

## 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 01 Specification Sections, apply to this Section.

#### 1.2 SUMMARY

- A. Section Includes:

1. Rectangular ducts and fittings.
2. Round ducts and fittings.
3. Sheet metal materials.
4. Sealants and gaskets.
5. Hangers and supports.

#### 1.3 PERFORMANCE REQUIREMENTS

- A. 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.

1. Static-Pressure Classes:

- a. Supply Ducts (Upstream from Air Terminal Units): 4-inch wg (500 Pa)
- b. Supply Ducts (Downstream from Air Terminal Units): 2-inch wg (250 Pa)
- c. Return Ducts (Negative Pressure): 2-inch wg (250 Pa)
- d. Exhaust Ducts (Negative Pressure): 1-inch wg (250 Pa)

2. Leakage Class:

- a. Round Supply-Air Duct: 3 cfm/100 sq. ft. at 1-inch wg (0.14 L/s per sq. m at 250 Pa)
- b. Rectangular Supply-Air Duct: 6 cfm/100 sq. ft. at 1-inch wg (0.29 L/s per sq. m at 250 Pa)
- c. Flexible Supply-Air Duct: 6 cfm/100 sq. ft. at 1-inch wg (0.29 L/s per sq. m at 250 Pa)

- B. Duct performance shall be demonstrated to engineer and owner for all new ductwork installed to be in compliance with requirements above.

1. Leakage test shall be a dual-manometer type.
2. Leakage rates shall be calculated by contractor based upon fan curves

3. No new ductwork may be insulated until leakage test has been performed and approved by engineer.

#### 1.4 SUBMITTALS

- A. Product Data: For each type of product indicated.
- B. 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. Duct layout indicating sizes, configuration, 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.
  13. Paint color samples.
- C. 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.
- D. Coordination Drawings: Plans, drawn to scale, on which the following items are shown and coordinated with each other, using input from installers of the items involved:
  1. Duct installation in congested spaces, indicating coordination with general construction, building components, and other building services. Indicate proposed changes to duct layout.
  2. Suspended ceiling components.
  3. Structural members to which duct will be attached.
  4. Size and location of initial access modules for acoustical tile.
  5. Penetrations of smoke barriers and fire-rated construction.
  6. Items penetrating finished ceiling including the following:
    - a. Lighting fixtures.
    - b. Air outlets and inlets.

- c. Speakers.
- d. Sprinklers.
- e. Access panels.
- f. Perimeter moldings.

E. Welding certificates.

## 1.5 QUALITY ASSURANCE

A. Welding Qualifications: Qualify procedures and personnel according to the following:

- 1. AWS D1.1/D1.1M, "Structural Welding Code - Steel," for hangers and supports.
- 2. AWS D9.1M/D9.1, "Sheet Metal Welding Code," for duct joint and seam welding.

## PART 2 - PRODUCTS

### 2.1 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," Figure 1-4, "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," Figure 1-5, "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," Chapter 2, "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."

## 2.2 ROUND DUCTS AND FITTINGS

- A. General Fabrication Requirements: Comply with SMACNA's "HVAC Duct Construction Standards - Metal and Flexible," Chapter 3, "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 available manufacturers offering products that may be incorporated into the Work include, but are not limited to, 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," Figure 3-2, "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."
  - 1. Transverse Joints in Ducts Larger Than 60 Inches (1524 mm) in Diameter: Flanged.
- C. Longitudinal Seams: Select seam types and fabricate according to SMACNA's "HVAC Duct Construction Standards - Metal and Flexible," Figure 3-1, "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."
  - 1. Fabricate round ducts larger Than 90 inches (2286 mm) in diameter with butt-welded longitudinal seams.
- D. Tees and Laterals: Select types and fabricate according to SMACNA's "HVAC Duct Construction Standards - Metal and Flexible," Figure 3-4, "90 Degree Tees and Laterals," and Figure 3-5, "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."

## 2.3 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: G90 (Z275).
  2. Finishes for Surfaces Exposed to View: Mill phosphatized.
- C. Carbon-Steel Sheets: Comply with ASTM A 1008/A 1008M, with oiled, matte finish for exposed ducts.
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.
- D. Tie Rods: Galvanized steel, 1/4-inch (6-mm) minimum diameter for lengths 36 inches (900 mm) or less; 3/8-inch (10-mm) minimum diameter for lengths longer than 36 inches (900 mm).

## 2.4 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: 4 inches (102 mm).
  3. Sealant: Modified styrene acrylic.
  4. Water resistant.
  5. Mold and mildew resistant.
  6. Maximum Static-Pressure Class: 10-inch wg (2500 Pa), positive and negative.
  7. Service: Indoor and outdoor.
  8. Service Temperature: Minus 40 to plus 200 deg F (Minus 40 to plus 93 deg C).
  9. Substrate: Compatible with galvanized sheet steel (both PVC coated and bare), stainless steel, or aluminum.
- 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 (2500 Pa), 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.

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 (0.14 L/s per sq. m at 250 Pa) and shall be rated for 10-inch wg (2500-Pa) 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.

## 2.5 HANGERS AND SUPPORTS

- A. Hanger Rods for Noncorrosive Environments: Cadmium-plated steel rods and nuts.
- B. Hanger Rods for Corrosive Environments: Electrogalvanized, all-thread rods or galvanized rods with threads painted with zinc-chromate primer after installation.
- C. Strap and Rod Sizes: Comply with SMACNA's "HVAC Duct Construction Standards - Metal and Flexible," Table 4-1 (Table 4-1M), "Rectangular Duct Hangers Minimum Size," and Table 4-2, "Minimum Hanger Sizes for Round Duct."
- D. Steel Cables for Galvanized-Steel Ducts: Galvanized steel complying with ASTM A 603.
- E. 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.
- F. Duct Attachments: Sheet metal screws, blind rivets, or self-tapping metal screws; compatible with duct materials.
- G. Trapeze and Riser Supports:
  1. Supports for Galvanized-Steel Ducts: Galvanized-steel shapes and plates

## PART 3 - EXECUTION

### 3.1 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 (25 mm), 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 (38 mm).
- K. Where ducts pass through fire-rated interior partitions and exterior walls, install fire dampers. Comply with requirements in 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."

### 3.2 SEAM AND JOINT SEALING

- A. Seal duct seams and joints for duct static-pressure and leakage classes specified in "Performance Requirements" Article, according to SMACNA's "HVAC Duct Construction Standards - Metal and Flexible," Table 1-2, "Standard Duct Sealing Requirements," unless otherwise indicated.

### 3.3 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 (100 mm) thick.
  - 4. Do not use powder-actuated concrete fasteners for lightweight-aggregate concretes or for slabs less than 4 inches (100 mm) thick.
  - 5. Do not use powder-actuated concrete fasteners for seismic restraints.
- C. Hanger Spacing: Comply with SMACNA's "HVAC Duct Construction Standards - Metal and Flexible," Table 4-1 (Table 4-1M), "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 (610 mm) of each elbow and within 48 inches (1200 mm) 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 (5 m).
- 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.
- G. Drilling for and Setting Anchors:
  - 1. Identify position of reinforcing steel and other embedded items prior to drilling holes for anchors. Do not damage existing reinforcement or embedded items during drilling. Notify the Architect if reinforcing steel or other embedded items are encountered during drilling. Locate and avoid prestressed tendons, electrical and telecommunications conduit, and gas lines.
  - 2. Do not drill holes in concrete or masonry until concrete, mortar, or grout has achieved full design strength.
  - 3. Wedge Anchors: Protect threads from damage during anchor installation. Heavy-duty sleeve anchors shall be installed with sleeve fully engaged in the structural element to which anchor is to be fastened.
  - 4. Set anchors to manufacturer's recommended torque, using a torque wrench.
  - 5. Install zinc-coated steel anchors for interior applications and stainless-steel anchors for applications exposed to weather.

### 3.4 STORAGE AND HANDLING

- A. All duct arriving on site shall be externally wrapped.
- B. Duct stored on site shall be installed with un-attached end wrapping.



- C. Ductwork that is determined dirty by the engineer of record shall be cleaned at the cost of the GC.

### 3.5 CONNECTIONS

- A. Make connections to equipment with flexible connectors complying with 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.

### 3.6 DUCT SCHEDULE

- A. Square Duct, Interior -Supply, Exhaust, Return.
  - 1. Exposed: Galvanized, welded joints, paint color by Architect.
  - 2. Concealed: Galvanized, Flanged joints.
- B. Round Duct, Interior Supply, Exhaust, Return.
  - 1. Exposed: Galvanized, spiral, welded joints, paint color by Architect.
  - 2. Concealed: Galvanized, Flanged joints.
  - 3. Acid-Resistant (Fume-Handling) Ducts:
    - a. Type 304, stainless-steel sheet.
    - b. Exposed to View: No. 3 finish.
- C. Square Duct, Exterior -Supply, Exhaust, Return.
  - 1. Galvanized, flanged joints.
  - 2. Acid-Resistant (Fume-Handling) Ducts:
    - a. Type 304, stainless-steel sheet.
    - b. Exposed to View: No. 3 finish.
- D. Intermediate Reinforcement:
  - 1. Galvanized-Steel Ducts: Galvanized steel.
- E. Elbow Configuration:
  - 1. Rectangular Duct: Comply with SMACNA's "HVAC Duct Construction Standards - Metal and Flexible," Figure 2-2, "Rectangular Elbows."
    - a. Velocity 1000 fpm (5 m/s) or Lower:
      - 1) Radius Type RE 1 with minimum 0.5 radius-to-diameter ratio.
      - 2) Mitered Type RE 4 without vanes.

- b. Velocity 1000 to 1500 fpm (5 to 7.6 m/s):
  - 1) Radius Type RE 1 with minimum 1.0 radius-to-diameter ratio.
  - 2) Radius Type RE 3 with minimum 0.5 radius-to-diameter ratio and two vanes.
  - 3) 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."
- c. Velocity 1500 fpm (7.6 m/s) or Higher:
  - 1) Radius Type RE 1 with minimum 1.5 radius-to-diameter ratio.
  - 2) Radius Type RE 3 with minimum 1.0 radius-to-diameter ratio and two vanes.
  - 3) 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," Table 3-1, "Mitered Elbows." Elbows with less than 90-degree change of direction have proportionately fewer segments.
    - 1) Velocity 1000 fpm (5 m/s) or Lower: 0.5 radius-to-diameter ratio and three segments for 90-degree elbow.
    - 2) Velocity 1000 to 1500 fpm (5 to 7.6 m/s): 1.0 radius-to-diameter ratio and four segments for 90-degree elbow.
    - 3) Velocity 1500 fpm (7.6 m/s) or Higher: 1.5 radius-to-diameter ratio and five segments for 90-degree elbow.
  - b. Round Elbows, 12 Inches (305 mm) and Smaller in Diameter: Stamped or pleated.
  - c. Round Elbows, 14 Inches (356 mm) and Larger in Diameter: Standing seam.
- F. Branch Configuration:
  - 1. Rectangular Duct: Comply with SMACNA's "HVAC Duct Construction Standards - Metal and Flexible," Figure 2-6, "Branch Connections."
    - a. Rectangular Main to Rectangular Branch: 45-degree entry.
    - b. Rectangular Main to Round Branch: Spin in.
  - 2. Round: Comply with SMACNA's "HVAC Duct Construction Standards - Metal and Flexible," Figure 3-4, "90 Degree Tees and Laterals," and Figure 3-5, "Conical Tees." Saddle taps are permitted in existing duct.
    - a. Velocity 1000 fpm (5 m/s) or Lower: 90-degree tap.

- b. Velocity 1000 to 1500 fpm (5 to 7.6 m/s): Conical tap.
- c. Velocity 1500 fpm (7.6 m/s) or Higher: 45-degree lateral.

END OF SECTION 233113

*(This page intentionally left blank)*