dampers and other fire protective details, see Pamphlet No. 90 of the *National Board of Fire Underwriters.*[23]

The recommended gages for steel (or iron) and aluminum sheet metal rectangular ducts are given in Table 8. Steel or iron sheets are specified according to the Manufacturers or U. S. Standard Gage System. Aluminum sheets are specified according to the American or Brown & Sharpe Gage System. Weights of black and galvanized steel and iron sheets per square foot of surface for various gages are given in Table 9. Similar data for 2S aluminum sheets will be found in Table 10. Weights of standard

TABLE 8. RECOMMENDED SHEET METAL GAGES FOR RECTANGULAR DUCT CONSTRUCTION[a]

Aluminum B.&S. Gage	Steel U. S. Std. Gage	Maximum Side, Inches	Type of Transverse Joint Connections[b]	Bracing
24	26	Up to 12	S, Drive, Pocket or Bar Slips, on 7 ft 10 in. centers	None
22	24	13 to 24	S, Drive, Pocket or Bar Slips, on 7 ft 10 in. centers	None
		25 to 30	S, Drive, 1 in. Pocket or 1 in. Bar Slips, on 7 ft 10 in. centers[c]	1 x 1 x ⅛ in. angles 4 ft from joint
20	22	31 to 40	Drive, 1 in. Pocket or 1 in. Bar Slips, on 7 ft 10 in. centers[c]	1 x 1 x ⅛ in. angles 4 ft from joint
		41 to 60	1½ in. Angle Connections, or 1½ in. Pocket or 1½ in. Bar Slips with 1⅜ in. x ⅛ in. bar reinforcing on 7 ft 10 in. centers[c]	1½ x 1½ x $\frac{1}{16}$ in. angles 4 ft from joint
18	20	61 to 90	1½ in. Angle Connections, or 1½ in. Pocket or 1½ in. Bar Slips 3 ft 9 in. maximum centers with 1⅜ x ⅛ in. bar reinforcing	1½ x 1½ x ⅛ in. diagonal angles, or 1½ x 1½ x ⅛ in. angles 2 ft from joint
16	18	91 and up	2 in. Angle Connections or 1½ in. Pocket or 1½ in. Bar Slips 3 ft 9 in. maximum centers with 1⅜ x ⅛ in. bar reinforcing[d]	1½ x 1½ x ⅛ in. diagonal angles, or 1½ x 1½ x ⅛ in. angles 2 ft from joint

[a] For normal pressures and velocities (see Table 4) utilized in typical ventilating and air conditioning systems. Where special rigidity or stiffness is required, ducts should be constructed of metal two gages heavier. All uninsulated ducts 18 in. and larger should be cross-broken. Cross-breaking may be omitted on uninsulated ducts if two gages of heavier metal are used.

[b] Other joint connections of equivalent mechanical strength and air tightness may be used.

[c] Duct sections of 3 ft 9 in. may be used with bracing angles omitted; instead of 7 ft 10 in. lengths with joints indicated.

[d] Ducts 91 in. and larger require special field study for hanging and supporting methods.

copper sheets are given in Table 11. In calculating the total weight of a given length of duct work from these tables, it is customary to add 20 percent for the weight of joints and bracings.

Aluminum sheets of the 2S and 3S type alloy and ¾ hard temper are readily workable, and can be used for practically all duct work. The 2S type (commercially pure aluminum) is suitable for all, except very large ducts. For large ducts, where more strength is desired, the 3S alloy with ¾ or ½ hard temper is frequently used. The higher tempers, particularly full hard, do not have the formability of the lower tempers. For very large ducts, where considerable strength is required, aluminum sheets

TABLE 9. WEIGHTS OF BLACK AND GALVANIZED SHEETS

U. S. Std. Gage	Black Sheets				Galvanized Sheets[a]			
	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

[a] Galvanized sheets are gaged before galvanizing and are therefore approximately 0.004 in. thicker.

should be 2 gages heavier than indicated in Table 8, and should be amply stiffened. Joints can be of any of the standard designs, and can be fabricated in the same manner as iron. Repeated sharp bending and rebending should be avoided, as aluminum has a tendency to crack under such treatment. Aluminum of 16 B. & S. gage or heavier can readily be welded by the metallic arc or acetylene process. Soldering is difficult and is not generally recommended. Riveting is done in the same manner as in iron or steel sheet. Self-tapping screws tend to loosen because of the softness of aluminum.

HEAT LOSSES FROM DUCTS

In designing duct systems, the heat gains or losses of ducts should not be neglected. Heat gains in large duct systems can be quite considerable, not only if the duct passes through unconditioned space, but also on long duct runs within conditioned space. Proper insulation will remedy this situation considerably, but sometimes a redistribution of the supply air to the various supply outlets is necessary in order to compensate for the heating effect of the duct surface.

The thermal transmittance U for ducts can be found as follows:

For uninsulated metal duct, $$U = \frac{1}{\frac{1}{f_i} + \frac{1}{f_o}} \qquad (20)$$

TABLE 10. WEIGHTS AND THICKNESSES OF 2S ALUMINUM (DENSITY 0.098 LB/CU IN.)

B. & S. Gage	Thickness, Inches		Weight per Square Foot	
	Decimal	Nearest Fraction	Ounces	Pounds
28	0.012	1/64	2.7	0.169
26	0.016	1/64	3.6	0.226
24	0.020	1/64	4.5	0.282
22	0.025	1/32	5.4	0.353
20	0.032	1/32	7.2	0.452
18	0.040	3/64	9.0	0.563
16	0.051	3/64	11.5	0.720
14	0.064	1/16	14.4	0.903