

AIR FLOW CHARTS

Chart 1			
CFM requirements at specified velocity.			
Dia.	3500 FPM	4000 FPM	4500 FPM
3"	170	195	220
4"	300	350	390
5"	475	550	610
6"	700	785	880
7"	950	1100	1200
8"	1200	1400	1570
9"	1550	1800	1990
10"	1900	2200	2450
12"	2800	3175	3600
14"	3800	4300	4800

Chart 2					
Static Pressure based on 100' of Pipe.				Elbow to Straight Pipe Conversion	
Dia.	3500 FPM	4000 FPM	4500 FPM	90° Elbow 1.5 Dia. Rad.	45° Elbow 1.5 Dia. Rad.
3"	7.5	10.0	12.0	5'	2.5'
4"	5.5	7.0	8.5	6'	3.0'
5"	4.2	5.5	6.5	9'	4.5'
6"	3.5	4.5	5.5	12'	6.0'
7"	2.8	3.8	4.5	13'	6.5'
8"	2.4	3.2	3.8	15'	7.5'
9"	2.0	2.8	3.4	17.5'	8.75'
10"	1.8	2.4	3.0	20'	10.0'
12"	1.5	2.0	2.5	25'	12.5'
14"	1.3	1.6	2.0	30'	15.0'

Recommended Minimum Duct Velocities

Metalworking dusts _____	4500 fpm branches	4000 fpm mains
Woodworking & other light dusts _____	4000 fpm branches	3500 fpm mains

Conveying Velocities

Material Conveyed	Conveying Velocity in Ducts-FPM
Vapors, gases, fumes, very fine dusts _____	1500-2000
Fine dry dusts _____	3000-3500
Average industrial dusts _____	3500-4000
Coarse particles _____	3500-4500
Large particles, heavy loads, moist materials, pneumatic conveying _____	4500 and higher