



# Double Wall Round Catalog





# Table of Contents

Nomenclature Definitions.....	4	Linx Safe Assembly Instructions .....	8
Smart Part Construction.....	5	Double Wall Specifications.....	9
Linx Safe Connection .....	6	Tolerance, Gauge, e-dimension & Fittings Slip Dimension...10	
Duct System Leakage Classification .....	7	Acoustical Performance .....	11

## Spiral Duct

Corrugated/Non-corrugated - SC/SN .....	12
---	----

## Elbows

90° 1.5" Radius Elbow - E 90 .....	13
90° 1.0" Radius Elbow - ER 90 .....	14
60° 1.0" Radius Elbow - ER 60 .....	15
45° 1.5" Radius Elbow - E 45 .....	16
45° 1.0" Radius Elbow - ER 45 .....	17
30° 1.0" Radius Elbow - ER 30 .....	18
15° 1.0" Radius Elbow - ER 15 .....	19
Mitered Elbow - BM.....	20
Mitered Elbow w/Vanes - BMV .....	20

## Reducers

Fabricated Concentric Reducers - RC/RCF .....	21
Fabricated Eccentric Reducers - RE/REF .....	22

## Taps

45° Boot-Style Tap - PBF/PB .....	23
Pressed or Fabricated Saddle Tap - PS.....	24
45° Lateral Saddle Tap for Round - PV45 .....	25
Conical Saddle Tap for Round - PC .....	26

## Tees/Crossing Tees

Bullhead Tee - TBH/TRBH .....	27
45° Boot-Style Tee - TB/TRB .....	28
45° Boot-Style Crossing Tee - XB/XRB .....	29
Conical Tee - TC/TRC .....	30
Conical Crossing Tee - XC/XRC .....	31
Assembled Straight Tee - TS/TRS .....	32
Assembled Crossing Tee - XS/XRS .....	33
45° Lateral Tee - TV45/TRV45 .....	34
45° Lateral Crossing Tee - XV45/XRV45 .....	35

## Y-Branch

45° Directional Split Fitting - Y45 .....	36
---	----

## Offsets

One-Piece Offset - Z .....	36
----------------------------	----

## Couplings

Coupler - CD/CF .....	37
-----------------------	----

## End Caps

End Cap - ED/EF .....	38
-----------------------	----

## Take-Offs

Flat Take-Off - PT/DPT .....	39
------------------------------	----

## Dampers

Manual Balancing Damper - DS .....	40
Gasketed Flat or Bellmouth Damper - DPT/DPR .....	41
Damper with Saddle Tap Base - DSPS .....	41
Balancing Damper with Air Flow Shut Off - DT.....	42

## Rectangular to Round

Rectangular to Round Transition - RRT .....	43
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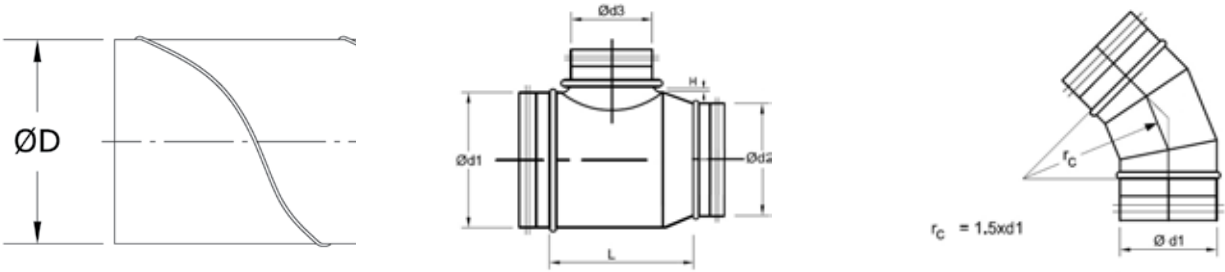
## Transitions

Double Wall to Single Wall Transition - IN/INF .....	44
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## Field Cut Adapter

Field Cut Adapter - FC.....	45
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# Nomenclature Definitions



- Nominal inside diameter (duct size).....  $\text{ØD}$
- Nominal outside diameter (fitting size).....  $\text{Ød1}, \text{Ød2}, \text{Ød3}, \text{Ød4}$
- Material thickness (gauge).....  $t$
- Installed height.....  $H$
- Center line radius.....  $r_c$
- Installed length.....  $L$
- Fitting slip dimension .....  $e$
- All measurements in inches (in or ") unless otherwise noted
- All angles in degrees ( $^\circ$ )

# Smart Part Anatomy

## Nomenclature / Abbreviations

PRODUCT	Designation And Description	PRODUCT	Designation And Description
<b>DUCT</b>	SC = Corrugated Single Slip Double Wall Round Spiral Duct SNC - Noncorrugated Single Slip Double Wall Round Spiral Duct SCV - Corrugated Double Slip Double Wall Round Spiral Duct SNCV - Noncorrugated Double Slip Double Wall Round Spiral Duct	<b>ELBOWS</b>	E = 1.5 Radius Elbow Stamped Or With 3 - 5 Gores ER = 1.0 Radius Elbow Stamped Or With 3 - 4 Gores EM = Mitered Elbow EMV = Mitered Elbow With Vanes
<b>REDUCERS</b>	RC = Reducer Concentric Male RCF = Reducer Concentric Female RE = Reducer Ecentric Male REF = Reducer Ecentric Female	<b>END CAPS</b>	ED = End Duct EF = End Fitting
<b>COUPLINGS</b>	CD = Coupling Duct CF = Coupling Fitting	<b>TAKE-OFFS</b>	PT = Straight Take Off PR = Radius Take Off
<b>TEES</b>	TBH = Bull Head Tee TRBH = Reducing Bull Head Tee TB = Tee With Boot Tap TRB = Reducing Tee With Boot Tap TC = Tee With Conical Tap TRC = Reducing Tee With Conical Tap TS = Straight Tee TRS = Reducing Straight Tee	<b>CROSSING TEES</b>	XB = Boot Style Crossing Tee XRB = Reducing Boot Style Crossing Tee XC = Conical Crossing Tee XRC = Reducing Conical Crossing Tee XS = Crossing Tee XRS = Reducing Crossing Tee XV = Lateral Crossing Tee XRV = Reducing Lateral Crossing Tee
<b>LATERAL TEES</b>	TV = Tee With Lateral Tap TRV = Reducing Tee With Lateral Tap	<b>Y-BRANCH</b>	Y = Y Branch
<b>TAPS</b>	PB = Boot Tap PBF = Boot Tap Flat PS = Press Tap PV = Lateral Tap PVF = Lateral Tap Flat PC = Conical Tap PCF = Conical Tap Flat	<b>DAMPERS</b>	DS = Damper DT = Damper DIL = Combination Damper with Take-Off DILR = Combination Damper with Take-Off DSPS = Combination Damper with Saddle Tap
<b>TRANSITIONS</b>	IN = Transition INF = Transition	<b>FIELD CUT ADAPTERS</b>	FC = Field Cut Adapter

### REQUIRED FOR ORDERING

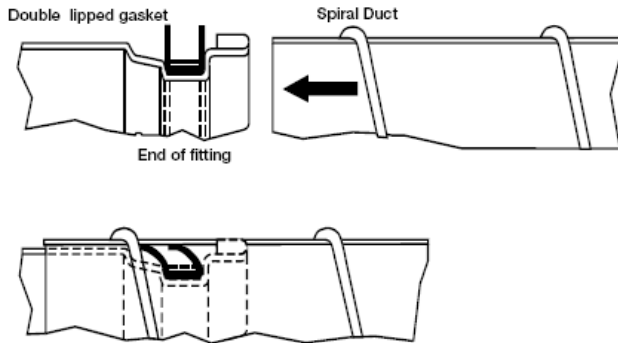
### OPTIONAL FOR ORDERING

\*LINUX STANDARDS PROVIDED IF NOT GIVEN

CONSTRUCTION	INSULTHICK (IN)	CONNECTION	DIAMETER (IN)	PART DESIGNATION	MATERIAL (ID)	GAUGE (ID)	MATERIAL (OD)	GAUGE (OD)
I = Insulated	1", 2", or 3"	U = Safe N = Non-gasketed	Diameter	See Chart Above	PF = Perforated Galvanized* G9 = G90 Galvanized* S4 = S304 Stainless S6 = S316 Stainless AL = Aluminum	Gauge	G9 = G90 Galvanized* S4 = S304 Stainless S6 = S316 Stainless GN = Galvanneal AL = Aluminum	Gauge
<b>I</b>	<b>1</b>	<b>U</b>	<b>10</b>	<b>EF</b>	<b>PF</b>	<b>22</b>	<b>G9</b>	<b>26</b>

= Linx Insulated 10" Diameter End Cap in Galvanized OD with perforated ID

# Linx Safe Connection



## Benefits of the Linx Safe Duct System

- A complete line of self-sealing spiral duct and fittings
- Factory installed gasket - no loose parts
- Fast and easy installation
- Environmentally friendly, no harmful sealers required
- Installation not contingent on weather
- Performance rated from -20°F to +212°F
- Double lipped gasket minimizes the risk of leakage in the event of damage
- Meets SMACNA's Leakage Class 3
- Gasket U.L. classified rating (Flame Spread - 0 / Smoke Developed - 0) in accordance with ASTM standard E84 and ANSI / UL 723
- Rolled over edges for easier installation, reduces risk of injury and adds strength
- Adjustability - fittings can be rotated 360° during installation and still maintain the seal's integrity

The Linx Safe self-sealing duct system is based on a U-profile, EPDM rubber gasket. This gasket is located in a groove at the end of the fitting and is securely attached by a stainless steel band. This design ensures that the rubber gasket is always held in the correct position.

When the fitting is inserted into the spiral duct, the gasket folds back forming a seal against the inside of the spiral duct eliminating the need for any duct sealer.

In order to achieve optimum sealing for all diameters, various gasket sizes are used as shown in the table below.

The standard Linx Safe gasket is made from a material resistant to ozone, UV rays, and temperature fluctuations. A silicone gasket for special applications is also available. The standard Linx Safe gasket is rated for temperatures from -20°F to +212°F (silicone gasket rated for temperatures from -94°F to +302°F).



Gasket Connection for diameters less than 26" OD

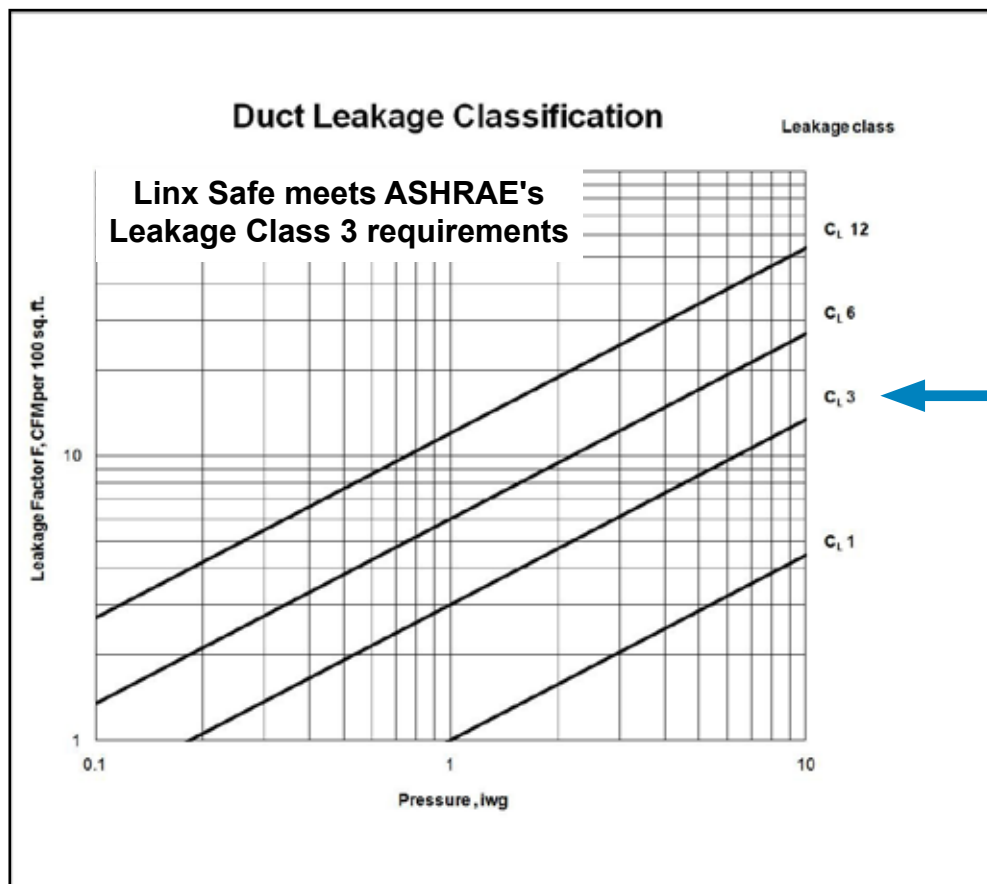
"THE LEADING EDGE" for larger diameter fittings (26" OD - 60" OD)

# Duct System Leakage Classification

The graph below represents a selected series of leakage classes as defined by the formula  $C_L = F/P^{0.65}$ . The formula defines leakage class as the relationship between leakage rate, duct surface area, and pressure.

Since the calculation of leakage class is based on several relevant factors, leakage class is a comprehensive method of assigning allowable leakage rates. This enables the designer to address all major system factors by simply assigning a leakage class.

Linx Safe meets ASHRAE's Leakage Class 3 requirements without the use of any duct sealants.



F = Leakage rate per unit of duct surface (cfm/100 sq. ft.)  
C<sub>L</sub> = Leakage Class  
P = Static pressure (iwg)

# Linx Safe Assembly Instructions

## Preparations For Assembly

- Check that all ductwork to be used in the system is Linx Safe and is undamaged. All Linx Safe fittings must be used with calibrated spiral duct certified by Linx Industries.
- Do not use any ductwork that has been damaged in such a way that it may jeopardize the air tightness or structural strength of the system.
- Store all ductwork in a well organized and weather proof storage area to minimize the risk of damage.
- Cut all spiral duct at right angles and carefully remove any burrs from the cut edges. Installation is easier and the risk of damaging the gasket is reduced if there are no burrs.

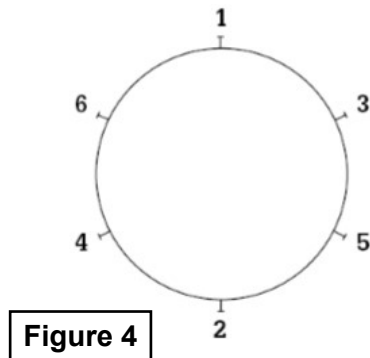
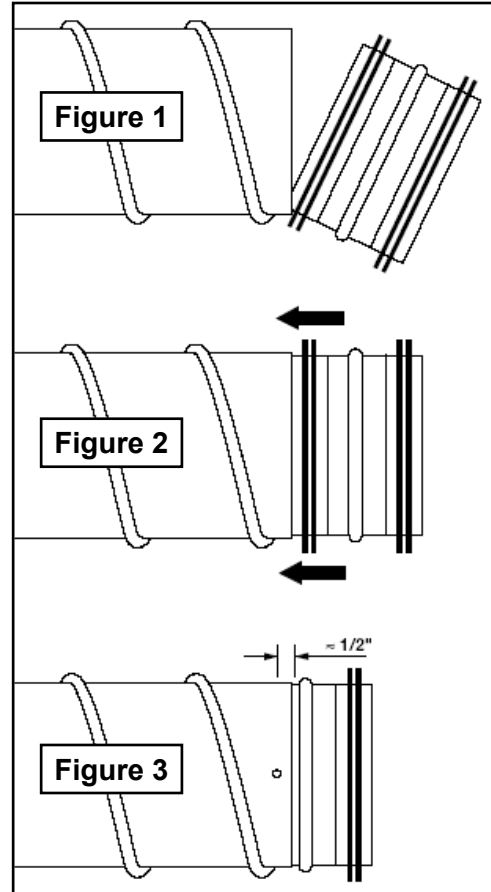
## Assembly

1. Start by inserting the turned-over edge of the fitting into the spiral duct (figure 1).
2. Check that the first lip of the gasket is in contact with the edge of the spiral duct all the way around and sticks straight out so that the lip is not twisted in one direction or the other.
3. Push the end of the fitting into the spiral duct. Turning the fitting slightly aids insertion. Removal, if necessary, is also aided by turning (figure 2)
4. Secure the fitting in the spiral duct using self-tapping screws or airtight pop rivets. Quantities and sizes to be used are shown in the table below. Do not use more fasteners than specified.
5. Fasteners should be positioned 1/2 inch from the bead stop to prevent damage to the gasket (figure 3).

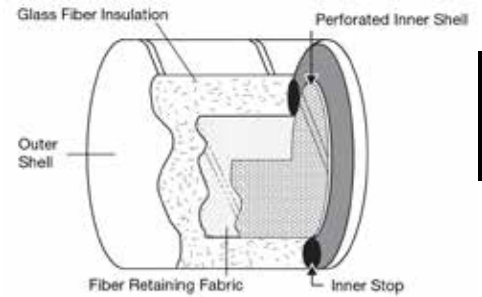
Spiral Pipe Dia. (in)	Screw Dia. (in)	Quantity
3-5	1/8	2
6-10	1/8	3
12-24	1/8	4
26-50	1/8	6
52-60	1/8	8

6. Placement of the fastening screws should be opposite from one another evenly spaced around the circumference, much like the procedure for tightening lug nuts on a tire. Start where the distance between the spiral duct and the fitting is largest (figure 4).

Carefully seal any holes left by measurements, removed screws, pop rivets, etc.



# Double Wall Specifications



## MATERIAL ( \* ) not available in pressed construction

- Galvanized steel conforming to ASTM standards A653 and A924
- Stainless steel type 304L conforming to ASTM standard A240\*
- Stainless steel type 316L conforming to ASTM standard A240\*
- Aluminum T3003\*

## Double Wall

- Tested in accordance to UL-723 with flame developed index and smoke developed index of 0/0.
- Perforated inner liner will consist of 0.125" perforations on 0.250" staggered centers corresponding to an overall open area of 23%.
- Glass fiber insulation will have a maximum conductivity factor (k) of 0.26 BTU-in/hr x ft<sup>2</sup> x °F at 75°F mean ambient temperature (R=3.8).
- Retaining fabric will be 0.008" thick, 15.6 lb/ft<sup>3</sup> density non-woven polyester fabric with an air permeability rate of 9.2 ft<sup>3</sup>/ft<sup>2</sup> x s.
- Linx's EnergyX™ insulation stop is constructed of a closed-cell elastomeric foam with a maximum conductivity factor (k) of 0.28 BTU-in/hr x ft<sup>2</sup> x °F and an operating temperature range of -70°F to +220°F.

## Surface Finish

- Galvanized steel (galvanized in accordance with latest SMACNA standards).
- Stainless steel type 304L - Mill Finish
- Stainless steel type 316L - 2B Mill Finish
- ProCoat™ (outside only) or ProCoat™ Plus (inside and outside) on duct and/or fittings
  - Standard color = white (additional color options available)
  - Average coating thickness of 4 mils (0.004 inch)
  - Coating to meet or exceed 1,000 hour Salt Spray Test per ASTM B117-97.
- Epoxy (duct and/or fittings)
- Antimicrobial - coating containing antimicrobial compound complies with UL standard - not to exceed flame or smoke developed ratings of 25/50.

## Thickness

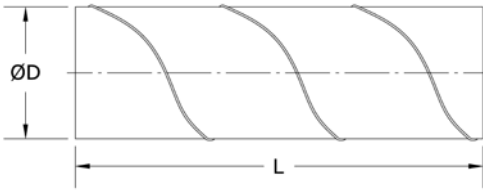
Material thickness constructed from galvanized steel in accordance with the latest SMACNA's HVAC Duct Construction Standards for +10" water gauge pressure.

## Construction

- Duct is of spiral lock seam construction with a mechanically formed seam locking indentation evenly spaced along the spiral seam. All spiral duct 8" diameter and larger shall incorporate multiple corrugations between spiral seams. Inner and outer duct will be of spiral lockseam construction.
- Double wall duct and fittings will consist of a perforated or solid inner liner, 1" thick x 1.0 lb/ft<sup>3</sup> layer of glass fiber insulation, and a solid outer pressure shell. When a perforated inner liner is specified, a retaining fabric must be wrapped, between the perforated inner and the glass fiber insulation. This is to prevent glass fiber tearing into the airstream and maintains the desired acoustical properties.
- Double wall options: 1" thick insulation (standard); and 2" thick insulation (optional).
  - The outer pressure shell diameter shall be two times the insulation thickness larger than the inner liner.
  - Fittings shall be manufactured using one or more of the following construction methods:
    - Overlapped edges stitch welded along the entire length of the fitting
    - Standing seam gore locked and internally sealed Button punched and internally sealed
    - Elbows 3" through 12" diameter will be die stamped and continuously stitch welded

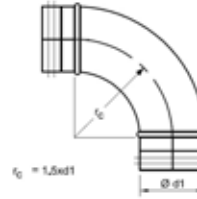
# Tolerance, Gauge, & e-dimensions

## Tolerances for Spiral Duct



Ø D (inch)	Ø D Tolerance (inch) min.-max.	t* (gauge)	t** (gauge)
3	2.950 - 2.969	28	28
4	3.950 - 3.969	28	28
5	4.950 - 4.969	28	28
6	5.950 - 5.969	28	28
7	6.950 - 6.972	28	28
8	7.950 - 7.972	28	28
9	8.950 - 8.972	28	28
10	9.950 - 9.976	28	28
11	10.950 - 10.976	28	28
12	11.950 - 11.976	28	28
14	13.950 - 13.976	28	28
16	15.936 - 15.969	26	26
18	17.936 - 17.969	26	26
20	19.936 - 19.972	26	26
22	21.936 - 21.972	26	26
24	23.936 - 23.976	26	26
26	25.936 - 25.976	24	24
28	27.934 - 27.976	24	24
30	29.924 - 29.969	24	24
32	31.924 - 31.976	24	24
34	33.924 - 33.976	24	24
36	35.924 - 35.988	24	24
38	37.912 - 37.976	24	24
40	39.912 - 39.976	24	24
42	41.912 - 41.976	24	24
44	43.912 - 43.988	22	22
46	45.912 - 45.998	22	22
48	47.912 - 47.988	22	22
50	49.912 - 49.988	22	22
52	51.913 - 51.992	22	22
54	53.913 - 53.992	22	22
56	55.909 - 55.992	22	22
58	57.909 - 57.992	22	22
60	59.909 - 59.992	22	22

## Tolerances for Fittings



Ød <sub>1</sub> (inch)	Ødx Tolerance (inch) min.- max.	t* (gauge)	Die Stamped t** (gauge)	Fabricated t** (gauge)	e (inch)
3	2.902 - 2.917	28	24	-----	1.625
4	3.902 - 3.917	28	24	-----	1.625
5	4.902 - 4.917	28	24	-----	1.625
6	5.898 - 5.917	28	24	-----	1.625
7	6.894 - 6.913	28	24	-----	1.625
8	7.890 - 7.913	28	24	-----	1.625
9	8.886 - 8.909	28	24	-----	1.625
10	9.882 - 9.909	28	24	-----	2.375
11	10.882 - 10.909	28	24	-----	2.375
12	11.882 - 11.909	28	24	-----	2.375
14	13.878 - 13.909	28	-----	24	2.375
16	15.862 - 15.898	26	-----	24	3.125
18	17.862 - 17.898	26	-----	24	3.125
20	19.858 - 19.898	24	-----	24	3.125
22	21.858 - 21.898	24	-----	24	3.125
24	23.854 - 23.898	24	-----	24	3.125
26	25.854 - 25.898	22	-----	22	3.125
28	27.846 - 27.894	22	-----	22	4.000
30	29.839 - 29.886	22	-----	22	4.000
32	31.835 - 31.886	22	-----	22	4.000
34	33.835 - 33.886	22	-----	22	4.000
36	35.831 - 35.886	22	-----	22	4.000
38	37.819 - 37.874	22	-----	20	4.000
40	39.819 - 39.874	22	-----	20	4.750
42	41.819 - 41.874	22	-----	20	4.750
44	43.815 - 43.874	20	-----	20	4.750
46	45.815 - 45.874	20	-----	20	4.750
48	47.815 - 47.874	20	-----	20	4.750
50	49.815 - 49.874	20	-----	20	4.750
52	51.811 - 51.874	20	-----	20	4.750
54	53.811 - 53.874	20	-----	20	4.750
56	55.799 - 57.862	20	-----	20	4.750
58	57.799 - 57.862	20	-----	20	4.750
60	59.795 - 59.862	22	-----	20	4.750

\* Latest SMACNA HVAC Duct Construction Standards for +10" wg  
 \*\* Linx Industries Manufacturing Standard  
 "-----" = Not currently available

## Length Tolerances

Length - L, H, e, D, d (inch)	Tolerances (inch)
1 - 10	± 1/8
12 - 16	± 3/16
18 - 28	± 1/4
30 - 50	± 1/2
52 - 60	± 3/4

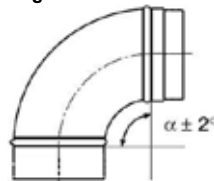
### Weight Tolerance

±10%

### Thickness Tolerance

±10%

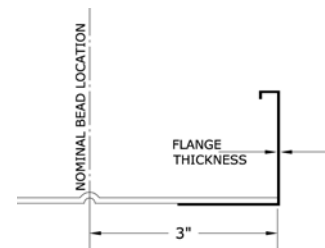
### Angular Tolerance



## Fitting Dimension For Flange Connections

Our products are designed with a male/female slip connections. For Linx Safe Connections, refer to the e-dimension listed in the chart above.

Factory-applied Flange	
Collar Length	Make-up Length
3"	3" + flange thickness



## Surface/Finish

Stainless steel fittings provided with a 2B mill finish.

Coated products have a minimum surface hardness of 2H when tested per ASTM D33-63-92A with an average thickness of 4 mils. ProCoat™ (OD only) or ProCoat™ Plus (ID & OD) coated duct.

# Acoustical Performance

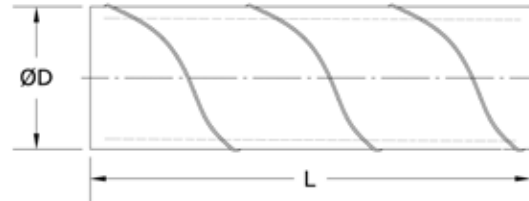
## NET INSERTION LOSS

Standard 1" thick double wall with perforated inner

Duct Diameter (in)	Insulation Thickness (in)	Velocity (fpm)	Octave Band / Frequency (Hz)							
			1	2	3	4	5	6	7	8
			63	125	250	500	1000	2000	4000	8000
6	1	0	0.3	0.5	1.2	2.1	2.5	2.3	2.3	2.1
		1000	0.2	0.5	1.2	2.1	2.3	2.3	2.3	2.2
		2000	0.2	0.5	1.2	2.1	2.5	2.4	2.3	2.3
		3000	0.1	0.5	1.2	2.1	2.2	2	2.3	2.3
2	1	0	0.1	0.3	0.7	1.7	2.5	2.5	1.9	1.6
		1000	0.1	0.3	0.7	1.6	2.5	2.5	2	1.7
		2000	0.1	0.3	0.7	1.6	2.4	2.5	2.1	1.8
		3000	0.1	0.3	0.7	1.5	2	2.1	2.1	1.9
18	1	0	0.3	0.3	0.6	1.5	2.5	2.3	1.6	1.4
		1000	0.3	0.3	0.6	1.4	2.6	2.4	1.6	1.4
		2000	0.2	0.2	0.6	1.4	2.5	2.3	1.6	1.4
		3000	0.2	0.1	0.6	1.3	2.3	2.3	1.5	1.4
24	1	0	0.2	0.2	0.5	1.2	2.7	1.7	1.3	1.4
		1000	0.2	0.2	0.5	1.2	2.7	1.6	1.3	1.2
		2000	0.2	0.2	0.5	1.2	2.7	1.6	1.2	1.2
		3000	0.3	0.2	0.4	1.1	2.6	1.7	1.2	1.3
30	1	0	0.1	0.2	0.4	1.3	2.1	1.3	1.2	1.2
		1000	0.1	0.2	0.4	1.3	2.1	1.2	1.1	1.1
		2000	0.1	0.2	0.4	1.3	2.1	1.2	1.1	1.1
		3000	0.1	0.2	0.4	1.3	2	1.2	1	1.1
36	1	0	0.1	0.2	0.3	1.1	1.6	1.2	1	0.9
		1000	0.1	0.2	0.3	1.1	1.6	1.1	0.9	0.9
		2000	0.1	0.2	0.3	1.1	1.6	1	0.9	0.9
		3000	0.1	0.2	0.3	1	1.5	1	0.9	0.9
42	1	0	0.1	0.1	0.3	1.1	1.2	1	0.8	0.8
		1000	0.1	0.2	0.3	1.1	1.1	1	0.7	0.6
		2000	0.1	0.2	0.3	1.1	1	0.9	0.7	0.6
		3000	0.1	0.2	0.3	1	1	0.9	0.7	0.6

- The Net Insertion Loss chart represents tests performed by an independent testing laboratory in accordance with ASTM standard E477-96, entitled "Standard Method of Testing Duct Liner Materials and Prefabricated Silencers for Acoustical and Airflow Performance". Data for test specimens with inside diameters of 6", 12", 18", 24", 30", 36" and 42" were recorded for 20' lengths of duct and then divided to obtain the dB/foot ratings.
- Insertion loss gains of approximately 0.25 to 0.50 dB/ft in the 4th, 5th, and 6th octave bands were recorded for 24" diameter duct with 2" thick insulation. Gains were negligible in the 1st, 2nd, 3rd, 7th and 8th octave bands.
- Data recorded for a 30' section of 24" diameter duct indicates an average gain of 1 dB in the 2nd octave band, 3 dB in the 3rd octave band, 9 dB in the 4th octave band, 1 dB in the 5th octave band, 4 dB in the 6th octave band, 4 dB in the 7th octave band and 3 dB in the 8th octave band. These gains were the average for insertion loss data collected at 0, 1000, 2000 and 3000 fpm with 0.000, 0.006, 0.031, and 0.070 inch water gauge respectively.
- Data was not collected for duct lengths greater than 30'. However, the results for the 30' test indicate the insertion loss gains diminish with longer duct lengths. For this reason, the data in the above table should be considered valid only for sections of duct 20' or less in length. In addition, data was not collected for larger diameter duct. As the test data indicates, insertion loss decreases with increasing duct diameters.
- The self-generated noise for double wall duct is too low to be measured by ASTM E477-96. The measurements obtained for these ducts are equal to the corresponding single wall duct reference condition or are within +/- 10 dB per ASTM E477-96 section 9.1.2.
- Reduced breakout noise in double wall duct with outer diameter 14" and larger is attributed to double corrugation which increases rigidity and minimizes the area of the outer shell that allows sound waves to break out of the system.





## Description

spiral lock seam duct

- SMACNA RL-1 spiral seam
- evenly spaced integral seam locking feature
- multiple corrugations on all duct 8" diameter and larger
- standard length: 120"
- standard inner liner: perforated
  - solid inner liner optional
- built in accordance with the latest SMACNA HVAC Duct Construction Standard for +10 iwg
- Linx SAFE single-slip double wall systems are offered up through 60" OD
- Linx non-gasketed double wall spiral duct is also available
  - Linx non-gasketed double wall spiral is available for OD sizes >60" (call factory for more information)

## Dimensions

- Standard length = 120" (10 LF)
- Available in lengths\*:
  - 5" - 10" OD: 12" - 240"
  - 10" - 60 OD: 16" - 240"

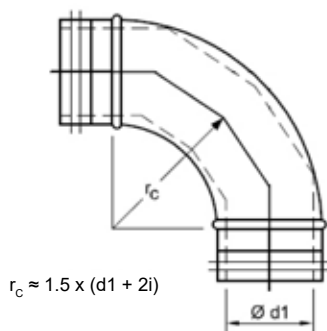
*\*Note: Double Wall spiral duct constructed from aluminum has a max length of 120"*



### Description

#### 90° elbow

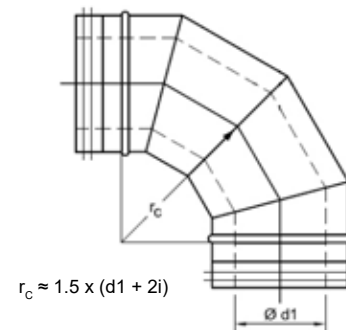
- inner shell
  - solid, die-stamped
  - continuously stitch welded
- outer shell
  - die stamped
  - continuously stitch welded
  - rolled edges
- available in  $\text{\O} 3\text{'-}10\text{'}$  with 1" insulation
  - optional: 2" insulation in  $\text{\O} 3\text{'-}8\text{'}$



### Description

#### 90° elbow

- inner shell
  - solid, gored
- outer shell
  - 5-gore standing seam
  - gore locked and internally sealed
  - rolled edges
- note: BF/U 90 elbows 48-inch diameter and larger will be supplied as two BF/G 45° elbows and an MF coupling
- available in  $\text{\O} 12\text{'-}58\text{'}$  with 1" insulation
  - optional: 2" insulation in  $\text{\O} 8\text{'-}56\text{'}$

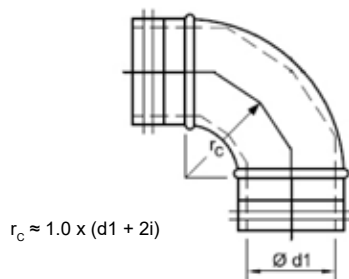




Description

90° elbow

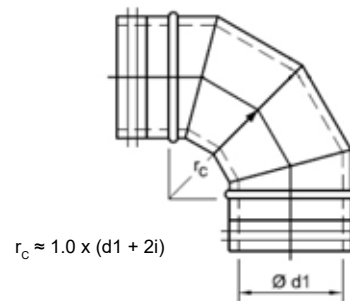
- inner shell
  - solid, die-stamped
  - continuously stitch welded
- outer shell
  - die stamped
  - continuously stitch welded
  - rolled edges
- available in Ø 5"-12" OD



Description

90° elbow

- inner shell
  - solid, gored
- outer shell
  - 4-piece gored, standing seam
  - gore locked and internally sealed
- available in Ø 14"-50" OD

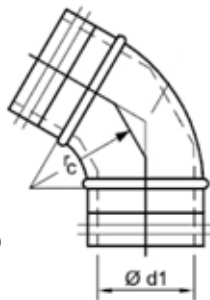




Description

60° elbow

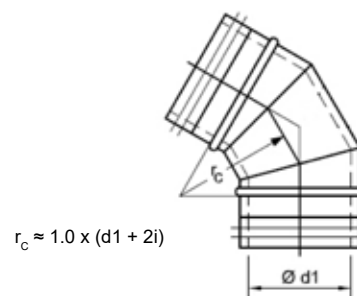
- inner shell
  - solid, die stamped
  - continuous stitch welded
- outer shell
  - die-stamped
  - continuously stitch welded
  - rolled edges
- available in Ø 5"-12" OD



Description

60° elbow

- inner shell
  - solid, gored
- outer shell
  - 3-piece gored, standing seam
  - gore locked and internally sealed
- available in Ø 14"-50" OD

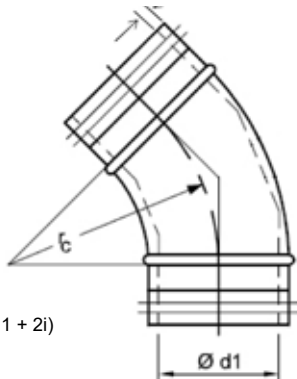




### Description

45° elbow

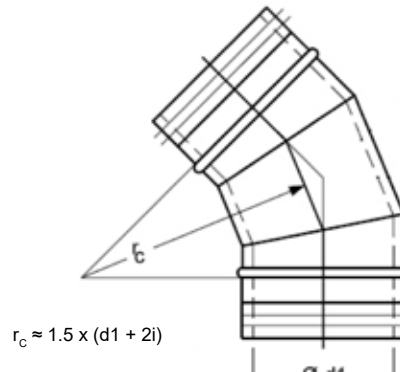
- inner shell
  - solid, die stamped
  - continuous stitch welded
- outer shell
  - die-stamped
  - continuous stitch welded
  - rolled edges
- available in Ø 5"-12" OD



### Description

45° elbow

- inner shell
  - solid, gored
- outer shell
  - 3-piece gored, standing seam
  - gore locked and internally sealed
  - rolled edges
- available in Ø 14"-60" OD

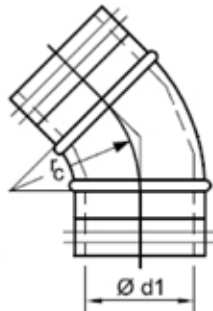




### Description

#### 45° elbow

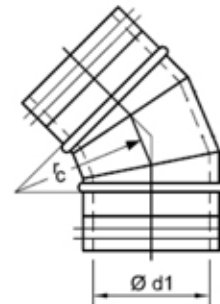
- inner shell
  - solid, die stamped
  - continuous stitch welded
- outer shell
  - die-stamped
  - continuously stitch welded
  - rolled edges
- available in Ø 5"-12" OD



### Description

#### 45° elbow

- inner shell
  - solid, gored
- outer shell
  - 3-piece gored, standing seam
  - gore locked and internally sealed
  - rolled edges
- available in Ø 14"-60" OD

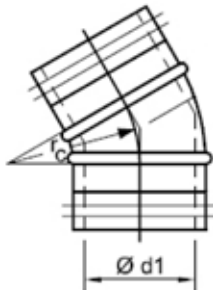




### Description

#### 30° elbow

- inner shell
  - solid, die stamped
  - continuous stitch welded
- outer shell
  - die-stamped
  - continuous stitch welded
  - rolled edges
- available in Ø 5"-12" OD



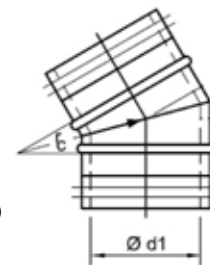
$$r_c \approx 1.0 \times (d1 + 2i)$$



### Description

#### 30° elbow

- inner shell
  - solid, gored
- outer shell
  - 2-piece gored, standing seam
  - gore locked and internally sealed
  - rolled edges
- available in Ø 14"-60" OD



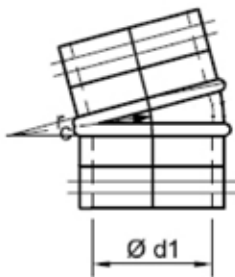
$$r_c \approx 1.0 \times (d1 + 2i)$$



## Description

### 15° elbow

- inner shell
  - solid, die stamped
  - continuous stitch welded
- outer shell
  - die-stamped
  - continuous stitch welded
  - rolled edges
- available in Ø 5"-12" OD



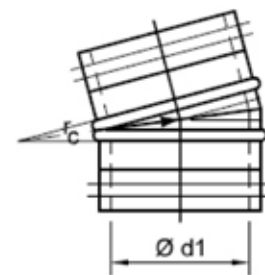
$$r_c \approx 1.0 \times (d_1 + 2i)$$



## Description

### 15° elbow

- inner shell
  - solid, gored
- outer shell
  - 2-piece gored, standing seam
  - gore locked and internally sealed
  - rolled edges
- available in Ø 14"-60" OD



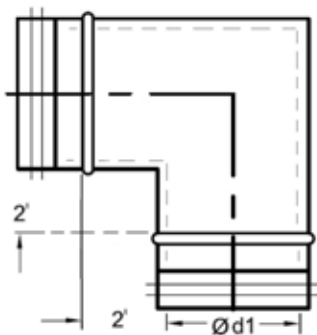
$$r_c \approx 1.0 \times (d_1 + 2i)$$



Description

mitered elbow

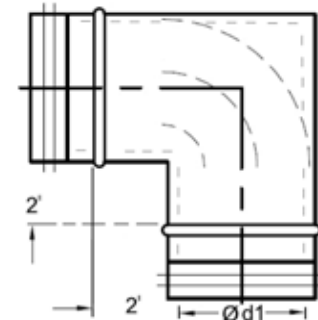
- rolled edge
- 2" standard throat length
- available in  $\text{Ø } 14\text{"-}50\text{" OD}$



Description

mitered elbow with vanes

- rolled edge
- 2" standard throat length
- turning vanes evenly spaced
- number of vanes vary by diameter
  - $\text{Ø } 4\text{"-}10\text{"} = 2$  vanes
  - $\text{Ø } 112\text{"-}14\text{"} = 3$  vanes
  - $\text{Ø } 16\text{"-}20\text{"} = 4$  vanes
  - $\text{Ø } 22\text{"-}58\text{"} = 5$  vanes
- available in  $\text{Ø } 14\text{"-}50\text{" OD}$



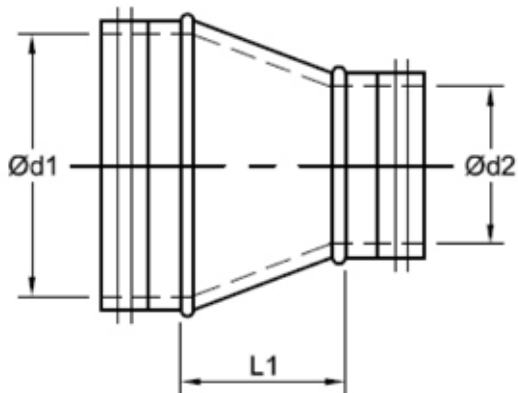


Description

fabricated concentric reducer

•  $L1 = (\text{Ø}d1 + 2i) - (\text{Ø}d2 + 2i)^*$

( \* ) minimum 4"



Description

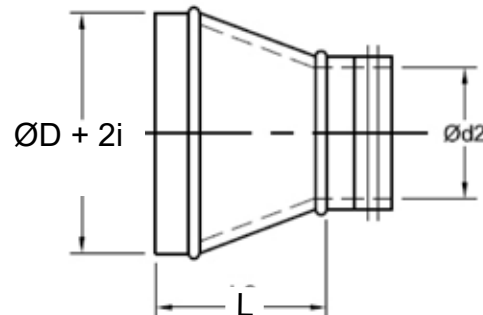
fabricated concentric reducer

•  $\text{Ø}D + 2i =$  duct size slips over Linx Safe double wall fittings

•  $i =$  insulation thickness (in)

•  $L = [(\text{Ø}D1 + 2i) - (\text{Ø}d2 + 2i)]^* + e$  dimension

( \* ) minimum 4"



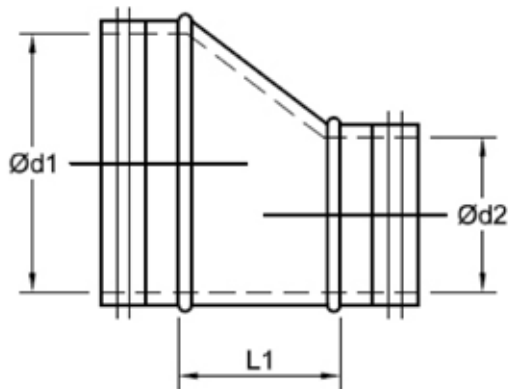


Description

fabricated eccentric reducer

•  $L1 = (\text{Ø}d1 + 2i) - (\text{Ø}d2 + 2i)^*$

( \* ) minimum 4"



Description

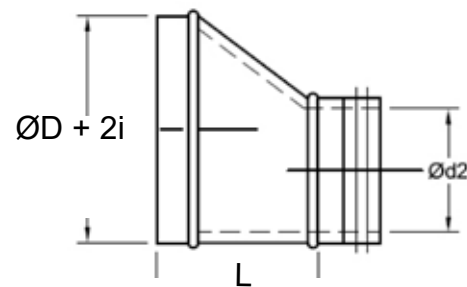
fabricated eccentric reducer

•  $\text{Ø}D + 2i =$  duct size slips over Linx Safe double wall fittings

•  $i =$  insulation thickness (in)

•  $L = [(\text{Ø}D + 2i) - (\text{Ø}d2 + 2i)]^* + e$  dimension

( \* ) minimum 4"



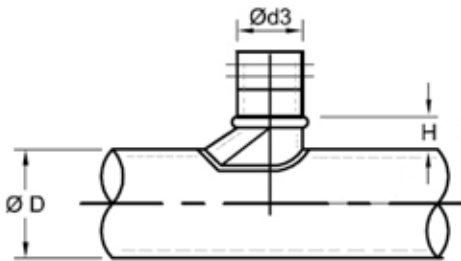


Description

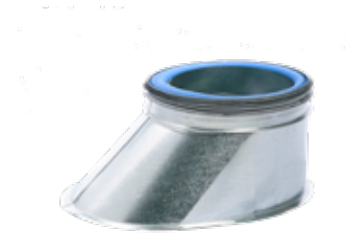
- 45° combination boot-style saddle tap
- New One Piece Design
  - No assembly needed

Dimension

- If  $\text{Ød3} + 2i \leq 8"$ ,  $H = 4"$
- If  $\text{Ød3} + 2i = 9"-14"$ ,  $H = 7"$
- If  $\text{Ød3} + 2i = 15"-26"$ ,  $H = 10"$
- If  $\text{Ød3} + 2i = 27"-46"$ ,  $H = 13"$
- If  $\text{Ød3} + 2i = 47"-60"$ ,  $H = 16"$



See Page 5 for full Smart Part Anatomy and all available options.  
All sizes refer to inside dimensions. Linx Safe comes with 1" insulation thicknesses standard and 2" as an option. 3" and 4" thicknesses are available in nongasketed only.  
We reserve the right to make changes without prior notice. Therefore, all designs, specifications, and product features are subject to change without notice.  
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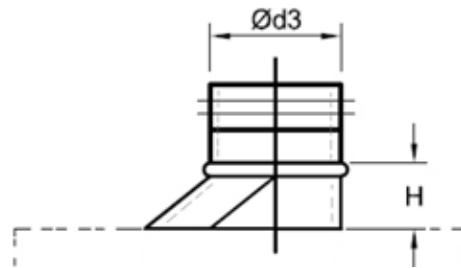


Description

- 45° boot-style tap
- New One Piece Design
  - No assembly needed
  - installed on flat side of duct or plenum

Dimension

- If  $\text{Ød3} + 2i \leq 8"$   $H = 4"$
- If  $\text{Ød3} + 2i = 9"-14"$ ,  $H = 7"$
- If  $\text{Ød3} + 2i = 15"-26"$ ,  $H = 10"$
- If  $\text{Ød3} + 2i = 27"-46"$ ,  $H = 13"$
- If  $\text{Ød3} + 2i = 47"-60"$ ,  $H = 16"$





pressed PSUI



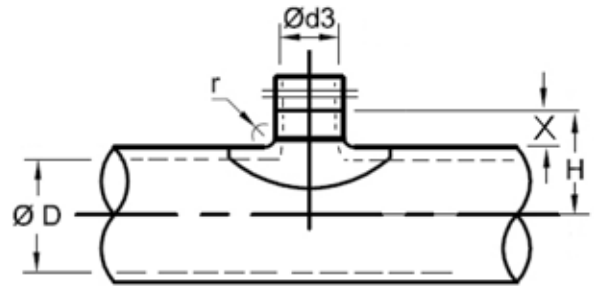
fabricated PSUI

### Description

saddle tap

- New One Piece Design
- No assembly needed
- pressed:
  - radius entry
  - limited to galvanized steel only
  - available in  $\text{Ød3}$  or tap diameters 3"-16", exceptions listed below
  - X-dimensions listed on right
- fabricated
  - sizes listed below
  - $X = 1"$

Fabricated Sizes										
$\text{Ød3}$	$\text{ØD}$									
	8	9	10	12	14	16	18	20	22	24
3	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
7					✓	✓	✓	✓	✓	✓
12										✓
14					✓	✓	✓	✓	✓	✓



### Dimension

•  $H = X + 0.5(\text{ØD})$

X - Dimensions		
$\text{Ød3}$ (inch)	Pressed Radius = r (in)	Fab Tap Height = x (in)
3	3/4	1
4	1	1
5	1	1
6	1	1
7	1	1
8	1	1
9	1	1
10	1 1/8	1
12	n/a	1
14	3/4	1
16	7/8	1
18	n/a	1
20	n/a	1
22	n/a	1
24	n/a	1
For $\text{Ød3} \geq 24"$ , $X = 1"$		



## Description

fabricated 45° lateral tap for round

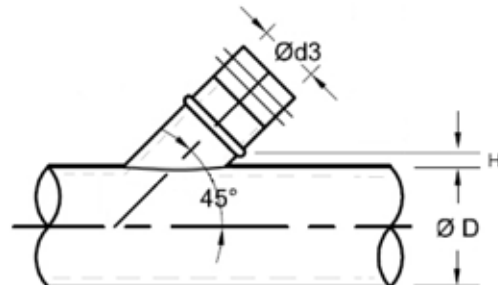
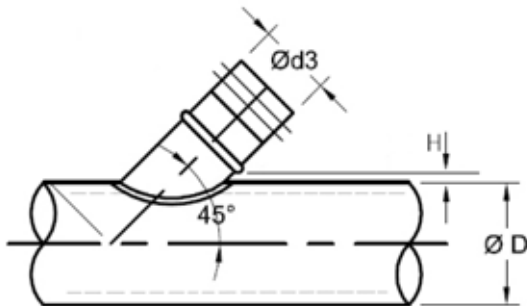
- New One Piece Design
- No assembly needed
- H = 2.5"
- special order: 15°, 30°, 60°



## Description

fabricated 45° lateral tap for flat surface

- New One Piece Design
- No assembly needed
- H = 2.5"
- special order: 15°, 30°, 60°

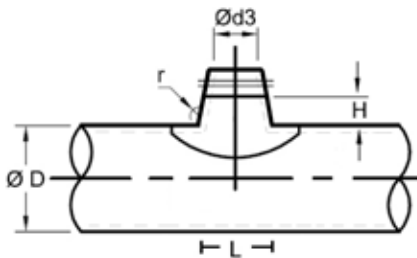




Description

conical saddle tap

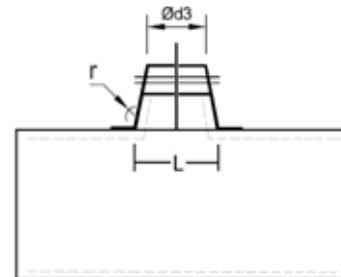
- New one piece design
- No assembly needed
- H = 6"
- i = insulation thickness (in)
- L =  $\text{Ød3} + 2i + 2$



Description

conical tap for flat surface

- New one piece design
- No assembly needed
- H = 6"
- i = insulation thickness (in)
- L =  $\text{Ød3} + 2i + 2$
- flat lip =  $\frac{3}{8}$ " -  $\frac{5}{8}$ " depending on diameter

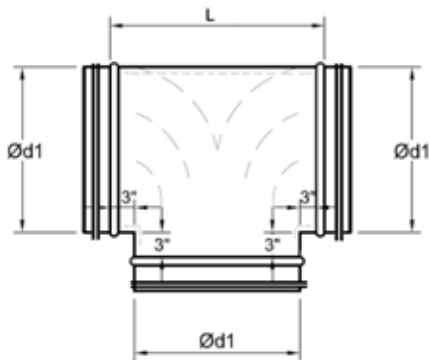




### Description

bullhead tee

- $i$  = insulation thickness (in)
- $L = \text{Ø}d1 + 6" + 2i$

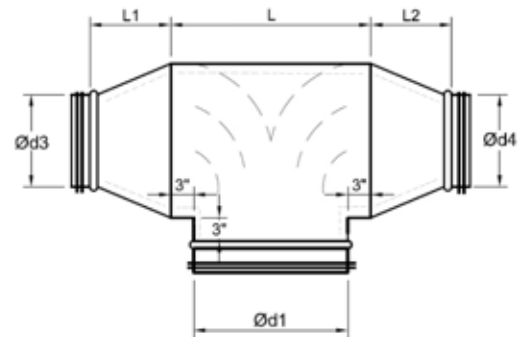


### Description

bullhead reducing tee

- $i$  = insulation thickness (in)
- $L = \text{Ø}d1 + 6" + 2i$
- $L1 = (\text{Ø}d1 - \text{Ø}d3)^*$
- $L2 = (\text{Ø}d1 - \text{Ø}d4)^*$

( \* ) minimum 4"

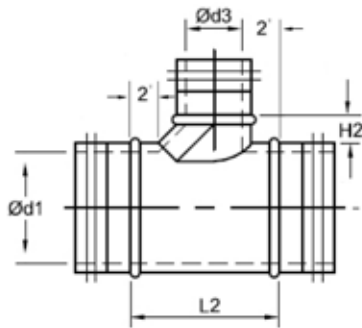




### Description

45° boot-style tee

- assembled with TBSRUI tap
- $\text{Ød3} \leq \text{Ød1}$
- $i$  = insulation thickness (in)
- $L2 = \text{Ød3} + 2i + H2 + 4"$
- If  $\text{Ød3} + 2i \leq 8"$ ,  $H2 = 4"$ ,  
 If  $\text{Ød3} + 2i = 9-14"$ ,  $H2 = 7"$ ,  
 If  $\text{Ød3} + 2i = 15-26"$ ,  $H2 = 10"$ ,  
 If  $\text{Ød3} + 2i = 27-46"$ ,  $H2 = 13"$ , and  
 If  $\text{Ød3} + 2i = 47-60"$ ,  $H2 = 16"$ .

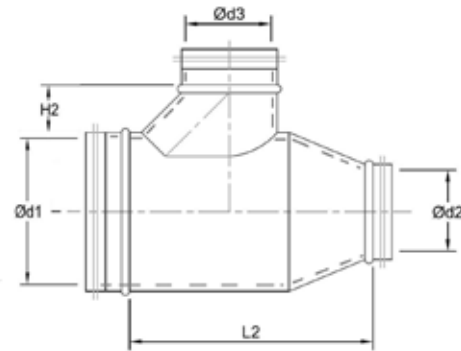


### Description

45° boot-style tee with reducer

- assembled with TBSRUI tap
- $\text{Ød3} \leq \text{Ød1}$
- $i$  = insulation thickness (in)
- $L2 = (\text{Ød3} + 2i + H2 + 4") + [(\text{Ød1} + 2i) - (\text{Ød2} + 2i)]^*$
- If  $\text{Ød3} + 2i \leq 8"$ ,  $H2 = 4"$ ,  
 If  $\text{Ød3} + 2i = 9-14"$ ,  $H2 = 7"$ ,  
 If  $\text{Ød3} + 2i = 15-26"$ ,  $H2 = 10"$ ,  
 If  $\text{Ød3} + 2i = 27-46"$ ,  $H2 = 13"$ , and  
 If  $\text{Ød3} + 2i = 47-60"$ ,  $H2 = 16"$ .

(\* ) minimum of 4"



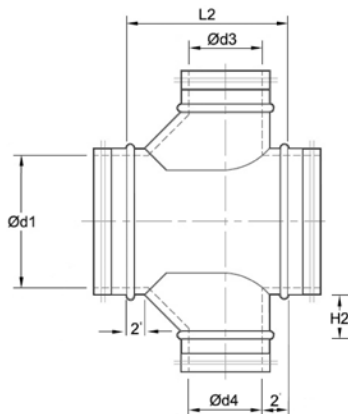
# Crossing Tees



## Description

### 45° boot-style crossing tee

- assembled with TBSRUI taps
- $\text{Ød3}$  and  $\text{Ød4} \leq \text{Ød1}$
- $\text{Ød3} \geq \text{Ød4}$
- $i$  = insulation thickness (in)
- $L = \text{Ød3} + 2i + H2 + 4"$
- If  $\text{Ød3} + 2i \leq 8"$ ,  $H2 = 4"$ ,
- If  $\text{Ød3} + 2i = 9-14"$ ,  $H2 = 7"$ ,
- If  $\text{Ød3} + 2i = 15-26"$ ,  $H2 = 10"$ ,
- If  $\text{Ød3} + 2i = 27-46"$ ,  $H2 = 13"$ , and
- If  $\text{Ød3} + 2i = 47-60"$ ,  $H2 = 16"$ .

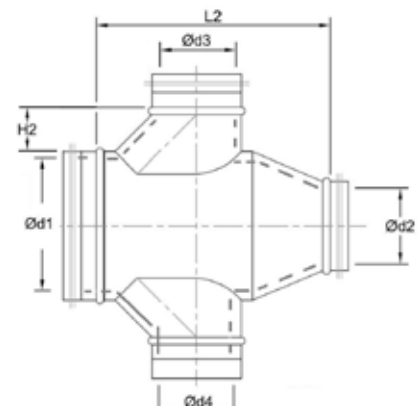


## Description

### 45° boot-style crossing tee with reducer

- assembled with TBSRUI taps
- $\text{Ød3}$  and  $\text{Ød4} \leq \text{Ød1}$
- $\text{Ød3} \geq \text{Ød4}$
- $i$  = insulation thickness (in)
- $L = (\text{Ød3} + 2i + H2 + 4") + [(\text{Ød1} + 2i) - (\text{Ød2} + 2i)]^*$
- If  $\text{Ød3} + 2i \leq 8"$ ,  $H2 = 4"$ ,
- If  $\text{Ød3} + 2i = 9-14"$ ,  $H2 = 7"$ ,
- If  $\text{Ød3} + 2i = 15-26"$ ,  $H2 = 10"$ ,
- If  $\text{Ød3} + 2i = 27-46"$ ,  $H2 = 13"$ , and
- If  $\text{Ød3} + 2i = 47-60"$ ,  $H2 = 16"$

(\* ) minimum of 4"

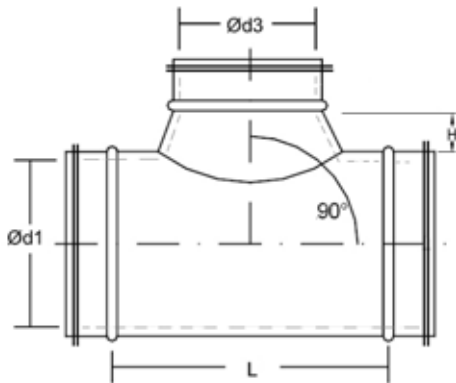




Description

conical tee

- $i$  = insulation thickness (in)
- $L = \text{Ø}d3 + 8" + 2i$
- $H = 6"$
- $\text{Ø}d1$  must be 2" or larger than  $\text{Ø}d3$

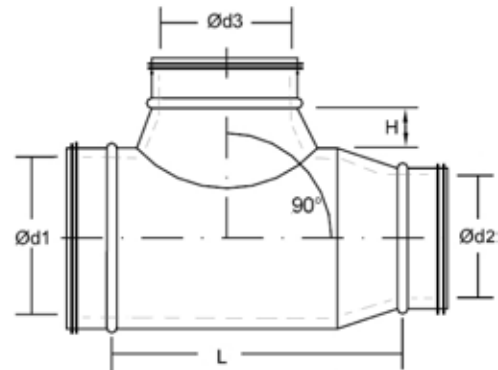


Description

conical reducing tee

- $i$  = insulation thickness (in)
- $L = (\text{Ø}d3 + 8" + 2i) + [(\text{Ø}d1 + 2i) - (\text{Ø}d2 + 2i)]^*$
- $H = 6"$
- $\text{Ø}d1$  must be 2" or larger than  $\text{Ø}d3$

(\* ) minimum of 4"



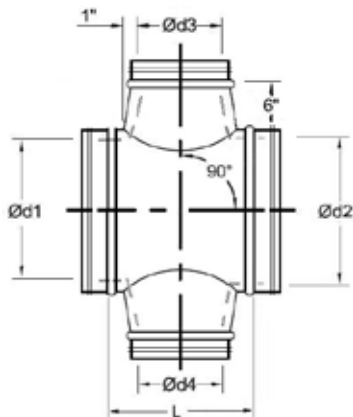
# Crossing Tees



## Description

conical crossing tee

- $i$  = insulation thickness (in)
- $L = \text{Ø}d3 + 8" + 2i$
- $H = 6"$
- $\text{Ø}d3 \geq \text{Ø}d4$
- $\text{Ø}d1$  must be 2" or larger than  $\text{Ø}d3$

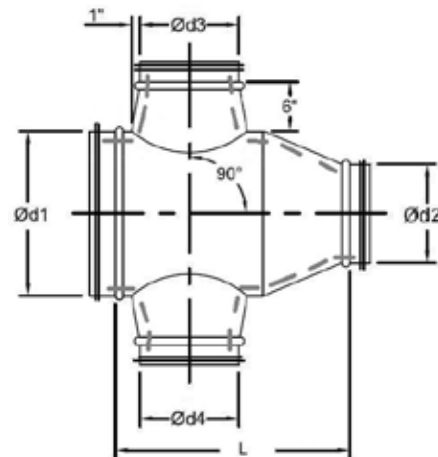


## Description

conical reducing crossing tee

- $i$  = insulation thickness (in)
- $L = (\text{Ø}d3 + 8" + 2i) + [(\text{Ø}d1 + 2i) - (\text{Ø}d2 + 2i)]^*$
- $H = 6"$
- $\text{Ø}d1$  must be 2" or larger than  $\text{Ø}d3$
- $\text{Ø}d3 \geq \text{Ø}d4$

( \* ) minimum of 4"

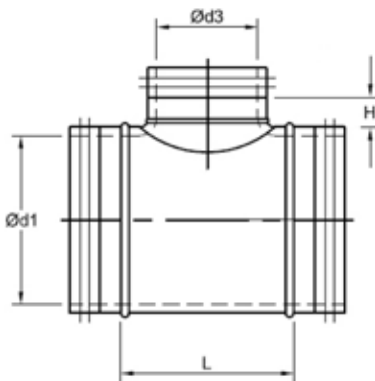




Description

assembled straight tee with die-stamped or fabricated PSU

- i = insulation thickness (in)
- $L = \text{Ø}d3 + 6'' + 2i$
- see page 28 for tap height details

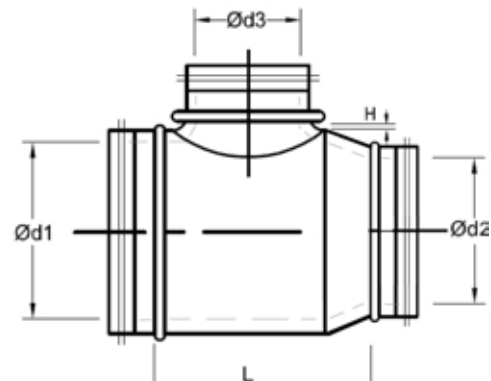


Description

assembled straight reducing tee with die-stamped or fabricated PSU

- i = insulation thickness (in)
- $L = (\text{Ø}d3 + 6'' + 2i) + [(\text{Ø}d1 + 2i) - (\text{Ø}d2 + 2i)]^*$
- see page 28 for tap height details

( \* ) minimum of 4"



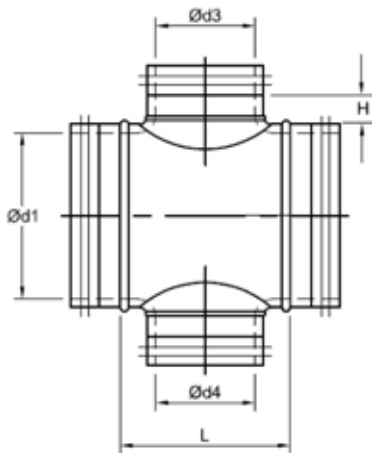
# Crossing Tees



## Description

assembled crossing tee with die-stamped or fabricated PSUI

- $\text{Ød3} \geq \text{Ød4}$
- $i$  = insulation thickness (in)
- $L = [\text{Ød3} + 2i] + 6"$
- see page 28 for tap height details

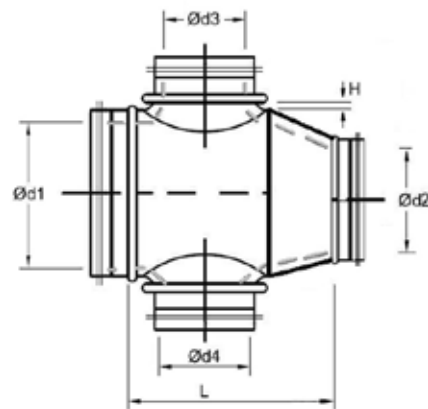


## Description

assembled reducing crossing tee with die-stamped or fabricated PSUI

- $\text{Ød3} \geq \text{Ød4}$
- $i$  = insulation thickness (in)
- $L = (\text{Ød3} + 6" + 2i) + [(\text{Ød1} + 2i) - (\text{Ød2} + 2i)]^*$
- see page 28 for tap height details

( \* ) minimum of 4"



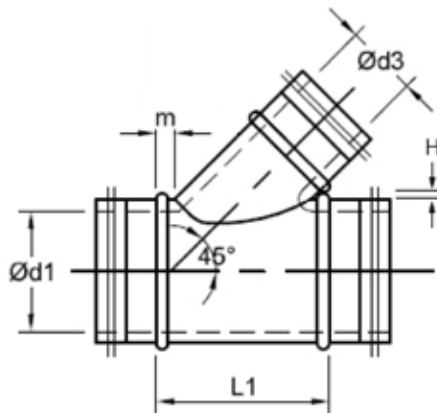


### Description

#### 45° lateral tee

- i = insulation thickness (in)
- $L1 = [\text{Ø}d3 + 2i][1/\sin(a)] + 4"$
- H = 2.5" (constant)(throat height)
- special order: 15° - 30° - 60°  
i.e. TVU 15° - aa - bb

Note: Use outer shell dimensions to locate tap on the fitting body

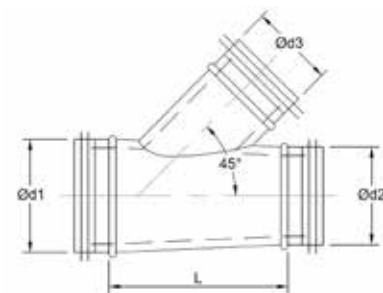


### Description

#### 45° lateral reducing tee

- i = insulation thickness (in)
- $L = [\text{Ø}d3 + 2i][1/\sin(a)] + 4" + [(\text{Ø}d1 + 2i) - (\text{Ø}d2 + 2i)]^*$
- H = 2.5" (constant)(throat height)

(\* ) minimum of 4



# Crossing Tees

XV45 / XRV45

Old Designations | XVUI / XVRUI

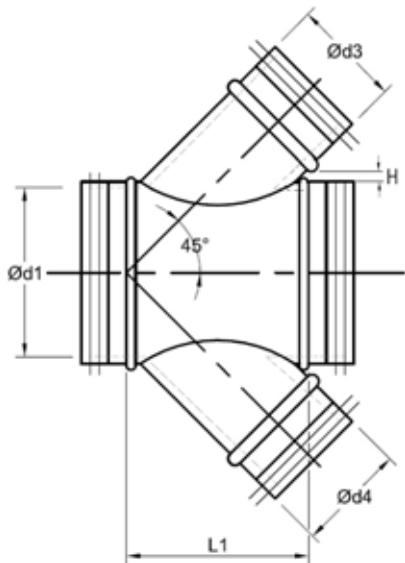
35



## Description

45° lateral crossing tee

- following dimension data for  $\text{Ød4} = \text{Ød3}$
- $\text{Ød3} \geq \text{Ød4}$
- $i$  = insulation thickness (in)
- $L1 = [\text{Ød3} + 2i][1/\sin(a)] + 4"$
- $H = 2.5"$  (constant)(throat height)
- special order: 15°- 30°- 60°  
i.e. XVU 15° - aa - bb - cc

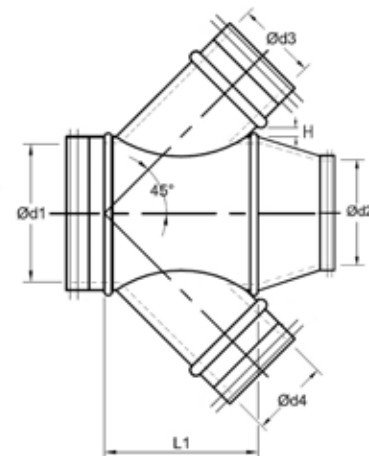


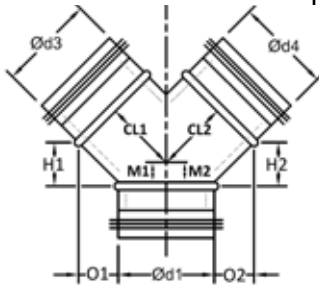
## Description

45° lateral reducing crossing tee

- $\text{Ød3} \geq \text{Ød4}$
- $i$  = insulation thickness (in)
- $L1 = [\text{Ød3} + 2i][1/\sin(a)] + 4" + [(\text{Ød1} + 2i) - (\text{Ød2} + 2i)]^*$
- $H = 2.5"$  (constant)(throat height)

( \* ) minimum of 4"





### Description

45° directional split fitting

- special order: 15°, 30°, 60°
- special order: Ød3 or Ød4 < Ød1
- special order: Ød3 ≤ Ød4
- i = insulation thickness (in)

### Dimension (45° shown)

$$H1 = \left[ \frac{(d3 \times 0.5) + (d1 \times 0.9)}{\tan(45)} \right] \times \cos(45) - \frac{d3 \times 0.5}{\sin(45)}$$

$$O1 = \left[ \frac{(d3 \times 0.5) + (d1 \times 0.8)}{\tan(45)} \right] \times \sin(45) - (d1 \times 0.5)$$

$$H2 = \left[ \frac{(d4 \times 0.5) + (d1 \times 0.9)}{\tan(45)} \right] \times \cos(45) - \frac{d4 \times 0.5}{\sin(45)}$$

$$O2 = \left[ \frac{(d4 \times 0.5) + (d1 \times 0.8)}{\tan(45)} \right] \times \sin(45) - (d1 \times 0.5)$$

$$M1 = H1 + (d3 \times 0.5)(\cos(45)) - (d1 \times 0.5) + O1 - (d3 \times 0.5)(\cos(45))$$

$$CL1 = \frac{(d1 \times 0.5) + O1 - (d3 \times 0.5)(\cos(45))}{\cos(45)}$$

$$CL2 = \frac{(d1 \times 0.5) + O2 - (d4 \times 0.5)(\cos(45))}{\cos(45)}$$

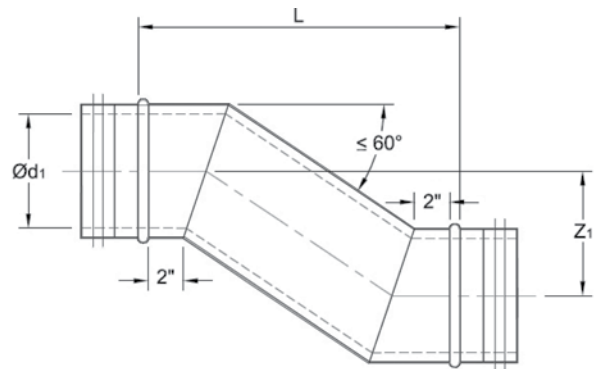


### Description

one-piece offset

- 60° max angle of convergence
- i = insulation thickness (in)
- max offset Z1 ≤ (Ød1+2i) / 2
- max length L = 60"

Note: SMACNA recommends that offsets be 30° or less

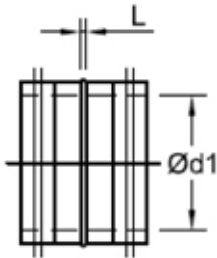




## Description

coupling used for joining double wall spiral duct

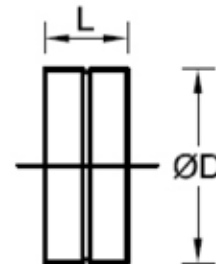
- If  $\text{Ø}$  3"-18",  $L = \frac{3}{8}"$ ,
- If  $\text{Ø}$  20"-24",  $L = \frac{1}{2}"$
- If  $\text{Ø}$  26"-58",  $L = \frac{5}{8}"$



## Description

noninsulated outer shell used for joining double wall fittings

- If  $\text{Ø}$  3"-7",  $L = \frac{3}{8}"$ ,
- If  $\text{Ø}$  8"-12",  $L = \frac{5}{8}"$ ,
- If  $\text{Ø}$  14"-18",  $L = \frac{6}{8}"$ ,
- If  $\text{Ø}$  20"-24",  $L = \frac{6}{4}"$ ,
- If  $\text{Ø}$  26"-42",  $L = \frac{8}{8}"$ ,
- If  $\text{Ø}$  44"-58",  $L = \frac{10}{8}"$

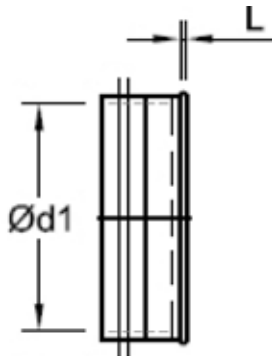




## Description

end cap for double wall spiral duct

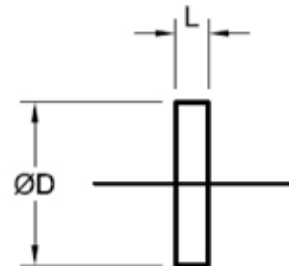
- If  $\text{Ø}$  3"-18",  $L = \frac{3}{8}$ "
- If  $\text{Ø}$  20"-24",  $L = \frac{1}{2}$ "
- If  $\text{Ø}$  26"-58",  $L = \frac{5}{8}$ "



## Description

end cap for fittings

- If  $\text{Ø}$  5"-7",  $L = 1\frac{5}{8}$ "
- If  $\text{Ø}$  8"-12",  $L = 2\frac{3}{8}$ "
- If  $\text{Ø}$  14"-24",  $L = 3\frac{1}{8}$ "
- If  $\text{Ø}$  26"-36",  $L = 4$ "
- If  $\text{Ø}$  38"-60",  $L = 4\frac{3}{4}$ "

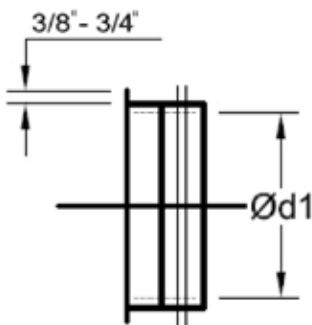




## Description

take-off/starting collar

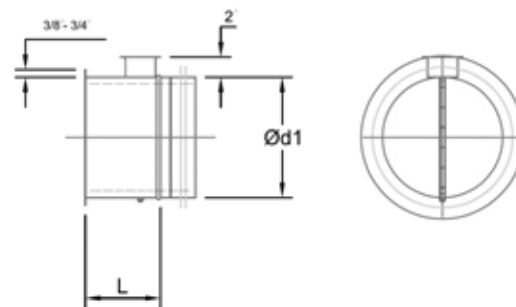
- installed on flat side of duct or plenum
- available in  $\text{\O} 3\text{'-}58\text{'}$  with 1" insulation
  - optional: 2" insulation in  $\text{\O} 3\text{'-}56\text{'}$



## Description

gasketed take-off with damper

- lengths (in):
  - diameters 4" - 7" :  $L = 5\frac{1}{2}\text{'}$
  - diameters 9" - 12" :  $L = 5\frac{5}{8}\text{'}$
  - diameters 14" - 22" :  $L = 6\frac{3}{8}\text{'}$
- shaft = 8 mm<sup>2</sup>
- 2" shaft extension available





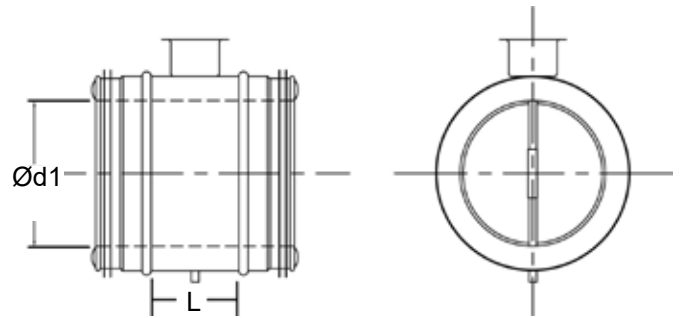
## Description

### Balancing damper

- for use in systems where a complete shut-off of air flow is not required
- gasketed shaft-mounted load bearing bushing to minimize air leakage
- integral shaft-blade assembly
- 2" sheet metal insulation stand-off
- locking blade quadrant w/damper position indicator
- full fitting body assembly with bead stop
- damper cup height = 2"

### Note:

- Dampers with  $\text{Ød1} > 12"$  equipped with extended handle and a reinforced damper blade.
- Dampers with  $\text{Ød1} > 22"$  have 2" bracket in place of cup-shaped stand-off.



## Dimension

$\text{Ød1}$	L	Shaft
inch	inch	mm <sup>2</sup>
4	3.9	8*
5	3.9	8*
6	3.9	8*
7	3.9	8*
8	3.5	8*
9	3.5	8*
10	3.5	8*
12	3.75	8*
14	3.75	8*
16	3.75	8*
18	3.75	8*
20	3.75	8*
22	3.75	8*
24	3.75	8*
26	3.75	8*
28	3.75	8*
30	3.75	8*
32	10.4	25.4**
34	10.4	25.4**
36	10.4	25.4**

\* 2" shaft extensions available  
\*\* 1" square tube shaft

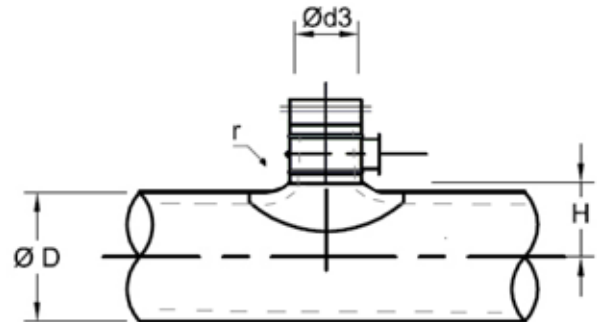
# Dampers



## Description

damper (DS) with saddle tap base

- shaft = 8 x 8 mm<sup>2</sup>
- 2" shaft extensions available
- refer to page 11 for "e" dimensions
- refer to page 28 for PS construction details (pressed/fabricated)



Available in the following sizes (✓):

Available Sizes									
ØD	Ød3								
	3	4	5	6	7	8	10	12	14
4	✓	✓							
5	✓	✓	✓						
6		✓	✓	✓					
7		✓	✓	✓	✓				
8		✓	✓	✓	✓	✓			
10		✓	✓	✓	✓	✓	✓		
12		✓	✓	✓		✓	✓	✓	
14		✓	✓	✓		✓	✓	✓	✓
16		✓	✓	✓		✓	✓	✓	✓
18		✓	✓	✓		✓	✓	✓	✓
20		✓	✓	✓		✓	✓	✓	✓
22		✓	✓	✓		✓	✓	✓	✓

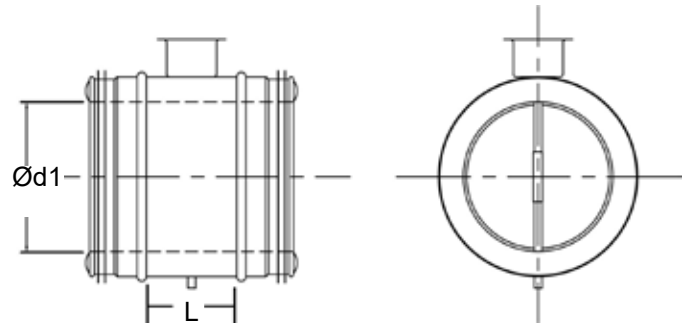


## Description

balancing damper with a gasketed blade for air-flow shut-off

- gasketed shaft-mounted load bearing bushing to minimize air leakage
- integral shaft-blade assembly
- 2" sheet metal insulation stand-off
- locking blade quadrant w/damper position indicator
- full fitting body assembly with bead stop
- shaft = 8 mm<sup>2</sup>
- 2" shaft extension available
- foam insulation stop (single slip Safe only)
- damper cup height = 2"
- Stainless steel construction available in Ø4", Ø6", Ø8", Ø10", and Ø12".
- Not available in aluminum.

Note: dampers with Ød1 > 12" have 2" extended handle and reinforced damper blade



## Dimension

Ød1	L	Shaft
inch	inch	mm <sup>2</sup>
4	3.9	8
5	3.9	8
6	3.9	8
7	3.9	8
8	3.5	8
9	3.5	8
10	3.5	8
12	3.75	8
14	3.75	8
16	3.75	8
18	3.75	8
20	3.75	8
22	3.75	8
24	3.75	8

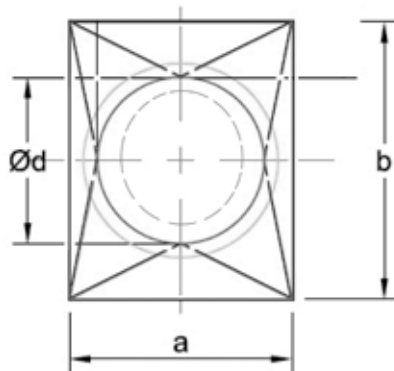
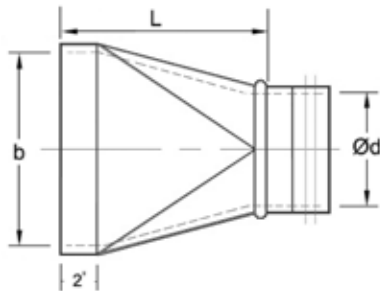
# Rectangular-to-Round



## Description

rectangular to round transition

- centerline
- available in  $\text{Ø}$  4"- 60"
- 2" raw edge rectangular end
- L = length, minimum 12"
- a = rectangular width
- b = rectangular height

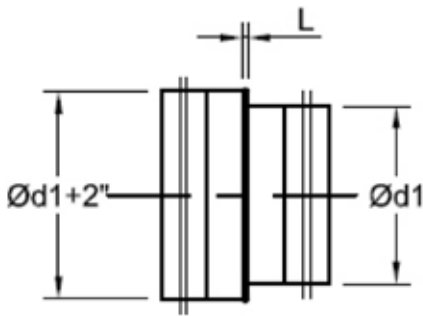




Description

double wall to single wall transition

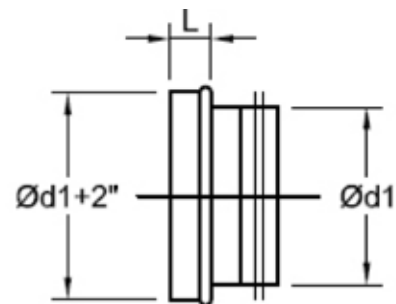
- slips into double wall spiral duct
- available  $\text{\O} 3''\text{-}58''$
- $L = \frac{1}{8}''$



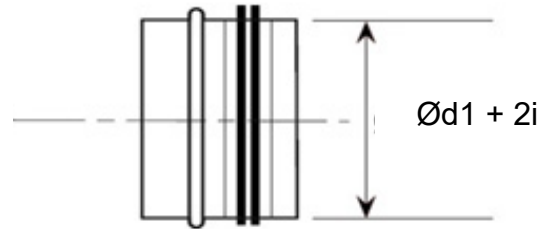
Description

double wall to single wall transition

- large end slips over double wall fittings
- available  $\text{\O} 3''\text{-}58''$
- Lengths (L):
  - $\text{\O} 3''\text{-}7''$ ,  $L = \frac{1}{8}''$
  - $\text{\O} 8''\text{-}12''$ ,  $L = \frac{2}{8}''$
  - $\text{\O} 14''\text{-}24''$ ,  $L = \frac{3}{8}''$
  - $\text{\O} 26''\text{-}36''$ ,  $L = 4''$
  - $\text{\O} 38''\text{-}58''$ ,  $L = 4\frac{3}{4}''$



# Field-cut-Adapter



## Description

adapter for preparing field cut double wall duct for connection to double wall fittings

- available  $\text{Ø}$  5"-58"

- Lengths (L):

  - $\text{Ø}$  5"-7", L =  $1\frac{5}{8}$ "

  - $\text{Ø}$  8"-12", L =  $2\frac{3}{8}$ "

  - $\text{Ø}$  14"-24", L =  $3\frac{1}{8}$ "

  - $\text{Ø}$  26"-42", L = 4"

  - $\text{Ø}$  44"-58", L =  $4\frac{3}{4}$ "



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