Policies

Product Return Policy

All spiral, oval and rectangular duct products are made to order. Items cannot be cancelled once fabricated and are not subject to return.

Products shipped that are damaged in transit are able to be returned or exchanged only when noted at the time of delivery.

Shortage/Overage Policy

Snap-Rite Manufacturing requires any shortages or overages to be reported within 24 hours of delivery.
Low Pressure Galvanized Fittings

Fittings are fabricated from hot-dipped galvanized steel in gauges that equal or exceed SMACNA standards. (See table at right)

**Key to Dimensions**
- A – Main Inlet Diameter
- B – Main Outlet Diameter
- C, D – Branch Outlet Diameters
- LR – Installed Length of Reducer

**Note “A”**
The barrel for a reducing tee or lateral will be made of one piece where dimensions permit. Where “C” or “D” is greater than “B” a straight barrel and reducer will be supplied.

### High Pressure Fittings

Fittings are made of hot-dipped galvanized steel. Joints may be solid welded or spot welded and bonded. All welded joints will be coated with a protective paint, inside and out, to prevent damage to the galvanized surface. Spot-welded fittings will have all joints sealed with a UL-Classified zero flame spread and zero smoke developed cement specially formulated for bonding metal-to-metal joints.

**Available Options**
- PCD (Polyvinyl Coated Ducts)
  - 4x1 / 4x4 / 4x1 Reverse
  - Stainless Steel
  - Aluminum
  - Galvaneal (Paint Grip)
  - Dual Wall Insulated
  - Dust Collection
  - Welded Pipe
  - Black Iron

**Consult Factory**
- Angle Rings
- Single & Double Wall Flanges
- Access Doors
- Vanstone (Factory Installed Rings)
- Factory Mounted Saddle Taps
- Gasketed Fittings (Self Sealing)
Weight and Gauge Chart

A complete line of slip-joint fittings, designed especially for use with spiral pipe, includes many types of elbows, crosses, tees, laterals, reducers and various accessories.

Spiral pipe is joined by means of couplings and sealed with duct sealer. Sheet metal screws or pop rivets are used at maximum 1.5” intervals, with a minimum of three fasteners per joint. These hold the fittings and joints in place while the sealant cures.

<table>
<thead>
<tr>
<th>NOMINAL US STANDARD GAUGE</th>
<th>NOMINAL US STANDARD GAUGE</th>
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<tbody>
<tr>
<td>DIAM</td>
<td>26 GAUGE LBS/FT</td>
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<td>12.4</td>
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</table>

Typical Coupling Slip Joint

Typical Fitting Slip Joint

Standard SMACNA gauges (grey areas) will be supplied unless ordered otherwise. Standard lengths are 10ft. Shorter and longer lengths can be made to order at extra cost.
(SPC) COUPLING - MALE
FITS INTO PIPE

(SPCF) COUPLING - FEMALE
PIPE SIZE

(EC) END CAP - MALE
FITS INTO PIPE

(RED) REDUCER
(CONCENTRIC)
LR = A - B (4" MIN.)

(ERED) REDUCER
(ECCENTRIC)
LR = A - B (6" MIN.)

REGISTER TAKEOFFS
ORDER TAKEOFFS BY
REGISTER SIZE ONLY
(RI / RO)

(SH 90") SHOE TAP

(ST45) 45" LATERAL TAP
Short Throat Elbows
C.L. RADIUS = 1A
These elbows are standards for low pressure systems. Elbows with other throat radii can be ordered.

(G-30) 30” ELBOW
(G-45) 45” ELBOW
(G-60) 60” ELBOW
(G-90) 90” ELBOW

Long Throat Elbows
C.L. RADIUS = 1 ½ A

(G-30L) 30” ELBOW
(G-45L) 45” ELBOW
(G-60L) 60” ELBOW
(G-90L) 90” ELBOW

(G-90T) 90” MITERED ELBOW WITH TURNING VANES
(M-90)
(T) 90° TEE

(RT) TEE WITH REDUCING BARREL

(RTR) TEE WITH REDUCER

(TT) CROSS
L = LARGEST OF “C” OR “D” PLUS 2"

(RTT) CROSS WITH REDUCING BARREL

(RTTR) CROSS WITH REDUCER
P.C.D. Underground and Fume Exhaust

P.C.D. is made by coating hot-dipped galvanized steel with an epoxy primer and then applying a 4 mil polyvinyl coating to one side to make 4 x 1 P.C.D. or both sides to make 4 x 4 P.C.D.

### P.C.D. Spiral Ducts - Weight and Gauge Chart

<table>
<thead>
<tr>
<th>DIAM</th>
<th>26 GAUGE LBS/FT</th>
<th>24 GAUGE LBS/FT</th>
<th>22 GAUGE LBS/FT</th>
<th>20 GAUGE LBS/FT</th>
<th>18 GAUGE LBS/FT</th>
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<td>12.9</td>
<td>17.1</td>
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</tr>
</tbody>
</table>

Standard length of duct is 10 feet. Shorter and longer lengths can be made to order.

### 4 x 1 P.C.D.

- Used for underground systems, it has the 4-mil polyvinyl coating on the outside for protection from the soil.

### 4 x 1 Reverse P.C.D.

- Has the 4-mil coating on the inside. Used for above-ground fume exhaust systems.

### 4 x 4 P.C.D.

- Has the 4-mil polyvinyl coating on both sides. Used where maximum protection is wanted both inside and outside.

### Minimum Gauges* for Underground Ducts and Fittings:

<table>
<thead>
<tr>
<th>DIAMETER</th>
<th>GAUGE</th>
</tr>
</thead>
<tbody>
<tr>
<td>4&quot; THRU 8&quot;</td>
<td>26 GAUGE</td>
</tr>
<tr>
<td>9&quot; THRU 16&quot;</td>
<td>24 GAUGE</td>
</tr>
<tr>
<td>18&quot; THRU 24&quot;</td>
<td>22 GAUGE</td>
</tr>
<tr>
<td>26&quot; THRU 32&quot;</td>
<td>20 GAUGE</td>
</tr>
<tr>
<td>34&quot; THRU 50&quot;</td>
<td>18 GAUGE</td>
</tr>
</tbody>
</table>

*Gauges equal or exceed SMACNA standards

### Minimum Gauges* for Above Ground Ducts and Fittings:

<table>
<thead>
<tr>
<th>DIAMETER</th>
<th>GAUGE</th>
</tr>
</thead>
<tbody>
<tr>
<td>4&quot; THRU 8&quot;</td>
<td>26 GAUGE</td>
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<tr>
<td>16&quot; THRU 26&quot;</td>
<td>24 GAUGE</td>
</tr>
<tr>
<td>28&quot; THRU 36&quot;</td>
<td>22 GAUGE</td>
</tr>
<tr>
<td>38&quot; THRU 50&quot;</td>
<td>20 GAUGE</td>
</tr>
<tr>
<td>52&quot; THRU 60&quot;</td>
<td>18 GAUGE</td>
</tr>
</tbody>
</table>

### Tapes & Sealers

#### P.C.D. Tape
- Thick polyethylene backing
- Strong & permanent
- For use above or below ground
- Superior adhesive quality even in hot or cold weather
- Available in rolls 2” x 108ft.

#### P.C.D. #8 Duct Sealer
- For positive sealing of joints and fittings on underground or fume exhaust installations
- Impervious to most corrosive atmospheres
- Available in cartridges and gallon cans

#### P.C.D. Touch-Up
- A special formula of polyvinyl chloride for air drying for quick scratch repair
- Available in aerosol spray cans and quart cans (brush on)
### Table 3-2A
ROUND DUCT GAGE UNREINFORCED POSITIVE PRESSURE

<table>
<thead>
<tr>
<th>MAX. DIA.</th>
<th>SPIRAL SEAM</th>
<th>LONG. SEAM</th>
</tr>
</thead>
<tbody>
<tr>
<td>6&quot;</td>
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<td>51-60&quot;</td>
<td>18</td>
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<tr>
<td>61-84&quot;</td>
<td>18</td>
<td>16</td>
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</tbody>
</table>

+ 10" W.G.

### Table 3-3
ALUMINUM ROUND DUCT GAGE SCHEDULE

<table>
<thead>
<tr>
<th>DUCT DIAMETER IN INCHES</th>
<th>MAXIMUM 2&quot; W.G. STATIC POSITIVE</th>
<th>MAXIMUM 2&quot; W.G. STATIC NEGATIVE</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>SPIRAL SEAM GAGE</td>
<td>LONGITUDINAL SEAM GAGE</td>
</tr>
<tr>
<td>3 THRU 8</td>
<td>.025&quot;</td>
<td>.032&quot;</td>
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<tr>
<td>9 THRU 14</td>
<td>.025&quot;</td>
<td>.032&quot;</td>
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<tr>
<td>15 THRU 26</td>
<td>.032&quot;</td>
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<tr>
<td>27 THRU 36</td>
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<tr>
<td>37 THRU 50</td>
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<td>.063&quot;</td>
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<tr>
<td>51 THRU 60</td>
<td>.063&quot;</td>
<td>.071&quot;</td>
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<tr>
<td>61 THRU 84</td>
<td>N.A.</td>
<td>.090&quot;</td>
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</tbody>
</table>
Hangers
Available in any size or material, every project needs them!

**Strap/Economy Hanger:** Most economical and easy to use, strap not included

**Tear Drop Hanger:** Most popular, 9/16” hole, rod not included

**Wall Mount:** 9/16” holes and mounting plate, very popular with dust collection and vertical installations, depth of mounting plate variable to fit your needs

**Double Rod/Half Double Rod:** 9/16” hole, rod not included, half double rod also available upon request

---

**Oval**

Eg: A 24x12 FOE-90-5 is a “Hard-Bend” or a “Long Way” flat oval 90° elbow. A 12x24 FOE-90-5 is a “Easy Bend” or “Short Way” flat oval 90° elbow.

Conical fittings taper only on the plan side.

Flat Oval duct is to be used in a positive pressure applications only.
Oval Spiral Duct & Fittings

(OHT) Oval Bull Head Tee

(OSP) Oval Spiral Pipe

(OCR) Oval Concentric Reducer

(OST) Oval Saddle Top

(45OL) 45” Oval Lateral

(OCT) Oval Conical Tee

(OER) Oval Eccentric Reducer

(OEC) Oval End Cap

(OC) Oval Coupling
# Flat Oval Duct & Fitting Sizes

## STANDARD SIZING CHART
FOR EVEN SIZES 6” - 36” MINOR AXIS

## NOMINAL FLAT OVAL PIPE SIZES

<table>
<thead>
<tr>
<th>MINOR AXIS</th>
<th>6”</th>
<th>8”</th>
<th>10”</th>
<th>12”</th>
<th>14”</th>
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Rectangular Duct

We use the latest software and state of the art equipment to fabricate duct. This allows us to provide incredibly short lead-times and competitive pricing, while maintaining the highest level of quality.

Straight duct is fabricated in numerous configurations. Upon request, sealant can be applied inside of longitudinal seams. All duct is shipped unassembled unless assembly is requested. We have coil lines that fabricate straight duct with the following options:

<table>
<thead>
<tr>
<th>Material</th>
<th>Thickness</th>
<th>Length</th>
<th>Seam</th>
<th>Connection</th>
</tr>
</thead>
<tbody>
<tr>
<td>Galvanized</td>
<td>26 - 18 ga</td>
<td>4', 5'</td>
<td>Snaplock</td>
<td>TDF - S&amp;D - Raw</td>
</tr>
<tr>
<td>Paint Grip</td>
<td>26 - 18 ga</td>
<td>5'</td>
<td>Pittsburgh</td>
<td></td>
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<tr>
<td>PVC</td>
<td>24 - 18 ga</td>
<td>5'</td>
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<tr>
<td>Aluminum</td>
<td>.032 - .050</td>
<td>5'</td>
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<tr>
<td>Stainless Steel</td>
<td>24 - 20 ga</td>
<td>5'</td>
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</table>

**Fittings**

Snap-Rite manufactures rectangular fittings in most sizes & configurations. Fittings are manufactured on our state of the art fabrication equipment. All fittings are fabricated with stiffening beads on duct sizes 19” wide and larger which have more than 10 square feet of unbraced panel. Fittings shall be beaded unless duct will have an insulation covering or an acoustical liner. This requirement is applicable to 20 gauge or less in thickness and 3” W.G. or less. Most all fittings are fabricated with Pittsburgh seams. Fittings are available completely assembled with all accessories (reinforcement, vane & rail, etc...) installed. Fittings are also available knocked down to reduce shipping and handling costs.

**SMACNA-Standards**

Snap-Rite will fabricate all duct & fittings to meet or exceed SMACNA standards.

**TDF Flanged Connection**

Transverse Duct Flange is a 4 bolt duct connection system that eliminates time and waste. Rather than using separate connectors to assemble your system, TDF flanges are roll-formed onto duct during the manufacturing process. This connection minimizes leakage and installation costs. All necessary hardware will be delivered with your order to ensure that you have everything you need to hang your ductwork.

**Slip & Drive Connection**

Snap-Rite manufactures all slip and drive connectors you need to meet your specifications. Connectors can be shipped cut-to-length at your request to minimize field assembly time and reduce material waste costs.

**Seams & Sealant**

Rectangular duct is fabricated using Snaplock or Pittsburgh lock longitudinal seams. Upon request, sealant can be applied inside of the lock seam.

**Duct Liner**

Snap-Rite stocks a large amount of duct liner. You may specify thickness, density, and material to meet your specifications. Anything from 1/2” up to 2” thickness is available upon your request.

**Internal & External Reinforcements**

Snap-Rite will reinforce duct with internal tie rods or external angle iron in accordance with SMACNA standards or per your specifications.

**Assembly**

Snap-Rite will ship ductwork with any of the above options to your job site knocked down. Upon request, we will assemble your ductwork prior to shipment for an additional charge. This greatly reduces field labor time and helps minimize and control your costs in a competitive marketplace.

**Plastic Wrap**

When required, all duct opening and pallets of material will be protected with self-adhesive and puncture resistant plastic wrap to prevent the intrusion of contaminants.
Seams & Connectors

Connector Types

DRIVE SLIP
HEMMED “S” SLIP
STANDING S
WELD FLANGE
COMPANION ANGLES
TDF FLANGED (with gasket)

Seam Types

PITTSBURGH LOCK
BUTTON PUNCH SNAP LOCK
LAP SEAM
STANDING SEAM
SINGLE CORNER SEAM
CORNER WELD
Standards

TDF Connection

Recommended Clip Spacing

60” duct  
4 clips required

48” duct  
3 clips required

36” duct  
3 clips required

24” duct  
2 clips required

18” duct and smaller  
1 clip required

Method of Fabrication:
Two “L” shaped sections are assembled in the field to form the finished joint of ductwork. This allows ductwork to be shipped in knocked down condition requiring less cartage space and easier handling. Wrap around fabrication also available.

44 - 56” finished length with TDF
47 - 59” finished length with drive cleat edges
60” length with ends unfinished

Straight Duct
Concentric Transition

- TDF
- S&D
- Raw
- Dimensions are O.D.

Top or Bottom Flat Transition

- TDF
- S&D
- Raw
- Dimensions are O.D.

Transition
(Top & Left Sides Flat)

- TDF
- S&D
- Raw
- Dimensions are O.D.

Transition
(Top & Right Sides Flat)

- TDF
- S&D
- Raw
- Dimensions are O.D.
Radius Offset

- TDF
- S&D
- Raw
- Dimensions are O.D.

Offset

- TDF
- S&D
- Raw
- Dimensions are O.D.

Reducing Offset

- TDF
- S&D
- Raw
- Dimensions are O.D.

Reducing Offset (Left or Right)

- TDF
- S&D
- Raw
- Dimensions are O.D.
Square Throat Elbow

- TDF
- S&D
- Raw
- Dimensions are O.D.

Radius Elbow

- TDF
- S&D
- Raw
- Dimensions are O.D.

Radius Elbow (With Square Throat)

- TDF
- S&D
- Raw
- Dimensions are O.D.

Reducing Radius Elbow (Left or Right)

- TDF
- S&D
- Raw
- Dimensions are O.D.
Square Throat Angle

- TDF
- S&D
- Raw
- Dimensions are O.D.

Radius Angle

- TDF
- S&D
- Raw
- Dimensions are O.D.

Straight 90° Tap

- TDF
- S&D
- Raw
- Dimensions are O.D.

90° Increased Tap

- TDF
- S&D
- Raw
- Dimensions are O.D.
Bullhead Tee

- TDF
- S&D
- Raw
- Dimensions are O.D.

Y-Branch

- TDF
- S&D
- Raw
- Dimensions are O.D.

Pants

- TDF
- S&D
- Raw
- Dimensions are O.D.

Pants

- TDF
- S&D
- Raw
- Dimensions are O.D.
Remember: When Quality Counts - Ask for Snap-Rite®
Manufacturing, Inc.
Full Line - HVAC - Residential & Commercial Air Duct Manufacturer
SPIRAL PIPE, ELBOWS, FITTINGS, RECTANGULAR DUCT, OVAL SPIRAL PIPE & FITTINGS

www.snaprite.com

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FX: (229) 559-9965

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Coats, NC 27521
PH: (910) 897-4080
FX: (910) 897-0355

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