

SECTION 15815 - 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 rectangular, round, and flat-oval metal ducts and plenums for heating, ventilating, and air-conditioning systems in pressure classes from minus 2- to plus 10-inch wg.
- B. Related Sections include the following:
 - 1. Division 15 Section "Mechanical Insulation" for duct insulation.
 - 2. Division 15 Section "Duct Accessories" for dampers, sound-control devices, duct-mounted access doors and panels, turning vanes, and flexible ducts.
 - 3. Division 15 Section "Diffusers, Registers, and Grilles."
 - 4. Division 15 Section "Testing, Adjusting, and Balancing" for air balancing and final adjusting of manual-volume dampers.

1.3 DEFINITIONS

- A. Thermal Conductivity and Apparent Thermal Conductivity (k-Value): As defined in ASTM C 168. In this Section, these values are the result of the formula $\text{Btu} \times \text{in.}/\text{h} \times \text{sq. ft.} \times \text{deg F}$ or $\text{W}/\text{m} \times \text{K}$ at the temperature differences specified. Values are expressed as Btu or W.
 - 1. Example: Apparent Thermal Conductivity (k-Value): 0.26 or 0.037.

1.4 SYSTEM DESCRIPTION

- A. Duct system design, as indicated, has been used to select and size air-moving and -distribution equipment and other components of air system. Changes to layout or configuration of duct system must be specifically approved in writing by Architect. Accompany requests for layout modifications with calculations showing that proposed layout will provide original design results without increasing system total pressure.

1.5 SUBMITTALS

- A. Product Data: For duct liner and sealing materials.
- B. Shop Drawings: Show details of the following:

1. Fabrication, assembly, and installation, including plans, elevations, sections, components, and attachments to other work.
 2. Duct layout indicating pressure classifications and sizes on plans.
 3. Fittings.
 4. Reinforcement and spacing.
 5. Seam and joint construction.
 6. Penetrations through fire-rated and other partitions.
 7. Hangers and supports, including methods for building attachment, vibration isolation, seismic restraints, and duct attachment.
- C. Coordination Drawings: Reflected ceiling plans drawn to scale and coordinating penetrations and ceiling-mounted items. Show the following:
1. Ceiling suspension assembly members.
 2. Other systems installed in same space as ducts.
 3. Ceiling- and wall-mounted access doors and panels required to provide access to dampers and other operating devices.
 4. Coordination with ceiling-mounted items, including lighting fixtures, diffusers, grilles, speakers, sprinkler heads, access panels, and special moldings.
- D. Record Drawings: Indicate actual routing, fitting details, reinforcement, support, and installed accessories and devices.

1.6 QUALITY ASSURANCE

- A. Comply with NFPA 90A, "Installation of Air Conditioning and Ventilating Systems," unless otherwise indicated.

1.7 DELIVERY, STORAGE, AND HANDLING

- A. Deliver sealant and firestopping materials to site in original unopened containers or bundles with labels indicating manufacturer, product name and designation, color, expiration period for use, pot life, curing time, and mixing instructions for multicomponent materials.
- B. Store and handle sealant and firestopping materials according to manufacturer's written recommendations.
- C. Deliver and store stainless-steel sheets with mill-applied adhesive protective paper maintained through fabrication and installation.

PART 2 - PRODUCTS

2.1 SHEET METAL MATERIALS

- A. Galvanized, Sheet Steel: Lock-forming quality; ASTM A 653/A 653M, G90 coating designation; mill-phosphatized finish for surfaces of ducts exposed to view.

- B. Reinforcement Shapes and Plates: Galvanized steel reinforcement where installed on galvanized, sheet metal ducts; compatible materials for aluminum and stainless-steel ducts.
- C. Tie Rods: Galvanized steel, 1/4-inch minimum diameter for 36-inch length or less; 3/8-inch minimum diameter for lengths longer than 36 inches.

2.2 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.
 - 1. Joint and Seam Tape: 2 inches wide; glass-fiber fabric reinforced.
 - 2. Tape Sealing System: Woven-fiber tape impregnated with a gypsum mineral compound and a modified acrylic/silicone activator to react exothermically with tape to form a hard, durable, airtight seal.
 - 3. Joint and Seam Sealant: One-part, nonsag, solvent-release-curing, polymerized butyl sealant, formulated with a minimum of 75 percent solids.
 - 4. Flanged Joint Mastics: One-part, acid-curing, silicone, elastomeric joint sealants, complying with ASTM C 920, Type S, Grade NS, Class 25, Use O.

2.3 HANGERS AND SUPPORTS

- A. Building Attachments: Concrete inserts, powder-actuated fasteners, or structural-steel fasteners appropriate for building materials.
 - 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 round, threaded steel rod.
 - 1. Hangers Installed in Corrosive Atmospheres: Electro galvanized, all-thread rod or galvanized rods with threads painted after installation.
 - 2. Straps and Rod Sizes: Comply with SMACNA's "HVAC Duct Construction Standards--Metal and Flexible" for sheet steel width and thickness and for steel rod diameters.
- 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 ductwork.

2.4 RECTANGULAR DUCT FABRICATION

- A. General: Fabricate ducts, elbows, transitions, offsets, branch connections, and other construction with galvanized, sheet steel, according to SMACNA's "HVAC Duct Construction Standards--Metal and Flexible." Comply 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 classification.
 - 2. Materials: Free from visual imperfections such as pitting, seam marks, roller marks, stains, and discolorations.
- B. Static-Pressure Classifications: Unless otherwise indicated, construct ducts to the following:
 - 1. Supply Ducts: 3-inch wg.
 - 2. Return Ducts: 2-inch wg, negative pressure.
 - 3. Exhaust Ducts: 2-inch wg, negative pressure.
- C. 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 unbraced panel area, unless ducts are lined.

2.5 ROUND AND FLAT-OVAL DUCT FABRICATION

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

2.6 ROUND AND FLAT-OVAL SUPPLY AND EXHAUST FITTING FABRICATION

- A. 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 duct.
- B. Diverging-Flow Fittings: Fabricate with a reduced entrance to branch taps with no excess material projecting from body onto branch tap entrance.
- C. Elbows: Fabricate in die-formed, gored, pleated, or mitered construction. Fabricate bend radius of die-formed, gored, and pleated elbows one and one-half times elbow 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 26 Inches in Diameter: 0.028 inch.
 - b. Ducts 27 to 36 Inches in Diameter: 0.034 inch.
 - c. Ducts 37 to 50 Inches in Diameter: 0.040 inch.
 - d. Ducts 52 to 60 Inches in Diameter: 0.052 inch.
 - e. Ducts 62 to 84 Inches in Diameter: 0.064 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 14 Inches in Diameter: 0.028 inch.
 - b. Ducts 15 to 26 Inches in Diameter: 0.034 inch.
 - c. Ducts 27 to 50 Inches in Diameter: 0.040 inch.
 - d. Ducts 52 to 60 Inches in Diameter: 0.052 inch.
 - e. Ducts 62 to 84 Inches in Diameter: 0.064 inch.
4. 90-Degree, Two-Piece, Mitered Elbows: Use only for supply systems, or exhaust systems for material-handling classes A and B; and only where space restrictions do not permit using 1.5 bend radius elbows. Fabricate with single-thickness turning vanes.
5. Round Elbows, 8 Inches and Smaller: 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 configuration or nonstandard diameter elbows with gored construction.
6. Round Elbows, 9 through 14 Inches: Fabricate gored or pleated elbows for 30, 45, 60, and 90 degrees, unless space restrictions require a mitered elbow. Fabricate nonstandard bend-angle configuration or nonstandard diameter elbows with gored construction.
7. Round Elbows, Larger Than 14 Inches, and All Flat-Oval Elbows: Fabricate gored elbows, unless space restrictions require a mitered elbow.
8. Die-Formed Elbows for Sizes through 8 Inches and All Pressures: 0.040 inch thick with two-piece welded construction.
9. Round Gored-Elbow Metal Thickness: Same as non-elbow fittings specified above.
10. Flat-Oval Elbow Metal Thickness: Same as longitudinal seam flat-oval duct specified above.
11. Pleated Elbows for Sizes through 14 Inches and Pressures through 10-Inch wg: 0.022 inch.

PART 3 - EXECUTION

3.1 DUCT INSTALLATION, GENERAL

- A. Duct installation requirements are specified in other Division 15 Sections. Drawings indicate general arrangement of ducts, fittings, and accessories.
- B. Construct and install each duct system for the specific duct pressure classification indicated.
- C. Install round and flat-oval ducts in lengths not less than 12 feet, unless interrupted by fittings.
- D. Install ducts with fewest possible joints.

- E. Install fabricated fittings for changes in directions, changes in size and shape, and connections.
- F. Install couplings tight to duct wall surface with a minimum of projections into duct.
- G. Install ducts, unless otherwise indicated, vertically and horizontally, parallel and perpendicular to building lines; avoid diagonal runs.
- H. Install ducts close to walls, overhead construction, columns, and other structural and permanent enclosure elements of building.
- I. Install ducts with a clearance of 1 inch, plus allowance for insulation thickness.
- J. Conceal ducts from view in finished spaces. Do not encase horizontal runs in solid partitions, unless specifically indicated.
- K. Coordinate layout with suspended ceiling, fire- and smoke-control dampers, lighting layouts, and similar finished work.
- L. Electrical Equipment Spaces: Route ductwork 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 space between construction opening and duct or duct insulation with sheet metal flanges of same metal thickness as duct. Overlap opening on four sides by at least 1-1/2 inches.
- N. Fire-Rated Partition Penetrations: Where ducts pass through interior partitions and exterior walls, install appropriately rated fire damper, sleeve, and firestopping sealant. Fire and smoke dampers are specified in Division 15 Section "Duct Accessories." Firestopping materials and installation methods are specified in Division 7 Section "Firestopping."

3.2 SEAM AND JOINT SEALING

- A. General: Seal duct seams and joints according to the duct pressure class indicated and as described in SMACNA's "HVAC Duct Construction Standards--Metal and Flexible."
- B. Pressure Classification Less Than 2-Inch wg: Transverse joints.
- C. Seal externally insulated ducts before insulation installation.

3.3 HANGING AND SUPPORTING

- A. Install rigid round, rectangular, and flat-oval metal duct with support systems indicated in SMACNA's "HVAC Duct Construction Standards--Metal and Flexible."
- B. Support horizontal ducts within 24 inches of each elbow and within 48 inches of each branch intersection.

- C. Support vertical ducts at a maximum interval of 16 feet and at each floor.
- D. Install upper attachments to structures with an allowable load not exceeding one-fourth of failure (proof-test) load.
- E. Install concrete inserts before placing concrete.

3.4 CONNECTIONS

- A. Connect equipment with flexible connectors according to Division 15 Section "Duct Accessories."
- B. For branch, outlet and inlet, and terminal unit connections, comply with SMACNA's "HVAC Duct Construction Standards--Metal and Flexible."

3.5 FIELD QUALITY CONTROL

- A. Maximum Allowable Leakage: Comply with requirements for Leakage Classification 3 for round and flat-oval ducts, Leakage Classification 12 for rectangular ducts in pressure classifications less than and equal to 2-inch wg (both positive and negative pressures), and Leakage Classification 6 for pressure classifications from 2- to 10-inch wg.
- B. Remake leaking joints and retest until leakage is less than maximum allowable.
- C. Leakage Test: Perform tests according to SMACNA's "HVAC Air Duct Leakage Test Manual."

3.6 ADJUSTING

- A. Adjust volume-control dampers in ducts, outlets, and inlets to achieve design airflow.
- B. Refer to Division 15 Section "Testing, Adjusting, and Balancing" for detailed procedures.

3.7 CLEANING

- A. After completing system installation, including outlet fittings and devices, inspect the system. Vacuum ducts before final acceptance to remove dust and debris.

END OF SECTION 15815