

DUCTING

DUSTECH fabricated accordance with 2005 'SMACNA' standards, ASHRAE standards or as per consultants specifications.

Rectangular duct work has been the main type of duct work in history of HVAC. It is still used today on a greater percentage of commercial projects over any other type. Commercial construction jobs. Every piece we manufacture meets or exceeds standards and project requirements, including Leeds and GREEN CONSTRUCTION STANDARDS.

Dustech is in fabrication of SPIRAL, OVAL & RECTANGULAR DUCTS & ducts products in galvanized iron steel, aluminum, stainless steel, fire rated ducting, linear acoustic insulation and aluminum cladding with an option of painting & powder coating.

RECTANGULAR DUCT

'DUSTECH' Rectangular duct and fitting are factory fabricated to furnish with a high quality line of products in a board range of standard size. To minimize field-assembly/fabrication cost. Rectangular duct is supplied in lengths upto 4 feet.

Longitudinal seams are typically made with Pittsburgh lock in transverse joint S&C cleat joint, four-bolt connectors are available.

DUSTECH-Rectangular duct work can be shipped completely assembled or knock down in 'L' shape. 'DUSTECH' standard rectangular products are fabricated to meet SMACNA, ASHREA duct connection/fabrication standards. We can also custom fabricate rectangular duct work for commercial and industrial application according to consultant specification.

This table gives minimum duct wall thickness (gage) for use of flat type joint systems. Plain S and hemmed as connectors are limited to 2 in. wg maximum. Slips and drives must not be less than two gages lighter than the duct wall nor below 24 gage. Double S slips must be 24 gage for ducts 30 in. (762 mm) wide or less and 22 gage for greater width.

DUCT DIMENSION (mm)	PRESSURE CLASS (in. wg)						
	Positive or Negative						
	½	1	2	3	4	6	10
200	26	26	26	24	24	24	22
201-250	26	26	26	24	22	20	18
251-300	26	26	24	22	20	18	16
301-350	26	24	22	20	18	18	
351-400	26	22	20	18	18	16	
401-450	26	22	20	18	16		
451-500	24	20	18	16			
501-550	22	18	16	16			
551-600	22	18	16	16			
601-650	20	18					
651-700	18	16					
701-750	18	16					
751-900	16						



REINFORCEMENT IS REQUIRED

Duct gage	26 to 22	20	18	16
Minimum flat slip and drive gage	24	22	20	18

SPIRAL DUCT

“DUSTECH” has been established to supply spiral duct and associated fittings our commitment to excellence also extended our leading after sales services and supply program’s “FOR ORDERING TO ON GOING SUPPORT.” Dustech specializes in HVAC & Dust extraction systems. We at Dustech (Roll-o-fab) master the science of air management with the experience of derstanding of practical applications, ensure the project is error free, on time and on budget. We look forward to work with your organization. Thanks for considering “DUSTECH DUCT” For your next project.

“DUSTECH” CAN BE USED IN VAROIUS FIELD SUCH

As high and low velocity air handling
General ventilation
Warm air heating
Sound absorbers
Weather proof jacketing of pipeline
column formers
pier liners
Dust extraction
fume extraction

Air conditioning
Tunnel/mine ventilation
Void/spon tubing
Daring/irrigation
Pool fundamation
Display props
Conveyor
Culvet
Well casing

ADVANTAGES OF ROLL-O-FAB

1. Energy efficient
2. Easy & fast installation
3. More straightly per square meter
4. Low noise level
5. Maintenance friendly
6. Modification & extraction is easy
7. Low friction losses
9. Need less handling arrangement
10. Light in weight
11. Low project cost
12. No accommodation of dust and foreign material in corner being smooth surface
13. Can be exposed for good a static
14. Used less raw material

AVAILABILITY OF SIZE/MARKED (28 SWG-18 AWG)

Galvano (pb free) Galvanized steel
Stainless steel Aluminum
Milled steel

DUCT FITTINGS

All accessories bends, elbow, reducer
off set, endxaps & Tee pieces etc are manufactured high speed modify with accurate dimension

SPIRAL DUCT

ROLL-O-FAB INSTALLATION INSTRUCTION

1. Spiral pipe must be cut at straight right angle and be burred.

2. Make sure the spiral pipe or large end fitting is pushed all the way in and up to the groove of the small end fitting.
3. Secure the slip connection together by using 1/8 sheet metal screws or rivets.
4. Place the screw or rivets 1"-1½ from the edge of the duct or the large end fitting to avoid cutting the gasket.

SELF SEALING COUPLING

- Between 15% to 25% off your field installation cost lower down.
- Ensure tight seats, assuring clean air quality and energy saving.
- Fitting can be used with most spiral pipe, without calibration.
- Ideal for exposed spiral projects finished duct work is clean with no silver tape.
- Fitting is available in a variety of metal and gauge.
- Fitting can be taken apart easily after connection has been made.
- Fitting can be reused, new screw hold can be added without destroying the integrity of self sealing system.
- If at the same point the gasket is damaged the fitting can be used as a part of the self system by shipping on a new o ring.

SIZE AND WALL THICKNESS CHART

Nom Mm	Inches	Nom Mm	Inches	Nom Mm	Inches
102	4	432	17	914	36
127	5	457	18	965	38
152	6	483	19	1018	40
178	7	508	20	1057	42
203	8	533	21	1118	44
229	9	559	22	1168	46
254	10	584	23	1319	48
279	11	610	24	1270	50
305	12	660	26	1321	52
330	13	711	28	1372	54
356	14	762	30	1400	55
381	15	813	32	1500	59
406	16	864	34	1600	63



Wall thickness for Diameters and thickness upon request

0.6mm	1.8mm	1.0mm	1.2mm
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OVAL DUCTING AND PIPING

Dustech spiral flat-oval duct is machine formed from Dustech round spiral duct. The flat shape is specifically designed for low head room and restricted space locations which cannot accept round duct.

FLAT-OVAL DUCT DESIGN



The design of a duct system utilizing flat-oval duct follows the same procedures used with rectangular duct.

1) The system is first designed on the basis of circular duct.

2) Where space limitations require the use of oval duct, the table has been arranged in a manner that makes its uses similar to tables for rectangular duct and should be used in exactly the same way.

3) Spiral flat-oval duct is made only in the sizes listed in tables 1. For maximum economy, select your flat-oval duct size from table 1.

Oval Made From Dia (mm)		356	381	406	457	508	559	610	660	711	762	813	864	914	965	1016	1047	1118	1168	1219	1270	1321	1372		
Nominal Duct Height (A)	15 2	#48 3 ~27 9	#52 1 ~29 2	#56 0 ~30 5	#63 5 ~31 8	#71 1 ~33 0	#80 0 ~34 3	#87 6 ~36 8	#95 2 ~38 1	#104 1 ~394	#117 6 ~406														
	20 3			#53 3 ~34 3	#61 0 ~36 8	#68 6 ~38 1	#75 5 ~40 6	#83 8 ~41 9	#92 7 ~44 5	#100 3 ~457	#109 2 ~470	#116 8 ~483													
	25 4				#58 4 ~39 4	#66 0 ~43 2	#73 7 ~44 5	#82 6 ~47 0	#90 2 ~49 5	#978 7 ~508	#106 7 ~533	#114 3 ~546	#121 8 ~559	#130 8 ~572	#137 9 ~604	#146 1 ~610	#153 1 ~621	#162 6 ~635							
	30 5				#63 5 ~45 7	#71 1 ~48 3	#78 7 ~50 8	#87 6 ~53 3	#953 9 ~559	#102 9 ~572	#111 8 ~597	#118 9 ~625	#127 0 ~635	#134 9 ~662	#143 5 ~673	#151 1 ~696	#160 0 ~716	#166 0 ~724	#175 3 ~742	#182 0 ~742	#191 8 ~762	#198 1 ~784			
	35 6					#68 6 ~50 8	#76 2 ~54 6	#83 8 ~57 2	#927 3 ~597	#100 3 ~622	#108 0 ~648	#116 5 ~671	#124 5 ~680	#132 0 ~713	#141 0 ~724	#148 1 ~752	#156 2 ~762	#164 6 ~787	#172 7 ~787	#180 2 ~821	#189 2 ~846	#195 2 ~850			
	40 6					#64 8 ~53 3	#73 7 ~57 2	#81 3 ~59 7	#889 3 ~622	#978 3 ~660	#105 4 ~686	#113 1 ~710	#121 9 ~724	#129 1 ~757	#137 5 ~775	#145 2 ~800	#153 7 ~813	#161 2 ~840	#170 2 ~851	#177 3 ~877	#185 4 ~921	#192 3 ~943			
	45 7						#71 1 ~58 4	#78 7 ~62 2	#864 3 ~660	#940 3 ~686	#102 9 ~711	#110 2 ~745	#118 1 ~762	#126 7 ~797	#134 6 ~813	#142 3 ~844	#151 1 ~851	#158 3 ~887	#166 4 ~902	#175 0 ~928	#182 9 ~947	#189 4 ~970			
	50 8							#74 9 ~63 5	#838 3 ~673	#914 3 ~711	#100 3 ~737	#107 3 ~775	#115 6 ~800	#124 1 ~830	#132 1 ~851	#139 4 ~882	#147 3 ~902	#155 4 ~934	#163 8 ~940	#172 4 ~974	#180 3 ~978	#186 5 ~100 3			
	61 0												#108 7 ~876	#116 8 ~900	#124 8 ~910	#132 7 ~940	#170 8 ~965	#148 6 ~995	#156 7 ~100 6	#164 6 ~103 2	#172 6 ~104 0	#180 6 ~106 2			

Specifications

Thickness:

0.50(26G) to 1.2 mm (18G)

Thickness of flat-oval spiral ducts as per SMACNA "HVAC DUCT CONSTRUCTION STANDARDS" -2005

Standard Length : 4,8,10 and 12ft. length

Material : Galvanized steel, mild steel (CR), Aluminium, stainless steel etc.

Surface constructions : Plain or corrugated (to increase the radial rigidity of the duct by 300%.

Surface finish : Powder Coated, Painted.