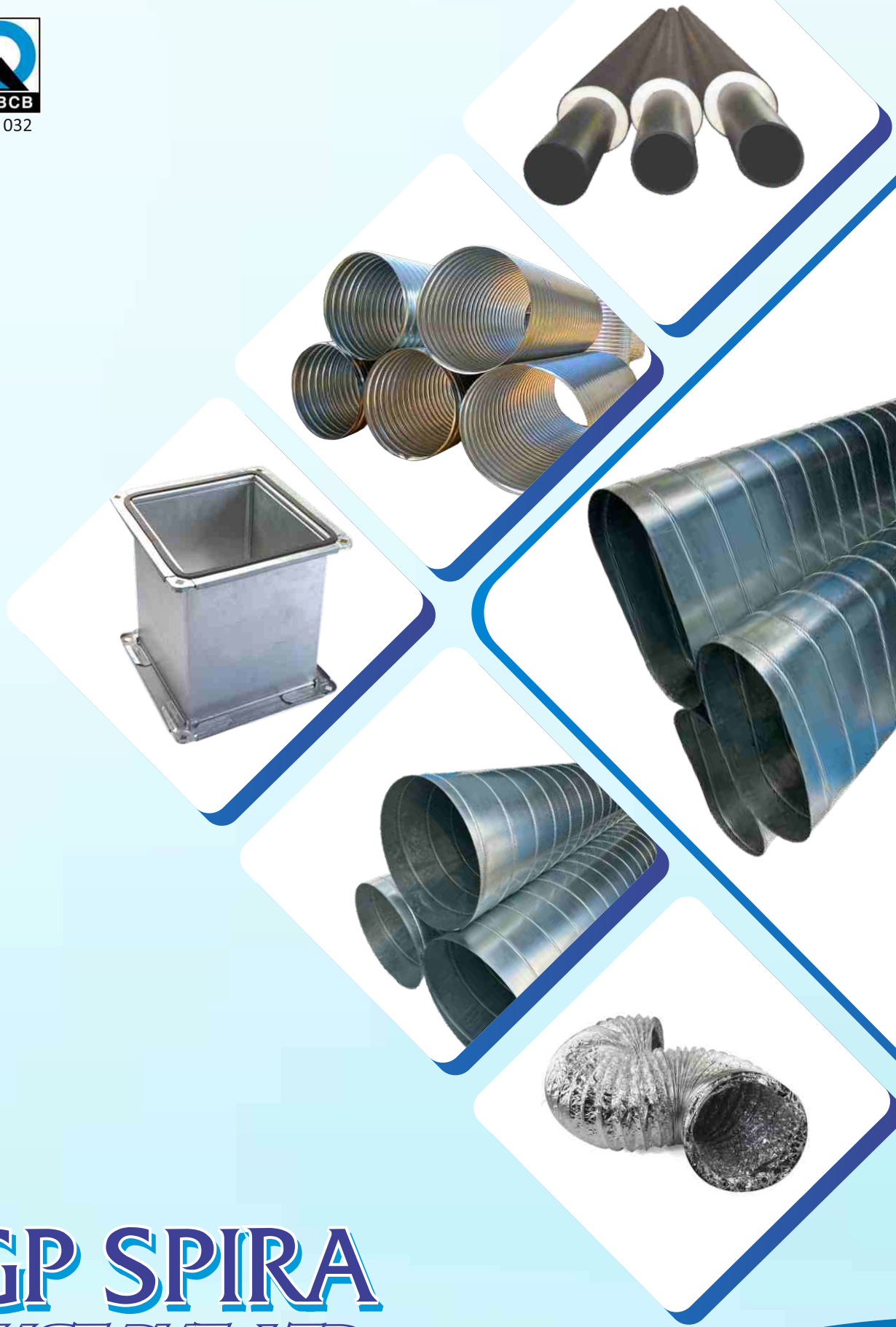
ISO 9001-2008 QM 032



GP SPIRA
DUCT PVT. LTD.

(An ISO 9001-2015 Company)

www.gpspira.com

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HYDERABAD FACTORY

DELHI FACTORY

KOLKATA FACTORY

MUMBAI FACTORY

BANGALORE FACTORY

CHENNAI FACTORY

About Us

GP SPIRA is a brand name of M/s. GP SPIRA DUCT Private Limited, formed with the concept of serving the customers for Supply of Factory Fabricated Ducts, Voids, Pre Insulated Pipes & QWIK FOOT support solutions for HVAC & Electrical Equipments.

The Directors of the company have vast experience in Sales and service in serving many of their clients. This 25 years old firm was formed engaging the experience to give their client long term Quality and Timely deliveries in the field of HVAC & Infrastructures Industry (voids/cross overs ducts) & where ducts plays primary importance of carrying conditioned air & also for cross overs for electrical / fiber cables and many other uses.

To cater fast ever growing market and to fulfill our customers demands in PAN INDIA our factory and offices are available in Hyderabad, Delhi, Kolkata, Bangalore, Chennai and Mumbai.

We follow Ducts manufacturing as per SMACNA, I S 655 and DW 144 STANDARDS & Consultant Specified specs. We excel in the manufacturing of TDF, C&S, Slip Flanges & Angle Iron flanged connecters type suitable Ducts, much to the satisfaction of some of our leading clients in the country. We also support with HVAC Accessories as an extended arm (Trade off items) to give value addition to benefit our customers.

Our Products Portfolio for your consideration.

- Spiral Round & Spiral Oval Ducts in GI, SS & Pre-coated materials. With / without insulation internally/externally.
- QWIK FOOT Support system for VRV/VRF Units , Aircooled & Water cooled Chiller, AHU's , Outdoor Condensing units , Ventilation Units, Electrical Panels etc., & Air Duct.
- Floor mountable Roof top Rubber Footing for Cable trays, copper pipes etc., sizes from 250L to 600L as standard, above sizes please consult us.
- GI ducts with TDF / Slip Flanges / C&S / Angle flanged connectors.
- Aluminum ducts upto 16G with corners and cleats for special projects & Hospitals cleanroom applications.
- Low Pressure Plenums
- Round Collars for flexible duct connections.
- Duct support systems (Threaded rods, nuts and washers, Slotted c channels, MS angle
- Supports , MS flanges etc, W - Brackets)"
- GI double skin ducts sandwitched with Fiber glass / Rockwool for special applications @ our Chennai Plant
- Round to square transition pieces, Square to Oval duct etc.,
- Duct flexible canvass connections. (GPSIRA & 7 STAR Brand Names)
- Round & Oval Flap DAMPERS
- GI Duct DAMPERS -
- Pre-insulated Pipes (PUF) with GI spiral, Aluminum Spiral duct cladding (for exposed ducts) & with HDPE Jacket (for Burried Underground Chilled water Pipes. (GPSIRA & 7 STAR Brand Names) Manufactured At Gurugram & Chennai

By giving GP Spira Duct dedicated endorsement as approved Vendors, our clients have verified their trust in our high standard of work and quality of equipment, Thus making us the only and preferred choice for repeated business.

G P SPIRA Strongly Believes In Delivering Its Clients

- Product which is best as per industry standards viz., SMACNA Standards / IS / DW Approved (By LEED / MEP & Project Management Consultants)
- Our commitment to the environment, A strict Health & Safety Policy @ works according to EH&S Policy, rules and regulations.
- An adherence to industry codes of practice in accordance with the CPWD/PWD/FSAI & other authorised authorities
- We are ISO Certified (ISO -9001-2015) with A professional, knowledgeable and attentive service.

➤ SPIRAL DUCT ➤

Today, more and more companies are switching from rectangular to spiral round rigid duct work. Why is this? what advantages do spiral systems have over rectangular? The answer is simple.

E nergy efficient
C est less to install
0 ften requires less space
N eed less hangers
0 peration cost lower
M ore noise free
I nstallation simplified
C leaning less complicated
A irflow measurement easier
L ight in weight

Also, the perimeter of round ducting system is less by 20% or more of same cross section of rectangular ducting. Hence, the area of ducting and insulation required is less by the same percentage.

Application :

- Air Conditioning (including high pressure and high velocity air distribution systems)
- Ventilation (Industrial & Tunnel)
- Warm air heating
- Fume and dust extraction
- Pneumatic conveying
- Exhaust and air intake pipes
- Humidification

Specifications :

Thickness: 0.60mm (24G) to 1.2mm (18G)
Thickness of Spiral ducts as per **SMACNA** (HVAC Duct construction standards)

Diameter (mm)	**Thickness mm(G)**
100 to 600	0.60 (24G)
601 to 900	0.80 (22G)
901 to 1250	1.00 (20G)
1251 to 1600	1.20 (18G)

Diameter: 100mm to 1600mm

Length: 3,4 & 6 Mtr.

Material: Galvanised Steel, Aluminium, Mild Steel (CRCA), Stainless Steel, etc

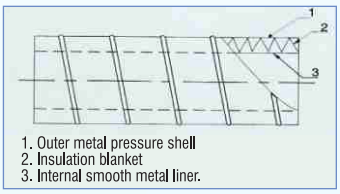
Surface Constructions: Plain or Corrugated (to increase the rigidity of the ducting by 300%)

Pre-insulated Double-walled Spiral Duct Systems

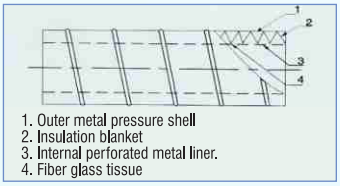
A. Thermal Insulation: A double-walled thermal insulated Spiral duct consists of an external pressure tight metal shell, 25/50mm thick of fibreglass/mineral wool/puf insulation and an internal protective metal liner.

Advantages:

- Double-wall fire protection
- No sheet metal screws in the air stream
- Lower friction loss
- Improved appearance
- Speeds installation
- No fibres in the air stream
- Protection from External damages.



1. Outer metal pressure shell
2. Insulation blanket
3. Internal smooth metal liner.

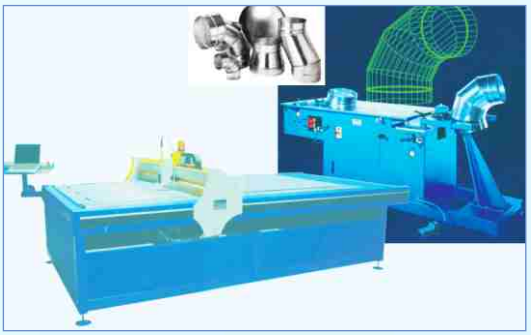


1. Outer metal pressure shell
2. Insulation blanket
3. Internal perforated metal liner.
4. Fiber glass tissue

B.Acoustic Insulation: A double-walled acoustic insulated spiral duct consists of an external pressure tight metal shell, 25/50mm thickness of fiber glass/miqeral wool insulations and an internal perforated protective metal liner and fiber glass tissue between the perforated liner and insulation material. In addition to the above advantages this system is having advantage of High Sound transmission loss.

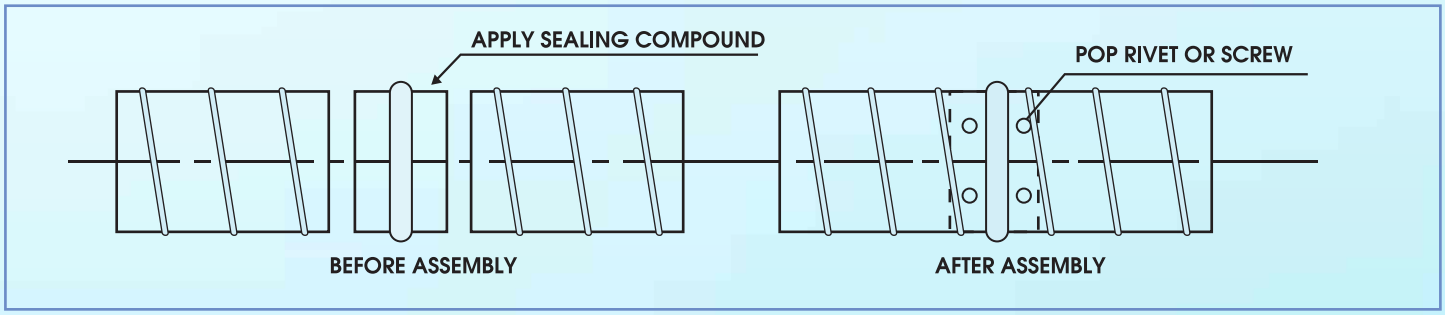
Duct Fittings:

Duct Fittings, standing seam Elbows, Reducers, End caps, Offsets, etc. are manufactured on high speed machines while maintaining the high dimensional accuracy.



Jointing System:

Spiral Ducts and duct fittings joined together by slip joint coupling.



Supporting / Hanging Systems

1.Isolater

2.I-Beam Holding Clamp

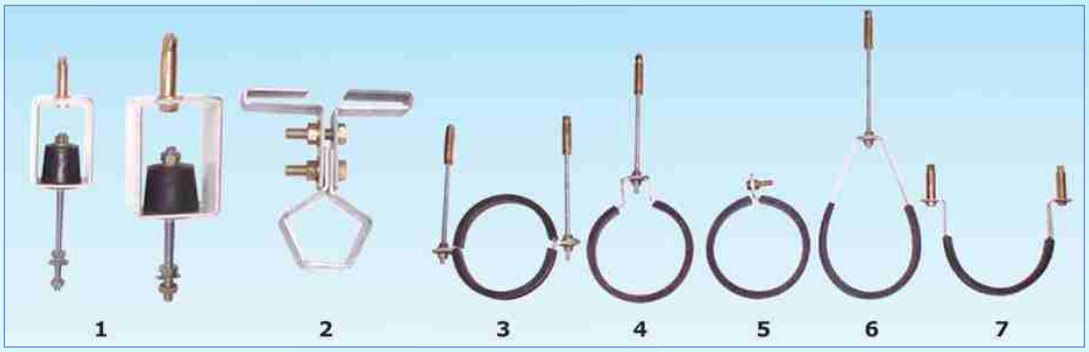
3.Split Clamp

4.Hightek Clamp

5.Ring Clamp

6.Universal Clamp

7.Wall Mounting Clamp



➤ FLAT - OVAL SPIRAL DUCT ➤

Flat -oval spiral duct is formed from round spiral duct. The straight sections of the long sides are stretched traut and perfectly flat. The flat oval shape is specifically designed for low head room and restricted space locations which can't accept round duct.

Spiral Duct work systems in both round and flat-oval shape have many advantages, some of the major advantages include

- Light weight spiral reinforced walls.
- Smooth streamline internal surfaces giving low friction loss and no turbulence.
- Long runs in continuous lengths.
- Simple joining Technique.
- Matted fittings of consistent size.
- Reduced space requirement in height or depth.

Specifications

Thickness: 0.60(24G) to I .00mm(20G)
Thickness of flat-oval spiral ducts as per **SMACNA HVAC Duct Construction Standards 1985**

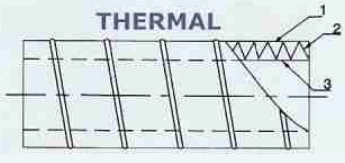
Major axis Duct width "B"	Spiral Duct Thickness Gauge (mm)	Duct Fittings Thickness Gauge (mm)
to 24"	24 (0.60)	22 (0.80)
25" to 36"	22 (0.80)	20 (1.00)
37" to 48"	22 (0.80)	20 (1.00)
49" to 60"	20 (1.00)	18 (1.20)
61 to 70"	20 (1.00)	18 (1.20)

Length: 4,8, and 10 ft.
Material : Galvanised steel, mild steel (CRCA), Aluminium, Stainless Steel etc.
Surface Constructions : Plain or Corrugated (to increase the radial rigidity, of the duct by 300%)

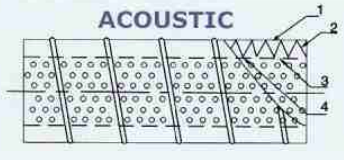
Pre-insulated Double-walled Flat Oval Duct

Thermal/ Acoustic Insulation :

A double-walled insulated Flat-oval Spiral Duct consists of an external pressure tight metal shell, 25/50mm thick of fiberglass/mineral wool / puf insulation and internal plain protective metal liner for thermal insulation or perforated metal inner liner for acoustic insulation.



1. Outer metal pressure shell
2. Insulation blanket
3. Internal smooth metal liner.

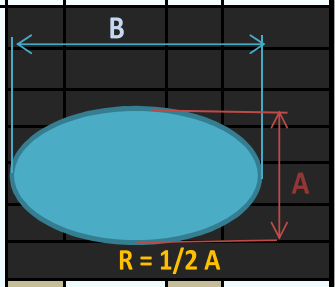


1. Outer metal pressure shell
2. Insulation blanket
3. Internal perforated metal liner.
4. Fiber glass tissue

STANDARD SIZE FOR OVAL DUCT OF GP SPIRA DUCT PVT. LTD.

NOMINAL DUCT WIDTH IN MM : (B)

Basic Circ. Dia	NOMINAL DUCT HEIGHT IN MM : (A) →											
	150		200		250		300		350		400		450		500
400	550		525												
425	581.25		550												
450	625		600		575										
475	662.5		631.25		600										
500	700		675		650		625								
525	737.5		712.50		681.25		650								
550	787.5		762.50		725		700		675						
575			787.50		762.5		731.25		700						
600			825		812.5		775		750		725				
625			868.75		837.5		812.5		793.75		750				
650			912.50		887.5		862.5		825		800		775		
700			987.50		962.5		937.5		912.5		875		850		825
750					1050		1012.5		987.5		962.5		925		900
800					1125		1100		1062.5		1037.5		1012.5		987.5
850					1200		1175		1150		1125		1100		1050
900					1287.5		1250		1225		1200		1162.5		1137.5
950							1325		1300		1275		1250		1225
1000							1412.5		1387.5		1350		1325		1300
1050							1500		1450		1425		1400		1375
1100							1575		1537.5		1500		1487.5		1450
1150									1625		1600		1550		1525
1200									1700		1675		1637.5		1612.5

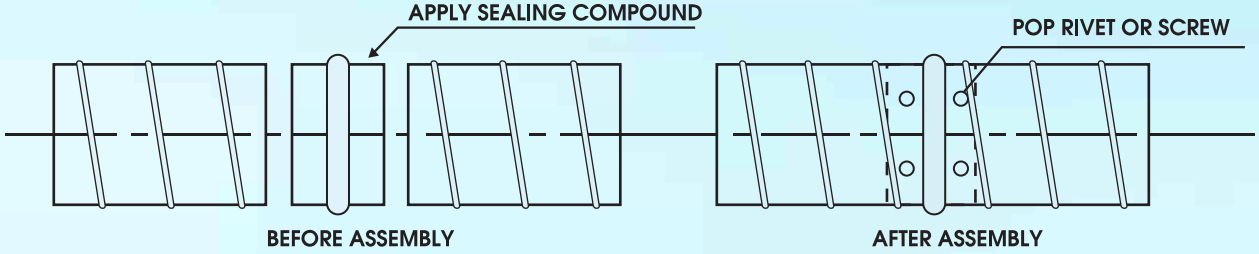


Duct Fittings :

A complete line of duct fittings designed for low leakage and efficient performance is available for use with single-wall and double-wall Flat-Oval Ducts.

Jointing System :

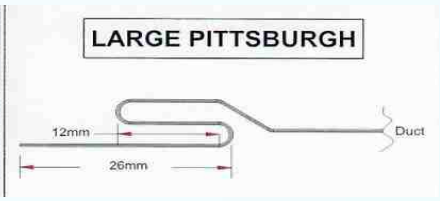
Flat-Oval Spiral Ducts and fittings joined together by slip joint coupling.

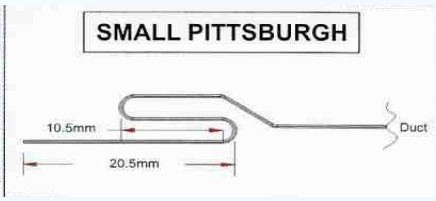


➤ RECTANGULAR DUCT ➤

Integrated Ducting System

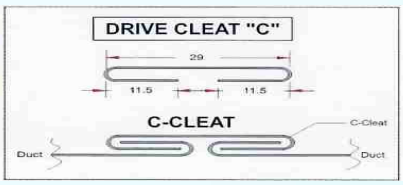
A. The **Longitudinal Joints** will be factory formed & sent to site in L shaped sections for easy transportation, site handling & storage & to facilitate easy assembly at site. Boxed up ducts also available on request.

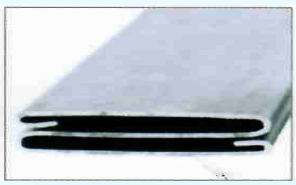


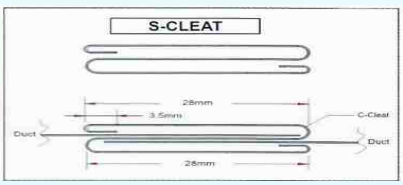


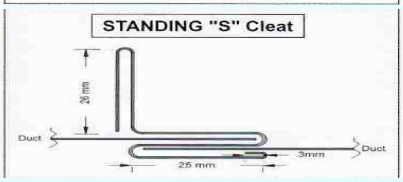
B. The **Transverse connectors** are C cleats, S cleats, Standing s cleats, TDF Flange (Integral Rolled on Duct Flange), 35mm mate Flange, Angle iron?GI Flange

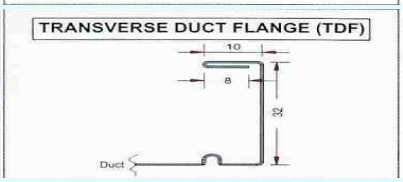
- C,S & Standing S cleats will be cut to size & sent loose to drive at site
- TDF corner flange will befixed on the L shaped contour, The corner Flange along with the requisite amount of C Clamps for flange locking will be sent separately.
- Slip on Mate Flange will have one corner flange locking will be sent separately.

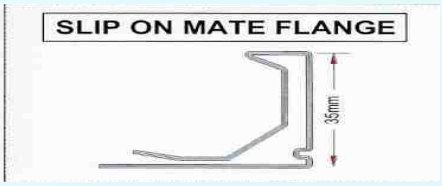












C. Bolts, Nuts, Gaskets, Sealants are also supplied on request to ensure thesystem is complete. This arrangement ensures that the duct can be boxed up & erected with simple hand tools.

RECOMMENDED SPECIFICATIONS										
SMACNA - 2005							IS 655 1963 & 2006			
Duct Sizes mm	OPERATION PRESSURE Pa						Low Pressure		Medium Pressure	
	250		500		1000					
	Gauge	Connector Type	Gauge	Connector Type	Gauge	Connector Type	Gauge	Connector Type	Gauge	Connector Type
0-450	26	C&S/TDF	26	TDF	26	TDF	26	C&S	22	TDF
451-750	26	C&S/TDF	26	TDF	24	TDF	24	C&Standing S/TDF	20	TDF
751-900	26	TDF	24	TDF	22	Slip on	22	C&Standing S/TDF	20	TDF
901-1000	26	TDF	24	TDF	20	Slip on	22	C&Standing S/TDF	20	TDF
1001-1200	24	TDF	22	Slip on	18	Slip on	22	TDF	20	TDF
1201-1300	24	TDF	20	Slip on	18	Slip on	22	TDF	18	TDF/Slip on
1301-1500	24	Slip on	18	Slip on			22	TDF/Slip on	18	TDF/Slip on
1501-1800	22	Slip on	18	Slip on			20	TDF/Slip on	18	TDF/Slip on
1801-2100	20	Slip on	18	Slip on			20	TDF/Slip on	18	TDF/Slip on
2101-2200	18	Slip on	18	Slip on			20	TDF/Slip on	18	TDF/Slip on
2201-2400	18	Slip on	18	Slip on			18	TDF/Slip on	18	Slip on
2401-2700	18	Slip on	18				18	TDF/Slip on	18	Slip on

- The specifications given above are based on the Relevant SMACNA & IS Standards. Ducts can also be manufactured based on other standards on request.
- Slip on Flanges indicate Mate/Angle Flanges
- Duct material can be GSS, Al or SS or other metals based on specifications.

➤ FLEXIBLE DUCT ➤

Flexible Duct: GP Spira flexible ducts class 1 listed and meet with requirements of ASTM E 84-08 a with flame spread ratio <20: smoke development ratio <40 made of 2ply multi-layered Aluminium Polyester, Metalised Polyester, etc. foils bonded together by quality adhesive with high carbon corrosion - proof spring wire. GP Spira Flexible ducts are non-flammable and more efficient.

Characteristics :

- Able to withstand high air pressure.
- Strong and Durable with 2 ply double facing aluminium foil.
- Tear and puncher resistant, energy efficient.
- No Problem of air leakage.
- GP Spira offers smooth Inner core which provides low friction loss. Low operating cost.
- Compressible and extendable by more than 10 times its original size. No problems of shrinking when fully extended.
- Non-flammable.

Application :

- Ideal for all air conditioning/ventilating systems and any other industrial or residential applications including hospital, hotel, commercial, office buildings and shopping malls.
- Very flexible and can be connected to whatever position required.
- Economical, quick and easy to install ever in complicated unworkable areas where other ducts cannot reach.
- Available bare or preinsulated with fibreglass of thickness 25mm (1"), or 50mm (2") X 1 6kg/m3 or 24kg/m3.

Size Available

Available in various I.D. ranging from 100 mm to 500 mm (4" to 20")

Supplied in Standard length of 7.5 meters each.

Uninsulated Duct

GP Spira uninsulated flexible duct is made of 2 ply multilayered metalized aluminium polyester permanently bonded to a coated spring steel wire helix.

Standard length	:	25Ft.
Range	:	150 mm to 500 mm dia.
Max. Permissible Velocity	:	5000 Fpm.
Max. recommended operating pressure	:	6" w.g. positive all dia. 1/2" w.g. negative all dia

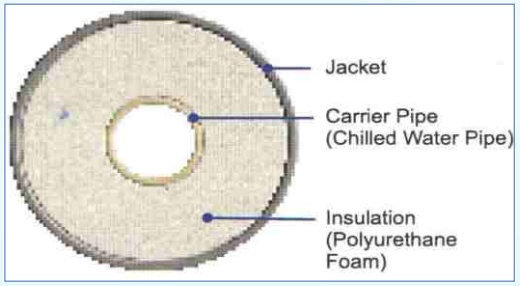
Insulated duct

GP Spira insulated flexible duct is made of 2 ply multilayered metalized aluminium polyester permanently bonded to a coated spring steel wire helix. Thermal efficiency is provided by wrapping the exterior with blanket of fi er glass insulation. The outer jacket is made of metalized polyester vapor barrier jacket

Standard length	:	25ft.
Range	:	150mm to 500mm dia.
Max. Permissible Velocity	:	5000 Fpm.
Max. recommended working pressure	:	8" w.g.
Temparetur range	:	32-2000 F
Insulation Thickness	:	25 mm/50 mm
Insulation Density	:	16kg/m3/24kg/m3
Insulation R-value	:	4.2 (oF-Ft.2 -hr/Btu)

➤ PRE-INSULATED PIPES ➤

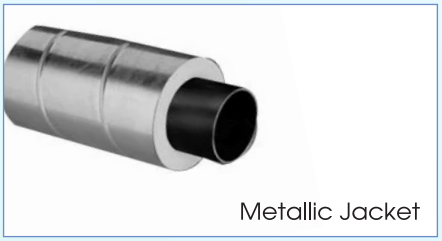
Today in India, Polystyrene or PUF pipe sections of 1m length are fixed to carrier pipes (chilled water pipes) using adhesives like hot bitumen or other compounds. Thus we have two longitudinal and one circumferential joint for every 1m length of pipe. Poor dimensional accuracy of pipe section and mismatch of carrier pipe O.D. and Insulation pipe section I.D. contour leaves a gap along the entire circumference between the two.Further a combination of factors, like quality of adhesive, improper and insufficient use of adhesive, lack of adequate space at field for proper insulation, poor quality of tradesmen, urgency of completion, lead to poor site insulation work. Thus, the present method gives room to openings and gaps for moisture to permeate and weaken insulation. Over a period of time these thermal losses lead to higher power consumption. Seven star pre-insulated pipes are designed to resolve all these problems.



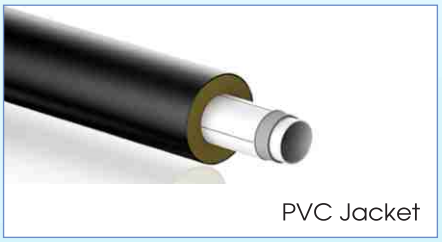
Sectional view of a Pre-insulated pipe

What are pre-insulated pipes?

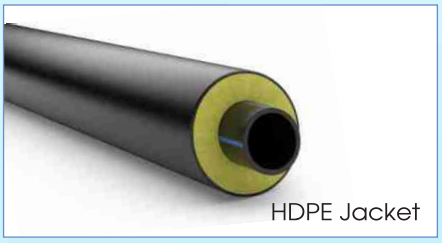
A metered dose of Poly urethane foam (PUF) is injected in the factory, in the angular space between carrier pipe (Chilled water pipe) and the outer jacket. The PUF expands and, upon setting, forms a homogenous insulation around the carrier pipe. The combination of pipe, insulation and jacket together is called pre-insulated pipe.



Metallic Jacket



PVC Jacket



HDPE Jacket

Specifications

1. Insulation	
Material	Polyurethane Foam
Thickness	25mm onwards to suit application
Density	Standard 36kg/m3 Other densities on specific request.
2. Fluid Temp. Range	-20^0 c to 120^0 c
3. Sizes	For carrier pipes 19mm onwards
4. Pre-insulated pipe length·	6m
5. Outer Jacket	6m
Metallic	GI/Al/Stainless Steel
Non-metallic	HDPE/PVC

Why Pre-insulated pipes?

Using Pre-insulated pipes ensures that the density of the insulation is accurate as metered dosages of chemicals are injected at the factory. This means a uniform insulation spread over the entire carrier pipe, ensuring no loss of energy.

Factory injection of PUF and Pre-fabricated kits for site fittings, ensure that the Carrier pipe, Insulation and Jacket form an integral part with ZERO" JOINTS. This means no chance for moisture to permeate and therefore much longer life for the insulation.

More than 2000 metres of insulation can be finished in a day. This means faster completion of chilled water piping work at site. This also means that lesser work at site especially where shafts and working spaces are small.

Factory insulation also ensures that there is a wide variety of choices for the outer skin. This enables the use of HDPE jackets for buried pipes which is not possible using the present methods.

The outer metallic jackets are also made of zero leak lock seam spiral tubes from a special spiral duct machine. This ensures that the quality of cladding is not dependent on the skill of the site worker alone.

Factory insulation and cladding also ensures excellent mechanical protection for the insulated piping. This means no special saddle or wooden block is required at site for supporting the insulated pipe.

Field Jointing Methods

Field Joint closure for overground piping

Place sleeve in position

Place elbow cover

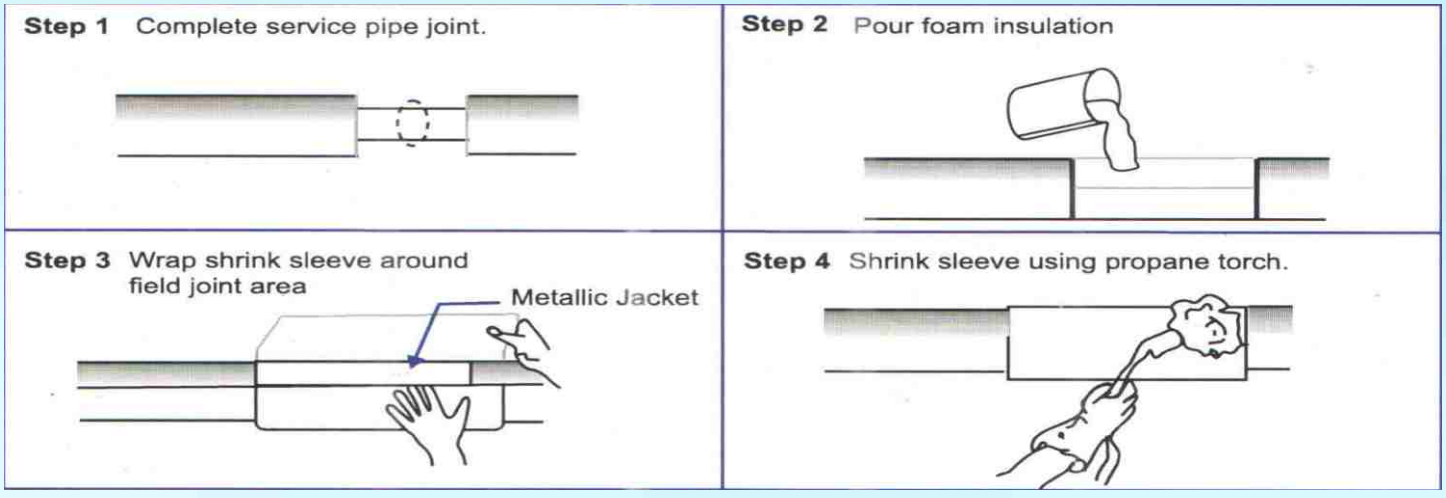
Place elbow cover

Open pour-hole on fitting cover

Pour Chemicals through opening

Pour Chemicals through opening

Field Joint closure for buried piping



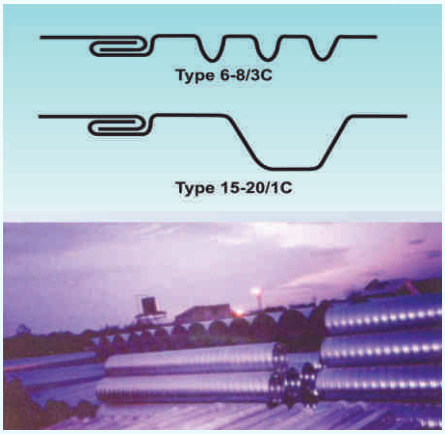
◄ VOID FORMING TUBES ►

Corrugations

Two different tubes corrugations are manufactured.

Type 6-8/3C with three 6-8mm deep corrugations between seams.

Type IS-20/IC with one 15-20mm deep corrugation between seams

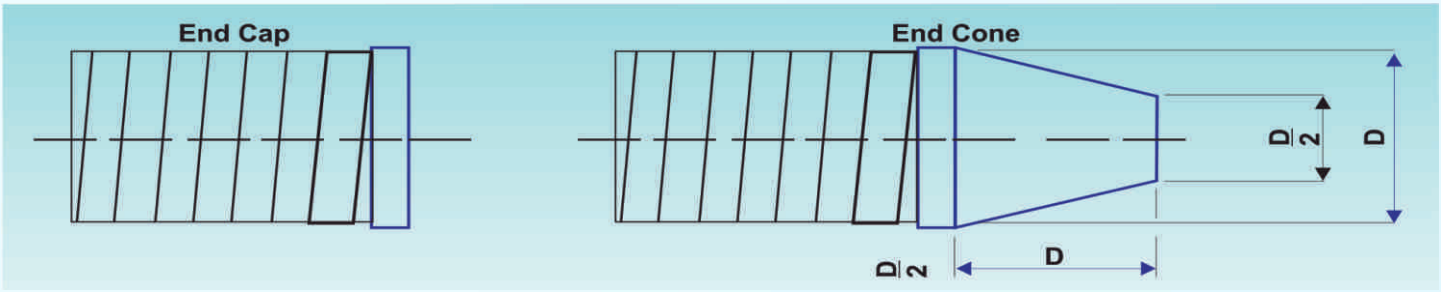


Material

GP SPIRA-VOID tubes are made of cold rolled steel and hot dipped Galvanized Steel

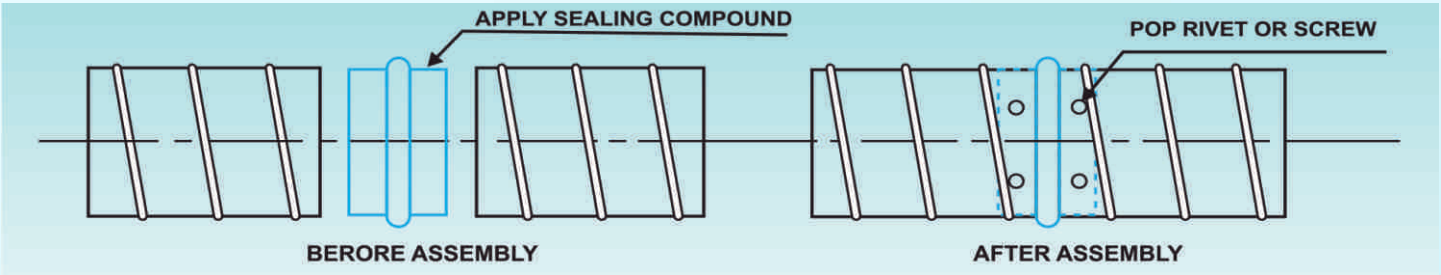
End Cones and End Caps

To close the ends of the GP SPIRA-VOID tubing. end caps or end cones can be used. Dimensions and total lengths are shown in the sketch below.



Jointing System

GP SPIRA-VOID tubes joined together by slip joint coupling



Product Information

GP SPIRA-VOID tubing has, on account of its special corrugations, a very high radial stiffness well adapted for use as void formers in concrete structures. It is also being used as culverts and forms for concrete piles, plinths and columns. As void formers SPIRA-VOID tubes are used to reduce the cross section area and thus the weight of the structure. The weight reduction will amount to approximately 40% and thus produce a favorable effect on foundation, wall and slab construction.

Applications

On many construction projects like apartment buildings, parking garages, office buildings, industrial buildings, bridges, and docks, schools and hospitals, the introduction of SPIRA-VOID tubes will make it possible to use very long spans. The reduction in weight allows large areas and fewer columns which in turn will give technical economical and esthetic advantages.

Characteristics

GP SPIRA-VOID tubes meet with structural design specifications for void former. It is a very rigid but yet light weight sheet metal tubing that without excessive deformation, withstands existing forces during the pouring of the concrete. The spiro seam is tight and no water from the concrete will enter the tubing. The low weight of the tubing makes it easy to handle.

Technical Data

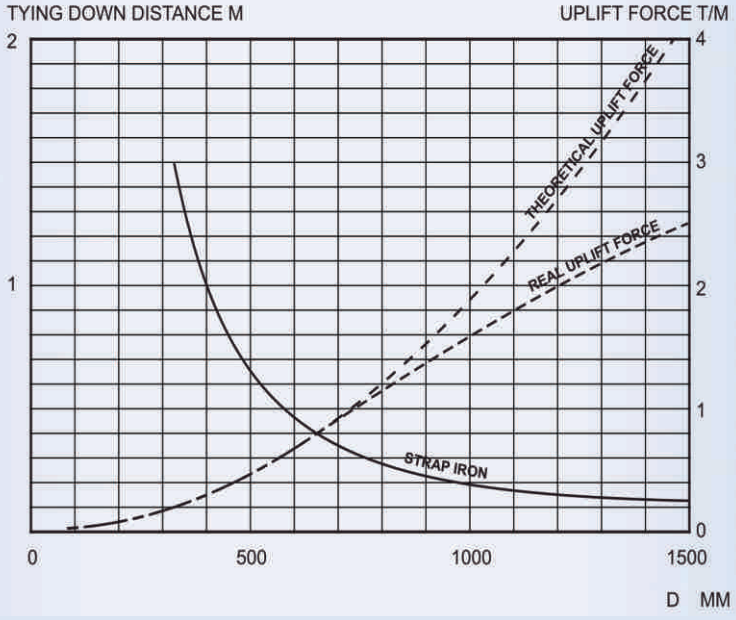
Dimensions

SPIRA-VOID tubes are manufactured exactly to specifications.

Length is limited only by transportation. Standard diameter and thickness are shown in Table below. Other dimensions are available on request.

Cat No.	Nominal Outside Diameter MM	Thickness	Weight Kg./M
150	154	0.5	2.06
200	201	0.5	3.34
250	252	0.5	4.17
300	302	0.5	5.01
350	351	0.5	5.85
400	402	0.5	6.71
450	453	0.5	7.55
500	504	0.5	8.40
600	605	0.5	10.00
700	706	0.7	16.47
800	807	0.7	18.82
900	909	0.7	20.80
1000	1010	0.7	23.12
1200	1213	0.7	27.80
1500	1521	0.7	34.45

Tying Down Distance and Uplift Force in Slabs



Theoretical uplift force according to Archimedes principle. Real uplift force is the highest force that will occur at normal pouring. Tying down distance is determined by real uplift force.

Note: **Mobile Machine** is available where the quantities and location warrants

➤ THE MANUFACTURING FACILITY ➤

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