



SPIRAL PIPE OF TEXAS

America's Sheet Metal Source Since 1981

### Core Products



#### Round Spiral Duct

##### Sizes

3"φ to 92"φ  
1" increment to 25"  
2" increments to 92"



#### Flat Oval Spiral Duct

##### Sizes

minor axis 3" to 36"  
(2" increments above 6")  
major axis 15" to 129"  
(actual widths are based upon the perimeter of the available round spiral duct sizes)



#### Coil-Line Rectangular Duct

##### Sizes

4" x 4" to unlimited

##### Gauges

Carbon Steel: 28 ga. to 16 ga.  
Stainless Steel: 28 ga. to 18 ga.  
Aluminum: 0.025" to 0.080"

##### Gauges

Carbon Steel: 26 ga. to 18 ga.  
Stainless Steel: 26 ga. to 18 ga.  
Aluminum: 0.025" to 0.080"

##### Gauges

Carbon Steel: 26 ga. to 16 ga.  
Stainless Steel: 26 ga. to 16 ga.  
Aluminum: 0.025" to 0.080"

##### Materials

G-90 galvanized steel  
G-60 galvanized steel  
A-60 galvanealed steel  
Paint Grip (mill phosphatized steel)  
black iron  
aluminized steel - type I  
poly-vinyl coated steel  
3003 aluminum  
304-L stainless steel  
316-L stainless steel  
agion anti-microbial steel

##### Materials

G-90 galvanized steel  
G-60 galvanized steel  
A-60 galvanealed steel  
Paint Grip (mill phosphatized steel)  
black iron  
aluminized steel - type I  
3003 aluminum  
304-L stainless steel  
316-L stainless steel  
agion anti-microbial steel

##### Materials

G-90 galvanized steel  
G-60 galvanized steel  
A-60 galvanealed steel  
Paint Grip (mill phosphatized steel)  
black iron  
aluminized steel - type I  
poly-vinyl coated steel  
3003 aluminum  
304-L stainless steel  
316-L stainless steel  
agion anti-microbial steel

##### Lengths

Exposed: std. 8'-0" lengths  
Concealed: std. 10'-0" lengths  
available 1'-0" to 20'-0" lengths

##### Lengths

Exposed: std. 8'-0" lengths  
Concealed: std. 10'-0" lengths  
available 1'-0" to 20'-0" lengths

##### Lengths

TDF std. length: 56"  
slip & drive std. length: 59"

##### Double-Wall

1", 2", 3" or 4" insulation available  
perforated liner (23% open area)  
solid liner available  
mylar erosion barrier available  
std. 1# density fiberglass insulation  
optional anti-microbial insulation  
optional mineral wool insulation  
optional elastomeric insulation

##### Double-Wall

1" or 2" insulation available  
perforated liner (23% open area)  
solid liner available  
mylar erosion barrier available  
std. 1# density fiberglass insulation  
optional anti-microbial insulation  
optional mineral wool insulation  
optional elastomeric insulation

##### Double-Wall

1", 1.5", 2", 3" & 4" insulation avail.  
perforated liner (23% open area)  
solid liner available  
mylar erosion barrier available  
std. 1# density fiberglass insulation  
optional anti-microbial insulation  
optional mineral wool insulation  
optional elastomeric insulation



### Longitudinal Seam Welded Round Duct

#### Sizes

Unlimited

#### Gauges

Carbon Steel: 22 ga. to 3/8"  
Stainless Steel: 22 ga. to 3/8"  
Aluminum: 0.040" to 3/8"  
G-90 galvanized steel  
G-60 galvanized steel  
A-60 galvanealed steel  
Paint Grip (mill phosphatized steel)  
black iron  
aluminized steel - type I  
3003 aluminum  
304-L stainless steel  
316-L stainless steel  
agion anti-microbial steel

#### Insulation

available as Double-Walled  
available as Spiracoustic



### Longitudinal Seam Welded Flat Oval Duct

#### Sizes

Unlimited

#### Gauges

Carbon Steel: 22 ga. to 3/8"  
Stainless Steel: 22 ga. to 3/8"  
Aluminum: 0.040" to 3/8"  
G-90 galvanized steel  
G-60 galvanized steel  
A-60 galvanealed steel  
Paint Grip (mill phosphatized steel)  
black iron  
aluminized steel - type I  
3003 aluminum  
304-L stainless steel  
316-L stainless steel  
agion anti-microbial steel

#### Insulation

available as Double-Walled



### Welded Seam Rectangular Duct

#### Sizes

Unlimited

#### Gauges

Carbon Steel: 22 ga. to 3/8"  
Stainless Steel: 22 ga. to 3/8"  
Aluminum: 0.040" to 3/8"  
G-90 galvanized steel  
G-60 galvanized steel  
A-60 galvanealed steel  
Paint Grip (mill phosphatized steel)  
black iron  
aluminized steel - type I  
3003 aluminum  
304-L stainless steel  
316-L stainless steel  
agion anti-microbial steel

#### Insulation

available as Double-Walled

## Connectors

### Round

Slip joints & couplings  
butt-welded (raw ends)  
1/2" swedged/lapped  
van stoned angle rings  
welded angle rings  
1/2" weld flange

### Flat Oval

Slip joints & couplings  
butt-welded (raw ends)  
1/2" swedged/lapped  
  
welded angle rings  
1/2" weld flange

### Rectangular

TDF  
butt-welded (raw ends)  
standing seam  
  
welded angle frames  
1/2" weld flange

## Fittings



We offer a full selection of fittings in all configurations to match our straight duct options

## Special Finishes

- "Epoxy coated" available (using 3rd party services)
- Galvanized Hot-Dipped available (using 3rd party services)
- Stainless Steels --- #2B finish standard
- Stainless Steels --- #4 finish available
- Stainless Steels --- weld grinding available
- Stainless Steels --- weld pacification/de-blackening available
- Stainless Steels --- re-blend grain available



## Joint/Seam Methods

- |  |                                 |                            |
|--|---------------------------------|----------------------------|
| 4-ply Spiral Lockseams (round & flat oval) | Tack-Welded and Sealed          | Lap Welded / Swedge Welded |
| Pittsburgh Seams (rectangular)             | MIG welded (metal inert gas)    | Butt Welded                |
| Snap-Lock Seams (rectangular)              | TIG welded (tungsten inert gas) |                            |

*Certified Welding Available*

*Die-penetrant weld testing available*

## Industrial

The full capabilities listed above are available for industrial applications.

We also offer a selection of industrial specialty items:

- |             |              |
|-------------|--------------|
| Blast Gates | Floor Sweeps |
| Hoods       | Dampers      |
| Stacks      |              |



## Cleaning

- "Open ends plastic wrapped" available
- "Ducts cleaned and capped with plastic wrap" available
- "Ducts cleaned and plastic wrapped" available

## Services

- Piecemarking / Color Coding
- Assembly Drawings
- Spooling / Manifolding

## Standards

We strive to fabricate duct systems with the highest performance and the lowest leakage. SPOT is an active participant in and contributor to many industry organizations such as ASHRAE and SPIDA. We are knowledgeable in the leading duct construction standards --- both US and international --- and maintain a library of and knowledge in the publications and standards of: ASHRAE, SMACNA, SPIDA, AMCA, ACGIH, AWS and NAIMA.

SPOT's products are manufactured consistent with HVAC industry dimensions and practices. For pressure loss data and information, please refer to the ASHRAE Duct Fitting Database for loss coefficients.

Actual fabrication standards for a project are defined by contract with our customers. Variance from "industry standard" construction may be dictated by customer demand or through price negotiation. Where construction defaults to a "standard" we are conversant in and can fabricate in accordance with the following:

- SMACNA HVAC Duct Construction Standards (1985, 1995 or 2005)
- SMACNA Round Industrial Duct Construction Standards (1999)
- SMACNA Rectangular Industrial Duct Construction Standards
- SMACNA Guide to Steel Stack Construction
- AWS D9.1M/D9.1 (2006)
- ACGIH Industrial Ventilation Manual
- ASHRAE HVAC Systems and Equipment Handbook (2016)
- NAIMA Fibrous Glass Duct Liner Standard (2002)
- SPIDA Tolerance Standards (2013)



Large or Small,  
Your Full-Line  
Duct Source



# QUALITY DUCT SYSTEMS FROM START TO FINISH

Spiral, Oval, Rectangular Ductwork & Fittings  
Sound Attenuators, Acoustical & Thermal Panels  
Industrial Ventilation Duct  
Custom Sheet Metal Fabrication



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