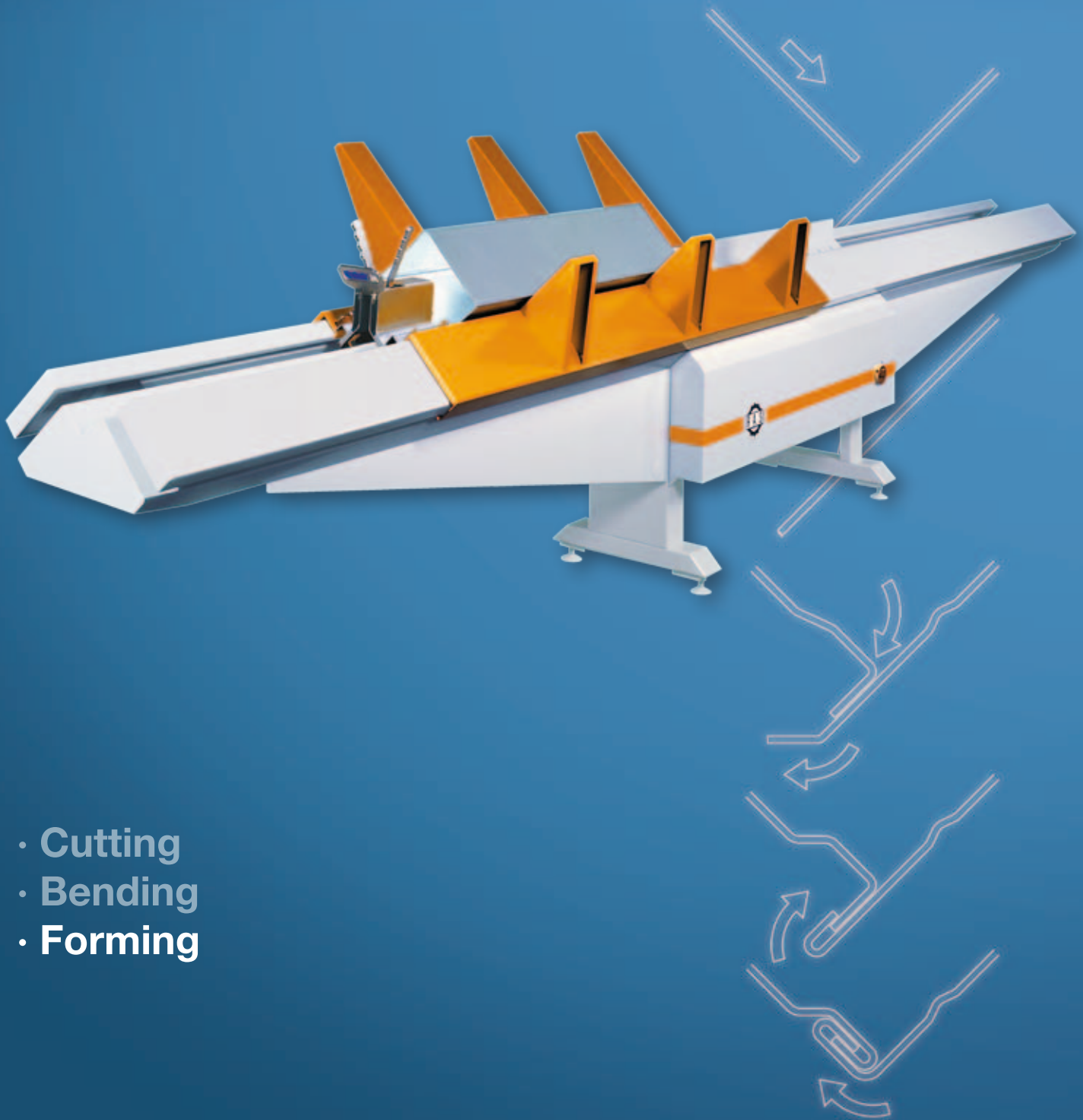


DuctZipper



- Cutting
- Bending
- Forming

DuctZipper

DuctZipper: From 3 to 1!

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.



Easy slide-back of semifinished ducts to the entry point

The innovative material handling system

It's so simple: Insert material, run through ... that's it. The material handling gives the best access to the operator when inserting the sheet and supports the duct while the machine forms and closes the seam. This extremely

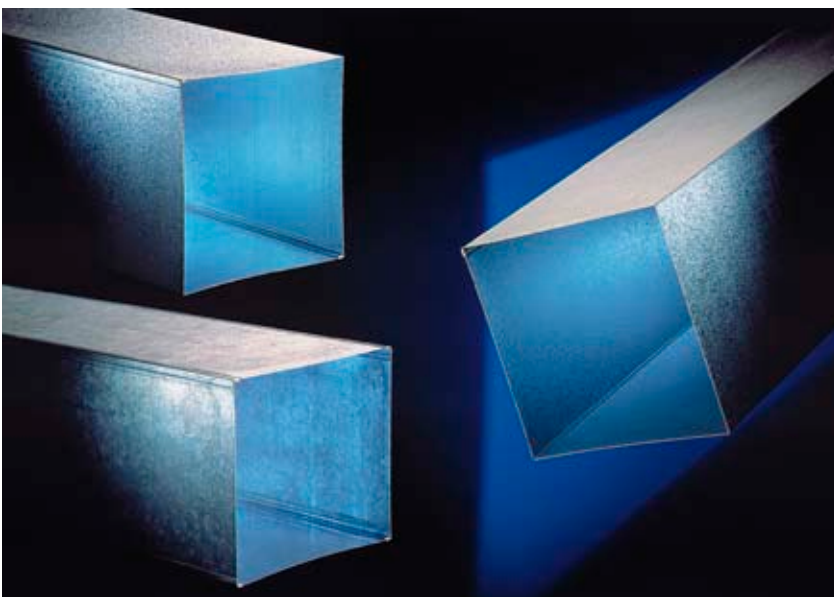
productive "in-line design" moves through the machine along with the duct work. Where previously two operators were required to produce a duct, a single operator is able to complete the work.

Innovative. Effortless. Economical.

The unique AutoPilot

The AutoPilot is the answer to automation of the duct seaming process with minimal operator involvement. Combined with the support arms of the material guidance system, the AutoPilot moves with the material in a tandem effort through the machine. To complete a duct with multiple seams, the operator simply puts the semifinished duct cross-wise onto the material guidance system and slides it back to the entry point. On ducts longer than two meter (6.5 ft) the AutoPilot automatically detaches from the material handling system.

Unique. Clever. Versatile.



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



Safe two point sheet clamping

DuctZipper

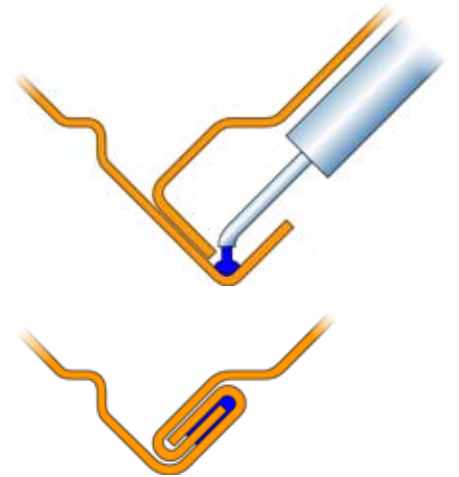
Durable technology

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 optional SealJet for highest tightness requirements



The Duct Seam is much tighter than other common seams such as Pittsburgh or SnapLock



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

SealJet

A vital factor in the air duct industry is the tightness and energy efficiency of the air duct. The RAS SealJet allows an easy, fast, efficient and clean seam joint sealing using the Mez-Bluemastic gel sealant. After the RAS DuctZipper has formed the seam, the SealJet injects an exact amount of the blue sealing gel in the base of the seam. Right after the injection, the DuctZipper forming rolls close the seam. Mez Bluemastic gel precisely seals the joint, preventing the sealing material from being squeezed out of the joint while closing the seam. After the process is completed, the sealant gel is not visible and both the air duct and the machine remain clean and messfree.

Efficient. Clean. Tight.



The DuctZipper RAS 20.10 seaming bar

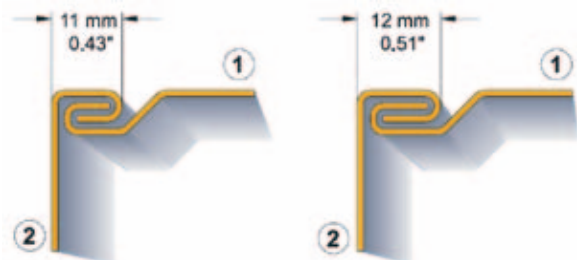


The reinforced DuctZipper RAS 20.12 seaming bar

DuctZipper



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
SealJet				
Air pressure approx.	5 - 6 bar	72 – 87 psi	5 - 6 bar	72 – 87 psi
Required sealant quantity approx.	1.4 g/m	0.001 lbs/ft	1.4 g/m	0.001 lbs/ft
Tank volume	25 kg	55 lbs	25 kg	55 lbs
Seaming allowance: (see graphic)				
Side ①	about 8 mm	about 0.315"	about 8 mm	about 0.315"
Side ②	about 18 mm	about 0.71"	about 18 mm	about 0.71"



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