

**SECTION 233113  
METAL DUCTS****PART 1 GENERAL****1.01 RELATED DOCUMENTS**

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

**1.02 SUMMARY**

- A. Section Includes:
  - 1. Single-wall rectangular ducts and fittings.
  - 2. Double-wall rectangular ducts and fittings.
  - 3. Single-wall round ducts and fittings.
  - 4. Double-wall round ducts and fittings.
  - 5. Sheet metal materials.
  - 6. Duct liner.
  - 7. Sealants and gaskets.
  - 8. Hangers and supports.
- B. Related Sections:
  - 1. Division 23 Section "Air Duct Accessories" for dampers, sound-control devices, duct-mounting access doors and panels, turning vanes, and flexible ducts.

**1.03 PERFORMANCE REQUIREMENTS**

- A. Delegated Duct Design: Duct construction, including sheet metal thicknesses, seam and joint construction, reinforcements, and hangers and supports, shall comply with SMACNA's "HVAC Duct Construction Standards - Metal and Flexible" and performance requirements and design criteria indicated in "Duct Schedule" Article.
- B. Structural Performance: Duct hangers and supports shall withstand the effects of gravity loads and stresses within limits and under conditions described in SMACNA's "HVAC Duct Construction Standards - Metal and Flexible"
- C. Airstream Surfaces: Surfaces in contact with the airstream shall comply with requirements in ASHRAE 62.1-2004.

**1.04 SUBMITTALS**

- A. Shop Drawings:
  - 1. Fabrication, assembly, and installation, including plans, elevations, sections, components, and attachments to other work.
  - 2. Factory- and shop-fabricated ducts and fittings.
  - 3. 3 D duct layout indicating sizes, configuration, liner material, and static-pressure classes.
  - 4. Elevation of top of ducts.
  - 5. Dimensions of main duct runs from building grid lines.
  - 6. Fittings.
  - 7. Reinforcement and spacing.
  - 8. Seam and joint construction.
  - 9. Penetrations through fire-rated and other partitions.
  - 10. Equipment installation based on equipment being used on Project.
  - 11. Locations for duct accessories, including dampers, turning vanes, and access doors and panels.
  - 12. Hangers and supports, including methods for duct and building attachment and vibration isolation.
- B. Delegated-Design Submittal:
  - 1. Sheet metal thicknesses.
  - 2. Joint and seam construction and sealing.
  - 3. Reinforcement details and spacing.

- 4. Materials, fabrication, assembly, and spacing of hangers and supports.
- C. Fabrication and installation will not be permitted until drawings have been submitted and approved.

### **1.05 QUALITY ASSURANCE**

- A. ASHRAE Compliance: Applicable requirements in ASHRAE 62.1-2010, Section 5 - "Systems and Equipment" and Section 7 - "Construction and System Start-Up."
- B. ASHRAE/IESNA Compliance: Applicable requirements in ASHRAE/IESNA 90.1-2010, Section 6.4.4 - "HVAC System Construction and Insulation."

## **PART 2 PRODUCTS**

### **2.01 SINGLE-WALL RECTANGULAR DUCTS AND FITTINGS**

- A. General Fabrication Requirements: Comply with SMACNA's "HVAC Duct Construction Standards - Metal and Flexible" based on indicated static-pressure class unless otherwise indicated.
- B. Transverse Joints: Select joint types and fabricate according to SMACNA's "HVAC Duct Construction Standards - Metal and Flexible - Transverse (Girth) Joints," for static-pressure class, applicable sealing requirements, materials involved, duct-support intervals, and other provisions in SMACNA's "HVAC Duct Construction Standards - Metal and Flexible."
- C. Longitudinal Seams: Select seam types and fabricate according to SMACNA's "HVAC Duct Construction Standards - Metal and Flexible - Longitudinal Seams - Rectangular Ducts," for static-pressure class, applicable sealing requirements, materials involved, duct-support intervals, and other provisions in SMACNA's "HVAC Duct Construction Standards - Metal and Flexible."
- D. Elbows, Transitions, Offsets, Branch Connections, and Other Duct Construction: Select types and fabricate according to SMACNA's "HVAC Duct Construction Standards - Metal and Flexible," - "Fittings and Other Construction," for static-pressure class, applicable sealing requirements, materials involved, duct-support intervals, and other provisions in SMACNA's "HVAC Duct Construction Standards - Metal and Flexible."

### **2.02 DOUBLE-WALL RECTANGULAR DUCTS AND FITTINGS**

- A. Manufacturers: Subject to compliance with requirements, provide products by one of the following:
  - 1. McGill AirFlow LLC.
  - 2. Sheet Metal Connectors, Inc.
- B. Rectangular Ducts: Fabricate ducts with indicated dimensions for the inner duct.
- C. Outer Duct:
  - 1. Factory Metal-Phosphatized "Paint Grip" exterior ready for field painting.
  - 2. Gauge and Construction: Comply with SMACNA's "HVAC Duct Construction Standards - Metal and Flexible" based on indicated static-pressure class.
- D. Transverse Joints: Select joint types and fabricate according to SMACNA's "HVAC Duct Construction Standards - Metal and Flexible - Transverse (Girth) Joints", for static-pressure class, applicable sealing requirements, materials involved, duct-support intervals, and other provisions in SMACNA's "HVAC Duct Construction Standards - Metal and Flexible."
- E. Longitudinal Seams: Select seam types and fabricate according to SMACNA's "HVAC Duct Construction Standards - Metal and Flexible - Longitudinal Seams - Rectangular Ducts", for static-pressure class, applicable sealing requirements, materials involved, duct-support intervals, and other provisions in SMACNA's "HVAC Duct Construction Standards - Metal and Flexible."
- F. Interstitial Insulation: Polystyrene foam board, expanding foam injected, closed cell flexible elastomeric, or acrylic coated (IAQ type) cellular glass complying with ASTM C 1071, NFPA 90A, or NFPA 90B; and with NAIMA AH124
  - 1. Maximum Thermal Conductivity: 0.27 Btu x in./h x sq. ft. x deg F at 75 deg F mean temperature.

2. Install spacers that position the inner duct at uniform distance from outer duct without compressing insulation.
  3. Thickness: 2 inches
  4. Density (if applicable): 3lb
- G. Inner Duct: Minimum 0.028-inch perforated steel sheet.
- H. Formed-on Transverse Joints (Flanges): Select joint types and fabricate according to SMACNA's "HVAC Duct Construction Standards - Metal and Flexible - Traverse (Girth) Joints", for static-pressure class, applicable sealing requirements, materials involved, duct-support intervals, and other provisions in SMACNA's "HVAC Duct Construction Standards - Metal and Flexible."
- I. Longitudinal Seams: Select seam types and fabricate according to SMACNA's "HVAC Duct Construction Standards - Metal and Flexible - Longitudinal Seams - Rectangular Ducts," for static-pressure class, applicable sealing requirements, materials involved, duct-support intervals, and other provisions in SMACNA's "HVAC Duct Construction Standards - Metal and Flexible."

### 2.03 SINGLE-WALL ROUND DUCTS AND FITTINGS

- A. General Fabrication Requirements: Comply with SMACNA's "HVAC Duct Construction Standards - Metal and Flexible, Round, Oval, and Flexible Duct," based on indicated static-pressure class unless otherwise indicated.
1. Manufacturers: Subject to compliance with requirements, provide products by one of the following:
    - a. Lindab Inc.
    - b. McGill AirFlow LLC.
    - c. SEMCO Incorporated.
    - d. Sheet Metal Connectors, Inc.
    - e. Spiral Manufacturing Co., Inc.
- B. Transverse Joints: Select joint types and fabricate according to SMACNA's "HVAC Duct Construction Standards - Metal and Flexible, Transverse Joints - Round Duct," for static-pressure class, applicable sealing requirements, materials involved, duct-support intervals, and other provisions in SMACNA's "HVAC Duct Construction Standards - Metal and Flexible."
- C. Longitudinal Seams: Select seam types and fabricate according to SMACNA's "HVAC Duct Construction Standards - Metal and Flexible, Seams - Round Duct and Fittings," for static-pressure class, applicable sealing requirements, materials involved, duct-support intervals, and other provisions in SMACNA's "HVAC Duct Construction Standards - Metal and Flexible."
- D. Tees and Laterals: Select types and fabricate according to SMACNA's "HVAC Duct Construction Standards - Metal and Flexible, 90 Degree Tees and Laterals," and "Conical Tees," for static-pressure class, applicable sealing requirements, materials involved, duct-support intervals, and other provisions in SMACNA's "HVAC Duct Construction Standards - Metal and Flexible."

### 2.04 SHEET METAL MATERIALS

- A. General Material Requirements: Comply with SMACNA's "HVAC Duct Construction Standards - Metal and Flexible" for acceptable materials, material thicknesses, and duct construction methods unless otherwise indicated. Sheet metal materials shall be free of pitting, seam marks, roller marks, stains, discolorations, and other imperfections.
- B. Galvanized Sheet Steel: Comply with ASTM A 653/A 653M.
1. Galvanized Coating Designation: G60.
- C. Aluminum Sheets: Comply with ASTM B 209 Alloy 3003, H14 temper; with mill finish for concealed ducts, and standard, one-side bright finish for duct surfaces exposed to view.
- D. Reinforcement Shapes and Plates: ASTM A 36/A 36M, steel plates, shapes, and bars; black and galvanized.
1. Where black and galvanized steel shapes and plates are used to reinforce aluminum ducts, isolate the different metals with butyl rubber, neoprene, or EPDM gasket materials.

- E. Tie Rods: Galvanized steel, 1/4-inch minimum diameter for lengths 36 inches or less; 3/8-inch minimum diameter for lengths longer than 36 inches.
- F. Where installation will be exposed to view in occupied areas: Factory Metal-Phosphatized "Paint Grip" exterior ready for field painting.

## 2.05 DUCT LINER

- A. Flexible Elastomeric Duct Liner: Factory installed, Preformed, cellular, closed-cell, sheet materials complying with ASTM C 534, Type II, Grade 1; and with NFPA 90A or NFPA 90B.
  - 1. Manufacturers: Subject to compliance with requirements, provide products by one of the following:
    - a. Aeroflex USA Inc.
    - b. Armacell LLC.
    - c. Rubatex International, LLC
  - 2. Surface-Burning Characteristics: Maximum flame-spread index of 25 and maximum smoke-developed index of 50 when tested according to UL 723; certified by an NRTL.
  - 3. Liner Adhesive: As recommended by insulation manufacturer and complying with NFPA 90A or NFPA 90B.
    - a. For indoor applications, use adhesive that has a VOC content of 50 g/L or less when calculated according to 40 CFR 59, Subpart D (EPA Method 24).
- B. Insulation Pins and Washers:
  - 1. Cupped-Head, Capacitor-Discharge-Weld Pins: Copper- or zinc-coated steel pin, fully annealed for capacitor-discharge welding, 0.106-inch- diameter shank, length to suit depth of insulation indicated with integral 1-1/2-inch galvanized carbon-steel washer.
  - 2. Insulation-Retaining Washers: Self-locking washers formed from 0.016-inch- thick galvanized steel; with beveled edge sized as required to hold insulation securely in place but not less than 1-1/2 inches in diameter.
- C. Shop Application of Duct Liner: Comply with SMACNA's "HVAC Duct Construction Standards - Metal and Flexible," Figure 2-19, "Flexible Duct Liner Installation."
  - 1. Adhere a single layer of indicated thickness of duct liner with at least 90 percent adhesive coverage at liner contact surface area. Attaining indicated thickness with multiple layers of duct liner is prohibited.
  - 2. Apply adhesive to transverse edges of liner facing upstream that do not receive metal nosing.
  - 3. Butt transverse joints without gaps, and coat joint with adhesive.
  - 4. Fold and compress liner in corners of rectangular ducts or cut and fit to ensure butted-edge overlapping.
  - 5. Do not apply liner in rectangular ducts with longitudinal joints, except at corners of ducts, unless duct size and dimensions of standard liner make longitudinal joints necessary.
  - 6. Apply adhesive coating on longitudinal seams in ducts with air velocity of 2500 fpm.
  - 7. Secure liner with mechanical fasteners 4 inches from corners and at intervals not exceeding 12 inches transversely; at 3 inches from transverse joints and at intervals not exceeding 18 inches longitudinally.
  - 8. Secure transversely oriented liner edges facing the airstream with metal nosings that have either channel or "Z" profiles or are integrally formed from duct wall. Fabricate edge facings at the following locations:
    - a. AHU Fan Section discharge openings.
    - b. Intervals of lined duct preceding unlined duct.
    - c. Upstream edges of transverse joints in ducts where air velocities are higher than 2500 fpm or where indicated.

## 2.06 SEALANT AND GASKETS

- A. General Sealant and Gasket Requirements: Surface-burning characteristics for sealants and gaskets shall be a maximum flame-spread index of 25 and a maximum smoke-developed index of 50 when tested according to UL 723; certified by an NRTL.
- B. Two-Part Tape Sealing System:

1. Tape: Woven cotton fiber impregnated with mineral gypsum and modified acrylic/silicone activator to react exothermically with tape to form hard, durable, airtight seal.
  2. Tape Width: 6 inches.
  3. Sealant: Modified styrene acrylic.
  4. Water resistant.
  5. Mold and mildew resistant.
  6. Maximum Static-Pressure Class: 10-inch wg, positive and negative.
  7. Service: Indoor and outdoor.
  8. Service Temperature: Minus 40 to plus 200 deg F.
  9. Substrate: Compatible with galvanized sheet steel (both PVC coated and bare), stainless steel, or aluminum.
  10. For indoor applications, use sealant that has a VOC content of 250 g/L or less when calculated according to 40 CFR 59, Subpart D (EPA Method 24).
- C. Water-Based Joint and Seam Sealant:
1. Application Method: Brush on.
  2. Solids Content: Minimum 65 percent.
  3. Shore A Hardness: Minimum 20.
  4. Water resistant.
  5. Mold and mildew resistant.
  6. VOC: Maximum 75 g/L (less water).
  7. Maximum Static-Pressure Class: 10-inch wg, positive and negative.
  8. Service: Indoor or outdoor.
  9. Substrate: Compatible with galvanized sheet steel (both PVC coated and bare), stainless steel, or aluminum sheets.
- D. Flanged Joint Sealant: Comply with ASTM C 920.
1. General: Single-component, acid-curing, silicone, elastomeric.
  2. Type: S.
  3. Grade: NS.
  4. Class: 25.
  5. Use: O.
  6. For indoor applications, use sealant that has a VOC content of 250 g/L or less when calculated according to 40 CFR 59, Subpart D (EPA Method 24).
- E. Flange Gaskets: Butyl rubber, neoprene, or EPDM polymer with polyisobutylene plasticizer.
- F. Round Duct Joint O-Ring Seals:
1. Seal shall provide maximum leakage class of 3 cfm/100 sq. ft. at 1-inch wg and shall be rated for 10-inch wg static-pressure class, positive or negative.
  2. EPDM O-ring to seal in concave bead in coupling or fitting spigot.
  3. Double-lipped, EPDM O-ring seal, mechanically fastened to factory-fabricated couplings and fitting spigots.

## 2.07 HANGERS AND SUPPORTS

- A. Hanger Rods for Noncorrosive Environments: Cadmium-plated steel rods and nuts.
- B. Strap and Rod Sizes: Comply with SMACNA's "HVAC Duct Construction Standards - Metal and Flexible," Table 4-1, "Rectangular Duct Hangers Minimum Size," and Table 4-2, "Minimum Hanger Sizes for Round Duct."
- C. Steel Cables for Galvanized-Steel Ducts: Galvanized steel complying with ASTM A 603.
- D. Steel Cable End Connections: Cadmium-plated steel assemblies with brackets, swivel, and bolts designed for duct hanger service; with an automatic-locking and clamping device.
- E. Duct Attachments: Sheet metal screws, blind rivets, or self-tapping metal screws; compatible with duct materials.
- F. Trapeze and Riser Supports:
  1. Supports for Galvanized-Steel Ducts: Galvanized-steel shapes and plates.

2. Supports for Aluminum Ducts: Aluminum or galvanized steel coated with zinc chromate.

### **PART 3 EXECUTION**

#### **3.01 DUCT INSTALLATION**

- A. Drawing plans, schematics, and diagrams indicate general location and arrangement of duct system. Indicated duct locations, configurations, and arrangements were used to size ducts and calculate friction loss for air-handling equipment sizing and for other design considerations. Install duct systems as indicated unless deviations to layout are approved on Shop Drawings and Coordination Drawings.
- B. Install ducts according to SMACNA's "HVAC Duct Construction Standards - Metal and Flexible" unless otherwise indicated.
- C. Install round ducts in maximum practical lengths.
- D. Install ducts with fewest possible joints.
- E. Install factory- or shop-fabricated fittings for changes in direction, size, and shape and for branch connections.
- F. Unless otherwise indicated, install ducts vertically and horizontally, and parallel and perpendicular to building lines.
- G. Install ducts close to walls, overhead construction, columns, and other structural and permanent enclosure elements of building.
- H. Install ducts with a clearance of 1 inch, plus allowance for insulation thickness.
- I. Route ducts to avoid passing through transformer vaults and electrical equipment rooms and enclosures.
- J. Where ducts pass through non-fire-rated interior partitions and exterior walls and are exposed to view, cover the opening between the partition and duct or duct insulation with sheet metal flanges of same metal thickness as the duct. Overlap openings on four sides by at least 1-1/2 inches.
- K. Where ducts pass through fire-rated interior partitions and exterior walls, install fire dampers. Comply with requirements in Division 23 Section "Air Duct Accessories" for fire and smoke dampers.
- L. Protect duct interiors from moisture, construction debris and dust, and other foreign materials. Comply with SMACNA's "Duct Cleanliness for New Construction Guidelines."

#### **3.02 INSTALLATION OF EXPOSED DUCTWORK**

- A. Protect ducts exposed in finished spaces from being dented, scratched, or damaged.
- B. Trim duct sealants flush with metal. Create a smooth and uniform exposed bead. Do not use two-part tape sealing system.
- C. Maintain consistency, symmetry, and uniformity in the arrangement and fabrication of fittings, hangers and supports, duct accessories, and air outlets.
- D. Repair or replace damaged sections and finished work that does not comply with these requirements.

#### **3.03 DUCT SEALING**

- A. Seal ducts to the following seal classes according to SMACNA's "HVAC Duct Construction Standards - Metal and Flexible":

#### **3.04 HANGER AND SUPPORT INSTALLATION**

- A. Comply with SMACNA's "HVAC Duct Construction Standards - Metal and Flexible," Chapter 4, "Hangers and Supports."
- B. Building Attachments: Concrete inserts, powder-actuated fasteners, or structural-steel fasteners appropriate for construction materials to which hangers are being attached.
  - 1. Where practical, install concrete inserts before placing concrete.
  - 2. Install powder-actuated concrete fasteners after concrete is placed and completely cured.

3. Use powder-actuated concrete fasteners for standard-weight aggregate concretes or for slabs more than 4 inches thick.
  4. Do not use powder-actuated concrete fasteners for lightweight-aggregate concretes or for slabs less than 4 inches thick.
- C. Hanger Spacing: Comply with SMACNA's "HVAC Duct Construction Standards - Metal and Flexible," Table 4-1, "Rectangular Duct Hangers Minimum Size," and Table 4-2, "Minimum Hanger Sizes for Round Duct," for maximum hanger spacing; install hangers and supports within 24 inches of each elbow and within 48 inches of each branch intersection.
- D. Hangers Exposed to View: Threaded rod and angle or channel supports.
- E. Support vertical ducts with steel angles or channel secured to the sides of the duct with welds, bolts, sheet metal screws, or blind rivets; support at each floor and at a maximum intervals of 16 feet.
- F. Install upper attachments to structures. Select and size upper attachments with pull-out, tension, and shear capacities appropriate for supported loads and building materials where used.

### 3.05 CONNECTIONS

- A. Make connections to equipment with flexible connectors complying with Division 23 Section "Air Duct Accessories."
- B. Comply with SMACNA's "HVAC Duct Construction Standards - Metal and Flexible" for branch, outlet and inlet, and terminal unit connections.

### 3.06 PAINTING

- A. Paint interior of metal ducts that are visible through registers and grilles and that do not have duct liner. Apply one coat of flat, black, latex paint over a compatible galvanized-steel primer. Paint materials and application requirements are specified in Division 09 painting Sections.

### 3.07 FIELD QUALITY CONTROL

- A. Perform tests and inspections.
- B. Leakage Tests:
  1. Comply with SMACNA's "HVAC Air Duct Leakage Test Manual." Submit a test report for each test. Duct leakage shall not exceed State Energy Code prescriptive maximums.
  2. Test the following systems:
    - a. Supply Ducts with a Pressure Class of 3-Inch wg or Higher: Cap high-pressure ductwork upstream of the VAV boxes and at the AHU outlet, and test the entire high-pressure system.
    - b. All ductwork Located Outdoors/Outside of the building envelope.
  3. Disassemble, reassemble, and seal segments of systems to accommodate leakage testing and for compliance with test requirements.
  4. Test for leaks before applying external insulation.
  5. Conduct tests at static pressures equal to maximum design pressure of system or section being tested. If static-pressure classes are not indicated, test system at maximum system design pressure. Do not pressurize systems above maximum design operating pressure.
  6. Give three days' advance notice for testing.
- C. Duct System Cleanliness Tests:
  1. Visually inspect duct system to ensure that no visible contaminants are present.
  2. Test sections of metal duct system, chosen randomly by Owner, for cleanliness according to "Vacuum Test" in NADCA ACR, "Assessment, Cleaning and Restoration of HVAC Systems."
    - a. Acceptable Cleanliness Level: Net weight of debris collected on the filter media shall not exceed 0.75 mg/100 sq. cm.
- D. Duct system will be considered defective if it does not pass tests and inspections.
- E. Prepare test and inspection reports.

**3.08 INDOOR DUCT SCHEDULE**

- A. Fabricate metal ducts with galvanized sheet steel except as otherwise indicated and as follows:
- B. Supply Ducts and Outdoor Air Ducts in Equipment Rooms, Boiler Rooms, and Exposed in Occupied or Unoccupied Spaces:
  - 1. Ducts Connected to Constant-Volume Air-Handling Units: Single Wall
    - a. Pressure Class: Positive or negative 2-inch wg.
    - b. Minimum SMACNA Seal Class: A.
  - 2. Ductwork Exposed in Conditioned Occupied Spaces: Factory Metal-Phosphatized galvanized steel sheet "Paint Grip" exterior ready for field painting.
  - 3. Ductwork Exposed in and conveying conditioned air through unconditioned spaces: Double Wall Insulated, with "Paint Grip" outer layer.
    - a. Pressure Class: Matching Service as listed above.
    - b. Minimum SMACNA Seal Class: A.
- C. Supply Ducts and Outdoor Air Ducts in concealed spaces and ceiling plenums:
  - 1. Ducts Connected to Constant-Volume Air-Handling Units: Single Wall
    - a. Pressure Class: Positive and negative 2-inch wg.
    - b. Minimum SMACNA Seal Class: A.
- D. Return Ducts in Equipment Rooms, Boiler Rooms, and Exposed in Occupied or Unoccupied Spaces:
  - 1. Ducts Connected to Constant-Volume Air-Handling Units: Single Wall
    - a. Pressure Class: Positive and negative 2-inch wg.
    - b. Minimum SMACNA Seal Class: A.
  - 2. Ductwork Exposed in Occupied Spaces: Phosphatized paint grip exterior ready for painting.
- E. Transfer Ducts in Equipment Rooms, Boiler Rooms, and Exposed in Occupied or Unoccupied Spaces:
  - 1. Ducts Connected to Air-Handling Units: Single Wall
    - a. Pressure Class: Positive or negative 2-inch wg.
    - b. Minimum SMACNA Seal Class: B.
  - 2. Ductwork Exposed in Occupied Spaces: Phosphatized paint grip exterior ready for painting.
- F. Return and Transfer Air Ducts in concealed spaces and ceiling plenums:
  - 1. Pressure Class: Positive or negative 2-inch wg.
  - 2. Minimum SMACNA Seal Class: C.
- G. Exhaust & Relief Air Ducts in Equipment Rooms, Boiler Rooms, and Exposed in Occupied or Unoccupied Spaces:
  - 1. Ducts Connected to general exhaust fans and Power Roof Ventilators (ASHRAE 62.1, Class 1 and 2) Air:
    - a. Pressure Class: Negative 1-inch wg.
    - b. Minimum SMACNA Seal Class: C if negative pressure, and A if positive pressure.
  - 2. Ducts Connected to Air-Handling Units and System Exhaust/Relief fan equipment:
    - a. Pressure Class: Positive or negative 2-inch wg.
    - b. Minimum SMACNA Seal Class: B if negative pressure, and A if positive pressure.
- H. Exhaust & Relief Air Ducts in concealed spaces and ceiling plenums: Single Wall
  - 1. Ducts Connected to general exhaust fans and Power Roof Ventilators (ASHRAE 62.1, Class 1 and 2) Air:
    - a. Pressure Class: Negative 1-inch wg.
    - b. Minimum SMACNA Seal Class: C if negative pressure, and A if positive pressure.
  - 2. Ducts Connected to Air-Handling Units and System Exhaust/Relief fan equipment:
    - a. Pressure Class: Positive or negative 2-inch wg.
    - b. Minimum SMACNA Seal Class: B if negative pressure, and A if positive pressure.
- I. Intermediate Reinforcement:

1. Galvanized-Steel Ducts: Galvanized steel.
  2. Stainless Steel Ducts: Matching Stainless steel
  3. Aluminum Ducts: Aluminum.
- J. Liner (For metal ducts)
1. Supply Air Ducts: Flexible elastomeric, 1/2 inch thick. Within 20' of fan equipment or as indicated on drawings.
  2. Return Air Ducts: Flexible elastomeric, 1/2 inch thick. Within 20' of fan equipment or as indicated on drawings.
  3. Transfer Ducts: Flexible elastomeric, 1/2 inch thick. Ducts lined in full or as indicated on drawings.
  4. Return Grille Plenums: Flexible elastomeric, 1/2 inch thick.
- K. Elbow Configuration:
1. Rectangular Duct: Comply with SMACNA's "HVAC Duct Construction Standards - Metal and Flexible," - "Rectangular Elbows." The drawings indicate elbow construction only as a guide. Use the largest radius possible. Mitered elbows should only be used as a last resort
    - a. Radius Type RE 1 with minimum 1.5 radius-to-diameter ratio.
    - b. Radius Type RE 3 with minimum 1.0 radius-to-diameter ratio and two vanes.
    - c. Mitered Type RE 2 with vanes complying with SMACNA's "HVAC Duct Construction Standards - Metal and Flexible," Figure 2-3, "Vanes and Vane Runners," and Figure 2-4, "Vane Support in Elbows."
  2. Round Duct: Comply with SMACNA's "HVAC Duct Construction Standards - Metal and Flexible," Figure 3-3, "Round Duct Elbows."
    - a. Minimum Radius-to-Diameter Ratio and Elbow Segments: Comply with SMACNA's "HVAC Duct Construction Standards - Metal and Flexible," - "Mitered Elbows." Elbows with less than 90-degree change of direction have proportionately fewer segments.
      - 1) Radius-to Diameter Ratio: 1.5.
    - b. Round Elbows, 12 Inches and Smaller in Diameter: Stamped or pleated.
    - c. Round Elbows, 14 Inches and Larger in Diameter: Standing seam.
- L. Branch Configuration:
1. Rectangular Duct: Comply with SMACNA's "HVAC Duct Construction Standards - Metal and Flexible," - "Branch Connections."
    - a. Rectangular Main to Rectangular Branch: 45-degree entry.
  2. Round and Flat Oval: Comply with SMACNA's "HVAC Duct Construction Standards - Metal and Flexible," - "90 Degree Tees and Laterals," and "Conical Tees".
    - a. Velocity less than 1500 fpm: Conical tap.
    - b. Velocity 1500 fpm or Higher: 45-degree lateral.

### 3.09 DUCTWORK PENETRATING EXTERIOR ENVELOPE

- A. Where Ductwork penetrates exterior walls and roof structure: 2" thick DOUBLE WALL.
1. Extend minimum 12" past exterior and interior face of structure (wall or roof).
  2. Provide Flange as required to connect to adjacent ductwork.
  3. Pressure Class: Matching Service listed in 3.7 above.
  4. Minimum SMACNA Seal Class: A.

**END OF SECTION 233113**

This page intentionally left blank