

Round Duct CONSTRUCTION STANDARDS

TAMBE METAL PRODUCTS

MAX DIAMETER	POSITIVE PRESSURE					
	+2" w.g.		+4" w.g.		+10" w.g.	
	Spiral Seam	Long. Seam	Spiral Seam	Long. Seam	Spiral Seam	Long. Seam
6"	28	28	28	28	28	28
8"	28	28	28	28	28	26
10"	28	26	28	26	28	26
12"	28	26	28	26	26	24
14"	28	26	26	24	26	24
16"	26	24	26	24	24	22
18"	26	24	24	24	24	22
19-26"	26	24	24	22	24	22
27-36"	24	22	22	20	22	20
37-50"	22	20	20	20	20	20
51-60"	20	18	18	18	18	18
61-84"	18	16	18	16	18	16

MAX DIAMETER	NEGATIVE PRESSURE					
	-2" w.g.		-4" w.g.		-10" w.g.	
	Spiral Seam	Long. Seam	Spiral Seam	Long. Seam	Spiral Seam	Long. Seam
6"	28	28	28	28	26	26
7"	28	28	28	28	26	26
8"	28	28	28	28	26	26
9"	28	28	28	26	26	24
10"	28	28	26	26	26	22
11"	28	26	26	24	26	22
12"	28	26	26	24	24	22
13"	28	26	26	24	24	20
14"	28	24	24	22	24	20
15"	28	24	24	22	22	20
16"	26	24	24	22	22	18
17"	26	24	24	20	22	18
18"	24	22	24	20	22	18
19"	24	22	24	20	22	18
20"	24	22	22	20	22	18
21"	24	20	22	18	22	18
22"	24	20	22	18	22	16
23"	24	20	22	18	20	16
24"	22	20	22	18	20	16
25-26"	22	20	20	18	20	18 A4
27-29"	22	18	20	16	18	16 A4
30"	22	18	20	16	18	16 B4
31-33"	20	18	20	16	18	16 B4
34"	20	18	20	20 A6	18	16 B4
35-36"	20	16	20	20 A6	18	16 B4
37-42"	20	16	18	18 B6	18 F12	
43-48"	20	18 A6	18	18 B6	18 F6	
49-60"	18	18 B4	18 F6	16 B4	18 F6	
61-72"	16		18 F6		16 F4	

An alphabet letter in the table means that reinforcement angles or their equivalent must be used at the foot interval following the letter. The angle sizes are:

A = 1" x 1" x 1/8"; **B** = 1-1/4" x 1-1/4" x 3/16"; **C** = 1-1/2" x 1-1/2" x 3/16"; **D** = 1-1/2" x 1-1/2" x 1/4"; **E** = 2" x 2" x 3/16"; **F** = 2" x 2" x 1/4"

If companion flange joints are used as reinforcements, those for 25" to 36" diameter shall be 1-1/2" x 1-1/2" x 3/16"; for 37" to 48" diameter 2" x 2" x 3/16"; for 40" to 60" diameter 2-1/2" x 2-1/2" x 3/16"; for 61" to 72" diameter 3" x 3" x 1/4".

Round Duct **CONSTRUCTION STANDARDS**

TAMBE METAL PRODUCTS

ALUMINUM ROUND DUCT GAUGE SCHEDULE

Duct Diameter in inches	Maximum +2" w.g. Static Positive		Maximum -2" w.g. Static Negative	
	Spiral Gauge Seam	Longitudinal Gauge Seam	Spiral Gauge Seam	Longitudinal Gauge Seam
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.

POLYVINYL COATED DUCT GAUGES FOR UNDERGROUND DUCT AND FITTINGS

Duct Diameter in inches	Gauges	Fittings
4 thru 8"	26 Gauge	26 Gauge
9 thru 16"	24 Gauge	24 Gauge
18 thru 24"	22 Gauge	22 Gauge
26 thru 32"	20 Gauge	20 Gauge
34 thru 60"	18 Gauge	18 Gauge

POLYVINYL COATED DUCT GAUGES FOR ABOVE GROUND DUCT AND FITTINGS

Duct Diameter in inches	Gauges	Fittings
4 thru 14"	26 Gauge	26 Gauge
16 thru 26"	24 Gauge	24 Gauge
28 thru 36"	22 Gauge	22 Gauge
38 thru 50"	20 Gauge	20 Gauge
52 thru 60"	18 Gauge	18 Gauge

* Gauges equal or exceed SMACNA standards

Round Duct **SEAMS**

TAMBE METAL PRODUCTS



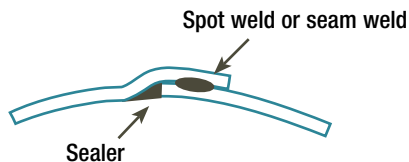
Spiral pipe lock seam (RL-1)

**Available
Gauges**

Galvanized	28-16
Stainless steel	26-22
Aluminum	22-16
Paint grip	26-16
Poly vinyl coated	26-18
Perforated	22

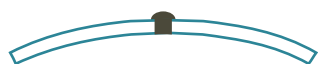


Spiral pipe lock seam (RL-1)
(Corrugated 14" and larger for extra strength below grade)



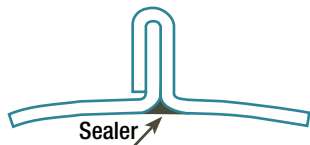
Spot weld and bonded seam
or continuous seam weld

Galvanized	26-20
Stainless steel	26-20
Aluminum	22-20
Paint grip	26-20
Poly vinyl coated (button punched or riveted)	26-18



Butt-welded seam

Galvanized	20-10
Stainless steel	20-10
Aluminum	18-1/4"
Paint grip	20-10



Gore locked seam

Galvanized	26-18
Stainless steel	26-22
Aluminum	22-16
Paint grip	26-18
Poly vinyl coated	26-18

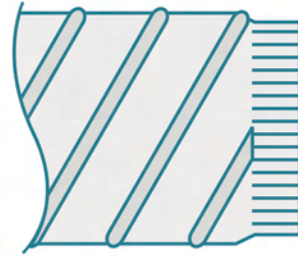
Round Duct **CONNECTORS**

TAMBE METAL PRODUCTS

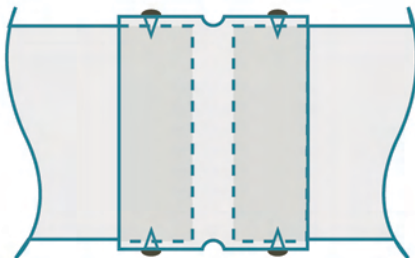
PIPE COUPLING



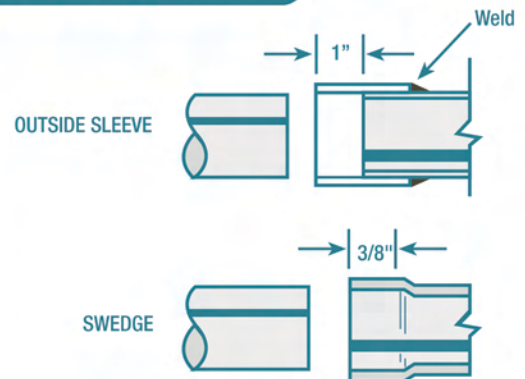
CRIMPED END



FITTING COUPLING



SWEDGE/SLEEVE



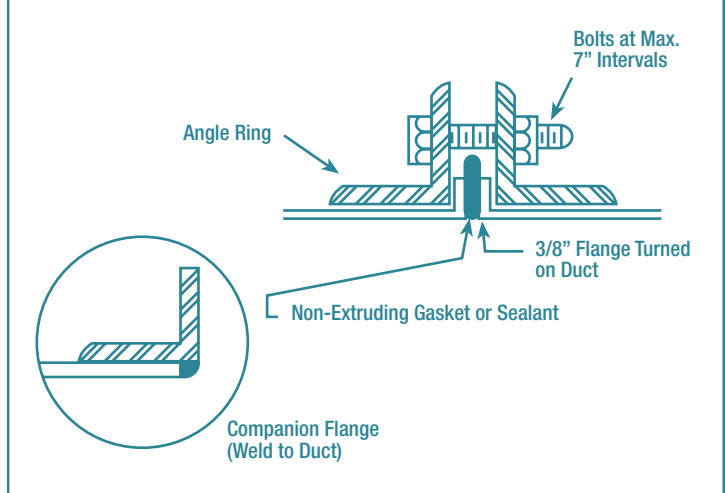
Round Duct CONNECTORS

TAMBE METAL PRODUCTS

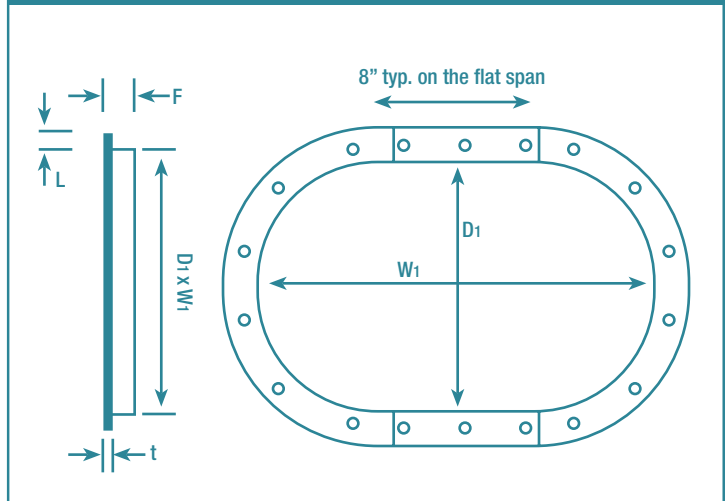
Angle Iron Ring Specifications

ORDER SIZE	ANGLE MILD STEEL	I.D.	BOLT HOLES	HOLE SIZE	BOLT CIRCLE	WEIGHT LBS.
3	PRESSED	3-1/16	6	9/32	4-5/16	0.70
4	10 GA	4-1/16	6	9/32	5-5/16	0.85
5		5-1/16	6	9/32	6-5/16	1.20
6	1-1/4 X	6-1/8	6	3/8	7-5/16	1.75
7	1-1/4 X	7-1/8	6	3/8	8-1/2	2.00
8	1/8	8-1/8	6	3/8	9-9/16	2.25
9		9-1/8	6	3/8	10-5/8	2.50
10		10-1/8	6	3/8	11-13/16	2.75
11		11-1/8	6	3/8	12-3/4	3.00
12	1-1/2 X	12-3/16	8	7/16	14	4.00
13	1-1/2 X	13-3/16	8	7/16	15	4.25
14	1/8	14-3/16	8	7/16	16	4.75
15		15-3/16	8	7/16	17	5.00
16	1-1/2 X	16-3/16	8	7/16	18	8.00
17	1-1/2 X	17-	8	7/16	19	8.25
18	3/16	3/1618-	8	7/16	20	8.50
19		3/16	12	7/16	20 3/4	8.75
20		19-3/16	12	7/16	21-3/4	9.50
21		20-3/16	12	7/16	22-3/4	10.25
22		21-3/16	12	7/16	23-3/4	10.75
23		22-3/16	12	7/16	24-7/8	11.25
24		23-3/16	12	7/16	25-7/8	11.50
25	2X2 X	24-3/16	16	7/16	26-7/8	15.75
26	3/16	25-3/16	16	7/16	28-3/8	16.50
27		26-	16	7/16	29-3/8	16.75
28		3/1627-	16	7/16	30-3/8	18.00
29		3/16	16	7/16	31-3/8	18.75
30		28-3/16	16	7/16	32-3/8	19.50
31		29-3/16	16	7/16	33-3/8	19.75
32		30-3/16	16	7/16	34-3/8	20.00
33		31-3/16	16	7/16	35-3/8	21.25
34		32-3/16	16	7/16	36-3/8	22.50
35		33-3/16	16	7/16	37-3/8	22.75
36		34-3/16	16	7/16	38-3/8	23.00
37		35-	24	7/16	39-3/8	23.75
38		3/1636-	24	7/16	40-3/8	24.50
39		3/16	24	7/16	41-3/8	25.00
40		37-3/16	24	7/16	42-3/8	25.75
41		38-3/16	24	7/16	43-3/8	26.25
42		39-3/16	24	7/16	44-3/8	26.50
43		40-3/16	24	7/16	45-3/8	27.50
44		41-3/16	24	7/16	46-3/8	28.00
45		42-3/16	24	7/16	47-3/8	28.50
46		43-3/16	24	7/16	48-3/8	29.00
47		44-3/16	24	7/16	49-3/8	30.00
48		45-3/16	24	7/16	50-3/8	30.75
49		46-3/16	24	7/16	51-3/8	31.50
50		47-3/16	24	7/16	52-3/8	32.00
52		48-3/16	24	7/16	54-3/8	33.75
54		49-3/16	24	7/16	56-3/8	35.00
56		50-3/16	24	7/16	58-3/8	36.25
58		52-3/16	24	7/16	60-3/8	37.50
60		54-3/16	24	7/16	62-3/8	38.75
62		56-3/16	24	7/16	64-3/8	40.00
64		58-3/16	24	7/16	66-3/8	41.50
66		60-3/16	24	7/16	68-3/8	42.75
68		62-3/16	24	7/16	70-3/8	44.00
70		64-3/16	24	7/16	72-3/8	45.25
72		66-3/16	24	7/16	74-3/8	46.50

Vanstone Flange/Companion Flange



Oval Angle Ring Dimensions



a Minor Axis (inches)	Bolt Hole Diameter (inches)	Number of Bolts on Curved Side	LxF Nominal Size (inches)	t Nominal Thickness
3-5	9/32	6	1 x 1	10 gauge
5-11	3/8	6	1-1/4 x 1-1/4	1/8"
12-14	7/16	8	1-1/2 x 1-1/2	1/8"
16-18	7/16	8	1-1/2 x 1-1/2	3/16"
19-24	7/16	12	1-1/2 x 1-1/2	3/16"
25-36	7/16	16	2 x 2	3/16"
37-50	7/16	24	2 x 2	3/16"

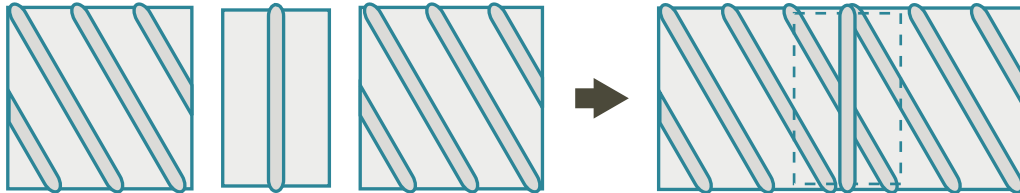
Standard Rings are hot rolled steel.
Galvanized, aluminum, and stainless steel rings are also available.

Round Duct **INSTALLATION**

TAMBE METAL PRODUCTS

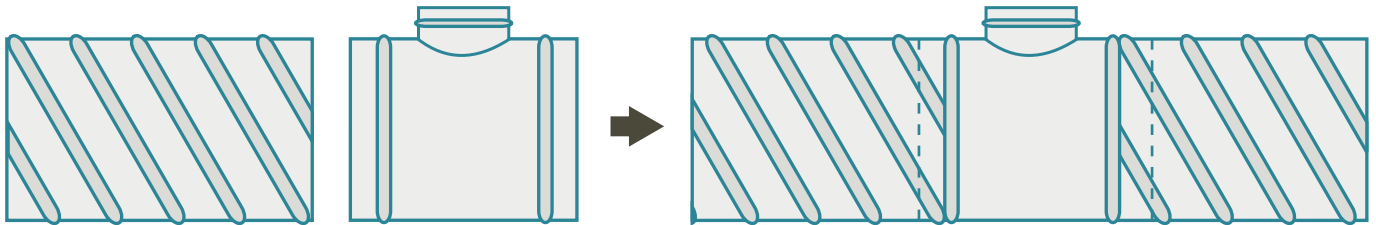
Installation of slip joint connectors

Duct-to-joint connections are made by using a duct coupling that slips inside the duct sections.



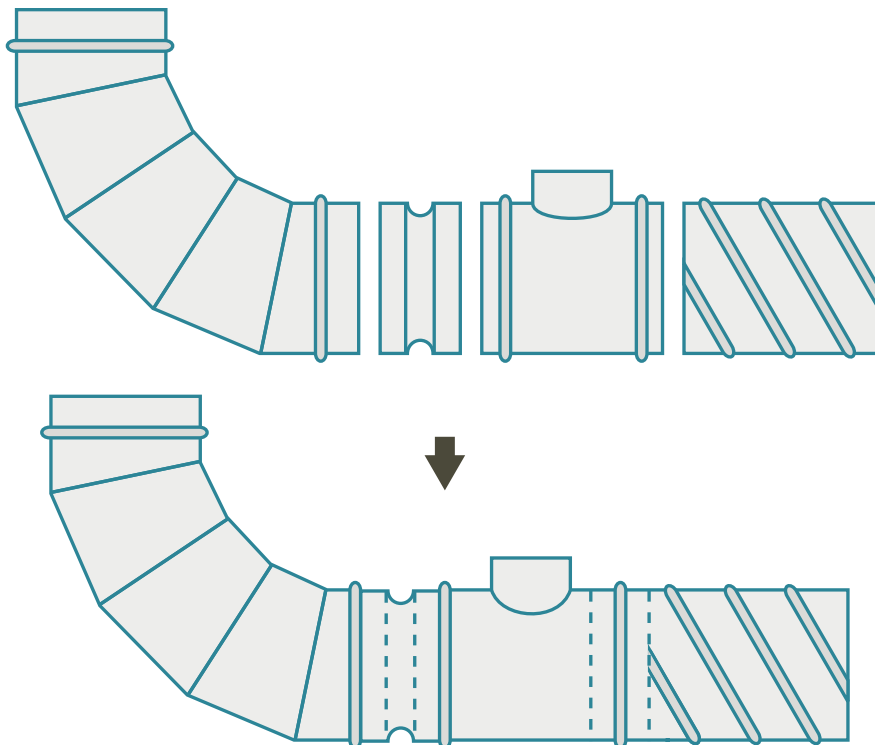
Duct-to-fitting connections

Duct-to-fitting connections are made by slipping the fitting collar into the duct.



Fitting-to-fitting connections

Connections can be made by using a short section of duct or by using a fitting coupling.



Round Duct **MANIFOLDS/ASSEMBLIES**

TAMBE METAL PRODUCTS

Tambe Metal Products standard manifolds/assemblies of duct and fittings

We offer manifolds/assemblies of duct and fittings from our standard duct and fitting components. Manifolds/assemblies reduce field labor and potential sources of leakage by eliminating joints between pipe and standard fittings.

