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## RECTANGULAR DUCTWORK

SMACNA 2005 GUIDELINES

STANDARDS DUCT CONSTRUCTION TABLE  
 FOR GALVANIZED · PAINTLOCK, 304/316 S.S. DUCTWORK  
 (NOT FOR ALUMINUM)

### 1" W.G. STATIC POSITIVE OR NEGATIVE

DUCT SIZE	DUCT GAUGE	JOINT LENGTH	WIDE SIDE CONNECTOR	NARROW SIDE CONNECTOR
0"-12"	26	59"	FLAT SLIP T-6 24GA	FLAT DRIVE T-1 24GA
13"-18"	26	59"	STANDING SLIP T-11 26GA	FLAT DRIVE T-1 24GA
19"-30"	26	56"	T.D.C. T-25a	T.D.C. T-25a
31"-42"	24	56"	T.D.C. T-25a	T.D.C. T-25a
43"-54"	22	56"	T.D.C. T-25a	T.D.C. T-25a
55"-60"	24	56"	T.D.C. W/C.T.R. T-25a	T.D.C. W/C.T.R. T-25a
61"-72"	22	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C. W/C.T.R. & J.T.R. T-25a
73"-84"	22	56"	T.D.C. W/2C.T.R. & J.T.R. T-25a	T.D.C. W/2C.T.R. & J.T.R. T-25a
85"-96"	20	56"	T.D.C. W/2C.T.R. & J.T.R. T-25a	T.D.C. W/2C.T.R. & J.T.R. T-25a
96"&UP	18	56"	T.D.C. W/CENTER A.R. & J.T.R. T-25a	T.D.C. W/CENTER A.R. & J.T.R. T-25a

**NOTES:**

J.T.R. - JOINT TIE ROD  
 C.T.R. - CENTER TIE ROD  
 A.R. ANGLE REINFORCEMENT  
 TIERODS ARE 1/2" EMT  
 IF MPT (MID-POINT TIE RODS) ARE USED, THE REINFORCEMENT SPACING IS BASED ON 2 1/2'  
**REFERENCES:**  
 SMACNA-HVAC DUCT CONSTRUCTION STANDARDS - METAL AND FLEXIBLE, THIRD EDITION 2005

**CONSTRUCTED:**

Hot Dipped Galvanized Steel PER ASTM A653 CS Type B.

**APPLICATIONS:**

Designed to meet SMACNA Duct Construction Standards.

**DESCRIPTION:**

All Rectangular Ductwork 1" W.G. Static Positive or Negative is Made With The Finest G90 American Steel.

**UNION MADE IN THE UNITED STATES OF AMERICA**  
**PROUDLY USING 100% AMERICAN MADE METALS MANUFACTURED BY C.H.I.**



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 (NOT FOR ALUMINUM)

### 2" W.G. STATIC POSITIVE OR NEGATIVE

DUCT SIZE	DUCT GAUGE	JOINT LENGTH	WIDE SIDE CONNECTOR	NARROW SIDE CONNECTOR
0"-10"	26	59"	FLAT SLIP T-6 24GA	FLAT DRIVE T-1 24GA
11"-14"	26	59"	STANDING SLIP T-11 26GA	FLAT DRIVE T-1 24GA
15"-26"	26	56"	T.D.C. T-25a	T.D.C. T-25a
27"-30"	24	56"	T.D.C. T-25a	T.D.C. T-25a
31"-36"	22	56"	T.D.C. T-25a	T.D.C. T-25a
37"-42"	20	56"	T.D.C. T-25a	T.D.C. T-25a
43"-60"	22	56"	T.D.C. W/C.T.R. T-25a	T.D.C. W/C.T.R. T-25a
61"-72"	22	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C. W/C.T.R. & J.T.R. T-25a
85"-96"	20	56"	T.D.C. W/2C.T.R. & J.T.R. T-25a	T.D.C. W/2C.T.R. & J.T.R. T-25a
96"&UP	18	56"	T.D.C. W/CENTER A.R. & J.T.R. T-25a	T.D.C. W/CENTER A.R. & J.T.R. T-25a

**NOTES:**

J.T.R. - JOINT TIE ROD  
 C.T.R. - CENTER TIE ROD  
 A.R. ANGLE REINFORCEMENT  
 TIERODS ARE 1/2" EMT  
 IF MPT (MID-POINT TIE RODS) ARE USED, THE REINFORCEMENT SPACING IS BASED ON 2 1/2'  
**REFERENCES:**  
 SMACNA-HVAC DUCT CONSTRUCTION STANDARDS - METAL AND FLEXIBLE, THIRD EDITION 2005

**CONSTRUCTED:**

Hot Dipped Galvanized Steel PER ASTM A653 CS Type B.

**APPLICATIONS:**

Designed to meet SMACNA Duct Construction Standards.

**DESCRIPTION:**

All Rectangular Ductwork 2" W.G. Static Positive or Negative is Made With The Finest G90 American Steel.

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SMACNA 2005 GUIDELINES

STANDARDS DUCT CONSTRUCTION TABLE  
 FOR GALVANIZED · PAINTLOCK, 304/316 S.S. DUCTWORK  
 (NOT FOR ALUMINUM)

### 3" W.G. STATIC POSITIVE OR NEGATIVE

DUCT SIZE	DUCT GAUGE	JOINT LENGTH	WIDE SIDE CONNECTOR	NARROW SIDE CONNECTOR
0"-12"	26	59"	STANDING SLIP T-11 26GA	FLAT DRIVE T-1 24GA
13"-26"	24	56"	T.D.C. T-25a	T.D.C. T-25a
27"-30"	22	56"	T.D.C. T-25a	T.D.C. T-25a
31"-36"	20	56"	T.D.C. T-25a	T.D.C. T-25a
37"-42"	22	56"	T.D.C. W/C.T.R. T-25a	T.D.C. W/C.T.R. T-25a
43"-54"	22	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C. W/C.T.R. & J.T.R. T-25a
55"-60"	20	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C. W/C.T.R. & J.T.R. T-25a
61"-84"	20	56"	T.D.C. W/2C.T.R. & J.T.R. T-25a	T.D.C. W/2C.T.R. & J.T.R. T-25a
85"-96"	18	56"	T.D.C. W/2C.T.R. & J.T.R. T-25a	T.D.C. W/2C.T.R. & J.T.R. T-25a
97"&120"	18	56"	T.D.C. W/CENTER A.R. & J.T.R. T-25a	T.D.C. W/CENTER A.R. & J.T.R. T-25a

**NOTES:**

J.T.R. - JOINT TIE ROD  
 C.T.R. - CENTER TIE ROD  
 A.R. ANGLE REINFORCEMENT  
 TIERODS ARE 1/2" EMT  
 IF MPT (MID-POINT TIE RODS) ARE USED, THE REINFORCEMENT SPACING IS BASED ON 2 1/2'  
**REFERENCES:**  
 SMACNA-HVAC DUCT CONSTRUCTION STANDARDS - METAL AND FLEXIBLE, THIRD EDITION 2005

**CONSTRUCTED:**

Hot Dipped Galvanized Steel PER ASTM A653 CS Type B.

**APPLICATIONS:**

Designed to meet SMACNA Duct Construction Standards.

**DESCRIPTION:**

All Rectangular Ductwork 3" W.G. Static Positive or Negative is Made With The Finest G90 American Steel.

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### 4" W.G. STATIC POSITIVE OR NEGATIVE

DUCT SIZE	DUCT GAUGE	JOINT LENGTH	WIDE SIDE CONNECTOR	NARROW SIDE CONNECTOR
0"-10"	26	59"	STANDING SLIP T-11 26GA	FLAT DRIVE T-1 24GA
11"-12"	26	59"	T.D.C. T-25a	T.D.C. T-25a
13"-22"	24	56"	T.D.C. T-25a	T.D.C. T-25a
23"-28"	22	56"	T.D.C. T-25a	T.D.C. T-25a
29"-42"	22	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C. W/C.T.R. & J.T.R. T-25a
43"-60"	20	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C. W/C.T.R. & J.T.R. T-25a
61"-72"	20	56"	T.D.C. W/2C.T.R. & J.T.R. T-25a	T.D.C. W/2C.T.R. & J.T.R. T-25a
73"-96"	18	56"	T.D.C. W/2C.T.R. & J.T.R. T-25a	T.D.C. W/2C.T.R. & J.T.R. T-25a
97"-120"	18	56"	T.D.C. W/CENTER A.R. & J.T.R. T-25a	T.D.C. W/CENTER A.R. & J.T.R. T-25a

**NOTES:**  
 J.T.R. - JOINT TIE ROD  
 C.T.R. - CENTER TIE ROD  
 A.R. ANGLE REINFORCEMENT  
 TIERODS ARE 1/2" EMT  
 IF MPT (MID-POINT TIE RODS) ARE USED, THE REINFORCEMENT SPACING IS BASED ON 2 1/2'  
**REFERENCES:**  
 SMACNA-HVAC DUCT CONSTRUCTION STANDARDS - METAL AND FLEXIBLE, THIRD EDITION 2005

**CONSTRUCTED:**  
 Hot Dipped Galvanized Steel PER ASTM A653 CS Type B.  
**APPLICATIONS:**  
 Designed to meet SMACNA Duct Construction Standards.  
**DESCRIPTION:**  
 All Rectangular Ductwork 4" W.G. Static Positive or Negative is Made With The Finest G90 American Steel.

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 (NOT FOR ALUMINUM)

### 6" W.G. STATIC POSITIVE OR NEGATIVE

DUCT SIZE	DUCT GAUGE	JOINT LENGTH	WIDE SIDE CONNECTOR	NARROW SIDE CONNECTOR
0"-8"	26	59"	STANDING SLIP T-11 26GA	FLAT DRIVE T-1 24GA
9"-12"	24	56"	T.D.C. T-25a	T.D.C. T-25a
13"-24"	22	56"	T.D.C. T-25a	T.D.C. T-25a
25"-26"	20	56"	T.D.C. T-25a	T.D.C. T-25a
27"-30"	22	56"	T.D.C. W/C.T.R. T-25a	T.D.C. W/C.T.R. T-25a
31"-36"	20	56"	T.D.C. W/C.T.R. T-25a	T.D.C. W/C.T.R. T-25a
37"-60"	20	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C. W/C.T.R. & J.T.R. T-25a
61"-72"	18	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C. W/C.T.R. & J.T.R. T-25a
73"-84"	18	56"	T.D.C. W/2C.T.R. & J.T.R. T-25a	T.D.C. W/2C.T.R. & J.T.R. T-25a
86"-96"	16	56"	T.D.C. W/2C.T.R. & J.T.R. T-25a	T.D.C. W/2C.T.R. & J.T.R. T-25a

NOTES:  
 J.T.R. - JOINT TIE ROD  
 C.T.R. - CENTER TIE ROD  
 A.R. ANGLE REINFORCEMENT  
 TIERODS ARE 1/2" EMT  
 IF MPT (MID-POINT TIE RODS) ARE USED, THE REINFORCEMENT SPACING IS BASED ON 2 1/2'  
 REFERENCES:  
 SMACNA-HVAC DUCT CONSTRUCTION STANDARDS - METAL AND FLEXIBLE, THIRD EDITION 2005

**CONSTRUCTED:**  
 Hot Dipped Galvanized Steel PER ASTM A653 CS Type B.  
**APPLICATIONS:**  
 Designed to meet SMACNA Duct Construction Standards.  
**DESCRIPTION:**  
 All Rectangular Ductwork 6" W.G. Static Positive or Negative is Made With The Finest G90 American Steel.

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 (NOT FOR ALUMINUM)

### 10" W.G. STATIC POSITIVE OR NEGATIVE

DUCT SIZE	DUCT GAUGE	JOINT LENGTH	WIDE SIDE CONNECTOR	NARROW SIDE CONNECTOR
0"-8"	24	56"	T.D.C. T-25a	T.D.C. T-25a
9"-12"	22	56"	T.D.C. T-25a	T.D.C. T-25a
13"-18"	20	56"	T.D.C. T-25a	T.D.C. T-25a
19"-26"	22	56"	T.D.C. W/CENTER A.R. T-25a	T.D.C. W/CENTER A.R. T-25a
27"-28"	20	56"	T.D.C. W/CENTER A.R. T-25a	T.D.C. W/CENTER A.R. T-25a
29"-42"	20	56"	T.D.C. W/CENTER A.R. & J.T.R. T-25a	T.D.C. W/CENTER A.R. & J.T.R. T-25a
43"-72"	18	56"	T.D.C. W/CENTER A.R. & J.T.R. T-25a	T.D.C. W/CENTER A.R. & J.T.R. T-25a
73"-84"	16	56"	T.D.C. W/CENTER A.R. & J.T.R. T-25a	T.D.C. W/CENTER A.R. & J.T.R. T-25a

**NOTES:**  
 J.T.R. - JOINT TIE ROD  
 C.T.R. - CENTER TIE ROD  
 A.R. ANGLE REINFORCEMENT  
 TIERODS ARE 1/2" EMT  
 IF MPT (MID-POINT TIE RODS) ARE USED, THE REINFORCEMENT SPACING IS BASED ON 2 1/2'  
**REFERENCES:**  
 SMACNA-HVAC DUCT CONSTRUCTION STANDARDS - METAL AND FLEXIBLE, THIRD EDITION 2005

**CONSTRUCTED:**  
 Hot Dipped Galvanized Steel PER ASTM A653 CS Type B.  
**APPLICATIONS:**  
 Designed to meet SMACNA Duct Construction Standards.  
**DESCRIPTION:**  
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## RECTANGULAR DUCTWORK

SMACNA 1995/1997 GUIDELINES

STANDARDS DUCT CONSTRUCTION TABLE  
 FOR GALVANIZED · PAINTLOCK, 304/316 S.S. DUCTWORK  
 (NOT FOR ALUMINUM)

### 1" W.G. STATIC POSITIVE OR NEGATIVE

DUCT SIZE	DUCT GAUGE	JOINT LENGTH	WIDE SIDE CONNECTOR	NARROW SIDE CONNECTOR
0"-12"	26	59"	FLAT SLIP T-6 24GA	FLAT DRIVE T-1 24GA
13"-18"	26	59"	STANDING SLIP T-11 26GA	FLAT DRIVE T-1 24GA
19"-30"	26	56"	T.D.C. T-25a	T.D.C. T-25a
31"-42"	24	56"	T.D.C. T-25a	T.D.C. T-25a
43"-54"	22	56"	T.D.C. T-25a	T.D.C. T-25a
55"-60"	20	56"	T.D.C. T-25a	T.D.C. T-25a
61"-72"	22	56"	T.D.C. W/C.T.R. T-25a	T.D.C. W/C.T.R. T-25a
73"-84"	22	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C. W/C.T.R. & J.T.R. T-25a
85"-96"	20	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C. W/C.T.R. & J.T.R. T-25a
96"&UP	18	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C. W/C.T.R. & J.T.R. T-25a

**NOTES:**

J.T.R. - JOINT TIE ROD  
 C.T.R. - CENTER TIE ROD  
 A.R. ANGLE REINFORCEMENT  
 TIERODS ARE 1/2" EMT  
 IF MPT (MID-POINT TIE RODS) ARE USED, THE REINFORCEMENT SPACING IS BASED ON 2 1/2'

**REFERENCES:**

SMACNA-HVAC DUCT CONSTRUCTION STANDARDS - METAL AND FLEXIBLE, SECOND EDITION 1995, PAGE 1-20, TABLE 1-4

**CONSTRUCTED:**

Hot Dipped Galvanized Steel PER ASTM A653 CS Type B.

**APPLICATIONS:**

Designed to meet SMACNA Duct Construction Standards.

**DESCRIPTION:**

All Rectangular Ductwork 1" W.G. Static Positive or Negative is Made With The Finest G90 American Steel.

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## RECTANGULAR DUCTWORK

SMACNA 1995/1997 GUIDELINES

STANDARDS DUCT CONSTRUCTION TABLE  
 FOR GALVANIZED · PAINTLOCK, 304/316 S.S. DUCTWORK  
 (NOT FOR ALUMINUM)

## 2" W.G. STATIC POSITIVE OR NEGATIVE

DUCT SIZE	DUCT GAUGE	JOINT LENGTH	WIDE SIDE CONNECTOR	NARROW SIDE CONNECTOR	*NOTES
0"-10"	26	59"	FLAT SLIP T-6 24GA	FLAT DRIVE T-1 24GA	Ref. 1
11"-14"	26	59"	STANDING SLIP T-11 26GA	FLAT DRIVE T-1 24GA	Ref. 1
15"-26"	26	56"	T.D.C. T-25a	T.D.C. T-25a	Ref. 1.2
27"-30"	24	56"	T.D.C. T-25a	T.D.C. T-25a	Ref. 1.2
31"-36"	22	56"	T.D.C. T-25a	T.D.C. T-25a	Ref. 2
37"-42"	20	56"	T.D.C. T-25a	T.D.C. T-25a	Ref. 2
43"-54"	22	56"	T.D.C. W/C.T.R. T-25a	T.D.C. W/C.T.R. T-25a	Ref. 2
55"-84"	22	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C. W/C.T.R. & J.T.R. T-25a	Ref. 2
85"-96"	20	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C. W/C.T.R. & J.T.R. T-25a	Ref. 2
96"&UP	18	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C. W/C.T.R. & J.T.R. T-25a	Ref. 2

**NOTES:**

J.T.R. - JOINT TIE ROD  
 C.T.R. - CENTER TIE ROD  
 A.R. ANGLE REINFORCEMENT  
 TIERODS ARE 1/2' EMT

IF MPT (MID-POINT TIE RODS) ARE USED, THE REINFORCEMENT SPACING IS BASED ON 2 1/2'

**REFERENCES:**

- SMACNA-HVAC DUCT CONSTRUCTION STANDARDS - METAL AND FLEXIBLE, SECOND EDITION 1995, PAGE 1-22, TABLE 1-5
- SMACNA-HVAC DUCT CONSTRUCTION STANDARDS - METAL AND FLEXIBLE, SECOND EDITION 1997, ADDENDUM 1, PAGE 1-41-6, TABLE 1-55

**CONSTRUCTED:**

Hot Dipped Galvanized Steel PER ASTM A653 CS Type B.

**APPLICATIONS:**

Designed to meet SMACNA Duct Construction Standards.

**DESCRIPTION:**

All Rectangular Ductwork 2" W.G. Static Positive or Negative is Made With The Finest G90 American Steel.

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## RECTANGULAR DUCTWORK

SMACNA 1995/1997 GUIDELINES

STANDARDS DUCT CONSTRUCTION TABLE  
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 (NOT FOR ALUMINUM)

### 3" W.G. STATIC POSITIVE OR NEGATIVE

DUCT SIZE	DUCT GAUGE	JOINT LENGTH	WIDE SIDE CONNECTOR	NARROW SIDE CONNECTOR
0"-12"	26	59"	STANDING SLIP T-11 26GA	FLAT DRIVE T-1 24GA
13"-26"	24	56"	T.D.C. T-25a	T.D.C. T-25a
27"-30"	22	56"	T.D.C. T-25a	T.D.C. T-25a
31"-36"	20	56"	T.D.C. T-25a	T.D.C. T-25a
37"-42"	22	56"	T.D.C. W/C.T.R. T-25a	T.D.C. W/C.T.R. T-25a
43"-72"	22	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C. W/C.T.R. & J.T.R. T-25a
63"-84"	20	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C. W/C.T.R. & J.T.R. T-25a
85"-UP	18	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C. W/C.T.R. & J.T.R. T-25a

**NOTES:**

J.T.R. - JOINT TIE ROD  
 C.T.R. - CENTER TIE ROD  
 A.R. ANGLE REINFORCEMENT  
 TIERODS ARE 1/2" EMT  
 IF MPT (MID-POINT TIE RODS) ARE USED, THE REINFORCEMENT SPACING IS BASED ON 2 1/2'

**REFERENCES:**

1. SMACNA-HVAC DUCT CONSTRUCTION STANDARDS - METAL AND FLEXIBLE, SECOND EDITION 1995, PAGE 1-24, TABLE 1-6

**CONSTRUCTED:**

Hot Dipped Galvanized Steel PER ASTM A653 CS Type B.

**APPLICATIONS:**

Designed to meet SMACNA Duct Construction Standards.

**DESCRIPTION:**

All Rectangular Ductwork 3" W.G. Static Positive or Negative is Made With The Finest G90 American Steel.

**UNION MADE IN THE UNITED STATES OF AMERICA**  
**PROUDLY USING 100% AMERICAN MADE METALS MANUFACTURED BY C.H.I.**



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## RECTANGULAR DUCTWORK

SMACNA 1995/1997 GUIDELINES

STANDARDS DUCT CONSTRUCTION TABLE  
 FOR GALVANIZED · PAINTLOCK, 304/316 S.S. DUCTWORK  
 (NOT FOR ALUMINUM)

### 4" W.G. STATIC POSITIVE OR NEGATIVE

DUCT SIZE	DUCT GAUGE	JOINT LENGTH	WIDE SIDE CONNECTOR	NARROW SIDE CONNECTOR	*NOTES
0"-10"	26	59"	STANDING SLIP T-11 26GA	FLAT DRIVE T-1 24GA	Ref. 1
11"-12"	26	56"	T.D.C. T-25a	FLAT DRIVE T-1 24GA	Ref. 1
13"-22"	24	56"	T.D.C. T-25a	T.D.C.	Ref. 1
23"-28"	22	56"	T.D.C. T-25a	T.D.C.	Ref. 1
29"-60"	22	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C.	Ref. 2
61"-72"	20	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C. W/C.T.R. & J.T.R. T-25a	Ref. 2
73"-UP	20	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C. W/C.T.R. & J.T.R. T-25a	Ref. 1,2

**NOTES:**

J.T.R. - JOINT TIE ROD  
 C.T.R. - CENTER TIE ROD  
 A.R. ANGLE REINFORCEMENT  
 TIERODS ARE 1/2" EMT  
 IF MPT (MID-POINT TIE RODS) ARE USED, THE REINFORCEMENT SPACING IS BASED ON 2 1/2'

**REFERENCES:**

- SMACNA-HVAC DUCT CONSTRUCTION STANDARDS - METAL AND FLEXIBLE, SECOND EDITION 1995, PAGE 1-26, TABLE 1-7
- SMACNA-HVAC DUCT CONSTRUCTION STANDARDS - METAL AND FLEXIBLE, SECOND EDITION 1997, ADDENDUM 1, PAGE 1-41-7, TABLE 1-75

**CONSTRUCTED:**

Hot Dipped Galvanized Steel PER ASTM A653 CS Type B.

**APPLICATIONS:**

Designed to meet SMACNA Duct Construction Standards.

**DESCRIPTION:**

All Rectangular Ductwork 4" W.G. Static Positive or Negative is Made With The Finest G90 American Steel.

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## RECTANGULAR DUCTWORK

SMACNA 1995/1997 GUIDELINES

STANDARDS DUCT CONSTRUCTION TABLE  
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 (NOT FOR ALUMINUM)

### 6" W.G. STATIC POSITIVE OR NEGATIVE

DUCT SIZE	DUCT GAUGE	JOINT LENGTH	WIDE SIDE CONNECTOR	NARROW SIDE CONNECTOR	*NOTES
0"-8"	26	59"	STANDING SLIP T-11 26GA	FLAT DRIVE T-1 24GA	Ref. 1
9"-12"	24	56"	T.D.C. T-25a	T.D.C. T-25a	Ref. 1
13"-24"	22	56"	T.D.C. T-25a	T.D.C. T-25a	Ref. 1
25"-26"	20	56"	T.D.C. T-25a	T.D.C. T-25a	Ref. 1
27"-48"	22	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C. W/C.T.R. & J.T.R. T-25a	Ref. 2
49"-54"	20	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C. W/C.T.R. & J.T.R. T-25a	Ref. 2
55"-60"	18	56"	T.D.C. W/C.T.R. T-25a	T.D.C. W/C.T.R. T-25a	Ref. 2
61"-72"	18	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C. W/C.T.R. & J.T.R. T-25a	Ref. 2
73"-UP	16	56"	T.D.C. W/C.T.R. & J.T.R. T-25a	T.D.C. W/C.T.R. & J.T.R. T-25a	Ref. 1

**NOTES:**

J.T.R. - JOINT TIE ROD  
 C.T.R. - CENTER TIE ROD  
 A.R. ANGLE REINFORCEMENT  
 TIERODS ARE 1/2" EMT  
 IF MPT (MID-POINT TIE RODS) ARE USED, THE REINFORCEMENT SPACING IS BASED ON 2 1/2'

**REFERENCES:**

- SMACNA-HVAC DUCT CONSTRUCTION STANDARDS - METAL AND FLEXIBLE, SECOND EDITION 1995, PAGE 1-28, TABLE 1-8
- SMACNA-HVAC DUCT CONSTRUCTION STANDARDS - METAL AND FLEXIBLE, SECOND EDITION 1997, ADDENDUM 1, PAGE 1-41-7, TABLE 1-85

**CONSTRUCTED:**

Hot Dipped Galvanized Steel PER ASTM A653 CS Type B.

**APPLICATIONS:**

Designed to meet SMACNA Duct Construction Standards.

**DESCRIPTION:**

All Rectangular Ductwork 6" W.G. Static Positive or Negative is Made With The Finest G90 American Steel.

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# RECTANGULAR DUCTWORK

SMACNA 1995/1997 GUIDELINES

STANDARDS DUCT CONSTRUCTION TABLE  
 FOR GALVANIZED · PAINTLOCK, 304/316 S.S. DUCTWORK  
 (NOT FOR ALUMINUM)

## 10" W.G. STATIC POSITIVE

DUCT SIZE	DUCT GAUGE	JOINT LENGTH	WIDE SIDE CONNECTOR	NARROW SIDE CONNECTOR
0"-30"	26	60"	DUCTMATE35 "E" I.R.	DUCTMATE35 "E" I.R.
31"-36"	24	60"	DUCTMATE35 "E" I.R.	DUCTMATE35 "E" I.R.
37"-42"	22	60"	DUCTMATE35 "F" I.R.	DUCTMATE35 "F" I.R.
43"-48"	22	60"	DUCTMATE35 "G" I.R.	DUCTMATE35 "G" I.R.
49"-54"	22	60"	DUCTMATE35 "H" I.R.	DUCTMATE35 "H" I.R.
55"-60"	22	60"	DUCTMATE35 "H" I.R.,J.T.R.	DUCTMATE35 "H" I.R.,J.T.R.
61"-84"	20	60"	DUCTMATE35 "H" I.R.,J.T.R.	DUCTMATE35 "H" I.R.,J.T.R.
85"-UP	18	60"	DUCTMATE35 "H" I.R.,J.T.R.	DUCTMATE35 "H" I.R.,J.T.R.

**NOTES:**

J.T.R. - JOINT TIE ROD  
 C.T.R. - CENTER TIE ROD  
 A.R. ANGLE REINFORCEMENT  
 TIERODS ARE 1/2' EMT  
 IF MPT (MID-POINT TIE RODS) ARE USED, THE REINFORCEMENT SPACING IS BASED ON 2 1/2'

**REFERENCES:**

1. SMACNA-HVAC DUCT CONSTRUCTION STANDARDS - METAL AND FLEXIBLE, SECOND EDITION 1995, PAGE 10, TABLE 7

**CONSTRUCTED:**

Hot Dipped Galvanized Steel PER ASTM A653 CS Type B.

**APPLICATIONS:**

Designed to meet SMACNA Duct Construction Standards.

**DESCRIPTION:**

All Rectangular Ductwork 10" W.G. Static Positive is Made With The Finest G90 American Steel.

**UNION MADE IN THE UNITED STATES OF AMERICA**  
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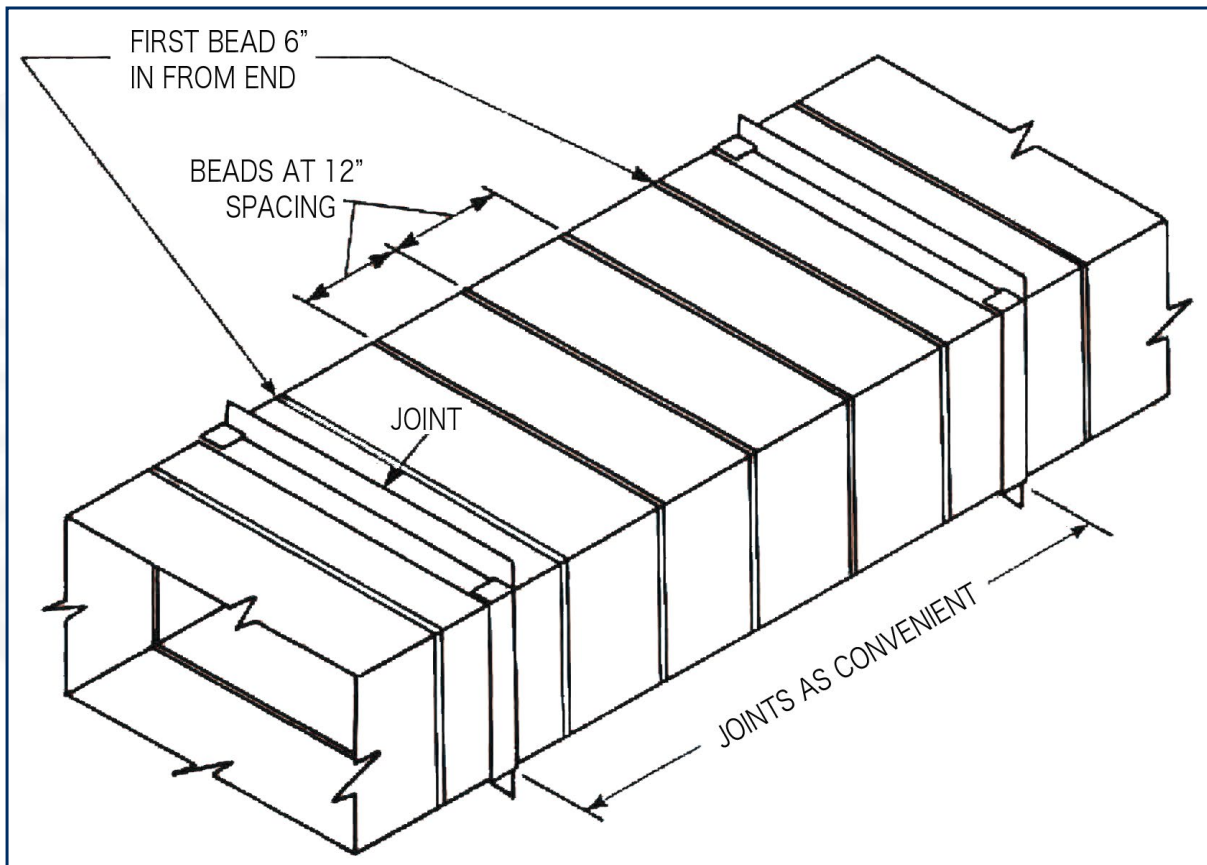
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# RECTANGULAR DUCTWORK

SMACNA 1995/1997/2005 GUIDELINES

STANDARDS DUCT CONSTRUCTION TABLE  
FOR GALVANIZED · PAINTLOCK, 304/316 S.S. DUCTWORK  
(NOT FOR ALUMINUM)

## BEADED DUCT



**REFERENCES:**

1. SMACNA-HVAC DUCT CONSTRUCTION STANDARDS - METAL AND FLEXIBLE, SECOND EDITION 1995, PAGE 1-75, FIGURE 1-8

**CONSTRUCTED:**

Hot Dipped Galvanized Steel PER ASTM A653 CS Type B.

**APPLICATIONS:**

Designed to meet SMACNA Duct Construction Standards.

**DESCRIPTION:**

All Rectangular Ductwork Beaded Duct is Made With The Finest G90 American Steel.

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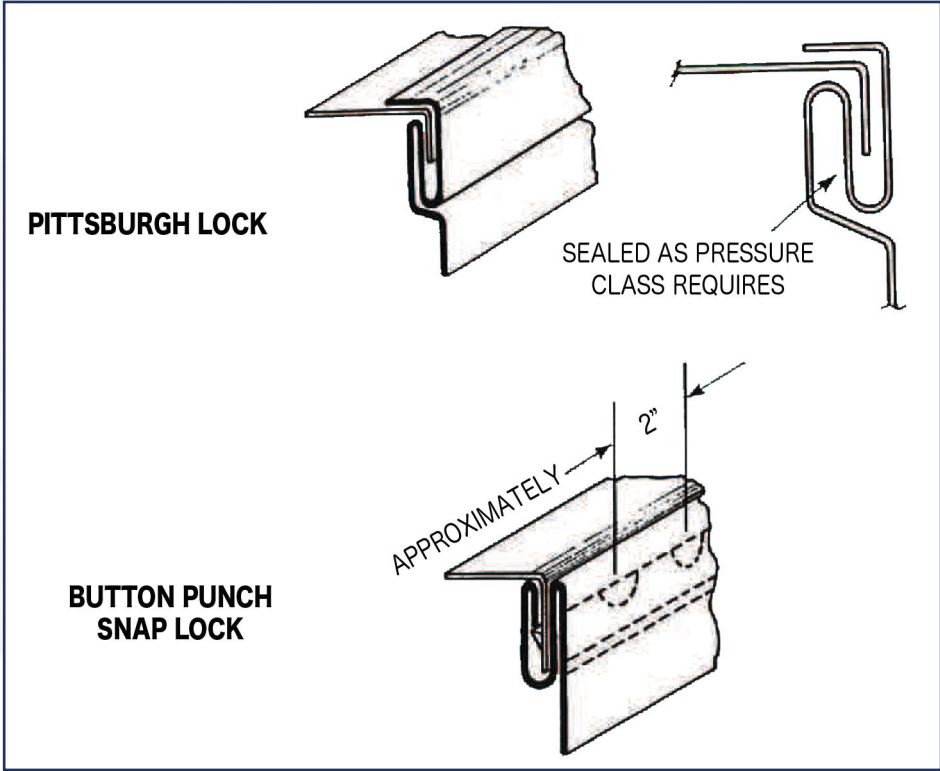
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# RECTANGULAR DUCTWORK

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STANDARDS DUCT CONSTRUCTION TABLE  
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(NOT FOR ALUMINUM)

## LONGITUDINAL SEAMS



REFERENCES:  
1. SMACNA-HVAC DUCT CONSTRUCTION STANDARDS - METAL AND FLEXIBLE, SECOND EDITION 1995, PAGE 1-67, FIGURE 1-5

**CONSTRUCTED:**  
Hot Dipped Galvanized Steel PER ASTM A653 CS Type B.

**APPLICATIONS:**  
Designed to meet SMACNA Duct Construction Standards.

**DESCRIPTION:**  
All Rectangular Ductwork Longitudinal Seams are Made With The Finest G90 American Steel.

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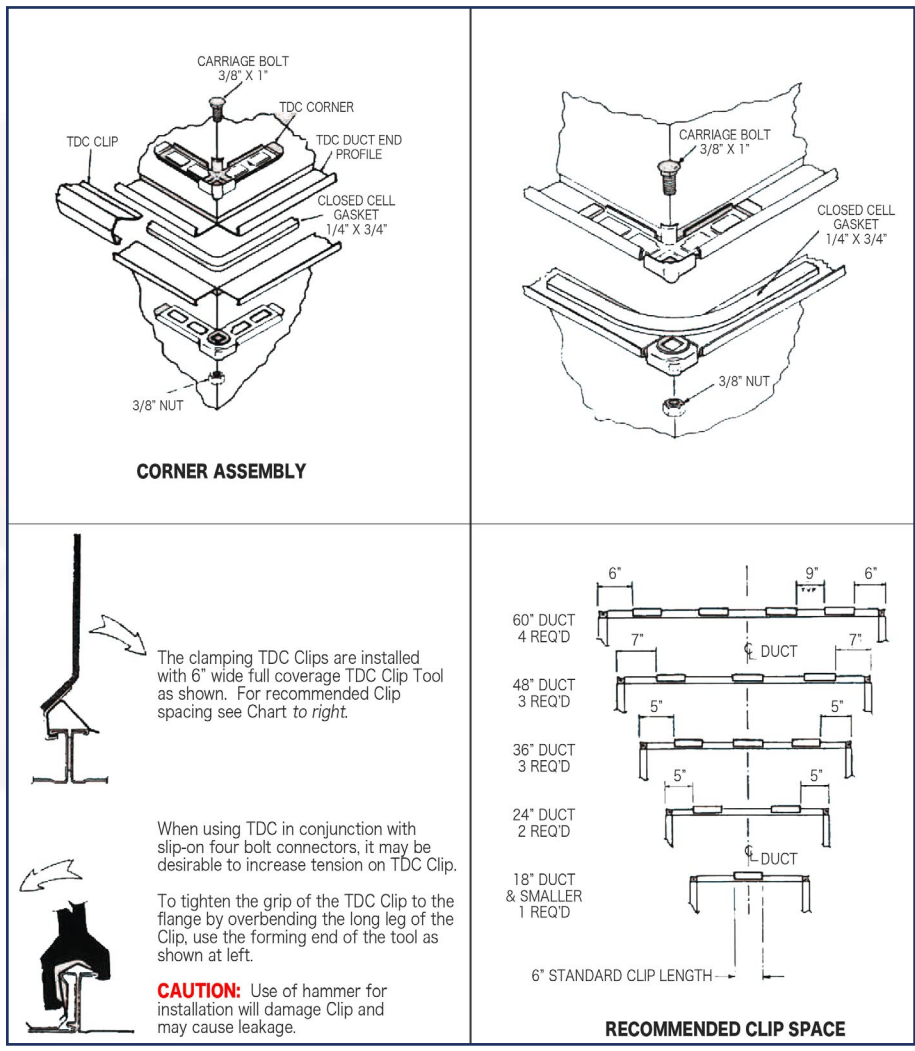


# RECTANGULAR DUCTWORK

SMACNA 1995/1997/2005 GUIDELINES

STANDARDS DUCT CONSTRUCTION TABLE  
 FOR GALVANIZED · PAINTLOCK, 304/316 S.S. DUCTWORK  
 (NOT FOR ALUMINUM)

## T.D.C. CONNECTORS



REFERENCES:  
 1. SMACNA-HVAC DUCT CONSTRUCTION STANDARDS - METAL AND FLEXIBLE, SECOND EDITION 1995

**CONSTRUCTED:**  
 Hot Dipped Galvanized Steel PER ASTM A653 CS Type B.  
**APPLICATIONS:**  
 Designed to meet SMACNA Duct Construction Standards.  
**DESCRIPTION:**  
 All Rectangular Ductwork T.D.C. Connectors are Made With The Finest G90 American Steel.

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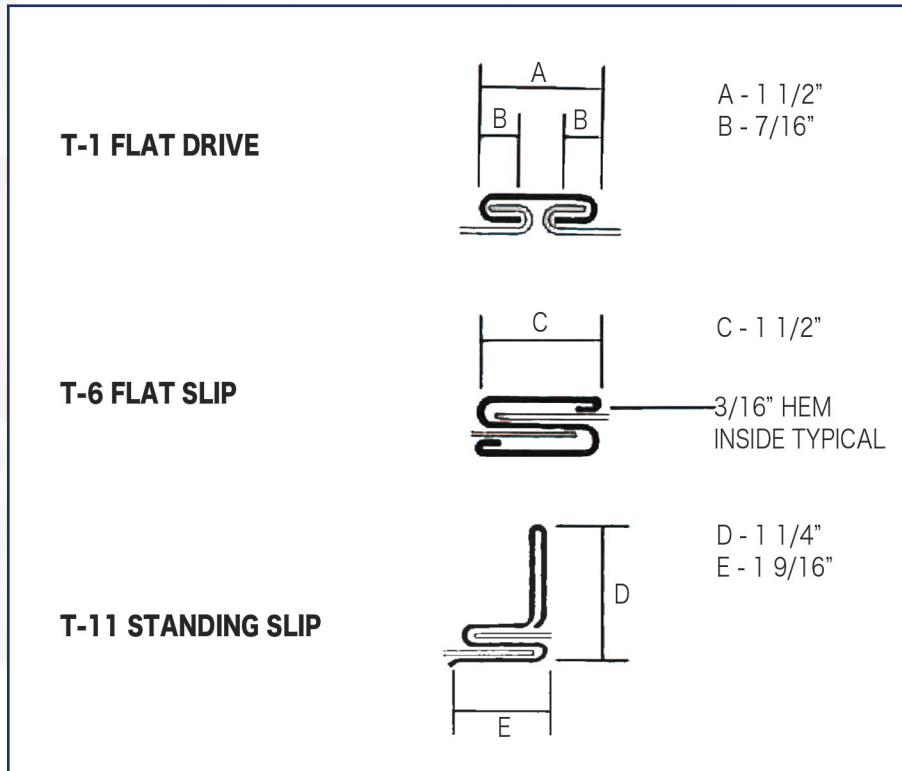


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**RECTANGULAR DUCTWORK**  
 SMACNA 1995/1997/2005 GUIDELINES

STANDARDS DUCT CONSTRUCTION TABLE  
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## TRANSVERSE CONNECTORS



**REFERENCES:**

- SMACNA-HVAC DUCT CONSTRUCTION STANDARDS - METAL AND FLEXIBLE, SECOND EDITION 1995, PAGE 1-61, FIGURE 1-4
- SEE DUCT CONSTRUCTION TABLES FOR LIMITS OF APPLICATION

**CONSTRUCTED:**

Hot Dipped Galvanized Steel PER ASTM A653 CS Type B.

**APPLICATIONS:**

Designed to meet SMACNA Duct Construction Standards.

**DESCRIPTION:**

All Rectangular Ductwork Transverse Connectors are Made With The Finest G90 American Steel.

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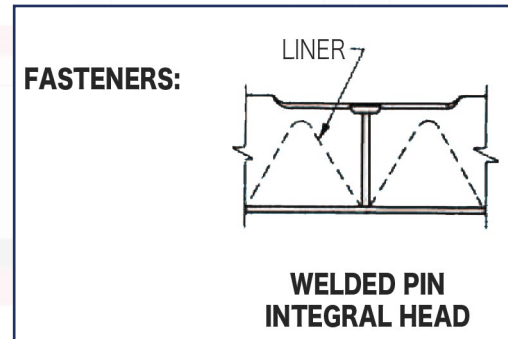
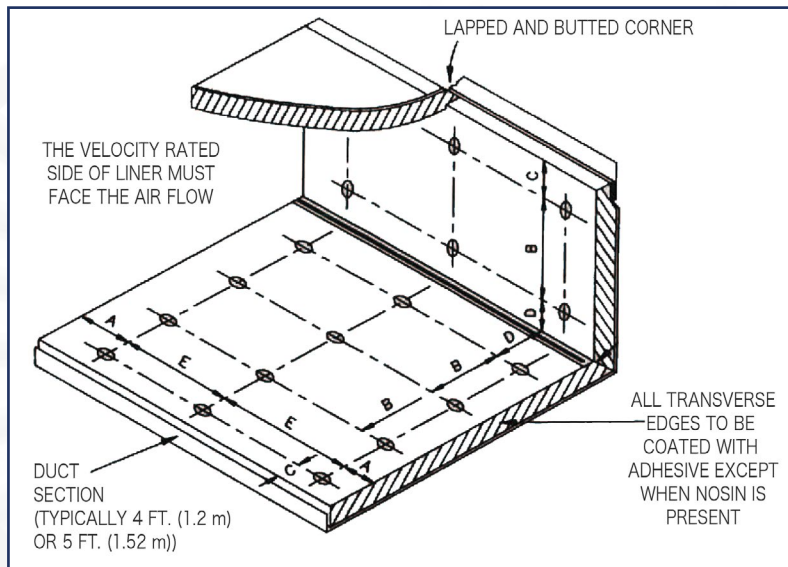
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# RECTANGULAR DUCTWORK

SMACNA 1995/1997/2005 GUIDELINES

STANDARDS DUCT CONSTRUCTION TABLE  
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 (NOT FOR ALUMINUM)

## DUCT LINER INSTALLATION



LINEAR FASTENING SCHEDULE					
VELOCITY	DIMENSIONS				
	A	B	C	D	E
0-2500 FPM	3"	12"	4"	6"	18"
2501-6000 FPM	3"	6"	4'	6"	16"

**REFERENCES:**

1. SMACNA-HVAC DUCT CONSTRUCTION STANDARDS - METAL AND FLEXIBLE, SECOND EDITION 1995, PAGE 2-24 and 2-28, FIGURE 2-19 and 2-20

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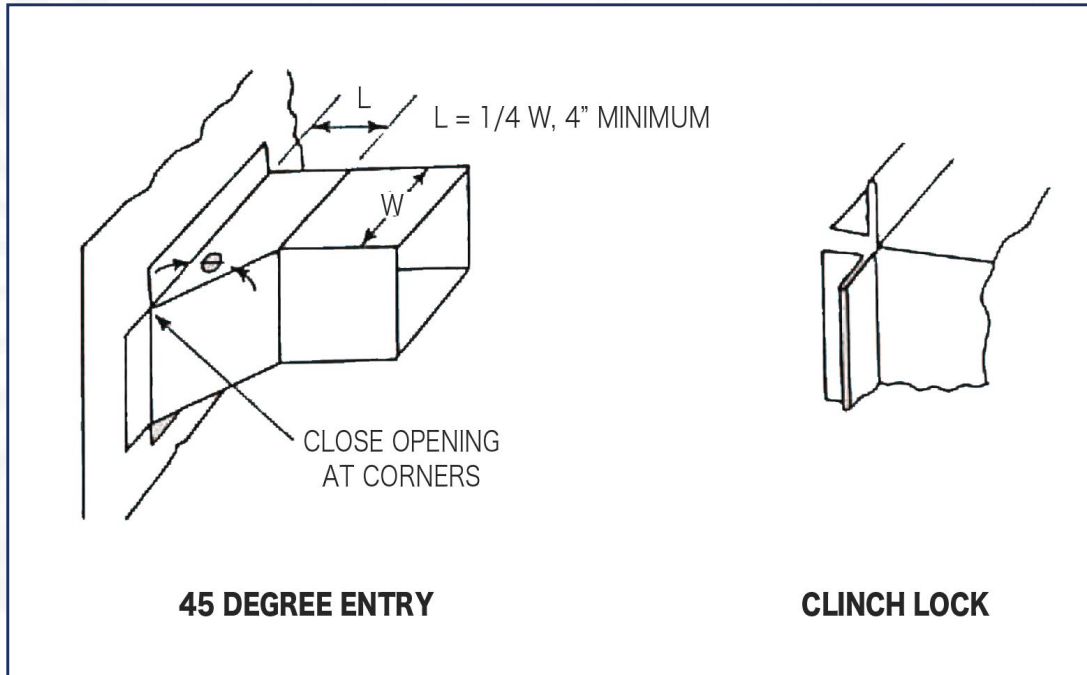


# RECTANGULAR DUCTWORK

SMACNA 1995/1997/2005 GUIDELINES

STANDARDS DUCT CONSTRUCTION TABLE  
FOR GALVANIZED · PAINTLOCK, 304/316 S.S. DUCTWORK  
(NOT FOR ALUMINUM)

## BRANCH CONNECTIONS



**REFERENCES:**

1. SMACNA-HVAC DUCT CONSTRUCTION STANDARDS - METAL AND FLEXIBLE, SECOND EDITION 1995, PAGE 2-8, FIGURE 2-6
2. EXTRACTORS TO BE FURNISHED AND INSTALLED BY ERECTORS WHERE SPECIFIED

**CONSTRUCTED:**

Hot Dipped Galvanized Steel PER ASTM A653 CS Type B.

**APPLICATIONS:**

Designed to meet SMACNA Duct Construction Standards.

**DESCRIPTION:**

All Rectangular Ductwork Branch Connections are Made With The Finest G90 American Steel.

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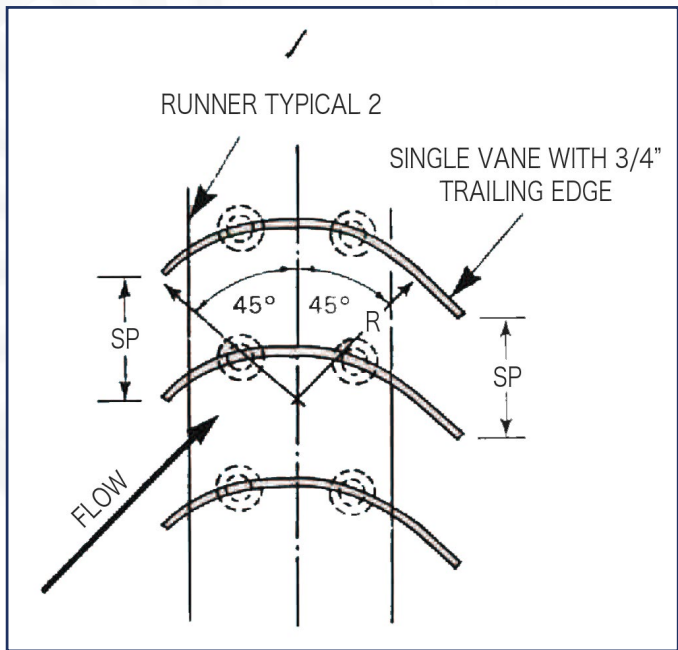
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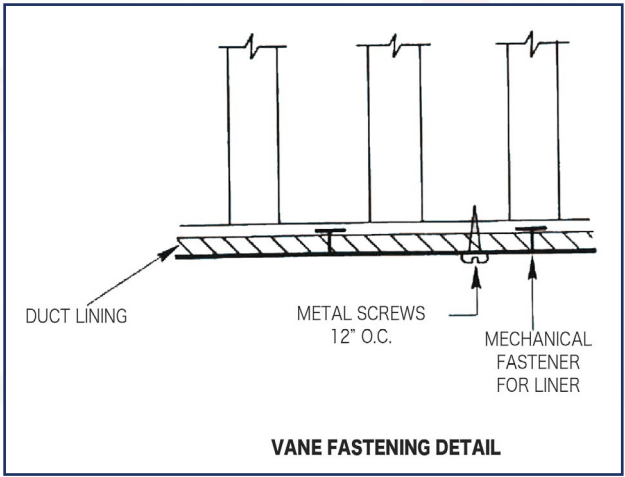
SMACNA 1995/1997/2005 GUIDELINES

STANDARDS DUCT CONSTRUCTION TABLE  
 FOR GALVANIZED · PAINTLOCK, 304/316 S.S. DUCTWORK  
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## SINGLE TURNING VANES



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



- REFERENCES:**
1. SMACNA-HVAC DUCT CONSTRUCTION STANDARDS - METAL AND FLEXIBLE, SECOND EDITION 1995, PAGE 2-5 and 2-6, FIGURE 2-3 and 2-4
  2. MAXIMUM UNSUPPORTED VANE LENGTH IS 36"

**CONSTRUCTED:**  
 Hot Dipped Galvanized Steel PER ASTM A653 CS Type B.

**APPLICATIONS:**  
 Designed to meet SMACNA Duct Construction Standards.

**DESCRIPTION:**  
 All Rectangular Ductwork Single Turning Vanes are Made With The Finest G90 American Steel.

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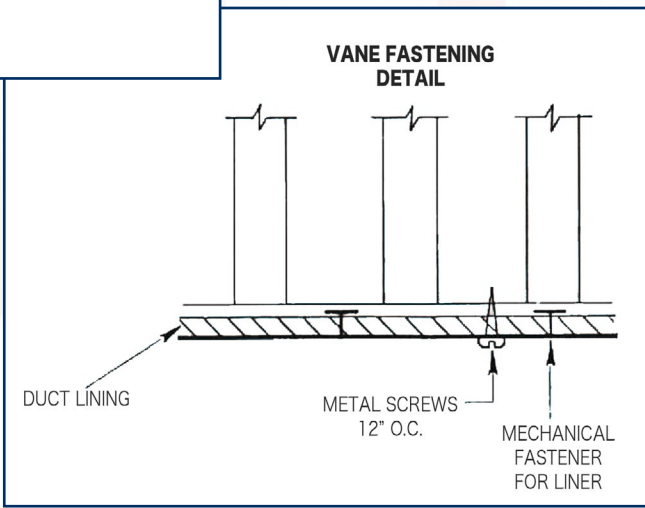
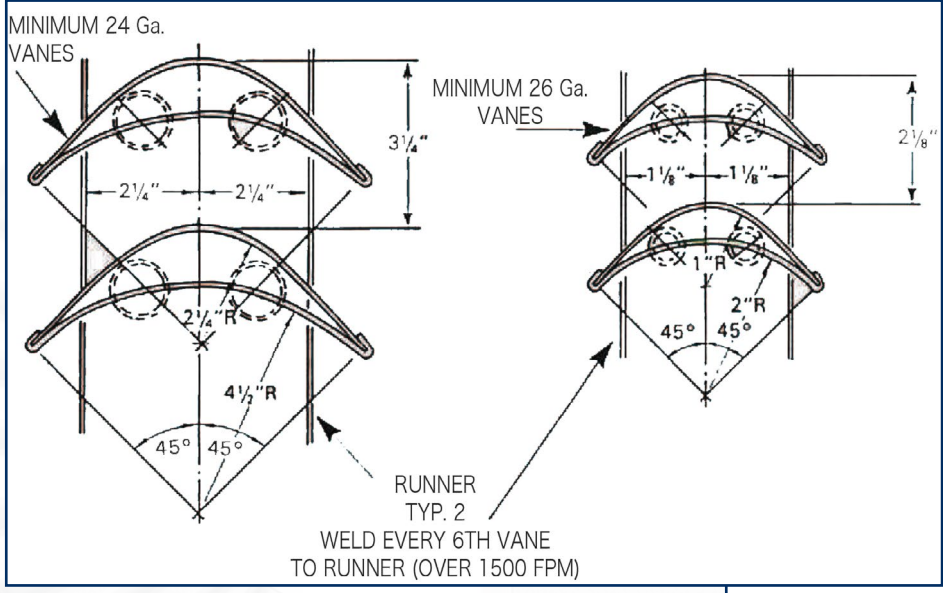
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SMACNA 1995/1997/2005 GUIDELINES

STANDARDS DUCT CONSTRUCTION TABLE  
 FOR GALVANIZED · PAINTLOCK, 304/316 S.S. DUCTWORK  
 (NOT FOR ALUMINUM)

## AIRFOIL TURNING VANES



- REFERENCES:
- SMACNA-HVAC DUCT CONSTRUCTION STANDARDS - METAL AND FLEXIBLE, SECOND EDITION 1995, PAGE 2-5, FIGURES 2-3 and 2-4
  - MAXIMUM UNSUPPORTED SMALL VANE LENGTH IS 48" AND LARGE LENGTH VANE IS 72"

**CONSTRUCTED:**  
 Hot Dipped Galvanized Steel PER ASTM A653 CS Type B.

**APPLICATIONS:**  
 Designed to meet SMACNA Duct Construction Standards.

**DESCRIPTION:**  
 All Rectangular Ductwork Airfoil Turning Vanes are Made With The Finest G90 American Steel.

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