

Sure Clamp Round Ductwork

18 GA Welded 304 Stainless Steel (60 Grit Finish Welds) Specifications

A. General : Fabricate single wall ducts, elbows, transitions, offsets, branch connections, and other construction according to SMACNA's "HVAC Duct Construction Standards - Metal and Flexible" and complying with requirements for metal thickness and minimum gauge as shown, reinforcing types and intervals, and joint intervals per static pressure class indicated.

1. Lengths : Fabricate round ducts in lengths appropriate to reinforcement and rigidity class required for pressure class. 5'-0" maximum lengths
2. Deflection : Duct systems shall not exceed deflection limits according to SMACNA's "HVAC Duct Construction Standards - Metal and Flexible".
3. Round Fittings : Fabricate fittings to match adjoining ducts, and to comply with duct requirements as applicable to fittings. Provide fitting types as indicated on drawings.
4. Round Elbows : Except as otherwise indicated, fabricate elbows with center-line radius equal to 1-1/2 times associated duct width. Where installation requirements prevent the use of fitting types indicated on the drawings and/or with center-line radius equal to 1-1/2 times the duct width, provide center-line radius equal to 1 times the duct width.
5. Ductwork leakage rates not to exceed 2 cfm per 100 square feet with three transverse connection at 20" W.G. negative pressure.

B. Material :

1. 304 Stainless Steel

C. Minimum Ductwork and Fittings Gauge (20" W.G. negative pressure) :

1. 18 GA 4" to 22" diameter.

D. Longitudinal Seams :

1. Ductwork Seams : (RL-4) ANSI/AWS D9.1-90 Mig Welded (GMAW)
2. Fittings Seams : (RL-4) ANSI/AWS D9.1-90 Mig Welded (GMAW)

3. Exterior Welds : Welds to be wire brush and ground to a 60 grit finish, the weld will be convex with high spots removed.
4. Interior Welds : Welds to be ground to a 60 grit finish, with no protrusion

E. Transverse Joints: Integral flange ductwork system

1. Manufacturer :

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www.langdonsheetmetal.com
Attn. : Joe Sandman. Mobile # 513-678-6825

- a. Sure-Clamp Ductwork, even and odd sizes 4" diameter to 22" diameter.
- b. Connection : 90 degree continuous machine formed ductwork flange.
- c. Clamps : Galvanized with zinc coated draw latch and self centering flange guides. Gasket profile forms to the inside of clamp, sealing the outer edges of the ductwork flange.
- d. Clamp Gauge : 22 GA 4" diameter. 20 GA 5" to 22" diameter.
- e. Gasket : Red silicone sponge gasket. Temperature range : -40 F to +400 F