

**STAINLESS MECHANICAL DUCTWORK**

## STAINLESS HVAC DUCTWORK

Mechanically seamed rectangular 304 or 316L stainless ductwork for light-gauge HVAC air distribution, return, exhaust, and equipment connections.

- Best for light-gauge rectangular duct systems that need stainless material but do not require fully welded seams.
- Offered in 26 ga through 20 ga 304 or 316L stainless; heavier gauges or continuous welded seams should move to welded stainless duct.
- Confirm grade, finish, connection type, liner/insulation, seal class, visible faces, and face-to-face dimensions before release.

MATERIAL	<b>304 or 316L Stainless</b>
GAUGE RANGE	<b>26 ga - 20 ga</b>
CONSTRUCTION	<b>Pittsburgh lock seam</b>

### CONSTRUCTION STANDARD

<b>Application</b>	Rectangular stainless ductwork and fittings for HVAC supply, return, exhaust, rooftop equipment connections, and standard air distribution systems requiring stainless material.
<b>Material</b>	304 stainless steel is typical; 316L stainless steel is available when corrosion resistance or project specifications require it.
<b>Gauge range</b>	Stainless lock seam duct is offered from 26 gauge through 20 gauge. Heavier stainless duct is typically quoted as welded stainless duct.
<b>Seam construction</b>	Pittsburgh / mechanical lock seam construction. This is a formed stainless duct product, not a fully welded duct system.
<b>Straight sections</b>	Produced in nominal duct sections and field-fit lengths as released. Connection style affects face-to-face dimensions and should be selected before fabrication.
<b>Connection options</b>	Raw ends with couplers, slip-and-drive, TDC / Ductmate, and angle rings are available as shown or quoted.
<b>Insulation options</b>	Fiberglass liner, rigid duct board insulation, and Armaflex options are available for acoustic or thermal protection when quoted.
<b>Quality check</b>	Duct sections and fittings receive visual inspection before release. Leak testing, pressure testing, or certified inspection are by others unless quoted.

### BUILD QUALITY



**Made to spec**

Built to released grade, gauge, finish, and connection details.



**Built tough**

304 or 316L stainless formed for mechanical ductwork.



**Quality checked**

Duct sections and fittings receive visual inspection.



**Finish aware**

Visible faces, grain direction, and handling planned before release.

## FABRICATION CAPABILITIES

<b>Duct sections</b>	Rectangular stainless straight duct, field-fit pieces, risers, drops, and custom lengths.
<b>Fittings</b>	Rectangular stainless elbows, radius bends, offsets, tapers, reducers, transitions, branches, and tees.
<b>Connections</b>	Raw ends with couplers, slip-and-drive, TDC / Ductmate, angle rings, equipment transitions, collars, curb adapters, and roof penetration fittings are available.
<b>Field-fit work</b>	Short sections, piece-marked runs, and coordinated connection faces.
<b>Shop details</b>	Tabs, brackets, companion flanges, angle frames, reinforcement, and special flange details when requested.
<b>Release support</b>	Built from released dimensions with connection type, liner requirements, seal class, access openings, finish direction, and piece marks coordinated before fabrication.

## LINER & INSULATION

### Fiberglass liner

Acoustic or thermal fiberglass liner is available in 1/2" through 2" thicknesses when specified.

### Rigid duct board

Rigid duct board insulation can be quoted where the project needs additional thermal or acoustic protection outside the normal liner scope.

### Armaflex

Armaflex options are available when the project requires flexible closed-cell insulation details.

### Attachment

Liner is installed with water-based adhesive and spot welded liner pins unless another attachment method is quoted.

## CONNECTION OPTIONS



COUPLERS

### Raw ends

Raw ends with couplers for screw assembly.



S & DRIVE

### Slip-and-drive

Standard rectangular duct connection for mechanical assembly.



TDC / DUCTMATE

### Bolted seal

Bolted frame connections with gasket or butyl sealant when specified.



ANGLE RINGS

### Custom pattern

Angle rings, frames, and bolt patterns to match the application.

## OPTIONAL ACCESSORIES

### Liner

Fiberglass liner, rigid duct board insulation, Armaflex, liner pins, adhesive, and exposed-edge details.

### Access

Access doors, cleanout openings, inspection panels, and drain fittings.

### Sealing

Gasket, butyl sealant, mastic, or seal class details where specified and quoted.

### Custom details

Reinforcement, tabs, brackets, piece marks, angle rings, and special hardware.

## REQUIRED FOR QUOTE / RELEASE

✓ 304 or 316L grade, gauge, duct size, quantity, connection type, and required nominal or field-fit lengths.

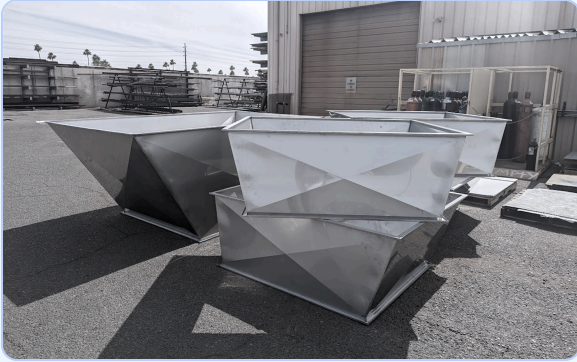
✓ Approved drawing, sketch, or verified field dimensions with airflow/orientation noted.

✓ Connection details: raw ends with couplers, slip-and-drive, TDC / Ductmate, angle rings, bolt patterns, or companion flange needs.

✓ Liner or insulation type, thickness, exposed edges, access needs, and any acoustic or thermal requirements.

✓ Piece marks, access openings, reinforcement, pressure class, seal class, visible-face handling, and any testing requirements.

## APPLICATIONS & DETAILS



### APPLICATION DETAIL

#### Cleanable rectangular duct



Stainless lock seam duct is used where 304 or 316L stainless is specified but fully welded construction is not required. It suits cleanable, exposed, corrosion-resistant, and specialty HVAC applications where formed construction remains appropriate.

### APPLICATION DETAIL

#### Finish-aware fabrication



Mill or #4 brushed finish, grain direction, visible faces, and handling requirements should be identified before release. Protective film, appearance-critical surfaces, connection marks, and shop handling expectations should be coordinated in advance.



304 /  
316L

Finish

Liner

Ends

### APPLICATION DETAIL

#### Release details



Confirm grade, gauge, finish, connection style, liner or insulation, openings, and field-fit dimensions before fabrication. Reinforcement, access requirements, exposed-edge treatment, hardware, and special cleaning scope should also be listed when required.

## NOT INCLUDED UNLESS QUOTED

- Installation, hoisting, rigging, roofing, roof penetration work, or field sealing unless quoted.
- Engineering, permits, inspections, balancing, cleaning, passivation, finish repair, or listed-system certification.
- Leak testing, pressure testing, fire wrap, fire-rated enclosure, gaskets, sealant, hardware, companion flanges, or rework from changed release dimensions unless quoted.

## SCOPE & RESPONSIBILITY

**Code note:** Stainless lock seam duct systems may be governed by mechanical code, local code, project specifications, pressure class, liner requirements, material compatibility requirements, and AHJ requirements. Empire fabricates duct and fittings to released dimensions and quoted scope; final system design, material selection, installation method, field sealing, insulation requirements, clearances, balancing, and acceptance remain the responsibility of others unless expressly included.

## READY TO QUOTE?



### Let's get your project moving.

Send drawings, sketches, photos, or field measurements. Empire is ready to go to work for you.

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