Sheet Metal Connectors, Inc. is proud to be a member or affiliated with the following associations:

- Sheet Metal Workers’ International Association
  Washington, DC

- Sheet Metal Air Conditioning Contractors’ National Association
  Chantilly, VA

- SPIDA
  Spiral Duct Manufacturers Association
  Irmo, SC

- SMACNA Testing & Research Institute
  Chantilly, VA
Double-Wall Round Spiral Pipe & Fittings
Sheet Metal Connectors, Inc. (SMC) Double Wall Pipe and Fittings with E-Z Flange and Barrel Clamp or Standard Slip Connection

Sheet Metal Connectors, Inc. double wall round spiral duct and fittings are one part of our complete line of HVAC products. Double wall round spiral duct has two different types of applications:
- Acoustical double wall for noise control
- Thermal double wall duct for temperature control

SMC double wall round spiral pipe and fittings are manufactured with an E-Z Flange with Barrel Clamp, E-Z Flange Jr. with Barrel Clamp or standard slip construction. All sizes shall be listed using inside dimensions.

Acoustical Double Wall

Standard acoustical double wall is for noise control. Constructed of a perforated inner shell surrounded by a layer of insulation and covered by a solid outer shell. The perforated inner shell has 3/32" diameter holes staggered at 3/16" on center for a clear open area of 23%.

Solid Outer Shell

<table>
<thead>
<tr>
<th>DIAMETER</th>
<th>MATERIAL</th>
<th>THICKNESS</th>
<th>ASTM</th>
<th>TYPE</th>
<th>LENGTH</th>
</tr>
</thead>
<tbody>
<tr>
<td>5&quot; - 96&quot;</td>
<td>Galvanized</td>
<td>26 - 14 gauge</td>
<td>A-653</td>
<td>G60-G90</td>
<td>1’ – 20’, 10’ Standard</td>
</tr>
<tr>
<td>5&quot; - 96&quot;</td>
<td>Paint Grip</td>
<td>24 - 18 gauge</td>
<td>A-653</td>
<td>A60</td>
<td>1’ – 20’, 10’ Standard</td>
</tr>
<tr>
<td>5&quot; - 96&quot;</td>
<td>PVS*</td>
<td>24 - 16 gauge</td>
<td>A-653</td>
<td>4 x 1, 4 x 4</td>
<td>1’ – 20’, 10’ Standard</td>
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<tr>
<td>5&quot; - 60&quot;</td>
<td>Aluminum</td>
<td>.032 -.063</td>
<td>B-316</td>
<td>3003 H-14</td>
<td>1’ – 20’, 10’ Standard</td>
</tr>
<tr>
<td>5&quot; - 60&quot;</td>
<td>Stainless Steel</td>
<td>24 - 18 gauge</td>
<td>A-240</td>
<td>304 or 316</td>
<td>1’ – 20’, 10’ Standard</td>
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</tbody>
</table>

*PVS specification book available

Perforated Inner Shell

<table>
<thead>
<tr>
<th>DIAMETER</th>
<th>MATERIAL</th>
<th>THICKNESS</th>
<th>ASTM</th>
<th>TYPE</th>
<th>LENGTH</th>
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</table>

*Special order perforated available in other materials - consult factory

Thermal Double Wall

Standard thermal double wall is for temperature control. Constructed of a solid shell surrounded by a layer of insulation and covered by a solid outer shell.

Solid Outer and Inner Shell

<table>
<thead>
<tr>
<th>DIAMETER</th>
<th>MATERIAL</th>
<th>THICKNESS</th>
<th>ASTM</th>
<th>TYPE</th>
<th>LENGTH</th>
</tr>
</thead>
<tbody>
<tr>
<td>3&quot; - 96&quot;</td>
<td>Galvanized</td>
<td>26 - 14 gauge</td>
<td>A-653</td>
<td>G60-G90</td>
<td>1’ – 20’, 10’ Standard</td>
</tr>
<tr>
<td>3&quot; - 96&quot;</td>
<td>Paint Grip</td>
<td>24 - 18 gauge</td>
<td>A-653</td>
<td>A60</td>
<td>1’ – 20’, 10’ Standard</td>
</tr>
<tr>
<td>3&quot; - 96&quot;</td>
<td>PVS*</td>
<td>24 - 16 gauge</td>
<td>A-653</td>
<td>4 x 1, 4 x 4</td>
<td>1’ – 20’, 10’ Standard</td>
</tr>
<tr>
<td>3&quot; - 60&quot;</td>
<td>Aluminum</td>
<td>.032 -.063</td>
<td>B-316</td>
<td>3003 H-14</td>
<td>1’ – 20’, 10’ Standard</td>
</tr>
<tr>
<td>3&quot; - 60&quot;</td>
<td>Stainless Steel</td>
<td>24 - 18 gauge</td>
<td>A-240</td>
<td>304 or 316</td>
<td>1’ – 20’, 10’ Standard</td>
</tr>
</tbody>
</table>

*PVS specification book available

Note: SMACNA Testing and Research Institute verified that Sheet Metal Connectors, Inc. shop standards comply with the 2005-3rd edition of the SMACNA HVAC Duct Construction Standards.
Double-Wall Connections

Double Wall E-Z Flange Jr. with Barrel Clamp - 6” to 24” Diameter
The Double Wall E-Z Flange Jr. is a 5/8” flange turned out 90° on the outer shell. A 1-3/8” angle flange is inserted into the inner shell. The two flanges are then tack welded together creating a double wall E-Z Flange Jr. This double wall E-Z Flange Jr. can be shipped in sets or factory installed. A set consists of two double wall E-Z Flange Jr. and one barrel clamp. For field installation the installer attaches the double wall E-Z Flange Jr., applies a gasket on one flange, mates the two double wall E-Z Flange Jr. together and attaches the barrel clamp. For field cuts a 5/8” double wall flange sleeve is available, cut the spiral pipe to the measured length and apply the sleeve.

Double Wall E-Z Flange with Barrel Clamp - 26” to 96” Diameter
The double wall E-Z Flange with Barrel Clamp can be shipped in sets or factory installed. A set consists of two double wall E-Z Flanges and one barrel clamp. For field installation the installer attaches the double wall E-Z Flange to the pipe and fittings. Next the installer applies the gasket to one flange, mates the two double wall flanges together and attaches the barrel clamp. Sheet Metal Connectors also installs double wall E-Z Flanges. Flanges are spot welded and internally sealed on all ends of the spiral pipe and fittings.

Double Wall Standard Spiral Pipe Connector
Pipe to Pipe connections are made by using a double wall fitting size coupling that slips inside the mating pipe sections, as shown. A stop bead runs around the middle of the coupling to center the coupling in the connection. Secure the connections by installing sheet metal screws through the outer shell of the duct, 1/2” from the stop bead.
Double Wall Fittings

Sheet Metal Connectors, Inc. double wall duct has a complete line of compatible fittings. Fittings can be fabricated with standing seam, elbow lock or welded seam construction. Double wall fittings can be fabricated to desired length and many different configurations. All sizes shall be listed using inside dimensions.

All fittings can be manufactured with:
- E-Z Flange Jr. with Barrel Clamp - 6” to 24” Diameter
- E-Z Flange with Barrel Clamp - 26” to 96” Diameter
- Double Wall Couplings

Insulation

SMC double wall round spiral duct is a dependable, erosion resistant alternative to lined round spiral duct, providing improved protection for insulation exposed to the airstream. In double wall round spiral duct a metal inner liner insures that high airflow velocities cannot separate insulation by pulling away from the duct’s outer wall and creating erosion or airflow problems.

SMC constructs each piece with an inner shell (perforated or solid) surrounded by a layer of insulation and covered by a solid outer shell. The insulation is used in both acoustical and thermal duct systems.

SMC solves air quality problems caused by bacteria and other contaminants that can embed in fibrous materials, which can be a health hazard in environments such as schools, hospitals, laboratories, and food or pharmaceutical plants. In cases where additional erosion or contamination protection is desired for such an environment, we can provide a customer specified barrier material (mylar or tedlar) between the insulation and the perforated liner.

Standard insulation is 1” thick with 1 1/2 lb. per cubic foot density. See chart below for specifications. Many other thickness’ and densities are available, consult factory.

<table>
<thead>
<tr>
<th>Type</th>
<th>125</th>
<th>250</th>
<th>500</th>
<th>1000</th>
<th>2000</th>
<th>4000</th>
<th>NRC</th>
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</thead>
<tbody>
<tr>
<td>.5” - 2 # Cu. Ft.</td>
<td>.09</td>
<td>.14</td>
<td>.40</td>
<td>.60</td>
<td>.73</td>
<td>.82</td>
<td>.45</td>
</tr>
<tr>
<td>1” - 1 1/2 # Cu. Ft.</td>
<td>.18</td>
<td>.36</td>
<td>.59</td>
<td>.86</td>
<td>.95</td>
<td>.90</td>
<td>.70</td>
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<tr>
<td>2” - 1 1/2 # Cu. Ft.</td>
<td>.34</td>
<td>.64</td>
<td>.96</td>
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<td>1.03</td>
<td>.90</td>
<td>.90</td>
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<tr>
<td>1” - 3 # Cu. Ft.</td>
<td>.09</td>
<td>.28</td>
<td>.63</td>
<td>.86</td>
<td>.91</td>
<td>.92</td>
<td>.65</td>
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</tbody>
</table>

Coefficients determined per ASTM E 795 Type A Mounting
Note: Pressure classifications are based on SMACNA Second Edition - 1995

Specification Compliance

SMC standard insulation meets the requirements of the following codes and specifications:

- NFPA 90A and NFPA 90B
- NAIMA Standard AHC-101
- ASTM C 1071 Type 1 Replaces HH-I-545B Type 1
### Single Wall Weight and Gauge Chart

<table>
<thead>
<tr>
<th>Diam.</th>
<th>26 Gauge lbs./ft.</th>
<th>24 Gauge lbs./ft.</th>
<th>22 Gauge lbs./ft.</th>
<th>20 Gauge lbs./ft.</th>
<th>18 Gauge lbs./ft.</th>
<th>16 Gauge lbs./ft.</th>
</tr>
</thead>
<tbody>
<tr>
<td>3&quot;</td>
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<td></td>
</tr>
<tr>
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<td>1.4</td>
<td>1.7</td>
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<td></td>
<td></td>
</tr>
<tr>
<td>5&quot;</td>
<td>1.4</td>
<td>1.7</td>
<td>2.1</td>
<td>2.5</td>
<td>3.2</td>
<td>4.0</td>
</tr>
<tr>
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<td>3.0</td>
<td>3.9</td>
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<td>7.2</td>
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<td>4.2</td>
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<td>7.9</td>
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<td>4.6</td>
<td>5.4</td>
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<td>8.7</td>
</tr>
<tr>
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<td>3.2</td>
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<td>5.0</td>
<td>5.9</td>
<td>7.8</td>
<td>9.5</td>
</tr>
</tbody>
</table>

Standard gauges in boxed area, weights may vary slightly.

To calculate weight of Double Wall Spiral:

\[(\text{Weight of Inner Shell}) + (\text{Weight of Outer Shell}) = \text{Lbs./Ft.}\]

Example:

10' - 0" of 20"Ø Double Wall

20"Ø I.D. 24 Gauge = 6.8 lbs./ft. x 10' = 68#
22"Ø O.D. 22 Gauge = 9.1 lbs./ft. x 10' = 91#

Weight = 159# Less Insulation

### Positive Pressure

#### Bursting Pressure various gauges of spiral tubing

<table>
<thead>
<tr>
<th>Diam.</th>
<th>26 Gauge</th>
<th>24 Gauge</th>
<th>22 Gauge</th>
<th>20 Gauge</th>
<th>18 Gauge</th>
</tr>
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<tbody>
<tr>
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<td>420</td>
<td>395</td>
<td>360</td>
<td>320</td>
<td>285</td>
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<td>4&quot;</td>
<td>308</td>
<td>292</td>
<td>275</td>
<td>250</td>
<td>225</td>
</tr>
<tr>
<td>5&quot;</td>
<td>238</td>
<td>203</td>
<td>180</td>
<td>160</td>
<td>140</td>
</tr>
<tr>
<td>6&quot;</td>
<td>189</td>
<td>152</td>
<td>125</td>
<td>105</td>
<td>90</td>
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<td>7&quot;</td>
<td>169</td>
<td>131</td>
<td>100</td>
<td>80</td>
<td>65</td>
</tr>
<tr>
<td>8&quot;</td>
<td>145</td>
<td>110</td>
<td>85</td>
<td>65</td>
<td>50</td>
</tr>
<tr>
<td>9&quot;</td>
<td>127</td>
<td>91</td>
<td>65</td>
<td>45</td>
<td>35</td>
</tr>
<tr>
<td>10&quot;</td>
<td>113</td>
<td>78</td>
<td>55</td>
<td>40</td>
<td>30</td>
</tr>
<tr>
<td>12&quot;</td>
<td>76</td>
<td>47</td>
<td>30</td>
<td>20</td>
<td>15</td>
</tr>
<tr>
<td>14&quot;</td>
<td>68</td>
<td>44</td>
<td>28</td>
<td>18</td>
<td>12</td>
</tr>
<tr>
<td>16&quot;</td>
<td>58</td>
<td>40</td>
<td>25</td>
<td>15</td>
<td>10</td>
</tr>
<tr>
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<td>48</td>
<td>35</td>
<td>20</td>
<td>12</td>
<td>8</td>
</tr>
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<td>7</td>
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<td>3</td>
<td>2</td>
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<tr>
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<td>2</td>
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<td></td>
</tr>
</tbody>
</table>

#### Internal Pressure

#### Collapsing Pressure various gauges of spiral tubing

<table>
<thead>
<tr>
<th>Diam.</th>
<th>26 Gauge</th>
<th>24 Gauge</th>
<th>22 Gauge</th>
<th>20 Gauge</th>
<th>18 Gauge</th>
</tr>
</thead>
<tbody>
<tr>
<td>6&quot;</td>
<td>220.4</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
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<td>69.2</td>
<td>121.2</td>
<td></td>
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<tr>
<td>10&quot;</td>
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<td>110.6</td>
<td>691.7</td>
<td></td>
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</tr>
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<td>110.6</td>
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<td>4.8</td>
<td>9.8</td>
<td>14.9</td>
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<td>4.2</td>
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<td>11.0</td>
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<td>3.9</td>
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<td>8.2</td>
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<td>6.8</td>
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<td>3.3</td>
<td>5.0</td>
<td>5.6</td>
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<td>2.9</td>
<td>3.8</td>
<td>4.3</td>
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</tbody>
</table>

\[\text{1 PSI} = 27.678 \text{H}_2\text{O}\]

All tube diameters in inches. All pressure in PSI.

### Close Cell Neoprene Gasket

<table>
<thead>
<tr>
<th>Neoprene</th>
<th>1/4&quot; x 1/2&quot; (50' rolls - 1500' per box)</th>
<th>E-Z Flange Jr.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Neoprene</td>
<td>1/4&quot; x 3/4&quot; (50' rolls - 1500' per box)</td>
<td>E-Z Flange &amp; TDC</td>
</tr>
</tbody>
</table>

These tables are given only as a courtesy. Sheet Metal Connectors is not responsible for any results listed on these charts.
Double Wall 90° Elbow
with E-Z Flange
and Barrel Clamp
Inside dimensions to be listed

<table>
<thead>
<tr>
<th>Standard Throats</th>
</tr>
</thead>
<tbody>
<tr>
<td>8&quot; Thru 18&quot;</td>
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<tr>
<td>20&quot; Thru 40&quot;</td>
</tr>
<tr>
<td>42&quot; Thru 60&quot;</td>
</tr>
</tbody>
</table>

Double Wall 45° Angle
with E-Z Flange
and Barrel Clamp
Inside dimensions to be listed

<table>
<thead>
<tr>
<th>Standard Throats</th>
</tr>
</thead>
<tbody>
<tr>
<td>8&quot; Thru 18&quot;</td>
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<tr>
<td>20&quot; Thru 40&quot;</td>
</tr>
<tr>
<td>42&quot; Thru 60&quot;</td>
</tr>
</tbody>
</table>

STANDARD INSULATION IS 1" - 1 1/2 # Cu. Ft.
OTHER INSULATION IS AVAILABLE – CONSULT FACTORY
Double Wall Pipe and Fitting

Double Wall 90° Tee with E-Z Flange and Barrel Clamp

Inside dimensions to be listed
A, B, C
Length = C + 2x Insulation Thickness + 8"

Double Wall 45° Lateral with E-Z Flange and Barrel Clamp

Inside dimensions to be listed
A, B, C
Insulation
Length = C + 2x Thickness x 1.414 + 9"

Double Wall Pipe with E-Z Flange and Barrel Clamp

Inside dimensions to be listed

Many Other Fittings Are Available, Please Consult Factory

STANDARD INSULATION IS 1” - 1 1/2 # Cu. Ft.
OTHER INSULATION IS AVAILABLE – CONSULT FACTORY
DP 77 INDUSTRIAL SPRAY ADHESIVE
Recommended Uses:
• Bonding galvanized metal, wood, fiberglass, foam rubber, cardboard, textiles, cloth and plastics

DP 2590 SOLVENT BASED DUCT SEALANT
A premium quality UL Classified high velocity duct sealant, for commercial use. Available in 12 oz. spray cans or 40 oz. canister. Pro spray gun and 12' hose sold separately.
Recommended Uses:
• Bonding fiberglass duct liner to galvanized ductwork
• Bonding fiberglass insulation to the exterior of galvanized steel, stainless steel and aluminum HVAC duct
• Sealing and bonding laps in HVAC duct insulation
• Adhering kraft backed foil and foil jacketing to urethane foam

Meets LEED Requirements for Low Emitting Materials

DP 2501 WATER BASED DUCT LINER ADHESIVE - Clear
A water based, premium quality U.L. Classified duct liner adhesive. DP 2501 is specifically formulated for roller and low pressure spray applications.
Available in 5 gallon pails, 54 gallon drum
Recommended Uses:
• Bonding fibrous duct liner installation to galvanized ductwork
• Sealing cut edges of fiberglass insulation
• Bonding kraft backed foil coverings to fiberglass and urethane flat stock or pipe insulation
• Bonding multiple layers of fibrous insulation board

DP 2502 WATER BASED DUCT LINER ADHESIVE - Clear
A water based, premium quality U.L. Classified duct liner adhesive. DP 2502 is a higher viscosity version of DP 2501. DP 2502 is specifically formulated for spray, brush, and roller applications.
Available in 5 gallon pails, 54 gallon drum
Recommended Uses:
• Bonding fibrous duct liner installation to galvanized ductwork
• Sealing cut edges of fiberglass insulation
• Bonding kraft backed foil coverings to fiberglass and urethane flat stock or pipe insulation
• Bonding multiple layers of fibrous insulation board

DP 1010 WATER BASED DUCT SEALANT - Gray
A smooth, water based, premium quality, U.L. 181 Classified, high velocity duct sealant for commercial and residential use. Available in 1/12 gallon tubes or 1 gallon pail.
Recommended Uses:
• Sealing metal joints on air duct where a smooth finish is desired
• Sealing connections on flexible duct or fiberglass ductboard
• Intended for use on duct systems which do not exceed 15 inches water column pressure

Meets LEED Requirements for Low Emitting Materials

DP 1090 SOLVENT BASED DUCT SEALANT
A premium quality UL Classified high velocity duct sealant, for commercial use. Available in 1/12 gallon tubes or 1 gallon pail.
Recommended Uses:
• DP1090 is formulated for sealing low, medium and high-pressure metal duct systems in commercial and industrial applications
• DP1090 is intended for use on duct systems which do not exceed 15 inches water column pressure
• DP1090 is ideal for sealing rectangular, round, oval and metal flexible ducts.

Meets LEED Requirements for Low Emitting Materials

DP 77 INDUSTRIAL SPRAY ADHESIVE
Recommended Uses:
• Bonding galvanized metal, wood, fiberglass, foam rubber, cardboard, textiles, cloth and plastics

DP 2" CHIP BRUSH

<table>
<thead>
<tr>
<th>Product Number</th>
<th>Description Application</th>
<th>Colors</th>
<th>Adhesive</th>
<th>Total Thickness (mils)</th>
<th>Tensile Strength (lbs/in (kg/cm))</th>
<th>Adhesion To Steel (ozs/in (g/cm))</th>
</tr>
</thead>
<tbody>
<tr>
<td>557 Printed</td>
<td>Premium performance duct tape specifically engineered for flex duct systems. Meets UL 181B-FX &amp; UL 723</td>
<td>Grey</td>
<td>Natural Rubber</td>
<td>14.0 (0.36)</td>
<td>45 (8.01)</td>
<td>50 (560)</td>
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<tr>
<td>229</td>
<td>Heavy duty contractor grade duct tape with extra thick adhesive for conformability Meets UL 723</td>
<td>Grey</td>
<td>Natural Rubber</td>
<td>12.0 (0.30)</td>
<td>25 (4.45)</td>
<td>70 (784)</td>
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<tr>
<td>339 Printed</td>
<td>Dead-soft aluminum foil backed duct tape for fiberglass duct systems. UL 181 A-P approved</td>
<td>Silver</td>
<td>Acrylic</td>
<td>4.4 (0.11)</td>
<td>25 (4.45)</td>
<td>72 (806)</td>
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<tr>
<td>330</td>
<td>All-weather duct tape, working temperature range of -35°F to 260°F, plain dead soft aluminum foil, extremely conformable.</td>
<td>Silver</td>
<td>Acrylic</td>
<td>3.5 (0.08)</td>
<td>20 (3.56)</td>
<td>45 (504)</td>
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</tbody>
</table>