

# **SUBMITTALS**

**For**

## **DoubleWall Spiral Pipe**

**From**

**DUCTS**  
**ON**  
**DEMAND**

***Custom Manufactured Ducts and Supplies***

***5580 W. Mill Rd. Raymond, NE. 68428***

**JOB:**

**Location:**

**Architect:**

**Engineer:**

**Representative:**

**Contractor:**

**Date Submitted:**



## SUBMITTAL DATA

Double Wall

1 - 10 inch WG Standard

Based on 1995 SMACNA 2nd Edition

PIPE GAUGES		
Double Wall	Minimum Gauge	
DIA (inches)	Inner	Outer
4-16	26	26
18-26	26	24
28-36	26	22
38-48	22	20
50-80	22	18

FITTING GAUGES		
Double Wall	Minimum Gauge	
DIA (inches)	Inner	Outer
4-10	26	26
12-16	26	24
18-26	26	22
28-50	22	20
52-60	22	18
65-80	22	16

Based on 1995 SMACNA 3rd Edition

PIPE GAUGES		
Double Wall	Minimum Gauge	
DIA (inches)	Inner	Outer
4-24	26	26
26-42	26	24
44-66	26	22
68-96	22	20

FITTING GAUGES		
Double Wall	Minimum Gauge	
DIA (inches)	Inner	Outer
4-10	26	26
12-16	26	24
18-26	26	22
28-50	22	20
52-60	22	18
65-80	22	16

\*\*\*Actual gauge will be determined by the job pressure class as specified.

\*\*\*All metal gauges and construction standards meet or exceed ASTM, SMACNA and ASHRAE standards.

### DoubleWall Spiral Pipe

DoubleWall Round Spiral duct is constructed of an inner spiral pipe shell and a 1" layer of fiberglass insulation (unless other wise specified). The inner shell can be produced from either perforated or non-perforated materials. Perforations will be 3/32" in diameter with an overall open area of 23%.

DoubleWall is produced using spiral lockseam construction. Standard lengths are 10'; other sizes up to 20' are available. All materials meet or exceed ASTM, SMACNA, and ASHRAE standards. DoubleWall spiral duct will have a maximum thermal conductivity (k) of 0.27 BTU per hour per degree Fahrenheit per inch thickness at 75° F.

DoubleWall spiral pipe should be ordered specifying the pipe ID dimension (20" ID creates a 22" outer shell for 1" insulation).

## **DoubleWall Spiral Fittings**

Standing seam joints are used wherever possible on fittings. Where a standing seam is not possible, joints will be spot welded, riveted, or fully welded. Where applicable seams will be sealed inside the fitting with an industry approved sealant.

DoubleWall fittings are constructed with an inner shell of perforated or non-perforated metal, a 1" layer of fiberglass (unless other wise specified) insulation, and an outer fitting shell. Perforations will be 3/32" in diameter with an overall open area of 23%. DoubleWall spiral fittings will have a maximum thermal conductivity (k) of 0.27 BTU per hour per degree Fahrenheit per inch thickness at 75° F.

DoubleWall fittings should be ordered specifying the fitting ID dimension (20" ID creates a 22" outer shell for 1" insulation).

## **DoubleWall Connections**

DoubleWall Fittings will be constructed as **SPECIFIED BY THE ORDERED CONNECTION METHOD**. Inner and outer duct and fitting liners can be connected using slip couplings or flanged type connections. Flanged types, such as SpiralMate or equivalent, are recommended for diameters greater than 34". Flanged type connections can be used for all diameters if desired.

- ***DoubleWall Slip Connections (standard unless other wise specified)***

*DoubleWall fittings and elbows are designed and built to slip inside spiral pipe. Fittings have a stop bead to locate fitting inside pipe. Fittings are constructed with the inner liner extended 2" past the outer shell to create an inner liner coupling for duct-to-fitting connections. Pipe-to-Pipe connections use a DoubleWall slip coupling with an inner liner that extends 2" past the outer coupling edge.*

- ***DoubleWall Flanged Connections***

*Flanged connections are strongly recommended for round duct and fittings with diameters greater than 34 inches. When flanged connections are desired, the customer must specify at the time of order the type of flange preferred. SpiralMate or equivalents are typical and most commonly used by most customers. Angle rings, although less common, are always available. Flanges are typically supplied loose, however, installation may be arranged at the time of order.*