



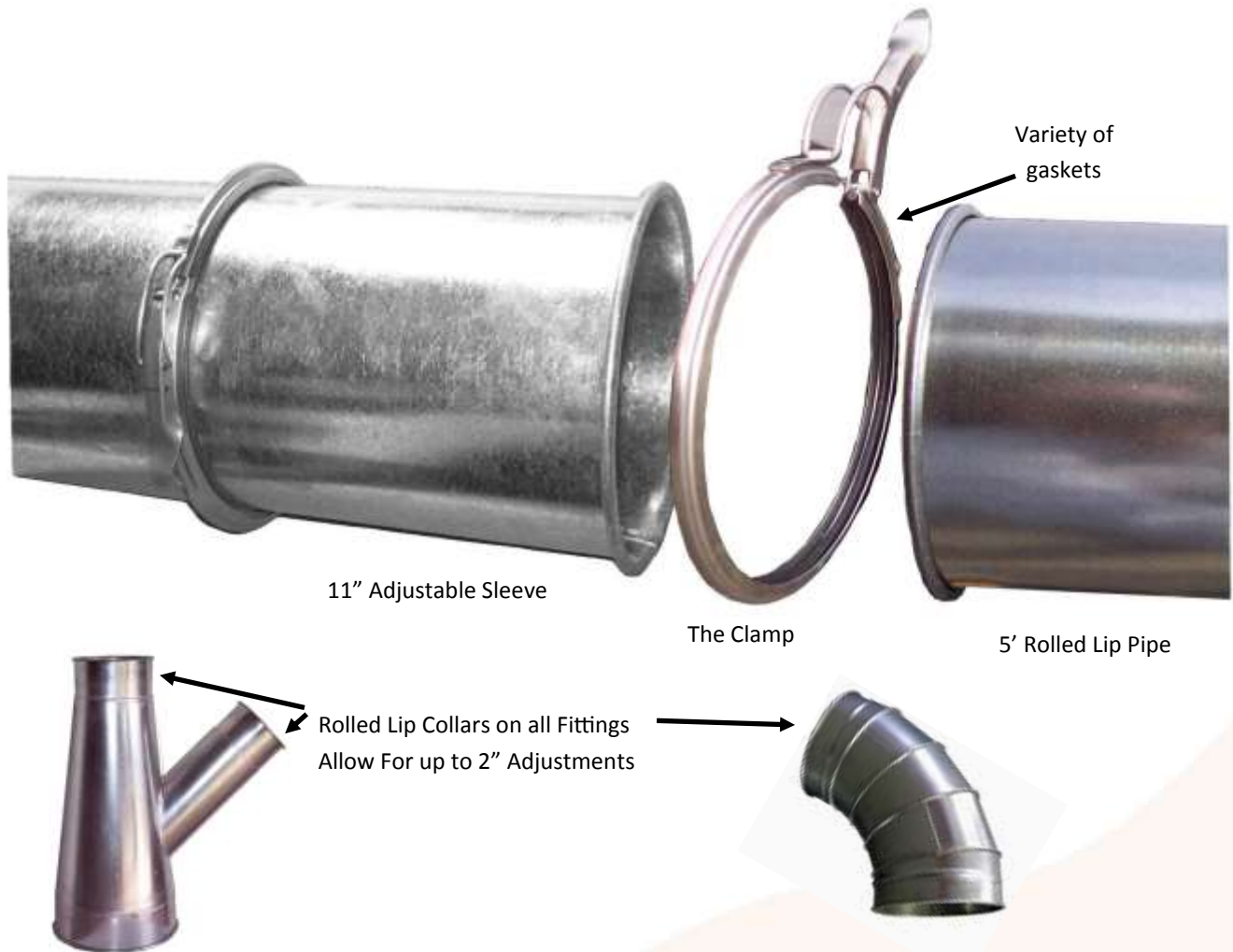
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Quality—Delivery—Service—Design—Price

Clamp Together Duct System

The Quick Connect, Quick Assembly, No-Weld Ductwork

At US Duct we know more about Clamp Together Duct than anyone. (see our profiles) Available in sizes 3" - 24", in galvanized and SS, in standard and heavy (up to 10) gauge. We provide ALL components and special fittings. The system is infinitely adjustable with adjustment capability built into EVERY fitting. While Clamp Together Duct is often the fastest, easiest and cheapest way to address dust/mist collection, it is often best used in conjunction with other connection methods as dictated by application or duct size.

NOTE: Galvanized material ASTM A527 with G-90 rating. 304 SS Meets ASTM A240 requirements.





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Clamp Together Duct System—The Clamp

Stainless Steel Duct Clamps

The stainless steel Duct Clamp is designed for repeatable and long term service. Like all of our products, these duct clamps are manufactured here in the states (with the exception of some very minor components not available in the US). The over center latch securely draws the special contoured band around the rolled lips of the components and seals them tightly.

The clamp securely holds the duct but is ready for easy release for the next move or modification. This is all done WITHOUT removing screws, tape or bolts. Like everything at US Duct- simple, easy and well-conceived

Dia.	Base #
3"	CL03
4"	CL04
5"	CL05
6"	CL06
7"	CL07
8"	CL08
9"	CL09
10"	CL10
11"	CL11
12"	CL12
13"	CL13
14"	CL14
15"	CL15
16"	CL16
17"	CL17
18"	CL18
19"	CL19
20"	CL20
22"	CL22
24"	CL24





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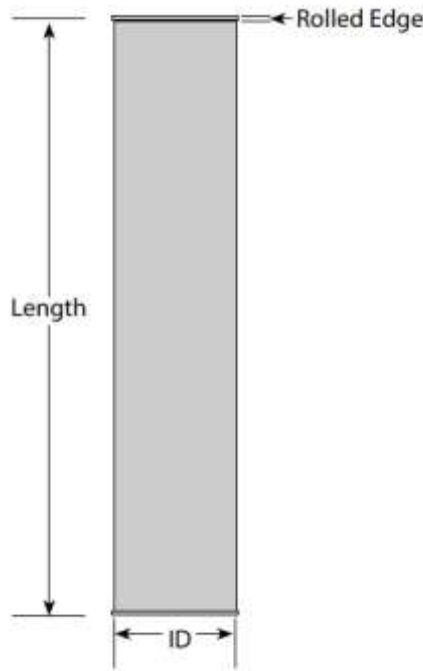
Clamp Together Duct System, cont.

The Rolled Lip pipe comes in standard 5' lengths. The seams are lock-seam connected along the length. The Rolled Lip and Clamp - Clamp it or rivet or weld it or bolt it together? It is a simple answer- if you want to save time and money. Clamp Together Duct is 70% faster. Don't believe us- call for a sample.

Anyone can do it- literally - In fact both self-installers and contractors love the product because it is so simple. US Duct will provide you with simple, easy to follow "A" to "B" drawings of your specific system. Large or small systems are literally quick and easy. Watch the whiteboard video: <https://youtu.be/Lx6Ghodh68Y>

5' Sections of Rolled-Lip Pipe

Dia.	Base #
3"	P03C
4"	P04C
5"	P05C
6"	P06C
7"	P07C
8"	P08C
9"	P09C
10"	P10C
11"	P11C
12"	P12C
13"	P13C
14"	P14C
15"	P15C
16"	P16C
17"	P17C
18"	P18C
19"	P19C
20"	P20C
22"	P22C
24"	P24C



Dia.	Base #
3"	AS03C
4"	AS04C
5"	AS05C
6"	AS06C
7"	AS07C
8"	AS08C
9"	AS09C
10"	AS10C
11"	AS11C
12"	AS12C
13"	AS13C
14"	AS14C
15"	AS15C
16"	AS16C
17"	AS17C
18"	AS18C
19"	AS19C
20"	AS20C
22"	AS22C
24"	AS24C



11" Adjustable Sleeve



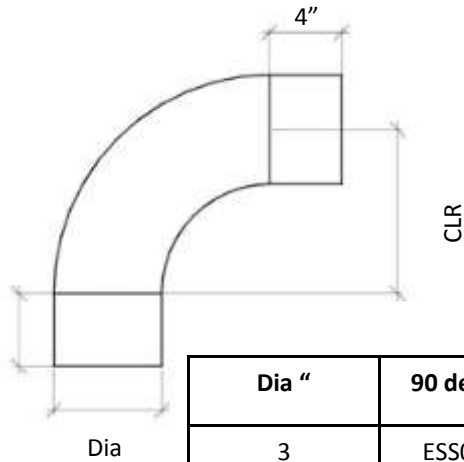
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Elbows— Stitch Welded

The name basically tells it all. These are elbows formed by stitch welding halves that have been stamped out using mechanical presses and forming dies. The stitch weld is virtually a continuous weld although a visual examination would lead one to think that the weld was an intermittent weld. HOWEVER, there is another weld on the reverse side welding the 'skipped space' from the other side. The result is a very tight elbow.

However, the mechanical stamping process places limits on the gauge that can be used limiting them to a maximum of 22 gauge. The result is that these elbows, while available in sizes 3",4",5",6",7",8",9",10" and 12" in 90,60,45 and 30 degrees, are good all around elbows for air or dust up to 8". Larger than that their application should be limited to light dust or air as the gauge is too light for heavy particle.

The stamping process also limits the elbow to fixed radii* of 1xD, 1.5xD, 2.5xD. .



Dia "	90 degree #	60 Degree #	45 Degree #	30 degree #	GA
3	ESS0390C	ESS0360C	ESS0345C	ESS0330C	22
4	ESS0490C	ESS0460C	ESS0445C	ESS0430C	22
5	ESS0590C	ESS0560C	ESS0545C	ESS0530C	22
6	ESS0690C	ESS0660C	ESS0645C	ESS0630C	22
7	ESS0790C	ESS0760C	ESS0745C	ESS0730C	22
8	ESS0890C	ESS0860C	ESS0845C	ESS0830C	22
9	ESS0990C	ESS0960C	ESS0945C	ESS0930C	22
10	ESS1090C	ESS1060C	ESS1045C	ESS1030C	22
12	ESS1290C	ESS1260C	ESS1245C	ESS1230C	22



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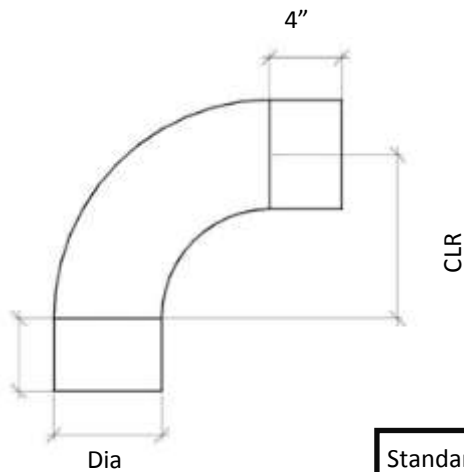
Elbows— Tubed

Tubed Elbow are constructed from non-seamed tubing that is mechanically bent. The elbows are available in 90, 60, 45 or 30 degrees, in 16,14 or 11 gauge and in galvanized or SS.

The ends can be fitted with a Rolled-Lipped collar or a angle ring flange.

US Duct tubed elbows are generally considered in applications for oil mist because they have no seam. Additionally they are widely used for paper trim for the same reason. A rolled-lip collar can be added for use with the Clamp Together Duct System.

They are the only SS option in sizes 3"-6".



Standard (1.5 x D) or Long Radius (2.5 x D)

Dia	GA
3"	16
4"	16
5"	14
6"	14
8"	14



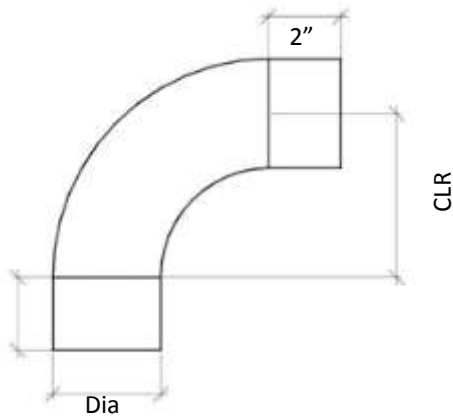
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Elbows— Segmented

Also known as 'Gored', 'Gored Segmented' elbows. Essentially the name says it all. These are segments that are then joined together by welding or mechanically. The mechanical method incorporates a machine that forms the ends of the segments (gores), so that one segment fits into the other and then mechanically locks them together. Because the metal is being formed, 18 gauge is the heaviest metal for this mechanical locking method. Heavier gauge metal require that the segments be welded.

Because the segment geometry controls the final geometry, these elbows are available in any degree and any radius*.

The ends of the elbow can be fitted with flanges or rolled lips or left raw for welding.



Dia "	90 degree #	60 Degree #	45 Degree #	30 Degree #	GA
8	EGS0890C	EGS0860C	EGS0845C	EGS0830C	20
9	EGS0990C	EGS0960C	EGS0945C	EGS0930C	20
10	EGS1090C	EGS1060C	EGS1045C	EGS1030C	20
11	EGS1190C	EGS1160C	EGS1145C	EGS1130C	18
12	EGS1290C	EGS1260C	EGS1245C	EGS1230C	18
13	EGS1390C	EGS1360C	EGS1345C	EGS1330C	18
14	EGS1490C	EGS1460C	EGS1445C	EGS1430C	18
15	EGS1590C	EGS1560C	EGS1545C	EGS1530C	18
16	EGS1690C	EGS1660C	EGS1645C	EGS1630C	18
17	EGS1790C	EGS1760C	EGS1745C	EGS1730C	18
18	EGS1890C	EGS1860C	EGS1845C	EGS1830C	18
19	EGS1990C	EGS1960C	EGS1945C	EGS1930C	18
20	EGS2090C	EGS2060C	EGS2045C	EGS2030C	18
22	EGS2290C	EGS2260C	EGS2245C	EGS2230C	18
24	EGS2490C	EGS2460C	EGS2445C	EGS2430C	18



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Branches

Also known as Lateral, 'Pant', T on taper and/or Y-branches, branches are still the same- a 'leg' is coming off the main line.

Typically, Single and Double Branches taper as the new line enters the main line. This is because the new line is bringing in more air. The exiting part of the branch (toward the fan) is therefore bigger to accommodate the increase in air. The new line typically enters at 30 or 45 degree so as to 'merge' into the air flow.

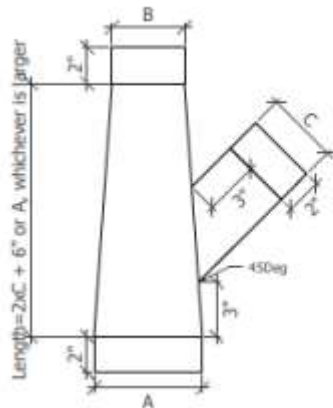
T's are called T's because the line enters the main line at 90 degree- forming a 'T'. T's are not the best air flow for negative systems as they increase static pressure to the point that the air can slide right by the side line and pull only from the straight end where the flow is 'easier'. T's however are often used in positive systems- where the air is being pushed.

Y's are exactly that- Y's with the two inlets diverging from the center line. Once again, the volume of the outlet is the sum of the two inlets. Typically the two inlets are the same size. If one needs to be smaller than the other, the branch is made with the two inlets equal to the largest requirement and then a reducer is used to reduce to the smaller requirement.

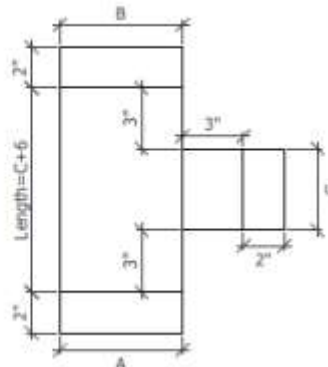
All US Duct branches are 18 gauge or heavier. This enables us to weld the branching part to the trunk and 'this' insures a very tight seal.



T-Branch



Single Branch





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Branches, cont.

Double Branches taper as the new line enters the main line. This is because the new line is bringing in more air. The exiting part of the branch (toward the fan) is therefore bigger to accommodate the increase in air. The new line typically enters at 30 or 45 degree so as to 'merge' into the air flow.

In cuts are used to create a branch on an existing trunk line. To create a new branch with an incut, a hole is cut in the pipe at the location of the branch. The incut is saddled over the hole and fastened with tech screws and caulked.

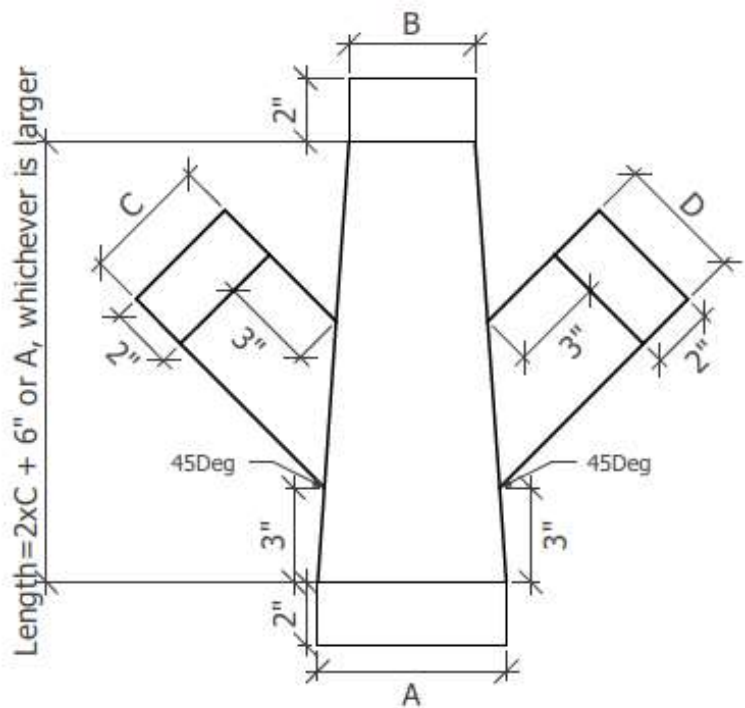
All US Duct branches are 18 gauge or heavier. This enables us to weld the branching part to the trunk and 'this' insures a very tight seal.



Double Branch



Incut





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Adapters

US Duct can adapt your duct to anything - a machine, a hose, or any outlet.

There are however some standard adapters.

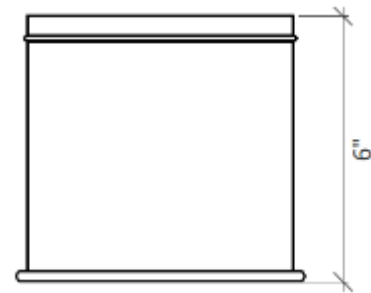
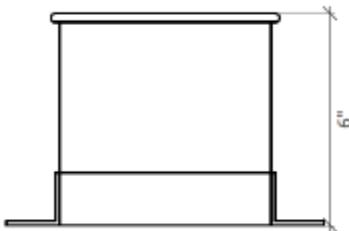
Hose Adapters adapt the duct to flex hose. An expanded bead is knurled onto the adapter. A worm clamp tightens the hose to the adapter and the expanded bead keeps it from sliding off.

Machine Adapters are made to adapt the duct to a machine. This adapter typically slides over the machine outlet and is affixed to the machine with tech screw or welding. Note about Oil/Mist Applications. - When connecting a flex hose to a machine where oil mist is being collected, there is a tendency for the fluid to seep by the hose clamp and spill onto the machine. To remedy this, US Duct offers an Oil/Mist Curb. The curb is a hose adapter with a curb directly under the hose. As the hose leaks (and it always does) the oil collects in the curb. The oil then 'leaks' back into the machine thru 'weep' holes that are drilled around the inside the curb where it is welded to the adapter. The unit then adapts to the machine.

Flanged Adapters are adapters that are flanged on one end and rolled lipped on the other.



Flange to Rolled-Lip Adapter



Hose to Rolled-Lip Adapter





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Gates

US Duct offers a full and varied line of gates for industrial duct work and custom applications. US Duct gates - commonly called cut-offs and blast gates - serve a variety of purposes. From added safety to decreasing operations costs, gates are an essential part of any dust collection or industrial duct system. Full gates, half gates, blast gates and auto gates – any type of gate you might need – are all available from US Duct.

Full gates - These are cast aluminum body units with galvanized or SS steel blades that smoothly move in and out of the air stream to fully cut off the air or partially close off the duct so as to balance the system and direct the air. A thumb screw allows the gate to be locked in any position. These gates come with a raw end that will slide into a cut piece of duct. But they can also be fitted with a rolled lip collar or a flange. Available in sizes to 24”.

Half gates –Like the Full Gates, these are cast aluminum body units with galvanized or SS steel blades that smoothly move in and out of the air stream to fully cut off the air or partially close off the duct so as to balance the system and direct the air. A thumb screw allows the gate to be locked in any position. However these are designed to fit ONTO the duct once a slit for the blade has



Full Gates



Half Gates

Dia	Full Gate #	Half gate #
3	CO03C	COH03
4	CO04C	COH04
5	CO05C	COH05
6	CO06C	COH06
7	CO07C	COH07
8	CO08C	COH08
9	CO09C	COH09
10	CO10C	COH10
11	CO11C	COH11
12	CO12C	COH12
13	CO13C	COH13
14	CO14C	COH14
15	CO15C	COH15
16	CO16C	COH16
17	CO17C	COH17
18	CO18C	COH18
19	CO19C	COH19
20	CO20C	COH20
22	CO22C	COH22
24	CO24C	COH24



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Gates, cont.

Blast gates – These fabricated units have fully welded housing and a sealed rod that moves the blade in and out of the air stream. They are essentially air tight to atmosphere- NOT across the blade. They are recommended for high moisture systems where the standard gate may leak.

Automatic gates- utilize an electric solenoid to control compressed air as it is delivered to open and close pneumatic cylinders. The solenoids are available in varied voltages (12/24V AC/DC, 120 and 220 line voltage). They can be wired to any electrical source and are typically wired so that the gates open when the machine or process in need of dust/fume collection.

Automatic Full Gates- US Duct offers two kind of Automatic full gates. One is constructed by fabricating an angle iron flange that attaches to the standard aluminum gate. The second incorporates a sleek galvanized framed gate.

Automatic Air Tight Gates- US Duct offers the sleek galvanized frame gate in an air tight version. Round UHMW seals are pushed together by a resilient rubber. The blade 'knives' between the seals as it closes. When open the seals press against one another to create a continuous seal.

Dia “	Blast Gate Base#	Auto Gate Base#
3	BG03C	ACO03C
4	BG04C	ACO04C
5	BG05C	ACO05C
6	BG06C	ACO06C
7	BG07C	ACO07C
8	BG08C	ACO08C
9	BG09C	ACO09C
10	BG10C	ACO10C
11	BG11C	ACO11C
12	BG12C	ACO12C
13	BG13C	ACO13C
14	BG14C	ACO14C
15	BG15C	ACO15C
16	BG16C	ACO16C
17	BG17C	ACO17C
18	BG18C	ACO18C
19	BG19C	ACO29C
20	BG20C	ACO20C
22	BG22C	ACO22C
24	BG24C	ACO24C



Automatic Gates



Manuel Blast gate