

**RAS 22.07 / RAS 22.09**



- **Cutting**
- **Bending**
- **Forming**

## RAS 22.07 / RAS 22.09



### Professional Quality Seaming

The RAS 22.07 SpeedySeamer with seven rollforming stations is a multi-functional and cost-efficient machine for various uses in the HVAC ducting industry. The top of the line RAS 22.09 SpeedySeamer is a 9-station high quality seam forming system.

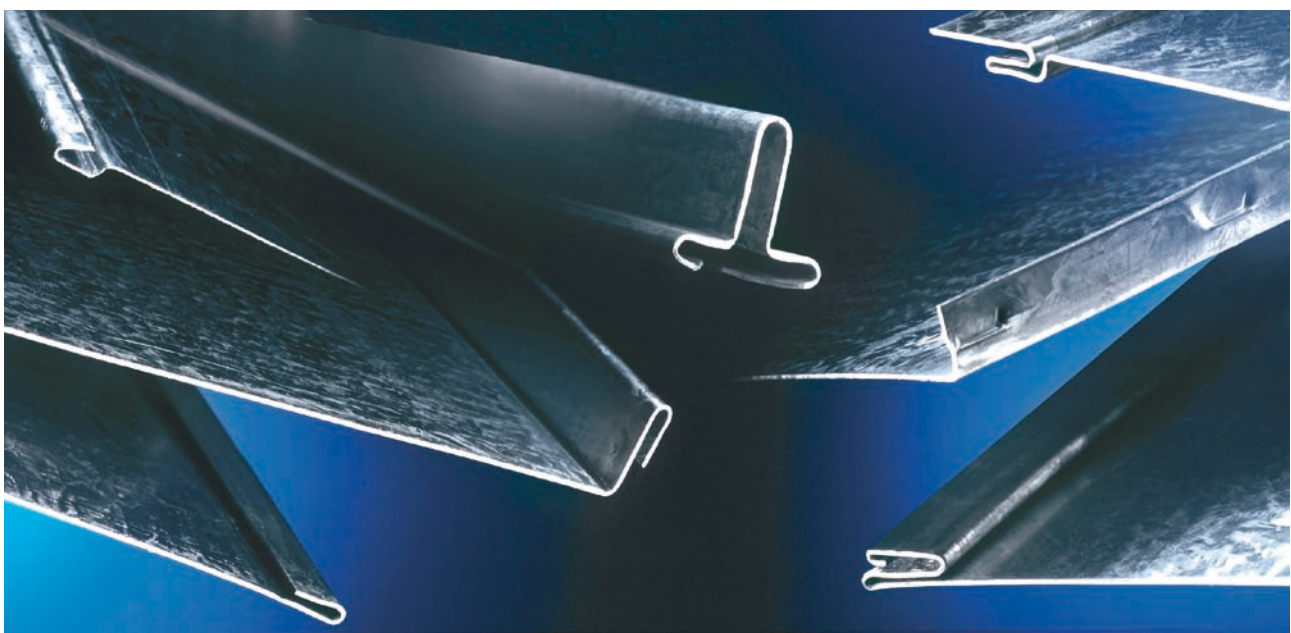
Each of these machines can have two sets of rolls installed at a time. This allows having a set of Pittsburgh Rolls on one side and a set of Standing Seam Rolls on the other side. The same could be done with a set of Snap Lock Rolls on one side and Cam Standing Rolls on the other. The rolls are made from the highest quality case-hardened special

steel. For additional safety the sheet support tables can be adjusted to the different run heights of the right and left roller set.

Roller shafts, housed in axial and radial roller bearings, provide high-quality profiles. A wide gear box supports the roller shafts in the best possible way. The high-quality gear-driven motor ensures smooth and quiet operation. It delivers the drive power directly to rolls without transfer gears or belt drives.

The usually plasma-cut material edges do not contact the sheet supports at the entrance,

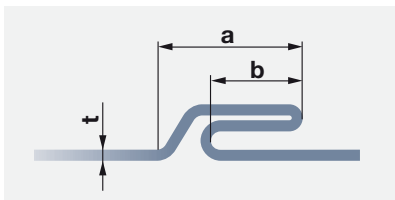
so scored run-in sheet support tables are a thing of the past. In addition, the hardened entrance guiding system is extremely wear resistant. Blanks strengthened with Z-seams can be processed easily, due to the material guiding system that uses hold down pins in the squaring arm. The standard configuration includes an adjustable leveling unit that allows you to straighten seamed blanks or pre-round them for radius cheeks.



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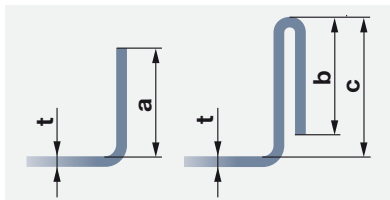
### Seaming without Limits

#### Pittsburgh Seam

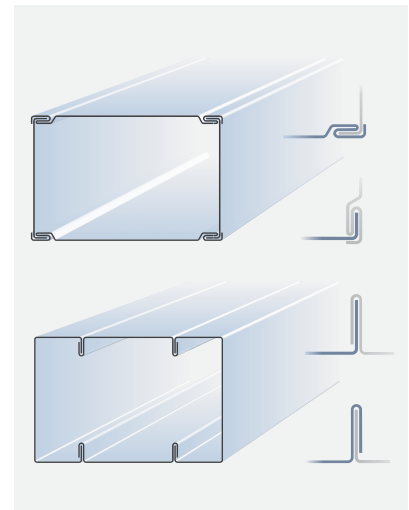


Material	t	a	b	Side
Steel	0.5 - 1.0	14.0	9.5	◄ ○
Steel	0.5 - 1.0	14.0	9.5	► ○
Steel	1.0 - 1.5	17.0	12.5	◄ ○
Steel	1.0 - 1.5	17.0	12.5	► ○
Stainless	0.7 - 1.0	14.0	9.5	◄ △
Stainless	0.7 - 1.0	14.0	9.5	► △
Stainless	1.0 - 1.25	17.0	12.5	◄ △
Stainless	1.0 - 1.25	17.0	12.5	► △

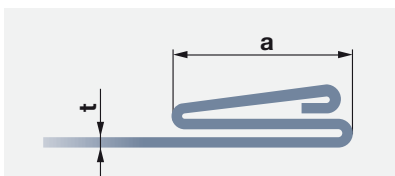
#### Standing Seam / Double Standing Seam



Material	t	a	b	c	Side
Steel	0.5 - 1.5	9.0	16.5	19.0	◄ ○
Steel	0.5 - 1.5	9.0	16.5	19.0	► ○
Stainless	0.5 - 1.0	9.0	16.5	19.0	◄ △

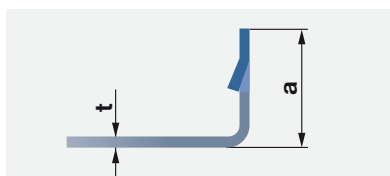


#### Snap Lock Seam

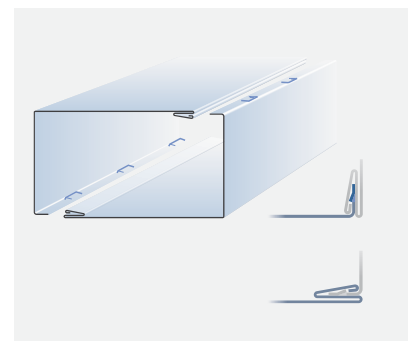


Material	t	a	Side
Steel	0.63 - 1.0	16.0	◄ △
Steel	1.25	17.0	◄ △
Stainless	0.63 - 0.8	16.0	◄ △

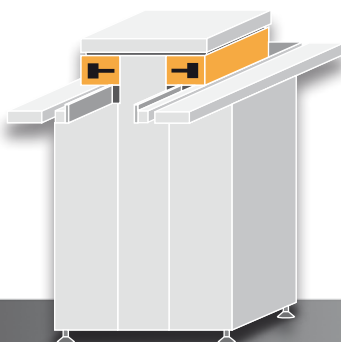
#### Cam Standing Seam



Material	t	a	Side
Steel	0.63 - 1.0	11.5	◄ △
Steel	1.25	11.5	◄ △
Stainless	0.63 - 0.8	11.5	◄ △



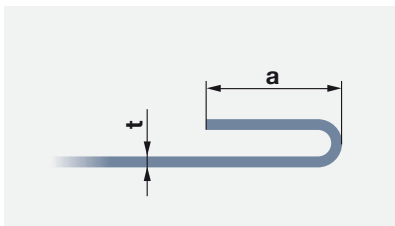
- ◄ Rolls on right machine side
- Rolls on left machine side
- RAS 22.07 and RAS 22.09
- △ RAS 22.09



Pittsburgh Seam rolls with seam opener

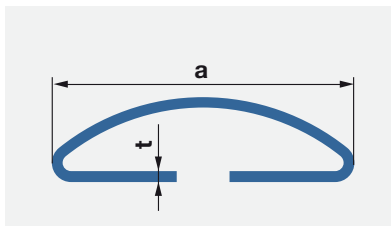
## RAS 22.07 / RAS 22.09

### Open Hem Seam

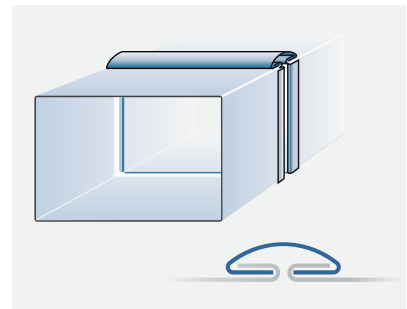


Material	t	a	Side
Steel	0.5 - 1.5	13.0	→ ○

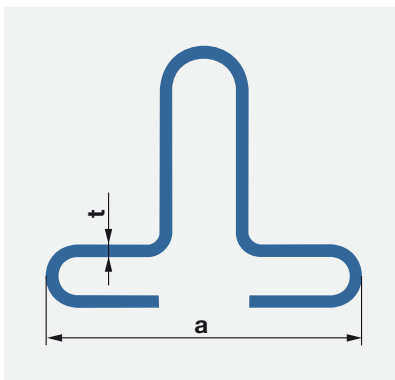
### Drive Cleat



Material	t	a	Side
Steel	0.5 - 1.5	29.0	→ ○



### Suspension Drive Cleat

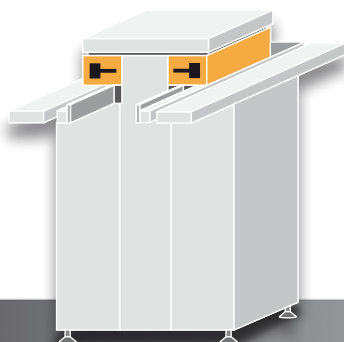


Material	t	a	Side
Steel	1.0	29.0	→ Δ

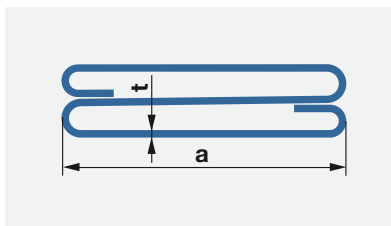


Duct connection with Suspension Drive Cleat and S-Cleat

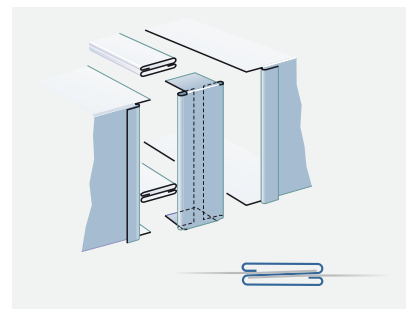
- Rolls on right machine side
- ← Rolls on left machine side
- RAS 22.07 and RAS 22.09
- Δ RAS 22.09



### S-Cleat



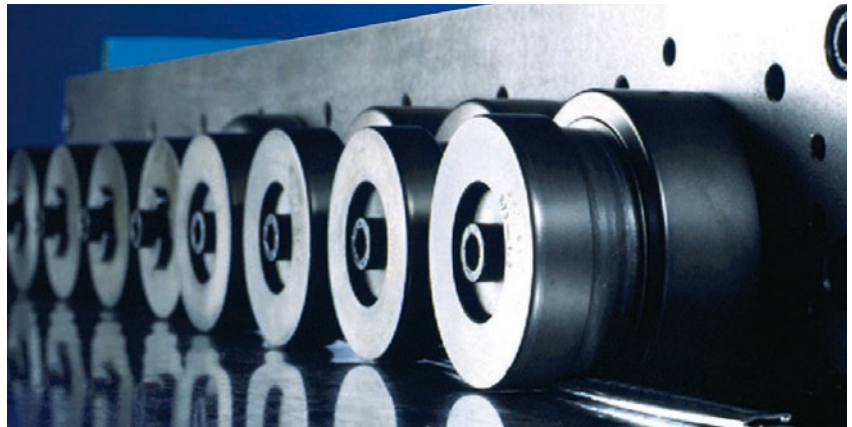
Material	t	a	Side
Steel	0.63	22.0	→ Δ



## RAS 22.07 / RAS 22.09

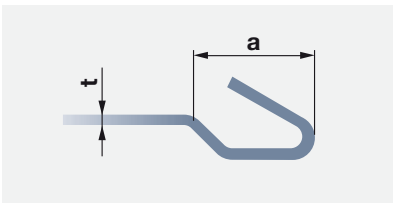


Snap Lock Joint

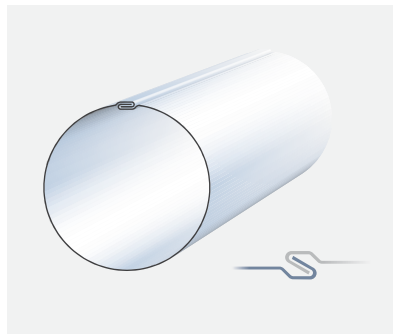


Snap Lock rolls

### Longitudinal Seam

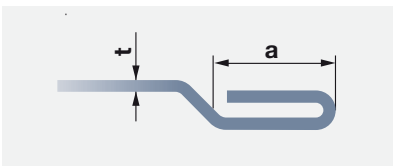


Material	t	a	Side
Steel	0.5 - 1.5	12.5	◄ ◯
Stainless	0.5 - 1.0	12.5	◄ Δ

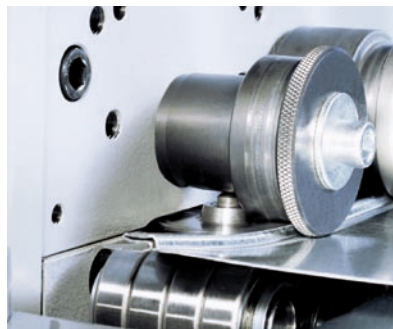


Longitudinal Seam Joint

### Closed Longitudinal Seam

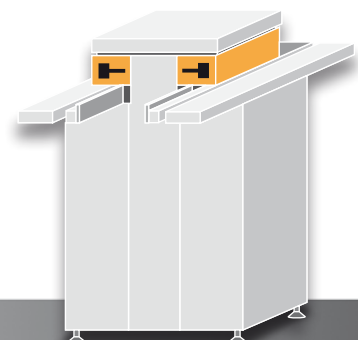


Material	t	a	Side
Steel	0.5 - 1.0	11.0	◄ ◯
Steel	1.0 - 1.5	14.9	◄ ◯
Stainless	0.5 - 1.0	14.9	◄ Δ



Straightening or pre-rounding unit

- ◄ Rolls on right machine side
- ◄◄ Rolls on left machine side
- ◯ RAS 22.07 and RAS 22.09
- Δ RAS 22.09



## RAS 22.07 / RAS 22.09



Technical Data	RAS 22.07		RAS 20.09	
Rollforming stations	7	7	9	9
Profile height max.	20 mm	0,787"	20 mm	0.787"
Material thickness max.	1.5 mm	16 ga	1.5 mm	16 ga
Speed about.*	16 m/min	52.5 ft/min	16 m/	52.5 ft/
Power	3 kW	4.1 hp	3 kW	4.1 hp
Machine length	2010 mm	79.1"	2210	87.0"
Machine width	640 mm	25.2"	640 mm	25.2"
Machine height	1025 mm	40.4"	1025	40.4"
Working height	845 mm	33.3"	845 mm	33.3"
Weight net	350 kg	770 lbs	430 kg	950 lbs

\* based on 72 mm (2.835") driving roll diameter



The wear resistant and hardened material guiding system has hold down pins which is ideal for blanks stiffened with Z-seams.



Sheet support table height and the top covers can be adjusted for each set of rolls. A set of scales simplifies the adjustment.



Small parts material guiding system.

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