



PVC & CPVC FABRICATED DUCT FITTINGS

FD-2-0508

Industrial Grade for General Purpose & Corrosive Vapor Fumes

Spears® Industrial Grade Fabricated PVC & CPVC Duct provides a light weight and low maintenance alternative to conventional metal ducting with superior chemical & corrosion resistance. Produced in a wide variety of sizes and configurations from 6" through 24" with custom fabrication available to virtually any size and shape.

Thermoplastic Duct Construction

Spears® Fabricated Duct fittings are manufactured in accordance with applicable guidelines and requirements to assure sound, reliable construction, performance and compatibility that meet customer design specifications. Included with our high quality standard duct line, Spears® offers duct product designed to the Sheet Metal and Air Conditioning Contractors' National Association (SMACNA) requirements.

Chemical & Corrosion Resistant PVC & CPVC Construction

Unlike metal, PVC & CPVC Duct never rusts, scales or pits remaining virtually maintenance free for years.

Fabricated From Premium Quality Seamless Extruded Round Duct

Spears® Fabricated Duct Fittings are produced from premium quality PVC & CPVC materials conforming to ASTM D1784.

Custom Fabricated Duct Fittings, Accessories & Complete Exhaust Systems

Spears® offers custom fabrication for a wide variety of specialty needs including:

- Square Duct
- Rectangular Duct
- Fume Hoods
- Fume Exhaust Systems

General Specifications for Round PVC & CPVC Duct Fittings

Materials

All fabricated duct fittings, sizes 6" to 24", shall be constructed from ASTM D 1784 PVC or CPVC seamless extruded duct. Custom produced sizes above 24" shall be constructed from cold rolled PVC Type I & Type II, Grade I extruded sheet with thermal fused seam.

Elbow Configurations

Elbows angles are manufactured through the use of thermoforming and hot gas welding. Standard 45° elbows are offered 1-piece formed, with 2-piece or 3-piece welded. The 45° 3-piece meet SMACNA requirements. Standard 90° elbows are offered in 2-piece formed, with 3-piece or 5-piece welded. The 90° 5-piece meet SMACNA requirements. Additional elbow configurations meeting SMACNA requirements are available upon request.

Maximum Service Temperatures

PVC = 140°F; CPVC = 200°F

Joining Methods

Solvent cement, hot-gas welding, or flanged connections.

Dimensions

Round Duct socket dimensions shall meet the requirements of the Sheet Metal and Air Conditioning Contractors' National Association Thermoplastic Duct Construction Manual. Fittings shall be constructed from seamless duct meeting the following dimensional specifications. All dimensions are in inches:

Size	Average O.D.	Average O.D. Tol	Out of Round ¹	Min. Wall	Max. Wall
6"	6.625	± .020	± .050	.172	.202
7" *	7.375	± .020	± .050	.172	.202
8"	8.625	± .020	± .075	.172	.202
9" *	9.375	± .025	± .075	.172	.202
10"	10.750	± .025	± .075	.172	.202
11" *	11.375	± .025	± .075	.172	.202
12"	12.750	± .025	± .075	.172	.202
14"	14.000	± .030	± .075	.172	.202
16"	16.000	± .030	± .075	.172	.202
18"	18.000	± .040	± .080	.172	.202
20"	20.000	± .070	± .140	.199	.239
24"	24.000	± .090	± .180	.230	.270

¹ : Out-of-Round as produced at factory.

* : PVC Only

Systems should be installed and supported in accordance with the duct pipe manufacturer's installation guidelines.

Contact Spears® Technical Services for additional information.

PROGRESSIVE PRODUCTS FROM SPEARS® INNOVATION & TECHNOLOGY

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