

SECTION 233113 – METAL DUCTS

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 1 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. This Section includes metal ducts for supply, return, outside, and exhaust air-distribution systems in pressure classes from minus 2- to plus 10-inch wg. Metal ducts include the following:
 - 1. Rectangular ducts and fittings.
 - 2. Single-wall, round ducts and formed fittings.
 - 3. Duct liner.
- B. Related Sections include the following:
 - 1. Division 23 Section "Duct Accessories" for dampers, sound-control devices, duct-mounting access doors and panels, turning vanes, and flexible ducts.

1.3 SYSTEM DESCRIPTION

- A. Duct system design, as indicated, has been used to select size and type of air-moving and -distribution equipment and other air system components. Changes to layout or configuration of duct system must be specifically approved in writing by Engineer. Accompany requests for layout modifications with calculations showing that proposed layout will provide original design results without increasing system total pressure.
- B. Drawings are diagrammatical and shall not be used as a shop drawing for fabrication. The contractor is responsible to coordinate with other trades and adjustments in elevation and routings as required to meet the project requirements.

1.4 SUBMITTALS

- A. Shop Drawings: CAD-generated and drawn to 1/4 inch equals 1 foot (1:50) scale. Show fabrication and installation details for metal ducts.
 - 1. Fabrication, assembly, and installation, including plans, elevations, sections, components, and attachments to other work.
 - 2. Duct layout indicating sizes and pressure classes.
 - 3. Elevations of top and bottom of ducts.
 - 4. Dimensions of main duct runs from building grid lines.

5. Fittings.
6. Reinforcement and spacing.
7. Seam and joint construction.
8. Penetrations through fire-rated and other partitions.
9. Equipment installation based on equipment being used on Project.
10. Duct accessories, including access doors and panels.
11. Hangers and supports, including methods for duct and building attachment and vibration isolation.

- B. Field quality-control test reports.

1.5 QUALITY ASSURANCE

- A. NFPA Compliance:

1. NFPA 90A, "Installation of Air Conditioning and Ventilating Systems."
2. NFPA 90B, "Installation of Warm Air Heating and Air Conditioning Systems."

- B. Comply with NFPA 96, "Ventilation Control and Fire Protection of Commercial Cooking Operations," Ch. 3, "Duct System," for range hood ducts, and the Michigan Department of Public Health Manual of Ventilation Systems for Food Service Establishments.

1.6 COORDINATION

- A. The contractor is responsible for coordination with other trades and maintaining required clearances for access and servicing of equipment.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. In other Part 2 articles where titles below introduce lists, the following requirements apply to product selection:
1. Manufacturers: Subject to compliance with requirements, provide products by one of the manufacturers specified.

2.2 SHEET METAL MATERIALS

- A. 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: Lock-forming quality; complying with ASTM A 653/A 653M and having G90 (Z275) coating designation; ducts shall have mill-phosphatized finish for surfaces exposed to view.

- C. Reinforcement Shapes and Plates: Galvanized-steel reinforcement where installed on galvanized sheet metal ducts.
- D. 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.

2.3 RECTANGULAR FITTING CONSTRUCTION

- A. General: Construct fittings in accordance with SMACNA HVAC Duct Construction Standards. Use low loss fittings.
- B. Elbows: Use full radius type with inside radius equal to the duct width except where space limits use. Where square elbows are shown or used, provide turning vanes. Use airfoil type vanes where duct velocities exceed 2000 fpm.
- C. Transitions: Construct transitions between duct sizes with tapered fittings. Use 22.5-degree maximum angle per side for diverging transitions and 30-degree maximum angle for converging transitions.
- D. Divided Flow Fittings: Use full radiused tees, square tees with turning vanes, or enlarged branch connections with 45-degree entry equal to ¼ times the duct width. Round branch ducts to rectangular ducts may be conical or enlarged rectangular to round fittings with 45 degree enlarged entry. Round taps serving individual diffusers may be straight taps where branch duct velocities are less than 800 fpm.

2.4 DUCT LINER

- A. Fibrous-Glass Liner: Comply with NFPA 90A or NFPA 90B and with NAIMA AH124.
 - 1. Manufacturers:
 - a. CertainTeed Corp.; Insulation Group.
 - b. Johns Manville International, Inc.
 - c. Knauf Fiber Glass GmbH.
 - d. Owens Corning.
 - 2. Materials: ASTM C 1071; surfaces exposed to airstream shall be coated to prevent erosion of glass fibers.
 - a. Thickness: 1 inch unless otherwise indicated.
 - b. Thermal Conductivity (k-Value): 0.26 at 75 deg F mean temperature.
 - c. Fire-Hazard Classification: Maximum flame-spread index of 25 and smoke-developed index of 50 when tested according to ASTM E 84.
 - d. Liner Adhesive: Comply with NFPA 90A or NFPA 90B and with ASTM C 916.
 - e. Mechanical Fasteners: Galvanized steel suitable for adhesive attachment, mechanical attachment, or welding attachment to duct without damaging liner when applied as recommended by manufacturer and without causing leakage in duct.

3. Tensile Strength: Indefinitely sustain a 50-lb- tensile, dead-load test perpendicular to duct wall.
4. Fastener Pin Length: As required for thickness of insulation and without projecting more than 1/8 inch into airstream.
5. Adhesive for Attaching Mechanical Fasteners: Comply with fire-hazard classification of duct liner system.

2.5 SEALANT MATERIALS

- A. Joint and Seam Sealants, General: The term "sealant" is not limited to materials of adhesive or mastic nature but includes tapes and combinations of open-weave fabric strips and mastics.
- B. Joint and Seam Tape: 2 inches wide; glass-fiber-reinforced fabric.
- C. Tape Sealing System: Woven-fiber tape impregnated with gypsum mineral compound and modified acrylic/silicone activator to react exothermically with tape to form hard, durable, airtight seal.
- D. Water-Based Joint and Seam Sealant: Flexible, adhesive sealant, resistant to UV light when cured, UL 723 listed, and complying with NFPA requirements for Class 1 ducts.
- E. Solvent-Based Joint and Seam Sealant: One-part, nonsag, solvent-release-curing, polymerized butyl sealant formulated with a minimum of 75 percent solids.
- F. Flanged Joint Mastic: One-part, acid-curing, silicone, elastomeric joint sealant complying with ASTM C 920, Type S, Grade NS, Class 25, Use O.
- G. Flange Gaskets: Butyl rubber or EPDM polymer with polyisobutylene plasticizer.

2.6 HANGERS AND SUPPORTS

- A. Building Attachments: Concrete inserts, powder-actuated fasteners, or structural-steel fasteners appropriate for construction materials to which hangers are being attached.
 1. Use powder-actuated concrete fasteners for standard-weight aggregate concretes or for slabs more than 4 inches thick.
 2. Exception: Do not use powder-actuated concrete fasteners for lightweight-aggregate concretes or for slabs less than 4 inches thick.
- B. Hanger Materials: Galvanized sheet steel or threaded steel rod.
 1. Hangers Installed in Corrosive Atmospheres: Electrogalvanized, all-thread rods or galvanized rods with threads painted with zinc-chromate primer after installation.
 2. Strap and Rod Sizes: Comply with SMACNA's "HVAC Duct Construction Standards-- Metal and Flexible" for steel sheet width and thickness and for steel rod diameters.
 3. Galvanized-steel straps attached to aluminum ducts shall have contact surfaces painted with zinc-chromate primer.
- C. Duct Attachments: Sheet metal screws, blind rivets, or self-tapping metal screws; compatible with duct materials.

- D. Trapeze and Riser Supports: Steel shapes complying with ASTM A 36/A 36M.
 - 1. Supports for Galvanized-Steel Ducts: Galvanized-steel shapes and plates.
 - 2. Supports for Stainless-Steel Ducts: Stainless-steel support materials.
 - 3. Supports for Aluminum Ducts: Aluminum support materials unless materials are electrolytically separated from ducts.

2.7 RECTANGULAR DUCT FABRICATION

- A. Fabricate 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, reinforcing types and intervals, tie-rod applications, and joint types and intervals.
 - 1. Lengths: Fabricate rectangular ducts in lengths appropriate to reinforcement and rigidity class required for pressure class.
 - 2. Deflection: Duct systems shall not exceed deflection limits according to SMACNA's "HVAC Duct Construction Standards--Metal and Flexible."
- B. Transverse Joints: Prefabricated slide-on joints and components constructed using manufacturer's guidelines for material thickness, reinforcement size and spacing, and joint reinforcement.
 - 1. Manufacturers:
 - a. Ductmate Industries, Inc.
 - b. Nexus Inc.
 - c. Ward Industries, Inc.
- C. Formed-On Flanges: Construct according to SMACNA's "HVAC Duct Construction Standards--Metal and Flexible," Figure 1-4, using corner, bolt, cleat, and gasket details.
 - 1. Manufacturers:
 - a. Ductmate Industries, Inc.
 - b. Lockformer.
 - 2. Duct Size: Maximum 30 inches wide and up to 2-inch wg pressure class.
 - 3. Longitudinal Seams: Pittsburgh lock sealed with noncuring polymer sealant.
- D. Cross Breaking or Cross Beading: Cross break or cross bead duct sides 19 inches and larger and 0.0359 inch thick or less, with more than 10 sq. ft. of nonbraced panel area unless ducts are lined.

2.8 APPLICATION OF LINER IN RECTANGULAR DUCTS

- A. Use 1-inch thick liner on supply and return air ducts for a minimum distance of 10 ft from all air handling equipment or distance as noted on the plans. Increase the duct dimension as required to provide the internal clear dimensions shown on the drawings.

- B. 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.
- C. Apply adhesive to transverse edges of liner facing upstream that do not receive metal nosing.
- D. Butt transverse joints without gaps and coat joint with adhesive.
- E. Fold and compress liner in corners of rectangular ducts or cut and fit to ensure butted-edge overlapping.
- F. Do not apply liner in rectangular ducts with longitudinal joints, except at corners of ducts, unless duct size and standard liner product dimensions make longitudinal joints necessary.
- G. Apply adhesive coating on longitudinal seams in ducts with air velocity of 2500 fpm.
- H. 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.
- I. 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:
 - 1. Fan discharges.
 - 2. Intervals of lined duct preceding unlined duct.
 - 3. Upstream edges of transverse joints in ducts where air velocities are greater than 2500 fpm or where indicated.
- J. Where indicated on the drawings, secure insulation between perforated sheet metal inner duct of same thickness as specified for outer shell. Use mechanical fasteners that maintain inner duct at uniform distance from outer shell without compressing insulation.
 - 1. Sheet Metal Inner Duct Perforations: 3/32-inch diameter, with an overall open area of 23 percent.
 - 2. Terminate inner ducts with buildouts attached to fire-damper sleeves, dampers, turning vane assemblies, or other devices. Fabricated buildouts (metal hat sections) or other buildout means are optional; when used, secure buildouts to duct walls with bolts, screws, rivets, or welds.

2.9 ROUND DUCT AND FITTING FABRICATION

- A. Diameter as applied to flat-oval ducts in this Article is the diameter of a round duct with a circumference equal to the perimeter of a given size of flat-oval duct.
- B. Round, Longitudinal- and Spiral Lock-Seam Ducts: Fabricate supply ducts of galvanized steel according to SMACNA's "HVAC Duct Construction Standards--Metal and Flexible."
- C. Duct Joints:

1. Ducts up to 20 Inches in Diameter: Interior, center-beaded slip coupling, sealed before and after fastening, attached with sheet metal screws.
2. Round Ducts: Prefabricated connection system consisting of double-lipped, EPDM rubber gasket. Manufacture ducts according to connection system manufacturer's tolerances.
 - a. Manufacturers:
 - 1) Lindab Inc.
- D. 90-Degree Tees and Laterals and Conical Tees: Fabricate to comply with SMACNA's "HVAC Duct Construction Standards--Metal and Flexible," with metal thicknesses specified for longitudinal-seam straight ducts.
- E. Diverging-Flow Fittings: Fabricate with reducing entrance to branch taps and with no excess material projecting from fitting onto branch tap entrance.
- F. Fabricate elbows using die-formed, gored, pleated, or mitered construction. Bend radius of die-formed, gored, and pleated elbows shall be 1-1/2 times duct diameter. Unless elbow construction type is indicated, fabricate elbows as follows:
 1. Mitered-Elbow Radius and Number of Pieces: Welded construction complying with SMACNA's "HVAC Duct Construction Standards--Metal and Flexible," unless otherwise indicated.
 2. Round Mitered Elbows: Welded construction with the following metal thickness for pressure classes from minus 2- to plus 2-inch wg:
 - a. Ducts 3 to 36 Inches in Diameter: 0.034 inch.
 3. Round Mitered Elbows: Welded construction with the following metal thickness for pressure classes from 2- to 10-inch wg:
 - a. Ducts 3 to 26 Inches in Diameter: 0.034 inch.
 4. 90-Degree, 2-Piece, Mitered Elbows: Use only for supply systems or for material-handling Class A or B exhaust systems and only where space restrictions do not permit using radius elbows. Fabricate with single-thickness turning vanes.
 5. Round Elbows 8 Inches and Less in Diameter: Fabricate die-formed elbows for 45- and 90-degree elbows and pleated elbows for 30, 45, 60, and 90 degrees only. Fabricate nonstandard bend-angle configurations or nonstandard diameter elbows with gored construction.
 6. Round Elbows 9 through 14 Inches in Diameter: Fabricate gored or pleated elbows for 30, 45, 60, and 90 degrees unless space restrictions require mitered elbows. Fabricate nonstandard bend-angle configurations or nonstandard diameter elbows with gored construction.
 7. Round Elbows Larger Than 14 Inches in Diameter and All Flat-Oval Elbows: Fabricate gored elbows unless space restrictions require mitered elbows.
 8. Die-Formed Elbows for Sizes through 8 Inches in Diameter and All Pressures 0.040 inch thick with 2-piece welded construction.
 9. Round Gored-Elbow Metal Thickness: Same as non-elbow fittings specified above.

10. Pleated Elbows for Sizes through 14 Inches in Diameter and Pressures through 10-Inch wg: 0.022 inch.

PART 3 - EXECUTION

3.1 DUCT APPLICATIONS

- A. Static-Pressure Classes: Unless otherwise indicated, construct ducts according to the following:
 1. Supply Ducts: 2-inch wg.
 2. Return Ducts (Negative Pressure): 1-inch wg.
- B. All ducts shall be galvanized steel.

3.2 DUCT INSTALLATION

- A. Construct and install ducts according to SMACNA's "HVAC Duct Construction Standards--Metal and Flexible," unless otherwise indicated.
- B. Install round ducts in lengths not less than 12 feet unless interrupted by fittings.
- C. Install ducts with fewest possible joints.
- D. Install fabricated fittings for changes in directions, size, and shape and for connections.
- E. Install couplings tight to duct wall surface with a minimum of projections into duct. Secure couplings with sheet metal screws. Install screws at intervals of 12 inches, with a minimum of 3 screws in each coupling.
- F. Install ducts, unless otherwise indicated, vertically and horizontally and parallel and perpendicular to building lines; avoid diagonal runs.
- G. Install ducts close to walls, overhead construction, columns, and other structural and permanent enclosure elements of building.
 1. Offsets and transitions as required to coordinate with other trades and equipment are the responsibility of the contractor.
- H. Install ducts with a clearance of 1 inch, plus allowance for insulation thickness.
- I. Conceal ducts from view in finished spaces. Do not encase horizontal runs in solid partitions unless specifically indicated.
- J. Coordinate layout with suspended ceiling, fire- and smoke-control dampers, lighting layouts, and similar finished work.
 1. Where ducts pass over light fixtures, maintain a minimum elevation of 6-inches above finish ceiling, or more as required by the light fixtures.

- K. Seal all joints and seams. Apply sealant to male end connectors before insertion, and afterward to cover entire joint and sheet metal screws.
- L. Electrical Equipment Spaces: Route ducts to avoid passing through transformer vaults and electrical equipment spaces and enclosures.
- M. Non-Fire-Rated Partition Penetrations: Where ducts pass through interior partitions and exterior walls and are exposed to view, conceal spaces between construction openings and ducts or duct insulation with sheet metal flanges of same metal thickness as ducts. Overlap openings on 4 sides by at least 1-1/2 inches. Provide sheet metal flanges on both sides of walls, exposed or concealed for sound sensitive walls.
- N. Fire-Rated Partition Penetrations: Where ducts pass through interior partitions and exterior walls, install appropriately rated fire dampers, sleeves, and firestopping sealant. Fire and smoke dampers are specified in Division 23 Section "Duct Accessories." Firestopping materials and installation methods are specified in Division 7 Section "Through-Penetration Firestop Systems."
- O. Protect duct interiors from the elements and foreign materials until building is enclosed.
- P. Paint interiors of metal ducts, that do not have duct liner, for 24 inches upstream of registers and grilles where line of sight permits view of ducts. Apply one coat of flat, black, latex finish coat over a compatible galvanized-steel primer. Paint materials and application requirements are specified in Division 9 painting Sections.
- Q. Connections to existing equipment: Duct connections to equipment shall be full size to match the specific equipment used.
 - 1. Provide tapered transitions to equipment.
 - 2. Adjust ductwork configuration to match equipment used on project.

3.3 SEAM AND JOINT SEALING

- A. Seal duct seams and joints according to SMACNA's "HVAC Duct Construction Standards--Metal and Flexible" for duct pressure class indicated.
 - 1. For pressure classes lower than 2-inch wg, seal transverse joints.
- B. Seal ducts before external insulation is applied.

3.4 HANGING AND SUPPORTING

- A. Support horizontal ducts within 24 inches of each elbow and within 48 inches of each branch intersection.
- B. Support vertical ducts at maximum intervals of 16 feet and at each floor.
- C. Install concrete inserts before placing concrete.
- D. Install powder-actuated concrete fasteners after concrete is placed and completely cured.

1. Do not use powder-actuated concrete fasteners for lightweight-aggregate concretes or for slabs less than 4 inches thick.

3.5 CONNECTIONS

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

3.6 FIELD QUALITY CONTROL

- A. Perform the following field tests and inspections according to SMACNA's "HVAC Air Duct Leakage Test Manual" and prepare test reports:
 1. Disassemble, reassemble, and seal segments of systems to accommodate leakage testing and for compliance with test requirements.
 2. Conduct tests at static pressures equal to maximum design pressure of system or section being tested. If pressure classes are not indicated, test entire system at maximum system design pressure. Do not pressurize systems above maximum design operating pressure. Give seven days' advance notice for testing.
 3. Determine leakage from entire system or section of system by relating leakage to surface area of test section.
 - a. Allowable Leakage, Supply Duct Systems: 1 percent of design airflow.
 - b. Allowable Leakage, Return Duct Systems: 2 percent of design airflow.
 - c. Allowable Leakage, Supply Duct Systems, Terminals to Air Outlets: 2 percent of design airflow.
 4. Maximum Allowable Leakage: Comply with requirements for Leakage Class 3 for round and flat-oval ducts, Leakage Class 12 for rectangular ducts in pressure classes lower than and equal to 2-inch wg (both positive and negative pressures), and Leakage Class 6 for pressure classes from 2- to 10-inch wg.
 5. Remake leaking joints and retest until leakage is equal to or less than maximum allowable.

END OF SECTION 233113