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.

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 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.

<table>
<thead>
<tr>
<th>MODE</th>
<th>CAPACITY</th>
<th>DEPTH OF POCKET/SIZE</th>
<th>OTHER</th>
<th>SPEED</th>
<th>MOTOR/VOLTAGE</th>
<th>DIMENSIONS/WEIGHT</th>
</tr>
</thead>
<tbody>
<tr>
<td>Pittsburgh Lock Model 24</td>
<td>24-28 gauge</td>
<td>5/16&quot; Uses approximately 1&quot; of material</td>
<td>Width of hammer-over edge adjustable up to 3/4&quot;</td>
<td>30-35 feet per minute</td>
<td>3/4 H.P., 115/230 volts, 60 cycle, single phase, A.C. 1,800 RPM. Other motors available upon request</td>
<td>Length - 30&quot; Width - 13.5&quot; Height - 20&quot; Weight - 175 lbs.</td>
</tr>
<tr>
<td>Pittsburgh Lock Model 20</td>
<td>20-26 gauge</td>
<td>5/16&quot; Uses approximately 1&quot; of material</td>
<td>Width of hammer-over edge adjustable up to 3/4&quot; Extended shafts for mounting auxiliary rolls</td>
<td>25 feet per minute</td>
<td>3/4 H.P., 115/230 volts, 60 cycle, single phase, A.C. 1,800 RPM. Other motors available upon request</td>
<td>Length - 36&quot; Width - 16.5&quot; Height - 41&quot; Passline - 32&quot; Weight - 450 lbs.</td>
</tr>
<tr>
<td>Pittsburgh Lock Model 20 Super Speed</td>
<td>20-26 gauge</td>
<td>5/16&quot; Uses approximately 1&quot; of material</td>
<td>Width of hammer-over edge adjustable up to 3/4&quot; Extended shafts for mounting auxiliary rolls</td>
<td>75 feet per minute</td>
<td>2 H.P., 230/460 volts, 60 cycle, 3 phase, A.C. 1,800 RPM. Other 3 phase models available</td>
<td>Length - 48&quot; Width - 34&quot; Height - 42&quot; Passline - 34&quot; Weight - 450 lbs.</td>
</tr>
<tr>
<td>Pittsburgh Lock Model 14</td>
<td>14-16 gauge</td>
<td>1/2&quot; Uses approximately 1-3/8&quot; of material</td>
<td>Width of hammer-over edge adjustable up to 3/8&quot; Extended shafts for mounting auxiliary rolls</td>
<td>35 feet per minute</td>
<td>5 H.P., 230/460 volts, 60 cycle, 3 phase, A.C. 1,800 RPM. Other motors available upon request</td>
<td>Length - 58.5&quot; Width - 24&quot; Height - 41&quot; Passline - 34&quot; Weight - 750 lbs.</td>
</tr>
<tr>
<td>Pittsburgh Lock Model 16</td>
<td>16-20 gauge</td>
<td>1/2&quot; Uses approximately 1-3/8&quot; of material</td>
<td>Width of hammer-over edge adjustable up to 3/8&quot; Extended shafts for mounting auxiliary rolls</td>
<td>40 - 45 feet per minute</td>
<td>3 H.P., 230/460 volts, 60 cycle, 3 phase, A.C. 3,600 RPM. Other motors available upon request</td>
<td>Length - 58.5&quot; Width - 24&quot; Height - 41&quot; Passline - 34&quot; Weight - 750 lbs.</td>
</tr>
<tr>
<td>Pittsburgh Lock Model 18</td>
<td>18-22 gauge</td>
<td>3/8&quot; Uses approximately 1-1/8&quot; of material</td>
<td>Width of hammer-over edge adjustable up to 3/8&quot; Extended shafts for mounting auxiliary rolls</td>
<td>40 - 45 feet per minute</td>
<td>2 H.P., 230/460 volts, 60 cycle, 3 phase, A.C. 1,800 RPM. Other motors available upon request</td>
<td>Length - 58.5&quot; Width - 24&quot; Height - 41&quot; Passline - 34&quot; Weight - 750 lbs.</td>
</tr>
</tbody>
</table>
**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 ¾" 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.

**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 roll set 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; extended shafts for mounting auxiliary rolls; and an arc-welded steel stand protected with Lockformer®’s top-quality primer and paint finish.

**MODEL CAPACITY DEPTH OF POCKET/SIZE OTHER**

<table>
<thead>
<tr>
<th>MODEL</th>
<th>CAPACITY</th>
<th>DEPTH OF POCKET/SIZE</th>
<th>SIZE</th>
<th>OTHER</th>
</tr>
</thead>
<tbody>
<tr>
<td>20 GAUGE BUTTON PUNCH SNAPLOCK</td>
<td>20–26 gauge</td>
<td>1-3/4&quot; material</td>
<td>Uses approximately 1-3/4&quot; material</td>
<td></td>
</tr>
<tr>
<td>TRIPLEX CLEATFORMER</td>
<td>22-28 gauge for “S” cleat profile and 20-26 gauge for drive cleat profile</td>
<td>“S” cleat width 1-1/16” Drive cleat width 1-1/8”</td>
<td>Extended shafts for mounting auxiliary rolls.</td>
<td></td>
</tr>
</tbody>
</table>

**SPEED**

- 60 - 65 feet per minute
- 100 feet per minute

**MOTOR/VOLTAGE**

- 3 H.P. 230460 volts, 60 cycle, 3phase, A.C. 3,600 RPM. Other motors available upon request.
- 5 H.P. 230460 volts, 60 cycle, 3phase, A.C. 1,800 RPM.

**DIMENSIONS/WEIGHT**

<table>
<thead>
<tr>
<th>MODEL</th>
<th>LENGTH</th>
<th>WIDTH</th>
<th>HEIGHT</th>
<th>PASSLINE</th>
<th>WEIGHT</th>
</tr>
</thead>
<tbody>
<tr>
<td>20 GAUGE BUTTON PUNCH SNAPLOCK</td>
<td>58.5&quot;</td>
<td>24&quot;</td>
<td>41&quot;</td>
<td>34&quot;</td>
<td>125 lbs.</td>
</tr>
<tr>
<td>TRIPLEX CLEATFORMER</td>
<td>60&quot;</td>
<td>24&quot;</td>
<td>40&quot;</td>
<td>32-1/2&quot;</td>
<td>850 lbs.</td>
</tr>
</tbody>
</table>

**TRIPLEX CLEATFORMER PROFILE**

- Uses approximately 1-3/4" material
- Extended shafts for mounting auxiliary rolls.
- Length - 58.5”
- Width - 24”
- Height - 41”
- Passline - 34”
- Weight - 125 lbs.

**TRIPLEX CLEATFORMER MODEL SHOWN WITH OPTIONAL SLITTER ATTACHMENT.”**

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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.

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.

<table>
<thead>
<tr>
<th>MODEL</th>
<th>CAPACITY</th>
<th>DEPTH OF POCKET/SIZE</th>
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<th>MOTOR/VOLTAGE</th>
<th>DIMENSIONS/WEIGHT</th>
</tr>
</thead>
<tbody>
<tr>
<td>ROUND/oval PIPE MACHINE 7 STATION</td>
<td>24-30 gauge</td>
<td>Uses approximately 1-9/16” material for both sides</td>
<td>V-belt</td>
<td>35 feet</td>
<td>2 H.P., 230/460 volts, 60 cycle, 3,600 RPM.</td>
<td>Length - 48” Width - 24” Height - 41” Passline - 34” Weight - 750 lbs.</td>
</tr>
<tr>
<td>ROUND/oval PIPE MACHINE 9 STATION</td>
<td>Pre-curl 24-30 gauge</td>
<td>Uses approximately 1-9/16” material for both sides</td>
<td>V-belt</td>
<td>35 feet</td>
<td>2 H.P., 230/460 volts, 60 cycle, 3,600 RPM.</td>
<td>Length - 48” Width - 24” Height - 41” Passline - 34” Weight - 750 lbs.</td>
</tr>
<tr>
<td>DRIVE TURN HEMMING</td>
<td>22-26 gauge</td>
<td>Uses approximately 1/2” Hem material</td>
<td>N/A</td>
<td>60 feet per minute</td>
<td>3 H.P. 230/460 volts, 60 cycle, 3-phase, A.C. 3,600 RPM</td>
<td>Length - 60” Width - 30” Height - 48” Passline - 34” Weight - 800 lbs.</td>
</tr>
</tbody>
</table>
**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.

**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

<table>
<thead>
<tr>
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</tr>
</thead>
<tbody>
<tr>
<td>STANDING &quot;S&quot; CLEAT</td>
<td>20-26 gauge</td>
<td>1-1/8&quot; pocket. Uses approximately 6-1/4&quot; material stretch out inboard</td>
<td>Extended shafts for mounting auxiliary rolls</td>
<td>60 - 70 feet per minute</td>
<td>5 H.P., 230/460 volts, 60 cycle, 3 phase, A.C. 1,800 RPM</td>
<td>Length - 84&quot; Width - 30&quot; Height - 37&quot; Passline - 33&quot; Weight - 1,700 lbs.</td>
</tr>
<tr>
<td>DS CONNECTOR</td>
<td>14 STATION</td>
<td>Variable</td>
<td>Variable</td>
<td>70 feet per minute</td>
<td>7.5 H.P., 230/460 volts, 60 cycle, 3 phase, 1,800 RPM, across-the-line starter</td>
<td>Length - 115&quot; Width - 32&quot; Height - 48&quot; Passline - 35&quot; Weight - 2,150 lbs. without roll</td>
</tr>
<tr>
<td>SUPER 11 CLEATFORMER</td>
<td>11 STATION</td>
<td>22-26 gauge for &quot;S&quot; cleat operation</td>
<td>Standing &quot;S&quot; cleat height 1/2&quot; Standing &quot;S&quot; cleat width 1-1/8&quot;</td>
<td>100 feet per minute</td>
<td>5 H.P., 230/460 volts, 60 cycle, 3 phase, 1,800 RPM. Manual switch with across-the-line starter</td>
<td>Length - 67&quot; Width - 24&quot; Height - 40&quot; Passline - 30 - 1/2&quot; Weight - 950 lbs.</td>
</tr>
</tbody>
</table>

www.hweiss.com
**AUTO-GUIDE FLANGER MODEL 1b**

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.

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**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.

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**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 PowerCheek Bender for making right-angle flanges for Pittsburgh fittings. Self contained hydraulic system.

---

**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.

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**Model Details**

<table>
<thead>
<tr>
<th>MODEL</th>
<th>CAPACITY</th>
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<th>SPEED</th>
<th>MOTOR/VOLTAGE</th>
<th>DIMENSIONS/WEIGHT</th>
</tr>
</thead>
<tbody>
<tr>
<td>MODEL 16</td>
<td>16 gauge maximum. Working range 16-24 gauge</td>
<td>Two flange heights available. Specify 3/8” or 1/4”</td>
<td>N/A</td>
<td>18 feet per minute</td>
<td>3/4 H.P. 115/230 volts, 60 cycle, single phase, A.C. 1,800 RPM</td>
<td>Length - 24” Width - 24” Passline - 34” Weight - 225 lbs.</td>
</tr>
<tr>
<td>MODEL 16</td>
<td>20 gauge or lighter</td>
<td>Makes flanges approximately 7/32” outside height</td>
<td>N/A</td>
<td>16 - 18 feet per minute</td>
<td>N/A</td>
<td>Length - 14” Width - 10” Passline - 8.5” Weight - 32 lbs.</td>
</tr>
<tr>
<td>MODEL 16</td>
<td>20 gauge or lighter</td>
<td>Variable</td>
<td>Self contained hydraulic system</td>
<td>N/A</td>
<td>3/4 H.P. 115/230 volts, 60 cycle, single phase, A.C. 1,800 RPM</td>
<td>Length - 24” Width - 28” Passline - 34” Weight - 200 lbs.</td>
</tr>
<tr>
<td>MODEL 16</td>
<td>20 gauge maximum Working range 20-28 gauge</td>
<td>7/16” flange</td>
<td>N/A</td>
<td>16 feet per minute</td>
<td>3/4 H.P. 115/230 volts, 60 cycle, single phase, A.C. 1,800 RPM</td>
<td>Length - 24” Width - 24” Passline - 34” Weight - 250 lbs.</td>
</tr>
</tbody>
</table>

www.hweiss.com
**VANEMAKER**

Mestek Machinery is now the exclusive provider of the Harper-type Vanemaker, 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.

<table>
<thead>
<tr>
<th>MODEL</th>
<th>CAPACITY</th>
<th>PART LENGTH</th>
<th>OTHER</th>
<th>MODEL</th>
<th>CAPACITY</th>
<th>PART LENGTH</th>
<th>OTHER</th>
<th>MOTOR/VOLTAGE</th>
</tr>
</thead>
<tbody>
<tr>
<td>2”VANEMAKER 2</td>
<td>26 gauge</td>
<td>48” maximum</td>
<td>N/A</td>
<td>2”</td>
<td>22-26 gauge</td>
<td>N/A</td>
<td>2¼” Vane Spacing</td>
<td>3 HP. / 1,140 RPM / 208-230-460 V / 3ph / 60HZ.</td>
</tr>
<tr>
<td>4”VANEMAKER</td>
<td>24 gauge</td>
<td>120” maximum</td>
<td>N/A</td>
<td>4”</td>
<td>22-26 gauge</td>
<td>N/A</td>
<td>3½” Vane Spacing</td>
<td>3 HP. / 1,140 RPM / 208-230-460 V / 3ph / 60HZ.</td>
</tr>
<tr>
<td>2”PUSH-TYPE</td>
<td>22-26 gauge</td>
<td>N/A</td>
<td>2¼” Vane Spacing</td>
<td>2”</td>
<td>22-26 gauge</td>
<td>N/A</td>
<td>2¼” Vane Spacing</td>
<td>3 HP. / 1,140 RPM / 208-230-460 V / 3ph / 60HZ.</td>
</tr>
<tr>
<td>RAILMAKER</td>
<td></td>
<td></td>
<td></td>
<td>4”</td>
<td>22-26 gauge</td>
<td>N/A</td>
<td>3½” Vane Spacing</td>
<td>3 HP. / 1,140 RPM / 208-230-460 V / 3ph / 60HZ.</td>
</tr>
<tr>
<td>CRATE DIMENSIONS</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Length: 54” Width: 30” Height: 51” Weight: 850 lbs.</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Length: 76” Width: 42” Height: 54” Weight: 1,950 lbs.</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Length: 24” Width: 20” Height: 45” Weight: 300 lbs.</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Length: 28” Width: 20” Height: 45” Weight: 300 lbs.</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

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<tr>
<th>MODEL</th>
<th>CAPACITY</th>
<th>PART LENGTH</th>
<th>OTHER</th>
<th>MOTOR/VOLTAGE</th>
</tr>
</thead>
<tbody>
<tr>
<td>2”VANEMAKER 2</td>
<td>26 gauge</td>
<td>48” maximum</td>
<td>N/A</td>
<td>Vane Motor 3hp / 208-230 V / 60HZ. / 20 amp. min. 1725 RPM</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Shear motors 3hp / 11s HP. / 208-230 V / 60HZ. / 1725 RPM</td>
</tr>
<tr>
<td>4”VANEMAKER</td>
<td>24 gauge</td>
<td>120” maximum</td>
<td>N/A</td>
<td>Vane Motor 5hp / 208-230 V / 60HZ. / 20 amp. min. / 1725 RPM</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Shear Motors 2 HP. / 208-230 V / 3ph / 60HZ. / 1725 RPM</td>
</tr>
<tr>
<td>2”PUSH-TYPE</td>
<td>22-26 gauge</td>
<td>N/A</td>
<td>2¼” Vane Spacing</td>
<td>Vane Motor 5ph / 208-230 V / 60HZ. / 20 amp. min. / 1725 RPM</td>
</tr>
<tr>
<td>RAILMAKER</td>
<td></td>
<td></td>
<td></td>
<td>Shear Motors 2 HP. / 208-230 V / 3ph / 60HZ. / 1725 RPM</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>N/A</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>N/A</td>
</tr>
<tr>
<td>CRATE DIMENSIONS</td>
<td></td>
<td></td>
<td></td>
<td>Length: 54” Width: 30” Height: 51” Weight: 850 lbs.</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Length: 76” Width: 42” Height: 54” Weight: 1,950 lbs.</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Length: 24” Width: 20” Height: 45” Weight: 300 lbs.</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Length: 28” Width: 20” Height: 45” Weight: 300 lbs.</td>
</tr>
</tbody>
</table>

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.

**VANEMAKER**

Mestek Machinery is now the exclusive provider of the Harper-type Vanemaker, 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.

<table>
<thead>
<tr>
<th>MODEL</th>
<th>CAPACITY</th>
<th>PART LENGTH</th>
<th>OTHER</th>
<th>MOTOR/VOLTAGE</th>
</tr>
</thead>
<tbody>
<tr>
<td>2”VANEMAKER 2</td>
<td>26 gauge</td>
<td>48” maximum</td>
<td>N/A</td>
<td>Vane Motor 3hp / 208-230 V / 60HZ. / 20 amp. min. 1725 RPM</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Shear motors 3hp / 11s HP. / 208-230 V / 60HZ. / 1725 RPM</td>
</tr>
<tr>
<td>4”VANEMAKER</td>
<td>24 gauge</td>
<td>120” maximum</td>
<td>N/A</td>
<td>Vane Motor 5hp / 208-230 V / 60HZ. / 20 amp. min. / 1725 RPM</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Shear Motors 2 HP. / 208-230 V / 3ph / 60HZ. / 1725 RPM</td>
</tr>
<tr>
<td>2”PUSH-TYPE</td>
<td>22-26 gauge</td>
<td>N/A</td>
<td>2¼” Vane Spacing</td>
<td>Vane Motor 5ph / 208-230 V / 60HZ. / 20 amp. min. / 1725 RPM</td>
</tr>
<tr>
<td>RAILMAKER</td>
<td></td>
<td></td>
<td></td>
<td>Shear Motors 2 HP. / 208-230 V / 3ph / 60HZ. / 1725 RPM</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>N/A</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>N/A</td>
</tr>
<tr>
<td>CRATE DIMENSIONS</td>
<td></td>
<td></td>
<td></td>
<td>Length: 54” Width: 30” Height: 51” Weight: 850 lbs.</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Length: 76” Width: 42” Height: 54” Weight: 1,950 lbs.</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Length: 24” Width: 20” Height: 45” Weight: 300 lbs.</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Length: 28” Width: 20” Height: 45” Weight: 300 lbs.</td>
</tr>
</tbody>
</table>
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.

**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)**

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® 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.

**SPEEDNOTCH MODEL 1b**

(3/6 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.

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### MODEL CAPACITY DEPTH OF POCKET/SIZE OTHER SPEED MOTOR/VOLTAGE DIMENSIONS/WEIGHT

<table>
<thead>
<tr>
<th>MODEL</th>
<th>CAPACITY</th>
<th>DEPTH OF POCKET/SIZE</th>
<th>OTHER</th>
<th>SPEED</th>
<th>MOTOR/VOLTAGE</th>
<th>DIMENSIONS/WEIGHT</th>
</tr>
</thead>
<tbody>
<tr>
<td>TDC® NOTCHER</td>
<td>16 gauge mild steel</td>
<td>2 7/16” for TDC® notch, 1 1/2” for “V” notch</td>
<td>Available in 3, 5 and 6 head combinations</td>
<td>N/A</td>
<td>3 H.P., 230/460 volts, 60 cycle, 3phase, A.C.</td>
<td>Length - 122”, Width - 24”, Height - 62”, Passline - 45”, Weight - 800 lbs.</td>
</tr>
<tr>
<td>SPEEDNOTCH MODEL 1b</td>
<td>16-28 gauge</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>3 H.P., 230/460 volts, 60 cycle, 3phase, A.C.</td>
<td>1,600 RPM</td>
</tr>
</tbody>
</table>

www.hweiss.com
**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.

**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 LS35950]

**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.

**Model Details**

Model: L535950

- **Function:** This Clip Tool makes effortless work out of the installation of TDC® or TDF® clips.
- **Usage:** Can be used with pliers or channel locks.
- **Size:** Optional stand is included.
- **Applications:** Suitable for 6” TDC® or TDF® SMACNA specified clips.

**Galv-Off**

- **Description:** A product for softening and dissolving galvanized build-up.
- **Benefits:** Prevents advanced roll wear and tooling damage.
- **Usage:** Lubricates and cleans galvanized surfaces.
- **Components:** 12 oz. aerosol size cans in cases of 12.

**Dimensions/Weight**

- **Width:** 4”
- **Height:** 18” with stand
- **Weight:** 23 lbs.

**Speed**

- **Rollformer Speeds:** Limited to 65 feet per minute on per-cut length
- **Motor/Voltage:** 115 volts, 60 cycle, single phase, Arm 100 psi

**Model Details**

- **Model:** L535950
- **Function:** Specifically designed for TDC® and TDF® clip installation.
- **Components:** Includes optical eye triggers for adjustable flow.

**Galv-Off**

- **Function:** A specially formulated product for lubrication and cleaning.
- **Components:** 12 oz. aerosol size cans in cases of 12.
- **Applications:** Ideal for precision rollforming machines.
- **Benefits:** Helps prevent roll wear and tooling damage.

**Dimensions/Weight**

- **Width:** 24”
- **Height:** 28”
- **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.

**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 movement.

**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”).

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**MODEL**  
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.

**MODEL**  
ROTO NOTCHER  
24-30 gauge  
N/A  
30 ft/min  
30 fpm  
3/4 hp, 115 volt, single phase  
Drive - V-belt  
Length - 20”  
Width - 23”  
Height - 36”  
Weight - 300 lbs.

**MODEL**  
SPIN COLLAR MAKER  
24-30 gauge  
N/A  
Curling Diameter - 4-18”  
MODEL 6: 2” - 6”  
MODEL 12: 2” - 12”  
40 fpm  
3/4 hp, 1725 rpm, 115 volt, 1 phase  
Length - 22 ½”  
Width - 42”  
Height - 37”  
Weight - 400 lbs.
LOCKFORMER
CORNER INSERTION MACHINES

**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.

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**MODEL DETAILS**

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

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**6016 BEADER**
Beads 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 bead- ing 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.

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VULCANPLUS® CUTTING SYSTEM

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.

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.

<table>
<thead>
<tr>
<th>MODEL</th>
<th>SOFTWARE/COMPUTER SYSTEM</th>
<th>MACHINE CONTROL</th>
<th>PLASMA UNIT</th>
<th>CUTTING CAPACITY</th>
<th>CUTTING AREA &amp; TABLE CAPACITY</th>
<th>SPEED</th>
<th>APPROXIMATE DIMENSIONS</th>
<th>APPROXIMATE WEIGHT</th>
</tr>
</thead>
<tbody>
<tr>
<td>VULCANPLUS® CUTTING SYSTEM</td>
<td>Vulcan® 6XP HVAC</td>
<td>Dell PC with 19&quot; Monitor &amp; Printer</td>
<td>Hypertherm Standard: PowerMax 45 Optional: PowerMax 65</td>
<td>3/8&quot; Mild Steel 1/2&quot; Mild Steel</td>
<td>5x10' Standard - 6x20'; Optional</td>
<td>Positioning Speed 3,000 IPM Max.</td>
<td>164' long 81' wide 58&quot; high</td>
<td>2,700 lbs.</td>
</tr>
</tbody>
</table>
**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.

**VULCAN® 1600 WJ 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 Vulcans® insulation cutting software and table to increase shop productivity, reduce waste, and improve their bottom line.

**Model Details**

**VULCAN® 1600 WJ WATERJET**

- **Model**: Vulcan® 1600 WJ Waterjet Cutting System
- **Specifications**
  - **Cutting Capacity**: 0.120” Mild Steel Midi Steel Optical Cutting Capacity
  - **Cutting Area & Table Capacity**: Standard: 5’x10’ Optional: 5’x20’
  - **Positioning Speed**: 1,100 IPM Max.
  - **Length**: 168”
  - **Width**: 96”
  - **Height**: 63”
  - **Weight**: 3,200 lbs.

**Software/Computer System**

- **VULCAN® LASER MAX 1.5**: Vulcan® 6XP HVAC
  - PC with 19” Monitor & Primar
  - Other Cam Software interfaces available upon request
- **VULCAN® 1600 WATERJET**: Vulcan® 6XP HVAC
  - Dell PC with 19” Monitor & Printer
  - 7500 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

**For more information, visit**: www.hweiss.com

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LOCKFORMER VULCAN® INSULATION CUTTING SYSTEM

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

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

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