

# **Stainless Steel Ductwork Construction**



to **2"**  
**Positive**  
**Pressure**  
 (+w.g.)

# Stainless Steel Construction

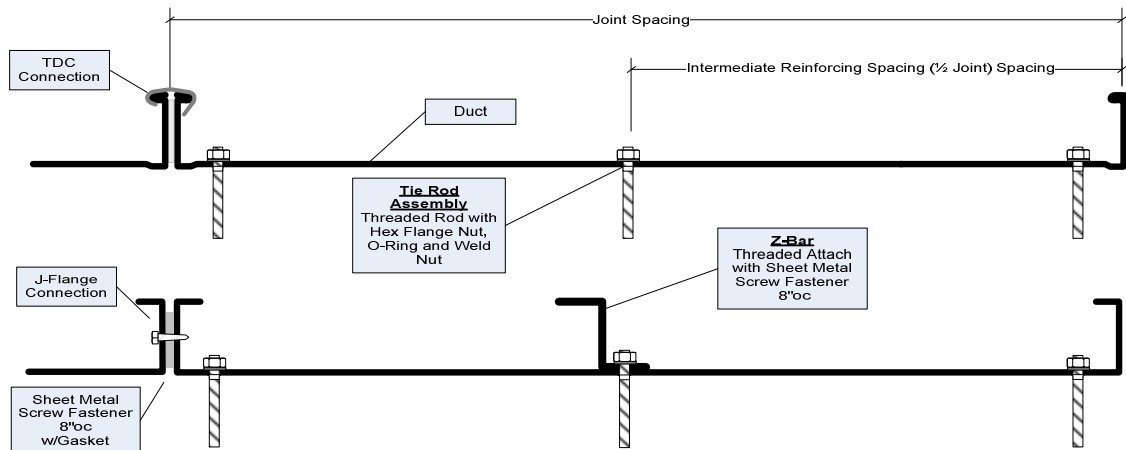
## Supply, Return & Makeup Air duct

### 5' Rectangular Duct & Fittings

Duct Size	Gauge @5'	Gauge @2½'	Connector	Joint Length	Duct Seam	Joint Reinforcing	Intermediate Reinforcing(Over2½')
0-26"	26ga	26ga	TDC	56¼"	Pittsburgh	-	-
to 30"	24ga	24ga	TDC	56¼"	Pittsburgh	-	-
to 36"	22ga	24ga	TDC	56¼"	Pittsburgh	-	-
to 42"	24ga	24ga	TDC	56¼"	Pittsburgh	-	CTR
to 54"	22ga	22ga	TDC	56¼"	Pittsburgh	-	CTR
to 60"	22ga	22ga	TDC	56¼"	Pittsburgh	JTR	CTR
to 72"	20ga	20ga	TDC	56¼"	Pittsburgh	JTR	CTR
to 96"	20ga	20ga	TDC	56¼"	Pittsburgh	JTR	CTR(2)
Over-96"	18ga	18ga	J-Flange	55½"	Pittsburgh	JTR(@48")	CTR(@60") & 2x1 1/8x12ga ZBar(l)

### 4' Rectangular Duct & Fittings

Duct Size	Gauge @4'	Gauge @2'	Connector	Joint Length	Duct Seam	Joint Reinforcing	Intermediate Reinforcing(Over2')
0-28"	26ga	26ga	TDC	44¼"	Pittsburgh	-	-
to 36"	24ga	24ga	TDC	44¼"	Pittsburgh	-	-
to 48"	24ga	24ga	TDC	44¼"	Pittsburgh	-	CTR
to 60"	22ga	22ga	TDC	44¼"	Pittsburgh	-	CTR
to 72"	20ga	20ga	TDC	44¼"	Pittsburgh	JTR	CTR
to 96"	20ga	20ga	TDC	44¼"	Pittsburgh	JTR	CTR(2)
Over-96"	18ga	18ga	J-Flange	43½"	Pittsburgh	JTR(@48")	CTR(@60") & 2x1 1/8x12ga ZBar(l)



#### References

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Table [2-32] Transverse Joint Reinforcement (T-24/25)

Table [2-17] 5ft Coil/Sheet Stock/T25a/T25b (TDC/TDF) Duct Reinforcement

Table [2-10] 4ft Coil/Sheet Stock/T25a/T25b (TDC/TDF) Duct Reinforcement

Table [2-29] Intermediate Reinforcement

Figure [2-12,13] Duct Over 120 In Wide

Figure [2-5] Tie Rod Attachments

<b>to 4"</b> <b>Positive Pressure</b> <b>(+w.g.)</b>	<h2 style="margin: 0;">Stainless Steel Construction</h2> <h3 style="margin: 0;">Supply, Return &amp; Makeup Air duct</h3>
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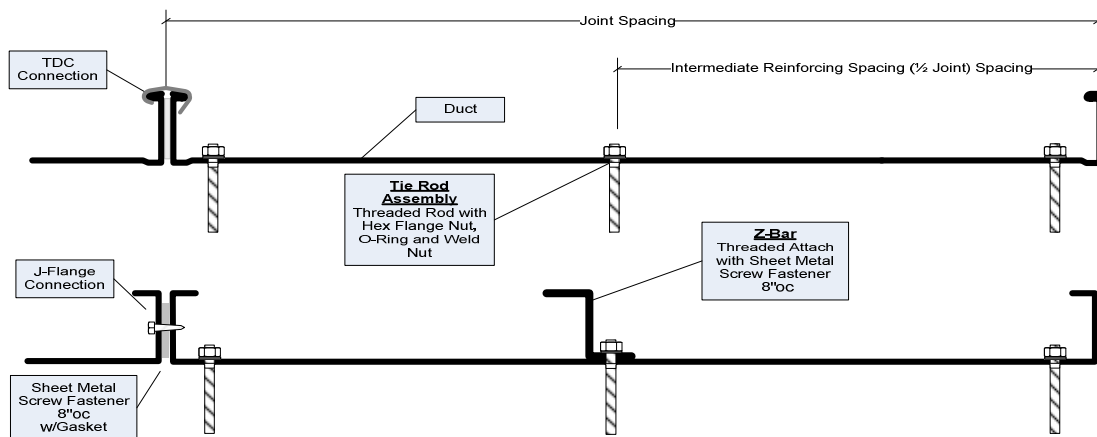
### 5' Rectangular Duct & Fittings

Duct Size	Gauge @5'	Gauge @2½'	Connector	Joint Length	Duct Seam	Joint Reinforcing	Intermidate Reinforcing(Over2½')
0-12"	26ga	26ga	TDC	56¼"	PittsBurgh	-	-
to 24"	24ga	24ga	TDC	56¼"	PittsBurgh	-	-
to 28"	22ga	24ga	TDC	56¼"	PittsBurgh	-	-
to 30"	24ga	24ga	TDC	56¼"	PittsBurgh	-	CTR
to 36"	22ga	22ga	TDC	56¼"	PittsBurgh	-	CTR
to 42"	20ga	22ga	TDC	56¼"	PittsBurgh	-	CTR
to 60"	20ga	20ga	TDC	56¼"	PittsBurgh	JTR	CTR
to 72"	20ga	20ga	TDC	56¼"	PittsBurgh	JTR	CTR(2)
to 96"	18ga	18ga	J-Flange	55½"	PittsBurgh	JTR	CTR(2)
Over-96"	18ga	18ga	J-Flange	55½"	PittsBurgh	JTR(@48")	CTR(@60") & 2x1 1/8x10ga ZBar(J)

### 4' Rectangular Duct & Fittings

Duct Size	Gauge @4'	Gauge @2'	Connector	Joint Length	Duct Seam	Joint Reinforcing	Intermidate Reinforcing(Over2')
0-18"	26ga	26ga	TDC	44¼"	PittsBurgh	-	-
to 24"	24ga	26ga	TDC	44¼"	PittsBurgh	-	-
to 30"	22ga	26ga	TDC	44¼"	PittsBurgh	-	-
to 36"	24ga	24ga	TDC	44¼"	PittsBurgh	-	CTR
to 42"	22ga	22ga	TDC	44¼"	PittsBurgh	-	CTR
to 30"	22ga	20ga	TDC	44¼"	PittsBurgh	-	CTR
to 48"	20ga	20ga	TDC	44¼"	PittsBurgh	-	CTR
to 72"	20ga	20ga	TDC	44¼"	PittsBurgh	JTR	CTR
to 96"	18ga	18ga	J-Flange	43½"	PittsBurgh	JTR	CTR(2)
Over-96"	18ga	18ga	J-Flange	43½"	PittsBurgh	JTR(@48")	CTR(@60") & 2x1 1/8x10ga ZBar(J)

(\*) Requires Intermidate Reinforcing All 4-Sides of Duct



#### References

##### SMACNA

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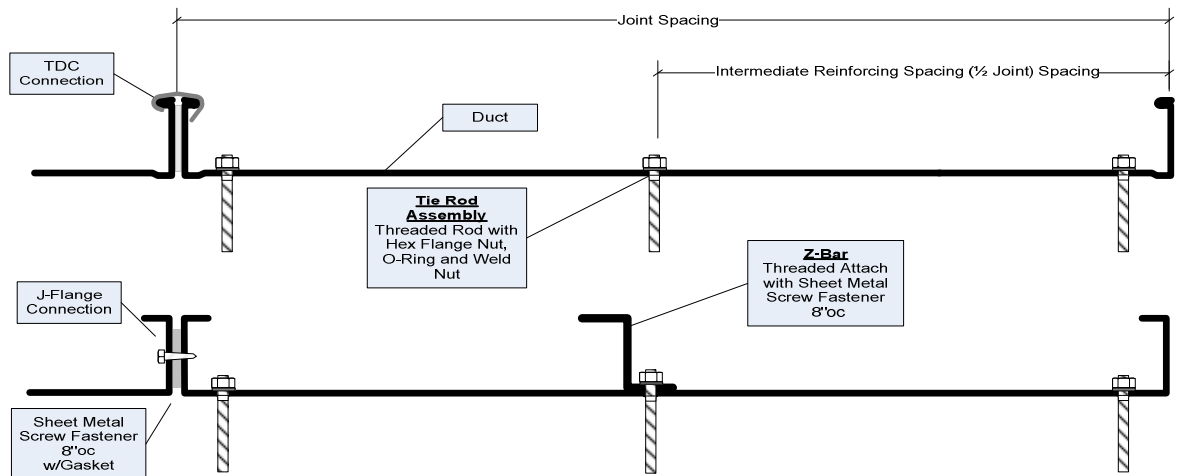
- Table [2-32] Transverse Joint Reinforcement (T-24/25)
- Table [2-19] 5ft Coil/Sheet Stock/T25a/T25b (TDC/TDF) Duct Reinforcement
- Table [2-12] 4ft Coil/Sheet Stock/T25a/T25b (TDC/TDF) Duct Reinforcement
- Table [2-29] Intermidate Reinforcment (I)Rating 2 x 1½ x 12ga
- Figure [2-12,13] Duct Over 120 In Wide
- Figure [2-5] Tie Rod Attachments

<b>to 6"</b> <b>Positive Pressure</b> <b>(+w.g.)</b>	<h1 style="margin: 0;">Stainless Steel Construction</h1> <h2 style="margin: 0;">Supply, Return &amp; Makeup Air duct</h2>
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<b>5' Rectangular Duct &amp; Fittings</b>							
Duct Size	Gauge @5'	Gauge @2½'	Connector	Joint Length	Duct Seam	Joint Reinforcing	Intermediate Reinforcing(Over2½')
0-12"	24ga	24ga	TDC	56¼"	Pittsburgh	-	-
to 24"	22ga	24ga	TDC	56¼"	Pittsburgh	-	-
to 26"	24ga	24ga	TDC	56¼"	Pittsburgh	-	CTR
to 30"	22ga	22ga	TDC	56¼"	Pittsburgh	-	CTR
to 36"	20ga	20ga	TDC	56¼"	Pittsburgh	-	CTR
to 60"	20ga	20ga	TDC	56¼"	Pittsburgh	JTR	CTR
to 84"	18ga	18ga	J-Flange	55½"	Pittsburgh	JTR	CTR(2)
Over-84"	18ga	18ga	J-Flange	55½"	Pittsburgh	JTR(@48")	CTR(@60") & 3x1 1/8x12ga ZBar(K)

<b>4' Rectangular Duct &amp; Fittings</b>							
Duct Size	Gauge @4'	Gauge @2'	Connector	Joint Length	Duct Seam	Joint Reinforcing	Intermediate Reinforcing(Over2')
0-12"	24ga	26ga	TDC	44¼"	Pittsburgh	-	-
to 22"	24ga	24ga	TDC	44¼"	Pittsburgh	-	-
to 26"	22ga	24ga	TDC	44¼"	Pittsburgh	-	-
to 36"	24ga	24ga	TDC	44¼"	Pittsburgh	-	CTR
to 42"	22ga	22ga	TDC	44¼"	Pittsburgh	JTR	CTR
to 30"	22ga	20ga	TDC	44¼"	Pittsburgh	JTR	CTR
to 60"	20ga	20ga	TDC	44¼"	Pittsburgh	JTR	CTR
to 84"	18ga	18ga	J-Flange	43½"	Pittsburgh	JTR	CTR(2)
Over-84"	18ga	18ga	J-Flange	43½"	Pittsburgh	JTR(@48")	CTR(@60") & 3x1 1/8x12ga ZBar(K)

(\*) Requires Intermediate Reinforcing All 4-Sides of Duct



### References

**SMACNA**

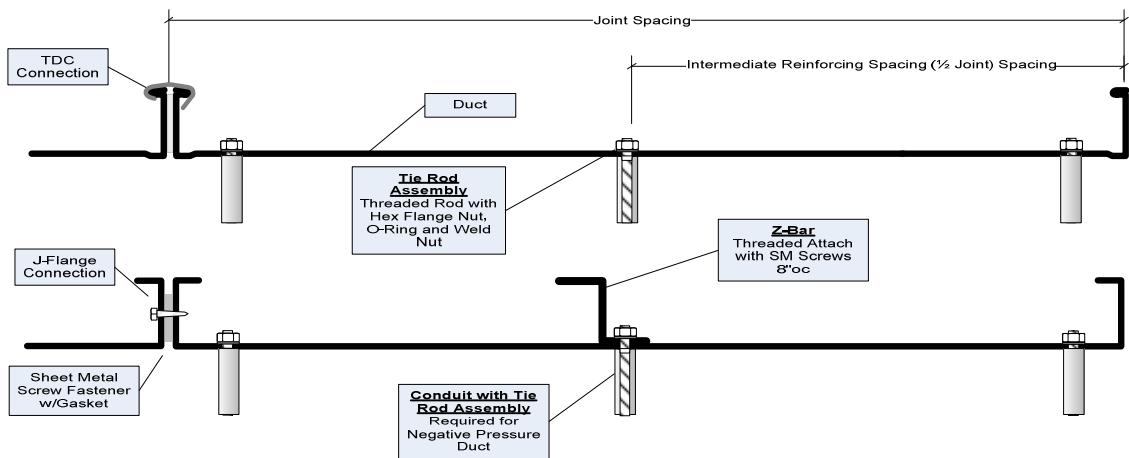
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- Table [2-32] Transverse Joint Reinforcement (T-24/25)
- Table [2-20] 5ft Coil/Sheet Stock/T25a/T25b (TDC/TDF) Duct Reinforcement
- Table [2-13] 4ft Coil/Sheet Stock/T25a/T25b (TDC/TDF) Duct Reinforcement
- Table [2-29] Intermediate Reinforcement (I)Rating 2 x 1½ x 12ga
- Figure [2-12,13] Duct Over 120 In Wide
- Figure [2-5] Tie Rod Attachments

<b>to 2"</b> <b>Negative Pressure</b> <b>(-w.g.)</b>	<h1 style="margin: 0;">Stainless Steel Construction</h1> <h2 style="margin: 0;">Exhaust, Fume &amp; Ventilation Duct</h2>
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<b>5' Rectangular Duct &amp; Fittings</b>							
Duct Size	Gauge @5'	Gauge @2½'	Connector	Joint Length	Duct Seam	Joint Reinforcing	Intermediate Reinforcing(Over2½')
to 30"	24ga	24ga	TDC	56¼"	Pittsburgh	-	-
to 36"	22ga	24ga	TDC	56¼"	Pittsburgh	-	-
to 42"	24ga	24ga	TDC	56¼"	Pittsburgh	-	CTR w/Conduit
to 54"	22ga	22ga	TDC	56¼"	Pittsburgh	-	CTR w/Conduit
to 60"	22ga	22ga	TDC	56¼"	Pittsburgh	JTR w/Conduit	CTR w/Conduit
to 72"	20ga	20ga	TDC	56¼"	Pittsburgh	JTR w/Conduit	CTR w/Conduit
to 96"	20ga	20ga	TDC	56¼"	Pittsburgh	JTR w/Conduit	CTR(2) w/Conduit
Over-96"	18ga	18ga	J-Flange	55½"	Pittsburgh	JTR(@48") w/Conduit	CTR(@60") w/Conduit *2x1 1/8x12ga ZBar(l)

<b>4' Rectangular Duct &amp; Fittings</b>							
Duct Size	Gauge @4'	Gauge @2'	Connector	Joint Length	Duct Seam	Joint Reinforcing	Intermediate Reinforcing(Over2')
to 36"	24ga	24ga	TDC	44¼"	Pittsburgh	-	-
to 48"	24ga	24ga	TDC	44¼"	Pittsburgh	-	CTR w/Conduit
to 60"	22ga	22ga	TDC	44¼"	Pittsburgh	-	CTR w/Conduit
to 72"	20ga	20ga	TDC	44¼"	Pittsburgh	JTR w/Conduit	CTR w/Conduit
to 96"	20ga	20ga	TDC	44¼"	Pittsburgh	JTR w/Conduit	CTR(2) w/Conduit
Over-96"	18ga	18ga	J-Flange	43½"	Pittsburgh	JTR(@48") w/Conduit	CTR(@60") w/Conduit *2x1 1/8x12ga ZBar(l)



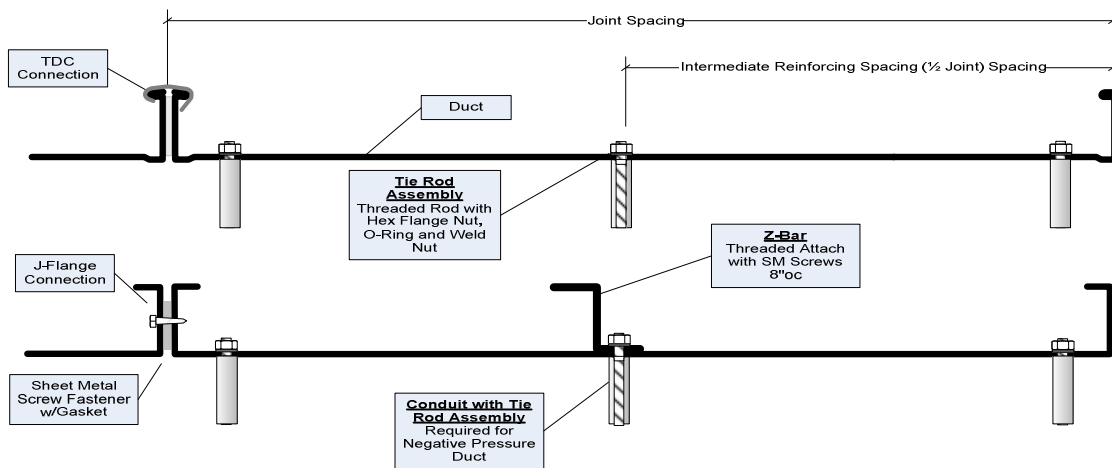
**References**  
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 Table [2-10] 4ft Coil/Sheet Stock/T25a/T25b (TDC/TDF) Duct Reinforcement  
 Table [2-29] Intermediate Reinforcement (l)Rating 2 x 1½ x 12ga  
 Figure [2-12,13] Duct Over 120 In Wide  
 Figure [2-5] Tie Rod Attachments

<b>to 4"</b> <b>Negative Pressure</b> <b>(-w.g.)</b>	<h2 style="margin: 0;">Stainless Steel Construction</h2> <h2 style="margin: 0;">Exhaust, Fume &amp; Ventilation Duct</h2>
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<b>5' Rectangular Duct &amp; Fittings</b>							
Duct Size	Gauge @5'	Gauge @2½'	Connector	Joint Length	Duct Seam	Joint Reinforcing	Intermediate Reinforcing(Over2½')
to 24"	24ga	24ga	TDC	56¼"	Pittsburgh	-	-
to 28"	22ga	24ga	TDC	56¼"	Pittsburgh	-	-
to 30"	24ga	24ga	TDC	56¼"	Pittsburgh	-	CTR w/Conduit
to 36"	22ga	22ga	TDC	56¼"	Pittsburgh	-	CTR w/Conduit
to 42"	20ga	22ga	TDC	56¼"	Pittsburgh	-	CTR w/Conduit
to 60"	20ga	20ga	TDC	56¼"	Pittsburgh	JTR w/Conduit	CTR w/Conduit
to 72"	20ga	20ga	TDC	56¼"	Pittsburgh	JTR w/Conduit	CTR(2) w/Conduit
to 96"	18ga	18ga	J-Flange	55½"	Pittsburgh	JTR w/Conduit	CTR(2) w/Conduit
Over-96"	18ga	18ga	J-Flange	55½"	Pittsburgh	JTR(@48") w/Conduit	CTR(@60") w/Conduit *2x1 1/8x10ga ZBar(J)

<b>4' Rectangular Duct &amp; Fittings</b>							
Duct Size	Gauge @4'	Gauge @2'	Connector	Joint Length	Duct Seam	Joint Reinforcing	Intermediate Reinforcing(Over2')
to 24"	24ga	24ga	TDC	44¼"	Pittsburgh	-	-
to 30"	22ga	24ga	TDC	44¼"	Pittsburgh	-	-
to 36"	24ga	24ga	TDC	44¼"	Pittsburgh	-	CTR w/Conduit
to 42"	22ga	22ga	TDC	44¼"	Pittsburgh	-	CTR w/Conduit
to 30"	22ga	20ga	TDC	44¼"	Pittsburgh	-	CTR w/Conduit
to 48"	20ga	20ga	TDC	44¼"	Pittsburgh	-	CTR w/Conduit
to 72"	20ga	20ga	TDC	44¼"	Pittsburgh	JTR w/Conduit	CTR w/Conduit
to 96"	18ga	18ga	J-Flange	43½"	Pittsburgh	JTR w/Conduit	CTR(2) w/Conduit
Over-96"	18ga	18ga	J-Flange	43½"	Pittsburgh	JTR(@48") w/Conduit	CTR(@60") w/Conduit *2x1 1/8x10ga ZBar(J)



**References**

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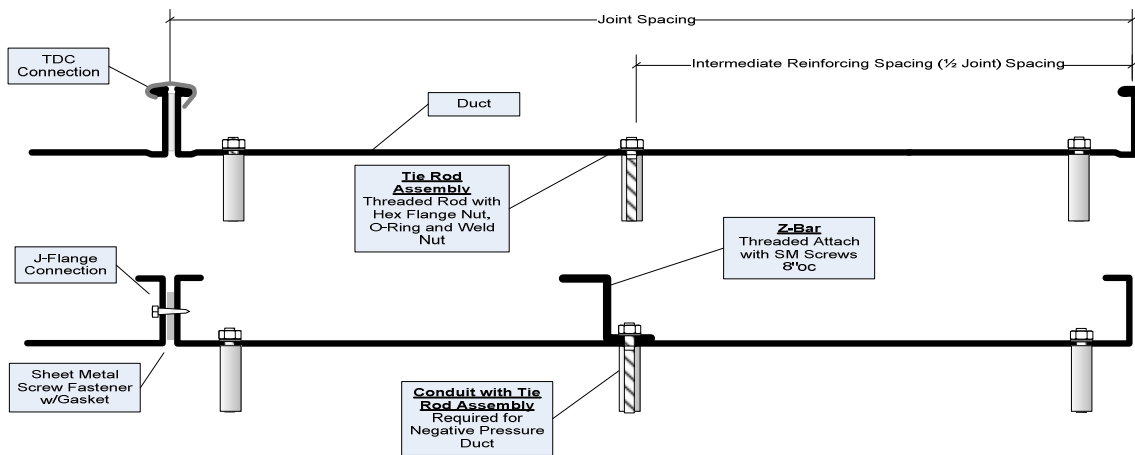
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<b>to 6"</b> <b>Negative Pressure</b> <b>(-w.g.)</b>	<h2 style="margin: 0;">Stainless Steel Construction</h2> <h2 style="margin: 0;">Exhaust, Fume &amp; Ventilation Duct</h2>
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<b>5' Rectangular Duct &amp; Fittings</b>							
Duct Size	Gauge @5'	Gauge @2½'	Connector	Joint Length	Duct Seam	Joint Reinforcing	Intermediate Reinforcing(Over2½')
0-12"	24ga	24ga	TDC	56¼"	Pittsburgh	-	-
to 24"	22ga	24ga	TDC	56¼"	Pittsburgh	-	-
to 26"	24ga	24ga	TDC	56¼"	Pittsburgh	-	CTR w/Conduit
to 30"	22ga	22ga	TDC	56¼"	Pittsburgh	-	CTR w/Conduit
to 36"	20ga	20ga	TDC	56¼"	Pittsburgh	-	CTR w/Conduit
to 60"	20ga	20ga	TDC	56¼"	Pittsburgh	JTR w/Conduit	CTR w/Conduit
to 84"	18ga	18ga	J-Flange	55½"	Pittsburgh	JTR(2) w/Conduit	CTR(2) w/Conduit
Over-84"	18ga	18ga	J-Flange	55½"	Pittsburgh	JTR(@48") w/Conduit	CTR(@60") w/Conduit *3x1 1/8x12ga ZBar(K)

<b>4' Rectangular Duct &amp; Fittings</b>							
Duct Size	Gauge @4'	Gauge @2'	Connector	Joint Length	Duct Seam	Joint Reinforcing	Intermediate Reinforcing(Over2')
to 22"	24ga	24ga	TDC	44¼"	Pittsburgh	-	-
to 26"	22ga	24ga	TDC	44¼"	Pittsburgh	-	-
to 36"	24ga	24ga	TDC	44¼"	Pittsburgh	-	CTR w/Conduit
to 42"	22ga	22ga	TDC	44¼"	Pittsburgh	JTR w/Conduit	CTR w/Conduit
to 30"	22ga	20ga	TDC	44¼"	Pittsburgh	JTR w/Conduit	CTR w/Conduit
to 60"	20ga	20ga	TDC	44¼"	Pittsburgh	JTR w/Conduit	CTR w/Conduit
to 84"	18ga	18ga	J-Flange	43½"	Pittsburgh	JTR(2) w/Conduit	CTR(2) w/Conduit
Over-84"	18ga	18ga	J-Flange	43½"	Pittsburgh	JTR(@48") w/Conduit	CTR(@60") w/Conduit *3x1 1/8x12ga ZBar(K)



### References

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- Figure [2-5] Tie Rod Attachments