



SPIRAL DUCT & FITTINGS



MID-ATLANTIC CHAPTER

Representing Sheet Metal and Air Conditioning Contractors
from Maryland, Virginia, Washington, D.C. and Eastern West Virginia



SHEET METAL WORKERS LOCAL 100

DC Duct & Sheet Metal LLC . **301-864-3828** . www.dcduct.com
202-575-0189

Your Local Spiral Duct & Oval Duct Connection

Office: 2520 Pennsylvania Avenue, SE · Washington, DC 20020

Shop: 3711 Wells Avenue · Mount Rainier, MD 20712



HVAC PRODUCTS - Spiral Duct & Fittings

301-864-3828

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Spiral Duct Material Options

Our products are fabricated from a variety of materials. Not all of our products are available in all materials. All duct and fittings are manufactured to SMACNA - HVAC construction standards, metal and flexible, third edition, 2005.

Some will exceed this standard.

Materials	Description
Galvanized Steel	G90 or G60 hot dipped, lock forming quality galvanized steel meeting ASTM A924 and ASTM A653
Galvaneal Steel (Paintable)	Lock-forming quality paintable galvanized steel meeting ASTM 924 and ASTM A653
Stainless Steel	Type 304 in 2B finish (Ask about additional Types and Finishes)
	Type 316 in 2B finish (Ask about additional Types and Finishes)
Aluminum	3003 H14 aluminum alloy
PVC Coated	Polyvinyl Chloride Coated Steel with 4 mil x 1mil or 4 mil x 4 mil (inside / outside) coating

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Spiral Duct Capabilities

SINGLEWALL CONSTRUCTION	AVAILABLE				GAUGES / THICKNESSES	
	MATERIALS	SIZES	SEAMS	LENGTHS	MIN.	MAX.
SPIRAL PIPE ¹	Galvanized (G60 & G90)		SPIRAL	1' - 20'	26 Ga.	14 Ga.
	Galvanized (Paintable)	4" - 72"+ Diam.		1' - 20'	24 Ga.	14 Ga.
	Stainless Steel (304 & 316)	4" - 72"+ Diam.		1' - 20'	24 Ga.	18 Ga.
	Aluminum (3003-H14)	4" - 72"+ Diam.		1' - 20'	0.024	0.071
	PVC Coated	4" - 72"+ Diam.		1' - 20'	24 Ga.	18 Ga.
LONGITUDINAL SEAM PIPE ²	Galvanized (G60 & G90)	6" - 72"+ Diam.	SWB OR SWL	1' - 5'	20 Ga.	10 Ga.
	Galvanized (Paintable)	6" - 72"+ Diam.		1' - 5'	20 Ga.	10 Ga.
	Stainless Steel (304 & 316)	6" - 72"+ Diam.		1' - 4'	20 Ga.	10 Ga.
	Aluminum (3003-H14)	6" - 72"+ Diam.		1' - 4'	0.040	0.125
FITTINGS	Galvanized (G60 & G90)	4" - 72"+ Diam.			24 Ga.	10 Ga.
	Galvanized (Paintable)	4" - 72"+ Diam.	SPS, SWB OR SWL		24 Ga.	10 Ga.
	Stainless Steel (304 & 316)	4" - 72"+ Diam.	SPS, SWB OR SWL		24 Ga.	10 Ga.
	Aluminum (3003-H14)	4" - 72"+ Diam.	SPS, SWB OR SWL		0.032	0.125
	PVC Coated	4" - 72"+ Diam.	RV, SC		24 Ga.	18 Ga.

1. Spiral Pipe is available in lengths exceeding 20' by special order.
2. Minimum Gauges / Thicknesses vary by Seam Type. Not all Seams can be fabricated in all gauges.

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Double Wall Round Spiral Duct Insulated

DOUBLEWALL (DW) & LINED CONSTRUCTION	OUTER SHELL MATERIALS (DW) AND LINED	INNER LINER MATERIALS (DW ONLY)	SEAMS	WALL THICKNESS	INSULATION / LINER
SPIRAL PIPE ¹ LONGITUDINAL SEAM PIPE AND FITTINGS	Galvanized (G60 & G90)	1. Perforated Galvanized Steel with 3/32" holes on 3/16" centers. 2. Solid Liner available in materials equal to OUTER SHELL	Outer Shell Seams equal to Singlewall. Inner liner Seams - Spiral for Pipe, Gore-locked for fittings.	1", 2" & 3" (DW) 1" & 1.5" (LINED)	1", 2" & 3" X 0.75 PCF UNFACED JOHNS MANVILLE SPIRACOUSTIC AND SPIRACOUSTIC PLUS (LINED)
	Galvanized (Paintable)				
	Stainless Steel (304 & 316)				
	Aluminum (3003-H14)				
	PVC Coated				

Oval duct is fabricated from spiral duct and the major and minor dimensions of the oval are limited to current spiral ovalizer machines on the market today.

(See next page)

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Spiral Duct Capabilities

ITEM

GALVANIZED

Spiral Pipe 1

Longseam Pipe 2,3

Spot./Tack Welded

Figs Fully Welded

26 Gauge		24 Gauge		22 Gauge		20 Gauge		18 Gauge		16 Gauge		14 Gauge		12 Gauge		10 Gauge	
Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.
4"	48"	4"	70"	4"	84"	4"	60"	4"	120"								
6"	14"	6"	26"	6"	36"	6"	50"	6"	60"								
4"	14"	4"	26"	4"	36"	4"	50"	4"	60"								
				4"	36"	4"	50"	4"	60"								

STAINLESS STEEL

Spiral Pipe 1

Longseam Pipe 2,3

Spot./Tack Welded Figs

Fully Welded Fittings

26 Gauge		24 Gauge		22 Gauge		20 Gauge		18 Gauge		16 Gauge		14 Gauge		12 Gauge		10 Gauge	
Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.
		4"	70"	4"	84"	4"	60"	12"	120"								
C	C	6"	26"	6"	36"	6"	50"	6"	120"								
C	C	4"	26"	4"	36"	4"	50"	6"	120"								
				4"	36"	4"	50"	6"	120"								

GALVANEAL

Spiral Pipe 1

Longseam Pipe

Spot./Tack Welded Figs

Fully Welded Fittings

26 Gauge		24 Gauge		22 Gauge		20 Gauge		18 Gauge		16 Gauge		14 Gauge		12 Gauge		10 Gauge	
Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.
		4"	70"	4"	84"	4"	60"	4"	120"								
		6"	26"	6"	36"	6"	50"	6"	60"								
		4"	26"	4"	36"	4"	50"	4"	60"								
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Spiral Duct Capabilities

PVC COATED

Spiral Pipe ¹
Longseam Pipe ^{4,5}
Fittings ^{4,5}
Fully Welded Fittings

26 Gauge		24 Gauge		22 Gauge		20 Gauge		18 Gauge		16 Gauge		14 Gauge		12 Gauge		10 Gauge	
Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.
		4"	36"	4"	50"	4"	60"	4"	120"								
		6"	26"	6"	36"	6"	50"	6"	120"								
		4"	26"	4"	36"	4"	50"	4"	120"								

ALUMINUM

Spiral Pipe ¹
Longseam Pipe
Spout /Tack Welded Figs
Fully Welded Fittings

0.024/22 Ga.		0.032/20 Ga.		0.04/18 Ga.		0.05/16 Ga.		0.063/14 Ga.		0.071/13 Ga.		0.09/11 Ga.	
Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.	Min. Dia.	Max. Dia.
4"	48"	4"	70"	4"	84"								
6"	14"	6"	26"	6"	36"								
4"	14"	4"	26"	4"	36"								

C = Custom Product, please contact our Sales Department

NOTES

1. Spiral available in even and odd sizes through 30" and even sizes from 4" through 120"
2. Smaller diameters may be available as tubing
3. Larger sizes available on special order. Please call.
4. Longseam pipe and fittings fabricated from PVC material will be riveted, screwed or standing construction.
5. PVC Fittings may also be coated after fabrication

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WEIGHT TABLE - GALVANIZED STEEL lbs/ft

TRIPLE RIB DUCT				TUBE DIA. INCH	HELIX SMOOTH DUCT				
STRIP WIDTH					STRIP WIDTH				
6.024"	5.827"				5.394"			5.5"	
153 mm	148mm				137 mm			140mm	
	STRIP THICKNESS				STRIP THICKNESS				
30Ga	28Ga	25Ga	24Ga		26Ga	24Ga	22Ga	20Ga	18Ga
0.015"	0.017"	0.019"	0.025"		0.019"	0.025"	0.031"	0.038"	0.050"
1.66	1.81	2.03	2.67	8	1.88	2.47	3.06	3.75	5.06
1.86	2.04	2.28	3.00	9	2.11	2.78	3.45	4.23	5.69
2.07	2.27	2.54	3.34	10	2.35	3.09	3.83	4.70	6.32
2.48	2.72	3.05	4.00	12	2.82	3.71	4.60	5.64	7.58
2.89	3.17	3.55	4.67	14	3.28	4.32	5.36	6.57	8.85
3.31	3.62	4.06	5.34	16	3.75	4.94	6.12	7.51	10.11
3.72	4.08	4.56	6.00	18	4.22	5.56	6.89	8.45	11.38
4.14	4.54	5.07	6.68	20	4.70	6.18	7.66	9.40	12.64
4.56	.5.00	5.58	7.35	22	6.17	6.80	8.43	10.34	13.90
4.96	.5.44	6.08	8.00	24	6.63	7.41	9.19	11.26	15.17
5.38	.5.90	6.59	8.67	26	6.10	8.03	9.96	12.21	16.43
5.78	6.34	7.09	9.33	28	6.57	8.64	10.71	13.13	17.70
6.20	6.80	7.60	10.00	30	7.04	9.26	11.48	14.08	18.96
6.62	7.26	8.11	10.67	32	7.51	9.38	12.25	15.02	20.22
7.45	8.17	9.13	12.01	36	8.45	11.12	13.79	16.90	22.75
8.27	9.07	10.14	13.34	40	9.39	12.35	15.31	18.77	26.28
9.10	9.98	11.15	14.67	44	10.32	13.58	16.84	20.64	27.80
9.93	10.89	12.17	16.01	48	11.26	14.82	18.38	22.53	30.34
10.76	11.80	13.18	17.35	52	12.21	16.06	19.91	24.41	32.86
11.58	12.70	14.20	18.68	56	13.14	17.29	21.44	26.28	35.39
12.40	13.60	15.20	20.00	60	14.08	18.52	22.96	28.15	37.92
13.24	14.52	16.22	21.35	64	15.02	19.76	24.50	30.04	40.45
14.07	15.42	17.24	22.68	68	15.96	21.00	26.04	31.92	42.98
14.89	16.33	18.25	24.00	72	16.89	22.23	27.56	33.79	45.50
15.72	17.23	19.26	25.34	76	17.83	23.46	29.10	35.66	48.03
16.55	18.14	20.28	26.68	80	18.77	24.70	30.63	37.54	50.56

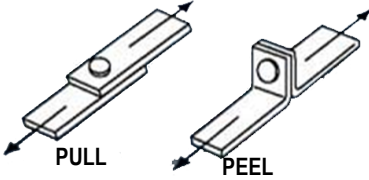
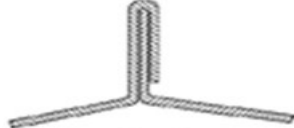


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Spiral Seams

SPIRAL  <u>SPIRAL LOCK SEAM</u> SMACNA RL-1	SPS  <u>OFFSET LAPPED, SPOT WELDED & SEALED</u> SMACNA RL-2 <u>LAPPED, SPOT WELDED & SEALED</u> SMACNA RL-3	
SWB  <u>SOLID BUTT WELD</u> SMACNA RL-4 20 GA, MIN	SWL  <u>SOLID WELDED LAPPED</u> SMACNA RL-4 20 GA, MIN	ST  <u>STITCH WELD</u>
SC  <u>SCREWED & SEALED</u>	 <u>CLINCHED SEAM (NORLOCKED)</u>	 <u>STANDING SEAM</u>

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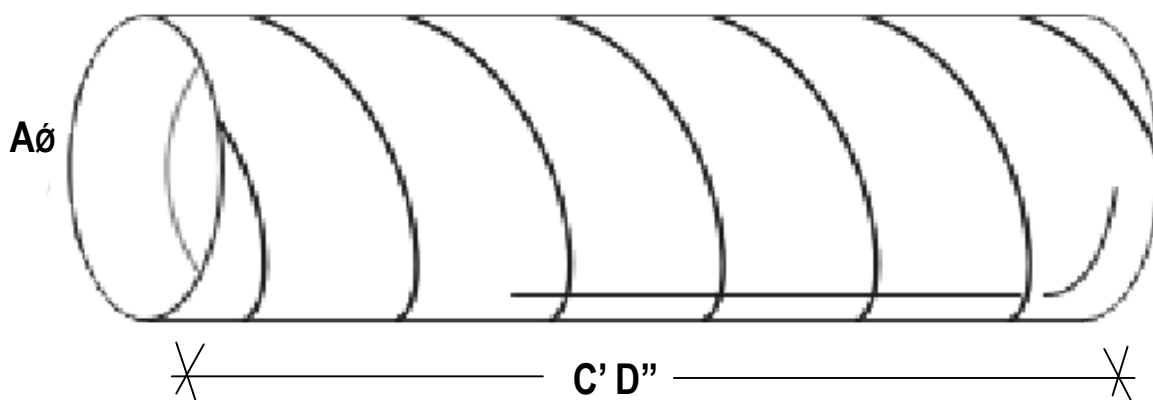
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Singlewall Spiral Duct

SPR



SPR



STANDARD (SMOOTH)

SPR2



2-CORR

WE CORRUGATE ALL DUCT LARGER THAN 13 inches ...

We will continue to do so unless we are instructed otherwise! We had the occasion when the corrugation was not wanted. This was when the spiral duct was going in a open ceiling and changed from corrugated to non-corrugated per our customer who made the request. There may be other reasons we are not aware of since we are not installers of any HVAC products.

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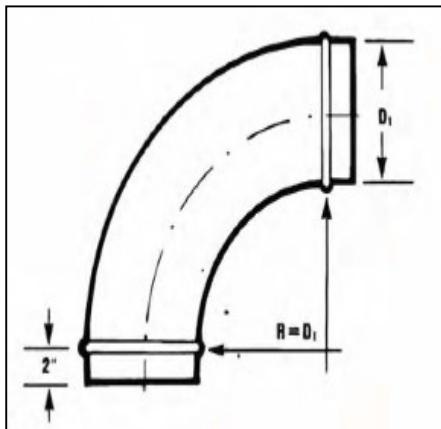
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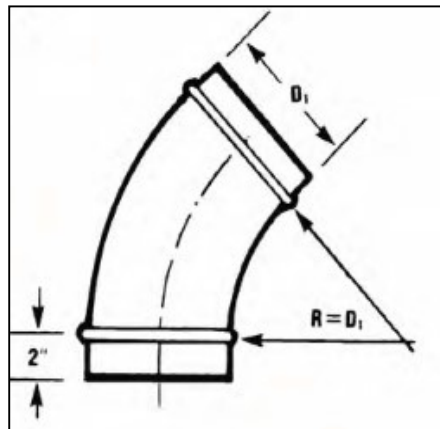
Fittings

SIZES 3" Ø THRU 12"

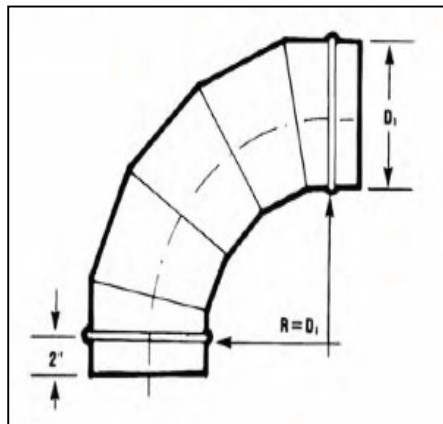


DC - 90
90° DIE STAMPED ELBOW
 $R = 1.5 \times D$

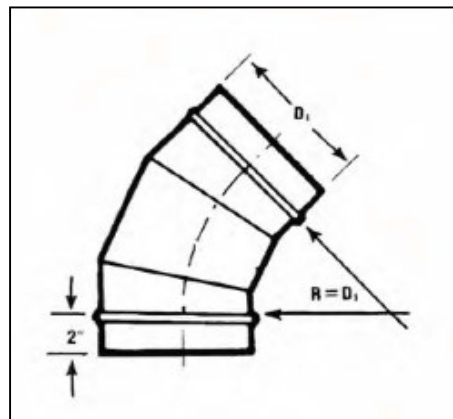
SIZES 3" Ø THRU 12"



DC - 45
45° DIE STAMPED ELBOW
 $R = 1.5 \times D$



DC - 90
90° GORE LOCKED ELBOW
 $R = 1.5 \times D$



DC - 45
45° GORE LOCKED ELBOW
 $R = 1.5 \times D$

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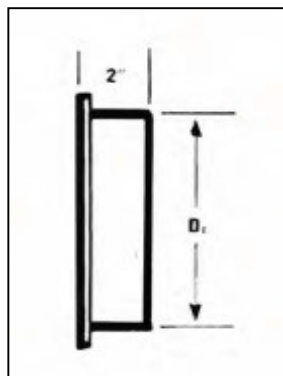
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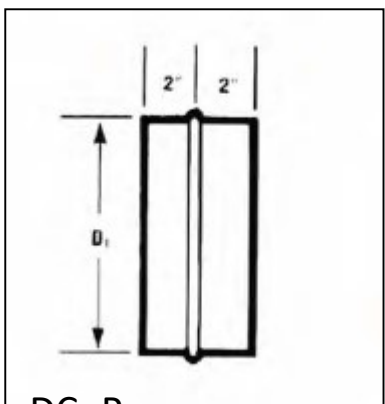
Fittings



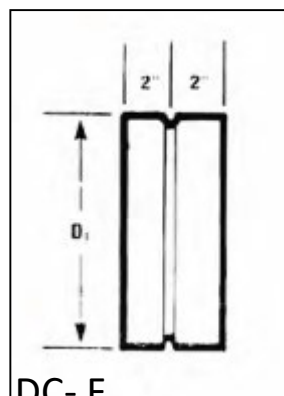
DC- P
END CAP
FOR PIPE

OR

DC- F
END CAP
FOR FITTING



DC- P
COUPLING FOR PIPE



DC- F
COUPLING FOR FITTINGS

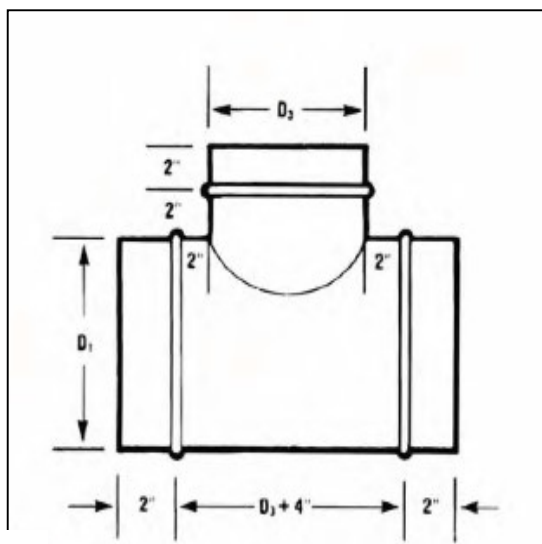
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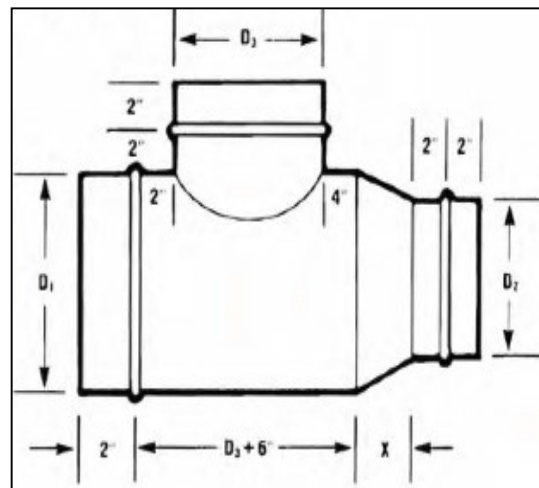
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Fittings



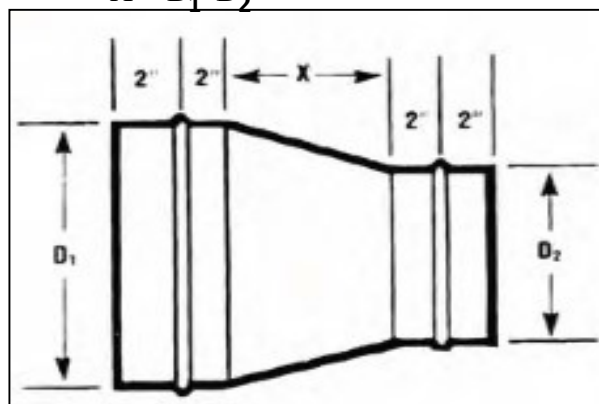
DCT - 90
 90° TEE

$X = 4''$ MINIMUM



DCT - 90 RT
 90° REDUCER TEE

$X = D_1 - D_2$



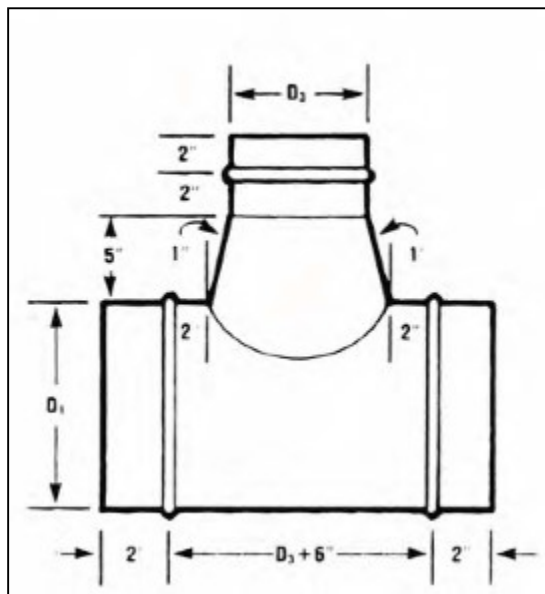
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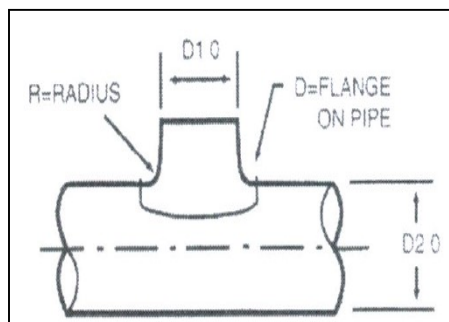


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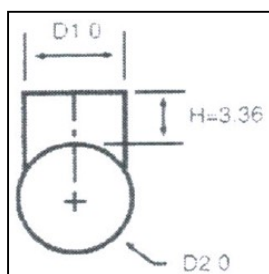
Fittings



DCCT - 90
 90° CONICAL TEE



DC - TAP
 45° OR 90° TAP



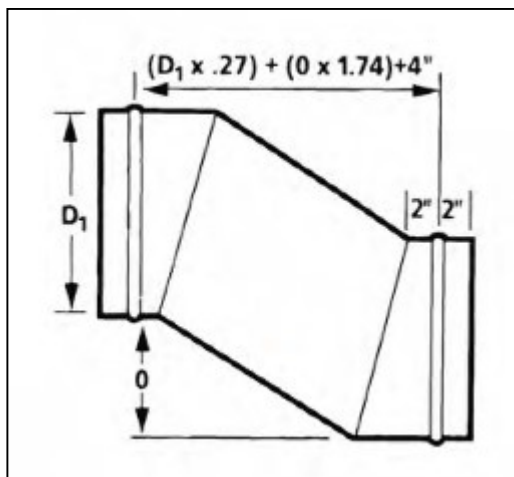
DCCT - TAP
 90° SADDLE TAP

SHOP OR FIELD INSTALLED

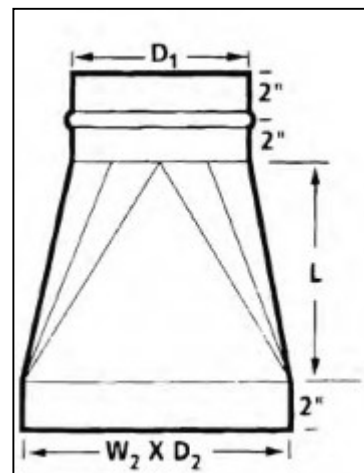
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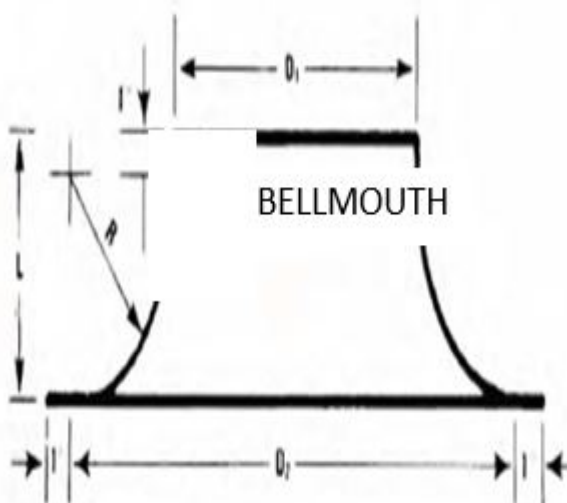
Fittings



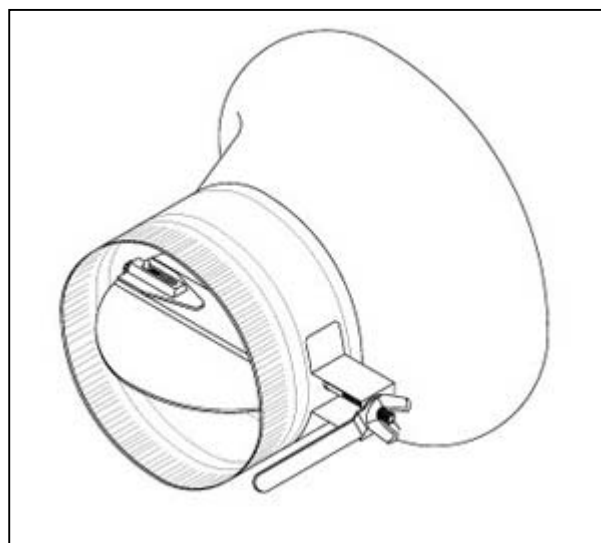
OFF
OFFSET



SQ 2RD
SQUARE TO ROUND



DC - BELLMO
BELLMOUTH



DC - BELLMOUTH
EXTENDED BELLMOUTH
With or Without Damper Available

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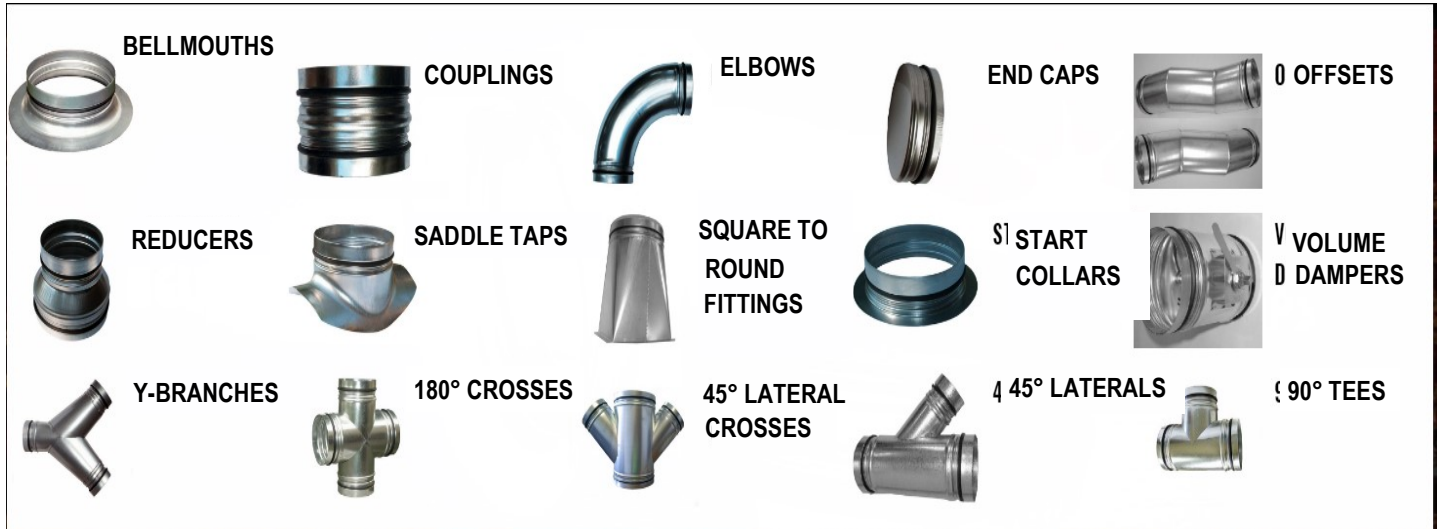
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SPIRAmir®

gasketed fittings



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