

ticularly those used in buffing and polishing, are connected by short branch pipes to the main duct which renders proportioning impractical.

Construction

The ducts leading from the hoods to the exhaust fan should be constructed of sheet metal not lighter than is shown in Table 4. The piping should be free from dents, fins and projections on which refuse might catch.

All permanent circular joints should be lap-jointed, riveted and soldered, and all longitudinal joints either grooved and locked or riveted and soldered. Circular laps should be in the direction of the flow, and piping installed out-of-doors should not have the longitudinal laps at the

TABLE 4. GAGE OF SHEET METAL TO BE USED FOR VARIOUS DUCT DIAMETERS

DIAMETER OF DUCT	GAGE OF METAL
8 in. or less.....	24
9 to 18 in.....	22
19 to 25 in.....	20
26 in. or more.....	18

bottom. Every change in pipe size should be made with an eccentric taper flat on the bottom, the taper to be at least 5 in. long for each inch change in diameter. All pipes passing through roofs should be equipped with collars so arranged as to prevent water leaking into the building.

The main trunks and branch pipes should be as short and straight as possible, strongly supported, and with the dead ends capped to permit inspection and cleaning. All branch pipes should join the main at an acute angle, the junction being at the side or top and never at the bottom of the main. Branch pipes should not join the main pipes at points where the material from one branch would tend to enter the branch on the opposite side of the main.

Cleanout openings having suitable covers should be placed in the main and branch pipes so that every part of the system can be easily reached in case the system clogs. Either a large cleanout door should be placed in the main suction pipe near the fan inlet, or a detachable section of pipe, held in place by lug bands, may be provided.

Elbows should be made at least two gages heavier than straight pipe of the same diameter, the better to enable them to withstand the additional wear caused by changing the direction of flow. They should preferably have a throat radius of at least one and one-half times the diameter of the pipe.

Every pipe should be kept open and unobstructed throughout its entire length, and no fixed screen should be placed in it, although the use of a trap at the junction of the hood and branch pipe is permissible, provided it is not allowed to fill up completely.

The passing of pipes through fire-walls should be avoided wherever possible, and sweep-up connections should be so arranged that foreign material cannot be easily introduced into them.

At the point of entrance of a branch pipe with the main duct, there

should be an increase in the latter equal to their sum. Some state codes specify that the combined area be increased by 25 per cent. While this is not always necessary and is frequently done at the expense of a reduced air velocity, it is none the less advisable where future expansion of the exhaust system is contemplated.

TABLE 5. AIR SPEEDS IN DUCTS NECESSARY TO CONVEY VARIOUS MATERIALS

MATERIAL	AIR VELOCITIES (FPM)
Grain dust.....	2000
Wood chips and shavings.....	3000
Sawdust.....	2000
Jute dust.....	2000
Rubber dust.....	2000
Lint.....	1500
Metal dust (grindings).....	2200
Lead dusts.....	5000
Brass turnings (fine).....	4000
Fine coal.....	4000

Air Velocities in Ducts

When the static suction has been fixed for a given hood, the air velocity in the duct may be determined from Equation 2. Air velocities for conveying a material should be moderate. Table 5 gives the velocities generally employed for conveying various substances. Equations 5a and 5b may be used as tests to determine the conveying efficiency of a system⁶. Velocities determined from these formulae should be increased by at least 25 per cent since they represent the minimum at which a stated size and density of material can be transported.

$$\text{For vertical ducts:} \quad V = 13,300 \frac{s}{s+1} d^{0.570} \quad (5a)$$

$$\text{For horizontal ducts:} \quad V = 6000 \frac{s}{s+1} d^{0.828} \quad (5b)$$

where

V = air velocity in duct, feet per minute.

s = specific gravity of particles.

d = average diameter of largest particles conveyed, inches.

Example 2. Granular material, the largest size of which is approximately 0.37 in. in diameter, with a specific gravity of 1.40 is to be conveyed in a vertical pipe the velocity of the air in which is 4100 fpm; find whether the material can be transported at this velocity.

Substitute data in Equation 5a and multiply by 1.25:

$$V = 1.25 \times 13,300 \times \frac{1.4}{2.4} \times 0.37^{0.57}$$

Antilog $(0.57 \times \log 0.37) = 0.568$; the required velocity is, therefore, 5500 fpm. Hence, the duct velocity must be increased either by speeding up the fan or decreasing the diameter of the duct, or both.

⁶DallaValle, J. M.: Determining Minimum Air Velocities for Exhaust Systems. (A.S.H.V.E. Journal Section, Heating, Piping and Air Conditioning, September, 1932).