CONCENTRIC)
 $LR = A - B$ (4" MIN.)



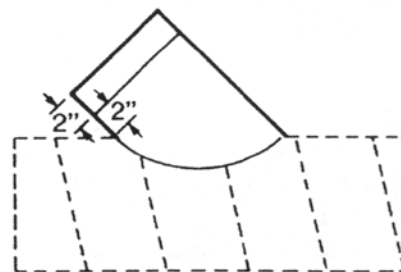
(ERED) REDUCER
(ECCENTRIC)
 $LR = A - B$ (6" MIN.)



REGISTER TAKEOFFS
ORDER TAKEOFFS BY
REGISTER SIZE ONLY
(RI / RO)



(SH 90°) SHOE TAP



(ST45) 45° LATERAL TAP





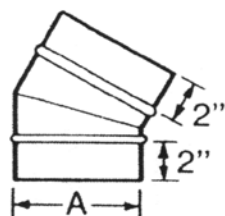
Spiral Air

MANUFACTURING INC

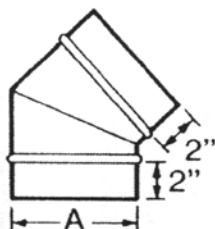
SHORT THROAT ELBOWS

C. L. RADIUS = 1A

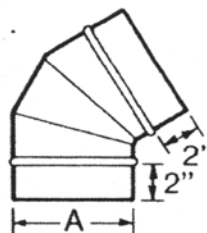
These elbows are standards for low pressure systems. Elbows with other throat radii can be ordered.



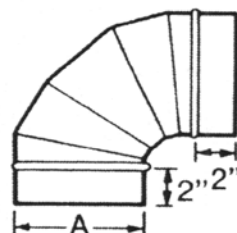
(G-30)
30° ELBOW



(G-45)
45° ELBOW



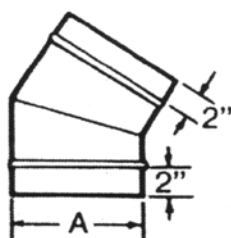
(G-60)
60° ELBOW



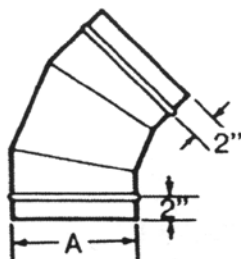
(G-90)
90° ELBOW

LONG THROAT ELBOWS

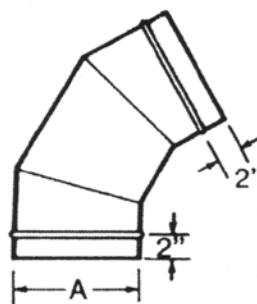
C. L. RADIUS = 1½A



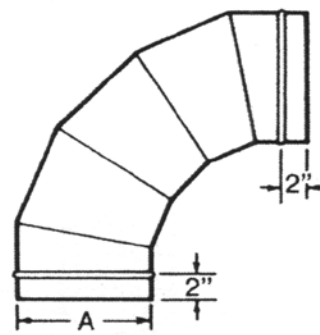
(G-30L)
30° ELBOW



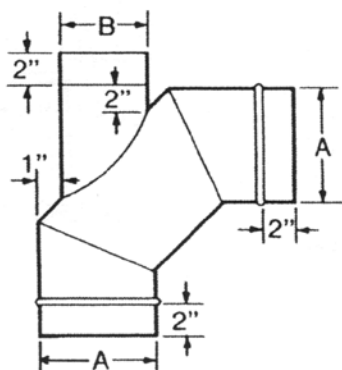
(G-45L)
45° ELBOW



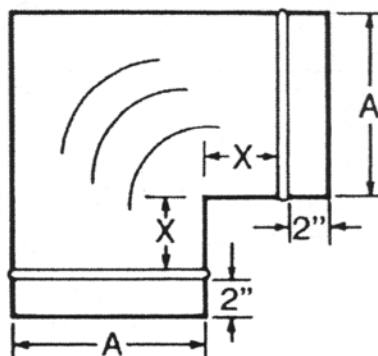
(G-60L)
60° ELBOW



(G-90L)
90° ELBOW



(G-90T)



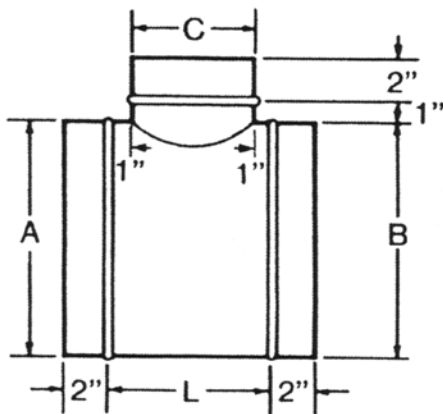
(M-90)
90° MITERED ELBOW
WITH TURNING VANES



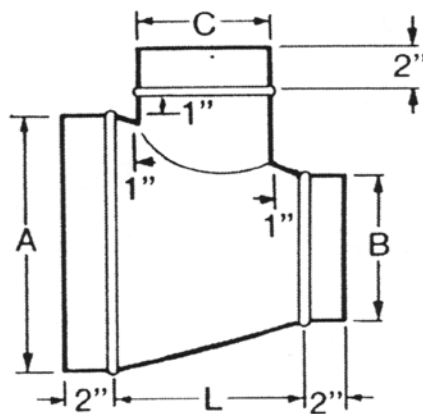


Spiral Air

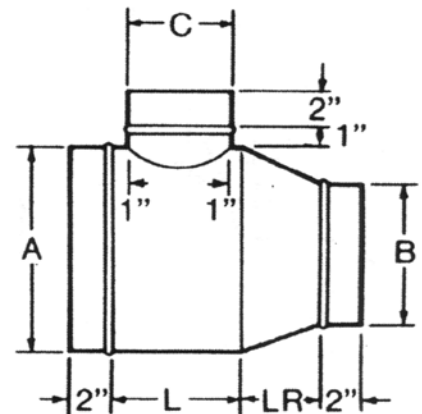
MANUFACTURING INC



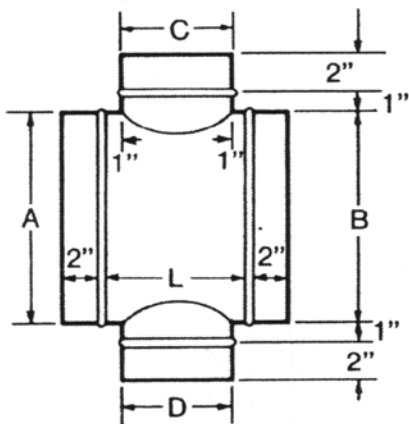
(T) 90° TEE



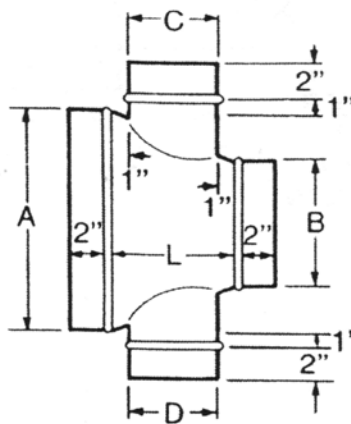
(RT) TEE
WITH REDUCING BARREL



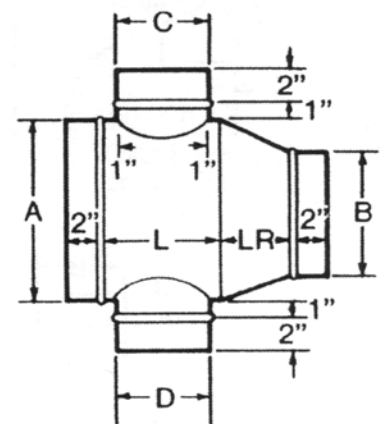
(RTR) TEE WITH REDUCER



(TT) CROSS
L = LARGEST OF "C" OR "D" PLUS 2"



(RTT) CROSS
WITH REDUCING BARREL



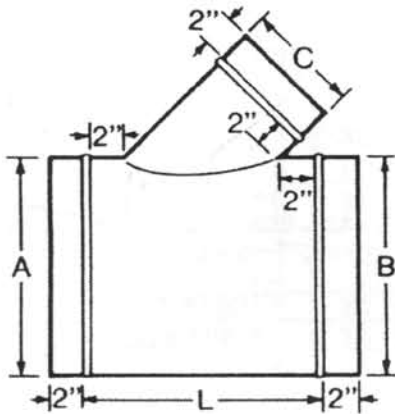
(RTTR) CROSS WITH REDUCER



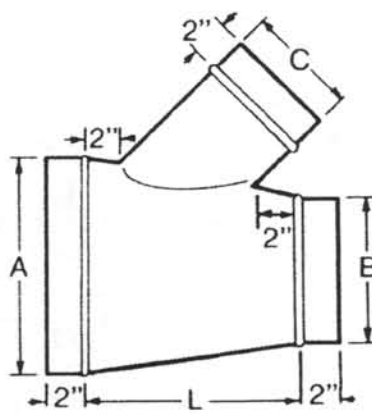


Spiral Air

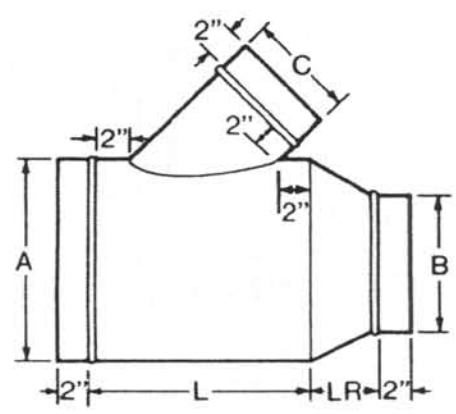
MANUFACTURING INC



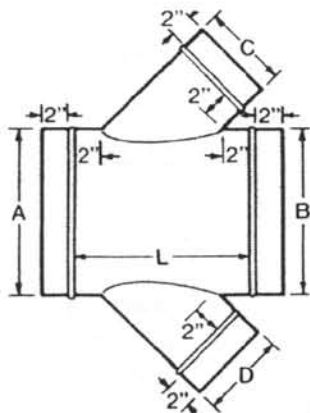
(TY) LATERAL



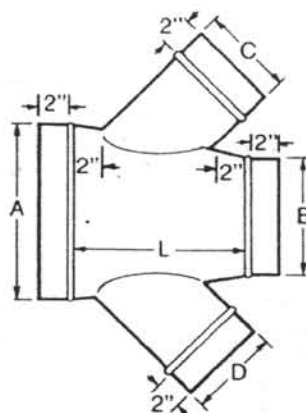
(RTY) LATERAL
WITH REDUCING BARREL



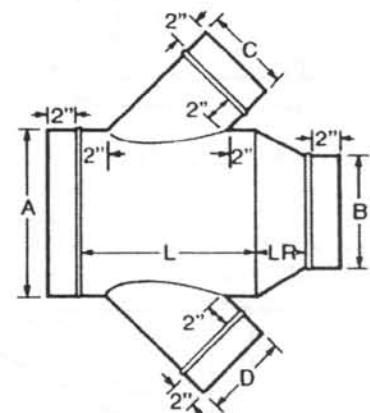
(RTYR) LATERAL
WITH REDUCER



(TTY) LATERAL CROSS



(RTTY) LATERAL CROSS
WITH REDUCING BARREL



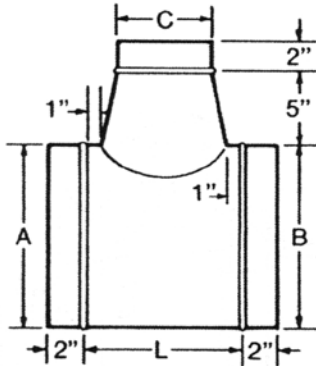
(RTTYR) LATERAL CROSS
WITH REDUCER



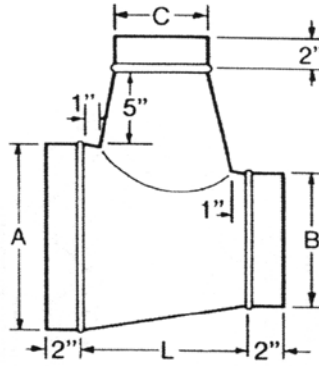


Spiral Air

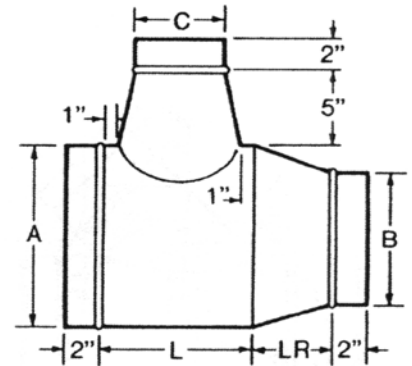
MANUFACTURING INC



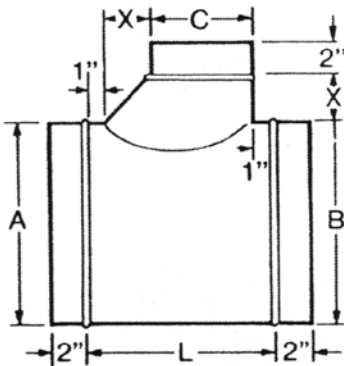
(CT) CONICAL TEE



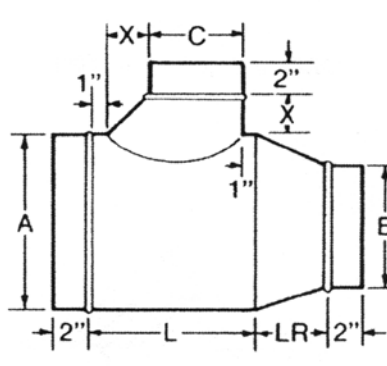
(CTR) CONICAL TEE
WITH REDUCING BARREL



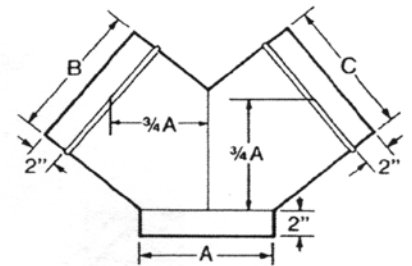
(CTRR) CONICAL TEE
WITH REDUCER



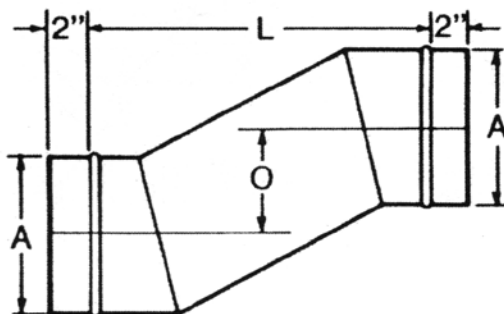
(SHT) SHOE TEE



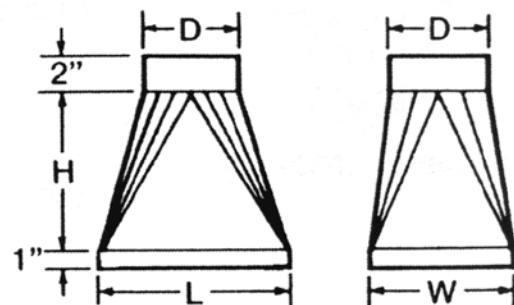
(SH&R) SHOE TEE
WITH REDUCER



(Y) - WYE



(OS) - OFFSET



(SQRD) - SQUARE-TO-ROUND TRANSITION





Spiral Air

MANUFACTURING INC

P.C.D. UNDERGROUND AND FUME EXHAUST

P.C.D. is made by coating hot-dipped galvanized steel with an epoxy primer and then applying a 4-mil polyvinyl coating to one side to make 4 x 1 P.C.D. or both sides to make 4 x 4 P.C.D.

P.C.D. SPIRAL DUCTS - WEIGHT AND GAUGE CHART

DIAM	26 GAUGE LBS/FT	24 GAUGE LBS/FT	22 GAUGE LBS/FT	20 GAUGE LBS/FT	18 GAUGE LBS/FT
4"	1.1	1.4	1.7	2.0	2.6
5"	1.4	1.7	2.1	2.5	3.2
6"	1.6	2.0	2.5	3.0	4.0
7"	1.9	2.4	2.9	3.5	4.7
8"	2.2	2.8	3.4	4.0	5.3
9"	2.5	3.1	3.8	4.5	6.0
10"	2.7	3.5	4.3	5.0	6.6
12"	3.3	4.2	5.1	6.0	7.9
14"	3.8	4.9	5.9	7.0	9.2
16"	4.4	5.6	6.7	7.9	10.5
18"	5.0	6.2	7.6	8.9	11.8
20"	5.3	7.0	8.5	10.0	13.2
22"		7.7	9.3	11.0	14.5
24"		8.4	10.1	11.9	15.8
26"		9.1	11.0	12.9	17.1

DIAM	24 GAUGE LBS/FT	22 GAUGE LBS/FT	20 GAUGE LBS/FT	18 GAUGE LBS/FT
28"	9.7	11.8	13.9	18.4
30"	10.4	12.6	14.8	19.7
32"	11.1	13.5	15.8	21.0
34"	11.9	14.4	16.9	22.3
36"	12.7	15.3	18.0	23.8
38"		16.1	18.9	25.0
40"		16.8	19.8	26.2
42"		17.7	20.8	27.5
44"		18.5	21.8	28.8
46"		19.3	22.8	30.2
48"		20.3	23.7	31.5
50"		21.1	24.9	32.8
52"		21.9	25.8	34.1
56"		23.5	27.7	36.8
60"		25.3	29.7	39.5

Standard length of duct is 10 feet.
Shorter and longer lengths can be made to order.

4 x 1 P.C.D. is used for underground systems, it has the 4-mil polyvinyl coating on the outside for protection from the soil.

4 x 1 Reverse P.C.D. has the 4-mil coating on the inside. Used for above-ground fume exhaust systems.

4 x 4 P.C.D. has the 4-mil polyvinyl coating on both sides. Used where maximum protection is wanted both inside and outside.

MINIMUM GAUGES* FOR UNDERGROUND DUCTS AND FITTINGS:

DIAMETER	GAUGE
4" THRU 8"	26 GAUGE
9" THRU 16"	24 GAUGE
18" THRU 24"	22 GAUGE
26" THRU 32"	20 GAUGE
34" THRU 60"	18 GAUGE

*Gauges equal or exceed SMACNA standards.

MINIMUM GAUGES* FOR ABOVE GROUND DUCTS AND FITTINGS:

DIAMETER	GAUGE
4" THRU 8"	26 GAUGE
16" THRU 26"	24 GAUGE
28" THRU 36"	22 GAUGE
38" THRU 50"	20 GAUGE
52" THRU 60"	18 GAUGE

TAPES AND SEALERS



P.C.D. Tape

Thick polyethylene backing. P.C.D. tape is strong, and permanent. For use above or below ground. Has superior adhesive quality even in hot or cold weather. Available in rolls 2" x 108 ft.



P.C.D. #8 Duct Sealer

For positive sealing of joints and fittings on underground or fume exhaust installations. Impervious to most corrosive atmospheres. Available in cartridges and gallon cans.



P.C.D. Touch-Up

A special formula of polyvinyl chloride for air drying for quick scratch repair. Available in aerosol spray cans and quart cans (brush on).





Spiral Air

MANUFACTURING INC

TABLE 3-2A
ROUND DUCT GAGE UNREINFORCED
POSITIVE PRESSURE

MAX. DIA.	+10" w.g.	
	Spiral Seam	Long. Seam
6"	28	28
8"	28	26
10"	28	26
12"	26	24
14"	26	24
16"	24	22
18"	24	22
19-26"	24	22
27-36"	22	20
37-50"	20	20
51-60"	18	18
61-84"	18	16

TABLE 3-3
ALUMINUM ROUND DUCT GAGE SCHEDULE

DUCT DIAMETER IN INCHES	MAXIMUM 2" W.G. STATIC POSITIVE		MAXIMUM 2" W.G. STATIC NEGATIVE	
	SPIRAL SEAM GAGE	LONGITUDINAL SEAM GAGE	SPIRAL SEAM GAGE	LONGITUDINAL SEAM GAGE
3 THRU 8	.025"	.032"	.025"	.040"
9 THRU 14	.025"	.032"	.032"	.040"
15 THRU 26	.032"	.040"	.040"	.050"
27 THRU 36	.040"	.050"	.050"	.063"
37 THRU 50	.050"	.063"	.063"	.071"
51 THRU 60	.063"	.071"	N.A.	.090"
61 THRU 84	N.A.	.090"	N.A.	N.A.

