



DUCT SIZE MAX DIM	MIN GAUGE	MAX JOINT LENGTH	TRANSVERSE JOINT CONNECTIONS	TRANSVERSE REINFORCING		METHOD OF SEALING	
				MIDWAY	AT JOINT	TRANS JOINTS	LONG SEAMS
12-Dn	26	71	Slip & Drive	None	None	Duct Sealer	Non-Hardening Sealant
13-30	26	68	TDC	None	None	Butyl Gasket	Non-Hardening Sealant
31-36	24	68	TDC	None	None	Butyl Gasket	Non-Hardening Sealant
37-42	22	68	TDC	None	None	Butyl Gasket	Non-Hardening Sealant
43-60	22	68	TDC	1 Mid-Point-Tie	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
61-72	20	68	TDC	1 Mid-Point-Tie	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
73-96	20	68	TDC	2 Mid-Point-Ties	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
97-Up	18	72	DM35	2" x 1 1/8" 12ga. ZBar	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant

Notes:

1. Longitudinal seams for 20ga. duct and up 5/8" Snap-Lock, 18ga. duct shall be Pittsburgh construction on straight duct
2. All fittings shall be Pittsburgh construction
3. All ductwork beaded at 12" spacing
4. Tie-Rods shall be 3/8" diameter
5. When required, ALL fittings over 36" long will be reinforced

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**1" W.G.**



DUCT SIZE MAX DIM	MIN GAUGE	MAX JOINT LENGTH	TRANSVERSE JOINT CONNECTIONS	TRANSVERSE REINFORCING		METHOD OF SEALING	
				MIDWAY	AT JOINT	TRANS JOINTS	LONG SEAMS
12-Dn	26	71	Slip & Drive	None	None	Duct Sealer	Non-Hardening Sealant
13-26	24	68	TDC	None	None	Butyl Gasket	Non-Hardening Sealant
27-36	22	68	TDC	None	None	Butyl Gasket	Non-Hardening Sealant
37-54	22	68	TDC	1 Mid-Point-Tie	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
55-60	22	68	TDC	2 Mid-Point-Ties	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
61-84	20	68	TDC	2 Mid-Point-Ties	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
85-96	18	68	TDC	2 Mid-Point-Ties	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
97-Up	18	72	DM35	2" x 1 1/8" 12ga. ZBar w/rod	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant

Notes:

1. Longitudinal seams for 20ga. duct and up 5/8" Snap-Lock, 18ga. duct shall be Pittsburgh construction on straight duct
2. All fittings shall be Pittsburgh construction
3. All ductwork beaded at 12" spacing
4. Tie-Rods shall be 3/8" diameter
5. When required, ALL fittings over 36" long will be reinforced

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**2" W.G.**



DUCT SIZE MAX DIM	MIN GAUGE	MAX JOINT LENGTH	TRANSVERSE JOINT CONNECTIONS	TRANSVERSE REINFORCING		METHOD OF SEALING	
				MIDWAY	AT JOINT	TRANS JOINTS	LONG SEAMS
18-Dn	24	68	TDC	None	None	Butyl Gasket	Non-Hardening Sealant
19-26	22	68	TDC	None	None	Butyl Gasket	Non-Hardening Sealant
27-42	22	68	TDC	1 Mid-Point-Tie	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
43-48	22	68	TDC	1 Mid-Point-Tie	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
49-54	22	68	TDC	2 Mid-Point-Ties	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
55-72	20	68	TDC	2 Mid-Point-Ties	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
73-84	18	68	TDC	2 Mid-Point-Ties	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
85-96	18	68	TDC	2" x 1 1/8" 12ga. ZBar w/rod	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
97-Up	18	72	DM35	2" x 1 1/8" 12ga. ZBar w/rod	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant

Notes:

1. All longitudinal seams shall be Pittsburgh construction on straight duct and fittings
2. All ductwork beaded at 12" spacing
3. Tie-Rods shall be 3/8" diameter
4. When required, ALL fittings over 36" long will be reinforced

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**3" W.G.**



DUCT SIZE MAX DIM	MIN GAUGE	MAX JOINT LENGTH	TRANSVERSE JOINT CONNECTIONS	TRANSVERSE REINFORCING		METHOD OF SEALING	
				MIDWAY	AT JOINT	TRANS JOINTS	LONG SEAMS
12-Dn	24	68	TDC	None	None	Butyl Gasket	Non-Hardening Sealant
13-28	22	68	TDC	None	None	Butyl Gasket	Non-Hardening Sealant
29-42	22	68	TDC	1 Mid-Point-Tie	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
43-48	22	68	TDC	1 Mid-Point-Tie	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
49-54	20	68	TDC	1 Mid-Point-Tie	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
55-60	20	68	TDC	2 Mid-Point-Ties	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
61-84	18	68	TDC	2 Mid-Point-Ties	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
85-96	18	68	TDC	2" x 1 1/8" 12ga. ZBar w/rod	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
97-Up	18	72	DM35	2" x 1 1/8" 12ga. ZBar w/rod at 23" spacing	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant

Notes:

1. All longitudinal seams shall be Pittsburgh construction on straight duct and fittings
2. All ductwork beaded at 12" spacing
3. Tie-Rods shall be 3/8" diameter
4. When required, ALL fittings over 36" long will be reinforced
5. All ZBar shall be tied

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**4" W.G.**



DUCT SIZE MAX DIM	MIN GAUGE	MAX JOINT LENGTH	TRANSVERSE JOINT CONNECTIONS	TRANSVERSE REINFORCING		METHOD OF SEALING	
				MIDWAY	AT JOINT	TRANS JOINTS	LONG SEAMS
8-Dn	18	59	Weld Flange - 1/2"	None	None	MIG Weld	MIG Weld
9-12	18	59	Weld Flange - 1/2"	None	None	MIG Weld	MIG Weld
13-20	18	59	Weld Flange - 1/2"	None	None	MIG Weld	MIG Weld
21-24	18	59	Weld Flange - 1/2"	None	None	MIG Weld	MIG Weld
25-30	18	59	Weld Flange - 1/2"	None	None	MIG Weld	MIG Weld
31-36	18	59	Weld Flange - 1/2"	None	None	MIG Weld	MIG Weld
37-42	18	59	Weld Flange - 1/2"	None	None	MIG Weld	MIG Weld
43-54	18	59	Weld Flange - 1/2"	None	None	MIG Weld	MIG Weld
55-60	18	59	Weld Flange - 1/2"	None	None	MIG Weld	MIG Weld
61-72	18	59	Weld Flange - 1/2"	None	None	MIG Weld	MIG Weld
73-84	16	59	Weld Flange - 1/2"	None	None	MIG Weld	MIG Weld
85-96	16	59	Weld Flange - 1/2"	2" x 1 1/8" 16ga. ZBar	None	MIG Weld	MIG Weld
97-Up	16	59	Weld Flange - 1/2"	2" x 1 1/8" 12ga. ZBar	None	MIG Weld	MIG Weld

**Notes:**

1. When required, all fittings over 36" long will be re-inforced
2. Material heavier than 16ga. will have a max joint length of 47"
3. Welded duct available in black iron, stainless steel, and galvanized material



DUCT SIZE MAX DIM	MIN GAUGE	MAX JOINT LENGTH	TRANSVERSE JOINT CONNECTIONS	TRANSVERSE REINFORCING		METHOD OF SEALING	
				MIDWAY	AT JOINT	TRANS JOINTS	LONG SEAMS
8-Dn	22	68	TDC	None	None	Butyl Gasket	Non-Hardening Sealant
9-12	22	68	TDC	None	None	Butyl Gasket	Non-Hardening Sealant
13-20	22	68	TDC	2" x 1 1/8" 16ga. ZBar	None	Butyl Gasket	Non-Hardening Sealant
21-24	22	68	TDC	2" x 1 1/8" 16ga. ZBar	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
25-36	20	68	TDC	2" x 1 1/8" 16ga. ZBar	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
37-54	18	68	TDC	2" x 1 1/8" 16ga. ZBar	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
				w/rod			
55-60	18	68	TDC	2" x 1 1/8" 12ga. ZBar	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
				w/rod at 23" spacing			
61-72	18	68	TDC	2" x 1 1/8" 12ga. ZBar	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
				w/rod at 23" spacing			
73-96	16	72	DM35	2" x 1 1/8" 12ga. ZBar	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
				w/rod at 23" spacing			
97-Up	16	72	DM35	2" x 1 1/8" 12ga. ZBar	3/8" Tie-Rods	Butyl Gasket	Non-Hardening Sealant
				w/rod at 23" spacing			

Notes:

1. All longitudinal seams shall be Pittsburgh construction
2. All ductwork beaded at 12" spacing
3. Tie-Rods shall be 3/8" diameter
4. When required, ALL fittings over 36" long will be reinforced
5. All ZBar shall be tied

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**10" W.G.**



2" W.G		
MAX DUCT DIAMETER	SPIRAL GAUGE	FITTING GAUGE
14	28	26
26	26	24
36	24	22
50	22	20
60	20	18
84	18	16

4" W.G		
MAX DUCT DIAMETER	SPIRAL GAUGE	FITTING GAUGE
12	28	26
16	26	24
18	24	24
26	24	22
36	22	20
50	20	20
60	18	18
84	18	16

10" W.G		
MAX DUCT DIAMETER	SPIRAL GAUGE	FITTING GAUGE
10	28	26
14	26	24
26	24	22
36	22	20
50	20	20
60	18	18
84	18	16

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