

Table 6 Duct Leakage Classification^a

Duct Type	Sealed ^{b,c}		Unsealed ^d	
	Predicted Leakage Class C _L	Leakage Rate, L/(s·m ²) at 250 Pa	Predicted Leakage Class C _L	Leakage Rate, L/(s·m ²) at 250 Pa
Metal (flexible excluded)	Round and flat oval	4	42 (8 to 99)	1.5 (0.1 to 3.6)
	Rectangular	17	68 (17 to 152)	2.5 (0.6 to 5.6)
Flexible	Metal, aluminum	11	42 (17 to 76)	1.5 (0.6 to 2.8)
	Nonmetal	17	30 (6 to 76)	1.5 (0.2 to 2.8)
Fibrous glass	Round	4	NA	NA
	Rectangular	8	NA	NA

^aLeakage classes here are averages based on tests conducted by ASHRAE/NA (1977), ASHRAE/SMACNA/TMLA (1985), and Brown and Grigg (1995).

^b“Sealed” leakage classes assume that, for metal ducts, all transverse joints, seams, and openings in duct wall are sealed.

^cLeakage classes anticipate about 0.82 joints per meter of duct. For systems with a high fitting-to-straight-duct ratio, greater leakage occurs in both sealed and unsealed conditions.

Table 7 Leakage as Percentage of Airflow^{a,b}

Leakage Class	System L/s per m ² Duct Surface ^c	Static Pressure, Pa						
		125	150	500	750	1000	1500	
68	10	15	24	38	49	59	77	
	12.7	12	19	30	39	47	62	
	15	10	16	25	33	39	51	
	20	7.7	12	19	25	30	38	
	25	6.1	9.6	15	20	24	31	
	34	10	7.7	12	19	25	30	38
34	12.7	6.1	9.6	15	20	24	31	
	15	5.1	8.0	13	18	20	26	
	20	3.8	6.0	9.4	12	15	19	
	25	3.1	4.8	7.5	9.8	12	15	
	17	10	3.8	6	9.4	12	15	19
		12.7	3.1	4.8	7.5	9.8	12	15
15		2.6	4.0	6.3	8.2	9.8	13	
20		1.9	3.0	4.7	6.1	7.4	9.6	
25		1.5	2.4	3.8	4.9	5.9	7.7	
8		10	1.9	3	4.7	6.1	7.4	9.6
	12.7	1.5	2.4	3.8	4.9	5.9	7.7	
	15	1.3	2.0	3.1	4.1	4.9	6.4	
	20	1.0	1.5	2.4	3.1	3.7	4.8	
	25	0.8	1.2	1.9	2.4	3.0	3.8	
	4	10	1.0	1.5	2.4	3.1	3.7	4.8
12.7		0.8	1.2	1.9	2.4	3.0	3.8	
15		0.6	1.0	1.6	2.0	2.5	3.2	
20		0.5	0.8	1.3	1.6	2.0	2.6	
25		0.4	0.6	0.9	1.2	1.5	1.9	

^aAdapted with permission from *HVAC Air Duct Leakage Test Manual* (SMACNA 1995, Appendix A).

^bPercentage applies to airflow entering a section of duct operating at an assumed pressure equal to average of upstream and downstream pressures.

^cRates in this column are typical of the volumetric flow rate divided by total system surface. Portions of systems may vary from these averages.

HVAC Duct Construction Standards (2005). Fibrous glass ducts and their closure systems are covered by U.L. Standards 181 and 181A. For fibrous glass duct construction standards, consult NAIMA (2002) and SMACNA (2003). Flexible duct performance and installation

Table 8 Typical Design Velocities for HVAC Components

Duct Element	Face Velocity, m/s
Louvers^a	
Intake	
3300 L/s and greater	2
Less than 3300 L/s	See Figure 14
Exhaust	
2400 L/s and greater	2.5
Less than 2400 L/s	See Figure 14
Filters^b	
Panel filters	
Viscous impingement	1 to 4
Dry-type, extended-surface	
Flat (low efficiency)	Duct velocity
Pleated media (intermediate efficiency)	Up to 3.8
HEPA	1.3
Renewable media filters	
Moving-curtain viscous impingement	2.5
Moving-curtain dry media	1
Electronic air cleaners	
Ionizing type	0.8 to 1.8
Heating Coils^c	
Steam and hot water	2.5 to 5 1 min., 8 max.
Electric	
Open wire	Refer to mfg. data
Finned tubular	Refer to mfg. data
Dehumidifying Coils^d	2 to 3
Air Washers^e	
Spray type	Refer to mfg. data
Cell type	Refer to mfg. data
High-velocity spray type	6 to 9

^aBased on assumptions presented in text.
^bAbstracted from Ch. 26, 2008 *ASHRAE Handbook—HVAC Systems and Equipment*.
^cAbstracted from Ch. 26, 2008 *ASHRAE Handbook—HVAC Systems and Equipment*.
^dAbstracted from Ch. 22, 2008 *ASHRAE Handbook—HVAC Systems and Equipment*.
^eAbstracted from Ch. 40, 2008 *ASHRAE Handbook—HVAC Systems and Equipment*.

standards are covered by U.L. Standards 181 and 181B and AHC (2003). Soldered or welded duct construction is necessary where sealants are not suitable. Sealants used on exterior ducts must be resistant to weather, temperature cycles, sunlight, and ozone.

Shaft and compartment pressure changes affect duct leakage and are important to health and safety in the design and operation of containment and smoke control systems. Shafts should not be used for supply, return, and/or exhaust air without accounting for their leakage rates. Airflow around buildings, building component leakage, and the distribution of inside and outside pressures over the height of a building, including shafts, are discussed in [Chapters 16 and 24](#).

System Component Design Velocities

[Table 8](#) summarizes face velocities for HVAC components in built-up systems. In most cases, the values are abstracted from pertinent chapters in the 2008 *ASHRAE Handbook—HVAC Systems and Equipment*; final selection of components should be based on data in these chapters or, preferably, from manufacturers.

Use [Figure 14](#) for preliminary sizing of air intake and exhaust louvers. For air quantities greater than 3300 L/s per louver, the air intake gross louver openings are based on 2 m/s; for exhaust louvers, 2.5 m/s is used for air quantities of 2400 L/s per louver and greater. For smaller air quantities, refer to [Figure 14](#). These criteria are presented on a per-louver basis (i.e., each louver in a bank of louvers) to include each louver frame. Representative production-run louvers were used in establishing [Figure 14](#), and all data used were based on AMCA Standard 500-L tests. For louvers larger than

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Table of Contents Ashrae Handbook Chapter 49

1. Understanding the eBook Ashrae Handbook Chapter 49
 - The Rise of Digital Reading Ashrae Handbook Chapter 49
 - Advantages of eBooks Over Traditional Books
2. Identifying Ashrae Handbook Chapter 49
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Ashrae Handbook Chapter 49
 - User-Friendly Interface
4. Exploring eBook Recommendations from Ashrae Handbook Chapter 49
 - Personalized Recommendations
 - Ashrae Handbook Chapter 49 User Reviews and Ratings
 - Ashrae Handbook Chapter 49 and Bestseller Lists

5. Accessing Ashrae Handbook Chapter 49 Free and Paid eBooks
 - Ashrae Handbook Chapter 49 Public Domain eBooks
 - Ashrae Handbook Chapter 49 eBook Subscription Services
 - Ashrae Handbook Chapter 49 Budget-Friendly Options
6. Navigating Ashrae Handbook Chapter 49 eBook Formats
 - ePub, PDF, MOBI, and More
 - Ashrae Handbook Chapter 49 Compatibility with Devices
 - Ashrae Handbook Chapter 49 Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Ashrae Handbook Chapter 49
 - Highlighting and Note-Taking Ashrae Handbook Chapter 49
 - Interactive Elements Ashrae Handbook Chapter 49
8. Staying Engaged with Ashrae Handbook Chapter 49
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Ashrae Handbook Chapter 49
9. Balancing eBooks and Physical Books Ashrae Handbook Chapter 49
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Ashrae Handbook Chapter 49
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Ashrae Handbook Chapter 49
 - Setting Reading Goals Ashrae Handbook Chapter 49
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Ashrae Handbook Chapter 49
 - Fact-Checking eBook Content of Ashrae Handbook Chapter 49
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
- Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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