

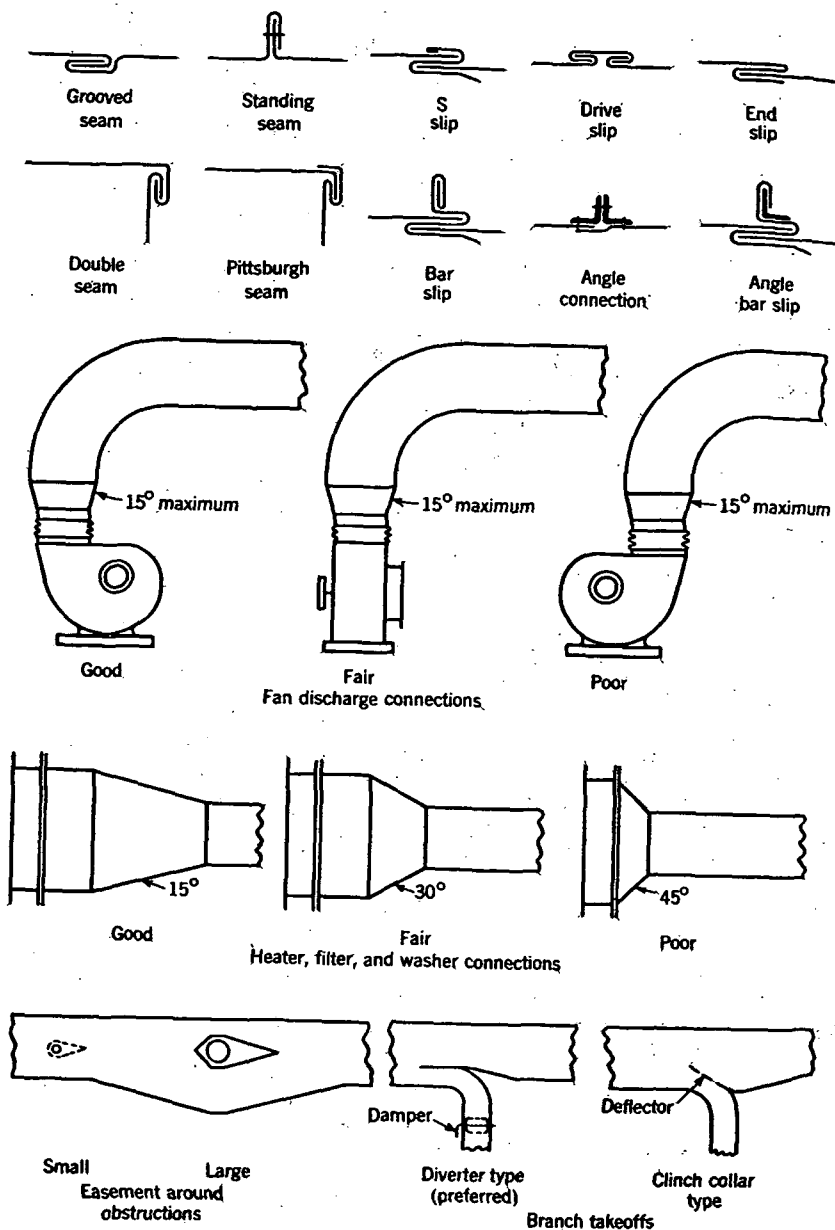


FIG. 7. SHEET METAL DUCT AND ARRANGEMENT DETAILS

TABLE 4. RECOMMENDED SHEET METAL GAGES FOR DUCTS^a

U. S. STD. GAGE	ROUND DUCTS DIAMETER, INCHES	RECTANGULAR DUCTS		
		Maximum Side, Inches	Type of Joint Connections	Bracing
26	Up to 18	Up to 12	S or Drive Slips	None
24	19 to 30	13 to 24	S or Drive Slips	None
24		25 to 30	S or Drive Slips	1 in. Angle 4 ft from Slips
22	31 to 45	31 to 48	Bar or Drive Slips	1 1/4 in. Angle 4 ft on Centers
20	46 to 60	49 to 60	1 1/4 in. Angle Bar Slips or 1 1/4 in. Angle Connections	1 1/4 in. Angle 2 ft 8 in. on Centers
18	61 and up	61 to 90	1 1/2 in. Angle Connections	1 1/2 in. Angle 2 ft 8 in. on Centers
18		91 and up	2 in. Angle Connections	2 in. Angle 2 ft 8 in. on Centers

^aIf flat sides are not cross-braced two gages heavier material should be used.

TABLE 5. WEIGHTS OF SHEET METAL USED FOR DUCT CONSTRUCTION

U. S. STD. GAGE	BLACK SHEETS				GALVANIZED SHEETS ^b			
	Approximate Thickness, In.		Weight Per Square Foot		Approximate Thickness, In.		Weight Per Square Foot	
	Steel	Iron	Ounces	Pounds	Steel	Iron	Ounces	Pounds
30	0.0123	0.0125	8	0.500	0.0163	0.0165	10.5	0.656
28	0.0153	0.0156	10	0.625	0.0193	0.0196	12.5	0.781
26	0.0184	0.0188	12	0.750	0.0224	0.0228	14.5	0.906
24	0.0245	0.0250	16	1.000	0.0285	0.0290	18.5	1.156
22	0.0306	0.0313	20	1.250	0.0346	0.0353	22.5	1.406
20	0.0368	0.0375	24	1.500	0.0408	0.0415	26.5	1.656
18	0.0490	0.0500	32	2.000	0.0530	0.0540	34.5	2.156
16	0.0613	0.0625	40	2.500	0.0653	0.0665	42.5	2.656
14	0.0766	0.0781	50	3.125	0.0806	0.0821	52.5	3.281
12	0.1072	0.1094	70	4.375	0.1112	0.1134	72.5	4.531
11	0.1225	0.1250	80	5.000	0.1265	0.1290	82.5	5.156
10	0.1379	0.1406	90	5.625	0.1419	0.1446	92.5	5.781

^bGalvanized sheets are gaged before galvanizing and are therefore approximately 0.004 in. thicker.

TABLE 6. WEIGHTS AND THICKNESSES OF STANDARD COPPER SHEETS^c
Rolled to Weight

WEIGHT PER SQUARE FOOT		THICKNESS, INCHES		NEAREST GAGE NO.		
Ounces	Pounds	Decimal Equivalent	Nearest Fraction	B. & S.	Stubs	U. S. STD.
10	0.625	0.0135	1/64	27	29	29
12	0.750	0.0162	1/64	26	27	28
14	0.875	0.0189	1/64	25	26	26
16	1.000	0.0216	1/32	23	24	25
18	1.125	0.0243	1/32	22	23	24
20	1.250	0.0270	1/32	21	22	23
24	1.500	0.0324	1/32	20	21	22
28	1.750	0.0378	1/32	19	20	20
32	2.000	0.0432	3/64	17	19	19
36	2.250	0.0486	3/64	16	18	18
40	2.500	0.0540	3/64	15	17	17
44	2.750	0.0594	1/16	15	17	17
48	3.000	0.0648	1/16	14	16	16
56	3.500	0.0756	5/64	13	15	14
64	4.000	0.0864	5/64	11	14	13

^cVariations from these weights must be expected in practice.