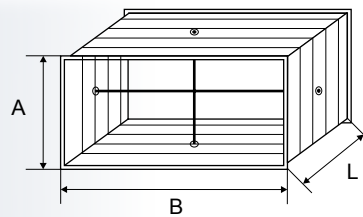
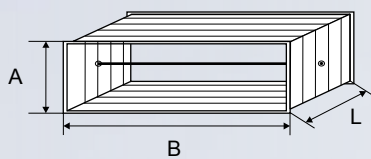


Technical data for execution of ducts and moulders

EXECUTION (Norm: PN-B-03434:1999, PN-B-76002:1996, PN-EN-1506:2001, PN-EN-1505:2001)		
min. underpressure/ max. overpressure	Low-pressure -400Pa / +1000Pa	Middle-pressure -1000Pa / 2500Pa
Dimension of longer side (mm)	minimal sheet metal thickness (mm)	minimal sheet metal thickness (mm)
100 - 499	0,60	0,70
500 - 899	0,80	0,90
900 - 2000	1,00	1,10
2001 - 4000	1,10	1,10

AIR TIGHTNESS (air tightness class according to PN-B-76001)				
Air tightness class	Ducts system	Leak index [f] at pressure differences [Dp]		
		200Pa	400Pa	1000Pa
A	normal air tightness	$0,84 \times 10^{-3}$	$1,32 \times 10^{-3}$	$2,40 \times 10^{-3}$
B	increased air tightness	$0,28 \times 10^{-3}$	$0,44 \times 10^{-3}$	$0,80 \times 10^{-3}$

RULES OF STIFFENING OF AIR DUCTS WITH GALVANIZED PIPES 1/2" STANDARD EXECUTION			
A (mm)	B (mm)	L (mm)	Number of stiffeners
< 1000	< 1000	< 1000	0
< 1000	≥ 1000	≥ 1000	1
< 1000	1500 + 2000	1000 + 1500	2
< 1000	1500 + 2000	1500 + 2000	3
≥ 1000	≥ 1000	1000 + 1500	1 cross-shaped
1000 + 2000	1000 + 2000	1000 + 1500	2 cross-shaped



RULES OF USE THE FRAMES IN AIR WIRES AND MOULDERS STANDARD EXECUTION			
Frame dimension depending on side length (mm)			
Side lengthness	≤ 1000	> 1000	> 2500
Profile dimension	P20	P30	P40

FURTHER INFORMATION:

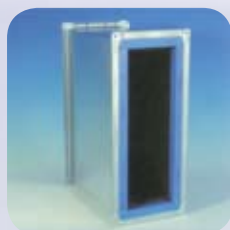
Dimension of air ducts surface according to DIN 18379
 Cold-rolled steel, galvanized on both sides, chromacised
 Corners and profiles are insulated with a sealing material.

Rectangular ducts and moulders



SPECIFICATION	PRICE
Air duct from galvanized sheet, low-pressure manufacture air tightness class A by PN-B-76001	22,20 €/m ²
Air duct from galvanized sheet, middle-pressure manufacture air tightness class A by PN-B-76001	23,30 €/m ²
Moulder from galvanized sheet, low-pressure manufacture air tightness class A by PN-B-76001	27,70 €/m ²
Moulder from galvanized sheet, middle-pressure manufacture air tightness class A by PN-B-76001	28,80 €/m ²

Insulated rectangular ducts and moulders



SPECIFICATION	PRICE
Double rectangular duct with inside insulation 50 mm	66,60 €/m ²
Double moulder with inside insulation 50 mm	80,50 €/m ²
Inside insulation with mineral wool 25 mm	17,70 €/m ²
Inside insulation with mineral wool 30 mm	18,00 €/m ²
Inside insulation with mineral wool 40 mm	24,40 €/m ²
Inside insulation with mineral wool 50 mm	26,11 €/m ²

Flange profile



SPECIFICATION	PRICE
RJFP 20 galvanized type P-20	1,40 €/rm
RJFP 30 galvanized type P-30	1,85 €/rm
RJFP 40 galvanized type P-40	4,19 €/rm



Execution from Al: factor 2



Execution from V2A: factor 4,5



Execution from V4A: factor 7

Corner



SPECIFICATION	PRICE
Corner for Profile 20 from galvanized Steel S-20	0,28 €/piece
Corner for Profile 30 from galvanized Steel S-30	0,45 €/piece
Corner for Profile 40 from galvanized Steel S-40	1,25 €/piece

Bolt clamps



SPECIFICATION	PRICE
Bolt clamp for KZ - Profile	0,32 €/piece
Connectiv overlay for NP - Profile	1,25 €/piece

Surcharge for supplementary works

SPECIFICATION	PRICE
DUCTS STRENGTHENING	
Inside strengthening with tube - single	1,38 €/m ²
Inside strengthening with tube - crossed	2,77 €/m ²
TIGHTNESS	
Air tightness class B by PN-B-76001	0,83 €/m ²
Brazed connection	5,55 €/m ²
PATTERN OF DUCT FOR MESH OR PROBE	
Duct pattern	2,22 €/piece
Duct pattern with assembly	3,88 €/piece
PICKLING OF DUCTS FROM STAINLESS STEEL	1,25 €/kg
SURCHARGE FOR DIMENSION	
Rectangular duct and moulder with side length from 2500 to 3500 mm	3,33 €/m ²
Rectangular duct and moulder with side length less than 130 mm	1,66 €/m ²

AI Execution from AI: factor 2

V2A Execution from V2A: factor 4,5

V4A Execution from V4A: factor 7