



ZEN Industries shop standards for rectangular duct

BASED ON 3rd Edition 2005 SMACNA STANDARDS

S&D - 1" W.G.

DUCT LENGTHS

MAX. WIDTH	CONNECTOR	60"	48"	36"	30"	24"
10" - DOWN	FS/D	26	26	26	26	26
11 - 12"	FS/D	26	26	26	26	26
13 - 14"	FS/D	26	26	26	26	26
15 - 16"	FS/D	26	26	26	26	26
17 - 18"	ST-S/D	26	26	26	26	26
19 - 20"	ST-S/D	26	26	26	26	26
21 - 22"	ST-S/D	26	26	26	26	26
23 - 24"	ST-S/D	26	26	26	26	26
25 - 26"	ST-S/D	26	26	26	26	26
27 - 28"	ST-S/D	26	26	26	26	26
29 - 30"	ST-S/D	26	26	26	26	26
31 - 36"	ST-S/D	24	26	26	26	26
37 - 42"	ST-S/D	24	24	26	26	26
43 - 48"	ST-S/D	22	24	24	26	26
49 - 54"	TDF	22	22	24	24	24
55 - 60"	TDF	24 MPT	22	22	24	24
61 - 72"	TDF	22 MPT	22 MPT	22	22	22
73 - 84"	TDF	20 MPT/JTR	20 MPT	20 MPT	20 MPT	22 MPT
85 - 96"	TDF	20 - 2MPT	20 - 2MPT	20 MPT	20 MPT	22 MPT
97 - 108"	WARD "J"	18 MPT	18 MPT	18	18	18
109 - 120"	WARD "J"	18 MPT	18 MPT	18	18	18

Zen Industries Standards based on the latest SMACNA standards:

galvanized sheets	26 & 24 ga	G-60 LFQ
all duct 12" and above will be beaded		
1/2"wg. to 2"wg	snaplock seam	(pittsburg available at an additional cost)
3"wg up to 48"wide	snaplock seam	(duct over 48" wide-pittsburg)
4"wg to 10"wg	pittsburg seam	
fittings - assembled	straight duct - unassembled	(assembly available at an additional cost)
duct sections width + height	up to 18" wrapped	
	up to 70" "L" shaped	
	71" & up 4 pc.	
FS/D = flat slip(24ga) & drive(24ga)	ST-S/D = standing slip(22ga) & drive	TDF =T-25b roll formed flange
MPT= midpoint tie-rod	JTR= joint tie-rods	
2x2x1/8" angle =	midpoint reinforcement in lieu of tie-rods	
Duct liner available 1/2" or 1"		