Claims

1. A duct flange structure which is arranged in an end portion of a tubular duct body having a substantially quadrilateral shape in section, comprising:

a flange portion formed by folding respective extension portions extending from an opening edge of each wall plate that forms a side of the duct body, each respective extension portion being folded away from the duct centre to form a substantially vertical portion relative to its wall plate and a horizontal portion extending substantially parallel to its wall plate from the vertical portion, **wherein** the folds of each respective extension section are such that they overlie and are in contiguous flat contact with each other resulting in a thickness that is twice as thick as the wall plate when a respective extension section is viewed in section.

2. The duct flange structure according to claim 1, wherein the vertical portion is formed with a bolt insertion hole for inserting a bolt into the vertical portion.

3. The duct flange structure according to claim 1 or claim 2, wherein the edge of the extension portion is inside of the duct body.

4. A manufacturing method for the duct flange structure according to any one of the preceding claims, comprising the steps of:

folding and superposing the extension portion in two or more to form a superposition portion; and

bending the superposition portion to form the

vertical portion and the horizontal.