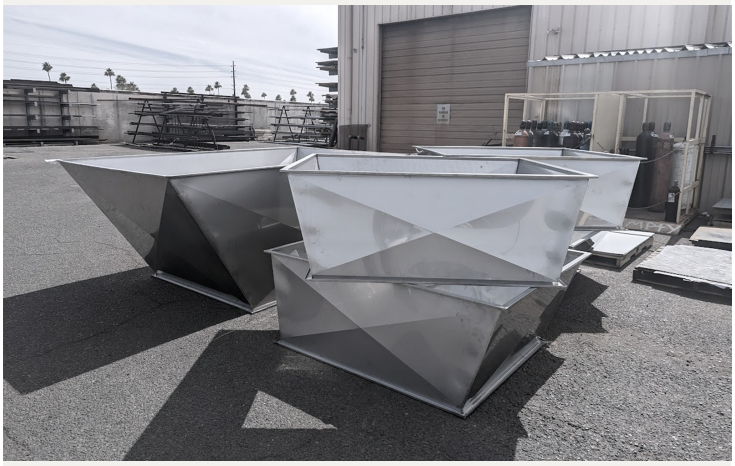
PRODUCT SPECIFICATIONS

Stainless Lock Seam Duct



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	**304 or 316L Stainless**
GAUGE RANGE	**26 ga - 20 ga**
CONSTRUCTION	**Pittsburgh lock seam**

Construction Standard

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

Stainless Lock Seam Duct

Build Quality

Made to spec	Built tough	Quality checked	Finish aware
Built to released grade, gauge, finish, and connection details.	304 or 316L stainless formed for mechanical ductwork.	Duct sections and fittings receive visual inspection.	Visible faces, grain direction, and handling planned before release.

Fabrication Capabilities

Duct sections	Rectangular stainless straight duct, field-fit pieces, risers, drops, and custom lengths.
Fittings	Rectangular stainless elbows, radius bends, offsets, tapers, reducers, transitions, branches, and tees.
Connections	Raw ends with couplers, slip-and-drive, TDC / Ductmate, angle rings, equipment transitions, collars, curb adapters, and roof penetration fittings are available.
Field-fit work	Short sections, piece-marked runs, and coordinated connection faces.
Shop details	Tabs, brackets, companion flanges, angle frames, reinforcement, and special flange details when requested.
Release support	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	S & Drive	TDC / Ductmate	Angle rings
Raw ends	**Slip-and-drive**	**Bolted seal**	**Custom pattern**
Raw ends with couplers for screw assembly.	Standard rectangular duct connection for mechanical assembly.	Bolted frame connections with gasket or butyl sealant when specified.	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

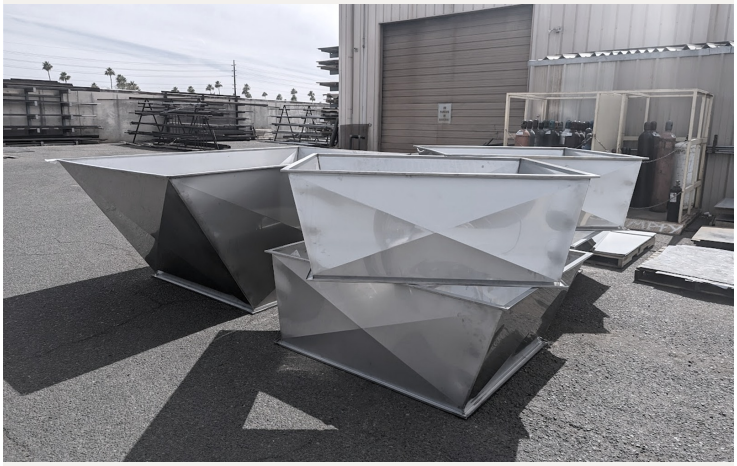
Reinforcement, tabs, brackets, piece marks, angle rings, and special hardware.

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.

Stainless Lock Seam Duct

Applications & details



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.

Fabrication details

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.

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.

304 / 316L | Finish | Liner | Ends

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: Applicable codes, project specifications, pressure class, liner, material compatibility, and AHJ direction govern the completed system. Legacy fabricates to released dimensions and quoted scope. System design, material selection, installation, field sealing, clearances, balancing, and acceptance remain by others unless quoted.

Ready to Quote?

Let's get your project moving.

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

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