SECTION 23 31 00
HVAC DUCTS AND CASINGS

PART 1 - GENERAL

1.1 DESCRIPTION

A. Ductwork and accessories for HVAC including the following:
   1. Supply air, return air, outside air, exhaust, make-up air, and relief systems.

B. Definitions:
   1. SMACNA Standards as used in this specification means the HVAC Duct Construction Standards, Metal and Flexible.
   2. Seal or Sealing: Use of liquid or mastic sealant, with or without compatible tape overlay, or gasketing of flanged joints, to keep air leakage at duct joints, seams and connections to an acceptable minimum.
   3. Duct Pressure Classification: SMACNA HVAC Duct Construction Standards, Metal and Flexible.

1.2 RELATED WORK

A. General Mechanical Requirements: Section 23 05 11, COMMON WORK RESULTS FOR HVAC and STEAM GENERATION.
B. Testing and Balancing of Air Flows: Section 23 05 93, TESTING, ADJUSTING, and BALANCING FOR HVAC.

1.3 QUALITY ASSURANCE

A. Refer to article, QUALITY ASSURANCE, in Section 23 05 11, COMMON WORK RESULTS FOR HVAC and STEAM GENERATION.
B. Fire Safety Code: Comply with NFPA 90A.
C. Duct System Construction and Installation: Referenced SMACNA Standards are the minimum acceptable quality.
D. Duct Sealing, Air Leakage Criteria, and Air Leakage Tests: Ducts shall be sealed as per duct sealing requirements of SMACNA HVAC Air Duct Leakage Test Manual for duct pressure classes shown on the drawings.
E. Duct accessories exposed to the air stream, such as dampers of all types (except smoke dampers) and access openings, shall be of the same material as the duct or provide at least the same level of corrosion resistance.

1.4 SUBMITTALS

A. Submit in accordance with Section 01 33 23, SHOP DRAWINGS, PRODUCT DATA, and SAMPLES.

B. Manufacturer's Literature and Data:

1. Rectangular ducts:
   a. Schedules of duct systems, materials and selected SMACNA construction alternatives for joints, sealing, gage and reinforcement.
   b. Duct liner.
   c. Sealants and gaskets.
   d. Access doors.
2. Round and flat oval duct construction details:
   a. Manufacturer's details for duct fittings.
   b. Duct liner.
   c. Sealants and gaskets.
   d. Access sections.
   e. Installation instructions.
3. Volume dampers, back draft dampers.
4. Upper hanger attachments.
5. Fire dampers, fire doors, and smoke dampers with installation instructions.
6. Sound attenuators, including pressure drop and acoustic performance.
7. Flexible ducts and clamps, with manufacturer's installation instructions.
8. Flexible connections.
9. Instrument test fittings.
10 Details and design analysis of alternate or optional duct systems.
11 COMMON WORK RESULTS FOR HVAC and STEAM GENERATION.

C. Coordination Drawings: Refer to article, SUBMITTALS, in Section 23 05 11 – Common Work Results for HVAC and Steam Generation.

1.5 APPLICABLE PUBLICATIONS

A. The publications listed below form a part of this specification to the extent referenced. The publications are referenced in the text by the basic designation only.

B. American Society of Civil Engineers (ASCE):

ASCE7-05.....Minimum Design Loads for Buildings and Other Structures

C. American Society for Testing and Materials (ASTM):

A167-99(2009).....Standard Specification for Stainless and Heat-Resisting Chromium-Nickel Steel Plate, Sheet, and Strip

A653-09.....Standard Specification for Steel Sheet, Zinc-Coated (Galvanized) or Zinc-Iron Alloy coated (Galvannealed) by the Hot-Dip process

A1011-09a.....Standard Specification for Steel, Sheet and Strip, Hot rolled, Carbon, structural, High-Strength Low-Alloy, High Strength Low-Alloy with Improved Formability, and Ultra-High Strength

B209-07.....Standard Specification for Aluminum and Aluminum-Alloy Sheet and Plate

C1071-05e1.....Standard Specification for Fibrous Glass Duct Lining Insulation (Thermal and Sound Absorbing Material)

E84-09a.....Standard Test Method for Surface Burning Characteristics of Building Materials

D. National Fire Protection Association (NFPA):

90A-09.....Standard for the Installation of Air Conditioning and Ventilating Systems

96-08.....Standard for Ventilation Control and Fire Protection of Commercial Cooking Operations

E. Sheet Metal and Air Conditioning Contractors National Association (SMACNA):

2nd Edition – 2005.....HVAC Duct Construction Standards, Metal and Flexible

1st Edition - 1985.....HVAC Air Duct Leakage Test Manual

6th Edition – 2003.....Fibrous Glass Duct Construction Standards

F. Underwriters Laboratories, Inc. (UL):

181-08.....Factory-Made Air Ducts and Air Connectors

555-06 .....Standard for Fire Dampers

555S-06 .....Standard for Smoke Dampers

PART 2 - PRODUCTS

2.1 DUCT MATERIALS AND SEALANTS

A. General: Except for systems specified otherwise, construct ducts, casings, and accessories of galvanized sheet steel, ASTM A653, coating G90; or, aluminum sheet, ASTM B209, alloy 1100, 3003 or 5052.

B. Joint Sealing: Refer to SMACNA HVAC Duct Construction Standards, paragraph S1.9.
   1. Sealant: Elastomeric compound, gun or brush grade, maximum 25 flame spread and 50 smoke developed (dry state) compounded specifically for sealing ductwork as recommended by the manufacturer. Generally provide liquid sealant, with or without compatible tape, for low clearance slip joints and heavy, permanently elastic, mastic type where clearances are larger. Oil base caulking and glazing compounds are not acceptable because they do not retain elasticity and bond.
   2. Tape: Use only tape specifically designated by the sealant manufacturer and apply only over wet sealant. Pressure sensitive tape shall not be used on bare metal or on dry sealant.
   3. Gaskets in Flanged Joints: Soft neoprene.
C. Approved factory made joints may be used.

2.2 DUCT CONSTRUCTION AND INSTALLATION

A. Regardless of the pressure classifications outlined in the SMACNA Standards, fabricate and seal the ductwork in accordance with the following pressure classifications:
B. Duct Pressure Classification:
   0 to 50 mm (2 inch)
   > 50 mm to 75 mm (2 inch to 3 inch)
   > 75 mm to 100 mm (3 inch to 4 inch)
   Show pressure classifications on the floor plans.
C. Seal Class: All ductwork shall receive Class A Seal
D. Round and Flat Oval Ducts: Furnish duct and fittings made by the same manufacturer to insure good fit of slip joints. When submitted and approved in advance, round and flat oval duct, with size converted on the basis of equal pressure drop, may be furnished in lieu of rectangular duct design shown on the drawings.
   1. Elbows: Diameters 80 through 200 mm (3 through 8 inches) shall be two sections die stamped, all others shall be gored construction, maximum 18 degree angle, with all seams continuously welded or standing seam. Coat galvanized areas of fittings damaged by welding with corrosion resistant aluminum paint or galvanized repair compound.
   2. Provide bell mouth, conical tees or taps, laterals, reducers, and other low loss fittings as shown in SMACNA HVAC Duct Construction Standards.
   3. Ribbed Duct Option: Lighter gage round/oval duct and fittings may be furnished provided certified tests indicating that the rigidity and

performance is equivalent to SMACNA standard gage ducts are submitted.

a. Ducts: Manufacturer's published standard gage, G90 coating, spiral lock seam construction with an intermediate standing rib.

b. Fittings: May be manufacturer's standard as shown in published catalogs, fabricated by spot welding and bonding with neoprene base cement or machine formed seam in lieu of continuous welded seams.

4. Provide flat side reinforcement of oval ducts as recommended by the manufacturer and SMACNA HVAC Duct Construction Standard S3.13. Because of high pressure loss, do not use internal tie-rod reinforcement unless approved by the Resident Engineer.

E. Casings and Plenums: Construct in accordance with SMACNA HVAC Duct Construction Standards Section 6, including curbs, access doors, pipe penetrations, eliminators and drain pans. Access doors shall be hollow metal, insulated, with latches and door pulls, 500 mm (20 inches) wide by 1200 - 1350 mm (48 - 54 inches) high. Provide view port in the doors where shown. Provide drain for outside air louver plenum. Outside air plenum shall have exterior insulation. Drain piping shall be routed to the nearest floor drain.

F. Volume Dampers: Single blade or opposed blade, multi-louver type as detailed in SMACNA Standards. Refer to SMACNA Detail Figure 2-12 for Single Blade and Figure 2.13 for Multi-blade Volume Dampers.

G. Duct Hangers and Supports: Refer to SMACNA Standards Section IV. Avoid use of trapeze hangers for round duct.

2.3 DUCT LINER (WHERE INDICATED ON DRAWINGS)

A. Duct sizes shown on drawings for lined duct are clear opening inside lining.

B. Duct liner is only permitted to be used for return, relief and general exhaust ducts. Duct liner is not permitted for outside air ducts, supply air ducts or any other positive pressure ductwork (provide exterior insulation only).

C. Rectangular Duct or Casing Liner: ASTM C1071, Type I (flexible), or Type II (board), 25 mm (one inch) minimum thickness, applied with mechanical fasteners and 100 percent coverage of adhesive in conformance with SMACNA, Duct Liner Application Standard.

D. Round and Oval Duct Liner: Factory fabricated double-walled with 25 mm (one) thick sound insulation and inner perforated galvanized metal liner. Construction shall comply with flame and smoke rating required by

NFPA 90A. Metal liner shall be 1.0 to 0.60 mm (20 to 24 gage) having perforations not exceeding 2.4 mm (3/32 inch) diameter and approximately 22 percent free area. Metal liner for fittings need not be perforated. Assemblies shall be complete with continuous sheet Mylar liner, 2 mil thickness, between the perforated liner and the insulation to prevent erosion of the insulation. Provide liner couplings/spacer for metal liner. At the end of insulated sections, provide insulation end fittings to reduce outer shell to liner size. Provide liner spacing/concentricity leaving airway unobstructed.

2.4 DUCT ACCESS DOORS, PANELS AND SECTIONS

A. Provide access doors, sized and located for maintenance work, upstream, in the following locations:
   1. Each duct mounted coil and humidifier.
   2. Each fire damper (for link service), smoke damper and automatic control damper.
   3. Each duct mounted smoke detector.
   4. For cleaning operating room supply air duct and kitchen hood exhaust duct, locate access doors at 6 m (20 feet) intervals and at each change in duct direction.

B. Openings shall be as large as feasible in small ducts, 300 mm by 300 mm (12 inch by 12 inch) minimum where possible. Access sections in insulated ducts shall be double-wall, insulated. Transparent shatterproof covers are preferred for uninsulated ducts.
   1. For rectangular ducts: Refer to SMACNA HVAC Duct Construction Standards (Figure 2-12).
   2. For round and flat oval duct: Refer to SMACNA HVAC duct Construction Standards (Figure 2-11).

2.5 FLEXIBLE AIR DUCT

A. General: Factory fabricated, complying with NFPA 90A for connectors not passing through floors of buildings. Flexible ducts shall not penetrate any fire or smoke barrier which is required to have a fire resistance rating of one hour or more. Flexible duct length shall not exceed 1.5 m (5 feet). Provide insulated acoustical air duct connectors in supply air duct systems and elsewhere as shown.

B. Flexible ducts shall be listed by Underwriters Laboratories, Inc., complying with UL 181. Ducts larger than 200 mm (8 inches) in diameter shall be Class 1. Ducts 200 mm (8 inches) in diameter and smaller may be Class 1 or Class 2.

C. Insulated Flexible Air Duct: Factory made including mineral fiber insulation with maximum C factor of 0.25 at 24 degrees C (75 degrees F) mean temperature, encased with a low permeability moisture barrier outer jacket, having a puncture resistance of not less than 50 Beach Units. Acoustic insertion loss shall not be less than 3 dB per 300 mm (foot) of straight duct, at 500 Hz, based on 150 mm (6 inch) duct, of 750 m/min (2500 fpm).

D. Application Criteria:
   1. Temperature range: -18 to 93 degrees C (0 to 200 degrees F) internal.
   2. Maximum working velocity: 1200 m/min (4000 feet per minute).
   3. Minimum working pressure, inches of water gage: 2500 Pa (10 inches) positive, 500 Pa (2 inches) negative.

E. Duct Clamps: 100 percent nylon strap, 80 kg (175 pounds) minimum loop tensile strength manufactured for this purpose or stainless steel strap with cadmium plated worm gear tightening device. Apply clamps with sealant and as approved for UL 181, Class 1 installation.

2.6 FLEXIBLE DUCT CONNECTIONS

Where duct connections are made to fans, air terminal units, and air handling units, install a non-combustible flexible connection of 822 g (29 ounce) neoprene coated fiberglass fabric approximately 150 mm (6 inches) wide. For connections exposed to sun and weather provide hypalon coating in lieu of neoprene. Burning characteristics shall conform to NFPA 90A. Securely fasten flexible connections to round ducts with stainless steel or zinc-coated iron draw bands with worm gear fastener. For rectangular connections, crimp fabric to sheet metal and fasten sheet metal to ducts by screws 50 mm (2 inches) on center. Fabric shall not be stressed other than by air pressure. Allow at least 25 mm (one inch) slack to insure that no vibration is transmitted.

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2.7 SEISMIC RESTRAINT FOR DUCTWORK

Refer to Section 13 05 41, SEISMIC RESTRAINT REQUIREMENTS FOR NON-STRUCTURAL COMPONENTS.

PART 3 - EXECUTION

3.1 INSTALLATION

A. Comply with provisions of Section 23 05 11, COMMON WORK RESULTS FOR HVAC and STEAM GENERATION, particularly regarding coordination with other trades and work in existing buildings.

B. Fabricate and install ductwork and accessories in accordance with referenced SMACNA Standards:

1. Drawings show the general layout of ductwork and accessories but do not show all required fittings and offsets that may be necessary to connect ducts to equipment, boxes, diffusers, grilles, etc., and to coordinate with other trades. Fabricate ductwork based on field measurements. Provide all necessary fittings and offsets at no additional cost to the government. Coordinate with other trades for space available and relative location of HVAC equipment and accessories on ceiling grid. Duct sizes on the drawings are inside dimensions which shall be altered by Contractor to other dimensions with the same air handling characteristics where necessary to avoid interferences and clearance difficulties.
2. Provide duct transitions, offsets and connections to dampers, coils, and other equipment in accordance with SMACNA Standards, Section II. Provide streamliner, when an obstruction cannot be avoided and must be taken in by a duct. Repair galvanized areas with galvanizing repair compound.
3. Provide bolted construction and tie-rod reinforcement in accordance with SMACNA Standards.
4. Construct casings, eliminators, and pipe penetrations in accordance with SMACNA Standards, Chapter 6. Design casing access doors to swing against air pressure so that pressure helps to maintain a tight seal.

C. Install duct hangers and supports in accordance with SMACNA Standards, Chapter 4.

D. Install fire dampers, smoke dampers and combination fire/smoke dampers in accordance with the manufacturer's instructions to conform to the installation used for the rating test. Install fire dampers, smoke dampers and combination fire/smoke dampers at locations indicated and where ducts penetrate fire rated and/or smoke rated walls, shafts and where required by the Resident Engineer. Install with required perimeter mounting angles, sleeves, breakaway duct connections, corrosion resistant springs, bearings, bushings and hinges per UL and NFPA. Demonstrate re-setting of fire dampers and operation of smoke dampers to the Resident Engineer.

E. Seal openings around duct penetrations of floors and fire rated partitions with fire stop material as required by NFPA 90A.

F. Flexible duct installation: Refer to SMACNA Standards, Chapter 3. Ducts shall be continuous, single pieces not over 1.5 m (5 feet) long (NFPA 90A), as straight and short as feasible, adequately supported. Centerline radius of bends shall be not less than two duct diameters.

Make connections with clamps as recommended by SMACNA. Clamp per SMACNA with one clamp on the core duct and one on the insulation jacket. Flexible ducts shall not penetrate floors, or any chase or partition designated as a fire or smoke barrier, including corridor partitions fire rated one hour or two hour. Support ducts SMACNA Standards.

G. Where diffusers, registers and grilles cannot be installed to avoid seeing inside the duct, paint the inside of the duct with flat black paint to reduce visibility.

H. Control Damper Installation:

1. Provide necessary blank-off plates required to install dampers that are smaller than duct size. Provide necessary transitions required to install dampers larger than duct size.
2. Assemble multiple sections dampers with required interconnecting linkage and extend required number of shafts through duct for external mounting of damper motors.
3. Provide necessary sheet metal baffle plates to eliminate stratification and provide air volumes specified. Locate baffles by experimentation, and affix and seal permanently in place, only after stratification problem has been eliminated.
4. Install all damper control/adjustment devices on stand-offs to allow complete coverage of insulation.

I. Air Flow Measuring Devices (AFMD): Install units with minimum straight run distances, upstream and downstream as recommended by the manufacturer.

J. Low Pressure Duct Liner: Install in accordance with SMACNA, Duct Liner Application Standard.

K. Protection and Cleaning: Adequately protect equipment and materials against physical damage. Place equipment in first class operating condition, or return to source of supply for repair or replacement, as determined by Resident Engineer. Protect equipment and ducts during construction against entry of foreign matter to the inside and clean both inside and outside before operation and painting. When new ducts are connected to existing ductwork, clean both new and existing ductwork by mopping and vacuum cleaning inside and outside before operation.

3.2 DUCT LEAKAGE TESTS AND REPAIR

A. Ductwork leakage testing shall be performed by the Testing and Balancing Contractor directly contracted by the General Contractor and independent of the Sheet Metal Contractor.

B. Ductwork leakage testing shall be performed for the entire air distribution system. C. Test procedure, apparatus and report shall conform to SMACNA Leakage Test manual. The maximum leakage rate allowed is 4 percent of the design air flow rate.

D. All ductwork shall be leak tested first before enclosed in a shaft or covered in other inaccessible areas.

E. All tests shall be performed in the presence of the Resident Engineer and the Test and Balance agency. The Test and Balance agency shall measure and record duct leakage and report to the Resident Engineer and identify leakage source with excessive leakage.

F. If any portion of the duct system tested fails to meet the permissible leakage level, the Contractor shall rectify sealing of ductwork to bring it into compliance and shall retest it until acceptable leakage is demonstrated to the Resident Engineer.

G. All tests and necessary repairs shall be completed prior to insulation or concealment of ductwork.

H. Make sure all openings used for testing flow and temperatures by TAB Contractor are sealed properly.

3.3 TESTING, ADJUSTING AND BALANCING (TAB)

Refer to Section 23 05 93, TESTING, ADJUSTING, and BALANCING FOR HVAC.

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