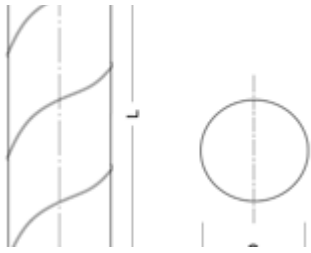
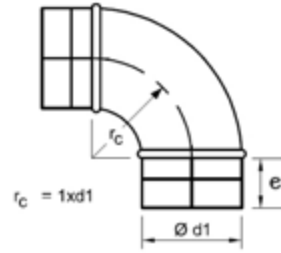


# Tolerance, Gauge, & e-dimensions



Tolerance for spiral duct



Tolerance for fittings

∅D (inch)	∅D Tolerance (inch) min. - max.	t* (gauge)	t** (gauge)
3	2.950 - 2.969	28	28
4	3.950 - 3.969	28	28
5	4.950 - 4.969	28	28
6	5.950 - 5.969	28	28
7	6.950 - 6.972	28	28
8	7.950 - 7.972	28	28
9	8.950 - 8.972	28	28
10	9.950 - 9.976	28	28
11	10.950 - 10.976	28	28
12	11.950 - 11.976	28	28
13***	12.950 - 12.976	28	28
14	13.950 - 13.976	28	28
15***	14.936 - 14.969	26	26
16	15.936 - 15.969	26	26
17***	16.936 - 16.969	26	26
18	17.936 - 17.969	26	26
19***	18.936 - 18.967	26	26
20	19.936 - 19.972	26	26
22	21.936 - 21.972	26	26
24	23.936 - 23.976	26	26
26	25.936 - 25.976	24	24
28	27.934 - 27.976	24	24
30	29.924 - 29.969	24	24
32	31.924 - 31.976	24	24
34	33.924 - 33.976	24	24
36	35.924 - 35.988	24	24
38	37.912 - 37.976	24	24
40	39.912 - 39.976	24	24
42	41.912 - 41.976	24	24
44	43.912 - 43.988	22	22
46	45.912 - 45.998	22	22
48	47.912 - 47.988	22	22
50	49.912 - 49.988	22	22
52	51.913 - 51.992	22	22
54	53.913 - 53.992	22	22
56	55.909 - 55.992	22	22
58	57.909 - 57.992	22	22
60	59.909 - 59.992	22	22

∅d <sub>1</sub> (inch)	∅d <sub>1</sub> Tolerance (inch) min. - max.	t* (gauge)	Pressed t** (gauge)	Fabricated t** (gauge)	e (inch)
3	2.902 - 2.917	28	24	-----	1.625
4	3.902 - 3.917	28	24	-----	1.625
5	4.902 - 4.917	28	24	-----	1.625
6	5.898 - 5.917	28	24	-----	1.625
7	6.894 - 6.913	28	24	-----	1.625
8	7.890 - 7.913	28	24	-----	1.625
9	8.886 - 8.909	28	24	-----	1.625
10	9.882 - 9.909	28	24	-----	2.375
11	10.882 - 10.909	28	24	-----	2.375
12	11.882 - 11.909	28	24	-----	2.375
13***	12.878 - 12.909	28	-----	-----	2.375
14	13.878 - 13.909	28	-----	24	2.375
15***	14.862 - 14.898	26	-----	-----	3.125
16	15.862 - 15.898	26	-----	24	3.125
17***	16.862 - 16.898	26	-----	-----	3.125
18	17.862 - 17.898	26	-----	24	3.125
19***	18.862 - 18.898	24	-----	-----	3.125
20	19.858 - 19.898	24	-----	24	3.125
22	21.858 - 21.898	24	-----	24	3.125
24	23.854 - 23.898	24	-----	24	3.125
26	25.854 - 25.898	22	-----	22	3.125
28	27.846 - 27.894	22	-----	22	4.000
30	29.839 - 29.886	22	-----	22	4.000
32	31.835 - 31.886	22	-----	22	4.000
34	33.835 - 33.886	22	-----	22	4.000
36	35.831 - 35.886	22	-----	22	4.000
38	37.819 - 37.874	22	-----	20	4.000
40	39.819 - 39.874	22	-----	20	4.750
42	41.819 - 41.874	22	-----	20	4.750
44	43.815 - 43.874	20	-----	20	4.750
46	45.815 - 45.874	20	-----	20	4.750
48	47.815 - 47.874	20	-----	20	4.750
50	49.815 - 49.874	20	-----	20	4.750
52	51.811 - 51.874	20	-----	20	4.750
54	53.811 - 53.874	20	-----	20	4.750
56	55.799 - 57.862	20	-----	20	4.750
58	57.799 - 57.862	20	-----	20	4.750
60	59.795 - 59.862	20	-----	20	4.750

\* In accordance with the latest SMACNA HVAC Duct Construction Standards for +10" wg

\*\* Gustafson Manufacturing Standard

\*\*\* " — " = Not currently available

# Tolerances for Spiral

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## Material Specifications

Gustafson components are made of galvanized sheet ASTM A653/A924.

Duct and fittings are also available in the following materials:

- G60
  - G90
  - 304 stainless steel ASTM A240\*
  - 316 stainless steel ASTM A240\*
  - Coated
  - Agion
  - Antimicrobial
  - Aluminum\*
- (\* ) not available in pressed construction

## Length Tolerances

Length -L, H, e, D, d	Tolerances
inch	inch
1 - 10	$\pm \frac{3}{8}$
12 - 16	$\pm \frac{5}{8}$
18 - 28	$\pm \frac{3}{4}$
30 - 50	$\pm 1$
52 - 60	$\pm 1 \frac{1}{4}$

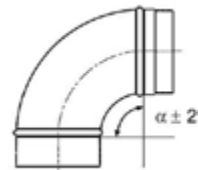
## Weight Tolerance

$\pm 10\%$

## Thickness Tolerance

$\pm 10\%$

## Angular Tolerance



## Surface/Finish

Die stamped products of G90 construction.

Stainless steel 316L fittings provided with a 2B mill finish.

Coated products have a minimum surface hardness of 2H when tested per ASTM D33-63-92A with an average thickness of 4 mils inside and out. Epoxy is used on duct and fittings or a PVC can be applied on duct.

# Fitting Slip Dimension

Our products are designed with a male/female slip connections. For gasket (G-3) connections, refer to the e-dimension listed in the chart on page 11. If flanges are utilized, add 3" plus flange thickness to the published L (length) dimension as shown elsewhere in this catalog as depicted in the diagram to the right.

Factory-applied Flange	
Collar Length	Make-up Length
3"	3" + flange thickness

