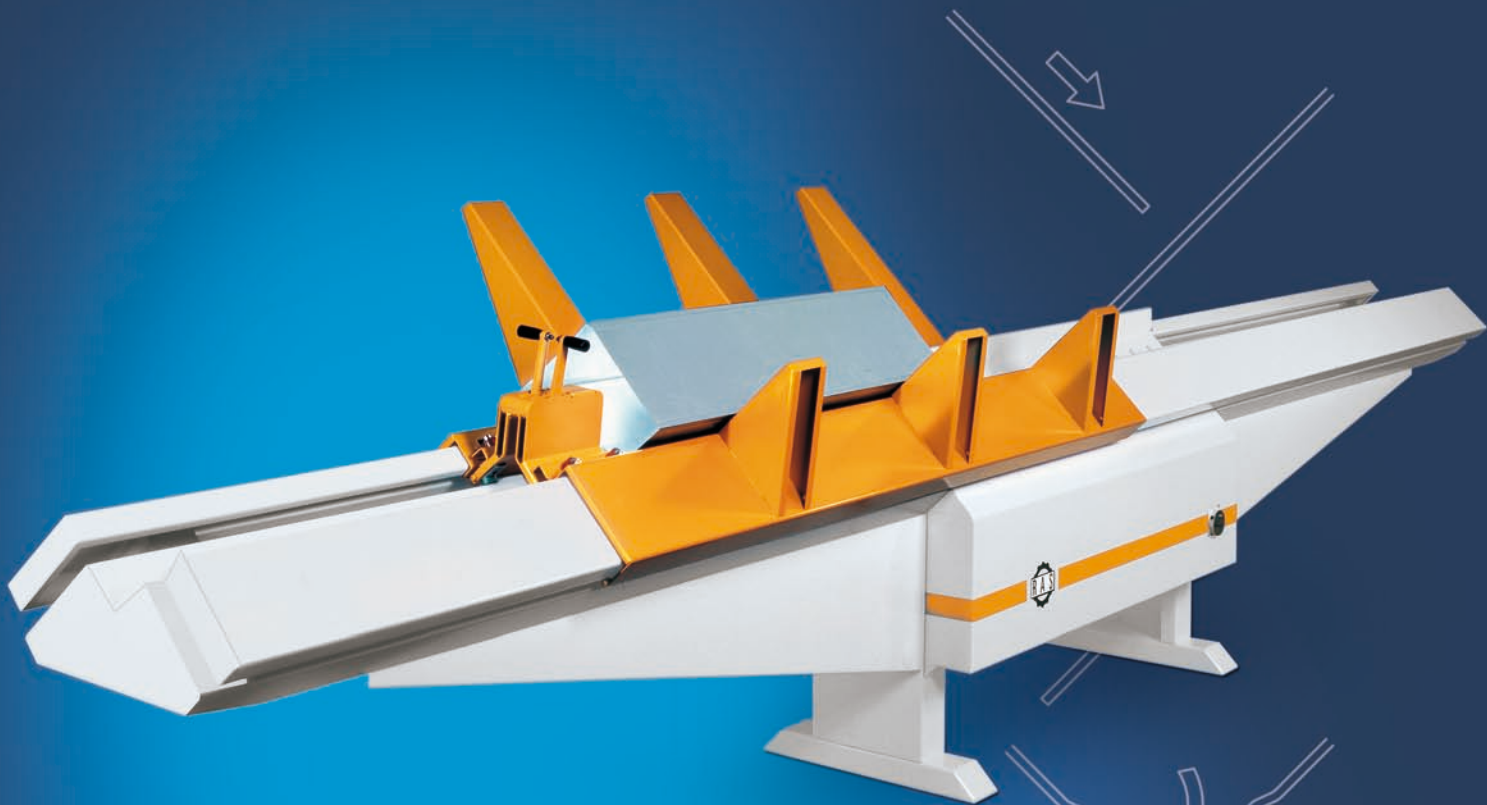


DuctZipper

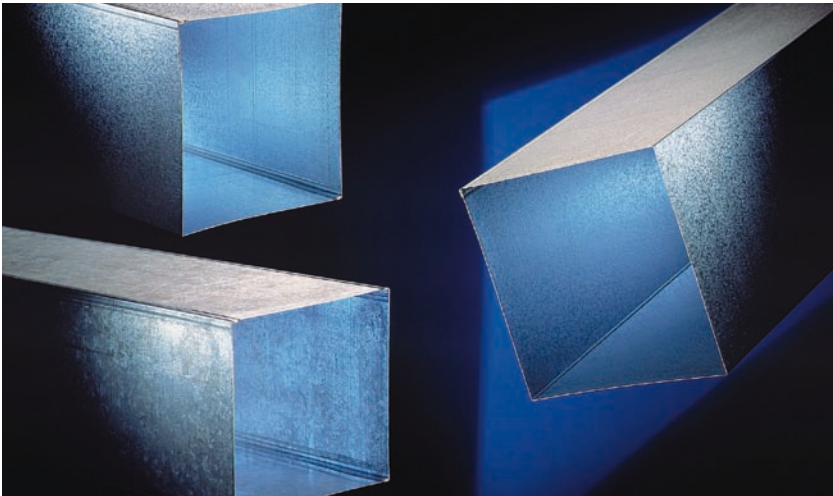


- Cutting
- Bending
- Forming



DuctZipper

DuctZipper: From 3 to 1!



The DuctZipper produces air ducts with one, two or four seams.

RAS technology and engineering have taken the seaming process from the traditional three steps down to only one. Traditional methods rollform the receiver lock, then they rollform the flange, and finally connect the two and close the seam. The DuctZipper does all this in one smooth and simple operation! The result is a clean joint, extremely tight ducts, and remarkably fast throughput.

Quick. Safe. Tight.

The innovative material handling system

It's so simple: Insert material, run through ... that's it. The material handling system comes short front and long rear arms to support the duct. They give the best access to the operator when inserting the sheet. They also support the duct while the machine forms and

closes the seam. This extremely productive "in-line design" moves through the machine along with the duct work. If a duct should be completed with multiple seams, the operator simply puts the semi-finished duct crosswise onto the material guidance system and slides it back to the entry point. Where previously two operators were required to produce a duct, a single operator is able to complete the work.

Innovative. Effortless. Economical.



The RAS material handling system with short front and long rear arms to support the duct.



If a duct should be completed with multiple seams, the operator simply puts the semi-finished duct crosswise onto the material guidance system and slides it back to the entry point.

The unique AutoPilot

The AutoPilot is the answer to automation of the duct seaming process with minimal operator involvement. The floating lower jaw offers an extremely safe two point clamp on all material thickness. Combined with the support arms of the material guidance system, the AutoPilot moves with the material in a tandem effort through the machine. On ducts longer than two meter (6.5 ft) the AutoPilot automatically detaches from the material handling system, allowing a larger operational range for the DuctZipper.

Unique. Clever. Versatile.



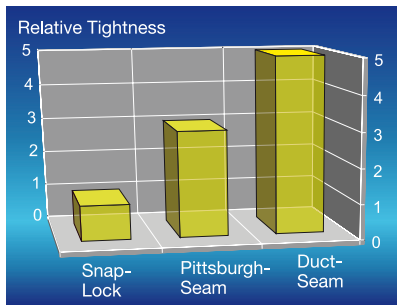
The floating lower jaw offers an extremely safe two point clamp on all material thickness.

DuctZipper

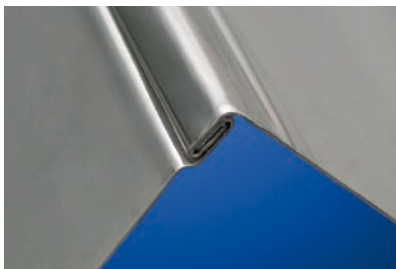
Durable technology

With finite element analysis design, the system represents the ultimate in rock-solid stability and maintenance free functionality. The all new drive system optimizes torque distribution, resulting in a machine that requires lubrication significantly less often! In addition the shafts are covered with a labyrinth sleeve, so that almost no zinc abrasion can get into the gear box or the bearings.

Durable. Robust. Low maintenance.



The Duct Seam is much tighter than other common seams such as Pittsburgh or Snap Lock.



Equipped with specific forming rolls the DuctZipper RAS 20.10 can also handle 0.8 mm (22 Ga.) stainless steel material.



The DuctZipper RAS 20.10 seaming bar



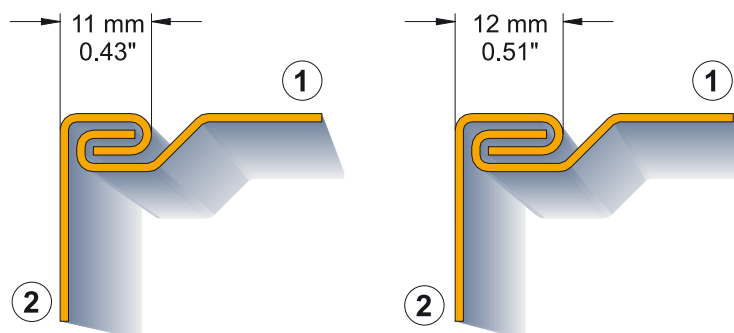
For special tightness requirements, an optional sealing compound unit injects the sealing material into the seam, before closing it.



The reinforced DuctZipper RAS 20.12 seaming bar

| | Leakage Check | Seam without Sealing Compound | Seam with Sealing Compound |
|--|-------------------------------------|--------------------------------------|---------------------------------------|
| | Inside pressure 100 mm (4") WS (WG) | 120 Liter/hour 31.7 Gallons/hour | 0.17 Liter/hour 0.04 Gallons/hour |
| | Inside pressure 150 mm (6") WS (WG) | 270 Liter/hour 71.3 Gallons/hour | 0.17 Liter/hour 0.04 Gallons/hour |
| | Inside pressure 200 mm (8") WS (WG) | 600 Liter/hour 158.5 Gallons/hour | 0.22 Liter/hour 0.06 Gallons/hour |
| | Recommended for: | General Requirements | Laboratories, Clinics, Power Stations |

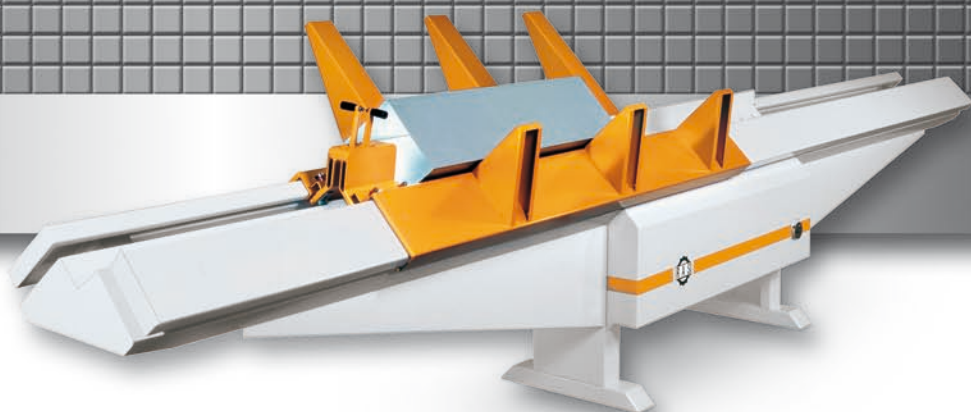
Leakage Check (Institute for Thermodynamic, University of Stuttgart, Germany)



| DuctZipper RAS 20.10 | DuctZipper RAS 20.12 |
|---|--|
| Material Thickness 0.5 – 1 mm (26 – 20 Ga.) | Material Thickness 1 – 1.25 mm (20 – 18 Ga.) |
| Seaming allowance: | Seaming allowance: |
| Side ① : about 8 mm (0.315") | Side ① : about 8 mm (0.315") |
| Side ② : about 18 mm (0.71") | Side ② : about 18 mm (0.71") |



DuctZipper



Duct Seaming Machine

| Technical Data | RAS 20.12 | | RAS 20.10 | |
|----------------------------------|--------------|--------------|--------------|--------------|
| Sheet Thickness (Mild Steel) | 1 – 1.25 mm | 20 – 18 Ga. | 0.5 – 1 mm | 26 – 20 Ga. |
| Min. Duct Dimensions | 140 x 140 mm | 5.5" x 5.5" | 100 x 100 mm | 4" x 4" |
| Speed approx. | 15 m/min | 49 ft/min | 15 m/min | 49 ft/min |
| Support Height up to | 700 mm | 27.5" | 700 mm | 27.5" |
| Number of Support Arms | 2 x 3 | 2 x 3 | 2 x 3 | 2 x 3 |
| Working Height | 800 mm | 31.5" | 800 mm | 31.5" |
| Machine Length | 5350 mm | 210" | 5350 mm | 210" |
| Machine Width incl. Arms | 1000 mm | 39" | 1000 mm | 39" |
| Drive Power max. | 3.0 kW | 4.1 hp | 3.0 kW | 4.1 hp |
| Weight approx. | 700 kg | 1550 lbs | 700 kg | 1550 lbs |
| Sealing Compound Injector | | | | |
| Air Pressure approx. | 4 bar | 58 PSI | 4 bar | 58 PSI |
| Required Sealing Compound | 3.5 g/m | 0.025 lbs/ft | 3.5 g/m | 0.025 lbs/ft |
| Tank Volume | 12 Liter | 3.17 Gallons | 12 Liter | 3.17 Gallons |

RAS Reinhardt Maschinenbau GmbH
 Richard-Wagner-Str. 4–10
 71065 Sindelfingen · Germany
 Tel. +49-7031-863-0
 Fax +49-7031-863-185

www.RAS-online.de
Info@RAS-online.de

Modifications reserved. Pictures may show options.