



1" STATIC PRESSURE

(Positive & Negative)

with CONDU-LOCK rod reinforcement
by Production Products

DUCT CONSTRUCTION STANDARDS FOR ±1" WG
GALVANIZED, 304 STAINLESS STEEL & 316 STAINLESS STEEL

DUCT SIZE (INCHES):	DUCT GAUGE:	FINISHED LENGTH: (INCHES)	CONNECTORS	
			LARGE SIDE:	SMALL SIDE:
0-18	26	59	FLAT SLIP T-6 24 GA	FLAT DRIVE T-1 24 GA
19-30	26	59	STANDING SLIP	
31-42	24	59		
43-54	22	59		
55-60	22	56	TDC T-25A	TDC T-25A
61-72	20	56	TDC W/CTR T-25A	
73-96	20	56	TDC W/CTR & JTR T-25A	TDC W/CTR & JTR T-25A
97 & UP	18	56		

NOTES:

CDS uses 3/4" EMT RODS

CTR- CENTER TIE ROD

JTR- JOINT TIE ROD

MPTR- MID POINT TIE RODS (SPACING 2.5')



2" STATIC PRESSURE

(Positive & Negative)

with CONDU-LOCK rod reinforcement
by Production Products

DUCT CONSTRUCTION STANDARDS FOR ±2" WG

GALVANIZED, 304 STAINLESS STEEL & 316 STAINLESS STEEL

DUCT SIZE (INCHES):	DUCT GAUGE:	FINISHED LENGTH: (INCHES)	CONNECTORS	
			LARGE SIDE:	SMALL SIDE:
0-14	26	59	FLAT SLIP T-6 24 GA	FLAT DRIVE T-1 24 GA
15-26	26	59	FLAT SLIP/ STANDING SLIP	
27-36	24	59	STANDING SLIP	
37-42	22	56		
43-48	22	56	TDC T-25A	TDC W/CTR T-25A
49-60	22	56	TDC W/CTR T-25A	TDC W/ CTR & JTR T-25A
61-84	22	56	TDC W/ CTR & JTR T-25A	
85-97	20	56		
98 & UP	18	56		

NOTES:

CDS uses 3/4" EMT RODS

CTR- CENTER TIE ROD

JTR- JOINT TIE ROD

MPTR- MID POINT TIE RODS (SPACING 2.5')



3" STATIC PRESSURE

(Positive & Negative)

with CONDU-LOCK rod reinforcement
by Production Products

DUCT CONSTRUCTION STANDARDS FOR ±3" WG
GALVANIZED, 304 STAINLESS STEEL & 316 STAINLESS STEEL

DUCT SIZE (INCHES):	DUCT GAUGE:	FINISHED LENGTH: (INCHES)	CONNECTORS	
			LARGE SIDE:	SMALL SIDE:
0-26	26	56 3/8	TDC T-25A	
27-36	24	56 3/8		
37-60	22	56 3/8	TDC T-25A CTR	TDC T-25A
61-72	20	56 3/8		
73-96	20	56 3/8	TDC T-25A CTR & JTR	
97 & UP	18	56 3/8	TDC T-25A CTR & JTR	

NOTES:

CDS uses 3/4" EMT RODS

CTR- CENTER TIE ROD

JTR- JOINT TIE ROD

MPTR- MID POINT TIE RODS (SPACING 2.5')



4" STATIC PRESSURE (Positive & Negative)

with CONDU-LOCK rod reinforcement
by Production Products

DUCT CONSTRUCTION STANDARDS FOR ±4" WG
GALVANIZED, 304 STAINLESS STEEL & 316 STAINLESS STEEL

DUCT SIZE (INCHES):	DUCT GAUGE:	FINISHED LENGTH: (INCHES)	CONNECTORS	
			LARGE SIDE:	SMALL SIDE:
0-26	26	56 3/8	TDC T-25A	
27-30	24	56 3/8		
31-36	22	56 3/8		
37-42	20	56 3/8	TDC T-25A	TDC JTR T-25A
43-60	20	56 3/8	TDC CTR T-25A	
61-96	20	56 3/8	TDC CTR + JTR T-25A	
97 & UP	18	56 3/8		

NOTES:

CDS uses 3/4" EMT RODS

CTR- CENTER TIE ROD

JTR- JOINT TIE ROD

MPTR- MID POINT TIE RODS (SPACING 2.5')



6" STATIC PRESSURE (Positive & Negative)

with CONDU-LOCK rod reinforcement
by Production Products

DUCT CONSTRUCTION STANDARDS FOR ±6" WG
GALVANIZED, 304 STAINLESS STEEL & 316 STAINLESS STEEL

DUCT SIZE (INCHES):	DUCT GAUGE:	FINISHED LENGTH: (INCHES)	CONNECTORS	
			LARGE SIDE:	SMALL SIDE:
0-18	24	56 3/8	TDC T-25A	
19-24	22	56 3/8		
25-42	22	56 3/8	TDC CTR T-25A	TDC T-25A
43-54	20	56 3/8		
55-96	20	56 3/8	TDC CTR + JTR T-25A	TDC CTR T-25A
97 & UP	18	56 3/8	TDC CTR + JTR T-25A	

NOTES:

CDS uses 3/4" EMT RODS

CTR- CENTER TIE ROD

JTR- JOINT TIE ROD

MPTR- MID POINT TIE RODS (SPACING 2.5')

DOUBLE WALL DUCT SOLID INNER WALL:

- ❑ **Durable alternative to lined duct**
- ❑ **Solid inner core completely encloses insulation, preventing airflow problems especially in high velocity air streams.**

- ❑ **Liner available from R-4 to R-8**

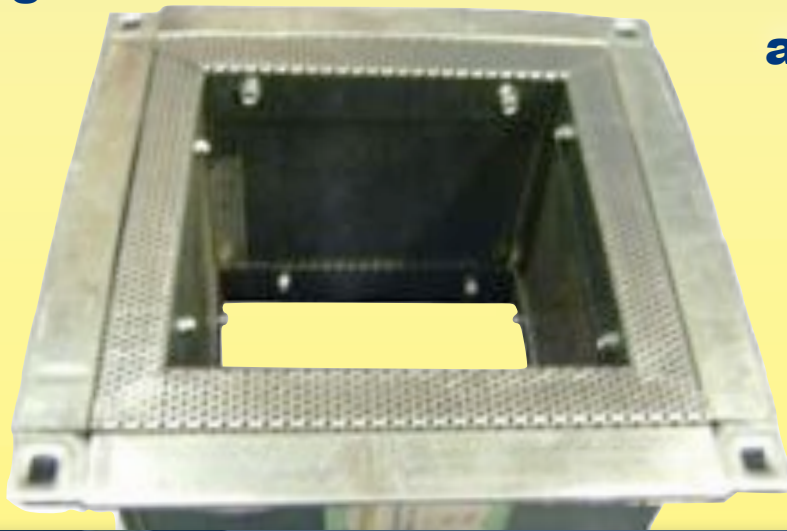


**COMMERCIAL
DUCT SYSTEMS^{LLC}**
PRECISION BEYOND STANDARDS.

DOUBLE WALL DUCT PERFORATED INNER WALL:

- **Has 3/32" diameter holes staggered on 3/16" centers for a clear open area of 23%**

- **Liner available from R-4 to R-8**



- **Perforated inner core with plastic film completely enclosing insulation, preventing airflow problems especially in high velocity air streams**

- **Dependable, noise reducing alternative to lined duct**



**COMMERCIAL
DUCT SYSTEMS^{INC.}**
PRECISION BEYOND STANDARDS.



LINER & ADHESIVE

- Liner is glued to duct with 90% adhesive coverage.**
- Adhesive is water based, asbestos free, & meets LEEDS standards.**
- Mechanically fastened by pins welded to duct.**
- Corner joints are overlapped and compressed.**
- Fire resistant material is treated with biocide.**
- Tough airside surface resists high velocity airflow.**
- Edges are coated or nosed in to meet project**

THICKNESS	WEIGHT	R-VALUE
1.0"	1.5#	4.0
	3.0#	5.8
1.5"	1.5#	6.0
2.0"		8.0

**Neatly line up edges
without gaps after
installation**

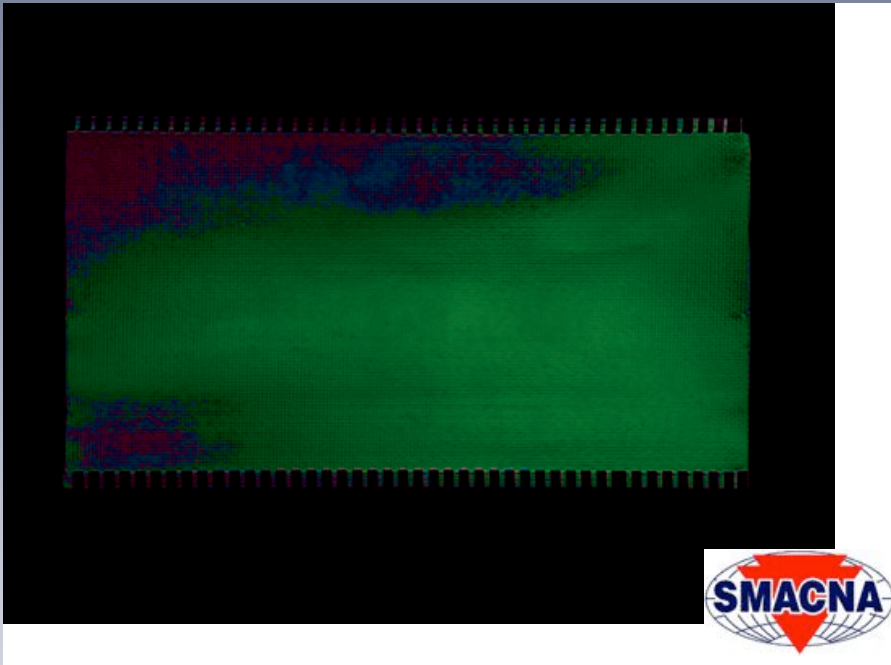
Reliable service

Durable & clean

Absorbs noise and vibration



CANVAS DUCT NOTCH LOCK



FABRIC DUCT- NOTCH LOCK BY ELGEN MANUFACTURING

Features:

- prevents vibration and noise between fans and duct systems
- seals from air and water by connecting fabric to sheetmetal on both sides
- meets SMACNA standards
- G60/G90 Materials conform with ASTM A-635
- flame retardant coating
- meets NFPA-701 (old UL-214)
- meets NFPA-90A & 90B
- hermetic, waterproof seal

Available Metals:

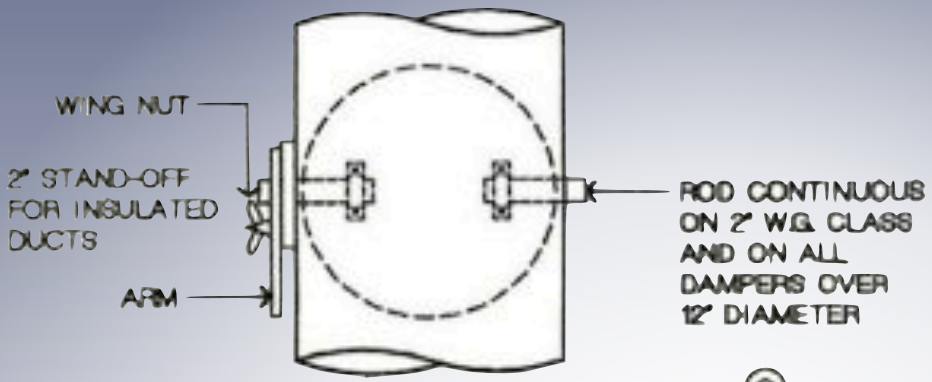
Galvanized	Alumium
Galvanneal (PaintGrip)	PVC Coated
Stainless Steel (#304 & #316)	AgION



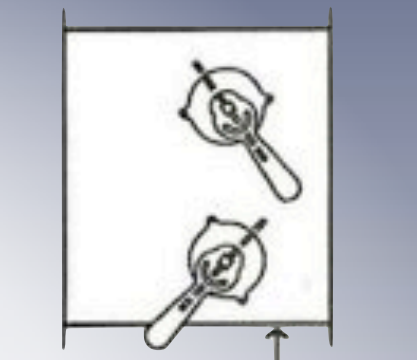
Canvas Material Technical Data

	Temp Range	Tear Strength	Tensile Strength	Color	Weight SQ/YD	Features	Compliant
Vinlon	-40 F up to 265 F	100/100	300/300	BLACK	22	General Purpose, Airtight Resistance to Acids, Gasoline & Grease	UL-723, NFPA-701, LEEDs 30% Recycled
Neoprene	-40 F up to 200 F	25/25	500/500	BLACK	32	Excellent Acid, Weather, UV, Mildew & Ozone Resistance, High Abrasion, Resistant to Grease	LEEDs 30% Recycled
Hypalon	-50 F up to 300 F	20/20	350/250	WHITE	24	High Tear Strength, High Abrasion, Low Smoke, Extremely Flexible	
Silguard	-75 F up to 500 F	50/40	200/150	WHITE	18	High Temp. & Acid Resistant, Best Overall Fabric	
Teflon	-75 F up to 500 F	60/40	400/300	GRAY	18	High Temp., Very Low Smoke, Flame, Water, & Oil Resistant	
40 oz Neoprene	-40 F to 285 F	17/12	630/465	BLACK	40		
Super High Temp	-40 F to 1800 F	60/60	480/330	GRAY/WHITE	36		

VOLUME DAMPERS



**FIG. C
ROUND DAMPER**



**FIG. D
ELEVATION
TWO BLADE ARRANGEMENT**

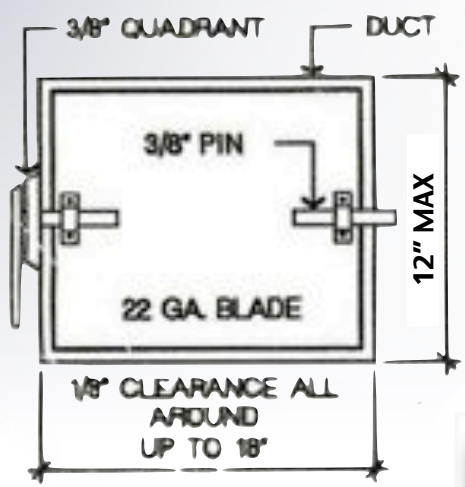


FIG. A

FOR SINGLE
BLADE DAMPERS

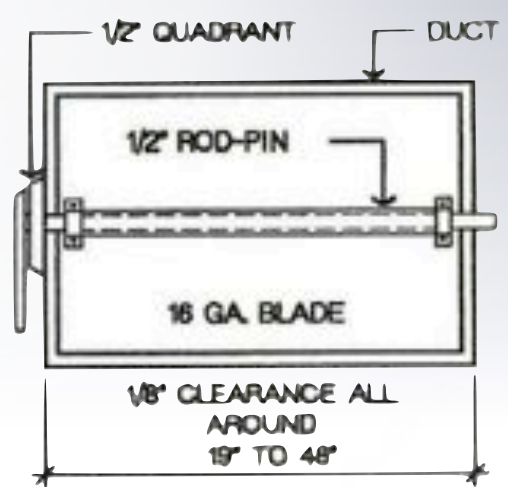
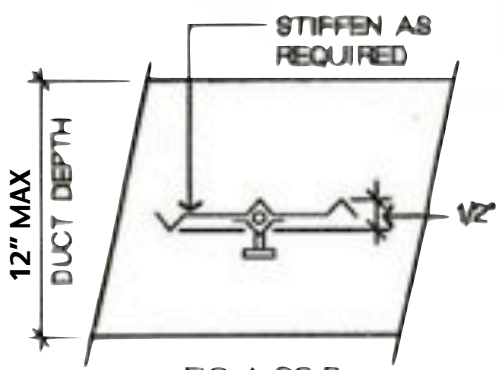
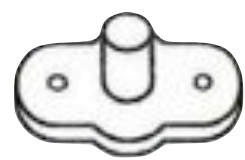


FIG. B

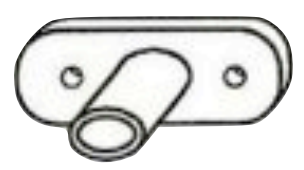
**NOTE:
OVER 18 X 12 USE
MUTLIPLE BLADES**



**FIG. A OR B
SIDE ELEVATION**



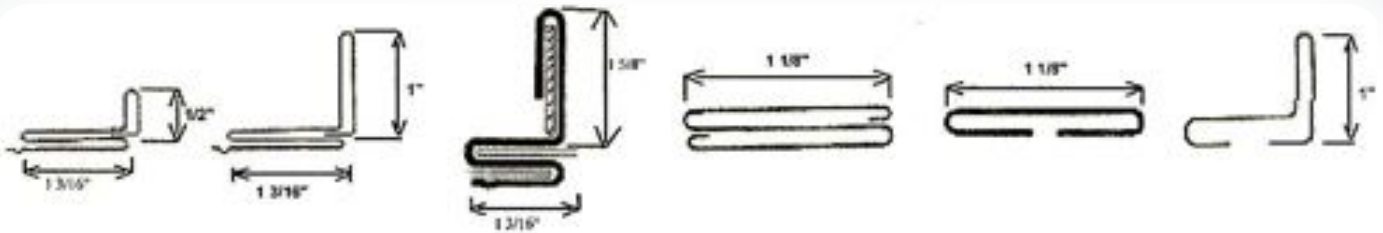
**OUTSIDE
END BEARING**



**INSIDE
END BEARING**

REQUIRED ON 2\"/>

SLIPS AND DRIVES



1/2" & 1" STANDING S

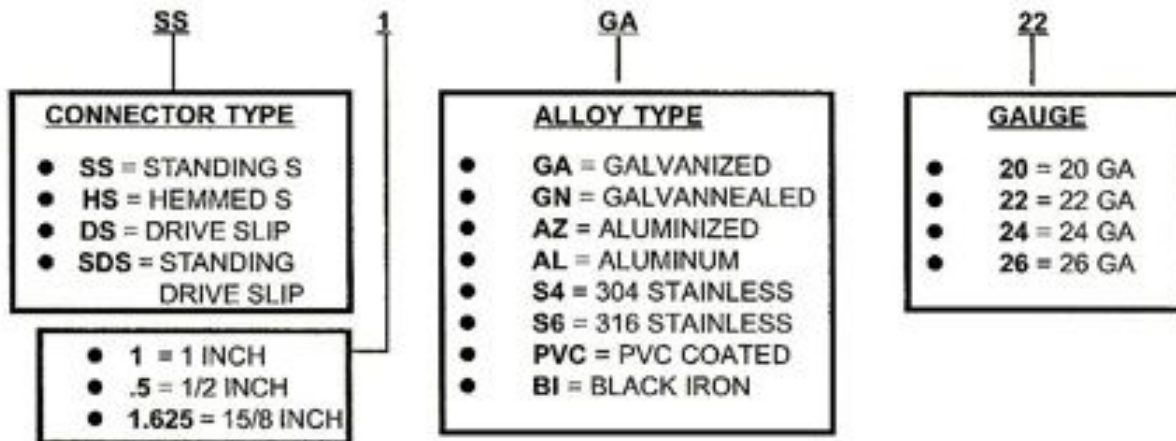
1 5/8" REINFORCED S

HEMMED S SLIP

DRIVE SLIP

**1" STANDING
DRIVE SLIP**

EXAMPLE: SSGA22



PACKAGING: 5', 8' OR 10' LENGTHS/100' BUNDLES

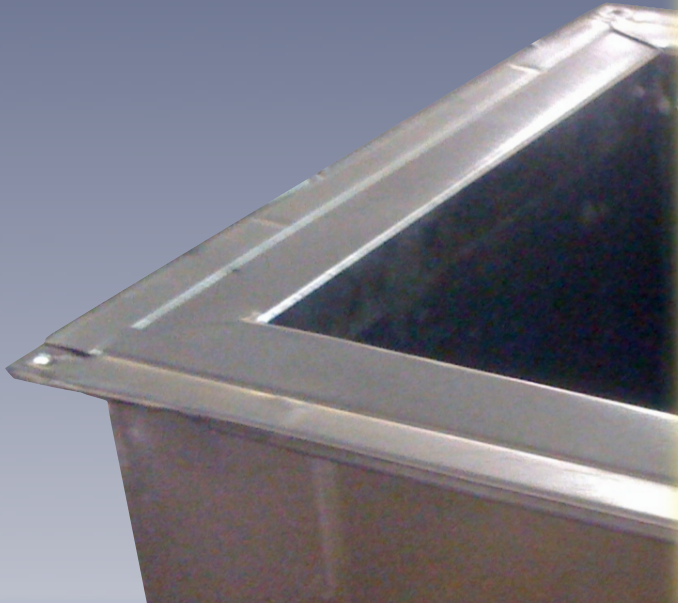
WEIGHTS LISTED IN LBS/FT

GAUGES	1/2" STANDING S	1" STANDING S	1 5/8" STANDING S	HEMMED S	DRIVE-SLIP	1" STANDING DRIVE SLIP	COLOR CODE
20 GA	N/A	0.78	0.79*	N/A	N/A	N/A	YELLOW
22 GA	N/A	0.58	0.68*	N/A	N/A	.46	GREEN
24 GA	0.41	0.55*	N/A	0.32*	0.19*	.40	ORANGE
26 GA	0.35*	0.44	N/A	0.25*	0.15*	.33	BLUE
28 GA	N/A	N/A	N/A	0.227	0.12	N/A	RED

*MOST POPULAR GAUGE PER CONNECTOR

N/A DESIGNATES GAUGES NOT YET AVAILABLE

TDC Connectors



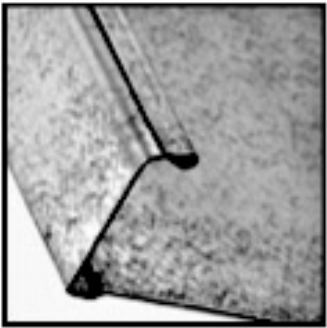
Benefits:

- ❑ Lower installation costs, times, and leakage
- ❑ 3/8" carriage bolts at each corner lock the joint together.
- ❑ Flanges are roll formed from the duct wall metal, reinforcing the joints.
- ❑ Rigid connectors
- ❑ No additional sealing is required.

TDC

Corner clips are available factory installed. Gasket and bolts are applied in the field. Optional clips are spaced down the length of the flanges sandwiching the gasket into a tight seal.

Profile

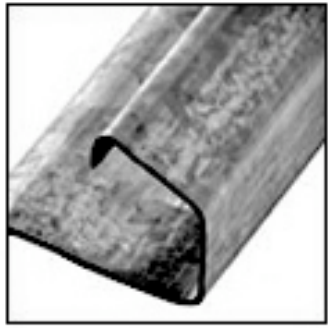


TDC® flange profile





TDC profile joined

Profile

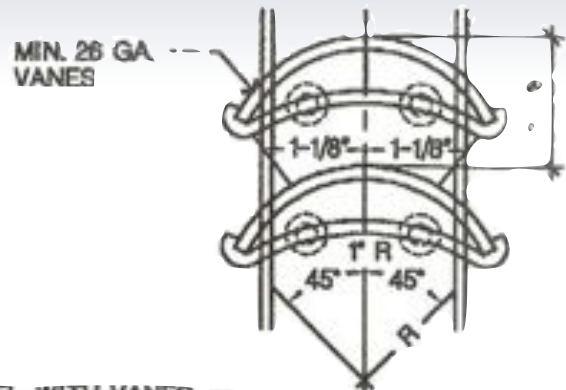
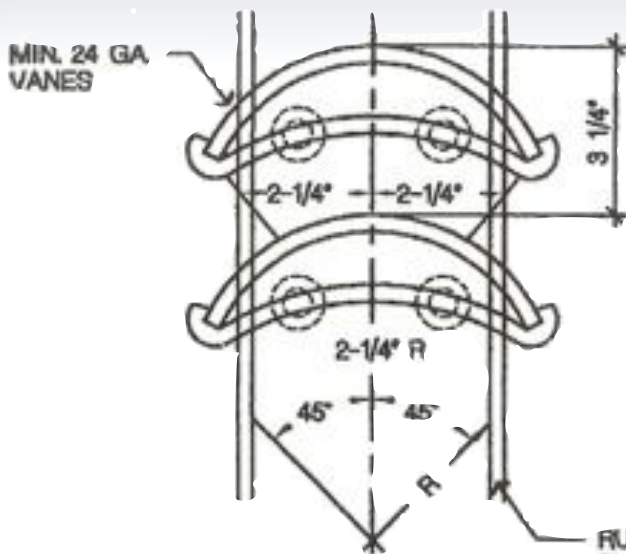


TDC profile joined with optional clip

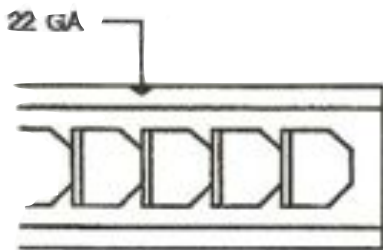
Auxiliary Rolls

ROLLS AND OPTIONS		CAPACITY	STRIP WIDTH
TDC® Clip (minimum length 20")		22 gauge	2 1/8"
TDC® Clip Rolls with Lance		22 gauge	2 1/8"
TDC® Lance Kit Only		22 gauge	
Lockformer®/TDC® II Rolls (mounted inboard, available in 35, 30 25 or 20 mm)		20 gauge	5 1/8"

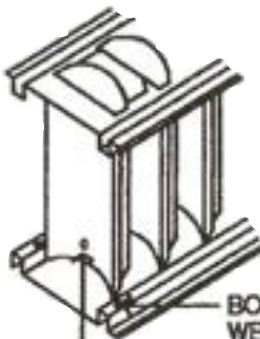
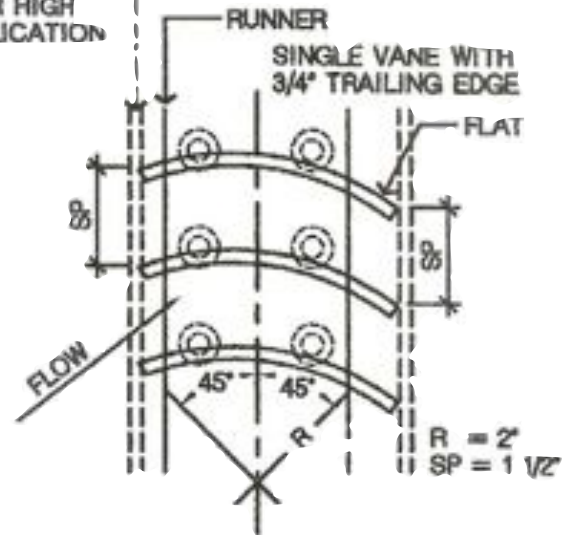
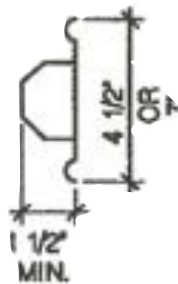
TURNING VANES & VANE RUNNERS



CHANNEL, WITH VANES TACKED IN FOR HIGH VELOCITY APPLICATION

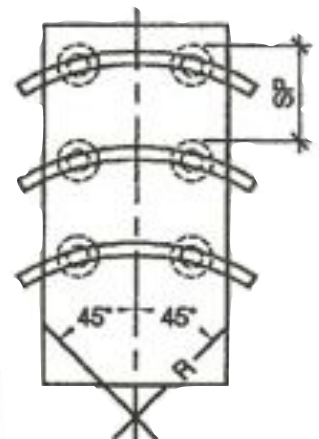


RUNNER TYPE 1



SCREW EVERY 8TH VANE

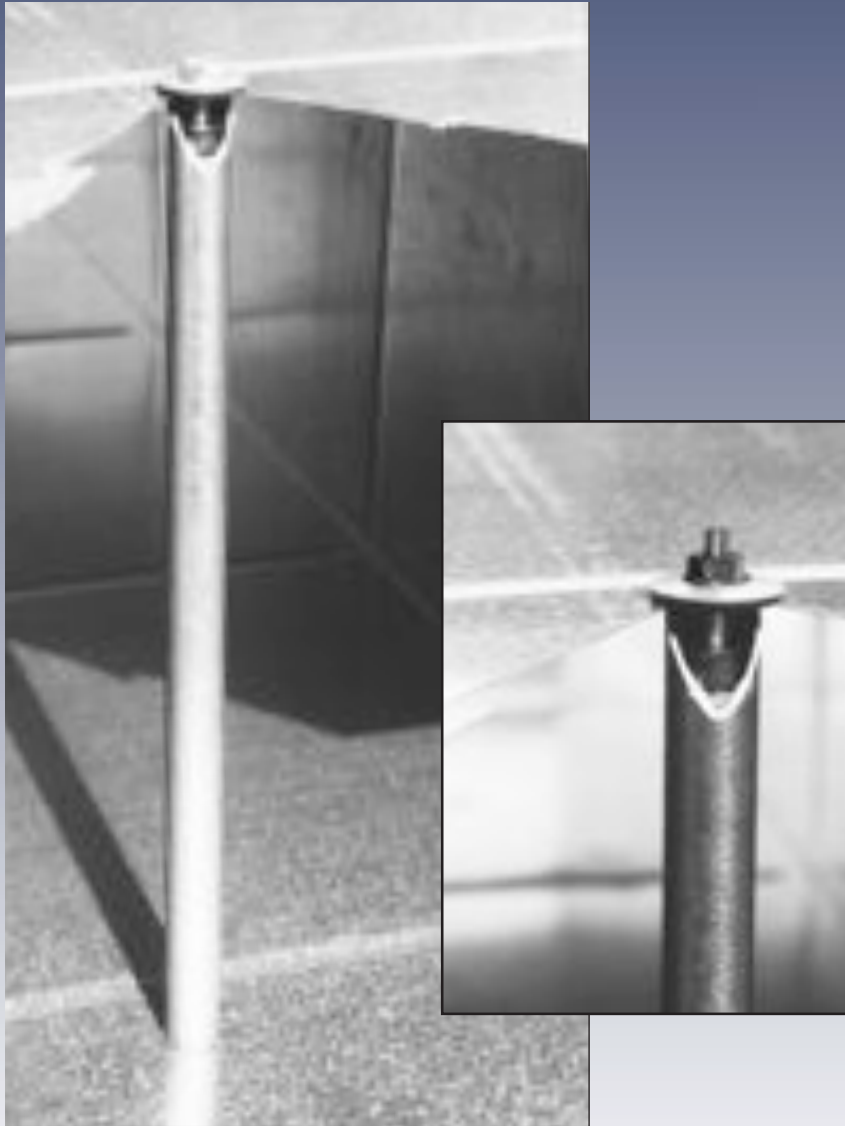
SINGLE VANE SCHEDULE			
SIZE	R	SP	GA.
SMALL	2"	1-1/2"	24
LARGE	4-1/2"	3-1/4"	22



GENERAL NOTES:

DOUBLE VANE FOR DUCTS GREATER THAN 18" x 18"
SINGLE VANE FOR DUCTS UP TO 18" x 18"

TIE ROD

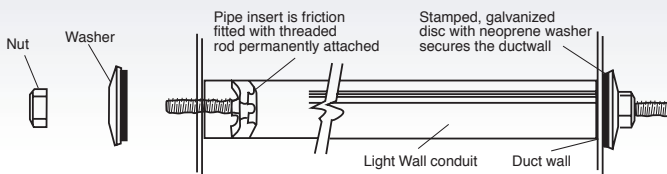


EASYROD/EASYSTUD BY DUCTMATE INDUSTRIES

Easystud/Easyrod reinforces ductwork by inserting threaded studs in EMT conduit for consistent installation in positive or negative pressure applications. Ductmate Industries guarantees Easyrod/Easystud against defective material.

Installation Instructions:

- ❑ Drill a hole for 9/32" through both top and bottom walls of duct.
- ❑ Cut conduit to size of duct.
- ❑ Place Easyrod/Easystud insert on installation tool with prongs facing the tool.
- ❑ Drive one insert into each end of the conduit.
- ❑ Position the conduit with inserts protruding through holes in duct walls.
- ❑ Install the washer and nut to bolt and tighten till snug. (Do not overtighten.)

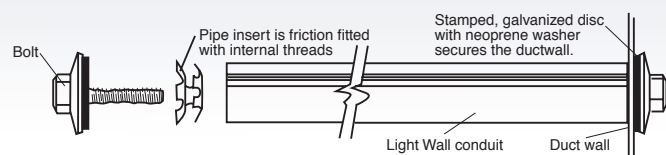


EASYSTUD

PULL OUT RATED - 600 lbs

COMPONENTS:

- 1/2" Easystud insert
- 1/4" ID x 1" OD galvanized neoprene bonded washer
- 1/2" bolt



EASYROD

PULL OUT RATED - 900 lbs

COMPONENTS:

- 1/2" or 3/4" Easyrod insert
- 1/4" ID x 1" OD galvanized neoprene bonded washer
- 1/4" x 1" N.C., Gr. 5, plated hex bolt



Galvanized Steel



All ductwork fabricated from galvanized steel is made with G-90 hot dipped galvanized metal. This cold rolled steel complies with ASTM A 527/A 653.

G90 steel is coated with a minimum .90 oz/ft² zinc to steel ratio.

Estimated to have zinc coating thickness of 1.53 mils (according to ASTM A 653/A 653M- 8.1.2.1).

Thermally treated galvanized steel suitable for immediate painting is available; known as “Galvaneal” and “Paintgrip”.

Available gauges: 16 ga to 26 ga Meets LEEDS standards for green construction.



COMMERCIAL DUCT SYSTEMS MEETS LEED/GREEN STANDARDS

- ONLY RECYCLED DOMESTIC STEEL
- DUCT WIPED OUT
- WRAPPED ENDS PREVENT DEBRIS CONTAMINATION

**2008 Recycled Steel Content
(% Total Weight)**

Product Group	Average Recycled Content
Nucor Bar Products	97.7%
Nucor Beam Products	76.2%
Nucor Plate Products	92.5%
Nucor Sheet Products	70.2%
Total Nucor Steel Combined	89.7%
Vulcraft Structural Products	97.7%
Vulcraft Decking	70.2%
Nucor Building Group	89.7%
NUCON Light Gauge Framing	70.2
Nucor Fastener Products	97.7%
Nucor Wire Products	97.7%
Nucor Cold Finish	97.7%

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Manufacturing with Pride



In the USA