



PRO-FAB SHEET METAL

Professional Fabricators of Sheet Metal Products

We Make it Happen!



SINGLE WALL SPIRAL PIPE & FITTINGS

WWW.PROFABSM.COM



Welcome to Pro-Fab Sheet Metal

WE MAKE IT HAPPEN:

Pro-Fab Sheet Metal, a family-owned and operated company, is the leading fabricator of commercial and industrial sheet metal products in the Midwest. Our state-of-the-art facilities are equipped with the latest in manufacturing innovation which provides us with capabilities difficult to match. Pro-Fab Sheet Metal is a proud yellow label union shop with a productive team.

With two manufacturing plants in the Midwest, the Illinois Plant and Indiana Plant, Pro-Fab Sheet Metal has the capability to accommodate any size order with the utmost quality. With the latest technology equipment, Pro-Fab Sheet Metal continues to increase value and maintain a strong reputation.

QUALITY CONTROL & EXPERTISE:

We pride ourselves in our quality control system which gives us great ability to maintain cost-efficiency. We remain dedicated to apply excellence in fabrication; use durable and credible materials; and employ precise workmanship. We are confident that our continuity will embrace our commitment to excellence.

Being personally attentive and responsive to each customer is vital to our continuing success. We have the most skilled workforce in the industry. Our professionally trained and dedicated sales team will be happy to give you a prompt and accurate quotation on any size order within hours.

LOGISTICS:

Our network of plants assures our customers that shipping and availability of product remains uninterrupted often resulting in same day processing. Our fleet of trucks, along with our reliable scheduling system, assures you of on-time delivery and service that are cost-efficient and unbeatable.



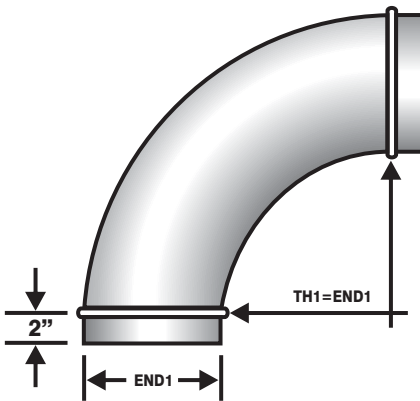
PRO-FAB SHEET METAL, INC.
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Catalog Index

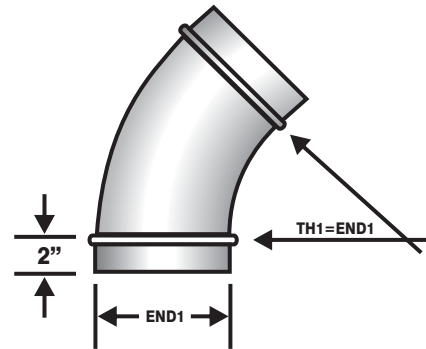
	Single Wall Round ELBOWS
	Single Wall Round ELBOWS
	Single Wall Round STRAIGHT TEES
	Single Wall Round CONICAL TEES
	Single Wall Round SHOE TEES
	Single Wall Round STRAIGHT LATERALS
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	Underground INSTALLATION
	Underground INSTALLATION
	Round Duct INSTALLATION
	Round Duct MANIFOLDS/ASSEMBLIES
	Notes



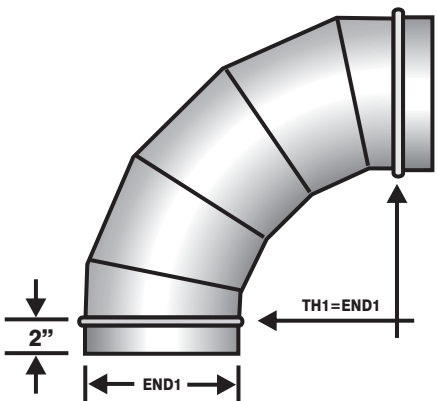
Single Wall Round ELBOWS



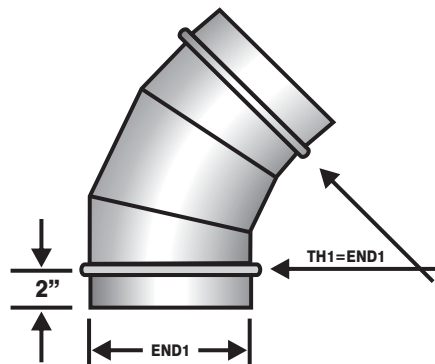
90° DIE STAMPED ELBOW 3" DIA. THRU 12"



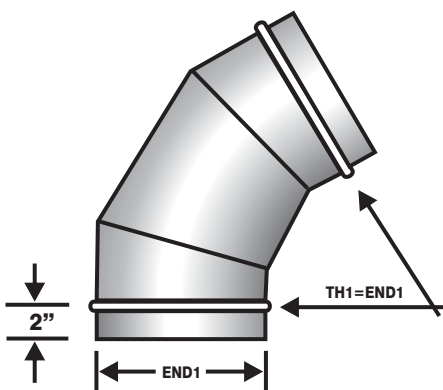
45° DIE STAMPED ELBOW 3" DIA. THRU 12"



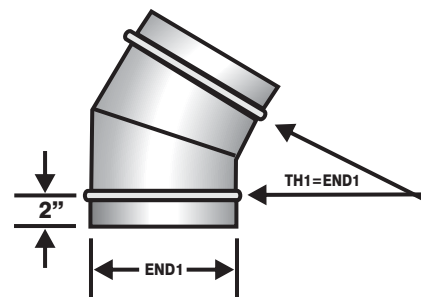
90° 5-PIECE GORE-LOCKED ELBOW



45° 3-PIECE GORE-LOCKED ELBOW



60° 3-PIECE GORE-LOCKED ELBOW



15° & 30° 2-PIECE GORE-LOCKED ELBOW

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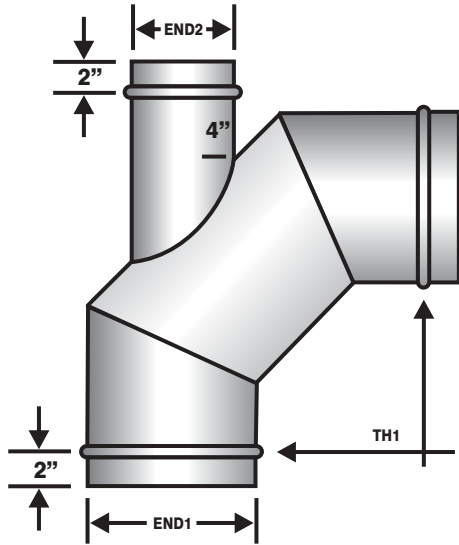
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info@profabsm.com

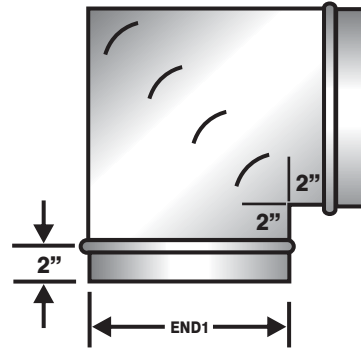
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Single Wall Round ELBOWS



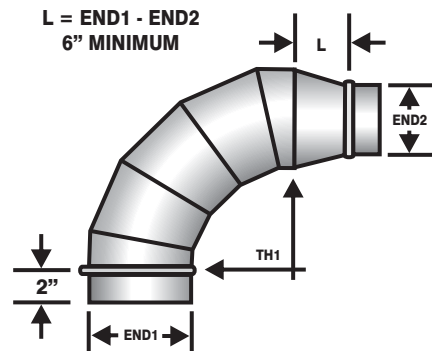
90° 3-PIECE ELBOW WITH STRAIGHT LATERAL



END1	NO. OF VANES
3-9	2
10-14	3
15-19	4
20-60	5
>60	MAX 12" SPACING

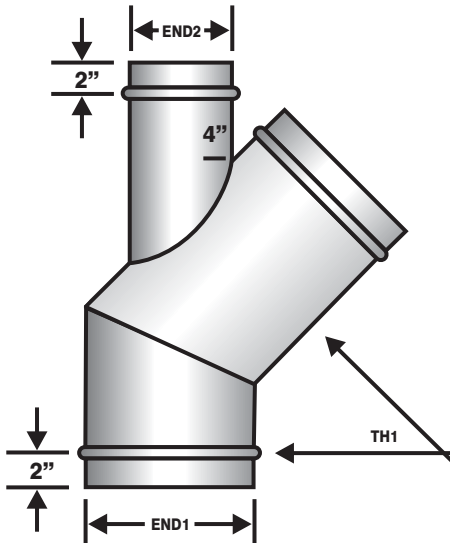
WITH OR WITHOUT VANES

90° 2-PIECE ELBOW

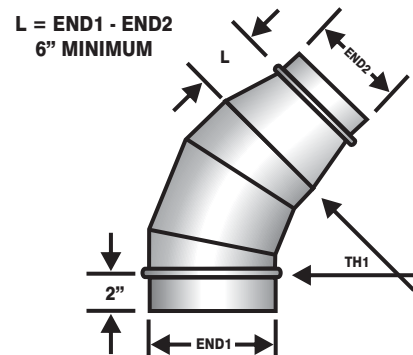


$L = \text{END1} - \text{END2}$
6" MINIMUM

90° 5-PIECE ELBOW WITH REDUCER



45° 2-PIECE ELBOW WITH STRAIGHT LATERAL



$L = \text{END1} - \text{END2}$
6" MINIMUM

45° 3-PIECE ELBOW WITH REDUCER

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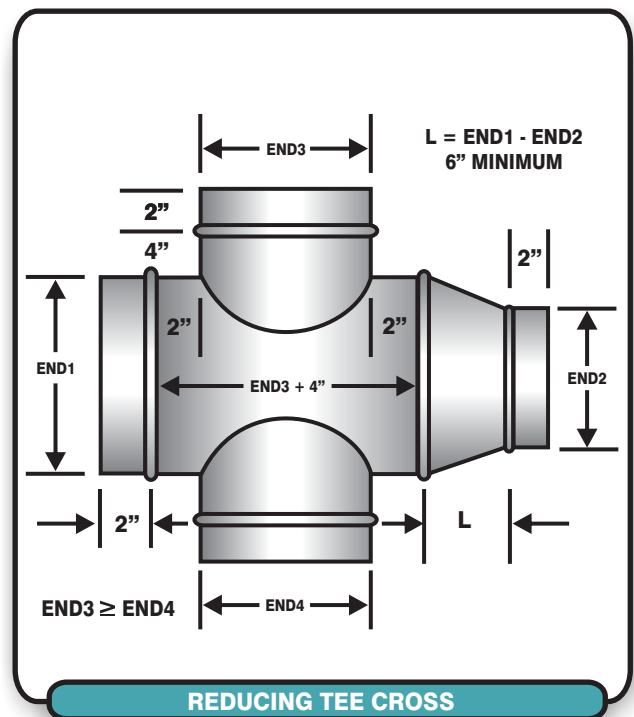
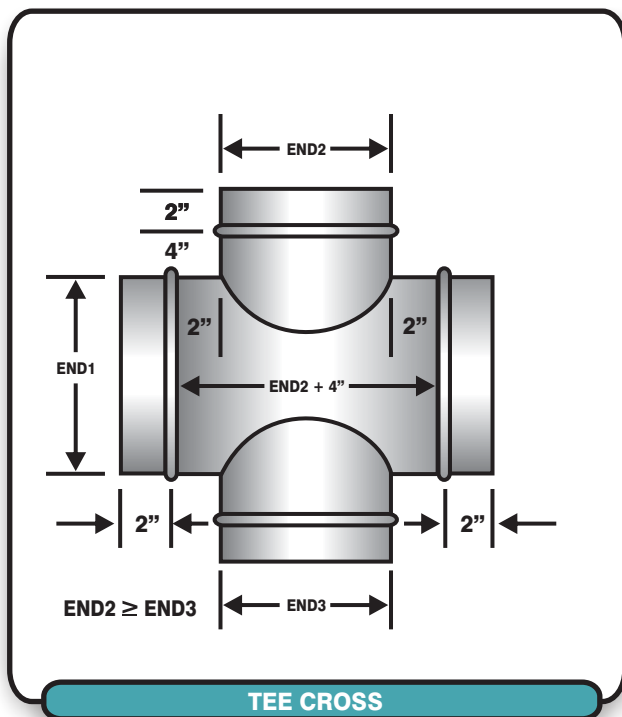
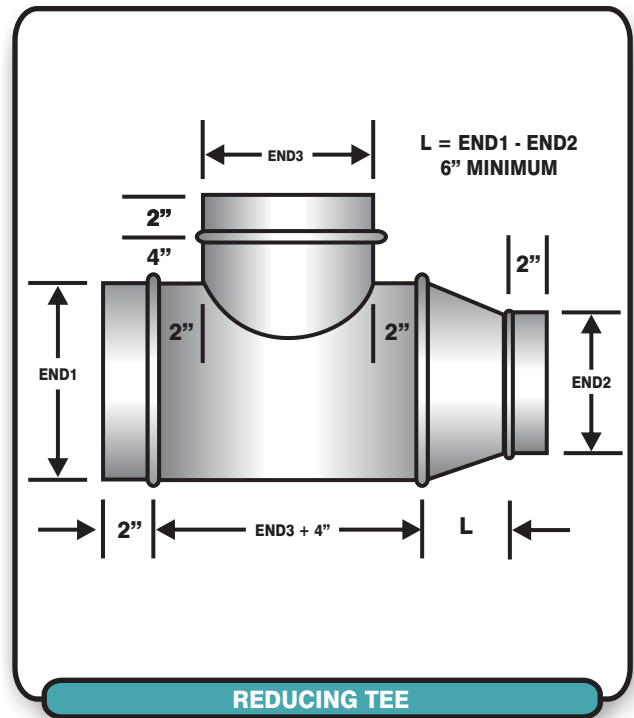
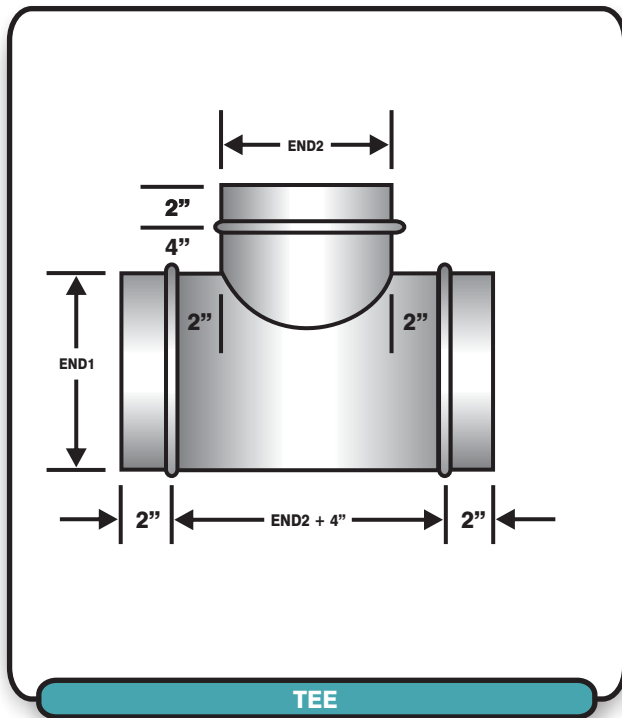
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Single Wall Round STRAIGHT TEES



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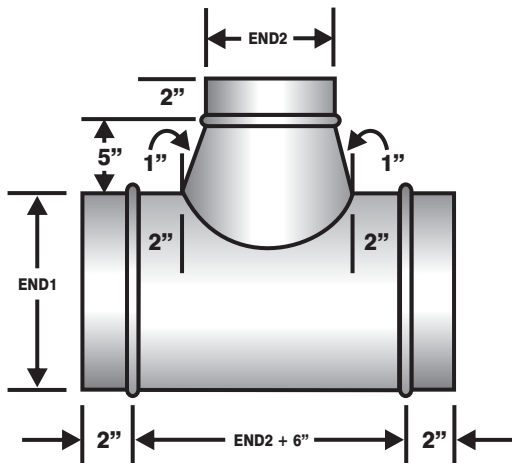
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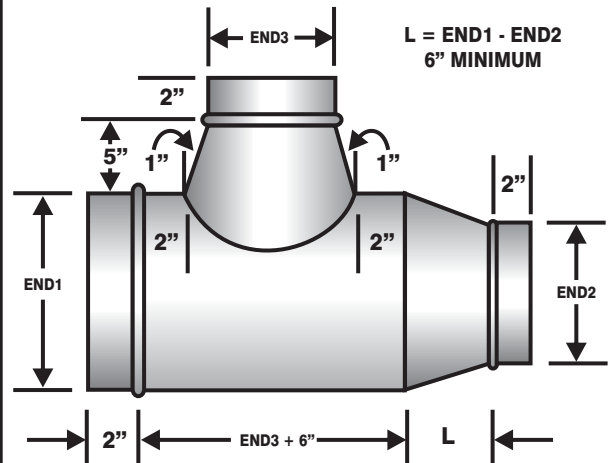
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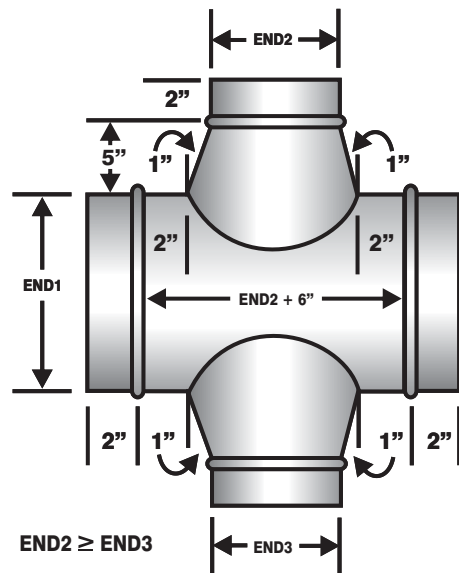
Single Wall Round CONICAL TEES



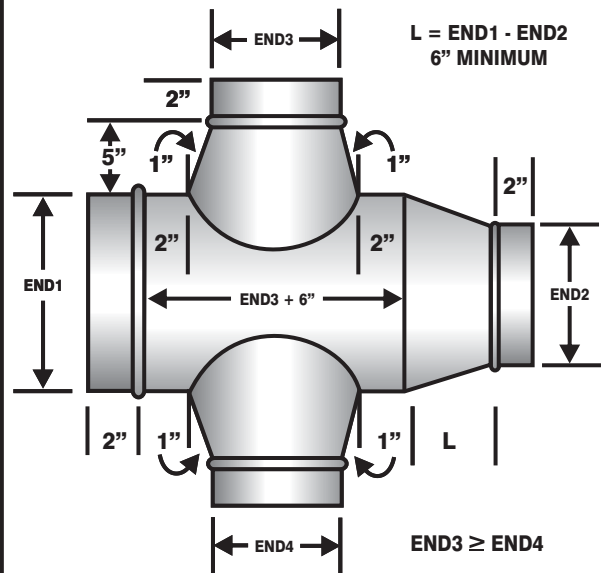
CONICAL TEE



REDUCING CONICAL TEE



CONICAL TEE CROSS



REDUCING CONICAL TEE CROSS

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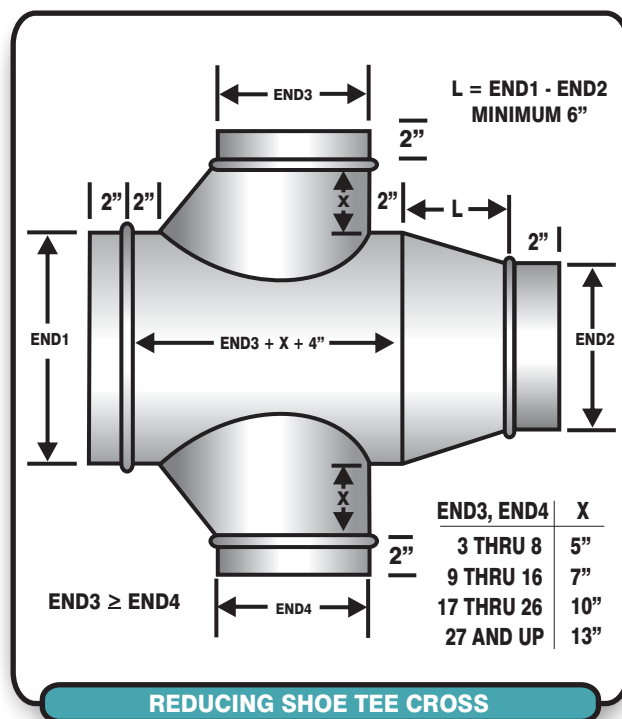
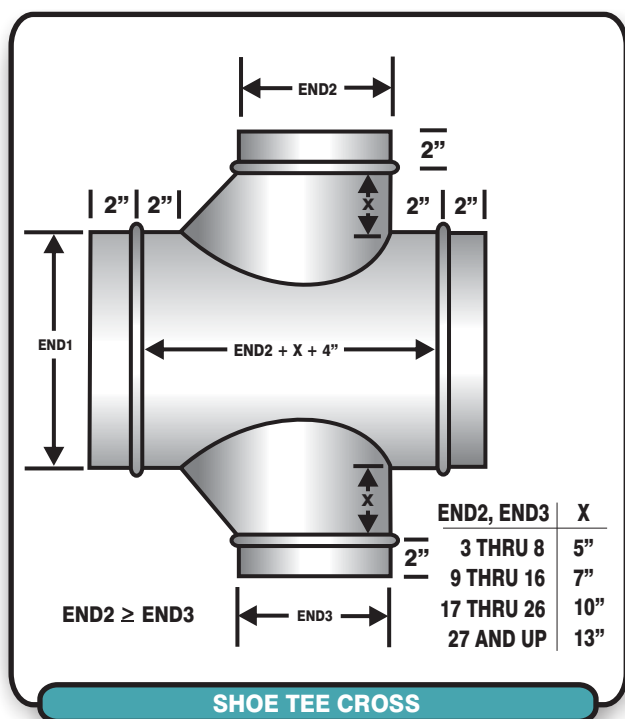
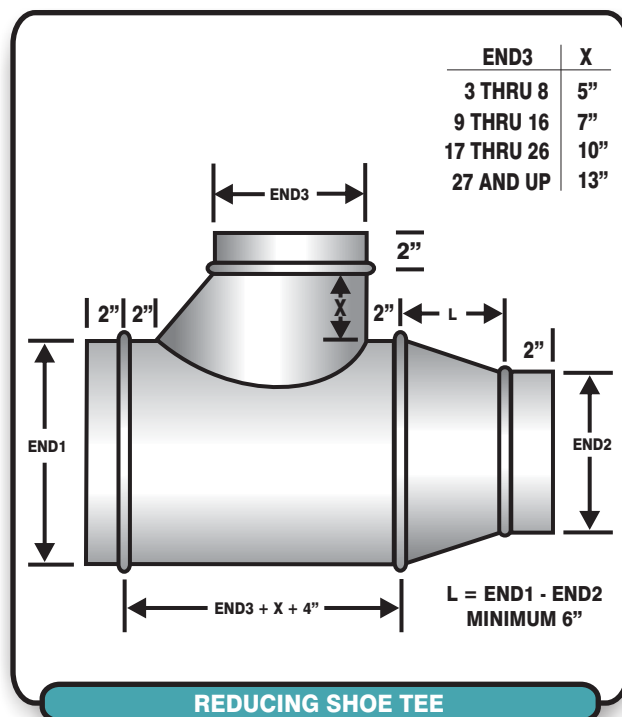
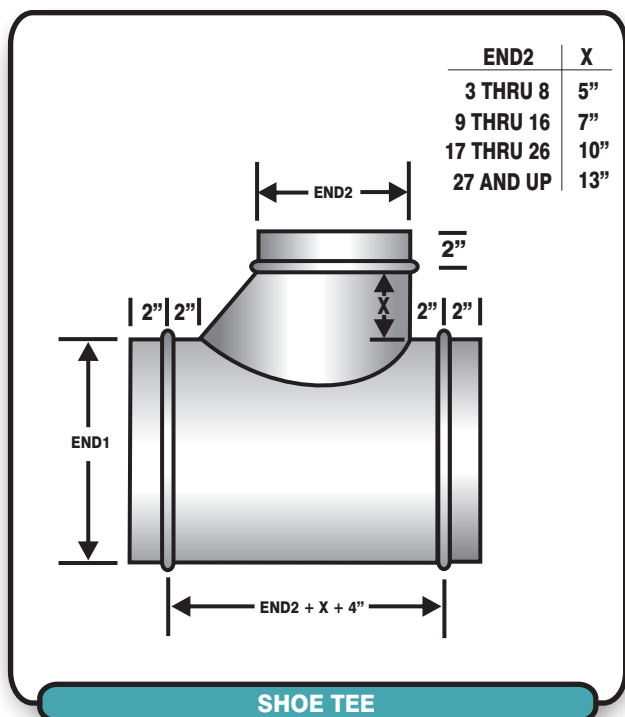
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Single Wall Round SHOE TEES



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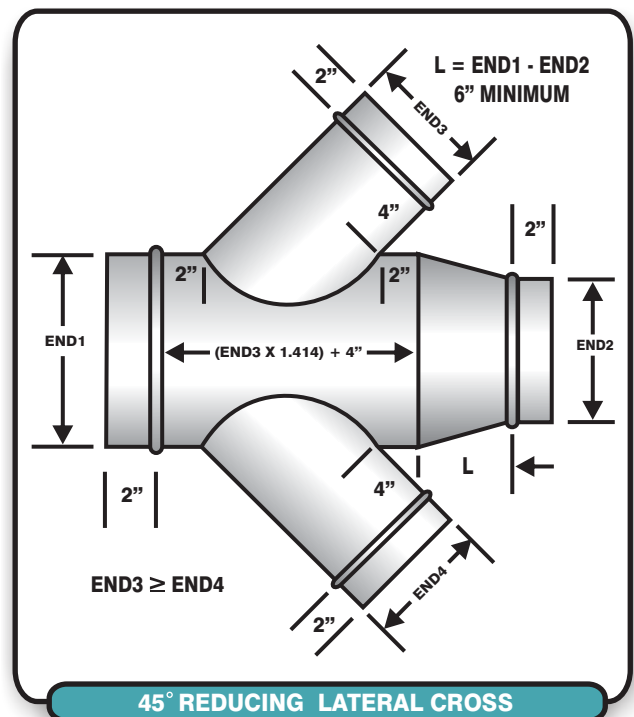
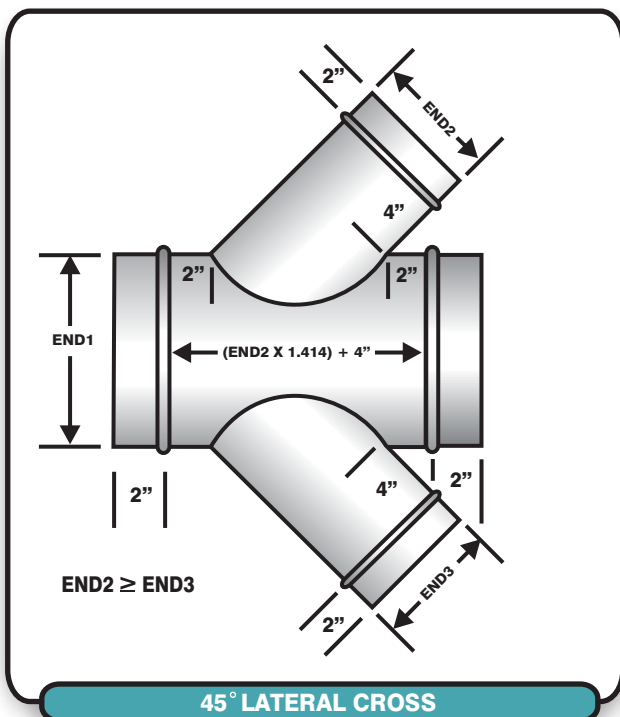
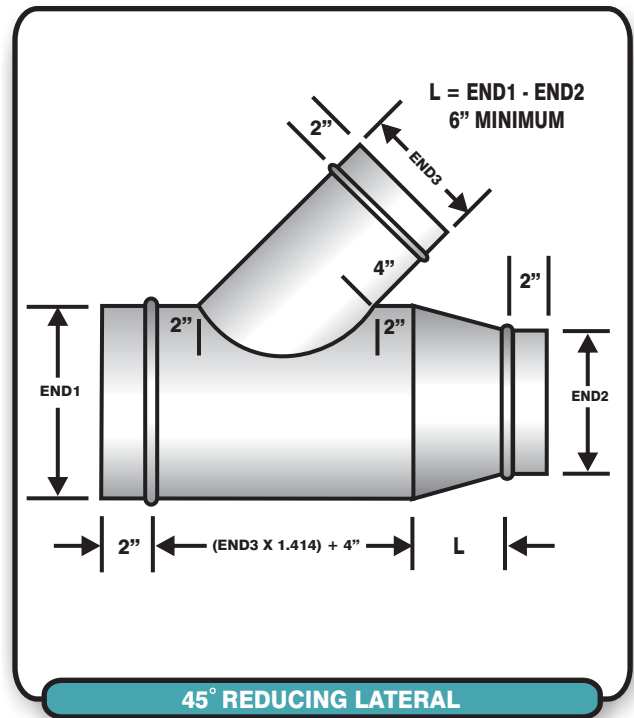
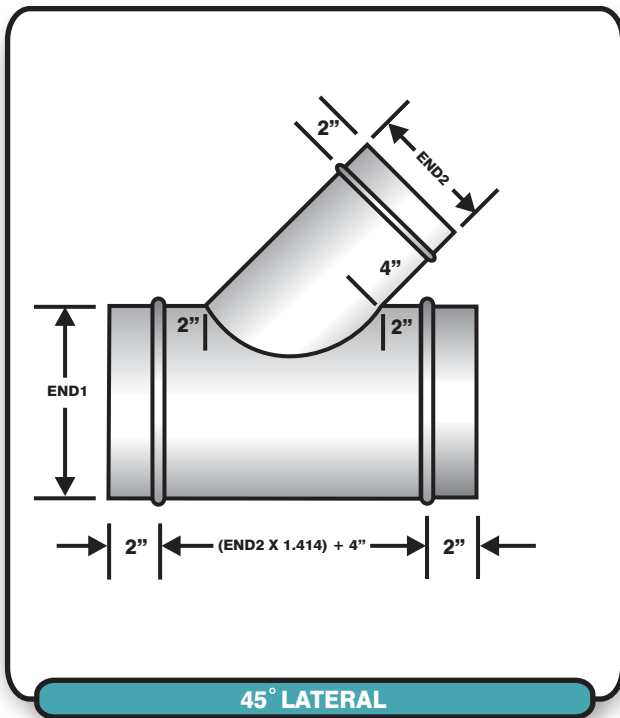
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Single Wall Round STRAIGHT LATERALS



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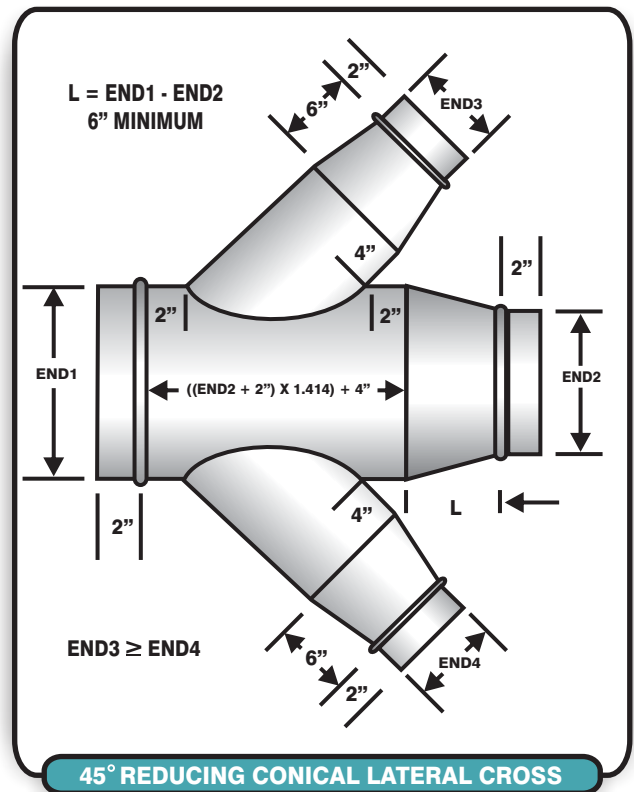
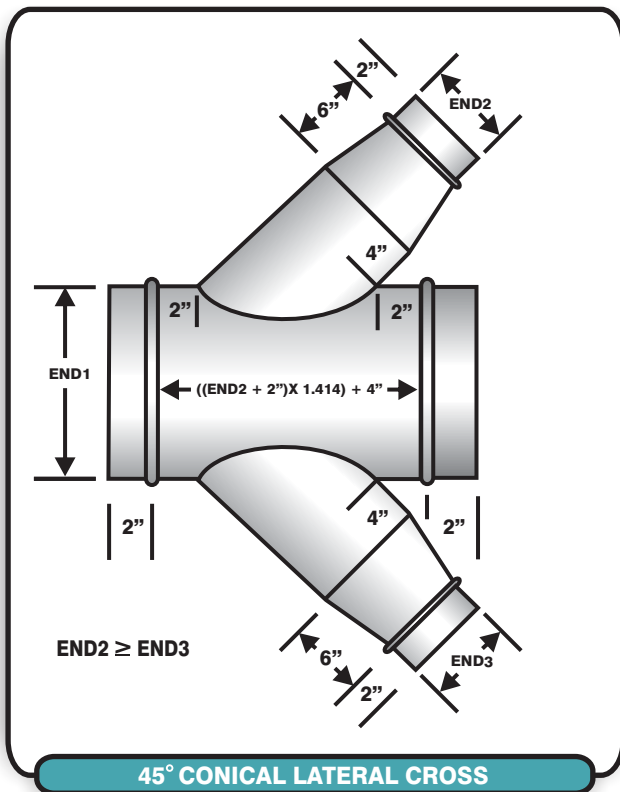
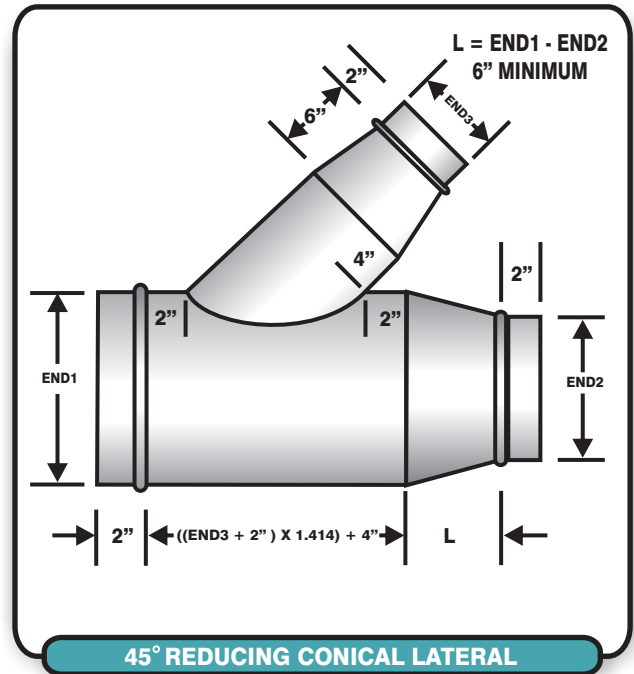
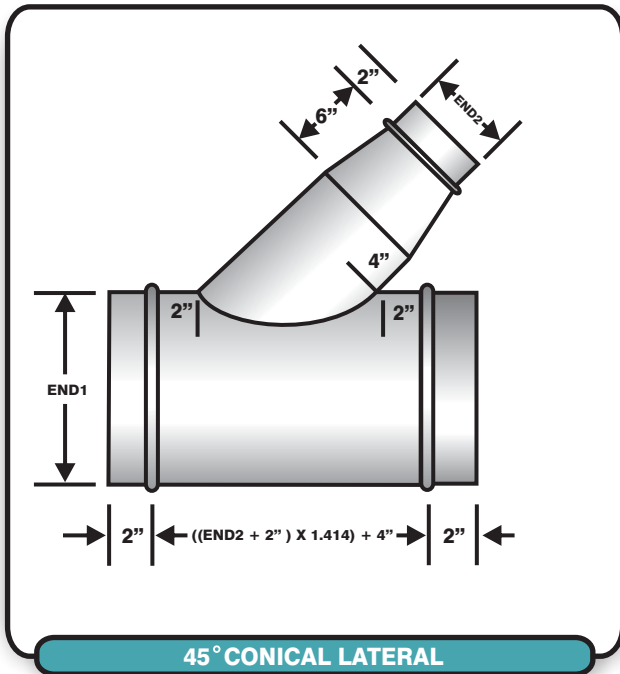
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Single Wall Round CONICAL LATERALS



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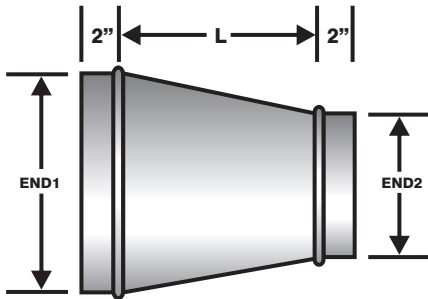
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Single Wall Round MISCELLANEOUS

$$L = \text{END1} - \text{END2}$$

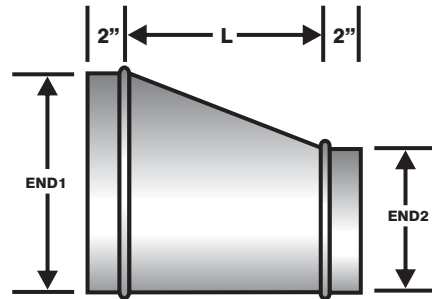
6" MINIMUM



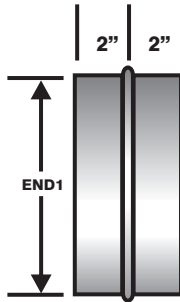
CONCENTRIC REDUCER

$$L = \text{END1} - \text{END2}$$

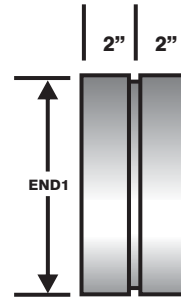
6" MINIMUM



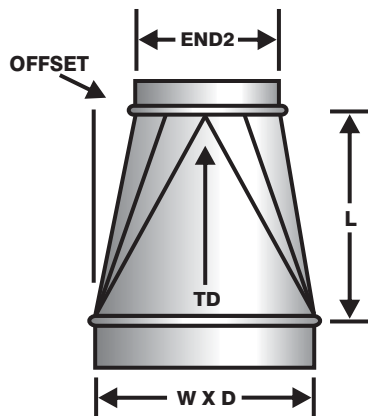
ECCENTRIC REDUCER



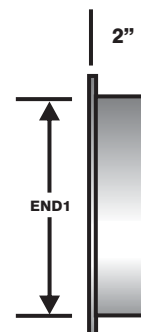
PIPE COUPLING



FITTING COUPLING



RECTANGLE TO ROUND



END CAP

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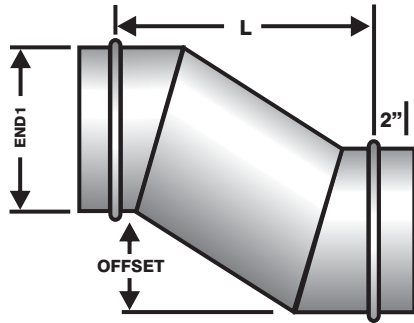
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INDIANA

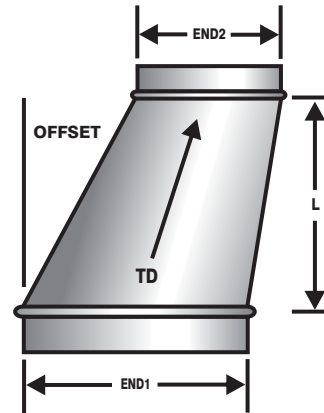
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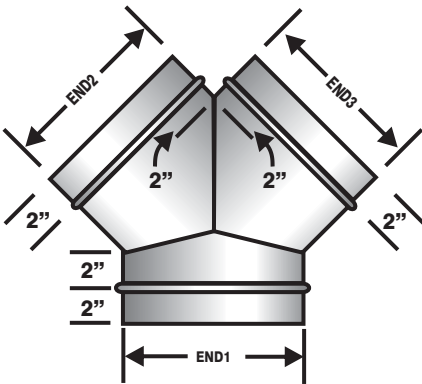
Single Wall Round MISCELLANEOUS



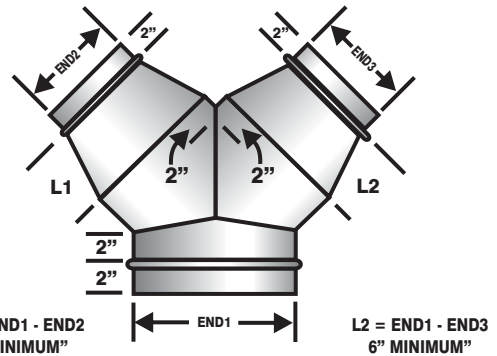
OFFSET



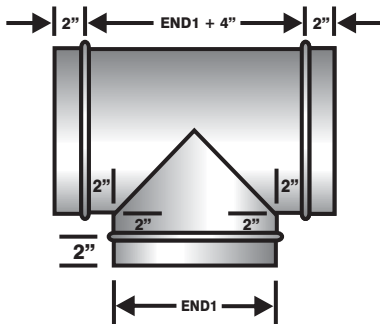
ROUND TO ROUND



Y BRANCH



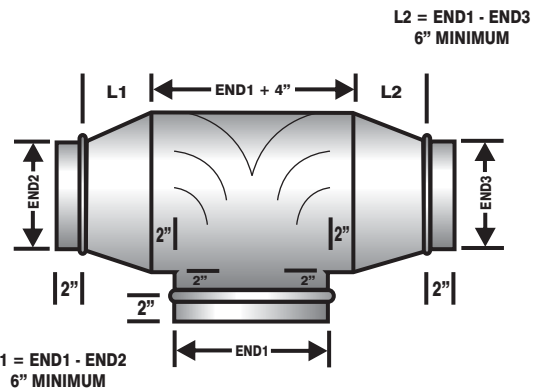
REDUCING Y BRANCH



WITH OR WITHOUT VANES

BULL HEAD TEE

END1	NO. OF VANES
3-7	1
8-10	3
10-60	5
>60	MAX 12" SPACING



WITH OR WITHOUT VANES

REDUCING BULL HEAD TEE

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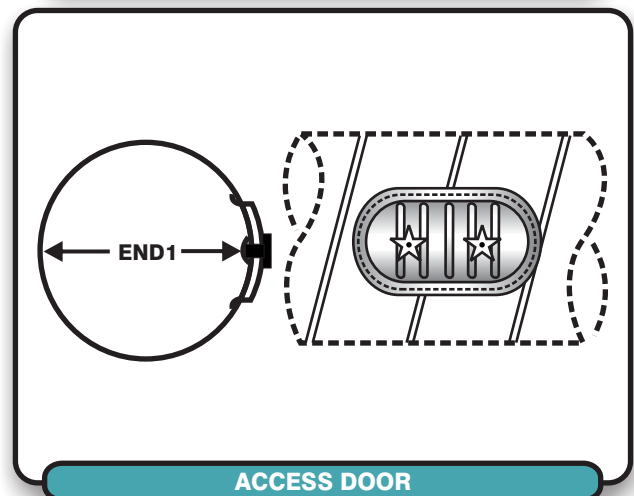
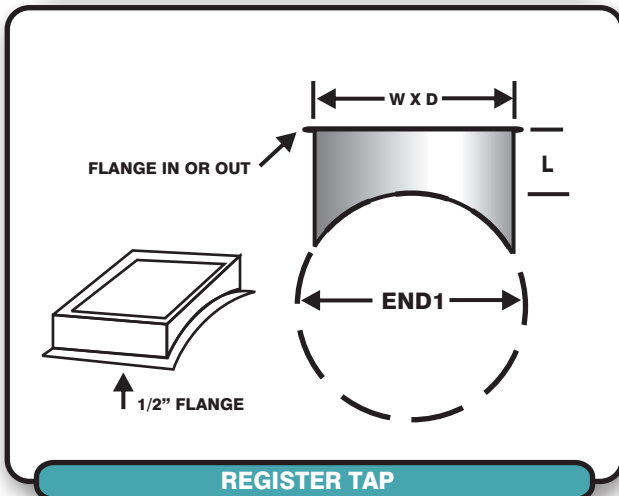
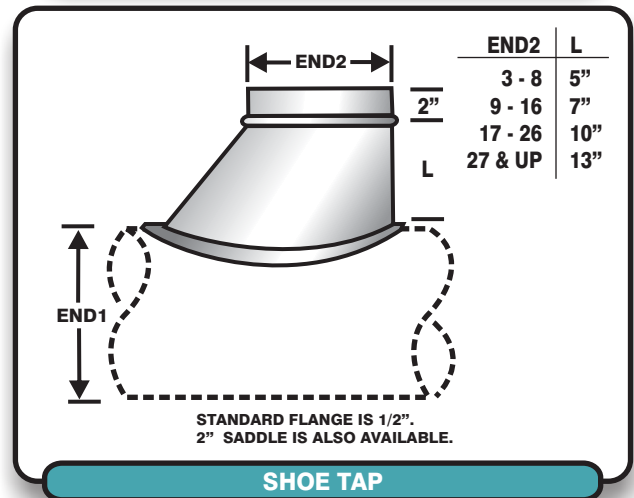
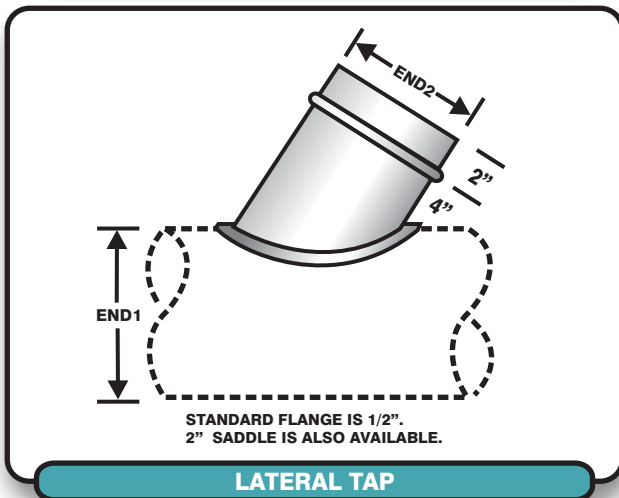
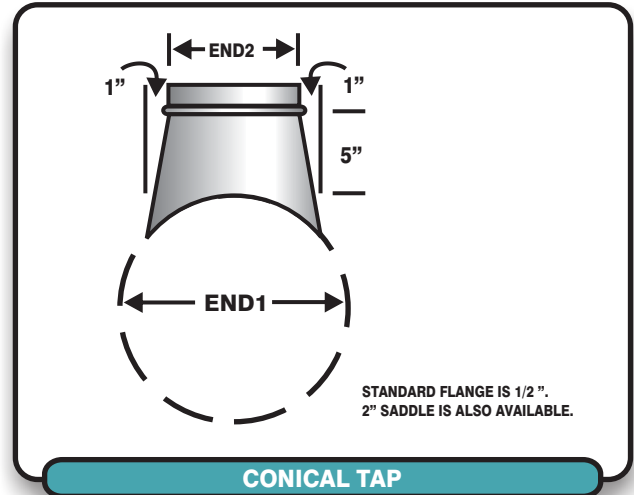
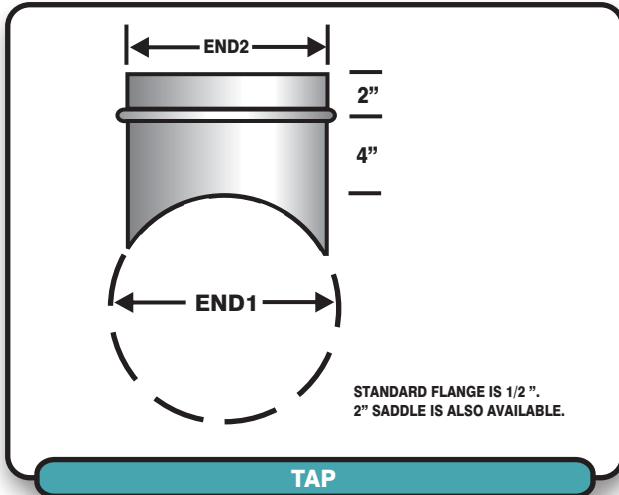
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Shop or Field Installed **ACCESSORIES**



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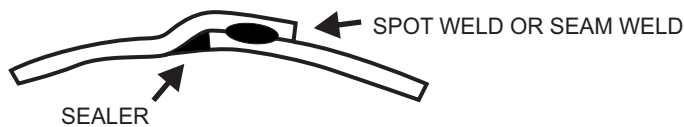
Round Duct SEAMS

MATERIAL	AVAILABLE GAUGES
Galvanized	26 - 18
Stainless Steel	26 - 20
Aluminum	0.025 - 0.063
Paint Grip	26 - 18
Poly Vinyl Coated	26 - 20
Perforated	24 - 20

Note: Other materials are available for special orders.



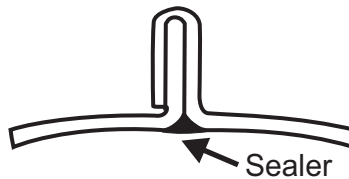
SPIRAL PIPE LOCK SEAM (RL-1)



SPOT WELD & BONDED SEAM OR CONTINUOUS SEAM WELD



BUTT-WELDED SEAM/STITCH-WELD



GORE-LOCKED SEAM

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Round Duct CONSTRUCTION STANDARDS

ALUMINUM ROUND DUCT GAUGE SCHEDULE

Duct Diameter in inches	Maximum +2" w.g. Static Positive		Maximum -2" w.g. Static Negative	
	Spiral Gauge Seam	Longitudinal Gauge Seam	Spiral Gauge Seam	Longitudinal Gauge Seam
3 Thru 8"	.025"	.032"	.025"	.040"
9 Thru 14"	.025"	.032"	.032"	.040"
15 Thru 26"	.032"	.040"	.040"	.050"
27 Thru 36"	.040"	.050"	.050"	.063"
37 Thru 50"	.050"	.063"	.063"	.071"
51 Thru 60"	.063"	.071"	N/A	.090"
61 Thru 84"	N/A	.090"	N/A	N/A

POLYVINYL COATED DUCT GAUGES FOR UNDERGROUND DUCT AND FITTINGS

Duct Diameter in inches	Gauges	Fittings
4 Thru 8"	26 Gauge	26 Gauge
9 Thru 16"	24 Gauge	24 Gauge
18 Thru 24"	22 Gauge	22 Gauge
26 Thru 32"	20 Gauge	20 Gauge
34 Thru 60"	18 Gauge	18 Gauge

POLYVINYL COATED DUCT GAUGES FOR ABOVE GROUND DUCT AND FITTINGS

Duct Diameter in inches	Gauges	Fittings
4 Thru 14"	26 Gauge	26 Gauge
16 Thru 26"	24 Gauge	24 Gauge
28 Thru 36"	22 Gauge	22 Gauge
38 Thru 50"	20 Gauge	20 Gauge
52 Thru 60"	18 Gauge	18 Gauge

*Gauges equal or exceed SMACNA standards

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Round Duct CONSTRUCTION STANDARDS

GALVANIZED ROUND DUCT GAUGE SCHEDULE

Max Diameter	POSITIVE PRESSURE					
	+2" w.g.		+4" w.g.		+10" w.g.	
	Spiral Seam	Long Seam	Spiral Seam	Long Seam	Spiral Seam	Long Seam
6"	26	26	26	26	26	26
8"	26	26	26	26	26	26
10"	26	26	26	26	26	26
12"	26	26	26	26	26	24
14"	26	26	26	24	26	24
16"	26	24	26	24	24	22
18"	26	24	24	24	24	22
19 - 26"	26	24	24	22	24	22
27 - 36"	24	22	22	20	22	20
37 - 56"	22	20	20	20	20	20
51 - 60"	20	18	18	18	18	18
61 - 84"	18	16	16	16	16	16

GALVANIZED ROUND DUCT GAUGE SCHEDULE

Max Diameter	NEGATIVE PRESSURE					
	+2" w.g.		+4" w.g.		+10" w.g.	
	Spiral Seam	Long Seam	Spiral Seam	Long Seam	Spiral Seam	Long Seam
6"	26	26	26	26	26	26
7"	26	26	26	26	26	26
8"	26	26	26	26	26	26
9"	26	26	26	26	26	24
10"	26	26	26	26	26	22
11"	26	26	26	24	26	22
12"	26	26	26	24	24	22
13"	26	26	26	24	24	20
14"	26	24	24	22	24	20
15"	26	24	24	22	22	20
16"	26	24	24	22	22	18
17"	26	24	24	20	22	18
18"	24	22	24	20	22	18
19"	24	22	24	20	22	18
20"	24	22	22	20	22	18
21"	24	20	22	18	22	16
22"	24	20	22	18	22	16
23"	24	20	22	18	20	16
24"	22	20	22	18	20	16
25 - 26"	22	20	20	18	20	18A4
27 - 29"	22	22	20	16	18	16A6
30"	22	18	20	16	18	16B4
31 - 33"	20	18	20	16	18	16B4
34"	20	18	20	20A6	18	16B4
35 - 36"	20	16	20	20A6	18	16B4
37 - 42"	20	16	18	18B6	18F12	
43 - 48"	20	18A6	18	18B6	18F6	
49 - 60"	18	18B4	18F6	16B4	18F6	
61 - 72"	16		18F6		16F4	

An alphabet letter in the table means that reinforcement angles or their equivalent must be used at the foot interval following the letter. The angle sizes are: A = 1" x 1" x 1/8", B = 1-1/4" x 1-1/4" x 3/16", C = 1-1/2" x 1-1/2" x 3/16", D = 1-1/2" x 1-1/2" x 1/4", E = 2" x 2" x 3/16", F = 2" x 2" x 1/4". If companion flange joints are used as reinforcements, those for 25" to 36" diameter shall be 1-1/2" x 1-1/2" x 3/16"; for 37" to 48" diameter 2" x 2" x 3/16" for 40" to 60" diameter.

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Approximate Weight SPIRAL DUCT

IN POUNDS PER LINEAR FOOT - BASED ON GALVANIZED STEEL

Diameter in inches	POSITIVE PRESSURE					
	26 gauge	24 gauge	22 gauge	20 gauge	18 gauge	16 gauge
3"	.76	1.01	1.23	1.48	*	*
4"	1.02	1.35	1.64	1.94	*	*
5"	1.28	1.69	2.06	2.42	*	*
6"	1.54	2.03	2.47	2.91	3.88	4.76
7"	1.79	2.37	2.88	3.40	4.52	5.58
8"	2.05	2.71	3.29	3.86	5.17	6.34
9"	2.31	3.05	3.71	4.37	5.82	7.18
10"	2.57	3.39	4.12	4.86	6.47	7.92
11"	2.82	3.73	4.54	5.34	7.11	8.72
12"	3.08	4.07	4.95	5.83	7.75	9.54
13"	3.34	4.41	5.36	6.32	8.48	10.31
14"	3.59	4.74	5.77	6.81	9.05	11.05
15"	3.84	5.08	6.18	7.28	9.70	11.80
16"	4.11	5.42	6.60	7.78	10.34	12.65
17"	4.36	5.77	7.02	8.25	11.08	13.47
18"	4.63	6.10	7.43	8.76	11.64	14.32
19"	4.89	5.44	7.84	9.25	12.29	15.09
20"	5.15	6.78	8.25	9.73	12.93	15.85
22"	5.65	7.46	9.08	10.71	14.23	17.50
24"	6.16	8.14	9.91	11.68	15.52	19.00
26"	*	8.82	10.73	12.66	16.82	20.70
28"	*	9.50	11.56	13.63	18.11	22.20
30"	*	10.18	12.38	14.60	19.41	23.90
32"	*	10.84	13.21	15.58	20.71	25.50
34"	*	11.54	14.01	16.51	21.97	27.08
36"	*	12.20	14.90	17.53	23.29	28.80
38"	*	*	15.67	18.46	24.51	30.26
40"	*	*	16.50	19.48	25.88	31.75
42"	*	*	17.32	20.40	27.21	33.47
44"	*	*	18.16	21.42	28.47	35.00
46"	*	*	18.99	22.39	29.77	36.65
48"	*	*	19.82	24.33	31.06	38.30
50"	*	*	20.63	25.30	32.37	39.94
52"	*	*	21.44	26.28	33.68	41.58
54"	*	*	22.26	26.28	34.98	43.18
56"	*	*	*	27.25	36.27	44.78
58"	*	*	*	28.23	37.56	46.38
60"	*	*	*	29.20	38.84	47.97

WEIGHTS MAY VARY SLIGHTLY

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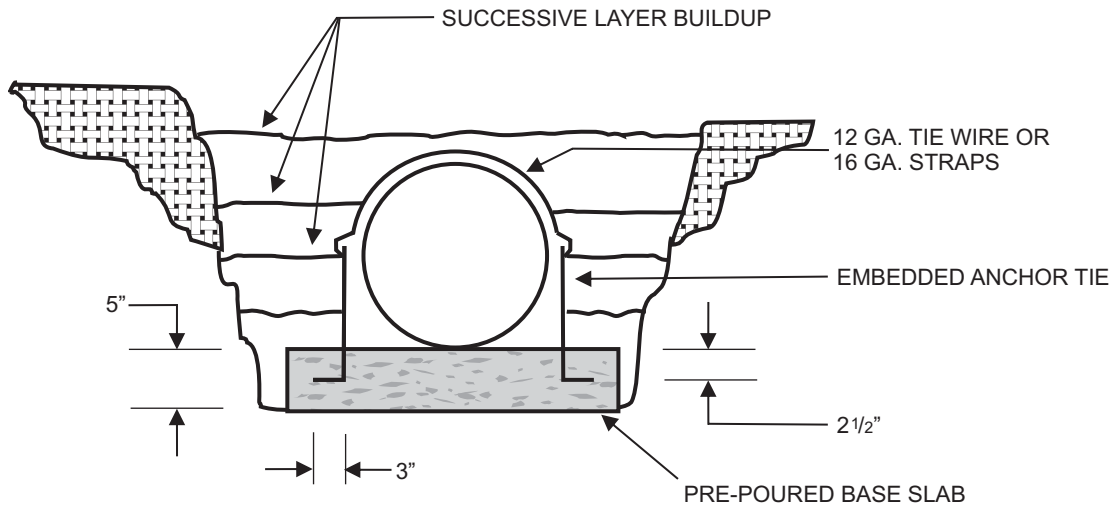
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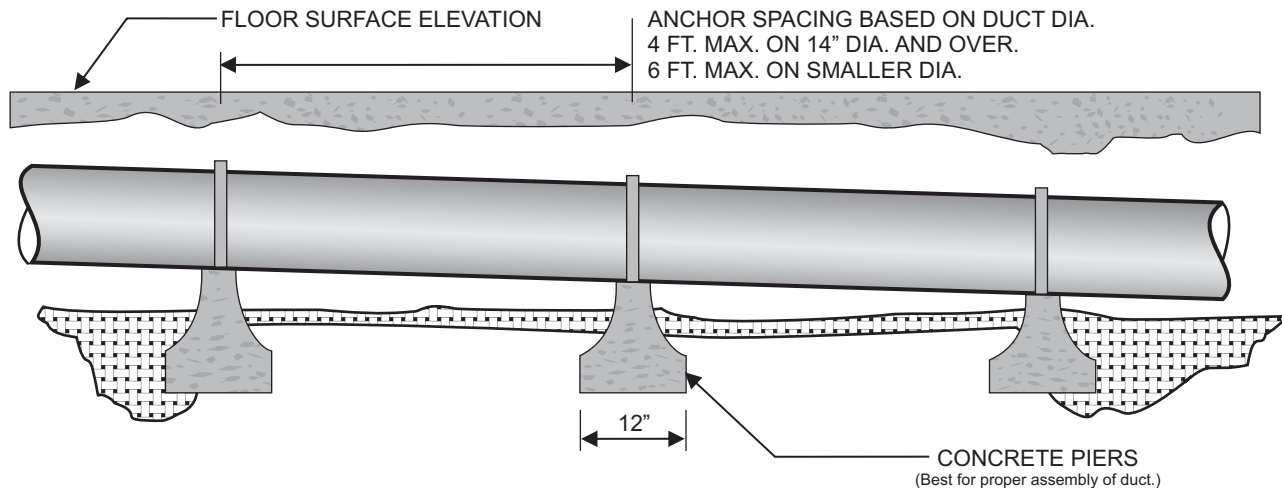
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Underground INSTALLATION



PRECAUTION!

THREE STAGE PLACEMENT OF CONCRETE IS ADVISABLE TO AVOID DAMAGE AND REDUCE DANGER OF FLOTATION. CONCRETE SHOULD NEVER BE DUMPED ON THE DUCT. COVER SHOULD BE MOVED Laterally OVER THE DUCT.



TYPICAL ANCHORAGE OF DUCTS TO BE ENCASED IN CONCRETE

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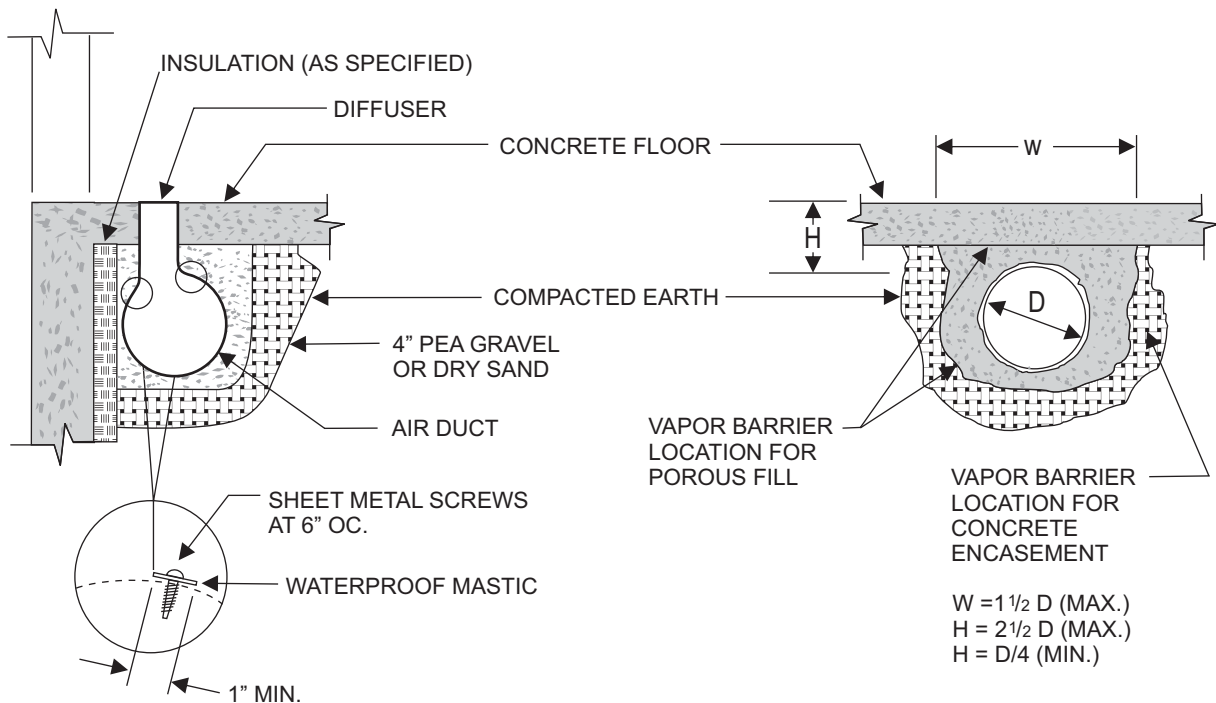
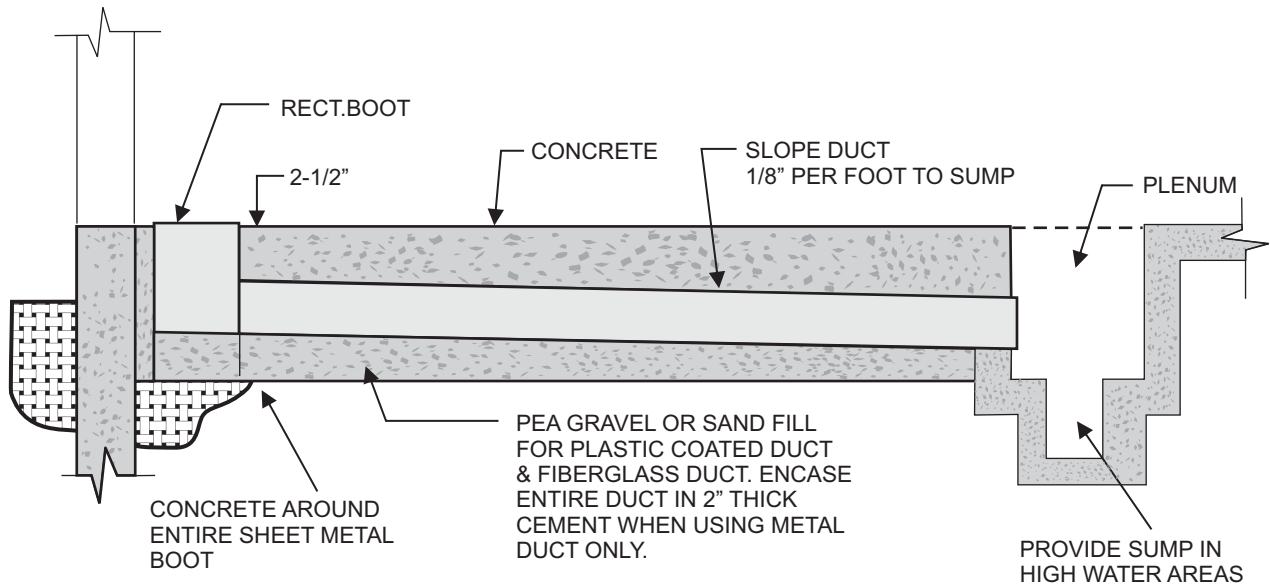
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Underground INSTALLATION



WATER TABLE IS BELOW DUCT.
SUBSOIL DRAIN PIPE MAY BE NEEDED
BELOW DUCT IN SOME AREAS.

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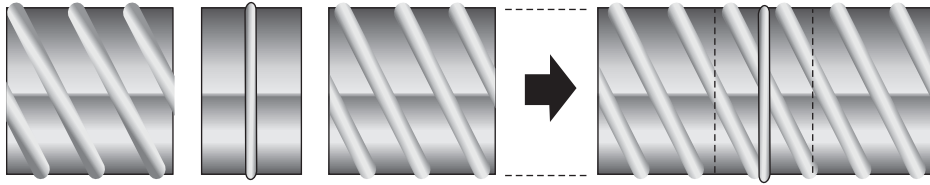
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Round Duct **INSTALLATION**

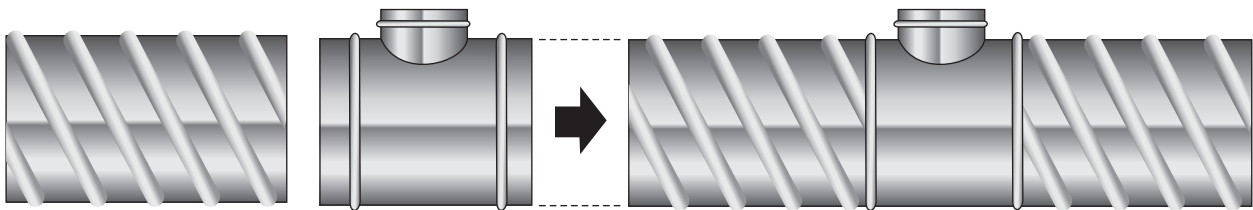
Installation of Slip Joint Connectors

Duct-to-joint connections are made by using a duct coupling that slips inside the duct sections.



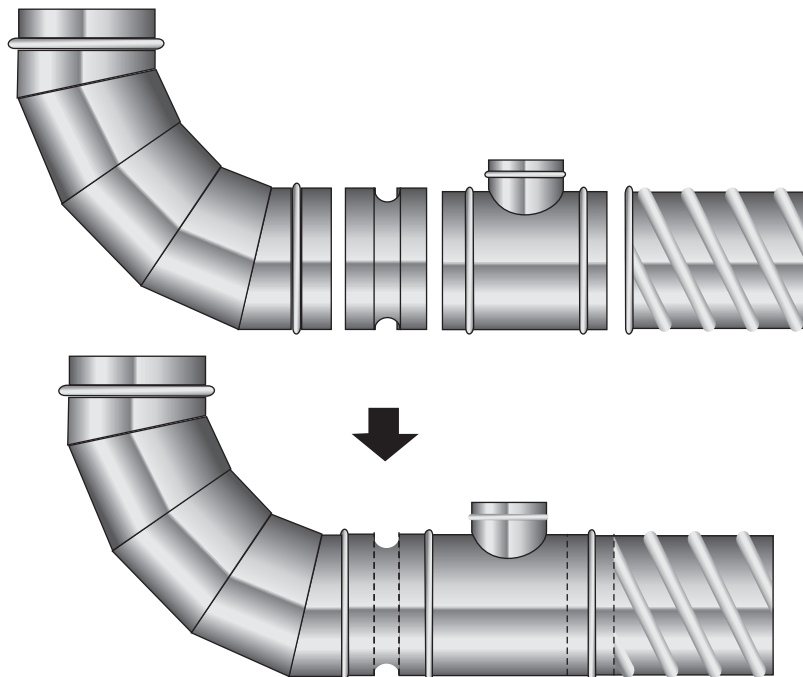
Duct-to-Fitting Connections

Duct-to-fitting connections are made by slipping the fitting collar into the duct.



Fitting-to-Fitting Connections

Connections can be made by using a short section of duct or by using a fitting coupling.



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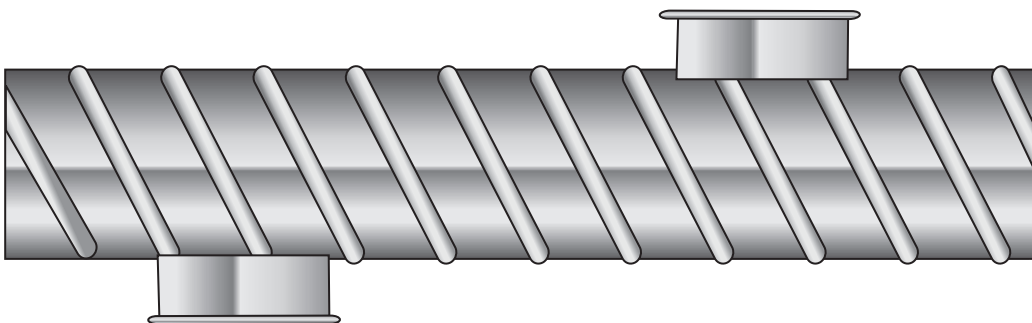
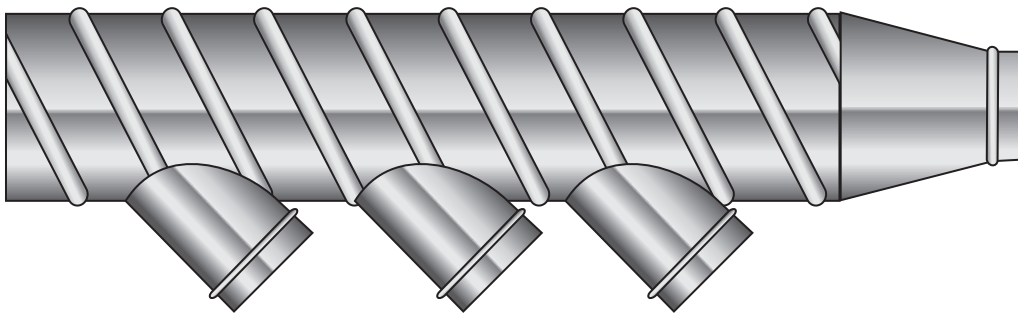
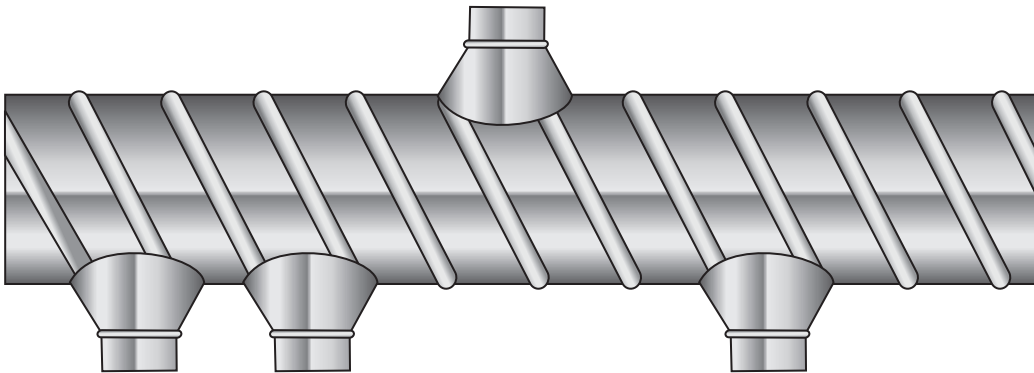
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Round Duct **MANIFOLDS/ASSEMBLIES**

Pro-Fab Sheet Metal Products Standard Manifolds/Assemblies of Duct and Fittings

We offer manifolds/assemblies of duct and fittings from our standard duct and fitting components. Manifolds/assemblies reduce field labor and potential sources of leakage by eliminating joints between pipe and standard fittings.



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Terms & Conditions Of Sale

All sales are C.O.D until account is established. Full payment for each shipment will be due within 30 days from date of shipment. Pro-Fab Sheet Metal, Inc. does not offer cash discounts nor does it allow the withholding of retainage.

PURCHASE ORDERS

Telephone purchase orders must be confirmed in writing or by fax to eliminate confusion and error. Items purchased for use in improvement of properties may be subject to the mechanic's lien laws of the State of Illinois civil code. All orders are subject to acceptance by Pro-Fab Sheet Metal, Inc.

CODES & SPECIFICATIONS

It is the responsibility of the contractor to determine that proper material, manufacturing and assembly procedures and both local and SMACNA codes are followed to meet the requirements for a given job. Pro-Fab Sheet Metal, Inc. extends no assurances that the products provided are adequate in type or quantity for the project or application.

CANCELLATIONS

Once accepted and material is consumed, orders cannot be cancelled but upon payment of charges, to compensate Pro-Fab Sheet Metal, Inc. for work performed plus a reasonable mark-up.

SHIPMENT

All products are F.O.B. Pro-Fab Sheet Metal, Inc. Customers must check shipment against an enclosed packing list. No claims for shortages, defects or nonconformity will be accepted after 72 hours from the date the shipment was received. An invoice will be issued if material is palletized and pallets are not returned within 15 days.

PRICING

All proposals are valid for 30 days from the date issued. Changes to products specifications and quantities will require changes to prices.

ADDITIONAL NOTES

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