

MESTEK MACHINERY

Year After Year Improving Duct Fabrication Productivity For You

LOCKFORMER



ABOUT OUR COMPANY

THE INDUSTRY STANDARD

Mestek Machinery is pleased to provide you with the latest edition of our product catalog. On the following pages you'll find the industry's widest range of high-performance Heating, Ventilation and Air Conditioning (HVAC) machinery and equipment, built to a standard of quality that's second to none. For your convenience we've listed as many details as possible about each piece of equipment. If you would like additional information or if you have any questions, please contact us at (319) 364-9181.

ONLY THE BEST FOR OUR CUSTOMERS

Mestek Machinery offers you much more than the industry's finest products – we also offer an unrivaled level of after-sales care and attention. Rest assured, when you commit to purchasing a Mestek Machinery brand product, we commit a broad range of experienced resources and expertise to you, making sure that you receive the maximum return on your investment.

Whether you have a maintenance request, want to upgrade your hardware or software, or just need a question answered, our experienced team of qualified professionals offers you the kind of careful assistance that is so rare these days.

Should you need a spare part, we'll get it to you quickly – even if you don't know the serial number of the machine or part.

What's more, Mestek Machinery has a knowledgeable group of dealers around North America which means that you are assured of ongoing local support.

Invest in Mestek Machinery and see for yourself why we set the standard for product quality, performance, customer service and integrity – the standard against which every equipment manufacturer in the HVAC industry is judged.

Mestek Machinery is proud to announce it is now certified as an ISO 9001:2008 compliant organization as accredited by NSF-ISR. The certification represents the achievement of a base-line of practice, procedure and documentation that Mestek Machinery will use to improve its products and services and to increase customer satisfaction.



All capacities of machines listed are based upon the use of galvanized or C.R.S. materials.

Galv. Sheet Gauge No.	Decimal Equiv.
16	0.063
17	0.057
18	0.051
19	0.045
20	0.039
21	0.036
22	0.033
23	0.030
24	0.027
25	0.024
26	0.021
27	0.020
28	0.018
29	0.017
30	0.015

NOTE:

All dimensions are "nominal" for categorization and identification purposes only.

Photos are shown without guards for clarity purposes only. Photos may also depict machines with special features that are optional.

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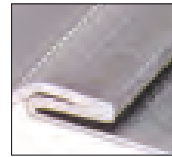
PITTSBURGH LOCK MODEL 24

The 24 gauge Pittsburgh rollforming machine has 5 forming stations and 1 inboard forming position. The forming chassis is constructed of 1/2" steel plate. This machine is compact and lightweight and can easily be taken to the job site!

An optional Auto-Guide Power Flanger attachment is available for the 24 gauge Pittsburgh machine. The flanging attachment follows any edge straight or irregular while forming a 7/32 (outside) flange height. Just turn up a starting flange in the table slot, feed materials into the rolls and let go. Handles radii down to 3.25" or 1.375" manually at speeds of 16 - 18 fpm.



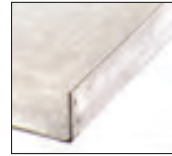
Model Details



Pittsburgh Lock Profile



Optional auto-guide power flanging attachment



The auto-guide power flanging attachment will create this right-angled flange

PITTSBURGH LOCK MODEL 20 AND MODEL 20 SUPER SPEED

The Pittsburgh Lock revolutionized the HVAC Industry in the late 1940's and is still used today for its strength and ease in assembling ductwork.

The Super Speed 20 and Model 20 Pittsburgh rollforming machines have 5 forming stations with 2 forming positions. One inboard forming position forms the Pittsburgh lock and one auxiliary or outboard forming position has the capability of forming 1 of 3 different profiles. Forming speeds are listed in the chart below.



PITTSBURGH LOCK MODELS 14-16-18

The Pittsburgh lock revolutionized the HVAC industry in the late 1940's and is still used today for its strength and ease in assembling ductwork.

The 14, 16, and 18 gauge Pittsburgh rollforming machines have 7 forming stations with 2 forming positions. One inboard position forms the Pittsburgh lock; and one auxiliary or outboard position has the capability of forming 1 of 8 different profiles depending on which auxiliary roll set is ordered. See chart pgs. 84 & 85. The forming speeds for the individual machines are listed in the chart below.

Standard with Lockformer® quality construction, these machines have industrial motors; high precision needle-type bearings; heavy 3/4" chassis plate; case-hardened and ground roll shafts; and arc-welded steel stands protected with Lockformer®'s top-quality primer and paint finish.

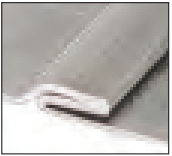
Pittsburgh Lock Models 14-16-18 Profile



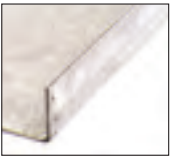
Model Details



Fast Seam Rollset



Pittsburgh Seam Profile



The auto-guide power flanger will create this right-angled flange See pg. 12



MODEL	CAPACITY	DEPTH OF POCKET/SIZE	OTHER	SPEED	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
PITTSBURGH LOCK MODEL 24	24-28 gauge	5/16" Uses approximately 1" of material	Width of hammer-over edge adjustable up to 3/8"	30-35 feet per minute	1/3H.P., 115/230 volts, 60 cycle, single phase, A.C. 1,800 RPM. Other motors available upon request	Length - 30" Width - 13.5" Height - 20" Weight - 175 lbs.
PITTSBURGH LOCK MODEL 20	20-26 gauge	5/16" Uses approximately 1" of material	Width of hammer-over edge adjustable up to 3/8". Extended shafts for mounting auxiliary rolls.	25 feet per minute	3/4 H.P., 115/230 volts, 60 cycle, single phase, A.C. 1,800 RPM. Other motors available upon request	Length - 36" Width - 16.5" Height - 41" Passline - 32" Weight - 450 lbs.
PITTSBURGH LOCK MODEL 20 SUPER SPEED	20-26 gauge	5/16" Uses approximately 1" of material	Width of hammer-over edge adjustable up to 3/8". Extended shafts for mounting auxiliary rolls.	75 feet per minute	2 H.P. 230/460 volts, 60 cycle, 3 phase, A.C. 1,800 RPM. Other 3 phase models available	Length - 48" Width - 24" Height - 42" Passline - 34" Weight - 450 lbs.
PITTSBURGH LOCK MODEL 14	14-16 gauge	1/2" Uses approximately 1-3/8" of material	Width of hammer-over edge adjustable up to 3/8". Extended shafts for mounting auxiliary rolls.	35 feet per minute	5 H.P., 230/460 volts, 60 cycle, 3 phase, A.C. 1,800 RPM. Other motors available upon request	Length - 58.5" Width - 24" Height - 41" Passline - 34" Weight - 750 lbs.
PITTSBURGH LOCK MODEL 16	16-20 gauge	1/2" Uses approximately 1-3/8" of material	Width of hammer-over edge adjustable up to 3/8". Extended shafts for mounting auxiliary rolls.	40 - 45 feet per minute	3 H.P., 230/460 volts, 60 cycle, 3phase, A.C. 3,600 RPM. Other motors available upon request	Length - 58.5" Width - 24" Height - 41" Passline - 34" Weight - 750 lbs.
PITTSBURGH LOCK MODEL 18	18-22 gauge	3/8" Uses approximately 1-1/8" of material	Width of hammer-over edge adjustable up to 3/8". Extended shafts for mounting auxiliary rolls.	40 - 45 feet per minute	2 H.P., 230/460 volts, 60 cycle, 3 phase, A.C. 1,800 RPM. Other motors available upon request	Length - 58.5" Width - 24" Height - 41" Passline - 34" Weight - 750 lbs.

BUTTON PUNCH SNAP-LOCK

The Button Punch Snap Lock Machine forms a two piece seam that greatly simplifies ductwork assembly. The male seam is a button, the female seam is a lock and the two snap together for a flush corner. These machines can form 20 to 26 gauge sheet metal into female locks on the inboard and button punched right angle flanges on outboard rolls at speeds of 60-65 fpm and are available in seven and nine forming station machines. Not only do these locks assemble twice as fast as traditional methods but, because the two pieces nest, they are easier to transport too.

Standard with Lockformer® quality construction, these machines have industrial motors; high precision needle-type bearings; heavy 3/4" chassis plate; case-hardened and ground roll shafts; and arc-welded steel stands protected with Lockformer®'s top-quality primer and paint finish. Alternate fittings are easily accessible from a main transmission bearing lubrication panel.

Button Punch Snap Lock Profile



Model Details



Outboard roll profile



Inboard roll profile

TRIPLEX CLEATFORMER

"S" cleats and more – A flexible Lockformer®, designed for super high productivity of inboard cleats. The triplex design has two inboard and two outboard forming positions allowing bearing support on both sides of the profile. The top plate and roll assembly are split into three zones with each having special design details like knurled rolls and angled guides to keep material moving through the machine in a straight line. These zones also can be adjusted by the operator to meet the requirements of a wide variety of gauges.

With 9 forming stations, the Triplex Cleatformer can form multiple gauge sheet metal into "S" and drive cleats on the inboard forming positions and up to 12 auxiliary offset profiles on the outboard forming positions at speeds averaging 100 fpm.

Standard with Lockformer® quality construction, this machine has a 5 H.P. industrial motor; high precision needle-type bearings; heavy 3/4" chassis plate; case-hardened and ground roll shafts; and an arc-welded steel stand protected with Lockformer®'s top-quality primer and paint finish.

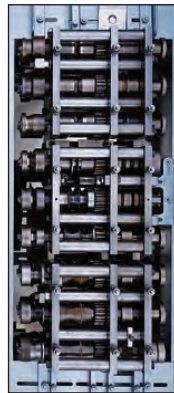
Model Details



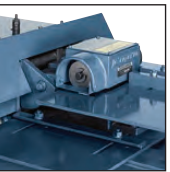
"S" Cleat inboard profile



Drive cleat roll profile



Form roll configuration



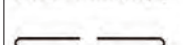
"S" and drive cleat scrap cutter attachment



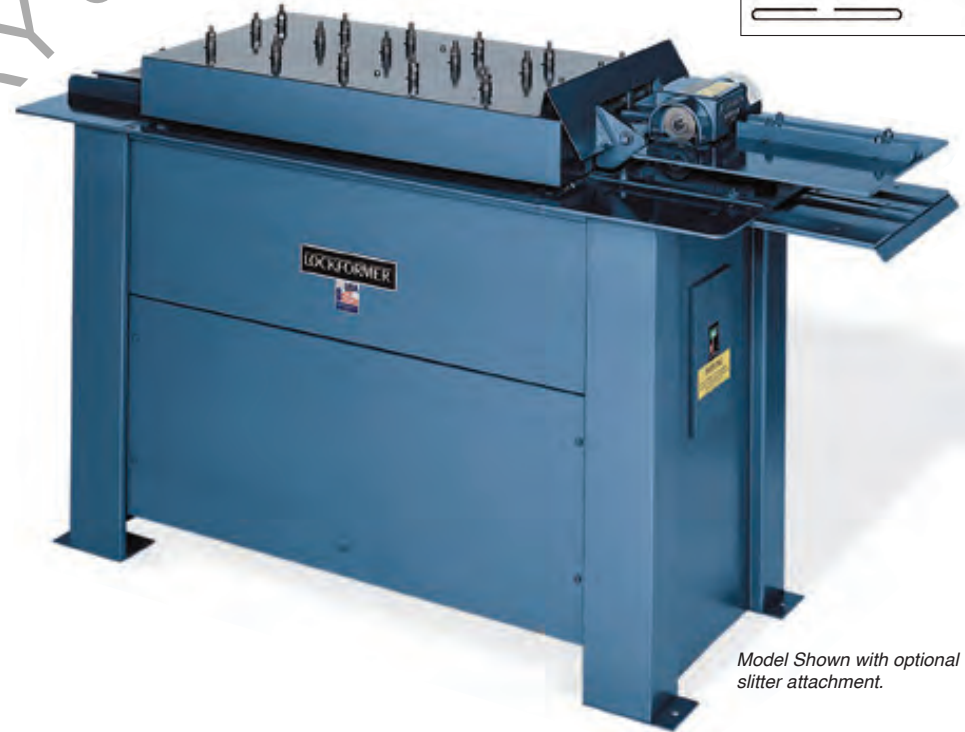
Plate housing

Triplex Cleatformer Profile

Drive cleat rolls inboard 20-26 gauge



"S" cleat inboard 22-26 gauge



Model Shown with optional slitter attachment.

MODEL	CAPACITY	DEPTH OF POCKET/SIZE	OTHER	SPEED	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
20 GAUGE BUTTON PUNCH SNAPLOCK	20-26 gauge	Uses approximately 1-3/4" material		60 - 65 feet per minute	3 H.P. 230/460 volts, 60 cycle, 3phase, A.C. 3,600 RPM. Other motors available upon request.	Length - 58.5" Width - 24" Height - 41" Passline - 34" Weight - 125 lbs.
TRIPLEX CLEATFORMER	22-28 gauge for "S" cleat profile and 20-26 gauge for drive cleat profile	"S" cleat width 1-1/16" Drive cleat width 1-1/8"	Extended shafts for mounting auxiliary rolls.	100 feet per minute	5 H.P. 230/460 volts, 60 cycle, 3phase, A.C. 1,800 RPM.	Length - 60" Width - 24" Height - 40" Passline - 32-1/2" Weight - 850 lbs.

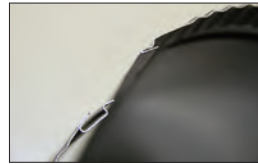
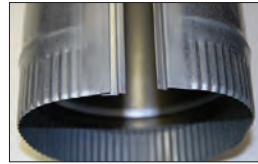
ROUND & OVAL PIPE MACHINE

Available in either 7-station or 9-station (for pre-curl) machines which fabricate both male and female forms for Reeves-type snap lock. Each lock is formed on flat sheets with no restrictions on the diameter of the finished pipe.

Round/Oval Pipe Machine Forms



Model Details



DRIVE TURN HEMMING

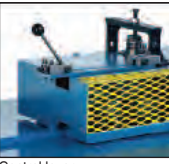
The Lockformer® Skip Dent Indexing Roll is the heart of the system. The indexer is the first roll and has four pins and two milled ridges. The control lever determines whether the blank is hemmed after the first or second notch. With the lever in position 1, as the blank engages the indexing roll, a pin drops into the first notch. A ridge adjacent to the pin pre-bends the material at its corner just enough to force the material into the hem forming rolls where the 180 degree hem is formed. The next pin, on the rotating index roll, drops into the second notch and since there is no ridge present, the corner of the blank is not turned down and misses the hemming rolls and this section remains unformed.



Model Details



Indexing roll



Control lever



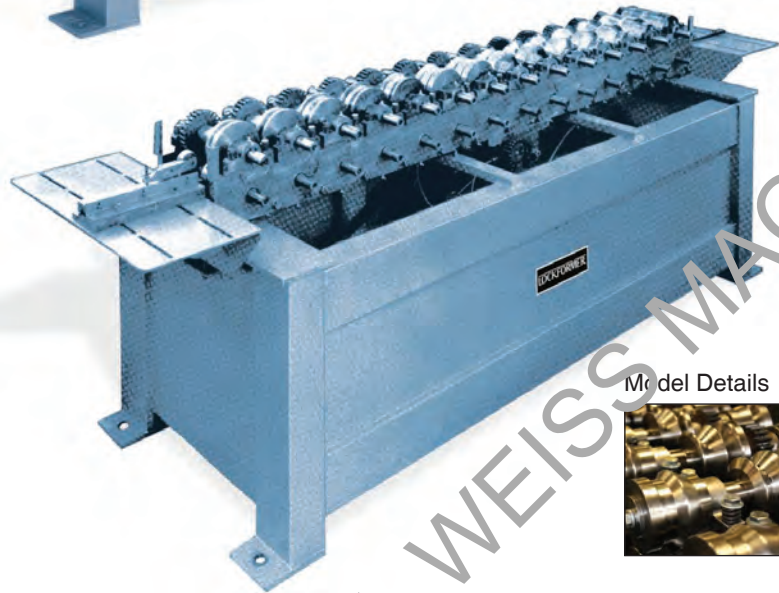
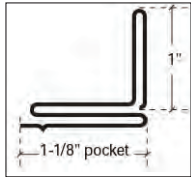
Rollset

MODEL	CAPACITY	DEPTH OF POCKET/ SIZE	OTHER	SPEED	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
ROUND/OVAL PIPE MACHINE 7 STATION	24-30 gauge	Uses approximately 1-9/16" material for both sides	V-belt	35 feet	2 H.P., 230/460 volts, 60 cycle, 3 phase, 3,600 RPM. Manual switch. Other motors available.	Length - 48" Width - 24" Height - 41" Passline - 34" Weight - 750 lbs.
ROUND/OVAL PIPE MACHINE 9 STATION	Pre-curl 24-30 gauge	Uses approximately 1-9/16" material for both sides	V-belt	35 feet	2 H.P., 230/460 volts, 60 cycle, 3 phase, 3,600 RPM. Manual switch. Other motors available.	Length - 48" Width - 24" Height - 41" Passline - 34" Weight - 750 lbs.
DRIVE TURN HEMMING	22-26 gauge	Uses approximately 1/2" Hem material	N/A	60 feet per minute	3 H.P. 230/460 volts, 60 cycle, 3phase, A.C. 3,600 RPM	Length - 60" Width - 30" Height - 48" Passline - 34" Weight - 800 lbs.

STANDING "S" CLEAT [10 STATION]

In just one pass, form a shape that combines a conventional "S" cleat with a standing seam for greater strength and rigidity. This seam is adaptable in fabrication of large trunk or branch lines in industrial and commercial heating and ventilating ducts. Included are double-extended auxiliary shafts for a variety of choices for optional rollform tooling. The design integrity and quality construction of its 10-station configuration will provide years of trouble-free service.

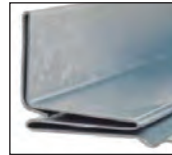
Standing "S" Cleat Profile



DS CONNECTOR [14 STATION]

This Lockformer® 14-Station Connector Machine is for the contractor who has need for only one duct connector profile inboard but wants the flexibility of two outboard auxiliary forming stations. It has the same rigid double plate construction as the popular Lockformer® Standing "S" Cleat Machine yet offers more forming stations, more combinations of standard rolls and more versatility.

Model Details



"S" Cleat profile



Detail of rollformer

Model Details



SUPER 11 CLEATFORMER [11 STATION]

When the job calls for heavy-duty "giants," this machine tool is it. For a multitude of HVAC rollforming shapes and profiles, look no further than the Super 11 Cleatformer. Pittsburgh Lock, Acme/Double Seam, Combination 3-1, Hemming, Boot Clip and reinforced "S" and drive cleats are just some of the many rollset tooling options you can add to this Super machine.

Every 11-station Cleatformer incorporates Lockformer®'s precision built head-plates, offers extended shafts on both sides of the machine and can accommodate many other sheet-edge operations including the 20 gauge Pittsburgh Lock and the Button Punch Snap Lock.

Famous Lockformer® quality construction with an industrial motor and gear box; high precision bearings; heavy duty three zone chassis; plate head construction; hardened and ground roll shafts all protected with a cabinet finished with Lockformer®'s top-quality primer and paint finish.

Model Details



"S" Cleat profile



MODEL	CAPACITY	DEPTH OF POCKET/ SIZE	OTHER	SPEED	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
STANDING "S" CLEAT	20-26 gauge	1-1/8" pocket. Uses approximately 6-1/4" material stretch out inboard	Extended shafts for mounting auxiliary rolls	60 - 70 feet per minute	5 H.P., 230/460 volts, 60 cycle, 3phase, A.C. 1,800 RPM	Length - 84" Width - 30" Height - 37" Passline - 33" Weight - 1,700 lbs.
DS CONNECTOR 14 STATION	Variable	Variable		70 feet per minute	7.5 H.P., 230/460 volts, 60 cycle, 3 phase, 1,800 RPM. across-the-line starter	Length - 115" Width - 32" Height - 48" Passline - 33" Weight - 2,150 lbs. without roll
SUPER 11 CLEATFORMER 11 STATION	22-26 gauge for "S" cleat operation	Standing "S" cleat height 1/2" Standing "S" cleat width 1-1/6"	V-belt	100 feet per minute	5 H.P., 230/460 volts, 60 cycle, 3 phase, 1,800 RPM. Manual switch with across-the-line starter	Length - 67" Width - 24" Height - 40" Passline - 32 - 1/2" Weight - 950 lbs.

AUTO-GUIDE FLANGER MODEL 16

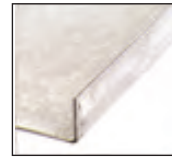
These ductwork prep machines automatically follow any edge – curved or straight.

Use the convenient table slot to turn up a “starting flange” and let it go! A calibrated dial can be set for radii as small as 3-1/4" (or 2" when auto-guide is deactivated). Automatically flange 16 to 26 gauge material at speeds of 18 fpm. A non-releasing type head is suitable for open-end fittings, straight and irregular curves.

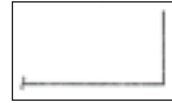
Standard with Lockformer® quality construction, this machine has an industrial electric motor, and an arc-welded steel stand protected with Lockformer®’s top-quality primer and paint finish.



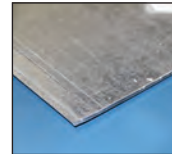
Model Details



Right-angle flange



Auto-guide flanger 16 profile



AUTO-GUIDE POWER FLANGING ATTACHMENT

Auto-Guide will automatically follow any edge — straight, inner or outer radii — and no change over is necessary between Pittsburgh Lock and flanging operations.

Automatically handles radii down to 3-1/4". Lock out the automatic feature to run a radius down to 1-3/8". Two Auto-Guide Power Flanging Attachment models are available, one for Model 24 and one for Model 20.



Model Details



Optional auto-guide power flanging attachment



Auto-guide flanger 16-18 profile

BUTTON PUNCH CHEEK BENDER

This machine provides any shop with a complete work center for fabricating fittings. One side of the dual purpose bending die bends and punches the cheeks for Button Punch Snap Lock 90-degree fittings. Flip the die over and you have a 20 gauge Power Cheek Bender for making right-angle flanges or Pittsburgh fittings. Self contained hydraulic system.



Model Details



BUTTON PUNCH SNAP-LOCK FLANGER

Roll single-direction curves down to a minimum radius of 3-1/2" inside or a 5" outside radius, almost automatically. These punched right-angle flanged curves fit perfectly in the receiver formed on the Lockformer® 20 gauge or the 24 gauge Button Punch Snap Lock.

Model Details

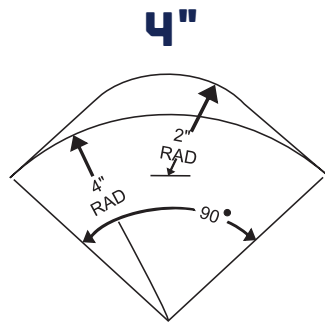
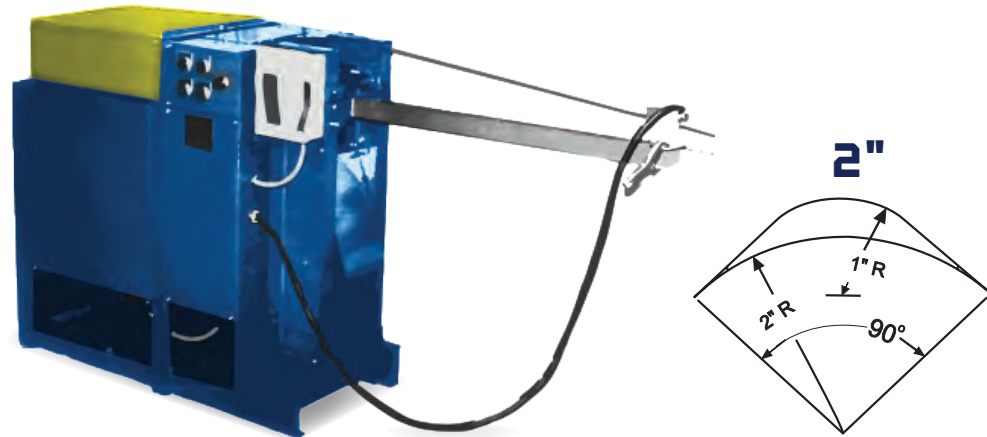


Snap-Lock profile

MODEL	CAPACITY	DEPTH OF POCKET/SIZE	OTHER	SPEED	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
AUTO GUIDE FLANGER MODEL 16	16 gauge maximum. Working range 16-24 gauge	Two flange heights available. Specify 3/8" or 1/4"	N/A	18 feet per minute	3/4 H.P. 115/230 volts, 60 cycle, single phase, A.C. 1,800 RPM	Length - 24" Width - 24" Passline - 34" Weight - 225 lbs.
AUTO GUIDE POWER FLANGING ATTACHMENT	20 gauge or lighter	Makes flanges approximately 7/32" outside height	N/A	16 - 18 feet per minute	N/A	Length - 14" Width - 10" Passline - 8.5" Weight - 32 lbs.
BUTTON PUNCH CHEEK BENDER	20 gauge or lighter	Variable	Self contained hydraulic system	N/A	3/4 H.P. 115/230 volts, 60 cycle, single phase, A.C. 1,800 RPM	Length - 24" Width - 28" Passline - 34" Weight - 200 lbs.
BUTTON PUNCH SNAP-LOCK FLANGER	20 gauge maximum Working range 20-28 gauge	7/16" flange	N/A	18 feet per minute	3/4 H.P. 115/230 volts, 60 cycle, single phase, A.C. 1,800 RPM	Length - 24" Width - 24" Passline - 34" Weight - 250 lbs.

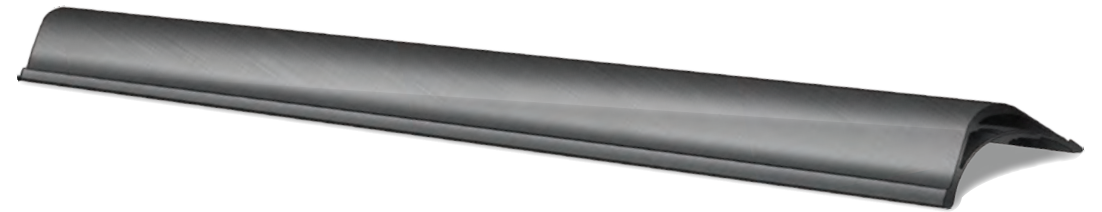
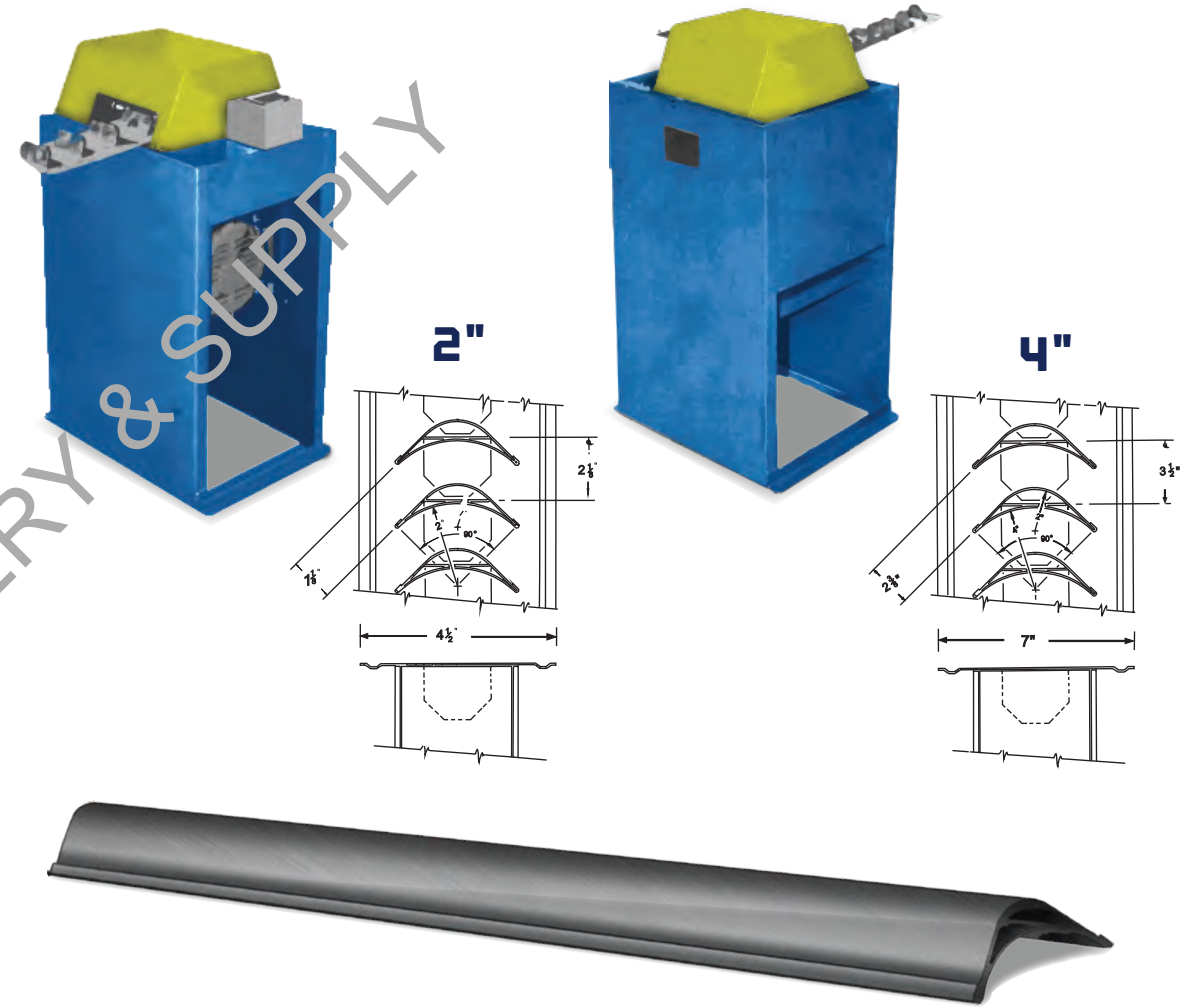
VANEMAKER

Mestek Machinery is now the exclusive provider of the Harper-type Vanemake, previously offered by Harper Metal Products. These machines for roll forming double wall air turning vanes, now joined with the HVAC fabricating expertise of Lockformer. With the Vanemaker, produce 500 pieces of 12" long vane per hour or up to 400 pieces of 36" long vane per hour.



PUSH-TYPE RAILMAKER

Mestek Machinery is now the exclusive provider of the Harper-type Railmaker, previously offered by Harper Metal Products. These machines for roll forming push-type side rails, now joined with the HVAC fabricating expertise of Lockformer.



MODEL	CAPACITY	PART LENGTH	OTHER	MOTOR/VOLTAGE	CRATE DIMENSIONS
2"VANEMAKER	26 gauge	48" maximum	N/A	Vane Motor 3ph / 208-230 V / 60HZ. / 20 amp. min. 1725 RPM Shear motors 3ph / 1 1/2 HP. / 208-230 V / 60HZ. / 1725 RPM	Length - 54" Width - 35" Height - 51" Weight - 850 lbs.
4"VANEMAKER	24 gauge	120" maximum	N/A	Vane Motor 5ph / 208-230 V / 60HZ. / 20 amp. min. / 1725 RPM Shear Motors 2 HP. / 208-230 V / 3ph / 60HZ. / 1725 RPM	Length - 76" Width - 42" Height - 54" Weight - 1,950 lbs.
2"PUSH-TYPE RAILMAKER	22-26 gauge	N/A	2 1/8" Vane Spacing	3 HP. / 1,140 RPM / 208-230-460 V / 3ph / 60HZ.	Length - 24" Width - 20" Height - 45" Weight - 300 lbs.
4"PUSH-TYPE RAILMAKER	22-26 gauge	N/A	3 1/2" Vane Spacing	3 HP. / 1,140 RPM / 208-230-460 V / 3ph / 60HZ.	Length - 28" Width - 20" Height - 45" Weight - 300 lbs.

TDC® V

The TDC® V Rollformer has 12 forming stations and produces TDC® flanges at speeds of up to 50 feet per minute!

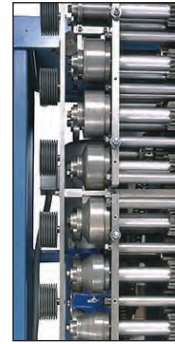
This is the only transverse duct connector machine on the market certified to comply with SMACNA Duct Construction Standard (DCS) T-25a based on actual laboratory tests across the full range of water gauges.

Famous Lockformer® quality construction with an industrial motor and gear box; high precision bearings; heavy duty two zone chassis; plate head construction; hardened and ground roll shafts all protected with a cabinet finished with Lockformer®'s top-quality primer and paint finish. Optional rolls are available for TDC® Clip or Pittsburgh lock production.

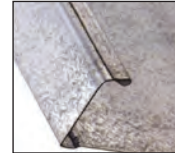
*Ask about our TDC® Notching machine and Corner Cadet® to speed up your productivity even more.



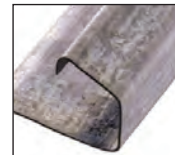
Model Details



Rollset



TDC flange profile



Optional clip flange profile



Scan this QR Code for more information on the TDC® V

TDC® Assembled Profile



TDC® 14 STATION [2 PLATE]

Rollforming your own sealable flanges on transverse duct ends during the manufacturing process has never been easier. The TDC® flange, formed on the machine's left-hand auxiliary, has unique, snap-on corners that eliminate spot welding. Optional rolls are also available for Z-Bar and TDC® Clip.



TDC® TRIPLEX 14 STATION [3 PLATE]



Model Details



TDC® flange profile

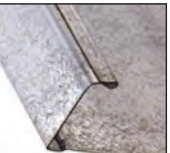


Optional clip flange profile

TDC® Assembled Profile



Model Details



TDC® flange profile



Optional clip flange profile



Optional clip flange profile

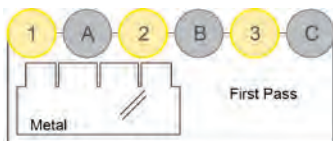
MODEL	CAPACITY	DEPTH OF POCKET/SIZE	OTHER	SPEED	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
TDC® V	18-24 gauge for TDC® 22 gauge for optional Clip Rolls	1-7/8" for TDC® 2-1/8" for Clip	Extended shafts for mounting auxiliary rolls	50 feet per minute	7.5 H.P. 230/460 volts, 60 cycle, 3phase, A.C. (22 amps @230V) 1,800 RPM	Length - 137" Width - 38" Height - 48" Passline - 33" Weight - 2,800 lbs.
TDC® V 16	16-22 gauge for TDC® 22 gauge for optional Clip Rolls	1-7/8" for TDC® 2-1/8" for Clip	Extended shafts for mounting auxiliary rolls	50 feet per minute	7.5 H.P. 230V/460 volts, 60 cycle, 3phase, A.C. (22 amps @230V) 1,800 RPM	Length - 137" Width - 38" Height - 48" Passline - 33" Weight - 2,800 lbs.
TDC® 14 STATION [TWO PLATE] [THREE POSITION] [ONE INBOARD]	18-24 gauge for TDC® 22 gauge for optional Clip Rolls	1-7/8" for TDC® 2-1/8" for Clip	Extended shafts for mounting auxiliary rolls.	50 feet per minute	10 H.P. 230V/460 volts, 60 cycle, 3phase, A.C. (28 amps @230V) 1,800 RPM	Length - 144" Width - 33" Height - 48" Passline - 33" Weight - 3,900 lbs.
TDC® TRIPLEX 14 STA- TION [THREE PLATE] [FOUR POSITION] [TWO INBOARD]	18-24 gauge for TDC® 22 gauge for optional Clip Rolls	1-7/8" for TDC® 2-1/8" for Clip	Extended shafts for mounting auxiliary rolls.	50 feet per minute	10 H.P. 28 amp @230V/460 volts, 60 cycle, 3phase, A.C. (28 amps @230V) 1,800 RPM	Length - 144" Width - 33" Height - 48" Passline - 33" Weight - 4,400 lbs.

TDC® NOTCHER [3/5/6 HEAD MODELS]

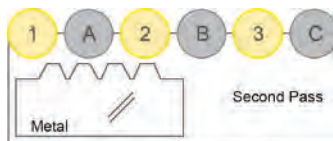
For fast and accurate gang notching of duct blanks.

TDC® NOTCHER comes standard with 5 notching heads.

The LOCKFORMER® TDC® NOTCHER will gang notch duct blanks as much as 6 times faster than notching by hand. The Hydraulic powered notch units have individual shutoff valves for positive control. Notch units are designed for fast and easy repositioning. A built in locking handle and a measuring scale makes notch location setup a simple task. Notch depth is also adjustable. The TDC® NOTCHER has a thickness capacity of 16 ga. / 1,6 mm in galvanized mild steel.



First pass uses combination heads TDC 1, 2, & 3



Second pass uses combination cleat heads drive A, B & C

The yellow circle represents the combination of heads being used

*Patterns shown are for 6 head models



SPEEDNOTCH MODEL 16 [3&5 HEAD MODELS]

Speednotch allows you to gang-notch sheet metal hydraulically up to 600% faster than by hand, without layout or scribing.

It's the perfect tool for preparing ductwork to receive bar, slip or "S" and other drive connections. So, its profitability is tremendous ... even on single piece set-up. Complete self-containment provides instantaneous setting from the front for up to 5 notches on materials up to 16 gauge with 3-1/4" to 10' stretch out and a foot switch permits one man, unskilled, to handle most notching jobs.



MODEL	CAPACITY	DEPTH OF POCKET/SIZE	OTHER	SPEED	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
TDC® NOTCHER [3/5/6 HEAD MODELS]	16 gauge mild steel 10 feet	2 7/16" for TDC® notch 1-1/2" for "V" notch	Available in 3, 5 and 6 head combinations	N/A	3 H.P. 230/460 volts, 60 cycle, 3phase, A.C. 1,600 RPM.	Length - 122" Width - 24" Height - 52" Passline - 45" Weight - 800 lbs.
SPEEDNOTCH MODEL 16 [3&5 HEAD MODELS]	16-28 gauge	N/A	N/A	N/A	3 H.P. 230/460 volts, 60 cycle, 3phase, A.C. 1,800 RPM	Length - 122" Width - 24" Height - 52" Passline - 45" Weight - 800 lbs.

EASY EDGER (MANUAL)

Turn perfect flanges on elbows or other curved fittings as fast as you can notch them. No gauge to set. Hand clamps to any bench. Available with or without stand. 20 gauge maximum.

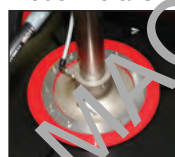


COLD SEALANT SYSTEM [5 OR 55 GALLON]

These portable cold sealant units (available in both 5-gallon and fixed 55-gallon sizes) should be factory installed to all Lockformer® rollforming machines and are available with one to four gun systems. Optical eye triggers are included to adjust flow. Snuffer devices are also included to eliminate leaks in the shut-off position. From pump assemblies to nozzles, everything is quality engineered for top performance. The sealant itself is specially formulated to produce perfect, non-toxic, flame-retardant sealing beads to ductwork in-shop or on-site. Beads that won't crust or shrink – even under extreme temperature conditions.

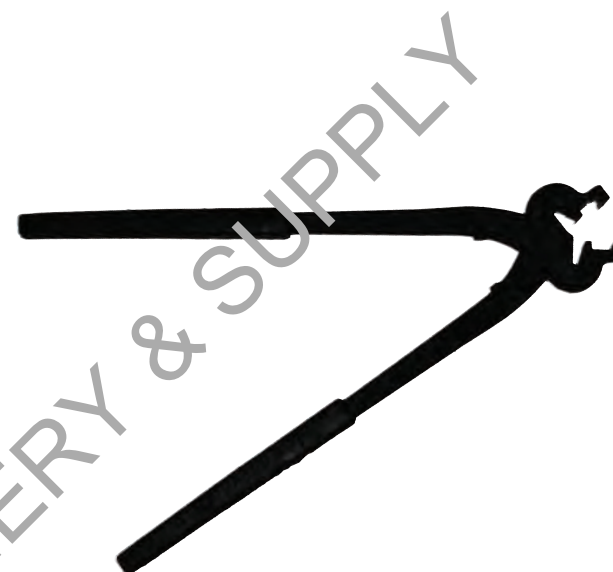


Model Details



TDC®/TDF® CLIP TOOL

This specially designed and engineered Clip Tool makes effortless work out of the installation of 6" TDC® or TDF® SMACNA specified clips. Snapping the clips into place with pliers or channel locks can damage the clip and compromise the rigid binding integrity of the TDC®/TDF® joint. [Model L535950]



TDC®/TDF® CORNER CLEAT WRENCH

When manually inserting corners with a hammer, take the necessary next step to insure that the corners are securely held in place with the TDC®/TDF® Corner Tool. The process is effortless and uniformly bends the TDC®/TDF® flange over the inserted corner so that no corners are lost in shipment and/or during field installation. [Model A-1]

GALV-OFF (PER CASE)

There is simply no better product to soften and dissolve galvanize build-up on forming rolls and press dies.

Galv-Off has been used by metal fabricators around the world to keep precision rollformers from advanced roll wear and tooling damage.

Do not use common off-the-shelf lubricants on your machines. These paraffin based products actually attract dirt, grime and galvanized particles! Galv-Off is specially formulated to lubricate as it cleans. The spray nozzle has been developed to deliver an accurate and precise coating so you don't waste any. Handy 12 oz. aerosol size cans come in cases of 12. SDS (formerly MSDS) sheet provided.



12 cans per case



12 ounce aerosol size

MODEL	CAPACITY	DEPTH OF POCKET/SIZE	OTHER	SPEED	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
EASY EDGER	20 gauge galvanized	1/4" flange	Optional stand	N/A	N/A	Width - 4" Height - 18" with stand Weight - 23 lbs.
COLD SEALANT SYSTEM	N/A	N/A	Optical eye included	Rollformer speeds limited to 65 feet per minute on per-cut length	115 volts, 60 cycle, single phase, Air= 100 psi	Length - 24" Width - 28" Passline - 34" Weight - 175 lbs. (5 Gal System) 300 lbs. (55 Gal System)

COLLARMAKER (DOVE TAIL WITH TABS)

Notch, bead, crimp & roll in one pass!

Save time and money by combining notching, beading, crimping and rolling in one operation.

For complete round starting collars 3 to 14 inches in diameter out of 24-30 gauge galvanized steel, the Lockformer® Collar Maker is the perfect tool. All it takes is one pass! Just cut to width and length or use scrap. This machine uses either 3" or 6" width blanks with simple movement of the crimp roll.



SPIN COLLAR MAKER

Make your own spin collars in minutes. Just cut galvanized stock (24 gauge & lighter) to width and length, set the diameter from 4" to 16", and push the blank against the automatic stop. A synchronized die notches the lead edge for easy spin-installation on the job site. The notched piece is then pushed past the stop, feeding the part into the roll former and finally into the automatic crimping and curling operations. Two models are available - Model 6 (2" to 6") and Model 12 (2" to 12").

Model Details

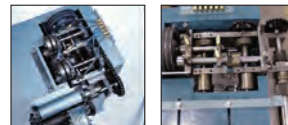


ROTO NOTCHER

Dove-tail notch out of 24 to 30 gauge galvanized — in only one pass!

Just cut to width and length or use scrap. This machine uses either 3" or 6" width blanks with simple adjustment.

Model Details



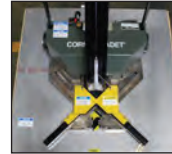
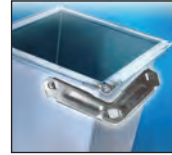
MODEL	CAPACITY	DEPTH OF POCKET/SIZE	OTHER	SPEED	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
COLLARMAKER (DOVE TAIL WITH TABS)	24-30 gauge	N/A	Tab-notch depth 5/8" standard, adjustable to 3/4" Optional depth available upon request. Tab-notch spacing Approx. 3/4" center	30 fpm	3/4 hp, 115 volt, single phase Drive - V-belt	Length - 20" Width - 22" Height - 36" Weight - 300 lbs.
ROTO NOTCHER	24-30 gauge	N/A	30 feet per minute	30 fpm	3/4 hp, 115 volt, single phase Drive - V-belt	Length - 20" Width - 23" Height - 36" Weight - 300 lbs.
SPIN COLLARMAKER	24-30 gauge	N/A	Curling Diameter - 4-16" MODEL 6: 2" - 6" MODEL 12: 2" - 12"	40 fpm	3/4 hp, 1725 rpm, 115 volt, 1 phase	Length - 22 1/2" Width - 42" Height - 37 1/2" Weight - 400 lbs.

CORNER CADET® (PORTABLE)

Fast, easy corner insertion and crimping in ducts and fittings. Although the Corner Cadet® is portable and light in weight, it's heavy on performance, automatically inserting and crimping specially designed TDC® and TDF® corners in seconds. In addition to handling virtually every style of duct, the Corner Cadet® also works with multiple types of straight fittings. Automatic duct squaring. For ducts and fittings from 18 ga., 1.2 mm to 26 ga. and .6 mm galvanized mild steel. For angled fittings to 16 ga., 1.6 mm, please see the Cornermatic Plus® on page 31.



Model Details



6016 BEADER

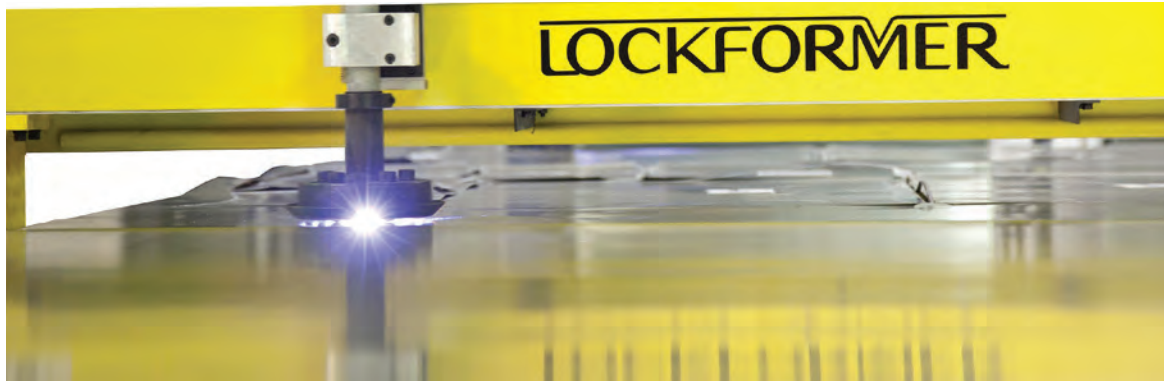
Beading is a cost-conscious way to stiffen ductwork. It is 5 times faster than the old method, cross-braking, and uses only one operator. Designed to meet the requirements of SMACNA, this ductwork prep machine produces 5 beads on 12" centers and is adjustable to 3/16" depth. A convenient hand-wheel raises or lowers the top roll assembly to set depth of bead. The top and bottom rollers are kept parallel with adjustable screw and pillow block assemblies connected by a link chain. Individual adjustable screw and pillow block assemblies connected by a link chain. Individual collared beading rolls are replaceable. Feed rolls are self-compensating over the entire gauge range. Double entrance feed bars are provided so that material can be gauged from either left or right side.

With Lockformer® quality construction, this machine has an industrial electric motor; precision bearings; turned, ground, and polished steel forming rolls and roll shafts; and an arc-welded steel stand protected with Lockformer®'s top-quality primer and paint finish. Lubrication fittings are located on each bearing.

Model Details



MODEL	CAPACITY	DEPTH OF POCKET/SIZE	OTHER	SPEED	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
CORNER CADET®	18-26 gauge	N/A	N/A	N/A	110 volt, single phase, 60 cycle Air = 90 PSI	Length - 34.5" Width - 32" Height - 49.5" (top of handle) Platform - 48.5" x 48.5" Weight - 240 lbs.
6016 BEADER	16-30 gauge	N/A	N/A	30 fpm	3/4 H.P. 115/230 volts, 60 cycle, single phase, A.C. 1,800 RPM	Weight - 1650 lbs. Capacity: 16 gauge max. width 5 ft.

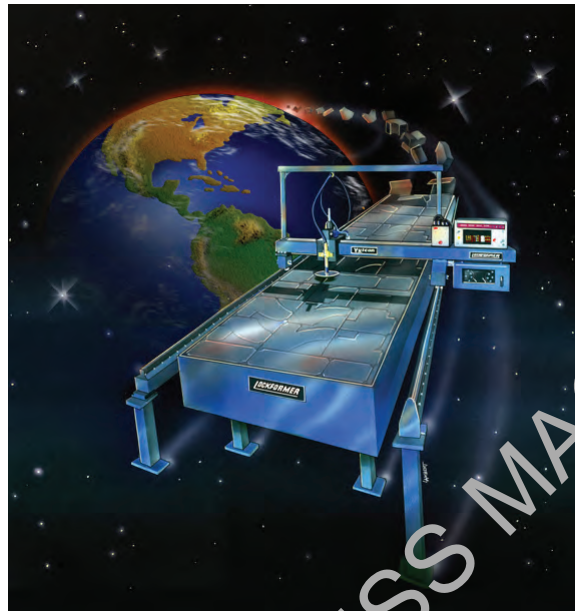


LOCKFORMER VULCAN® [DURABILITY, PRECISION, AND CRAFTSMANSHIP]

It's what's in a name—durability, precision, and craftsmanship. It's the confidence and pride in knowing a job's done right. It's why we put our name on every product, so at the end of the day you can put your name on yours.

The very first Vulcan® Model 1200 was unveiled in January of 1982 at the Atlantic City ASHRAE Show. Now, 30 years later, the "Vulcan" product brand name has become the most recognized HVAC Plasma Cutting System in the world and there are no other competitive brands that come close.

A superior product brand because it has earned the reputation for unrivaled quality, performance and value. Through the years, Lockformer®'s steady stream of innovations provide the latest trends in HVAC sheet metal cutting and these influences significantly set us apart. Trust Lockformer®'s Vulcan® to drive your business. HVAC contractors rely on Vulcan's sheet metal cutting software and table to increase shop productivity, reduce waste and improve their bottom line.



VULCANPLUS® CUTTING SYSTEM

Vulcan® is . . .

Simply the best....Worldwide. The Plus is the benchmark in plasma cutting systems - now featuring the new "Flex-Ability" technology to side or end load.

A superior product brand because it has earned the reputation for unrivaled quality, performance and value.

Through the years, Lockformer®'s steady stream of innovations provide the latest trends in HVAC sheet metal cutting and these influences significantly set us apart.



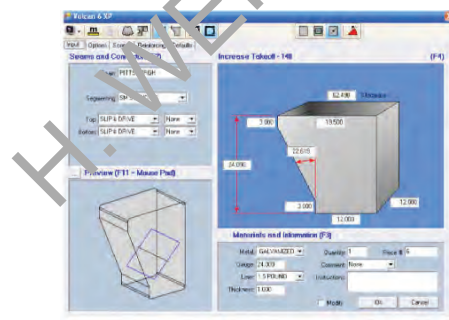
Model Details



Cutting software library of fittings



Cutting software options



Gain additional productivity with the optional **Trimble Field Fitting Input (TFFI)** for iPad, the most efficient and easiest way to enter sheet metal fitting information in the field and transfer it to the office for import into your Vulcan® cutting software. Whether you are looking to do a small residential or large commercial project, Trimble Field Fitting Input covers you with a comprehensive fitting library for most any situation. Additionally, **TFFI** provides your organization with 97% of the Vulcan® CAM software library of fittings. **TFFI** allows contractors to keep each project separate, and keep floor and drawing information separate within each project. Contractors are able to enter every dimension as well as the type of metal, gauge, insulation and liner thickness, and seam data. Reduce errors and rework while increasing productivity and return on investment.

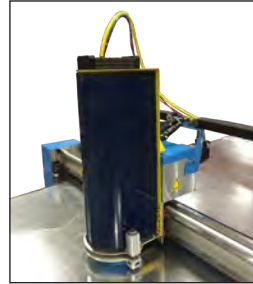
MODEL	SOFTWARE/ COMPUTER SYSTEM	MACHINE CONTROL	PLASMA UNIT	CUTTING CAPACITY	CUTTING AREA & TABLE CAPACITY	SPEED	APPROXIMATE DIMENSIONS	APPROXIMATE WEIGHT
VULCANPLUS® CUTTING SYSTEM	Vulcan® 6XP HVAC Dell PC with 19" Monitor & Printer	7590 CNC-TS & 15" Color Graphic Industrial Touch Screen	Hypertherm Standard: PowerMax 45 Optional: PowerMax 65	3/8" Mild Steel 1/2" Mild Steel	5'x10' Standard - 50x200' Optional Table Capacity 1,000 pounds	Positioning Speed 3,000 IPM Max.	164" long 81" wide 58" high	2,700 lbs.

VULCAN® LASER MAX

The next evolution in the Vulcan cutting systems is the Laser-Max. With minimal heat affected zone on the cut edge, the parts coming off the machine will cause less wear to downstream fabrication equipment. Minimal kerf combined with 4-axis controls enable the cutting of intricate patterns.

- Laser cutting uses less heat – edges are not hardened leading to less wear and tear on other machinery.
- Exclusive Patent-pending technology allows operator to access parts directly from the table and eliminates need for a pallet shuttle system.
- Coil feeding made easy as full table enclosure is eliminated – Laser Max 1.5 can be sheet or coil fed.
- Laser-Max features a fiber laser resonator – the latest in industrial laser cutting.
- Running speed up to 1100 ipm on thinner materials (24-26ga).
- All rack and pinion 4-Axis (2-Y, 1-X, 1-Z) controlled. Z is servo driven with automatic torch height.

Model Details



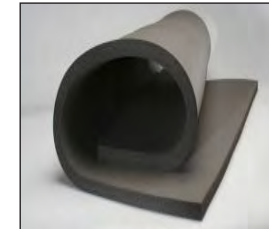
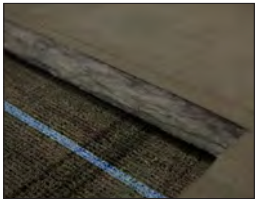
VULCAN® 1600WJ WATERJET CUTTING SYSTEM

Lockformer's® Vulcan® plasma cutting systems have been shipped around the world for 30 years, so you can trust the Vulcan® 1600 WaterJet to provide you with superior performance including the latest technology.

The Vulcan® 1600 WJ is designed with traditional Lockformer® quality and reliability, to eliminate the duct liner bottleneck in your shop while reducing the labor associated with this process.

HVAC contractors rely on Vulcan's® insulation cutting software and table to increase shop productivity, reduce waste, and improve their bottom line.

Model Details



Vulcan®
1600 WJ Waterjet
Cutting System
Specifications

MODEL	SOFTWARE/ COMPUTER SYSTEM	MACHINE CONTROL	CUTTING/PLASMA UNIT	CUTTING CAPACITY	CUTTING AREA & TABLE CAPACITY	SPEED	APPROXIMATE DIMENSIONS	APPROXIMATE WEIGHT
VULCAN® LASER MAX 1.5	Vulcan® 6XP HVAC PC with 19" Monitor & Printer Other Cam Software interfaces available upon request	Mach 3 & Color Graphic Industrial Touch Screen	0.75 KW Standard 1.0 and 1.5 KW available	0.120" Mild Steel Mild Steel Optical Cutting Capacity	Standard: 5'x10' Optional: 5'x20' Table Capacity 350 lbs.	Positioning Speed 1,100 IPM Max.	168" long 96" wide 63" high (5' x 10' table)	3,200 lbs.
VULCAN® 1600 WATERJET	Vulcan® 6XP HVAC Dell PC with 19" Monitor & Printer	7590 CNC-TS & 15" Color Graphic Industrial Touch Screen	KMT STREAMLINE SL-VI 15-HP WaterJet intensifier	Up to 4" Fiberglass or 2" Foam Insulation	5' x 10' Standard 5' x 20' Optional Table Capacity: 2,500 lbs.	3,000 IPM Max Positioning Speed	Length - 168" Width - 96" Height - 63"	4,500 lbs.

VULCAN® 1500 COMBINATION PLASMA & KNIFEJET CUTTING SYSTEM

Double-up your fabrication capabilities with this all-in-one machine that processes both plasma cut metal and knife cut duct liner.

Your cutting table drives your business. Trust Lockformer®'s Vulcan to drive your table.

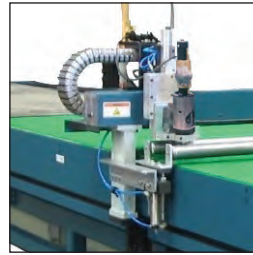
Manual cutting of duct liner is wasteful. This system cuts costs by reducing insulation scrap and you know fiberglass costs more than metal these days.

HVAC contractors rely on Vulcan's insulation cutting software and table to increase shop productivity, reduce waste, and improve their bottom line.

Insulation Cutting System Consisting of:

- 5' x 10' Cutting Table.
- Hypertherm Powermax 45 Plasma Unit, Upgrade to Powermax 65 available.
- Includes Reusable Turf Covered cutting board that replaces slat configuration on normal plasma cutting table.
- Equipped with Special Knife for cutting up to 1.5 lbs 1.5" Short Fibered Insulation, not ROTARY and not 1" minimal spec.
- Also quoted with the product is the optional bar code scanner and software that offers "On Demand" nesting of the fitting insulation pieces.
- (2) Full width Pneumatic Hold down rolls for positive positioning of the Insulation while cutting fittings
- Option to buy Roto-Zip attachment instead of knife blade to cut insulation

Model Details



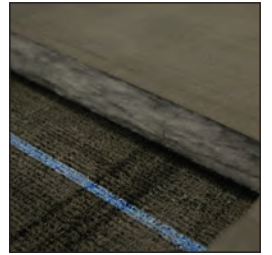
VULCAN® 1700 KNIFEJET INSULATION CUTTING SYSTEM

Your cutting table drives your business. HVAC contractors rely on Vulcan's insulation cutting software and table to increase shop productivity, reduce waste, and improve their bottom line. The Vulcan® 1700 Insulation Cutting System consists of 'turf' covered cutting board that replaces the typical slat configuration on normal plasma cutting tables. Equipped with special knife for cutting up to 1.5 lb, 1.5" short fibered insulation, not rotary and not 1" minimal spec, and pair of full width pneumatic hold down rolls for positive positioning of the insulation while cutting. Optional bar code scanner and software offers "On Demand" nesting of the fitting insulation pieces.

Insulation Cutting System Consisting of:

- 5' x 10' Cutting Table
- Includes Reusable Turf Covered cutting board that replaces slat configuration on normal plasma cutting table.
- Equipped with Special Knife for cutting up to 1.5 lbs 1.5" ROTARY type duct liner
- Also quoted with the product is the optional bar code scanner and software that offers "On Demand" nesting of the fitting insulation pieces.
- (2) Full width Pneumatic Hold down rolls for positive positioning of the Insulation while cutting fittings
- Option to buy Roto-Zip attachment instead of knife blade to cut insulation

Model Details



Scan this QR Code for more information on the Knifejet 1700



MODEL	SOFTWARE/ COMPUTER SYSTEM	MACHINE CONTROL	CUTTING UNIT	CUTTING CAPACITY	CUTTING AREA & TABLE CAPACITY	SPEED	APPROXIMATE DIMENSIONS	APPROXIMATE WEIGHT
VULCAN® 1500 COMBINATION PLASMA & KNIFEJET	Vulcan® 6XP HVAC Dell PC with 19" Monitor & Printer	7590 CNC-TS & 15" Color Graphic Industrial Touch Screen	Hypertherm Powermax 45	Cut 3/8" Mild Steel-Powermax 45 Cut 1/2" Mild Steel-Powermax 65 1.5" Fiberglass Insulation	5' x 10' Standard 5' x 20' Optional Table Capacity: 2,500 lbs.	3,000 IPM Max Positioning Speed	164" long 81" wide 58" high	2,700 lbs. (5' x 10' model)
			Upgrade to Powermax 65 available					
VULCAN® 1700 KNIFEJET	Vulcan® 6XP HVAC Dell PC with 19" Monitor & Printer	7590 CNC-TS & 15" Color Graphic Industrial Touch Screen	Knife Blade	1.5" Fiberglass Insulation	5' x 10' Standard 5' x 20' Optional Table Capacity: 1,00 lbs.	3,000 IPM Max Positioning Speed	Length - 168" Width - 96" Height - 63"	2,700 lbs.

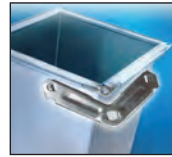
DUAL HEAD CORNERMATIC® CLASSIC

Cornermatic® automatically inserts and crimps specially designed TDC®/TDF® style corners in seconds. Lets you do a duct section, eight corners, in about 60 seconds with virtually no physical exertion. Compared to other methods of hand insertion and crimping, it's a saving of 3 to 6 minutes per section of ductwork depending on size and gauge.

- Corners are inserted square and fully crimped.
- No need to change the crimping adjustment when inserting corners in 18 to 26 gauge ducts.
- Each quick loading magazine holds up to 175 corners.
- Corners are shipped presorted and oriented for direct loading into the magazine.
- No need for hand sorting.
- Push the ductwork or fitting into the flange guides and the machine automatically does the rest.
- Rotate duct to each corner, then flip and repeat until all 8 corners are crimped.
- Handles 5' nominal duct



Model Details



Scan this QR Code to use the Cornermatic ROI Calculator

ADJUSTABLE DUAL HEAD CORNERMATIC® CLASSIC

Adjustable Dual Head Cornermatic® Classic adds the feature of automatically adjusting the upper crimping head to handle duct from 48" to 72" in length.

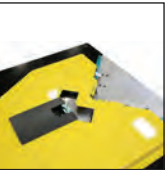
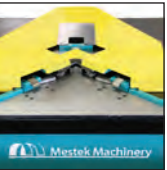
CORNERMATIC PLUS®

The CORNERMATIC PLUS® was specifically designed to address the difficulty with inserting corners into some styles of fitting ductwork. It joins other world-wide successful Cornermatics such as the Dual-Head and the Corner Cadet® in reducing shop labor. Three years in development brings to the trade a machine that can handle any TDC®/TDF® fitting assembled on a bench. The CORNERMATIC PLUS® automatically and effortlessly inserts and crimps TDC®/TDF® corners in seconds. Lets you do a duct section (eight corners) in about 20 seconds in any gauge, 16 through 26. Generally, tests have shown 80 ducts/hour vs. 15 ducts/hour for manual insertion.

- Specifically designed for the fabrication of duct fittings - even your toughest inside or outside angle offset transition fitting from 16-26 gauge.
- Fully automated - no switches or foot pedals - just push in, Cornermatic Plus® does the rest.
- Completes (8) corner inserts in seconds.
- New quick loading StrapPak™ packaging technology speeds loading and eliminates the need to sort and orient the corners before installation.
- Corners feed from below the work-surface allowing a clean, unobstructed work area.
- Handles tight square throat elbows and flex connectors.
- Works with SMACNA-conforming, T-25a and T-25b flange and many other flanged duct systems, without changing settings.
- Ask about optional table or 'in-floor' mounted unit.
- Bring your fitting productivity up to duct section standards!



Model Details



Strap-Pak™ US Patent No. 9,377,213 B2; 9,545,695 B2

MODEL	CAPACITY	DEPTH OF POCKET	OTHER	SPEED	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
DUAL HEAD CORNERMATIC® CLASSIC & ADJUSTABLE DUAL HEAD CORNERMATIC® CLASSIC	18 to 26 (.050" to .022" / 1.3mm to 0.6mm) Mild Steel Only	Flange Type for insertion: TDC®/TDF® (Customer to Specify)	Model Capacity - Depends on strapped or boxed type corners used 16 gauge capacity available.	Approximately 2 ½ seconds per corner	Electrical - 110/1/60 (Single Phase) Air - 85 to 100 PSI (5.5 - 7 Bar)	Model CM3-DH: 24-1/8" x 24-1/8" x 116" Weight - 1,400 lbs. Model CM3-DHA - 35-3/4" x 35-3/4" x 127" Weight - 1,800 lbs.
CORNERMATIC PLUS®	16 to 26 (.0062" to .022" / 1.6mm to 0.6mm) Mild Steel Only	Flange Type for insertion: TDC®/TDF® (Customer to Specify)	Model Capacity - Max 80 Corners StrapPak™ Quick-loading sleeve loads in 10 seconds	Approximately 2 ½ seconds per corner	Electrical - 110/1/60 (Single Phase) Air - 85 to 100 PSI (5.5 - 7 Bar)	Model CM-P Length - 32" Width - 36" Height - 34" Weight - 600 lbs.

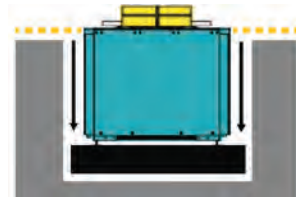
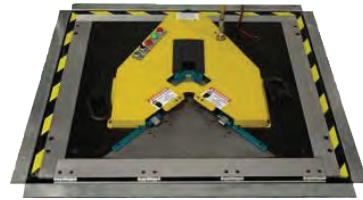
CORNERMATIC PLUS® IG

Our NEW Cornermatic® IG [In Ground] model was created with the largest duct in mind and still retains all of the outstanding features and benefits of the Cornermatic Plus®.

Material handling your largest duct sections and fittings is time-consuming and problematic. By creating this floor-level Cornermatic® IG, we've solved those troubles by locating the controls, the air and electrical connections, as well as the lifting hooks to the top of the machine.

KEY FEATURES:

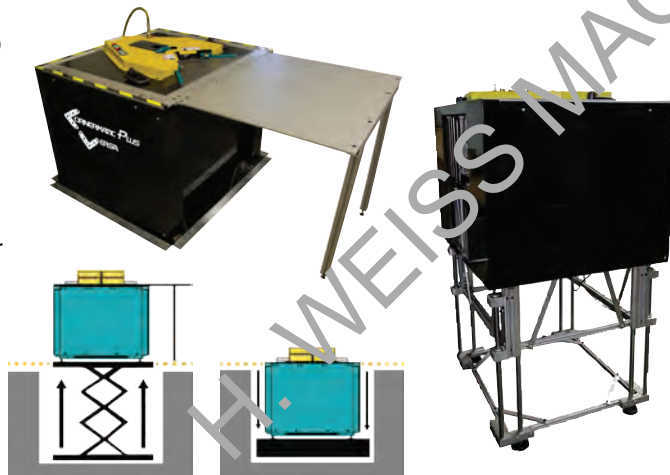
- Cornermatic® IG was specifically designed for automated corner insertion of large duct sections and fittings, inside or outside angle off-set transition fittings from 16-26 gauge.
- Fully automated - no switches or foot pedals - just push in, Cornermatic® IG does the rest.
- Completes (8) corner inserts in seconds.
- New quick loading StrapPak™ packaging technology speeds loading and eliminates the need to sort and orient the corners before installation.
- Corners feed from below the work-surface allowing a clean, unobstructed work area.
- Handles tight square throat elbows and flex connectors as well.
- Works with SMACNA-conforming, T-25a and T-25b flange and many other flanged duct systems, without changing settings. New quick loading StrapPak™ packaging technology speeds loading - same as Cornermatic Plus®.
- EZ Connector™ or Cornermatic® Corners for use in the Cornermatic®II™ are available in the traditional boxes or a new quick loading apparatus from Mestek Machinery and other distributors.



CORNERMATIC PLUS® VERSA

Our most flexible unit for production combines the ability to produce heavier gauge larger fittings and straight duct while the Versa is lowered in the ground position. The Versa also gives the operator the option of raising the Cornermatic Plus® into the above ground table height position for fitting production.

The Versa utilizes a heavy duty hydraulic scissor lift to safely raise and lower the unit table height for fitting production with just a push of a button!



CORNERMATIC® COMBO

The CORNERMATIC® II™ ~ WHISPER-LOC® COMBO is a unique, innovative machine that not only inserts and crimps corners into both ends of ductwork but closes longitudinal Pittsburgh seams on the same ductwork when required. This design allows the operator to accomplish both corner insertion and seam closing on one machine without having to handle the ductwork between processes.

The corner insertion is a pneumatically operated process that rapidly and automatically inserts and crimps corners into both ends of ductwork that uses the TDC® or TDF® method of joining. This unit automatically places a corner piece into a corner on each end of the duct and crimps them securely and permanently into place.

The seam closing is powered by an electric motor and gearbox using a Variable Frequency Drive. It will accommodate duct with various end joining methods. It will close the Pittsburgh seam as well as insert corners on any ductwork that uses the duct flanges conforming to T25-a or T25-b under the Duct Construction Standards. It will also close the Pittsburgh seam only on ductwork that uses the raw edge or slip and drive method.

The CORNERMATIC II® ~ WHISPER-LOC® COMBO requires only compressed air and 460/3/60 current to operate.

Specially designed corners for automation are quickly loaded into the magazines from the shipping cartons. The corners come oriented and stacked in the carton for quick and easy loading. The CORNERMATIC II® ~ WHISPER-LOC® COMBO is capable of utilizing standard StrapPak™ corners. The standard StrapPak™ come loaded with 80 corners per sleeve for the traditional Cornermatic® type and with 78 corners per sleeve in the EZ Connector® type.



Cornermatic II® Whisper-Loc® Combo Model CM-II-FAH-1660
US Patent No. 9,027,376 and 9,157,653

MODEL	CAPACITY	DEPTH OF POCKET	OTHER	SPEED	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
CORNERMATIC PLUS® IG CORNERMATIC PLUS® VERSA	16 to 26 (.0062" to .022" / 1.6mm to 0.6mm) Mild Steel Only	Flange Type for insertion: TDC®/TDF® (Customer to Specify)	Model Capacity - Max 80 Corners StrapPak™ Quick-loading sleeve loads in 10 seconds	Approximately 2 ½ seconds per corner	Electrical - 110/1/60 (Single Phase) Air - 85 to 100 PSI (5.5 - 7 Bar)	Length - 32" Width - 36" Height - 34" Weight - 600 lbs.
CORNERMATIC® COMBO	16 to 26 (.062" to .022") Coil Width: 60" +/- 1/8" (1524 mm +/- 3.2 mm) Mild Steel Only	Flange Type for corner insertion: TDC® or TDF® Style	Magazine Capacity - Depends on strapped or boxed corners used	Approximately 2 ½ seconds per corner	460/3/60 2.3 Full Load Amps Air Required: 9 CFM @ 100 psi (6.8 BAR) min. Other 3 phase voltages available	Length - 30-1/2" Width - 34" Height - 96" Approximately 1800 lbs.

WHISPER-LOC® MODEL FAH 3456-H [HORIZONTAL]

The quiet, automated way to close Pittsburgh seams in less than six seconds!

- Eliminate hammering to close ductwork seams.
- Greatly reduce noise levels and speed up duct seam closing in your shop or at the job site.
- WHISPER-LOC® will also close both insulated and reinforced ductwork.
- Seams from top and bottom to the middle to avoid run out and incomplete seaming



Model Details



Scan this QR Code to use the Whisperloc® ROI Calculator

WHISPER-LOC®-PRO XVI MODEL FAH 1672-VP [16 GA CHAINDRIVE]

The PRO-XVI is equipped with push button motor controls for quick-change duct lengths and is chain driven!

- Closes duct work seams - whether Pittsburgh or slip and drive - in a fraction of the time
- Adjustable from 18" to 72"
- Motorized control moves the clamp and slide block, as a unit, for faster set up - one handed
- Greatly reduced noise levels
- Minimal floor space required
- Micro-processor controlled for ease of operation
- Low maintenance 220 V single phase 2 HP (1.5 kw)
- Self-contained 10-gallon (38 liter) hydraulic unit
- Weight: 1,550 pounds (704 kg)
- 35" wide x 32.5" high x 96" long (889 x 825.5 x 2438 mm)
- The Whisperloc®-PRO16 closes seams in ducts, only requiring a minimal of hammer over top and bottom to assure straight and complete seaming
- Unlike competitive models that require extensive manual hammer over in Pittsburgh and full length hammer over of at least 45° in slip and drive
- Seams from top and bottom to the middle to avoid run out and incomplete seaming of full-travel models

Model Details



MODEL	CAPACITY	DEPTH OF POCKET/SIZE	OTHER	SPEED	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
WHISPERLOC® MODEL FAH 3456-H	18 gauge	N/A	Duct Length: 3, 4, 5, 6 ft (914/1219/1524/1829mm)	N/A	2 HP - 220/1/60	Length - 96" Width - 35" Height - 32½" Weight - 2400 lbs.
WHISPERLOC® - PRO XVI MODEL FAH 1672-VP	16 gauge	N/A	Duct Length: 3, 4, 5, 6 ft (914/1219/1524/1829mm)	N/A	3 HP - 220/1/60	Length - 96" Width - 35" Height - 32½" Weight - 1,550 lbs.

ADJUSTABLE ELBOW MACHINE

MODEL EMHP 3/4/5

MODEL EMHP 4/5/6

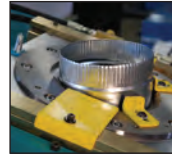
MODEL EMHP 6/7/8

MODEL EMHP 9/16 WITH 9, 10, 12, 14 & 16" TOOLING

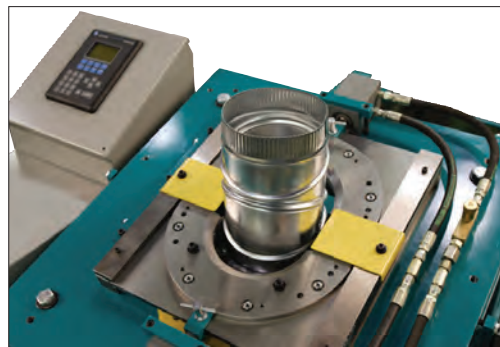
Adding to our line of machines is the Automatic Elbow Machine. This precision machine produces high quality straight, articulated elbows from tube blanks, which can be hand turned to any angle between 0° and 90° for various elbows. The control panel is angled for easier operator use.

Use tubes from the Iowa Precision® Tube-Matic. Optional sizes available upon request.

Model Details



Scan this QR Code for more information on the Adjustable Elbow Machine



TUBE-MATIC MACHINE

MODEL AEMTM 3-16

MODEL AEMTM-HS 3-24

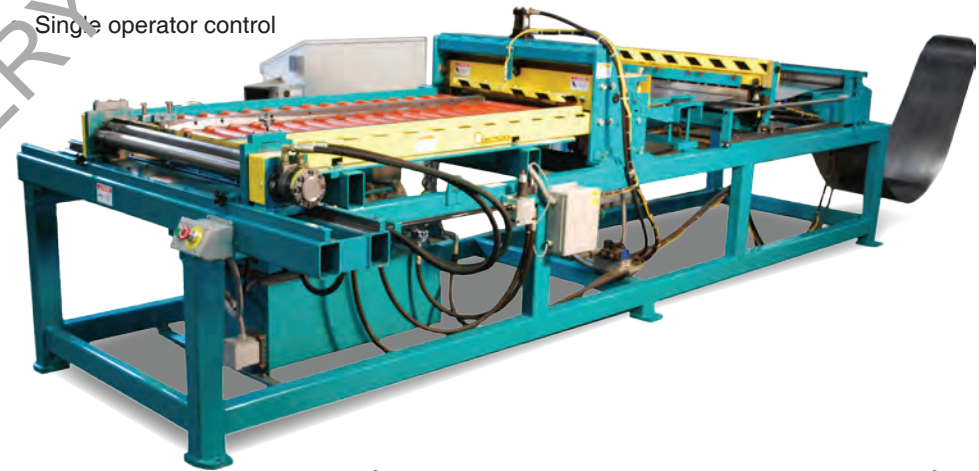
Unmatched in performance, versatility and quality – today and tomorrow!

The Tube-Matic elbow blanking line provides highly accurate punched, crimped, beaded and rolled blanks ready for processing and is an ideal companion line for the Iowa Precision® Adjustable Elbow Machines. Tube-Matic models permit automatic production of elbow blanks in diameter ranges of 3 to 16 inches or 3 to 24 inches (high speed model) with rates up to 3,150 per hour.

A programmable controller maintains batch counts and blank cut-off lengths. All cut-off shears are made of premium quality, high carbon/high chrome tool steel for exceptional long-life. With Tube-Matic, the entire fabrication line is easily managed by a single operator, reducing labor requirements. Plus, all Tube-Matic lines are backed by Iowa Precision®'s one year guarantee.

- Automatic production up to 3,150 elbow tubes per hour from 3 to 24 inches in diameter
- Programmable controller maintains batch counts and cut-off lengths
- Long-life D2 tool steel cut-off knives

Single operator control



Model Details



MODEL	CAPACITY	DEPTH OF POCKET/SIZE	SPEED	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
ADJUSTABLE ELBOW MACHINE MODEL EMHP 3/4/5	Gauge - .0125-.020 (0.32 to 0.51 mm)	Minimum tube diameter – 3 in. (76,2 mm) Maximum tube diameter – 5 in. (127 mm)	N/A	5 HP - 220/440/3/60	Length - 60" Width - 36" Height - 50" Weight - 1,550 lbs.
ADJUSTABLE ELBOW MACHINE MODEL EMHP 4/5/6	Gauge - .0125-.024 (0.32 to 0.6 mm)	Minimum tube diameter – 4 in. (101,6 mm) Maximum tube diameter – 6 in. (152,4 mm)	N/A	5 HP - 220/440/3/60	Length - 50" Width - 36" Height - 60" Weight - 1,550 lbs.
ADJUSTABLE ELBOW MACHINE MODEL EMHP 6/7/8	Gauge - .0125-.024 (0.32 to 0.6 mm)	Minimum tube diameter – 6 in. (152,4 mm) Maximum tube diameter – 8 in. (203,2 mm)	N/A	5 HP - 220/440/3/60	Length - 50" Width - 36" Height - 60" Weight - 1,550 lbs.
TUBE-MATIC MACHINE MODEL AEMTM 3-16	.030 max x 24 wide	Diameter ranges of 3 in. to 16 in.	Up to 1,200 blanks/hour	230/3/60	Length - 120" Width - 60" Height - 51" Weight - 4,450 lbs.
TUBE-MATIC MACHINE MODEL AEMTM-HS 3-24	.030 max x 32 wide	Diameter ranges of 3 in. to 24 in.	Up to 3150 blanks/hour	230/3/60	Length - 205" Width - 60" Height - 51" Weight - 4,450 lbs.

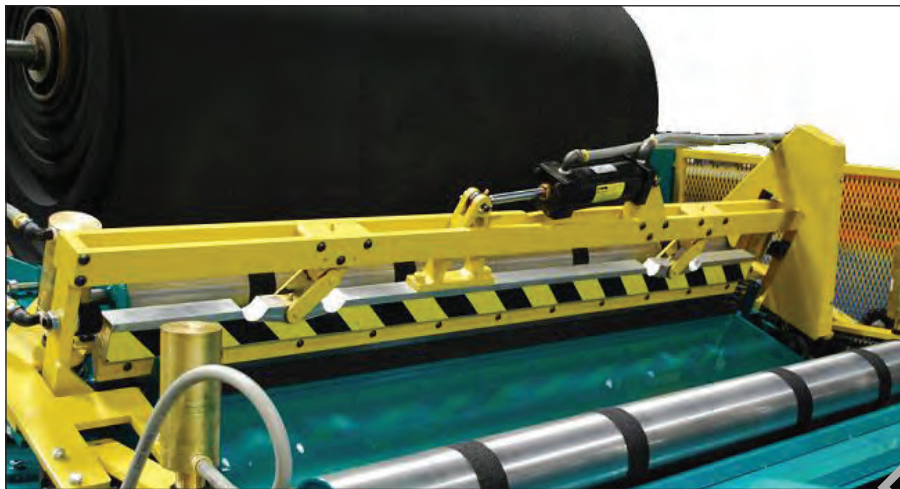
SWING-KNIFE® RETRO-FIT SYSTEM INSULATION CUTTING SYSTEM MODEL IMS-SK

To complete the INSULMATIC, the new patented SWING-KNIFE® CUT-OFF can be used to cut both the conformable non-fibrous foam insulation and standard fiberglass insulation.

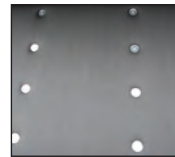
This new cut-off is a knife design that slices the insulation rather than the old chop method. This new cut-off also uses a special harden waved cutting edge for slicing the insulation. It also uses a patented narrow slot in the cutting stick for the knife to pass thru without touching the cutting stick. This increases the life of the knife.

When switching from fiberglass insulation to conformable non-fibrous foam insulation a new knife blade may be required. The fiberglass insulation is very abrasive and will take the fine edge off the knife blade after a period of time. The knife blade will continue to cut and fracture the fiberglass because of the narrow slot in which the knife blade passes through. When switching from conformable non-fibrous foam insulation a new knife blade is not required. Once programmed, the INSULMATIC will automatically measure the incoming part and cut off the insulation.

ARMA-FLEX™ open-cell forms into corners of duct, cuts to non-stretched lengths, able to be pinned and glued "in-line" and "on-the-fly." Do not confuse with AP-Armalex closed-cell usable for fittings.



Model Details



TIE ROD CRIMPER MODEL TRC-H [SPEED DOUBLED]

At Iowa Precision®, no detail is too small when it comes to improving your productivity and profitability. Our Tie Rod Crimper* is a great example.

Whether you use 1/2", 3/4" or 1" EMT, keeping HVAC ductwork quiet is reliably cost-effective and easy with our Tie Rod Crimper*. Using commonly available hardware, this machine crimps hex-bolts or hex-nuts into the tie rod end tight enough to survive a 3,000 lbs. Pull Test. Changeover from inserting hex-bolts to hex-nuts takes just a few seconds. Rubber grommets prevent air leaks, vibration and noise.

With Iowa Precision®'s Tie Rod Crimper* you can install quieter ductwork in less time. **Why are you still paying for proprietary alternatives?**



Model Details



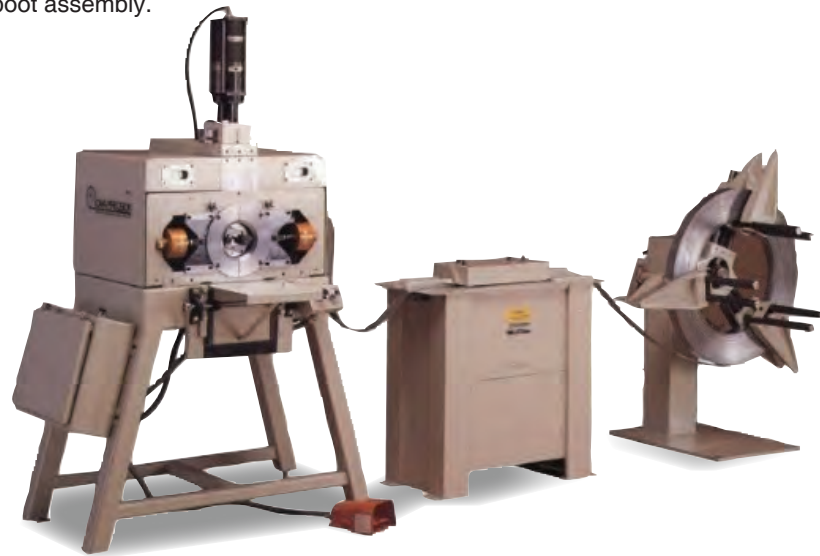
Scan this QR Code for more information on the Tie Rod Crimper

MODEL	CAPACITY	DEPTH OF POCKET/SIZE	OTHER	SPEED/CYCLE TIME	MOTOR/VOLTAGE	APPROXIMATE DIMENSIONS/WEIGHT
SWING-KNIFE®	1/2" - 2" Fiberglass Insulation 1/2" to 2-1/2" Elastomeric Foam	48" and 60" width	Minimum part length 22"	25-50 feet per minute	N/A	Length - 84" Width - 71" Height - 60" Weight - 1,850 lbs.
TIE ROD CRIMPER MODEL TRC-H	1/2", 3/4" & 1"	N/A	Uses common hex-bolt and hex-nut hardware	N/A	2HP, 208 - 230/1/60 Air Required: 85 PSI min. (5 to 6 BAR)	Length - 21" Width - 27" Height - 41" Weight - Approx. 800 lbs. (362 kg)

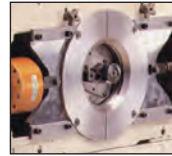
COLLAR-MATIC**MODEL CM-47-2****MODEL CM-58-2****MODEL CM-58-3**

Automated Collar Production and Collar / Boot Assembly

Iowa Precision®'s Collar-Matic Line takes the handwork out of collar production for collar/boot assemblies. The system uses convenient 2-1/8" drive cleat coil stock, .013" to .015" thick, to form hemmed collars. An integral parent metal locking joint eliminates the need for collar rivets or staples. The line's rollformer hems the collar's exposed edge while maintaining the required inside diameter. Collar-Matic automatically produces and places the collar into the beading die, ready for collar/boot assembly.



Model Details

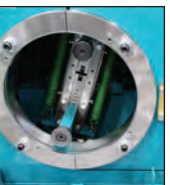
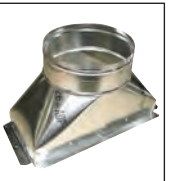
**COLATCH
COLLAR ATTACHING MACHINE
MODEL B MODEL C MODEL D**

This field-proven multi-functional machine forms a bead for the collaring operation in producing boots and other furnace fittings.

- Expands the boot or take-off
- Grooves the collar and boot or take-off
- Stabilizes the collar to boot or take-off
- 3-legged design facilitates precision leveling
- Models for 4" through 20" diameters



Model Details



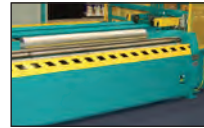
MODEL	CAPACITY	SIZE	OTHER	SPEED	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
COLLAR-MATIC MODEL CM-47-2	.013 - .018	2-1/8" wide	dies - 4" 5" 6" 7" 1 size std - others optional	N/A	1-1/2 HP @ 240/3/60	Length - 38" Width - 47" Height - 76" Weight - 1,000 lbs.
COLLAR-MATIC MODEL CM-58-2	.013 - .015	2-1/8" wide	dies - 5" 6" 7" 8" 1 size std - others optional Collar Diameter - 3"	N/A	1-1/2 HP @ 240/3/60	Length - 40" Width - 48" Height - 78" Weight - 1,100 lbs.
COLLAR-MATIC MODEL CM-58-3	.013 - .015	3" wide	dies - 5" 6" 7" 8" 1 size std - others optional Collar Diameter - 3"	N/A	1-1/2 HP @ 240/3/60	Length - 40" Width - 48" Height - 78" Weight - 1,100 lbs.
COLATCH MODEL B48	Max. Gauge 26	N/A	Standard Dies: 4"-5"-6"-7"-8" Collar Width - 6" Machine Collar Diameter - 4" thru 8"	N/A	Power: 220V, 1 Ph., 60 Hz	Length - 41" Width - 49" with legs Height - 23" without legs Weight - 725 lbs.
COLATCH MODEL C814	Max. Gauge 24	N/A	Standard Dies: 8"-9"-10"-11"-12"-14" Collar Width - 6" Machine Collar Diameter - 8" thru 12"	N/A	Power: 220V, 3 Ph., 60 Hz	Length - 52" Width - 55" with legs Height - 35" without legs Weight - 1,350 lbs.
COLATCH MODEL D1420	Max. Gauge 22	N/A	Standard Dies: 14"-16"-18"-20" Collar Width - 6" Machine Collar Diameter - 14" thru 20"	N/A	Power: 220V, 3 Ph., 60 Hz	Length - 60" Width - 58" with legs Height - 38" without legs Weight - 1,500 lbs.

AUTOMATED FURNACE PIPE SYSTEM

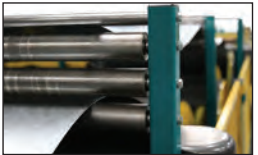
Save time and money by rolling your own pipe. Iowa Precision®'s advanced system produces oval or 3" to 14" diameter round pipe from 2' to 10' in length out of 24 to 30 gauge galvanized steel with the turn of a dial. Just feed blank material into the 9-station duplex rollforming machine where male and female configurations are formed.

The blank is then delivered to a two-stage conveyor where it's oriented and fed in a perfect 90° angle to the pipe-rolling machinery. That's all there is to it! The pipe is completely finished and ready for packing into shipping bundles.

Model Details



Model Details



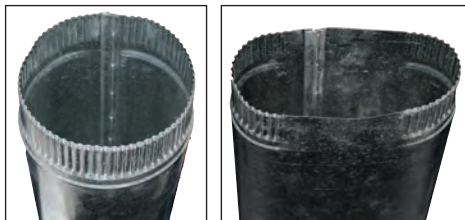
PLASMA COIL FEED

This machine is designed to feed a plasma cutting table. It is comprised of a drive motor and a series of rolls to feed and remove coil set from the material.

The operator uses an on/off switch attached to an electrical cable to advance the material. This allows the operator to feed the material to the proper location along the plasma table.

Drive is by way of entry pinch rolls, and exit pinch rolls. Straightening is accomplished with a fifth roll, which is located between the entry and exit rolls. This straightening roll is controlled by way of a hand wheel to vary the amount of flattening.

Plasma cut-off of the sheet length is standard, optional shear cut-off system available.



Scan this QR Code for more information on the Automated Furnace Pipe System



Model Shown with coil overfeed system. Underfeed system available



MODEL	CAPACITY	SIZE	OTHER	SPEED	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
AUTOMATED FURNACE PIPE SYSTEM	Pre-curl 24-30 gauge	2' to 10' lengths 4" to 14" diameters	N/A	Variable	9.5 H.P., (6 motors), 230/460 volts, 60 cycle, 3 phase	Length - 192" Width - 84" Height - 48" Passline - 33" Weight - 5,400 lbs.
PLASMA COIL FEED	Max Gauge Capacity 16 gauge Max. Width Capacity 60"	N/A	N/A	65 ft per minute	5H.P. 230/460 volts, 60 cycle, 3 phase	Length - 13' 4" (for 2 uncoilers) Height - 26' 8" (for 4 uncoilers) Width - 77" Passline - 32.5" Weight - 3,900 lbs. (for 2 uncoilers) / 7,800 lbs. (for 4 uncoilers)

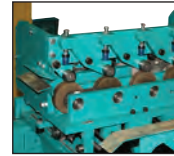
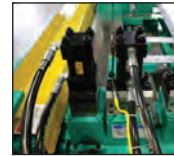
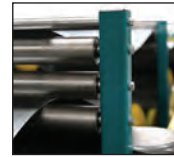
PRO-DUCTOMATIC® FRONT END COIL LINE

Every Pro-Ductomatic® Front-End Coil Line System has been designed to maximize your return on investment by delivering years of reliable production. Designed for Light to Heavy Duty Commercial applications with emphasis on Slip & Drive ductwork. Plus, we always design in the capability to add on to make this system a complete Automated Duct Line.

Pro-Ductomatic® Front-End Coil Line System provides you with the fastest feed rate in the industry and the most economical footprint in the world. This front-end system includes the highest quality components on:

- E-Z load coil drum assemblies (no lifting device to add to your lift truck).
- Soft start motors for long life.
- Direct hydraulically driven decoilers system on every coil station with hydraulic hold downs and low friction pockets.
- Grid Skate Roll System for every coil station.
- Coil Select for feeding material into the Pro-Ductomatic® Front-End Coil Line System .
- Industrial designed solid block die construction for a 25 year die life.
- The industry's toughest and most stable frames. Structured steel tube construction-maintaining structural strength will allow accessibility for maintenance, clean up and service.
- Full width contact feed rolls for positive accurate movement.
- Engineered with heavy-duty left/right synchronization to stabilize cutting action and give the lowest moving mass, thereby reducing shock and vibration during the cutting stroke.
- Quiet operating system with a sound level less than 67 DB.
- Shear head squaring system designed for "tool free" adjustment.
- State of the art control designed, manufactured and serviced by Iowa Precision®.
- Industrial, solid-state PLC touch screen operating system controller with storage recall.
- Remote self-diagnostics

Model Details



PRO-FABRIDUCT® FULL COIL LINE

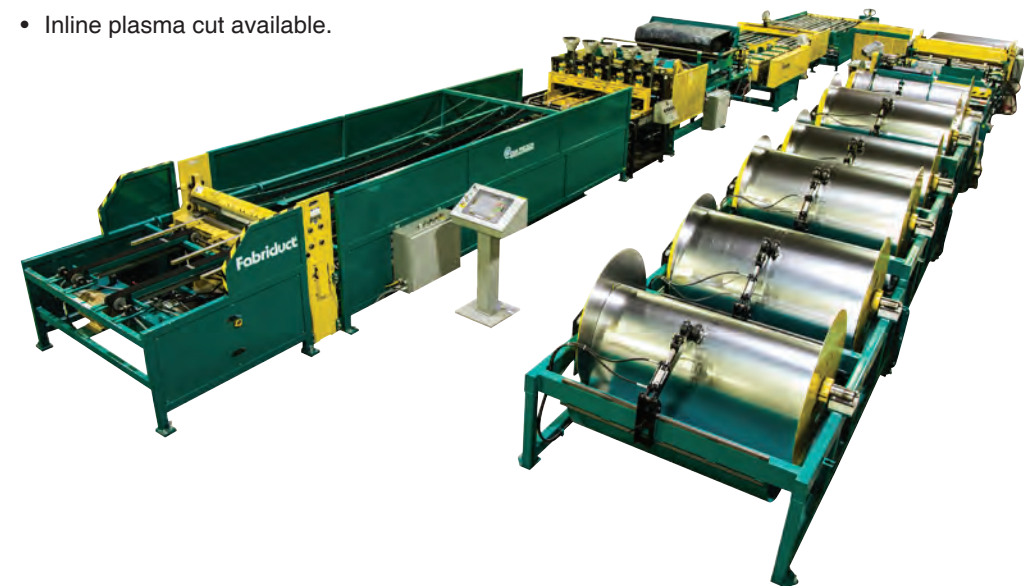
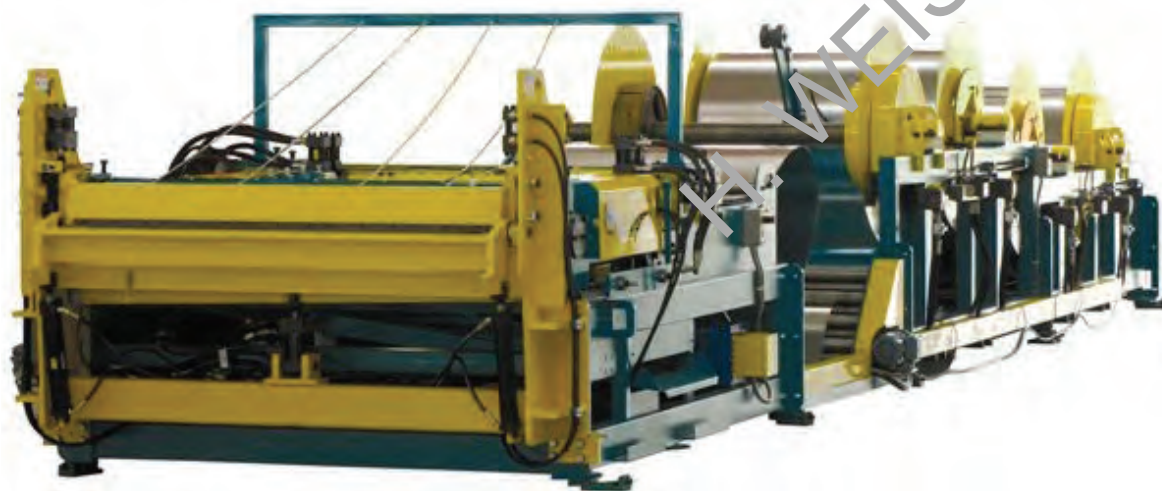
Truly the most Advanced Complete Coil Line produced in the industry today. Leverages footprint, speed and production rates along with tolerances NO other HVAC coil line can match!

- Most economical footprint in the world and fastest feed rate in the industry.
- E-Z load coil drum assemblies (no lifting devices to add to your lift truck).
- Soft start motors for long life.
- Direct hydraulically driven decoilers system on every coil station with hydraulic hold downs and low friction pockets.
- Grid Skate Roll System for every coil station.
- Coil Select for feeding material into the coil processor.
- Industrial designed solid block die construction for a 25 year die life.
- The industry's toughest and most stable frames. Structured steel tube construction-maintaining structural strength will allow accessibility for maintenance, clean up and service.
- Full width contact feed rolls for positive accurate movement.
- Engineered with heavy-duty left/right synchronization to stabilize cutting action and give the lowest moving mass, thereby reducing shock and vibration during the cutting stroke.
- Quiet operating system with a sound level less than 67 DB.
- Shear head squaring system designed for "tool free" adjustment.
- State of the art control designed, manufactured and serviced by Iowa Precision®.
- Industrial, solid-state PLC touch screen operating system controller with storage recall.
- Tie Rod hole punching comes standard with either 5/16 and 7/16 punches.
- Swing Knife® Insulation cutting system for both fiber and non-fibrous insulation.
- Solid state B & R controls with industrial quality/reliability; operator intuitive interface and graphics.
- Servo driven high speed wrap brake.
- Remote diagnostics and fast 24 hour service.
- Inline plasma cut available.

Model Details

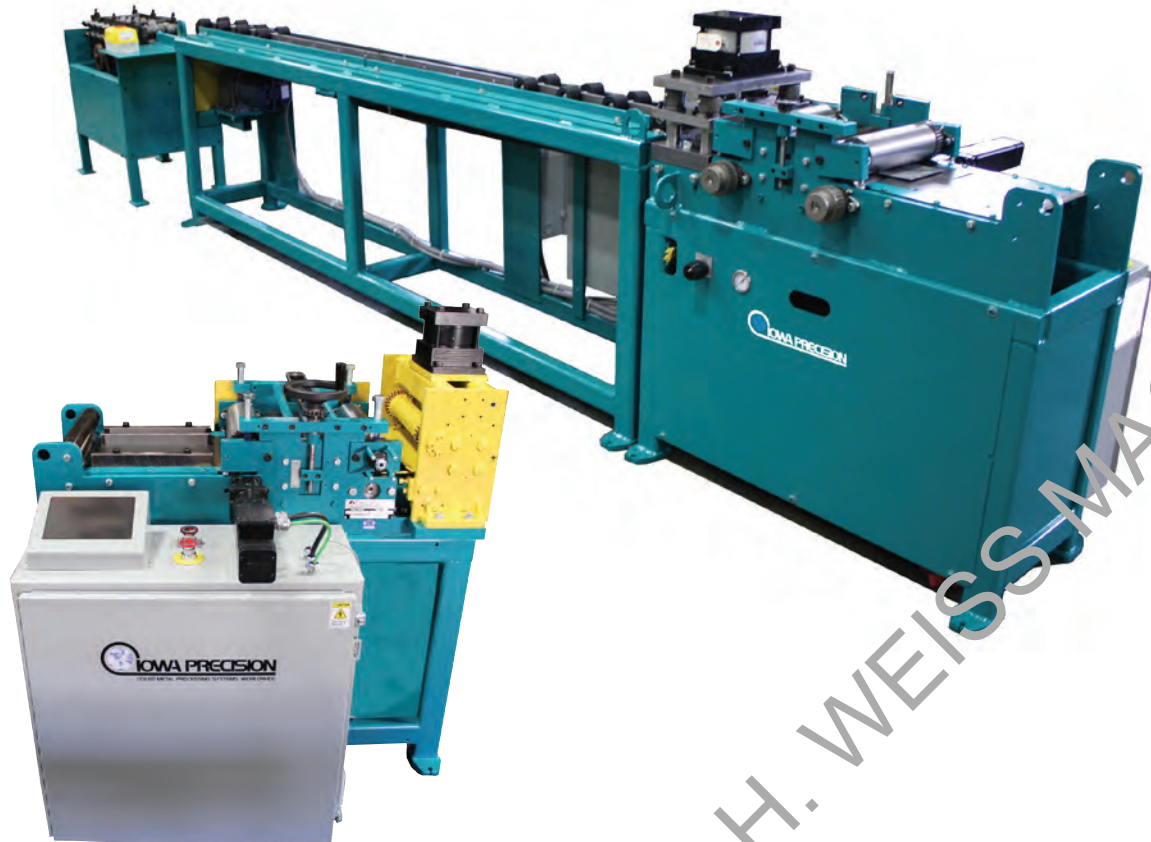


Scan this QR
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Pro-Fabriduct®
ROI Calculator

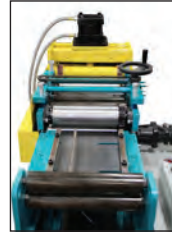


COIL STRIP PROCESSOR

- We give you +/- 32ND tolerance
- Extremely fast positioning and accuracy @ 75 FPM
- Encoder and feed guides are always stationary and satisfy both S & Drive
- We measure from the top feed roll and our feed roll diameters are precision and large
- High speed conveyor to precisely feed into the rollformer
- Industry proven tooling made of high-alloy hardened rolls driven on shafts spinning on sealed bearings - never needs lubrication
- A variety of uncoiling methods available including drop in cradles, pallet decoilers and cantilever spindle designs



Model Details



TRIPLEX CLEATFORMER

“S” cleats and more – A flexible Lockformer®, designed for super high productivity of inboard cleats. The triplex design has two inboard and two outboard forming positions allowing bearing support on both sides of the profile. The top plate and roll assembly are split into three zones with each having special design details like knurled rolls and angled guides to keep material moving through the machine in a straight line. These zones also can be adjusted by the operator to meet the requirements of a wide variety of gauges.

With 9 forming stations, the Triplex Cleat former can form multiple gauge sheet metal into “S” and drive cleats on the inboard forming positions and up to 12 auxiliary offset profiles on the outboard forming positions at speeds averaging 100 fpm.

Standard with Lockformer® quality construction, this machine has a 5 H.P. industrial motor; high precision needle-type bearings; heavy 3/4" chassis plate; case-hardened and ground roll shafts; and an arc-welded steel stand protected with Lockformer®'s top-quality primer and paint finish.

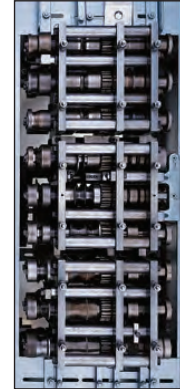
Model Details



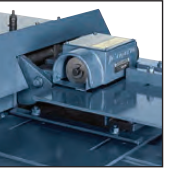
"S" Cleat inboard profile



Drive cleat roll profile



Form roll configuration

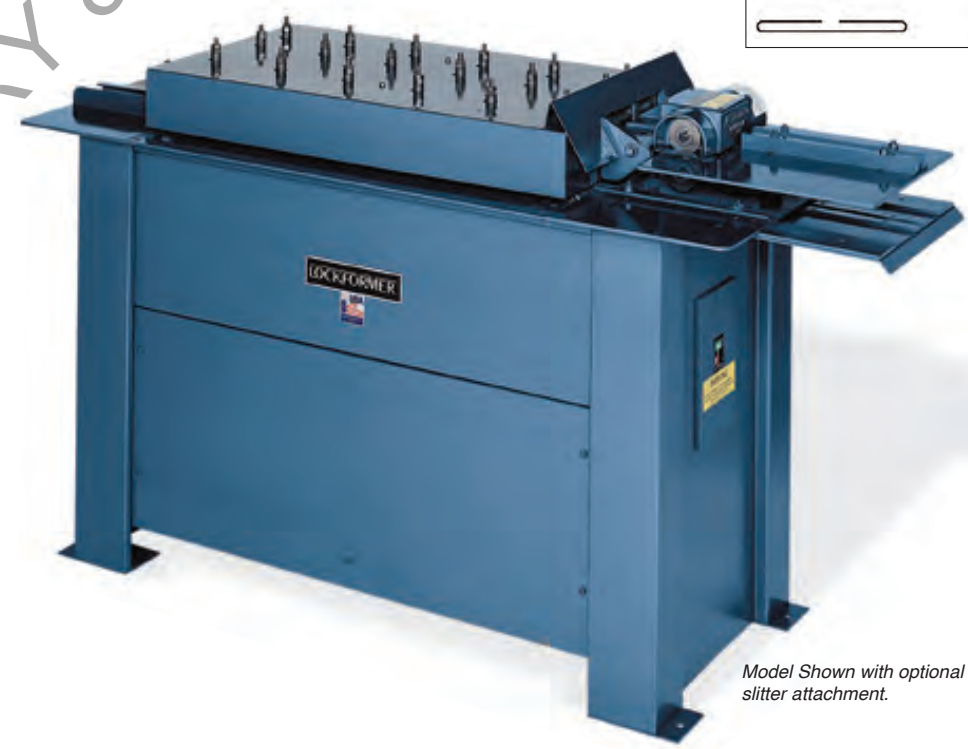


"S" and drive cleat scrap cutter attachment



Plate housing

Triplex Cleatformer Profile



Model Shown with optional slitter attachment.

MODEL	CAPACITY	DEPTH OF POCKET/SIZE	OTHER	SPEED	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
COIL STRIP PROCESSOR	Maximum Material Width: 6.5" Thickness Capacity: 20 Ga. M.S.	N/A	Maximum Feed Length: 120"	N/A	Air Supply: 5 CFM @ 100 PSI Voltage: 230/3/60 std.	Length - 14' 3" Width - 41" Height - 47" Weight - 1,350 lbs.
TRIPLEX CLEATFORMER	22-28 gauge for "S" cleat profile and 20-26 gauge for drive cleat profile	"S" cleat width 1-1/16" Drive cleat width 1-1/8"	Extended shafts for mounting auxiliary rolls.	100 feet per minute	5 H.P. 230/460 volts, 60 cycle, 3phase, A.C. 1,800 RPM.	Length - 60" Width - 24" Height - 40" Passline - 32-1/2" Weight - 850 lbs.

HB-800P BASE MACHINE NO TOOLING

HB-800P-20

HB-800P-18

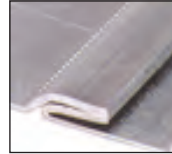
HB-800P-16

The Pittsburgh Lock revolutionized the HVAC Industry in the late 1930's and is still used today for its strength and ease in assembling ductwork.

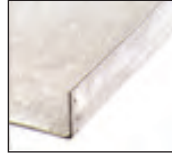
The HB-800 Series Pittsburgh rollforming machines have 8 forming stations with 2 forming positions. One inboard forming position forms the Pittsburgh lock and one auxiliary or outboard forming position has the capability of forming 1 of 3 different profiles.



Model Details



Pittsburgh Lock Profile



Optional Right-Angle Flange roll tooling available

Model Details



Outboard roll profile



Inboard roll profile

HB-800B-24

HB-800B-20

The Button Punch Snap Lock Machines form a two piece seam that greatly simplifies ductwork assembly. The male seam is a button, the female seam is a lock and the two snap together for a flush corner. These machines are available in eight forming station machines. Not only do these locks assemble twice as fast as traditional methods, but because the two pieces nest, they are easier to transport too.

825 ROLLFORMER

We provide you the most innovative design to bring your shop an industrial grade rollformer that is built to last longer, perform quieter, and deliver the highest levels of quality and value.

- Standard with extended roll shafts for mounting auxiliary rolls, one side outboard only.
- "S" & Drive Cleat roll set included inboard.
- No opening rolls required.
- Eight (8) stations, 2" vertical centers, 5" horizontal centers and polished 1" spindles.
- Three motor types are offered:
 - Three (3) HP single phase 220 V for small shops.
 - Five (5) HP single phase 220 V for medium shops.
 - Five (5) HP three phase 230/460 V for large shops - standard motor.
- Extra large bearings with inner races.
- Hardened steel guides to handle rough plasma cut edges.
- Inboard tooling on HB-825 for "S" and Drive.
- Optional Outboard tooling is available on all HB-800 Series Roll Formers.
- Four (4) sets of tooling can be installed on the Model HB-825.
- Optional Slitter Attachment on the HB-825 cuts scrap metal to the correct width for producing "S" and Drive cleats.



Model Details



"S" Cleat inboard profile



Drive cleat roll profile



Optional slitter attachment available



Scan this QR Code for more information on the 800 Series

MODEL	CAPACITY	DEPTH OF POCKET/SIZE	OTHER	SPEED	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
HB-800P-20	20-26 gauge	5/16" Uses approximately 1" of material	Width of hammer-over edge adjustable up to 3/8". Extended shafts for mounting auxiliary rolls.	25 feet per minute	115/230 volts, 60 cycle, single phase, A.C. 1,800 RPM. Other motors available upon request	Length - 48" Width - 24" Height - 42" Passline - 34" Weight - 450 lbs.
HB-800P-18	18-22 gauge	1/2" Uses approximately 1-3/8" of material	Width of hammer-over edge adjustable up to 3/8". Extended shafts for mounting auxiliary rolls.	40 - 45 feet per minute	230/460 volts, 60 cycle, 3 phase, A.C. 1,800 RPM. Other motors available upon request	Length - 58.5" Width - 24" Height - 41" Passline - 34" Weight - 750 lbs.
HB-800P-16	16-20 gauge	1/2" Uses approximately 1-3/8" of material	Width of hammer-over edge adjustable up to 3/8". Extended shafts for mounting auxiliary rolls.	40 - 45 feet per minute	230/460 volts, 60 cycle, 3phase, A.C. 3,600 RPM. Other motors available upon request	Length - 58.5" Width - 24" Height - 41" Passline - 34" Weight - 750 lbs.
HB-800B-24	24-30 gauge	Uses approximately 1-3/4" material	Special speeds available upon request	60 - 65 feet per minute	3 H.P. 230/460 volts, 60 cycle, 3phase, A.C. 3,600 RPM. Other motors available upon request.	Length - 58.5" Width - 24" Height - 41" Passline - 34" Weight - 550 lbs.
HB-800B-20	20-26 gauge	Uses approximately 1-3/4" material	Special speeds available upon request	60 - 65 feet per minute	3 H.P. 230/460 volts, 60 cycle, 3phase, A.C. 3,600 RPM. Other motors available upon request.	Length - 58.5" Width - 24" Height - 41" Passline - 34" Weight - 550 lbs.
825 ROLLFORMER	20-26 gauge	1-1/16" for Slip and 1-1/8" for Drive	Optional slitter attachment available	90 feet per minute	5 H.P. 230/460 volts, 60 cycle, 3phase, A.C. 3,600 RPM. Other motors available upon request.	Length - 48" Width - 24" Height - 42" Passline - 34" Weight - 850 lbs.

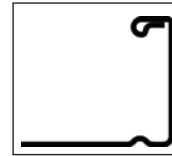
HB-1640 TDF® MACHINE

The HB-1640 machine uses 16 roll-forming stations. There are no adjustments when going from 26 gauge to 18 gauge material; competition requires adjustments. The “short parts feeder”, 6" length minimum, requires no manual adjustment and removal of machine guard when running short parts; competition does. The HB-1640 includes the Snap-Flange feature.

We use high yield and tensile strength shafts for our tooling, turning in precision, factory manufactured, hardened inner races; competition uses hardened shafts - which are brittle and breakage is common. All of our gears are large 6 pitch heavy duty style. They run very quietly well below OSHA noise limits. All of our bearings are “off the shelf” and available from local supply houses. Our machine is driven by an oil filled, sealed, gear reducer, direct coupled to the main motor and is very quiet. Competition utilizes a “V” belt drive between the main motor and their pinion gear. This drive is noisy and exposed to damage by metal chips. Our roll shafts are secured by high quality, large thrust washers. Competition uses snap rings that are less secure and an eye hazard to maintenance workers.



Model Details



TDF®-V16 MACHINE

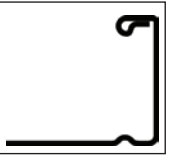
16 Station TDF® Rollform Machine Includes Patented TDF® Rolls.

This is the only transverse duct connector machine on the market certified to comply with SMACNA Duct Construction Standard (DCS) T-25b based on actual laboratory tests across the full range of water gauges.

Features and Benefits:

- Unitized steel construction.
- High yield and tensile strength shafts and “off the shelf” ball bearings.
- Heavy duty gears are Mod 4 (6 pitch) heavy duty style.
- Extended roll shafts for mounting auxiliary rolls, one side outboard only.
- Optional tooling sets available for outboard mounting.
- All steel forming head, hardened steel infeed guide and hardened steel forming rolls mounted on turned and ground spindles.
- No adjustments necessary when going from 26ga to 18ga material.
- Includes Snap Flange Feature.
- Comes standard with short parts feeder for 6 inch minimum lengths

Model Details



MODEL	CAPACITY	DEPTH OF POCKET/SIZE	OTHER	SPEED	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
HB-1640 TDF® MACHINE	16-26 gauge mild steel	1-11/16"	Includes Snap Flange Feature. One set of Inboard Tooling available.	75 feet per minute	208, 230-460/3/60 VAC, 5 H.P., 1,800 RPM.	Length - 127" Width - 27.5" Height - 43" Passline - 36" Weight - 3,000 lbs.
TDF®-V16	18-26 gauge mild steel	1-11/16"	Optional tooling sets available for outboard mounting.	75 feet per minute	208, 230-460/3/60 VAC, 7-1/2 H.P., 1,800 RPM.	Length - 134" Width - 28" Height - 45" Passline - 38.5" Weight - 3,000 lbs.

VALUEPLUS2® FRONT END

The ValuePLUS2® Front End effortlessly delivers the power and precision that today's HVAC companies demand. Innovative ideas are all over this affordable workhorse — ideas that will save you time and money.

Features and Benefits:

- Expandable to full line
- In-line footprint fits well in many factory layouts – saving valuable space.
- One man operation. Run in automatic or on demand mode using a convenient foot switch.
- Belt drive or hydraulic drive Uncoilers from 12,000 lb or 20,000 lb capacity available.
- From 2 to 10 stations available.
- Multi-Grid Feed systems available for easy threading.
- Quick coil changeover. Extra Coil Drum Assemblies available for fast changeover of even more coil inventory.
- Straighten, Bead, Notch and Shear (all standard) and Cleat Edge Former or Tie Rod Punching (both optional) all on one compact frame.
- No Infeed guide assembly required – ValuePLUS2® has built in entrance guides.
- Notcher and CEF heads have hand wheel adjustability.
- Electric Servo replaces hydraulic servo provided for faster, more accurate positioning.



Model Details



VALUEPLUS2® FULL COILINE THE "SPACE SAVER" FULL LINE AND OPTIONS

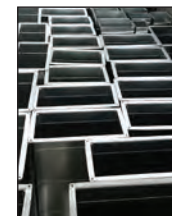
Produces 16" x 16" wrap in 60 seconds!

From start to finish the NEW ValuePlus2® Full Coiline has been completely re-engineered to effortlessly deliver the power and precision that today's HVAC companies demand. Innovative ideas are all over this affordable workhorse — ideas that will save you time and money.

Features and Benefits:

- Expandable to full line
- In line footprint fits well in many factory layouts – saving valuable space.
- One man operation. Run in automatic or on demand mode using a convenient foot switch.
- Belt drive or hydraulic drive Uncoilers from 12,000 lb or 20,000 lb capacity available.
- From 2 to 10 stations available.
- Multi-Grid Feed systems available for easy threading.
- Quick coil changeover. Extra Coil Drum Assemblies available for fast changeover of even more coil inventory.
- Straighten, Bead, Notch and Shear (all standard) and Cleat Edge Former or Tie Rod Punching (both optional) all on one compact frame.
- Patent Pending positioning and retention conveyor assures superior seam profile from the Pittsburgh rollformer.
- Notching dies include clearance holes for use with EZ Connector® system.
- Rollformer comes standard with 1/2" Pittsburgh and Snaplock rolls.
- TDC® or TDF® Rollformer available.
- Lin-O-Matic/ Pinspotter available.
- Wrap Brake produces 4 sided, "L", "U" and full wrap duct.
- No scrap between jobs run from the same coil.
- Accepts downloaded jobs from many popular software applications.
- User friendly touch screen control.
- Low maintenance.
- Modular construction. Any option can be added later. Expand your capabilities as your business grows.

Model Details



ENGEL® COMPACT II STARTER COILINE

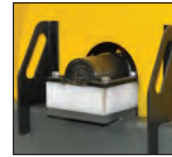
The Compact II Starter Coiline combines equal parts evolution and innovation. We have developed this full coiline specifically for the HVAC industry that is built to last longer, produce more and deliver the highest levels of quality and value.

The Engel® Compact II Starter Coiline has:

- A Direct Hydraulic Drive standard on every station with Hydraulic hold downs and low friction pockets. Engel® eliminates labor intensive and expensive wear items.
- Unitized structural steel frame with a low profile design & stress relieved welded construction for low maintenance and long life.
- Industrial, solid-state PLC touch screen operating system controller. Remote self diagnostics. Storage recall.
- Expandable to full line.



Model Details

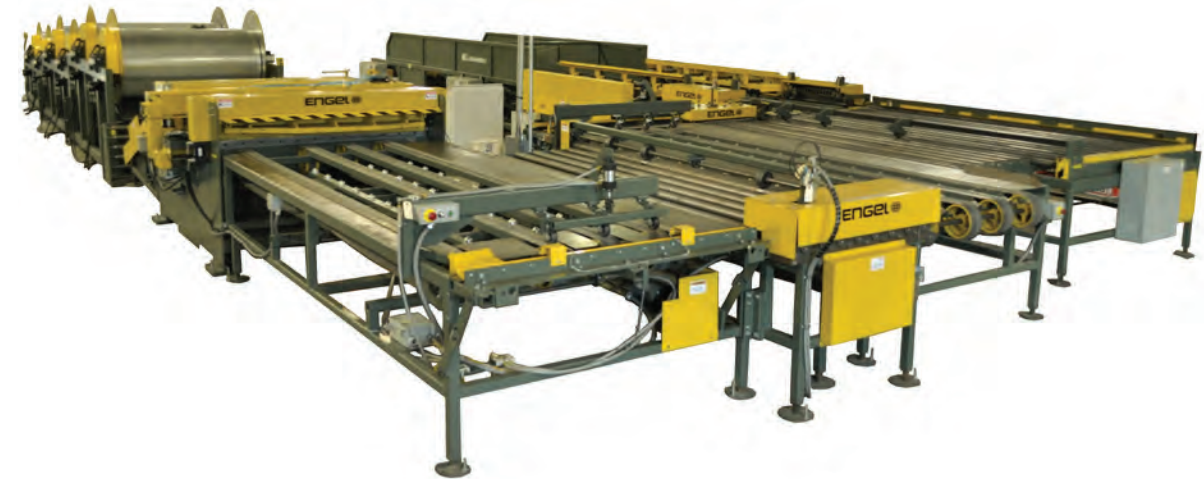


ENGEL® COMPACT II FULL COILINE

The Engel® Compact II Full Coiline has:

- A Direct Hydraulic Drive standard on every station with Hydraulic hold downs and low friction pockets. Engel® eliminates labor intensive and expensive wear items.
- Unitized structural steel frame with a low profile design & stress relieved welded construction for low maintenance and long life.
- Fast, accurate squaring 3-table transfer system with auto mode for continuous batch runs.
- A vertically rafted female Pittsburgh/Snaplock rollformer with computer controlled quick-change utilizing photo-eye sensing.
- Industry proven rollformer with positive-push transfer into cleat edge former and arms that index part via chain to TLF® rollformer.
- SMACNA tested and approved T-25B four bolt connector rollforming system with powered head movement and photo-eye stops.
- Automatic insulation applicator with no need for manual adjustments on varying material thicknesses, plus lead & trail placement of insulation is made from the service screen.
- Patented Spring-Blade cutting system is standard for cutting both fiberglass and elastomeric foam insulation.
- Consistent and accurate welded frame front-gauging hydraulic wrap brake.
- Industrial, solid-state PLC touch screen operating system controller. Remote self diagnostics. Storage recall.

AVAILABLE OPTIONS: PLC controlled Tie-Rod Hole Punching / Cold Sealant System / Grease Duct Companion Flange / Coiline Download



Model Details



SWING-BLADE™ RETRO-FIT SYSTEM INSULATION CUTTING SYSTEM MODEL IMS-5K

To complete the LINEOMATIC, the new patented SWING BLADE™ CUT-OFF can be used to cut both the conformable non-fibrous foam insulation and standard fiberglass insulation.

This new cut-off is a knife design that slices the insulation rather than the old chop method. The new cut-off also uses a special harden waved cutting edge for slicing the insulation. It also uses a patented narrow slot in the cutting stick for the knife to pass thru without touching the cutting stick. This increases the life of the knife.

When switching from fiberglass insulation to conformable non-fibrous foam insulation a new knife blade may be required. The fiberglass insulation is very abrasive and will take the fine edge off the knife blade after a period of time. The knife blade will continue to cut and fracture the fiberglass because of the narrow slot in which the knife blade passes through. When switching from conformable non-fibrous foam insulation a new knife blade is not required. Once programmed, the LINEOMATIC will automatically measure the incoming part and cut off the insulation.

ARMA-FLEX™ open-cell forms into corners of duct, cuts to non-stretched lengths, able to be pinned and glued "in-line" and "on-the-fly." Do not confuse with AP-Armflex closed-cell usable for fittings.



Model Details



CORNER CADET® [PORTABLE]

Fast easy corner insertion and crimping in ducts and fittings. Although the Corner Cadet® is portable and light in weight, it's heavy on performance, automatically inserting and crimping specially designed TDC®/F® corners in seconds. In addition to handling virtually every style of duct, the Corner Cadet® also works with multiple types of fittings. Automatic duct squaring. For ducts and fittings from 18 ga. 1.2 mm to 26 ga. and .6 mm galvanized mild steel.

Model Details



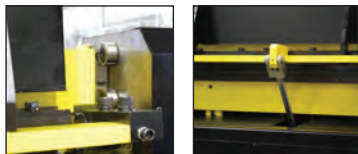
MODEL	CAPACITY	DEPTH OF POCKET/SIZE	OTHER	SPEED	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
SWING-BLADE™	1/2" - 2" Fiberglass Insulation 1/2" to 2-1/2" Elastomeric Foam	48" and 60" width	Minimum part length 22"	25-50 feet per minute	N/A	Length - 84" Width - 71" Height - 60" Weight - 1,850 lbs.
CORNER CADET®	18-26 gauge	N/A	N/A	N/A	110 volt, single phase, 60 cycle Air = 90 PSI	Length - 34.5" Width - 32" Height - 49.5" (top of handle) Platform - 48.5" x 48.5" Weight - 450 lbs.

PNEUMA-WRAP BRAKE

- Redesigned tooling to accept any size duct from 7" up to standard 5' without adjustment
- Redesigned beam to clear pins on lined duct
- Rugged Welded Steel Construction
- Maintenance-Free Bearing & Guides
- Pneumatic Drive For Clamping Beam with Automatic Return
- Pneumatic Drive For Folding Beam with Automatic Return
- Pneumatic Operated Pedal Control machine design:
- Dial-Adjustable Bend Angle 0 to 90°
- Automatic TDC®/F® Notch Locator
- Front Adjustable Support Apron
- Safety Interlock Controls



Model Details



TDC® WRAP BRAKE 2000

- Rugged Welded Steel Construction
- Maintenance-Free Bearing & Guides
- Programmable logic control
- Motorized folding beam
- Motorized clamping beam with automatic return
- Adjustable bend angle 0 - 90
- Safety interlock controls



CLEAT FOLDER [CLOSED END]

- MODEL 1836-0
- MODEL 1836-1
- MODEL 1836-2
- MODEL 1836-3



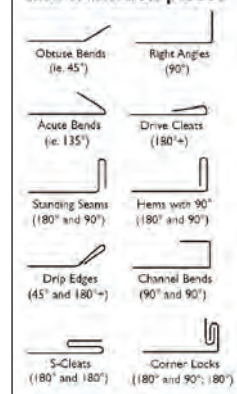
CLEAT BENDER [OPEN THROAT]

When your sheet metal job calls for high-speed folding or bending of drive cleat edges, standing seams, hems, drip edges s-cleats or right angles, the Lion Cleatfolder or Cleatbender roars into action.

These solid tools are built to last for thousands of jobs and years of hard work and abuse.



LION metal benders and folders make difficult bends easy on flats, pre-formed duct, and transition pieces

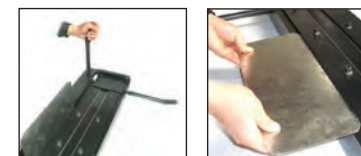


CHEEK BENDER (MANUAL)

A two-way trunnion keeps the bending bar in position at the starting point to assure perfect bends throughout the entire length. Mounting bolts are included. 20 gauge maximum.



Model Details

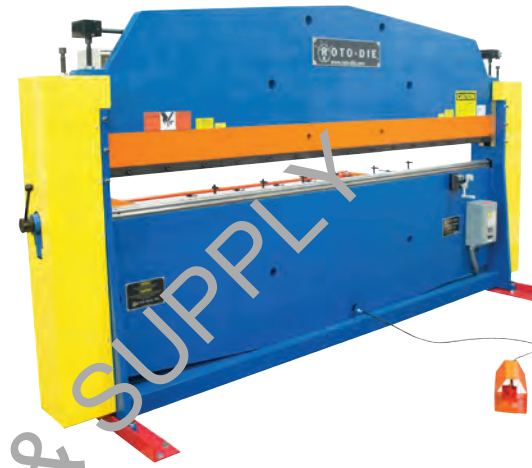


MODEL	CAPACITY	DEPTH OF POCKET	OTHER	SPEED	AIR CONSUMPTION/MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
PNEUMA-WRAP BRAKE	24-16 Gauge		Pneumatic drive for the clamping beam and the folding beam with automatic return	N/A	11 CFM @ 100 PSI	Length - 58.5" Width - 24" Height - 41" Weight - 3,500 lbs.
TDC® WRAP BRAKE 2000	16ga. (1,6 mm) for Ductwork Max. Bending width: 78" (2 m), Optional 118" (3 m)		Minimum Wrap Duct Size: 8-3/4"x 8-3/4" (220 x 220 mm) inside dimensions Hold Down Clamp: Powered Bending Angle Adjustment: 0 to 90 degrees (preset) PLC Machine Control	N/A	230/460 Volt, 3phase, 60 Hz	Length - 99" Width - 32" Height - 48" Weight - 3,300 lbs.
CLEAT BENDER: MODEL 1836-0 MODEL 1836-1 MODEL 1836-2 MODEL 1836-3	18 gauge or lighter	Preset at 7/16" or 1/2" Preset at 1" or 5/8" or 7/16" Preset at 1" and 5/8" or 7/16" Preset at 1" and 5/8" or 7/16"	Model 1836-0: Clearbender Only. Fixed back gauge Model 1836-1: 1 Position back gauge Model 1836-2: 2 Position back gauge with toggle switch Model 1836-3: 3 Position back gauge with toggle switch	N/A	0.5 CU. ft/cycle @ 100 PSI	Length - 40" Width - 47" Height - 34" Weight - 1,100 lbs.
CLEAT FOLDER MODEL 2030-A	20 gauge and lighter	3" - 29-1/4"	Bend width 7/16" or 1/2"	N/A	0.5 CU. ft/cycle @ 100 PSI	Length - 26" Width - 45" Height - 46" Weight - 475 lbs.
CHEEK BENDER MANUAL	20 gauge and lighter	1/4" - 3/4" Max bend length is 29 3/4"	Double-sided operation Bend angles 1° to true 90°	N/A	N/A	Length - 34" Width - 8-1/2" Height - 4" Weight - 95 lbs.

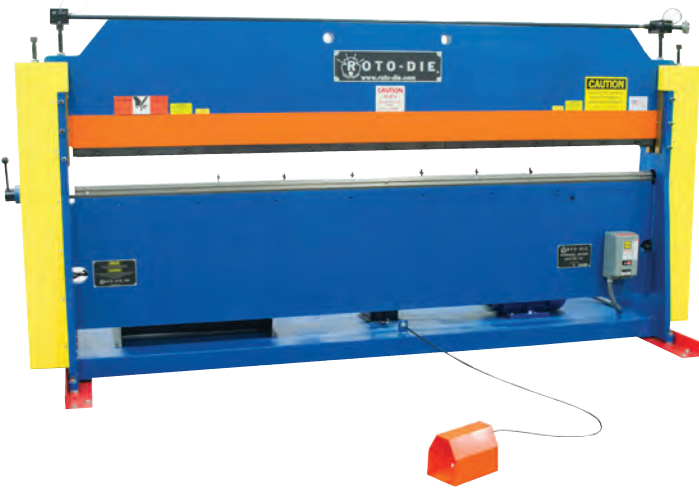
MODEL 5 PRESS BRAKE MACHINE



MODEL 15 PRESS BRAKE MACHINE



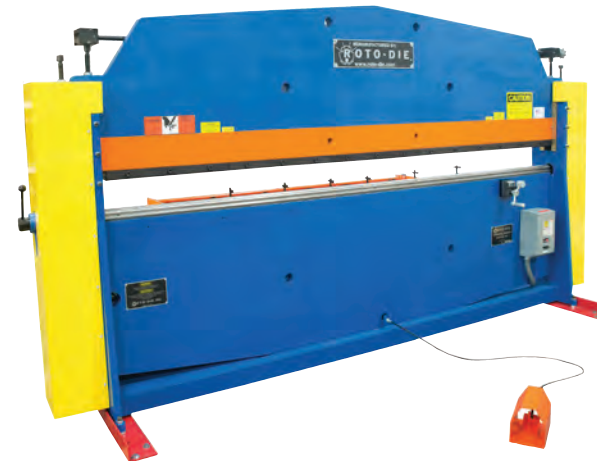
MODEL 10 PRESS BRAKE MACHINE



TDC/TDF Conversion Die Available



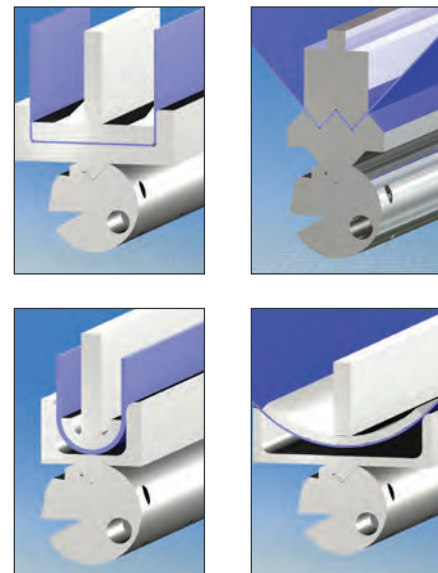
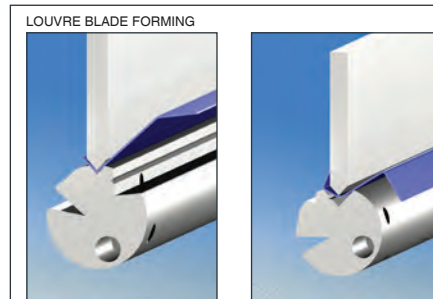
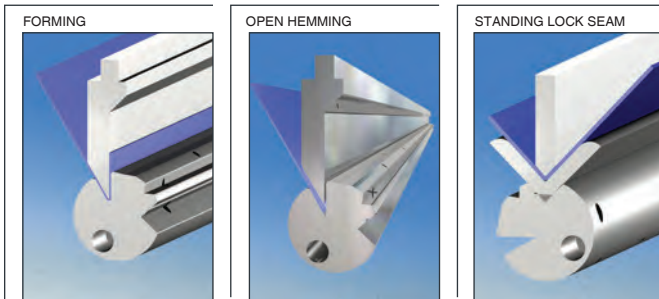
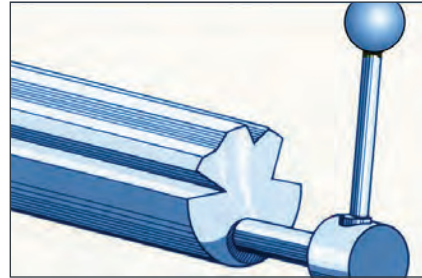
MODEL 15/12 PRESS BRAKE MACHINE



MODEL	BENDING CAPACITY	SIZE	OTHER	SPEED	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
MODEL 5 PRESS BRAKE MACHINE	60" x 16 gauge	Die Clearance 2-1/8" Die Space 7-1/2"	N/A	Length of Stroke: 3" Strokes / Minute: 20 to 50	7-1/2 HP	Length - 7' 10-1/2" Front to back - 22" Height - 5' 3-1/2" Weight - 3,300 lbs. * = 7/8" die opening with angle insert
MODEL 10 PRESS BRAKE MACHINE	120" x 16 gauge 72" x 10 gauge*	Die Clearance 2-1/8" Die Space 7-1/2"	Optional Die	Length of Stroke: 3" Strokes / Minute: 20 to 50	7-1/2 HP	Length - 12' 1" Front to back - 22" Height - 5' 3-1/2" Weight - 5,700 lbs. * = 7/8" die opening with angle insert
MODEL 15 PRESS BRAKE MACHINE	120" x 14 gauge (Mild Steel) 120" x 16 gauge* (Stainless Steel) 120" x 10 gauge*	Die Clearance 2-1/8" Die Space 7-1/2"	N/A	Length of Stroke: 3" Strokes / Minute: 20 to 50	15 HP	Length - 12' 6-1/4" Front to back - 22" Height - 6' 1" Weight - 8,950 lbs. * = 7/8" die opening with angle insert
MODEL 15/12 PRESS BRAKE MACHINE	144" x 16 gauge 144" x 10 gauge*	Die Clearance 2-1/8" Die Space 7-1/2"	N/A	Length of Stroke: 3" Strokes / Minute: 20 to 50	15 HP	Length - 14' 6" Front to back - 22" Height - 6' 1" Weight - 10,000 lbs. * = 7/8" die opening with angle insert

SHEET METAL BENDER VERSATILE PRODUCTIVE PROFITABLE

- Merely by shifting the selections lever, one operator can perform all basic sheet-metal forming operations. No dies to change.
- The Roto-Die® hydraulic bender forms full-length ducts, gravel stops, standing lock seams, flashing, and hemming operations accurately and economically.



CUSTOM DIES TO INCREASE YOUR CAPABILITIES

Our customers develop creative uses for their Roto-Die hydraulic sheet metal benders. Adding a custom die set to your Roto-Die will increase your capabilities and your profitability. The illustrations to the right show a few of the custom dies we have manufactured to customer specifications. These are available by special order or we can have a die made to fit your unique application.

OPEN-END CLEAT BENDER

Quickly form consistent cleats with no set up or adjustment.

- Pneumatically Operated
- Wide jaws allow forming in 1/2" increments
- Adjustable cleat settings
- Front-mounted quick-release valves
- Large, stainless steel feed table resists rust
- 30" bending area
- Backed with a full One Year Warranty
- Built in America



MODEL	CAPACITY	SIZE	TABLE HEIGHT	SPEED	AIR CONSUMPTION	DIMENSIONS/WEIGHT
OPEN-END CLEAT BENDER	20 Gauge and Lighter (Mild Steel)	Bend Length: 3" thru 29-1/2" Bend Width: 7/16" thru 1/2" Preset	36"	N/A	0.5 CU. ft/cycle @100 PSI	Length - 58.5" Width - 24" Height - 41" Weight -500 lbs.

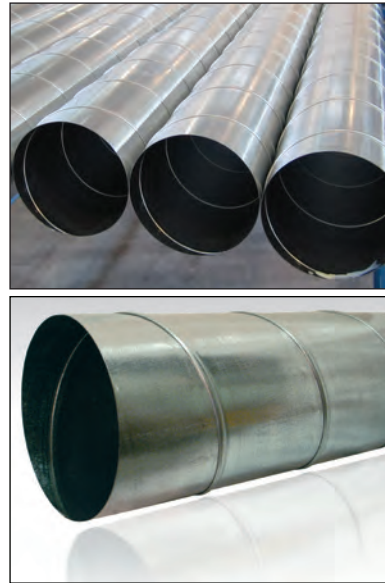
D-MAX TUBEFORMERS SERIES: 1.2E, 1.6HS & 2.0E

The D-Max Series machines are all revolutionary Automatic Spiral Tubeformers that combine the most advanced technology with one of the smallest footprints in the industry! Unlike other compact models, the D-Max 1.2E / 1.6 HS / 2.0E will not sacrifice speed, power or technology.

The D-Max Series machines offer (3) versions:

- **1.2E:** Our Most Popular model. Produces spiral pipe up to 18 gauge (1.25 mm) thickness with a maximum speed of 235 ft./min. (71 m/min).
- **1.6HS:** High Speed model. Produces spiral pipe up to 16 gauge (1.6 mm) thickness with a maximum speed of 344 ft./min. (105 m/min).
- **2.0E:** The Heavy Duty workhorse. Produces spiral pipe up to 14 gauge (2.0 mm) thickness with maximum speed of 276 ft./min. (84 m/min).

All of the D-Max series machines are the most affordable machines in their class. Their unsurpassed features and reliability make them the best value in the industry!



FEATURES OF ALL MODEL D-MAX MACHINES INCLUDE THE FOLLOWING:

- One of the Smallest Footprints in the Industry!
- Only Compact Unit in the Industry that is Fully Automatic!
- Self Diagnostics, Digital Length Control, and Spiral Smart Technology™ ALL Standard!
- Flying Cutting System!
- Ergonomically Friendly to the Operator!
- 10' standard run-off table
- Made in the U.S.A!

Model Details



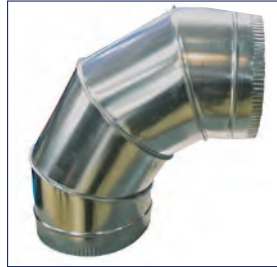
MODEL	CAPACITY	DIAMETER RANGE	SPEED	LENGTH	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
D-MAX 1.2E	28-18 gauge mild steel	3" - 64"	241 FPM	N/A	230V or 460V Special voltages available	Length - 72" Width - 68" Height - 62" Weight -3,000 lbs.
D-MAX 1.6HS	28-16 gauge	3" - 100"	344 FPM	N/A	460V/3 Ph/60 Hz Special voltages available	Length - 72" Width - 78" Height - 62" Weight -3,200 lbs.
D-MAX 2.0E	28-14 gauge	3" - 100"	287 FPM	N/A	460V/3 Ph/60 Hz Special voltages available	Length - 72" Width - 78" Height - 62" Weight -3,200 lbs.

GORE-MAX 1.5 PLUS

ISM's Gore-Max 1.5 Plus is your quality, efficient and cost-effective solution to the production of elbows, reducers, end caps and off-sets. ISM's operator friendly Gore-Max 1.5 Plus provides the power to fabricate quality standing seam fittings in-house.

On a single machine platform, the Gore-Max 1.5 Plus offers the ability to flange/swage on one end, while simultaneously closing the seam at the other end. The Gore-Max 1.5 Plus allows operators to modify controls when flanging/swaging, providing complete control of production speeds. After closing on the second station and creating a standing seam, the Gore-Max 1.5 Plus delivers an airtight seal, eliminating the need for sealing or painting.

Using minimal power and floor space, the Gore-Max 1.5 Plus handles a variety of materials and thicknesses - up to 16 gauge (1.5mm) - to produce standing rib diameters from 4" to 60"(100-1500mm). Added features of pneumatic-activated support rollers and a stronger closing station make the Gore-Max Plus 1.5 safer and easier for the operator to remove parts.

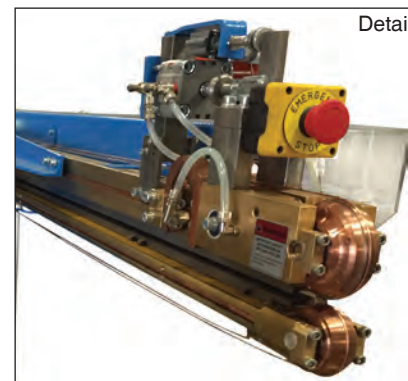
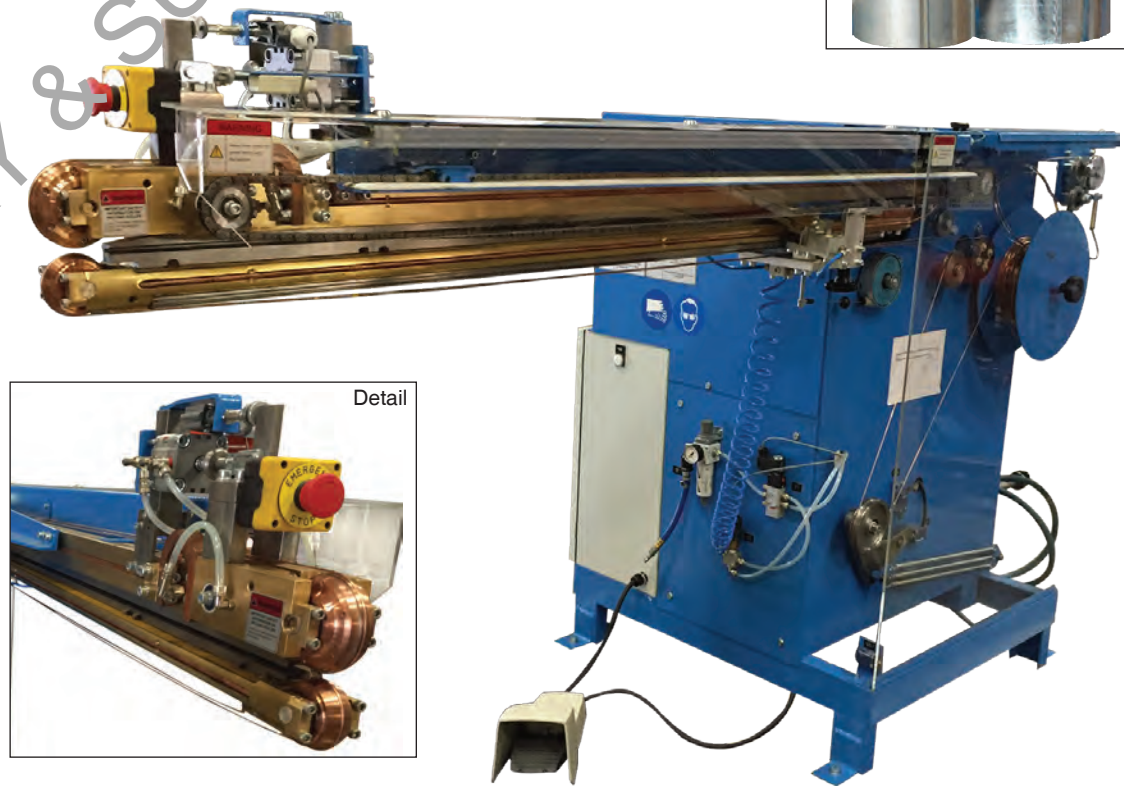


MAX-STITCH 1.0

The Max-Stitch 1.0 Stitchwelder maximizes your welding production output and quality by providing a controlled and consistent longitudinal weld from end to end, ensuring a remarkable weld every time.

The Max-Stitch allows the operator to choose from a continuous or stitch weld that provides an excellent solution for welding of both galvanized and stainless steel straight tubes and round fittings.

An air-actuated welding pressure system is included for faster welds and easier change-overs. The Max-Stitch 1.0 now includes an operator-friendly control panel that has a memory feature for ease of production.



MODEL	CAPACITY	DIAMETER RANGE	SPEED	LENGTH	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
GORE-MAX 1.5 PLUS	16 gauge	4" - 60"	N/A	N/A	460V/3 Ph/60 Hz	Length - 106" Width - 32" Height - 44" Weight - 2,310 lbs.
MAX-STITCH 1.0	20 gauge	3" - 40"	N/A	2.5" - 50"	460V/3 Ph/60 Hz CHILLER: 220V/ 1 Ph/ 60 Hz	Length - 110" Width - 49" Height - 70" Weight - 1,695 lbs.

ANGLE-MAX 1.6

The Angle-Max 1.6 machine is used to produce angle stock for flat oval and round flanges. Producing 90° angles from coil stock, the Angle Max also automatically cuts to a desired length, and features complete PLC controls and touch screen for easy operation. The Angle-Max produces parts that are a perfect fit to be used with the Max-Flange 2.7 flanging machine. Optional TDC® and other special flanges.



For more information on Angle-Max 1.6



Optionals include TDC® and other special flanges as well as pilot hole punching.



MAX-FLANGE 2.7

The diverse Max-Flange 2.7 flanging machine produces either straight angle or flared angle round and oval flanges for a variety of uses. The Max Flange 2.7 is filled with operator friendly features such as a touch screen PLC control and the ability to save and recall round and oval parameters for fast and easy production of duplicate parts.

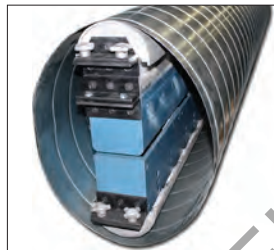
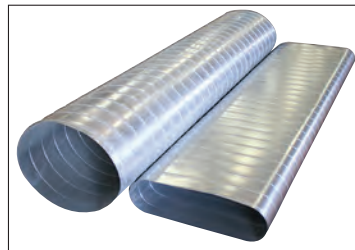


For more information on Max-Flange 2.7

MODEL	CAPACITY	DIAMETER RANGE	SPEED	LENGTH	MOTOR/VOLTAGE	AIR CONSUMPTION	DIMENSIONS/WEIGHT
ANGLE-MAX 1.6	Up to 16 gauge	N/A	N/A	20" - 200"	7.5 HP 460V/3 Ph/60 Hz	5 CFM @100PSI	Length - 99" Width - 42" Height - 47"
MAX-FLANGE 2.7	Up to 12 gauge	8" - 100" for standard 90° flange	N/A	N/A	13 HP (2 motors) 460V/3 Ph/60 Hz	1 CFM @100PSI	Length - 74" Width - 40" Height - 81"

OVAL-MAX

For all of your oval requests, ISM by Lockformer introduces the Oval-Max. The Oval-Max offers a full touch screen PLC combined with independent cylinders that stretch material at different pressures along the longitudinal surface of the pipe. This 18-gauge machine features a 10' boom which can produce up to 20' lengths as well as tooling from a Minor axis of 6" to an impressive Major axis of 96".



Model Details

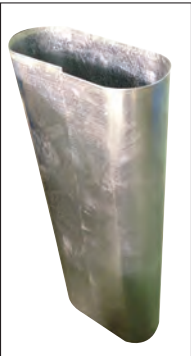


OVAL-MAX ROLLER 3

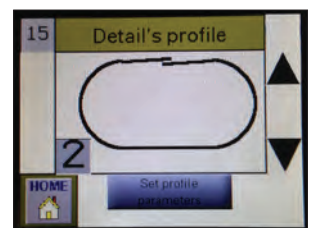
The Oval-Max Roller 3 is used to produce round and oval fittings on material up to 20 gauge and up to 40" wide. This machine's control panel allows for easy operator entry of part parameters.



Model Details



H. WEISS MACHINERY & SUPPLY



MODEL

OVAL-MAX

CAPACITY

Up to 18 gauge

DIAMETER RANGE

Minor Axis 6"-36"

SPEED

N/A

LENGTH

up to 20'

MOTOR/VOLTAGE

15 HP
460V/3 Ph/60 Hz

DIMENSIONS/WEIGHT

Length - 215"
Width - 48"
Height - 58"

OVAL-MAX ROLLER 3

Up to 20 gauge

Min. is 3.75"

N/A

N/A

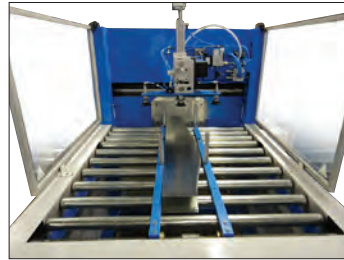
460V/3 Ph/60 Hz

Length - 97"
Width - 47"
Height - 72"
Weight - 1,700 lbs.

ROLLER-MAX 800

The Roller Max 800 is an automatic rollformer designed to support high-speed production of round metal parts. The Roller Max 800 produces parts with diameters ranging from 3"-40" and up to 20 gauge material, allowing for rapid changeover from one thickness to another.

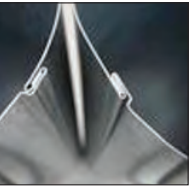
Model Details



MAX-CLOSE 25.15

The Max-Close 25.15 Seam Closer is designed to produce a recumbent fold in the production of air ducts. The Max-Close features a quick change-over from inside to outside seams. This functional machine works with material up to 20 gauge, has a shaft length of 60" (1520 mm) with a maximum length up to 120" (3040 mm) and minimum diameter of 3.5" (90 mm)

Model Details



MODEL	CAPACITY	DIAMETER RANGE	SPEED	LENGTH	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
ROLLER MAX 800	28-20 gauge	3.15"- 40"	1200 P/Hr	32" Max. Blank Width	460V/60 cycle, 3 phase	Length - 75" Width - 60" Height - 75" Weight - 1,660 lbs.
MAX-CLOSE 25.15	Up to 20 gauge	Min. 3.6"	N/A	120" Max Tube Length	460V/60 cycle, 3 phase	Length - 104" Width - 32" Height - 67" Weight - 1,200 lbs.

ROTO-MAX 125 & 175

The Roto-Max Line is a new generation edge forming machine for mass production of chimney and round fittings. The Roto-Max 175 is unique to other rotary machines with its "Smart Swage" microprocessor that memorizes the parameters and then automatically reproduces that exact same piece until changed by the operator.

The Roto-Max 175 can run up to a maximum material thickness of 1.75mm (16 gauge).

We also offer the Roto-Max 125, which is a manual machine that runs a maximum material thickness of 1.25mm (20 gauge)

Count on ISM Machinery's Roto-Max for all of your fitting needs.

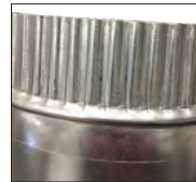


Roto-Max
125



Roto-Max
175

Model Details



CLINCHING MACHINE - 15" & 30"

These Clinching Machines use a Button Lock process to join two or more materials together. This fastening system eliminates the need for spot welding, rivets or screws.

The unique features of these Clinching Machines include:

- **Mechanical Clinching Press:** Faster, more reliable with a more consistent lock.
- **Solid-state Frame and Horn:** Provides less deflection and longer tooling life.
- **Single or Continuous Mode:** Operates over 280 SPM - fastest in industry.
- **Made in the USA!**

**Custom Frame and Horns are available!*



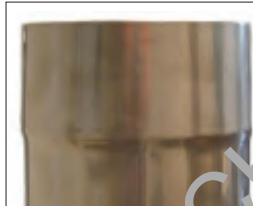
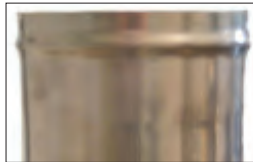
MODEL	CAPACITY	DIAMETER RANGE	SPEED	LENGTH	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
ROTO-MAX 175	Up to 16 gauge	N/A	0-92 FPM	N/A	230V/1 Ph/ 60 Hz	Length - 33" Width - 35" Height - 57" Weight - 325 lbs.
ROTO-MAX 125	Up to 18 gauge	N/A	0-92 FPM	N/A	208V/1 Ph/ 60 Hz	Length - 27" Width - 29" Height - 55" Weight - 175 lbs.
CLINCHING 15"	34-12 gauge	.020" - .20"	295 SPM	N/A	110V/1 Ph/ 60 Hz	Length - 48" Width - 40" Height - 80" Weight - 1,325 lbs.
CLINCHING 30"	34-12 gauge	.020" - .20"	295 SPM	N/A	110V/1 Ph/ 60 Hz	Length - 60" Width - 38" Height - 80" Weight - 1,800 lbs.

MAX-EXPAND

The Max-Expand Machine is used for widening pipes of V2A and V4A Stainless Steel for chimney, drain and ventilation pipes. This machine has an adjustable sensor-controlled expansion stroke and is ergonomically designed for adjustability and operator comfort.



Model Details

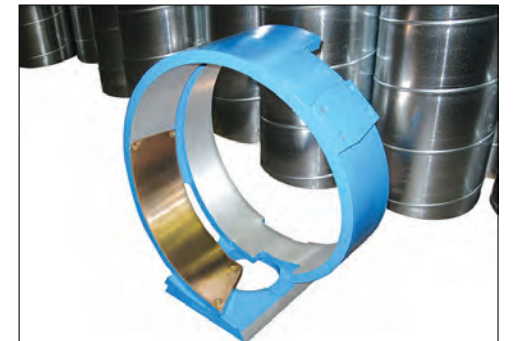


Custom Dimensions Available

FORMING HEADS

ISM's Forming Heads are made of aluminum and use brass inlays to give you long lasting quality forming heads. Our forming heads are compatible with other spiral machines in the industry.

In addition to Forming Heads, ISM offers a wide-range of replacement parts for most machine manufacturers.



MODEL	CAPACITY	DIAMETER RANGE	OTHER	SPEED	MOTOR/VOLTAGE	DIMENSIONS/WEIGHT
MAX-EXPAND	30 - 14 gauge	4" - 10" STD and 12" - 48" Option	N/A	N/A	460V/3 Ph/ 60 Hz	Length - 52" Width - 36" Height - 52" Weight - 665 lbs.
FORMING HEADS	28 - 14 gauge	3" - 100"	N/A	N/A	N/A	Varies by Size

EZ HANGER®

EZ Hanger® System can REDUCE your duct hanging and labor costs by more than 70%

- A Duct Hanging System that truly reduces the cost of installing duct up to 70% in the field
- Hanging duct from the STRONGEST part of the duct – the Flange
- Makes your installation easier and look more professional

For the EZ Hanger® System, 6 bolts connect the flanges on the top and 2 bolts connect the flanges at the bottom. EZ Connector® and EZ Hanger® have been independently tested and listed by the SMACNA Testing & Research Institute <http://smacnatri.org> for use in duct construction.

Trimble® software duct hanging guide includes EZ Hanger® for assignment of hanger installation locations.



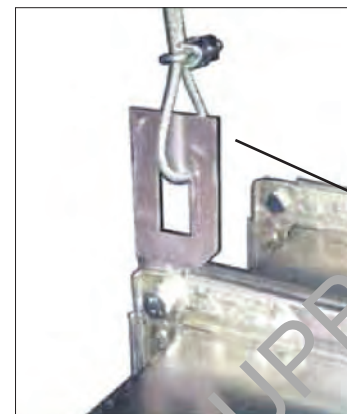
EZ CONNECTOR®

EZ CONNECTOR® is a new corner system that, for the first time, allows the contractor to make their duct joints with a super-fast locking bolt using a power drill.

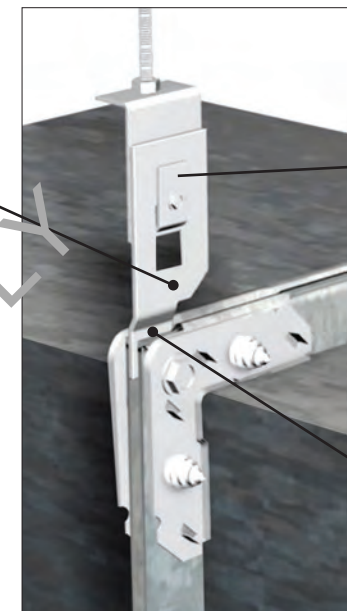
- Saves up to 50% installation costs in duct joint construction work
- Patented “tear drop” hole with matching Patented extra high drive head with built-in washer
- Reduces the need for drift pins – thanks to its self-piloting screw tip
- Allows installer to use a POWER DRILL for ultra fast duct joint fastening
- No more fumbling for washers, nuts and bolts. Magnetic adapter holds screw to the drill for one-hand use..even with gloves ON
- Complements new EZ Hanger® as a quick method of securing the corner in place



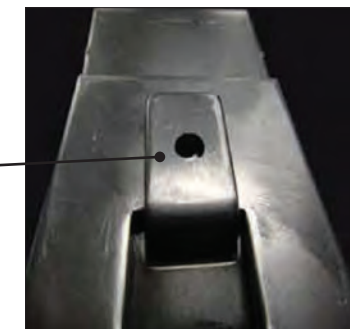
EZ CONNECTOR® AND EZ HANGER® SYSTEM®



Special die-stamped 1 offset so the female hanger will not accidentally rotate between duct sections when connecting



There are 2 ways to secure the corner to the flange for EZ Hanger®, Lance-N-Loc or EZ Connector®.



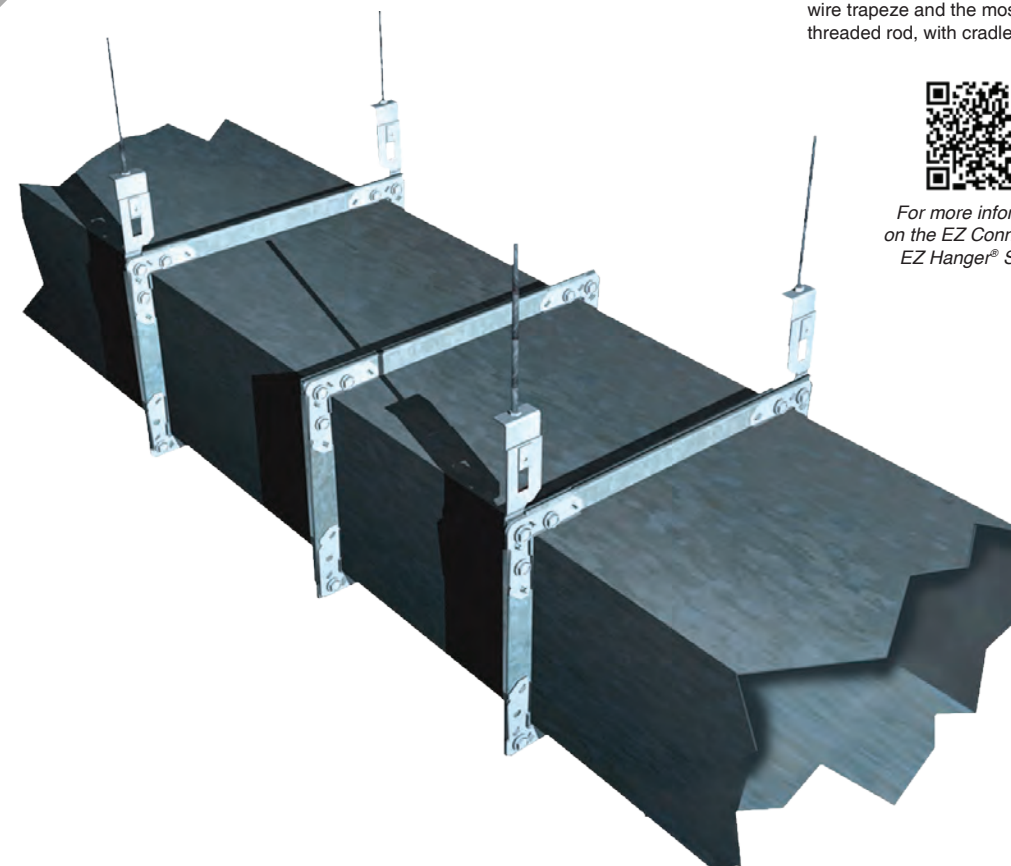
Laboratory tests confirm that the EZ Hanger® can hold an 18 ga. duct to 2,800 lbs. (with #10 self-tapping screw) or 1,400 lbs. (with no screw).



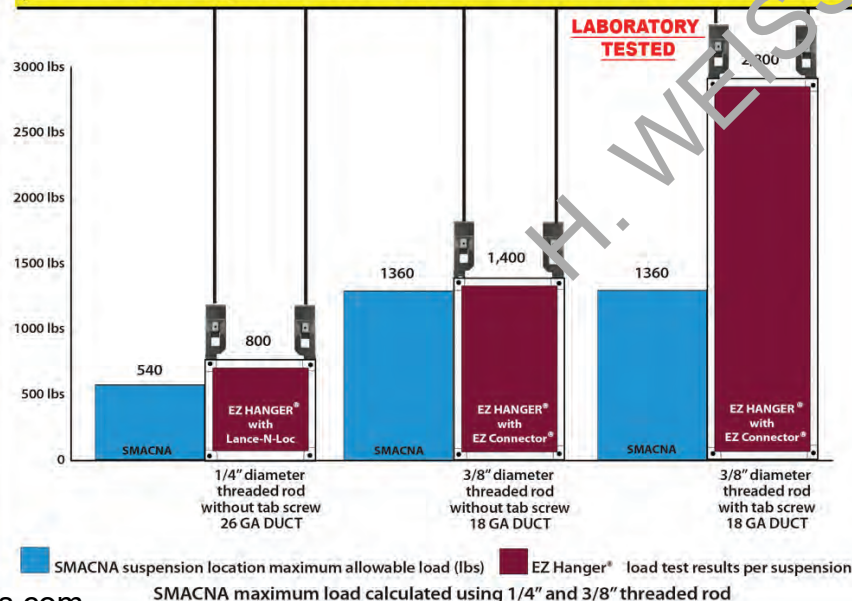
EZ Hanger® works with ALL THREE duct suspension methods - steel straps, steel wire trapeze and the most common, threaded rod, with cradle bar.



For more information on the EZ Connector® & EZ Hanger® System



EZ Hanger® System Load Results v. SMACNA Calculated Loads



EZ CONNECTOR® CORNER - STANDARD

- EZ Connector® corners feed from all IPI®/Engel® existing automated corner insertion/crimping machines with new presser blocks with simple modification. (Specify "C" or "F" for new presser block)
- Patented EZ "tear-drop" connector and clenching holes serve as pilot guide for EZ assembly with the most versatile and lightest screw-guns.
- Stronger connection for EZ factor duct assembly - can ship multiple ducts in connected assemblies.
- Specify "C" or "F" flange profile.



EZ CONNECTOR® CORNER - UNIVERSAL

- Universal type corner facilitates insertion and crimping in new style Iowa Precision® Cornermatic Plus® and Cornermatic II®.
- Comes strapped for quick loading.
- Works on standard duct and fittings.



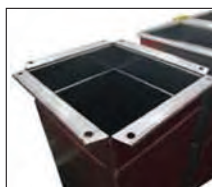
Strap-Pak™ US Patent No. 9,377,213 B2, 9,545,695 B2



CONTENTS CORNERMATIC™ CORNERS		
	COUNT	WEIGHT
□ A1	250	35 LBS
□ TDC	250	35 LBS
■ TDF	250	35 LBS

EZ CONNECTOR® BOLTS

- Amazing features lead to unprecedented utility and EZ installation
- Replaces 3/8" carriage bolt, washer and nut at the four corner connections
- Superior to standard 3/8" carriage bolts
- Washer built into "extra high" EZ drive head
- No need to use nuts with EZ Connector®.
- Fewer small-part items to drop or lose going up & down on the ladder or lift.
- Pilots and drives to significantly reduce or eliminate use of drift-pin and clamps for corner alignment
- Spin-out feature prevents over-torquing and reduces damage to gaskets (leakage at corner reduced)
- 1 1/2" long version available for heavier gauge, unique location, special fitting applications
- The whole process saves up to 50% installation labor, is safer and reduces leakage
- Currently sized work with rolled-on and slip-on flange of heights for 35mm USA) and 30mm (European)



1 - 1/2"

www.hweiss.com



3/4" Rugged Bolt



Our specially designed "Mag-Socket" is a 3/8" drive extension and socket with a built-in magnet that keeps the EZ Connector® bolts securely in place during assembly.

CONTROL RETROFIT

We design, program and build complete replacement control systems for your vintage Vulcan®, Engel® or Iowa Precision® Coil Line. Each new control we supply is quality checked to meet rigorous standards - exactly as you would expect from these industry leaders.

Sometimes, rather than a complete machine tool re-build, a CNC control retrofit is just what the doctor ordered to get an older, well maintained Vulcan®, Pro-Fabriduct® or Compact II® machine tool performing like you never thought possible.

That older machine may be very capable mechanically for years to come, but aging electronics can make it impossible to keep that machine in top operating condition. A control retrofit can give new life to that asset.



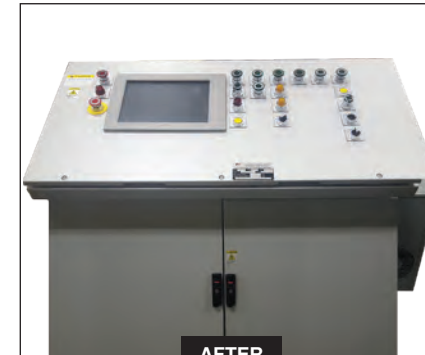
BEFORE



BEFORE



AFTER



AFTER

LOCKFORMER

Supplied with each new control application:

- HMI/PLC Interface Touch Screen Controller.
- Plug and play Control System
- Compact Flash Platform for Hard Drive (Solid State)
- No Moving Parts i.e., Fans and Hard Drives continually running.
- No proprietary cabling required as with other similar types of systems.
- No changes necessary for Vulcan® CAM Software or the Interface.

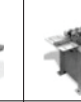


OR ENGEL

Supplied with each new control application:

- Solid state components with industrial grade touch screen.
- Intuitive user interface provides At-A-Glance operational assessment.
- Status messages prompt user for required information.
- Graphical Job Processing Flow Information.
- New operator manual and complete electrical drawings.
- Designed to NFPA 79-Standards for Industrial Machinery.

LOCKFORMER
STANDARD HVAC ROLLFORMING MACHINES



H. WEISS MACHINERY & SUPPLY

PHONE: (718) 605-0395

www.hweiss.com

Model	20 Ga Pittsburgh	20 Ga Pittsburgh Super Speed	16 Ga Pittsburgh	18 Ga Pittsburgh			20 Ga. Button Punch Snaplock	Triplex Cleatformer	Super 11 (& Oxford) Cleatformer	Standing "S" Cleat	TDC® V	TDC® 14 Station	TDC® 14 Station Triplex	DS Connector & Triplex Connector
Gauge	Price	Price	Price	Price										
5/16" Pittsburgh	20 - 26	Included	Included	Available Option	Available Option		Available Option	Available Option	Available Option					
3/8" Pittsburgh	18 - 22				Included									
1/2" Pittsburgh	14 - 16													
1/2" Pittsburgh	16 - 20			Included						Available Option	Available Option			
Pittsburgh Rolls - No Opening Roll	20 - 28			Available Option	Available Option		Available Option	Available Option	Available Option					
Drive Cleat	20 - 26	Available Option	Available Option	Available Option	Available Option		Available Option	Available Option	Available Option					
Straight Right Angle Flange	16 - 24	Available Option	Available Option	Available Option	Available Option		Available Option	Available Option	Available Option					
Button Punch Snap-lock (Male & Female)	20 - 24						Included	Available Option	Available Option					
	24 - 30							Available Option	Available Option					
Double Seam (Type "S")	22 - 28	Available Option	Available Option	Available Option	Available Option		Available Option	Available Option	Available Option					
Double Seam (Type "L")	16 - 20			Available Option	Available Option		Available Option	Available Option	Available Option					
Standing Seam	16 - 20			Available Option	Available Option		Available Option	Available Option	Available Option					
Combination 3-in-1 & 3-Step Gauge Bar	Right Angle Flange	22 - 26		Available Option	Available Option		Available Option	Available Option	Available Option					
	Standing Seam	22 - 26		Available Option	Available Option		Available Option	Available Option	Available Option	Available Option	Available Option			
	T - Connection	22 - 26		Available Option	Available Option		Available Option	Available Option	Available Option	Available Option	Available Option			
3-in-1 Perforating & Notching Arrangement				Available Option	Available Option			Available Option	Available Option					
Special 2-in-1 & 2-Step Gauge Bar	Right Angle Flange	22 - 26		Available Option	Available Option			Available Option	Available Option					
	Standing Seam	22 - 26		Available Option	Available Option			Available Option	Available Option					
2-in-1 Perforating & Notching Arrangement				Available Option	Available Option			Available Option	Available Option					
Hemming Rolls (Teardrop)	20 - 24			Available Option	Available Option		Available Option	Available Option	Available Option					
Boot Clip	26 - 30								Available Option					
Complete Set of Drive Cleat Rolls & Slitting Cutting Device				Available Option	Available Option				Available Option					
Slitting Cutting Device Only with Conversion Parts for Existing Drive Cleat Rolls				Available Option	Available Option				Available Option					
"S" Cleat Cutter Attachment									Available Option					
Combination "S" Cleat and Drive Cleat Cutter Attachment									Available Option					
1-1/8" Standing Seam and Right-Angle Flange Combination	16									Available Option	Available Option			
1-1/4" Standing Seam and Right-Angle Flange Combination	16									Available Option	Available Option			
1-1/2" Standing Seam and Right-Angle Flange Combination	16									Available Option	Available Option			
1-1/8" Government Lock (Cup Clip)	22 - 24									Available Option				
1-1/2" Government Lock (Cup Clip)	20 - 22									Available Option				
Reinforce On-Center Drive Cleat	22									Available Option	Available Option			
TDC® Clip											Available Option	Call for Pricing	Call for Pricing	
Nexus												Call for Pricing	Call for Pricing	
Z Bar												Call for Pricing	Call for Pricing	
Standing Slip with Assembly Ledge														Call for Pricing
New England Cleat with 1/2" Assembly Ledge. Can form shape A, B or C with a change of stock size and entrance gauge	20													Call for Pricing
One Pass Adjustable Bar Cleat - 1-1/8", 1-5/8", 2-1/8"	20													Call for Pricing
Reinforced Corner Drive Cleat	18													Call for Pricing
Reinforced On-Center Drive Cleat	22													Call for Pricing
New York Cleat with 1/2" Assembly Ledge	20										Call for Pricing			Call for Pricing
Government (or Pocket Lock) Pocket Size: 1-1/8", 1-1/2" with quick change washers	20													Call for Pricing
High Pressure Double "S" Slip; Can only be formed on 8" inboard position	20													Call for Pricing
Standing "S" Cleat	20													Call for Pricing
Corner Slide Connection Rollset "A"	20													Call for Pricing
Corner Slide Connection Rollset "B"	20													Call for Pricing
Two-Pass Adjustable Bar Cleat Pre-Hem Auxiliary. Completed Cleat Inboard with 1-1/8" to 2-1/8" Infinite adjustment range. Note: Pre-Hem can be furnished to run in 16 ga. capacity for plenum or edge-straightening needs	20													Call for Pricing
Combination 3-in-1 & 3-Step Gauge Bar	Right Angle Flange	16 or 20												Call for Pricing
	Standing Seam	16 or 20												Call for Pricing
	T - Connection	16 or 20												Call for Pricing
Combination Standing Seam & Right Angle	1-1/8" High (10-Station)	16												Call for Pricing
	1-1/4" High (10-Station)	16												Call for Pricing
	1-1/2" High (10-Station)	16												Call for Pricing
Streamline Duct, Inside Single "S" Slip	20													Call for Pricing
Pittsburgh Lock Pocket Depth = 1/2"	16													Call for Pricing

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Model	HB-520P	HB-800	HB-800P-20	HB-800P-18	HB-800P-16	HB-800B-24	HB-800B-20	HB-800B-18	HB-825 Triplex Cleatformer	M-S-5-10 LK Standing "S" Cleat	TDF®-V16	TDF® 1640
Gauge	Price	Price	Price	Price	Price	Price	Price	Price	Price	Price	Price	Price
5/16" Pittsburgh	20 - 26	Included	Available Option	Included	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option		
3/8" Pittsburgh	18 - 24		Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option		
1/2" Pittsburgh	18 - 22				Included							
1/2" Pittsburgh	16 - 20		Available Option	Available Option	Available Option	Available Option	Included	Available Option	Available Option	Available Option	Available Option	
Drive Cleat	20 - 26	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option		
Straight Right Angle Flange	20 - 26	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option		
Straight Right Angle Flange	16 - 20		Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option		
Button Punch Snaplock (Male & Female)	18 - 22		Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option		
Button Punch Snaplock (Male & Female)	20 - 24		Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option		
Button Punch Snaplock (Male & Female)	24 - 30		Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option		
[Individual Male or Female - divide by 2]												
Double Seam (Type "S")	22 - 28	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option		
Double Seam (Type "L")	16 - 20		Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option		
Standing Seam	16 - 20											
Combination 3-in-1 & 3-Step Gauge Bar	Right Angle Flange	22 - 26	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option
	Standing Seam	23 - 26	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option
	T - Connection	24 - 26	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option
3-in-1 Perforating & Notching Arrangement					Available Option							
2-in-1 Perforating & Notching Arrangement												
Hemming Rolls (180 Degrees)	24 - 28		Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option
Hemming Rolls (45 Degrees)	22 - 26		Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option	Available Option
Boot Clip	26 - 30											
3 in 1 Rolls [MR-T-1616-1 5/8]	16 - 18											Available Option
2x2 Angle [MR-AI-14-16]	14											Available Option
3 in 1 Rolls [MR-T-18-16]	18 - 24											Available Option
35mm Engelmate [MR-EM]	20 - 24											Call for Pricing
25mm Engelmate [MR-EM-25]	20 - 24											Call for Pricing
Z Bar	16 - 20											Call for Pricing
Hat Stiffener [MR-HS1640]	16 - 20											Call for Pricing
TDF® Clip [MR-TDA]	20											Available Option
Clip Stitcher [MR-CSA]	20											Available Option
1 inch Standing S Slip [MR-SS-20-16]	20 - 24										Call for Pricing	Call for Pricing
Standing S Slip-3 sizes [MR-SS-20-16-3]	20 - 24										Call for Pricing	Call for Pricing
Pittsburgh Lock Pocket Depth = 1/2"	16 - 24										Call for Pricing	Available Option

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MESTEK MACHINERY

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The milestones of our mission: Year After Year improving duct Fabrication productivity for you

KEY:



1938

The Lockformer Company was founded.

1939

The Pittsburgh lock rollformer first sold and the 2-pass bar-cleat machine was being designed.

1940

The 24 and the 20 ga. Pittsburgh lock machines were introduced.

1942

The EZ Edger hand operated flanger is created.

1946

The 8000 Series double-plate Cleatformer was developed to form drive cleats in one pass.

1948

The Standing "S" Cleat rollformer was first sold to the market.

1949

Charles Engel S/M worker produces first Shopmaster table and Engel as a Company is established with volume of sales.

1950

Welty Heating is a contractor in Coggon, IA

1952

Lockformer relocated to its new manufacturing facility on Cicero Avenue in Chicago. Hemming roll tooling was developed.

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1955

The 16 ga. Pittsburgh lock machine is first introduced.

1956

Welty Heating moved to Cedar Rapids to new location under the name Welty Way Products making patterned Pro-GutR (seamless gutter machine) & Co-pipe machines (making down spout and crimped down spout elbows)

1957

Engel Adds Rollformer and Small Tool i.e. Cleatbenders, Notchers. Also added the versatile power brake called Bend All.

1957

Welty Way develops the Coil Select feature.

1958

The first Button Punch Snaplock machine is sold and Acme lock roll tooling was newly designed.

1959

The "Shoil" was the first duct starter line with air controlled flying shear and notcher.

1960

The Roto-Notcher and Collar Maker machines were created.

1963

The Speednotch multi-head notcher was first sold.

1964

Duct-o-mation - full line with Lockformer Pittsburgh & Snaplock Coil - shear - notch - bead - Pitts - cleat - roll-L-Bruct.

1965

First Coil Lines with Shopmasters being fed. Electric Shear with Beading, Straightening and Feed Table to Shopmaster.

1968

First full line = Fabri-duct. Anderson & Litwick + the Zach Company in Chicago.

1968

Digital Dynapar added. Coil lines with flying notcher and mechanical brake.

1968

The Triplex Cleatformer created to produce 4 profiles in one machine with slitting attachment to cut "S" and drive cleats was added to the line-up of 8600 and 8900 Series Cleatformers.

1970

Hydraulic Length Control Compact 5-14 Coil Lines w/Fl-Wheel Mechanical Shear and Engel Built Digital Controls +/- 1/32 Accuracy.

1970

First Insulmatic added to Anderson & Litwick and Zach Co. do 4.5 million pounds of duct for the new McCormick Place. Welty-Way introduces the Feedie (coil feed punch, notch, cut-off feeding rollformers).

1970

Lockformer opened its new manufacturing facility in Lisle, IL.

1972

Dual Head Cleatroller introduced to Duct Lines.

1974

The DS Connector machine featuring New England cleat roll tooling was introduced along with the 24S Bandsaw.

1975

Lin-O-Matic with Gripnail Pinning System introduced along with purchased ECCI Controls Package (Digital).

1977

Full Hydraulic Compact Coil line shear, notch and feed.

1978

Welty Way becomes Iowa Precision and the Fabri-duct is now called Duct-o-Matic.

1980

First 5 Batch Micro Processor Control.

1982

The Transverse Duct Connector (TDC) and the first Vulcan 1200 Plasma Cutting System were unveiled at the Atlantic City ASHRAE Show.

1982

Engel TDF T25-B introduced to Market.

1984

The TDC Notcher and the Roll-A-Duct spiral duct rollforming system was developed.

1984

Iowa Precision establishes the Coil Line Software Programming department.

1985

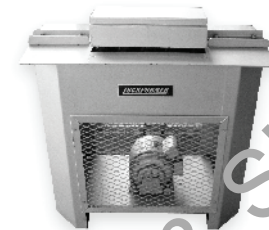
The new Vulcan 2400 replaced the Vulcan 1200.

1985

IPI introduces automated elbow fabrication machinery.

1988

On Lockformer's 50th Anniversary, the very first Pittsburgh Lock Machine ever produced (S/N-101) was found in Cleveland, OH still making ductwork after 50 years!



1989

The Vulcan 1000 was added to the Vulcan line-up.

1990

IPI introduces straight line Duct Line and the Whisper-Loc seam closer offered to market.

1990

Hydraulic Wrapper Brake w/side eject & Engel Built PC Controls E 1000 Controller.

1993

The Vulcan PCM (now the 3100HD) was first sold to the precision HVAC metal fabrication market.

1993

The Cornermatic automated corner insertion machine is developed by Systemation introduced by IPI, SMACNA approved. Tie Rod Hole punching added to automated lines. The first 14 gauge automated Duct Line delivered.

1995

Engel Seam Closer Introduced. Engel Fold N Shear introduced. End Eject Braking System in lieu of Side Eject.

1995

Newly designed Multi-Grid Coil Select introduced.

1999

The Vulcan 1000 was first introduced for high speed HVAC fitting cutting.

1999

Engel Fold N Shear With In Line Cleatroller introduced.

2000

Engel CDS Corner Insertion Equipment introduced at Dallas H.E. Gripnail Welder Multi Head introduced. Touch Screen Window Based Controls E-2000 with Ethernet Capability for interface with Down Stream Equipment.

2000

The Vulcan 1600 Waterjet was first introduced for high speed insulation cutting.

2001

Iowa Precision acquired by Mestek, Inc.

2001

Lockformer acquired by Mestek, Inc.

2003

Duct lines redesigned & renamed ProFabriduct - all lines offered with servo drives, directly driven, hydraulically actuated decoilers. Mark XV was newly designed and added to the automated lines.

2003

Engel is acquired by Mestek, Inc.

2005

The TDC-V is introduced to the market.

2005

The Ductmaker Coil Line developed and offered.

2006

The Engel Coil Lines are upgraded with Iowa Precision Features and Marketed under Mestek Machinery and the Compact II Front End now expandable.

2006

Servo driven Wrap Brake becomes standard on all ProFabriducts.

2008

Swing-Knife/Swing-Blade insulation cutting system developed for cutting elastomeric foam duct liner. Units subsequently offered as standard in all automated duct line controls.

2008

ValuePLUS line was created and offered to the market.

2008

Fully adjustable TDC Duplex and Stand Alone from 19mm to 38mm. The Vulcan 1000E developed and offered European Community; CE Certified, zoned exhaust, B&R.

2009

The newly designed TDC V16 is offered to the market - The Pneumo-Wrap Brake is now offered for contractors to bend TDF and TDC.

2009

All Coil Lines utilize the common B&R Control platform with industrial PLC's. The newly designed Easy-Load was offered on all coil lines.

2010

Significant Coil Line diagnostics developed.

2011

Vulcan users top 3,500. The VulcanPlus with new control and "Flex-Ability" updates the Vulcan 1000D technology. Total Integration from BIM to Field using Trimble® TDL CAD (now replaced by DD 3D CAD®).

2011

Milestone: Over 1,000 Iowa Precision Coil Line Systems SOLD - Many outside of North America.

2012

4th Quarter: ISM is acquired by Mestek, Inc.

2012

2012 Chicago AHR: Introduces the advanced diagnostic tool - "Guru on a Stick" and the TDC-FAM film application machine.

2012

Introduction of EZ Hanger and EZ Connector saves contractors more than 70% on their duct hanging and labor costs

2013

ISM by Lockformer introduces the Max-Flange flanging machine and Oval Max system with independent cylinders that stretch spiral round duct into oval.

2013

Cornermatic Plus introduced as first corner crimper exclusively for fittings.

2014

ISM by Lockformer introduces Angle-Max used to produce angle stock for flat oval and round flanges along with TDC®, TDF® and other special flanges from stock coil

2014

IPI and Engel introduce in-line Plasma cutting and welded duct options to coil lines

2015

Iowa Precision introduces redesigned Tie Rod Crimping machine with ¼" thread body standard on ½" and ¾" head bolts

2016

ISM by Lockformer brings to the industry the LASER-MAX 1.5 Laser cutting table with enclosed torch head

2017

Harper-type Vanemakers and Railmakers added to Lockformer product line for production of air turning vanes

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5480 - Sixth Street S.W. • Cedar Rapids, IA • 52404 | 319.364.9181

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With more than 100,000 square feet of manufacturing space at our disposal, the Mestek Machinery family of companies—Engel® Industries, Iowa Precision®, and Lockformer®—make their home in Cedar Rapids, Iowa. Our U.S. office and manufacturing facility is the division's base of operations, providing quality, precision metal forming equipment to leading sheet metal contractors and fabricators worldwide.



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FORMTEK INTERNATIONAL US HEADQUARTERS

Dedicated to the highest industry standards and technical accountability to our international customers, these specialists are a well-built team of management, sales engineers and support staff who pride themselves on being true experts, with an in depth knowledge of all of our brands of equipment.



FORMTEK EUROPE

Our Sales, market liaison, service and distribution center in Europe are true professionals who specialize in providing HVAC contractors with profitable solutions. Standard machines and parts are readily available to meet all of your HVAC machinery and equipment needs.



FORMTEK ASIA PACIFIC

Mestek Machinery's assembly facility in China is held to the same standards for quality as our Cedar Rapids plant achieving ISO-9001 certification from 2008 to the present. All components used in the assembly of our precision equipment are purchased from qualified vendors, ensuring the materials meet our stringent specifications. Additionally, the work of our highly trained assembly professionals is constantly monitored, guaranteeing you receive the precision and quality you expect from an industry leader.



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