

Snap-Rite[®]
Manufacturing, Inc.
A GRAY CO.



**SPIRAL, OVAL & RECTANGULAR DUCT
CATALOG**

Coats, NC

Lake Park, GA



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.

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Low Pressure Galvanized Fittings

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

DIAMETER	FITTINGS MINIMUM GAUGE
3" THRU 14"	26
15" THRU 26"	24
28" THRU 36"	22
38" THRU 50"	20
52" THRU 60"	18

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.

DIAMETER	FITTINGS MINIMUM GAUGE
3" THRU 14"	22
15" THRU 36"	20
37" THRU 60"	18

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

NOMINAL US STANDARD GAUGE

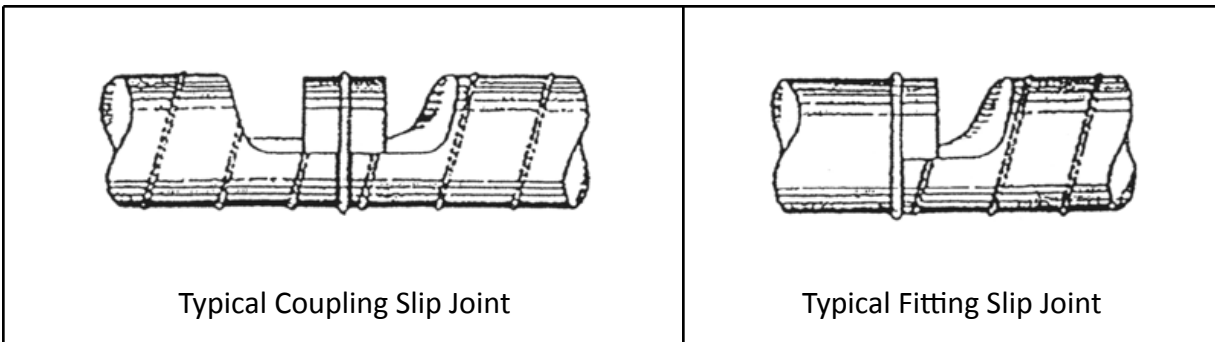
DIAM	26 GAUGE LBS/FT	24 GAUGE LBS/FT	22 GAUGE LBS/FT	20 GAUGE LBS/FT	18 GAUGE LBS/FT	16 GAUGE LBS/FT
3"	0.8	1.1	1.3	1.5		
4"	1.1	1.4	1.7	2.0		
5"	1.4	1.7	2.1	2.5	3.4	
6"	1.6	2.0	2.5	3.0	3.9	4.8
7"	1.9	2.4	2.9	3.4	4.6	5.6
8"	2.1	2.8	3.3	3.9	5.2	6.4
9"	2.4	3.1	3.8	4.4	5.9	7.2
10"	2.6	3.4	4.2	4.9	6.5	8.0
11"	2.9	3.8	4.6	5.4	7.1	9.1
12"	3.2	4.1	5.0	5.9	7.8	9.6
13"	3.4	4.5	5.4	6.4	8.5	10.7
14"	3.7	4.8	5.8	6.9	9.1	11.2
15"		5.1	6.2	7.4	9.8	12.5
16"		5.5	6.6	7.8	10.4	12.8
17"		5.8	7.1	8.3	11.1	13.3
18"		6.1	7.5	8.8	11.7	14.4
20"		6.8	8.3	9.8	13.0	16.0
22"		7.5	9.1	10.8	14.3	15.6
24"		8.2	9.9	11.7	15.6	19.2
26"		8.9	10.8	12.7	16.9	20.8
28"			11.6	13.7	18.2	22.4
30"			12.4	14.6	19.5	24.0

DIAM	22 GAUGE LBS/FT	20 GAUGE LBS/FT	18 GAUGE LBS/FT	16 GAUGE LBS/FT
32"	13.3	15.6	20.8	25.6
34"	14.1	16.6	22.0	27.9
36"	14.9	17.6	23.3	28.8
38"		18.5	24.6	29.8
40"		19.5	25.9	32.0
42"		20.5	27.2	33.5
44"		21.5	28.5	35.2
46"		22.5	29.8	36.7
48"		23.4	31.1	38.3
50"		24.5	32.4	40.0
52"		25.3	33.7	41.6
54"			35.0	43.2
56"			36.3	44.8
58"			37.6	46.4
60"			38.8	48.0
62"			41.1	50.7
64"			43.4	53.4
66"			44.7	55.1
68"			46.1	56.7
70"			47.4	58.4
72"			48.8	60.1

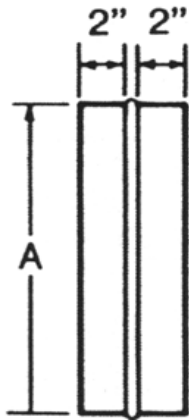
*SPIRAL PIPE IS AVAILABLE UP TO 90" DIAMETER

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.

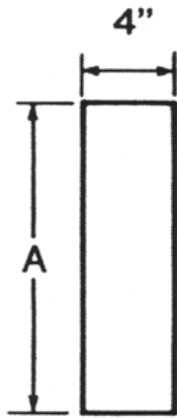
Spiral pipe is joined by means of couplings and sealed with duct sealer. Sheet metal screws or pop rivets are used at maximum 1.5" intervals, with a minimum of three fasteners per joint. These hold the fittings and joints in place while the sealant cures.



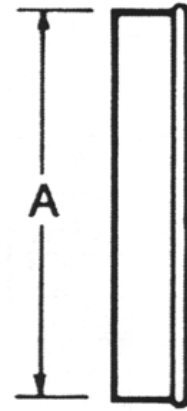
Standard SMACNA gauges (grey areas) will be supplied unless ordered otherwise. Standard lengths are 10ft. Shorter and longer lengths can be made to order at extra cost.



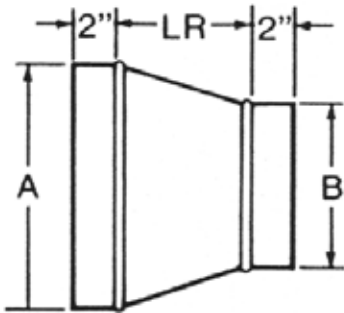
(SPC) COUPLING - MALE
 FITS INTO PIPE



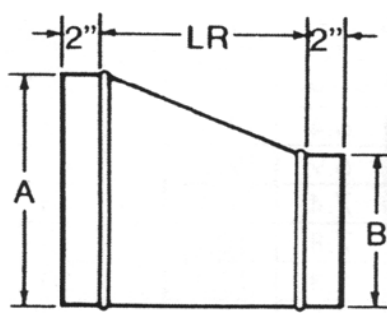
(SPCF) COUPLING - FEMALE
 PIPE SIZE



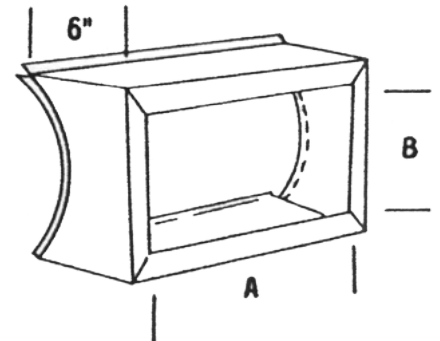
(EC) END CAP - MALE
 FITS INTO PIPE



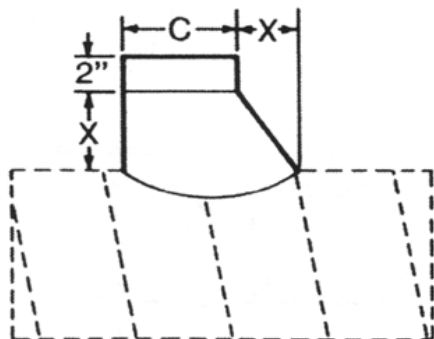
(RED) REDUCER
 (CONCENTRIC)
 $LR = A - B$ (4" MIN.)



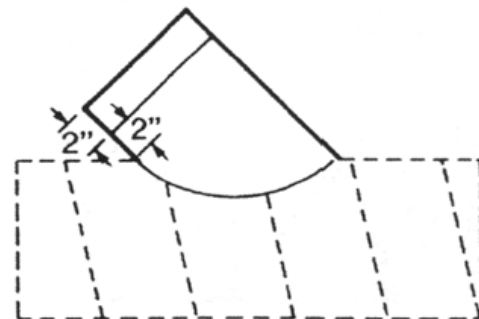
(ERED) REDUCER
 (ECCENTRIC)
 $LR = A - B$ (6" MIN.)



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



(SH 90) SHOETAP

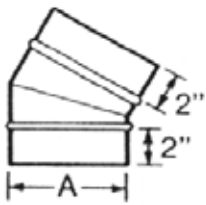


(ST45) 45 LATERAL TAP

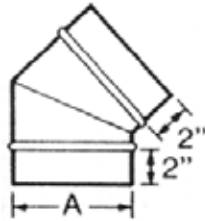
Short Throat Elbows

C.L. RADIUS = 1A

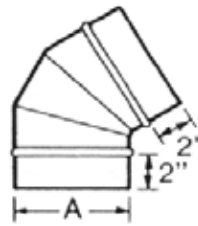
These elbows are standards for low pressure systems. Elbows with other throat radii can be ordered.



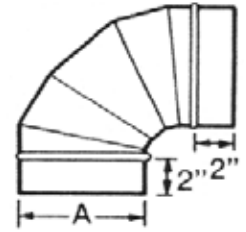
(G-30)
 30° ELBOW



(G-45)
 45° ELBOW



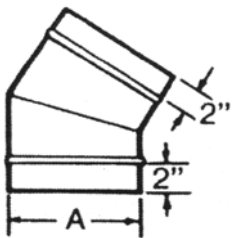
(G-60)
 60° ELBOW



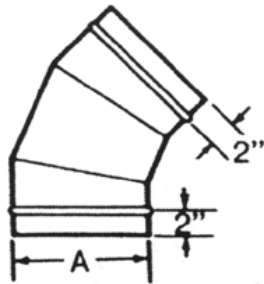
(G-90)
 90° ELBOW

Long Throat Elbows

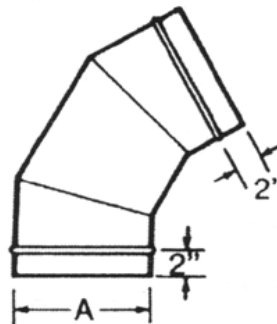
C.L. RADIUS = 1 1/2 A



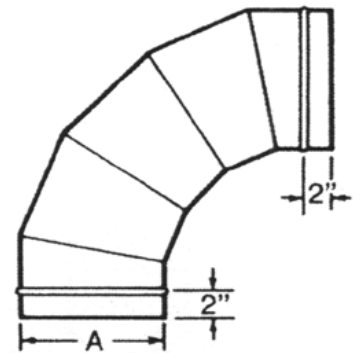
(G-30L)
 30° ELBOW



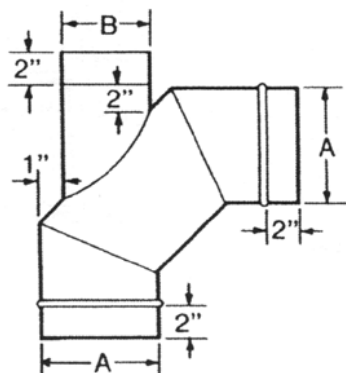
(G-45L)
 45° ELBOW



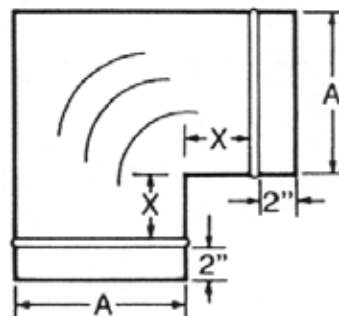
(G-60L)
 60° ELBOW



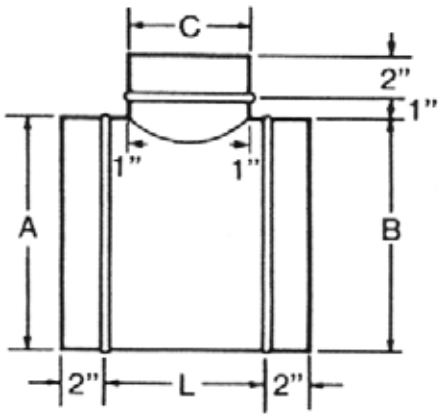
(G-90L)
 90° ELBOW



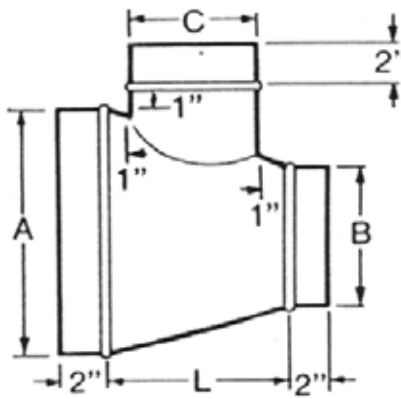
(G-90T)



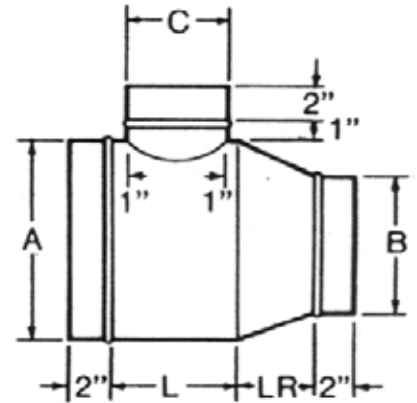
(M-90)
 90° MITERED ELBOW WITH TURNING VANES



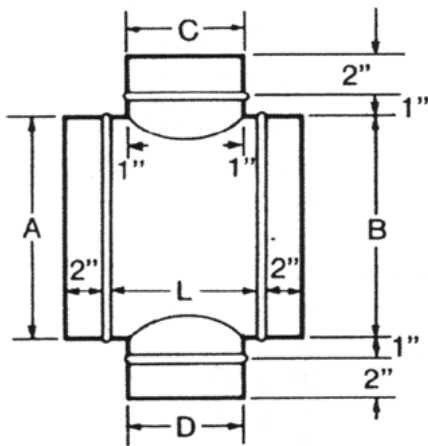
(T) 90° TEE



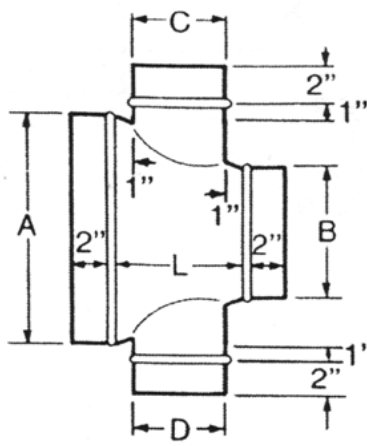
(RT) TEE
 WITH REDUCING BARREL



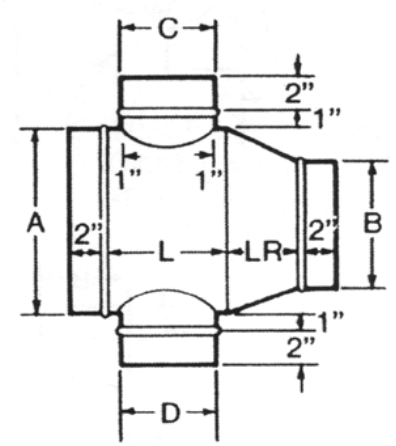
(RTR) TEE WITH REDUCER



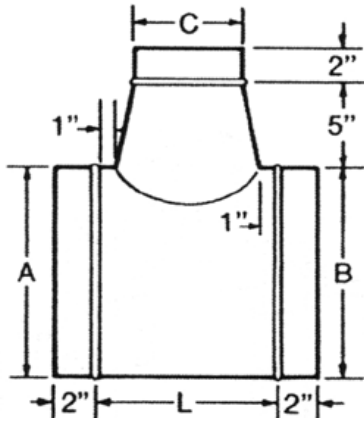
(TT) CROSS
 L = LARGEST OF "C" OR "D" PLUS 2"



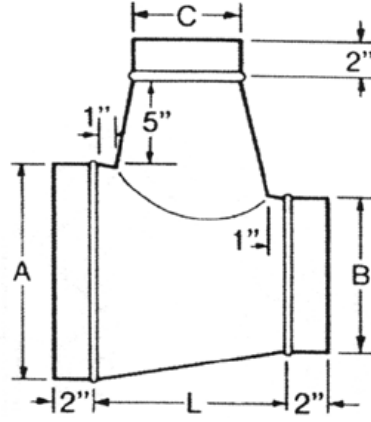
(RTT) CROSS
 WITH REDUCING BARREL



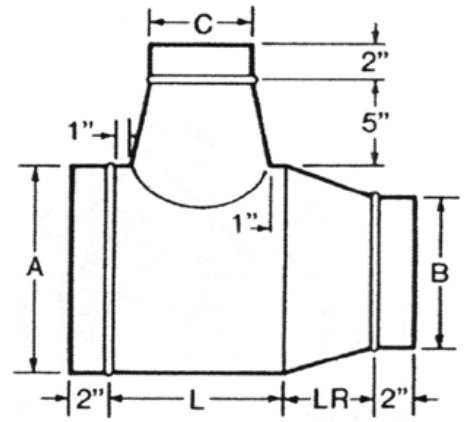
(RTTR) CROSS WITH REDUCER



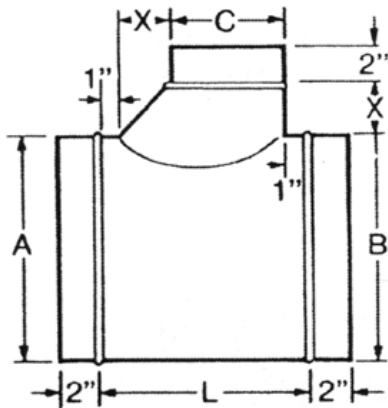
(CT) CONICAL TEE



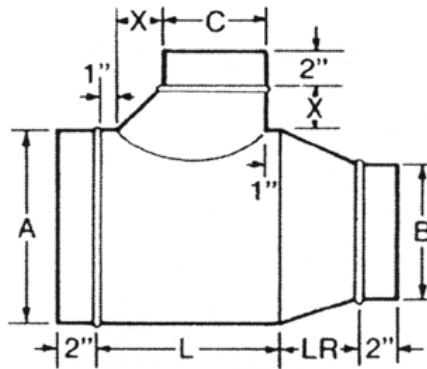
(CTR) CONICAL TEE
 WITH REDUCING BARREL



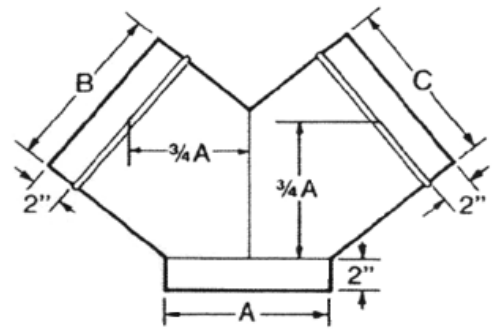
(CTRR) CONICAL TEE
 WITH REDUCER



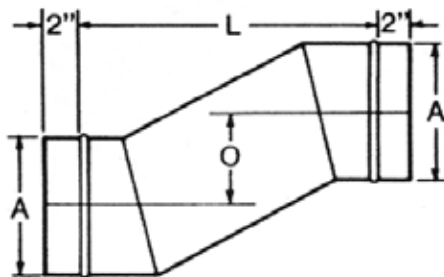
(SHT) SHOE TEE



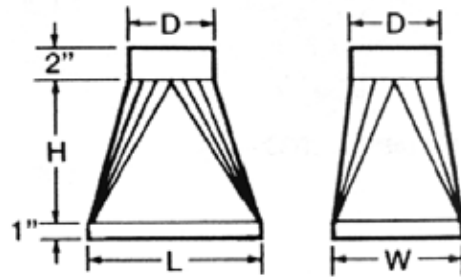
(SH&R) SHOE TEE
 WITH REDUCER



(Y) - WYE



(OS) - OFFSET



(SQRD) - SQUARE-TO-ROUND TRANSITION

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

DIAM	26 GAUGE LBS/FT	24 GAUGE LBS/FT	22 GAUGE LBS/FT	20 GAUGE LBS/FT	18 GAUGE LBS/FT
4"	1.1	1.4	1.7	2.0	2.6
5"	1.4	1.7	2.1	2.5	3.2
6"	1.6	2.0	2.5	3.0	4.0
7"	1.9	2.4	2.9	3.5	4.7
8"	2.2	2.8	3.4	4.0	5.3
9"	2.5	3.1	3.8	4.5	6.0
10"	2.7	3.5	4.3	5.0	6.6
12"	3.3	4.2	5.1	6.0	7.9
14"	3.8	4.9	5.9	7.0	9.2
16"	4.4	5.6	6.7	7.9	10.5
18"	5.0	6.2	7.6	8.9	11.8
20"	5.3	7.0	8.5	10.0	13.2
22"		7.7	9.3	11.0	14.5
24"		8.4	10.1	11.9	15.8
26"		9.1	11.0	12.9	17.1

DIAM	24 GAUGE LBS/FT	22 GAUGE LBS/FT	20 GAUGE LBS/FT	18 GAUGE LBS/FT
28"	9.7	11.8	13.9	18.4
30"	10.4	12.6	14.8	19.7
32"	11.1	13.5	15.8	21.0
34"	11.9	14.4	16.9	22.3
36"	12.7	15.3	18.0	23.8
38"		16.1	18.9	25.0
40"		16.8	19.8	26.2
42"		17.7	20.8	27.5
44"		18.5	21.8	28.8
46"		19.3	22.8	30.2
48"		20.3	23.7	31.5
50"		21.1	24.9	32.8
52"		21.9	25.8	34.1
56"		23.5	27.7	36.8
60"		25.3	29.7	39.5

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

4 x 1 P.C.D. is 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:

DIAMETER	GAUGE
4" THRU 8"	26 GAUGE
9" THRU 16"	24 GAUGE
18" THRU 24"	22 GAUGE
26" THRU 32"	20 GAUGE
34" THRU 60"	18 GAUGE

*Gauges equal or exceed SMACNA standards

Minimum Gauges* for Above Ground Ducts and Fittings:

DIAMETER	GAUGE
4" THRU 8"	26 GAUGE
16" THRU 26"	24 GAUGE
28" THRU 36"	22 GAUGE
38" THRU 50"	20 GAUGE
52" THRU 60"	18 GAUGE

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		
	+ 10" W.G.	
MAX. DIA.	SPIRAL SEAM	LONG. SEAM
6"	28	28
8"	28	26
10"	28	26
12"	26	24
14"	26	24
16"	24	22
18"	24	22
19-26"	24	22
27-36"	22	20
37-50"	20	20
51-60"	18	18
61-84"	18	16

TABLE 3-3				
ALUMINUM ROUND DUCT GAGE SCHEDULE				
	MAXIMUM 2" W.G. STATIC POSITIVE		MAXIMUM 2" W.G. STATIC NEGATIVE	
DUCT DIAMETER IN INCHES	SPIRAL SEAM GAGE	LONGITUDINAL SEAM GAGE	SPIRAL SEAM GAGE	LONGITUDINAL SEAM GAGE
3 THRU 8	.025"	.032"	.025"	.040"
9 THRU 14	.025"	.032"	.032"	.040"
15 THRU 26	.032"	.040"	.040"	.050"
27 THRU 36	.040"	.050"	.050"	.063"
37 THRU 50	.050"	.063"	.063"	.071"
51 THRU 60	.063"	.071"	N.A.	.090"
61 THRU 84	N.A.	.090"	N.A.	N.A.

Hangers

Available in any size or material, every project needs them!

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



Strap/Economy



Tear Drop

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



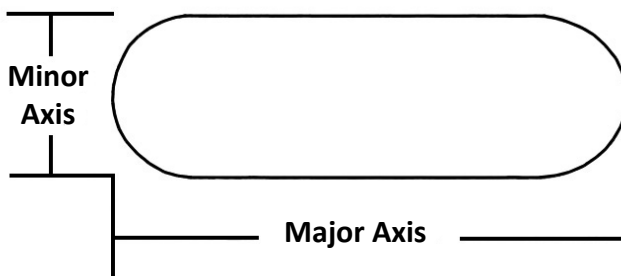
Wall Mount



Double Rod/
Half Double Rod

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

Oval

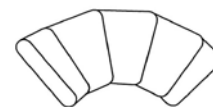


Eg: A 24x12 FOE-90-5 is a "Hard-Bend" or a "Long Way" flat oval 90° elbow.

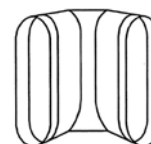
A 12x24 FOE-90-5 is a "Easy Bend" or "Short Way" flat oval 90° elbow.

Conical fittings taper only on the plan side.

Flat Oval duct is to be used in a positive pressure applications only.

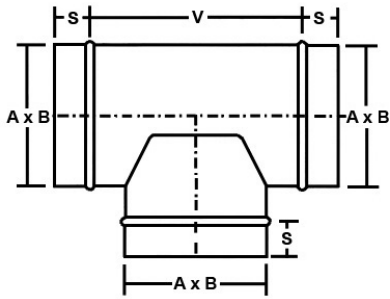


Hard Bend
(OHB90)

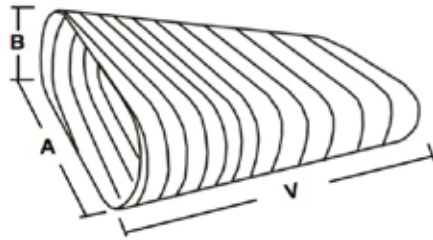


Easy Bend
(OEB90)

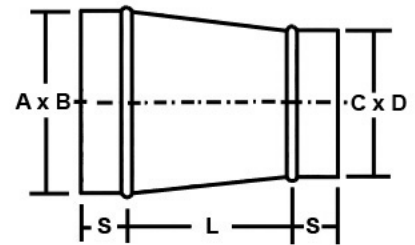
Oval Spiral Duct & Fittings



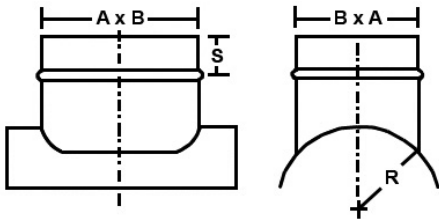
(OBHT) OVAL BULL HEAD TEE



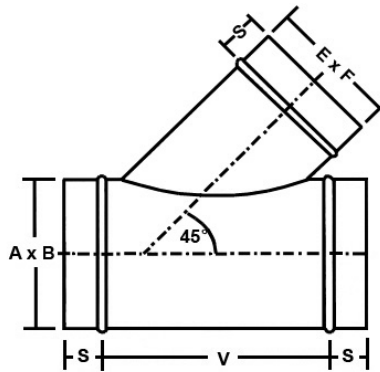
(OSP) OVAL SPIRAL PIPE



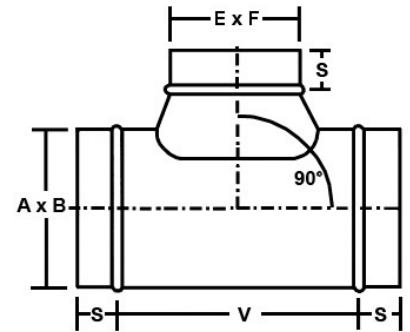
(OCR) OVAL CONCENTRIC REDUCER



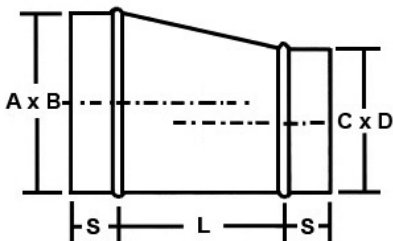
(OST) OVAL SADDLE TOP



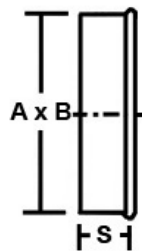
(45OL) 45° OVAL LATERAL



(OCT) OVAL CONICAL TEE

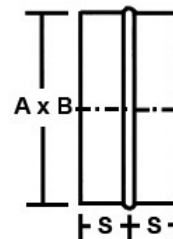


(OER) OVAL ECCENTRIC REDUCER

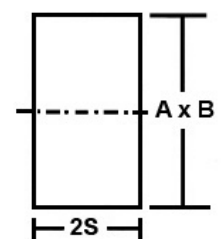


(OEC) OVAL END CAP

PIPE TO PIPE



FITTING TO FITTING



(OC) OVAL COUPLING

Flat Oval Duct & Fitting Sizes

STANDARD SIZING CHART FOR EVEN SIZES 6" - 36" MINOR AXIS

NOMINAL FLAT OVAL PIPE SIZES

		MINOR AXIS															
		6"	8"	10"	12"	14"	16"	18"	20"	22"	24"	26"	28"	30"	32"	34"	36"
M A J O R A X I S	20																
	22																
	23	22	21	20	19												
	25	24	23	21	20	19											
	26	25	24	23	22	21											
	28	27	26	25	23	22	21										
	31	30	29	28	27	25	24	23									
	34	33	32	31	30	29	27	26	25								
	37	36	35	34	33	32	31	29	28	27							
	41	39	38	37	36	35	34	33	31	30							
	44	42	41	40	39	38	37	36	35	33	32						
	47	46	45	43	42	41	40	39	38	37	35	34					
	50	49	48	47	45	44	43	42	41	40	39	37	36				
	53	52	51	50	49	47	46	45	44	43	42	41	39	38			
	56	55	54	53	52	51	49	48	47	46	45	44	43	41	40		
	59	58	57	56	55	54	53	51	50	49	48	47	46	45	43	42	
	63	61	60	59	58	57	56	55	53	52	51	50	49	48	47	45	
	66	65	63	62	61	60	59	58	57	55	54	53	52	51	50	49	
	69	68	67	65	64	63	62	61	60	59	57	56	55	54	53	52	
	72	71	70	69	67	66	65	64	63	62	61	59	58	57	56	55	
	74	73	72	71	69	68	67	66	65	64	63	61	60	59	58		
			75	74	73	71	70	69	68	67	66	65	63	62	61		
					76	75	73	72	71	70	69	68	67	65	64		
					79	78	77	75	74	73	72	71	70	69	67		
						81	80	79	77	76	75	74	73	72	71		
								82	81	79	78	77	76	75	74		
								85	84	83	81	80	79	78	77		
										86	85	83	82	81	80		
												87	85	84	83		
														89	87	86	
															91	89	
																93	

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:

Material	Thickness	Length	Seam	Connection
Galvanized	26 - 18 ga	4', 5'	Snaplock or Pittsburgh	TDF - S&D - Raw
Paint Grip	26 - 18 ga	5'		
PVC	24 - 18 ga	5'		
Aluminum	.032 - .050	5'		
Stainless Steel	24 - 20 ga	5'		

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

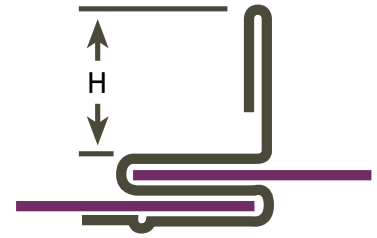
Connector Types



DRIVE SLIP



HEMMED "S" SLIP



STANDING S



WELD FLANGE



COMPANION ANGLES



TDF FLANGED
 (with gasket)

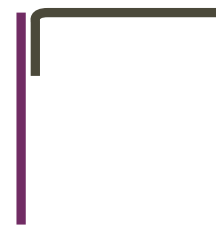
Seam Types



PITTSBURGH LOCK



BUTTON PUNCH
 SNAP LOCK



LAP SEAM



STANDING SEAM



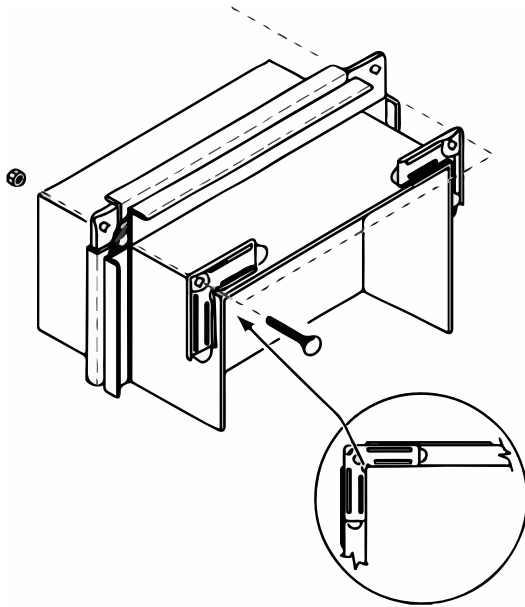
SINGLE CORNER SEAM



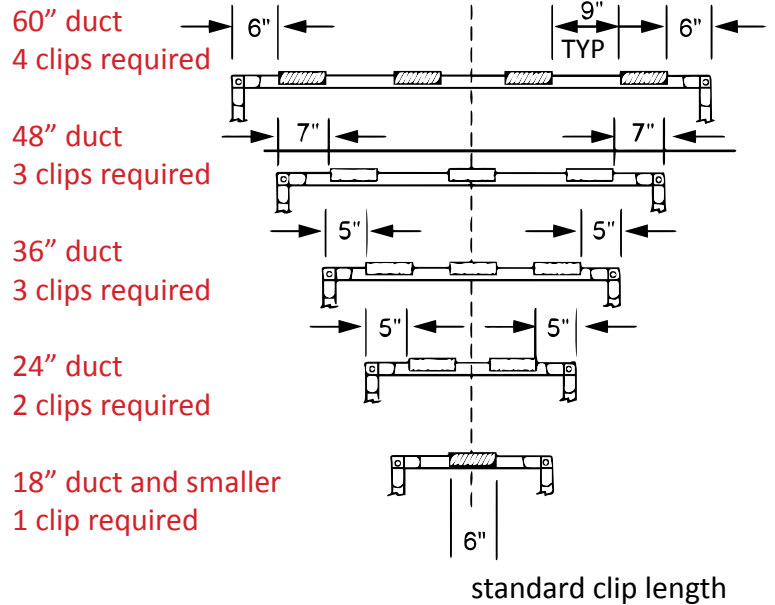
CORNER WELD

Standards

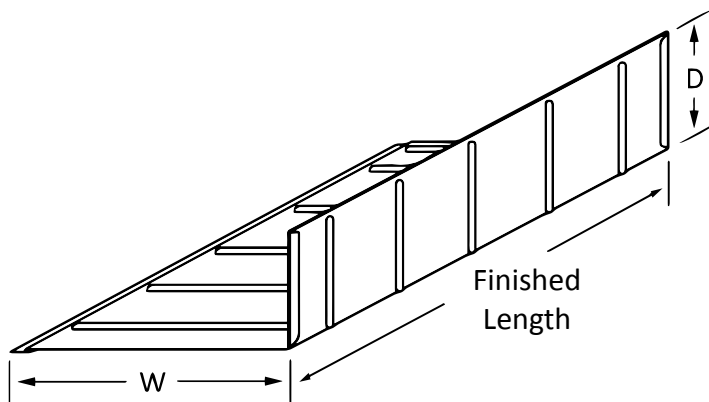
TDF Connection



Recommended Clip Spacing



Straight Duct

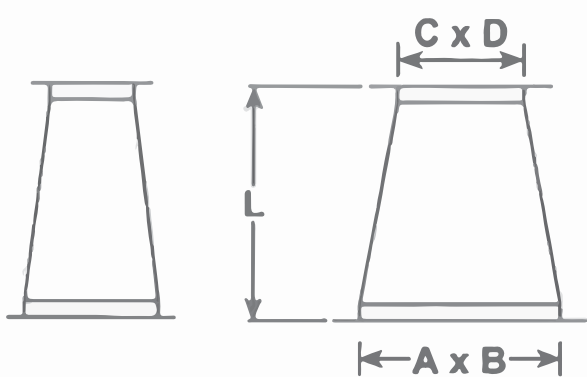


Method of Fabrication:

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.

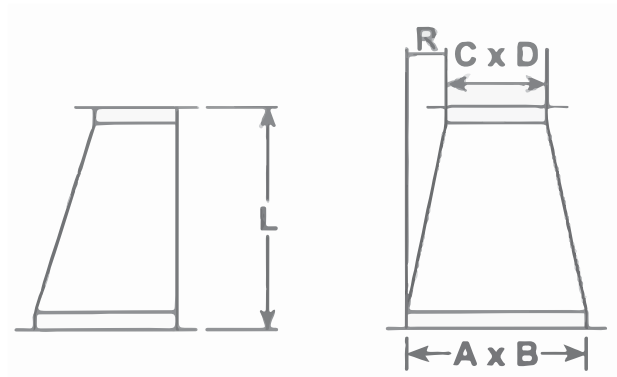
- 44 - 56" finished length with TDF
- 47 - 59" finished length with drive cleat edges
- 60" length with ends unfinished

Concentric Transition



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

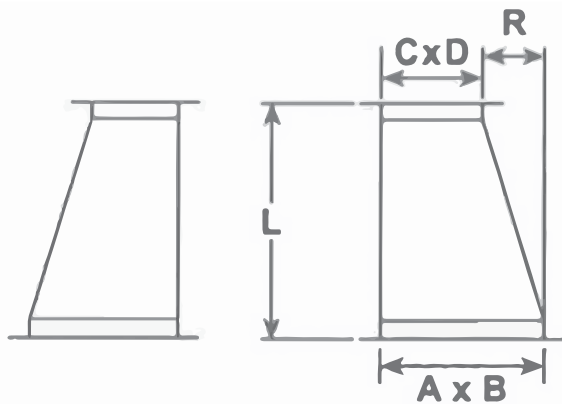
Top or Bottom Flat Transition



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

Transition

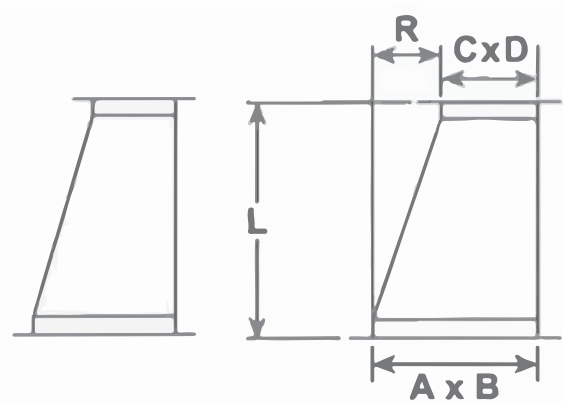
(Top & Left Sides Flat)



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

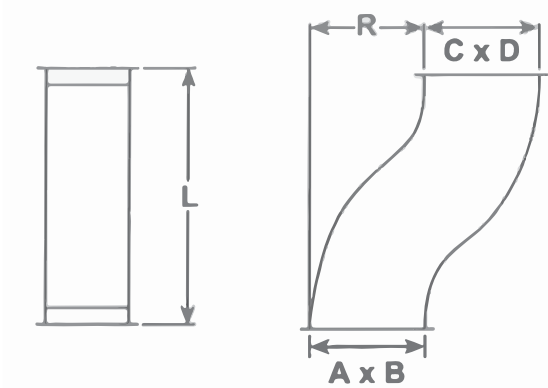
Transition

(Top & Right Sides Flat)



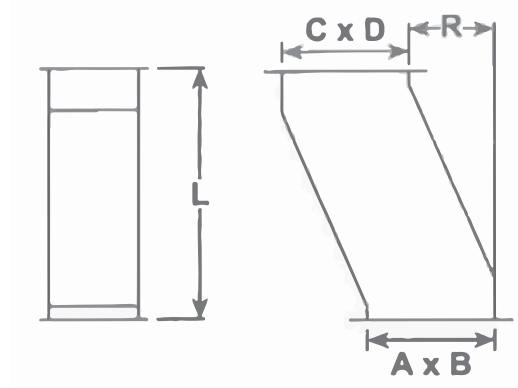
- TDF
- S&D
- Raw
- Dimensions are O.D.

Radius Offset



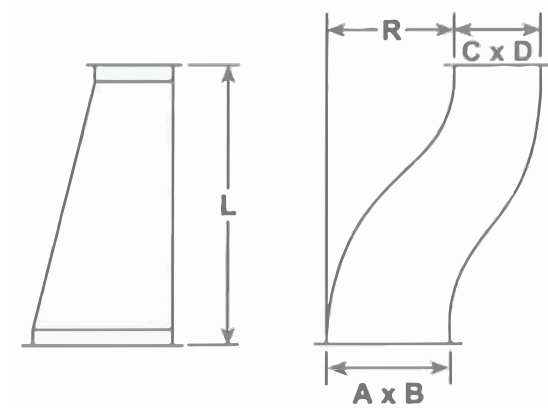
- TDF
- S&D
- Raw
- Dimensions are O.D.

Offset



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

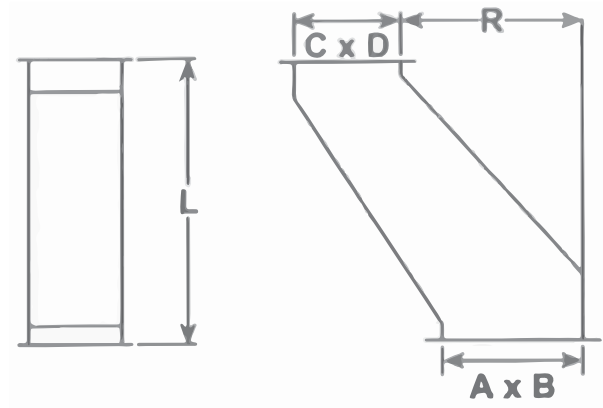
Reducing Offset



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

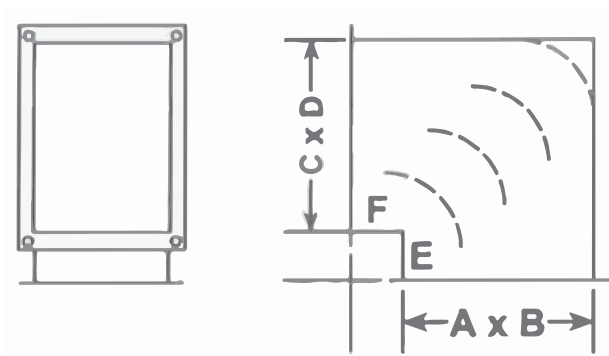
Reducing Offset

(Left or Right)



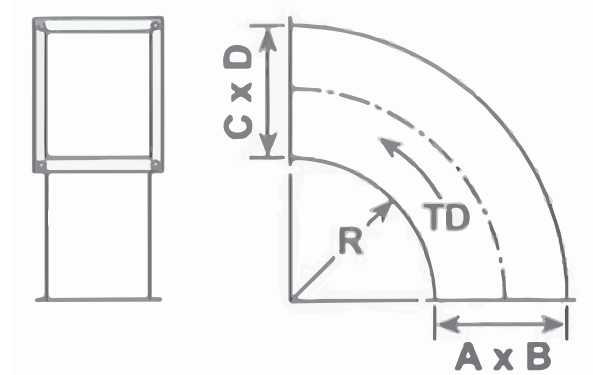
- TDF
- S&D
- Raw
- Dimensions are O.D.

Square Throat Elbow



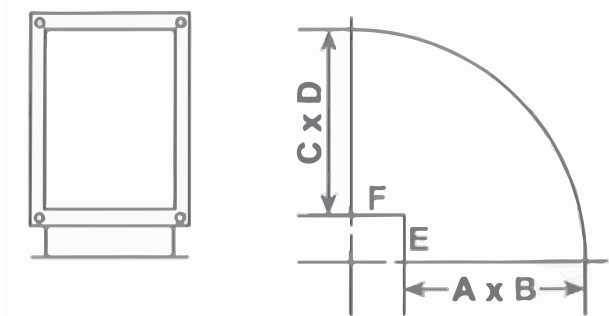
- TDF
- S&D
- Raw
- Dimensions are O.D.

Radius Elbow



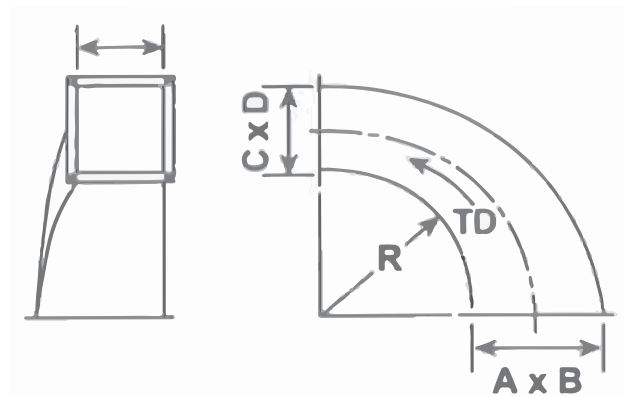
- TDF
- S&D
- Raw
- Dimensions are O.D.

Radius Elbow (With Square Throat)



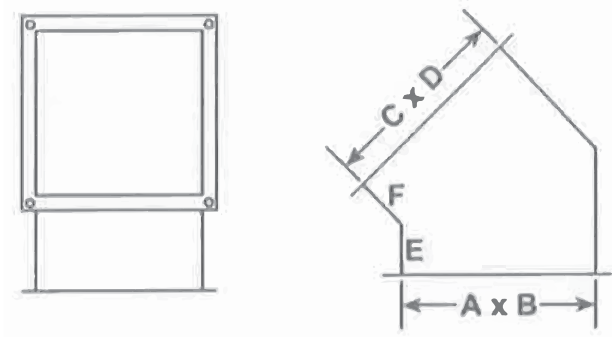
- TDF
- S&D
- Raw
- Dimensions are O.D.

Reducing Radius Elbow (Left or Right)



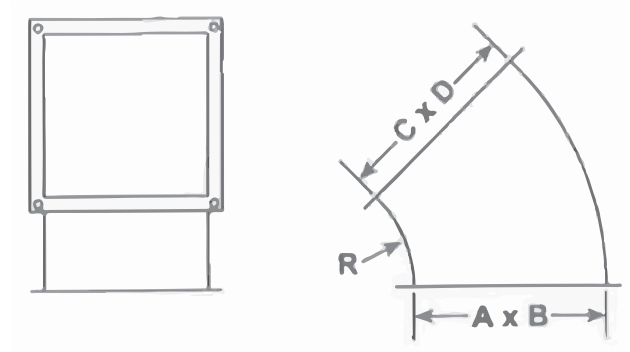
- TDF
- S&D
- Raw
- Dimensions are O.D.

Square Throat Angle



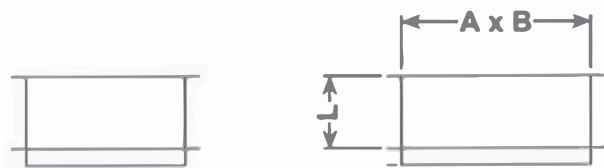
- TDF
- S&D
- Raw
- Dimensions are O.D.

Radius Angle



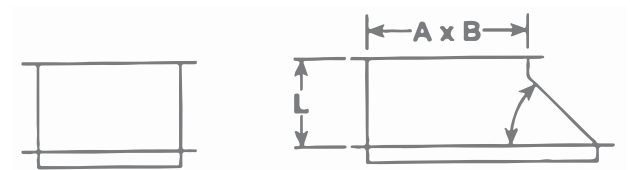
- TDF
- S&D
- Raw
- Dimensions are O.D.

Straight 90° Tap



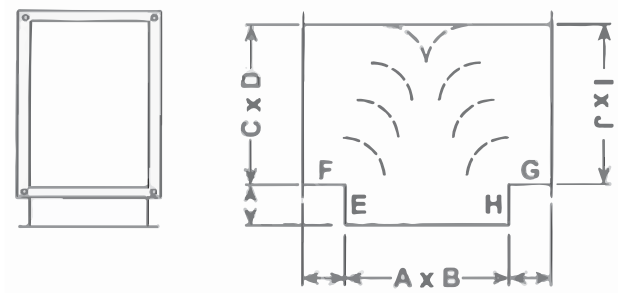
- TDF
- S&D
- Raw
- Dimensions are O.D.

90° Increased Tap



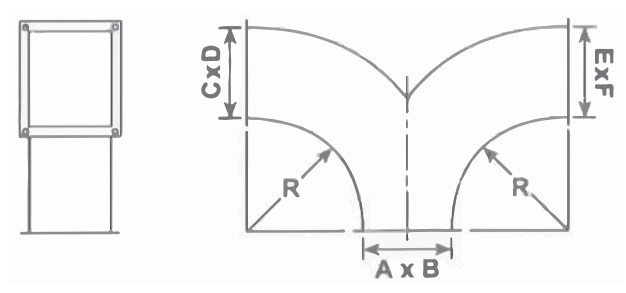
- TDF
- S&D
- Raw
- Dimensions are O.D.

Bullhead Tee



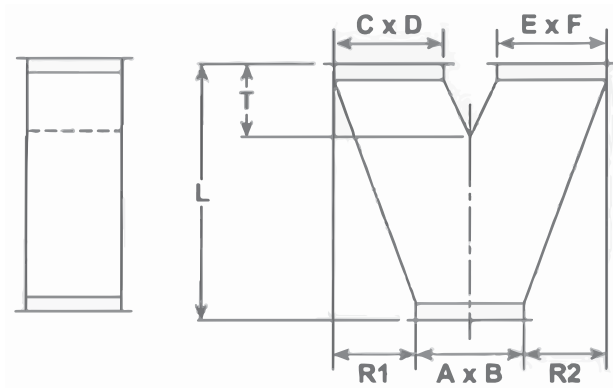
- TDF
- S&D
- Raw
- Dimensions are O.D.

Y-Branch



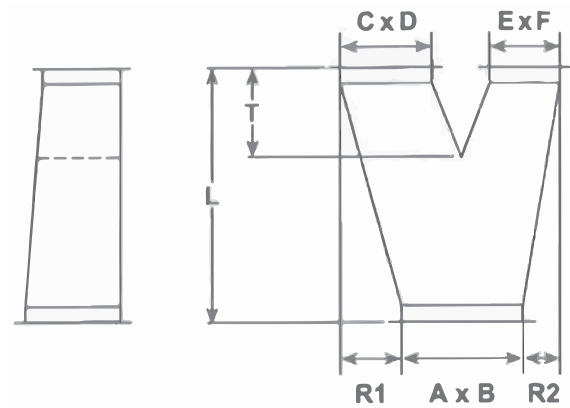
- TDF
- S&D
- Raw
- Dimensions are O.D.

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.

NOTES: _____

Full Line - HVAC - Residential & Commercial Air Duct Manufacturer

SPIRAL PIPE, ELBOWS, FITTINGS, RECTANGULAR DUCT, OVAL SPIRAL PIPE & FITTINGS

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Snap-Rite Manufacturing, Inc.



Updated 12-14

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