



## STANDARD DUCTING PRODUCTS

## OVERVIEW GUIDE

Dear reader,

This document is produced to give an overview of the different standard ranges available at Formula Air and to avoid possible confusion in the choices of products, finishes and complementary articles associated to them.

Keep in mind that a standard range doesn't necessarily mean that all of the products in all the diameters are kept in stock.

Note that it is only an overview and doesn't reflect all the products available in one single range.

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## 1. STANDARD GALVANIZED RANGE

a. Galvanized pipes :

All the pipes are laser welded longitudinally and are airtight. They are produced in Sendzimir galvanized metal sheets ranging from 0,75 mm up to 1 mm thicknesses depending on the diameter.

The edges of the pipes are 6 mm wide slightly rounded up to Ø300 (machine-made) and completely flat as of Ø315 (manmade) and all rings fit on them. (with a tolerance of  $\pm 1$  mm)



b. Galvanized bends :

The  $R=1,5D$  bends are either made of two halves spot-welded together (Ø80 up to Ø300) or made of segments that are lock-formed together (bigger than Ø300). These are not airtight.

They are produced in Sendzimir galvanized metal sheets ranging from 0,75 mm up to 1,2 mm thicknesses depending on the diameter.

The edges are 6 mm wide slightly rounded and all rings fit on them. (with a tolerance of  $\pm 1$  mm)



c. Galvanized branches :

The branches are made of a stitch-welded body and branch that are spot-welded together. These are not airtight.

They are produced in Sendzimir galvanized metal sheets ranging from 0,75 mm up to 1,0 mm thicknesses depending on the diameter.

The edges are 6 mm wide slightly rounded and they are normally designed so that all rings fit on them. (with a tolerance of  $\pm 1$  mm)



d. Variations :

There are R=2D stretched bends that are available for this range and they are airtight!

Other elements :

Note that all other thin walled galvanized components of this range can be assembled with these various items because they all have similar edges for lock rings.

Other thicknesses :

see sections "5. STANDARD HOT DIPPED GALVANIZED RANGE" and "6. OTHER RANGES"



e. A wide range of rings are available for this range :

- slim rings (OSØ)
- Wide rings (OWØ)
- Rapid-lock rings with red insert (ORØ)
- Slim rapid-lock rings (ORØAPS1)
- Strong rings with Terostat (OXØATE1)
- Special oil rings for seals (OXØAE9) with separate seal
- Rapid-lock rings for seals (ORØAE5) with separate seal
- Flanges
- DIN flanges
- And various clipbands to suspend the elements



f. Third party elements :

Note that other components from various suppliers can be assembled with all of these items as long as the diameter and design of the edges match our own range. (with a tolerance of  $\pm 1$  mm)



## 2. STANDARD AISI RANGE

### a. AISI pipes :

All the AISI pipes are laser welded longitudinally and are airtight.

They are produced in AISI 304 sheets with a thickness of 0,6 mm from Ø80 up to Ø 180 and in 0,8 mm as of Ø200.

The edges of the AISI pipes are 6 mm wide slightly rounded up to Ø300 (machine-made) and completely flat as of Ø315 (manmade) and all rings fit on them. (with a tolerance of  $\pm 1$  mm)



### b. AISI bends :

From Ø80 up to Ø120, the R=1,5D AISI bends are made of spot-welded segments that spot-welded together.

As of Ø140, the segments are stitch-welded and then lock-formed together.

They are produced in AISI 304 sheets with a thickness of 0,8 mm. These are not airtight.

The edges are 6 mm wide slightly rounded and all rings fit on them. (with a tolerance of  $\pm 1$  mm)



### c. AISI branches :

The branches are made of a stitch-welded body and branch that are spot-welded together. These are not airtight.

They are produced in AISI 304 sheets with a thickness of 0,8 mm.

The edges are 6 mm wide slightly rounded and only rings with a slim profile fit on them if they are conical. (with a tolerance of  $\pm 1$  mm)



d. Other elements :

Note that all other thin walled AISI components of this range can be assembled with these various items because they all have similar edges for lock rings.

They are produced in AISI 304 sheets with a thickness of 0,8 mm. These should be airtight if stitch-welded.

Other thicknesses :

See sections "4. STANDARD 2 mm AISI RANGE" and "6. OTHER RANGES"



e. Associated rings :

- AISI slim rings (OSØCP1)
- AISI wide rings (OWØCA9)
- AISI rapid-lock rings with red insert (ORØCRP1)
- AISI strong rings with Terostat (OXØCTE2)
- AISI special oil rings for seals (OX-CE9) with separate seal
- AISI rapid-lock rings for seals (OR-CE5) with separate seal
- Flanges
- DIN flanges
- And various clipbands to suspend the elements



f. Third party elements :

Note that other components from various suppliers can be assembled with all of these items as long as the diameter and design of the edges match our own range. (with a tolerance of  $\pm 1$  mm)





### 3. STANDARD 2mm RAL 7032 RANGE

a. 2 mm RAL 7032 pipes :

All the pipes are welded longitudinally and are airtight.

They are produced in ST12 (1.0330) sheets with a thickness of 2 mm polyester powder coated in RAL 7032 physiologically food safe, electrostatically conductive.

The edges of the pipes are 6 mm wide completely flat and all rings fit on them. (with a tolerance of  $\pm 1$  mm)



b. 2 mm RAL 7032 bends :

The bends are made of pressed pieces welded together or segments welded together. These are airtight.

They are produced in ST12 (1.0330) sheets with a thickness of 2 mm polyester powder coated in RAL 7032 physiologically food safe, electrostatically conductive.

The edges of the pipes are 6 mm wide completely flat and all rings fit on them. (with a tolerance of  $\pm 1$  mm)



c. 2 mm RAL 7032 branches :

The branches are made of rolled sheets that are welded together. These are airtight.

They are produced in ST12 (1.0330) sheets with a thickness of 2 mm polyester powder coated in RAL 7032 physiologically food safe, electrostatically conductive.

The edges of the pipes are 6 mm wide completely flat and all rings with a slim profile fit on them if they are conical. (with a tolerance of  $\pm 1$  mm)



d. Other elements :

Note that all other 2 mm components from this range can be assembled with these various items because they all have similar edges for lock rings.

FAB & FDH productions of these products are made of 37.2 (1.0038) mild steel.

Other thicknesses :

See sections in our "FULL WELDED RANGE" catalogue. Note that only the plate thickness varies. All other properties such as the edges and air-tightness stay the same.

Other colors :

Upon request with a supplement in certain cases



e. Associated rings :

- Strong rings with Terostat (OXØATE2)
- Special oil rings for seals (OXØAE9) with separate seal
- Rapid-lock rings for seals (ORØAE5) with separate seal
- Flanges
- DIN flanges
- And various clipbands to suspend the elements



f. Third party elements :

Note that other components from various suppliers can be assembled with all of these items as long as the diameter and design of the edges match our own range. (with a tolerance of  $\pm 1$  mm)





#### 4. STANDARD 2 mm AISI RANGE

a. 2 mm AISI pipes :

All the pipes are welded longitudinally and are airtight.

They are produced in AISI 304 (1.4301) sheets with a thickness of 2 mm and treated with Cr/Ni dust blasting (Chronital) but is NOT FOOD APPROVED AT THE MOMENT.

The edges of the pipes are 6 mm wide completely flat and all rings fit on them. (with a tolerance of  $\pm 1$  mm)



b. 2 mm AISI bends :

The bends are made of pressed pieces welded together or segments welded together. These are airtight.

They are produced in AISI 304 (1.4301) sheets with a thickness of 2 mm and treated with Cr/Ni dust blasting (Chronital) but is NOT FOOD APPROVED AT THE MOMENT.

The edges of the bends are 6 mm wide completely flat and all rings fit on them. (with a tolerance of  $\pm 1$  mm)



c. 2 mm AISI branches :

The branches are made of rolled sheets that are welded together. These are airtight.

They are produced in AISI 304 (1.4301) sheets with a thickness of 2 mm and treated with Cr/Ni dust blasting (Chronital) but is NOT FOOD APPROVED AT THE MOMENT.

The edges of the branches are 6 mm wide completely flat and all rings with a slim profile fit on them if they are conical. (with a tolerance of  $\pm 1$  mm)



d. Other elements :

Note that all other 2 mm AISI components from this range can be assembled with these various items because they all have similar edges for lock rings.

Other thicknesses :

See our "FULL WELDED RANGE" catalogue. Note that only the plate thickness varies. All other properties such as the edges and air-tightness stay the same.

Other qualities :

Other AISI plate qualities can be supplied upon request.

Finishes :

For a supplement, these can also be pickled and passivated or electro-polished.



e. Associated rings :

- Strong rings with Terostat (OXØCTE2)
- Special oil rings for seals (OXØCE9) with separate seal
- Rapid-lock rings for seals (ORØCE5) with separate seal
- Flanges
- DIN flanges
  
- And various clipbands to suspend the elements



f. Third party elements :

Note that other components from various suppliers can be assembled with all of these items as long as the diameter and design of the edges match our own range. (with a tolerance of  $\pm 1$  mm)



## 5. STANDARD HOT DIPPED GALVANIZED RANGE

a. Hot dipped galvanized pipes :

All the pipes are welded longitudinally and are airtight.

They are produced in ST12 (1.0330) sheets with a thickness of 1 mm hot dipped galvanized.

The edges of the pipes are 6 mm wide completely flat and all rings fit on them. (with a tolerance of  $\pm 1$  mm)



b. Hot dipped galvanized bends :

The bends are made of pressed pieces welded together or segments welded together. These are airtight.

They are produced in ST12 (1.0330) sheets with a thickness of 1 mm hot dipped galvanized.

The edges of the pipes are 6 mm wide completely flat and all rings fit on them. (with a tolerance of  $\pm 1$  mm)



c. Hot dipped galvanized branches :

The branches are made of rolled sheets that are welded together. These are airtight.

They are produced in ST12 (1.0330) sheets with a thickness of 1 mm hot dipped galvanized.

The edges of the pipes are 6 mm wide completely flat and rings with a slim profile fit on them if they are conical. (with a tolerance of  $\pm 1$  mm)



d. Other elements :

Note that all other hot dipped galvanized components from this range can be assembled with these various items because they all have similar edges for lock rings.

Other thicknesses :

Some of the elements are available in other thicknesses, see our "FULL WELDED RANGE" catalogue. Note that only the plate thickness varies. All other properties such as the edges and air-tightness stay the same.



e. Associated rings :

- Strong rings with Terostat (OXØATE2)
- Special oil rings for seals (OXØAE9) with separate seal
- Rapid-lock rings for seals (ORØAE5) with separate seal
- Flanges
- DIN flanges
- And various clipbands to suspend the elements



f. Third party elements :

Note that other components from various suppliers can be assembled with all of these items as long as the width and design of the edges match our own range. (with a tolerance of  $\pm 1$  mm)



## **6. OTHER RANGES (not standard) :**

### **6.1. Full welded galvanized range**

There are possibilities to have full welded galvanized ducting elements within the group from Formula Air Baltic or from Formula Air The Netherlands but you have to keep in mind some constraints :

- The minimum sheet thickness is 1,25 mm.
- There are never any “fbb” extensions. This means that all conical pieces are produced in “fb” and you have to check which types of rings fit on these.
- Unless specified, the welded areas are painted over with cold galva paint. (If you need a hot dipped galvanized, or electro-galvanized finish, make sure that they are able to do it and keep in mind the longer delivery time)
- Seeing as this type of execution is especially suited for the oil mist processes, it is recommended to use rings with special oil resistant seals. See the OYØAE9 rings & OGØPEX seals in our catalogues.

### **6.2. Other AISI ranges at Formula Air The Netherlands**

Other types of finishes for AISI materials are possible at Formula Air The Netherlands but are only upon request.

These can be :

- Untreated welded through or added wire
- Untreated welded outside only or welded both sides
- Added wire, welded through or gas-backed untreated.
- Added wire gas-backed with brushed welding lines
- Added wire gas-backed with electric pickled welding lines
- Added wire gas-backed completely pickled and passivated
- Added wire gas-backed completely shot-blasted

You need to say beforehand exactly what your client's needs are in order to have an adapted price offer.

### **6.3. Projects**

Keep in mind that Formula Air The Netherlands and the Formula Air group can be reactive to complete projects that are not in our standard ranges as well. May it be for air treatment (rectangular ducting), aluminum ducting (spot-welded or welded with added wire), black steel ducting (untreated) or client specific needs, we probably have the solution!

## 7. CONTACTS

Feel free to contact us at any time for further information on our products and availability :

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