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## LOC PVC Superduct Specifications

### SUGGESTED STANDARD DUCT & FITTING SPECIFICATIONS FOR PVC

- PVC material compounds shall conform to Type 1 Grade 1 PVC, Cell Class 12454B, as described in ASTM D-1784.
- Duct diameters thru 20" & 24" will be extruded and of seamless construction. Sizes thru 18" will have a 0.187" wall thickness. 20" diameter will be @ 0.219" and 24" @ 0.250" thickness.
- Fabricated (heat formed) duct diameters 22" and 26" thru 30" will have a 0.187" wall while 32", 34" and 36" & larger diameters will have a 0.250" wall. Fabricated duct shall consist of a singular butt welded seam, thermally fused under computer controlled temperature and pressure, without the use of PVC welding/filler rod.
- All extruded duct shall be furnished in 10 or 20 foot lengths, plain end; fabricated duct will be furnished in standard 4 foot lengths with a coupling attached on one end.
- Three piece 90° elbows and two piece 45° elbows are considered standard and are furnished with a centerline radius of approximately 1 to 1 1/2 times the duct diameter. Five piece 90° elbows and 3 piece 45° elbows, per SMACNA specifications, can be provided, on specific project requirements.
- All couplings will be "sleeve" type style having an over-all length of 4 1/2"
- All belled end sockets (5" and above) shall have a minimum socket depth of 2" or more. 2", 3", & 4" belled socket depths will be @ 1 3/4".
- Branch fittings are designed to enter the main duct, at an angle not exceeding 45° Branch 90° tees are available where systems allow.
- Transition fittings shall have formed corners where practical. They will be of concentric design (unless otherwise requested) with a tapered cone-type body.
- Reducer couplings having a size reduction greater than "two-step", shall be formed with cone-type body having an overall length generally calculated @ 4" per 1" size reduction, where space allows. One-step and two-step reducers will have a smooth-flow concentric design.
- Blastgate Dampers shall be furnished with a 3-position locking pin (open, half-open, closed).
- Butterfly (Balancing) Dampers shall be furnished with a locking quadrant, to permanently position. Motorized dampers are available on request.
- Rain Caps shall be of "Zero Pressure Loss" design, commonly known as Style "B". Style "A" Rain Caps are also available on request.