

STANDARD

SHEET METAL MACHINERY



PRODUCT CATALOG



Standard Sheet Metal Machinery, Inc., is incorporated in Lisbon, Iowa USA. The company specializes in sales and service of machinery for production of Spiral Round and Rectangular duct. We have over 40 years' experience selling duct machinery.

The Enterprise 500 Plasma cutting machines and cleaner beader machines are designed and built by Standard Sheet Metal Machinery in Lisbon, Iowa USA.

Standard sells Duct Making Machinery from **JinWoong Technology (JWT) Seoul Korea** worldwide and is the exclusive distributor for JWT machinery in North and South America.

JWT stated company mission is **to be the provider of the latest in duct making technology.**



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AIRZONE Installation - Spiral Mfg Minnesota

ENTERPRISE



ENTERPRISE KEY FEATURES

- Digital servo dual side driven cutting bridge
- Lightweight aluminum bridge construction
- Energy saving air zone table
- 5 damper controlled cutting table exhaust zones
- Lift out slag pans for easy table cleaning
- Cleaner cut parts
- Compact machine footprint
- Remove parts while cutting
- Table configured for side or end loading of sheets
- Drive and guide rails are protected beneath the table
- Precision near zero backlash sealed gearbox drive speed reduction
- Machine control trouble shooting via the internet
- All wiring is internal for protection
- Cutting torch can be removed without tools
- Air float cutting torch balance system with tip-up protection
- Cut partial sheets without covering entire table

E 500 MKIV



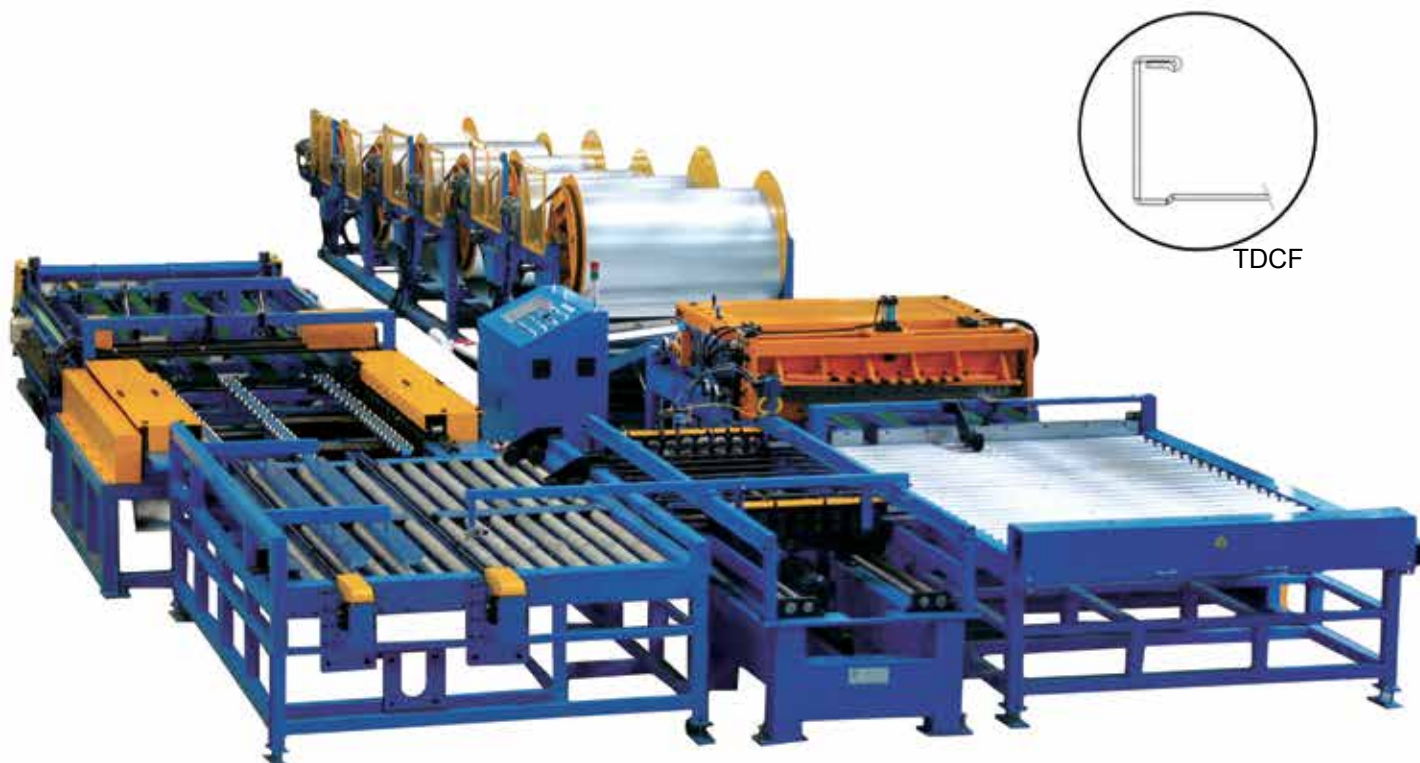
5' x 20' / 6.0M Dual table machine



5' x 10' / 1.5M x 3.0M Table

TDCF Full Duct Line U Type

TDCF full duct line (U Type) is designed to manufacture rectangular duct with TDCF, Slip and Drive, and machine closed Pittsburgh Seam. The PLC will accept production downloads from many Cad/Cam programs.



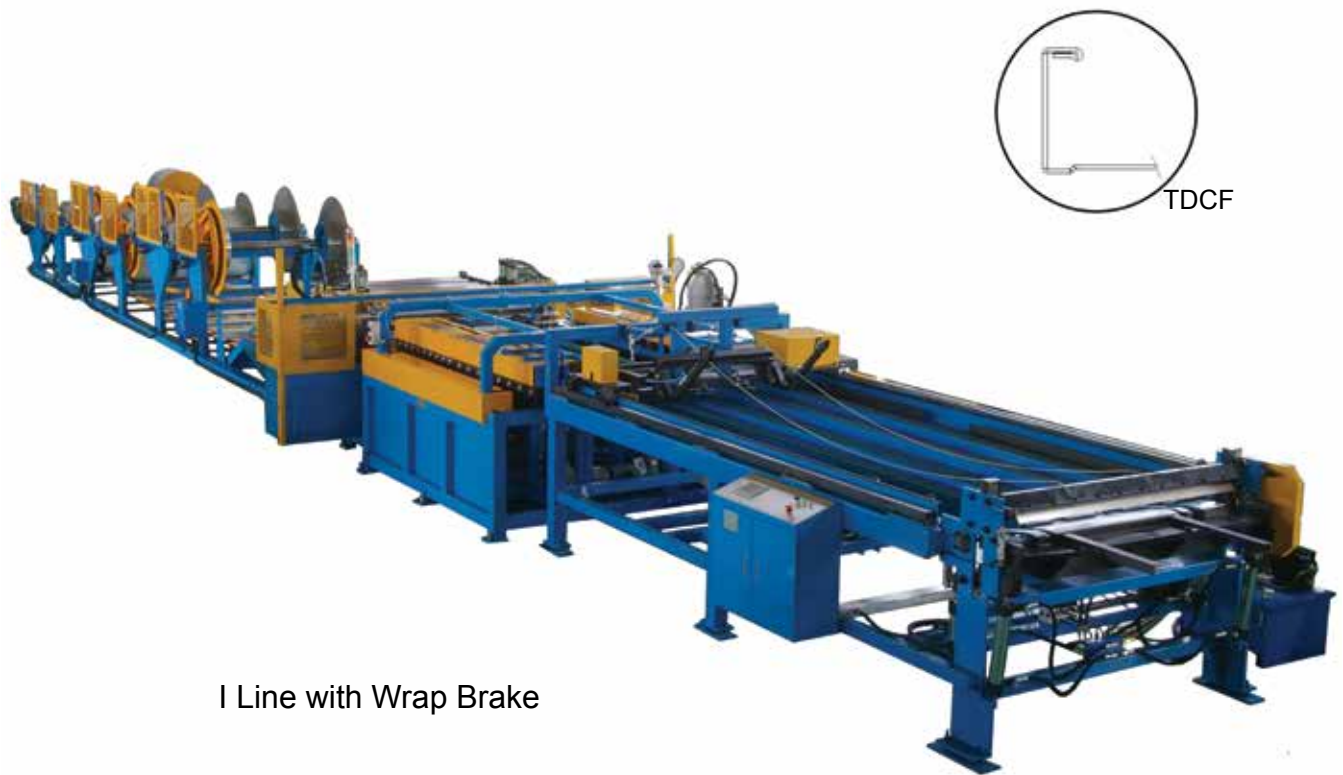
U Line with Wrap Brake

Specification

•Uncoiler	4 Station (or other option) /Max. 5 Tons	•Bead	“V” Bead or “Z” Bead, “Cross Bead”
•Coil Width	48”/60”/80” (or other option)	•Seam Type	Pittsburgh (Snap Lock) Seam
•Thickness	Maximum 18 ga. / 1.2mm (Galv. mild Steel)	•Notch Type	TDCF, S&D, End Cap, PDF
•Minimum Duct Size	6” x 6” / 150mm x 150mm	•Flange Type	TDCF, S&D, PDF
•Speed	Maximum 40 F.P.M. / 11M/min	•Option	Seam Closing Unit Sealant Injection System

TDCF Full Duct Line I Type

TDCF full duct line (U Type) is designed to manufacture rectangular duct with TDCF, Slip and Drive, and machine closed Pittsburgh Seam. The PLC will accept production downloads from many Cad/Cam programs.



I Line with Wrap Brake

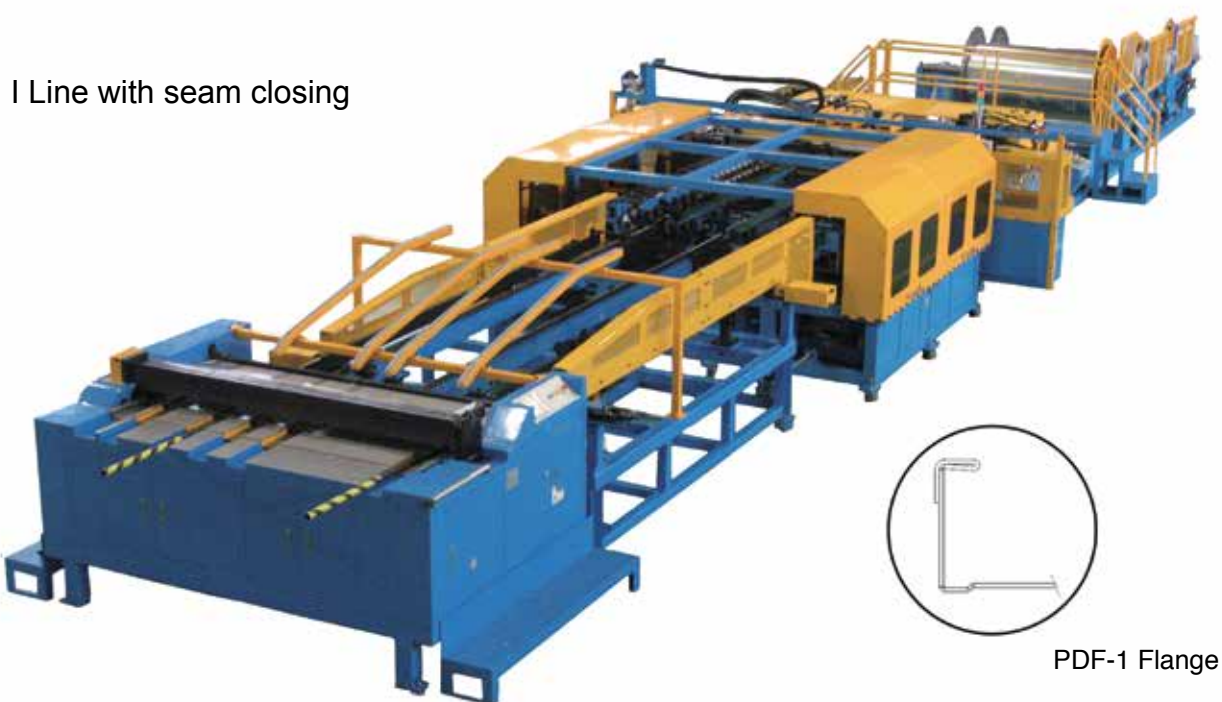
Specification

• Uncoiler	4 Station (or other option) /Max. 5 Tons	• Bead	"V" Bead or "Z" Bead, "Cross Bead"
• Coil Width	48"/60"/80" (or other option)	• Seam Type	Pittsburgh (Snap Lock) Seam
• Thickness	Maximum 1.2mm (Galv. mild Steel)	• Notch Type	TDCF, S&D, End Cap, PDF
• Minimum Duct Size	6" x 6" / 150mm x 150mm	• Flange Type	TDCF, S&D, PDF
• Speed	Maximum 40 F.P.M. / 11M/min	• Option	Seam Closing Unit Sealant Injection System

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PDF 1 Super Full Duct Line

TDCF full duct line (U Type) is designed to manufacture rectangular duct with TDCF, Slip and Drive, and machine closed Pittsburgh Seam. The PLC will accept production downloads from many Cad/Cam programs. The stronger PDF1 superflange profile is available on this line.

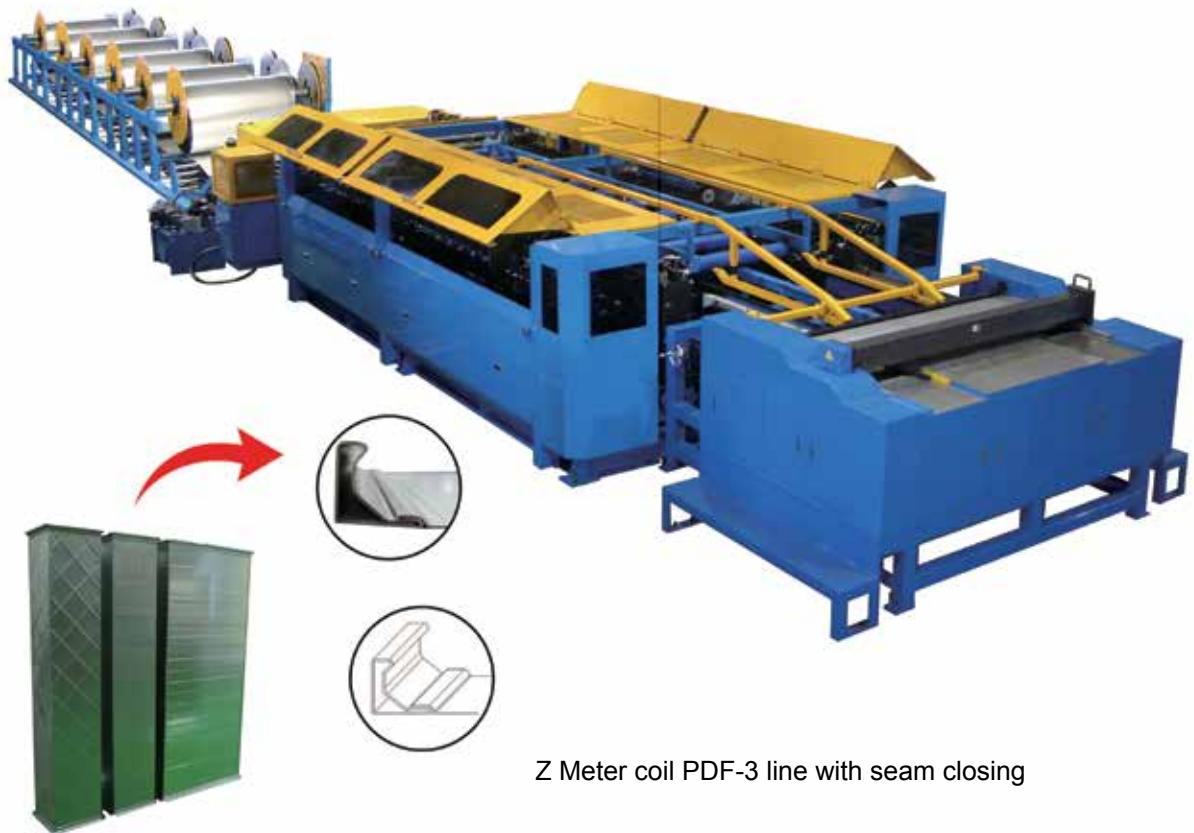


Specification

•Uncoiler	4 Station (or other option) /Max. 5 Tons	•Bead	"V" Bead or "Z" Bead, "Cross Bead"
•Coil Width	48"/60"/80" (or other option)	•Seam Type	Pittsburgh (Snap Lock) Seam
•Thickness	Maximum 1.2mm (Galv. mild steel)	•Notch Type	PDF 1 Super
•Minimum Duct Size	6" x 6" / 150mm x 150mm	•Flange Type	PDF 1 Super 20mm / 30mm
•Speed	Maximum 40 F.P.M. / 11M/min	•Option	Seam Closing Unit Sealant Injection System

PDF 3 Full Duct Line [Patented]

PDF 3 Full Duct Line produces rectangular duct with PDF 3 flange. This is the strongest integral duct flange connection available in the industry. This line produces finished ducts with closed seam in under 2 minutes per piece. TDCF flange is also available.



Z Meter coil PDF-3 line with seam closing

Specification

•Uncoiler	4 Station (or other option) /Max. 5 Tons	•Bead	"V" Bead or "Z" Bead, "Cross Bead"
•Coil Width	48"/60"/80"	•Seam Type	Pittsburgh (Snap Lock) Seam
•Thickness	Maximum 18 ga. / 1.2mm (Galv. mild steel)	•Notch Type	TDCF, S & D, End Cap, PDF
•Minimum Duct Size	6" x 6" / 150mm x 150mm	•Flange Type	TDCF, S & D, PDF
•Speed	Maximum 40 F.P.M. / 11M/min	•Option	Seam Closing Unit Sealant Injection System

STANDARD SHEET METAL MACHINERY

Square 1

Square-1 economy duct line produces blanks, L (2 piece) or wrap ducts for uses with companion angle flange or slip on profiles like Ductmate flange.



- | | |
|--------------------|---|
| •Uncoiler | 4 Station (or other option) /Max. 5 Tons |
| •Coil Width | 48"/60" (or other options) |
| •Thickness | Maximum 18 ga. / 1.2mm (Galv. mild steel) |
| •Minimum Duct Size | 150mm x 150mm |
| •Speed | Maximum 11M/min /40 F.P.M. |
| •Bead | "V" Bead, "Z" Bead |

Square 2

The starter portion of full line U Type. Square-2 line uncoils, beads, notches and cuts the duct blank to length. An optional shear and bending head are available to form the male Pittsburgh or optional Snap Lock seam. This line is designed for an easy upgrade to a full duct line U type.



- | | | | |
|--------------------|---|-------------|-------------------------|
| •Uncoiler | 4 Station (or other option) /Max. 5 Tons | •Bead | "V" Bead or "Z" Bead |
| •Coil Width | 48"/60"/80" (or other options) | •Notch Type | TDCF, S&D, End Cap, PDF |
| •Thickness | Maximum 18 ga. / 1.2mm (Galv. mild steel) | | |
| •Minimum Duct Size | 6" x 6" / 150mm x 150mm | | |
| •Speed | Maximum 18M/min./60 F.P.M. | | |

STANDARD SHEET METAL MACHINERY

Square 3

The starter portion of Full Line I Type. Square 3 uncoils, beads, notches, forms male and female seam & cuts the blank to length. A crop shear is also included.

Square 3 with Pittsburgh male & female seams



Specification

- Uncoiler 4 Station (or other options)
- Coil Weight 5 Tons
- Thickness Maximum 18 ga. / 1.2mm (Galv. mild steel)
- Minimum Duct Size 6" x 6" / 150mm x 150mm
- Speed Maximum 60 F.P.M. / 18M/min

Roll Forming Machines

Roll formers for TDC clip, slip & drive, damper vanes, hanger channel & your special profile.



PDF 1, PDF 1
Super



TDC/F Roll former
Standing S slip,
hanger channel,
standing seam



TDC Clip Line from coil



Slip & Drive Roll form line



7:11 Roll former
Inside tee, outside tee, standing seam



Snap lock flanger

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Spiral Elbow Line [Patented]

The JWT Spiral Elbow Line produces Spiral Elbow from material in coil. These elbow are produced automatically with production cycle times as low as 18 seconds per piece. The entire width of the coil is used so there is no material waste.

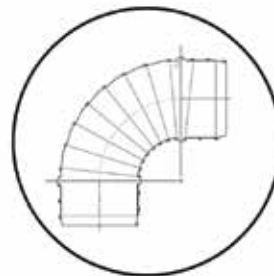
The JWT Spiral Elbow Line is available in three models. The SEL-300, SEL-450 and SEL-600. Elbow centerline radius can be changed from 1 to 1.5 times elbow diameter. Change of Spiral Elbow Angle (30°, 45°, 60°, 90°) is made by keyboard entry at the machine's PLC.



Model	SEL-300	SEL-450	SEL-600
Min. Elbow Diameter	4" / 100mm	4" / 100mm	8" / 200mm
Max. Elbow Diameter	12" / 315mm	18" / 450mm	26" / 600mm
Elbow Center Radius	1-1.5 x Diameter	1-1.5 x Diameter	1-1.5 x Diameter
Material Thickness (Galv. mild steel)	.020" - .026" / 0.4 - 0.5mm	.020" - .026" / .4 - 0.5mm	0.5 - 0.6mm / .009" - .023"
Power Requirement	30KVA	30KVA	30KVA
Floor Area Requirement	33' x 8' x 8' / 10M x 2.3M x 2.3M	33' x 8' x 8' / 10M x 2.3M x 2.3M	33' x 8' x 8' / 10M x 2.3M x 2.3M
Option (Material)	Stainless Steel	Stainless Steel	Stainless Steel



Spiral Elbow Beading Machine
Forms bead stop and edge bend to
reduce slitting wave



STANDARD SHEET METAL MACHINERY

Wrap Brakes

Machines equipped with notch locators for one man operation.

6 Ft. Wrap Brake

Specification

- Sheet Width 6 Ft. / 1,825mm
- Thickness Maximum 18 ga. / 1.2mm (Galv. mild steel)
- Operation Hydraulic or Pneumatic System
- Flange Type TDCF, PDF, Sheet



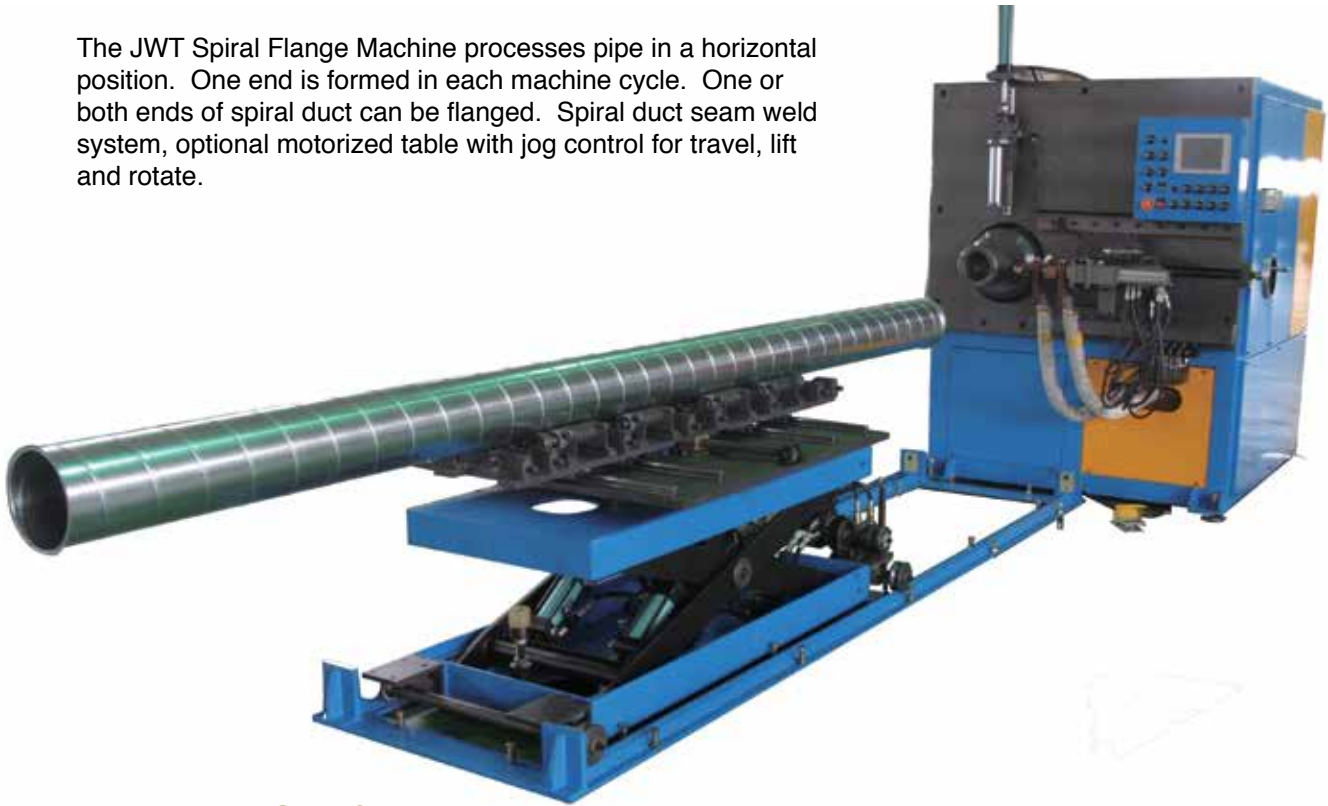
TDC Notcher

Specification

- Tooling component 5 Heads
- System Manual adjustment / positioning
- Thickness Maximum 18 g. / 1.2mm (Galv. Mild Steel)

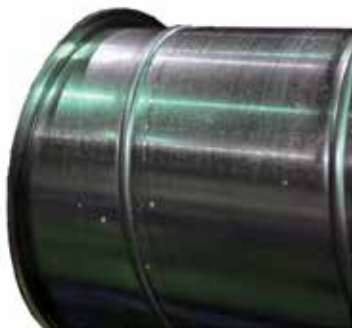
Spiral Duct Flanger Machine

The JWT Spiral Flange Machine processes pipe in a horizontal position. One end is formed in each machine cycle. One or both ends of spiral duct can be flanged. Spiral duct seam weld system, optional motorized table with jog control for travel, lift and rotate.



Specification

• Tube Length	12" - 10 Ft. / 300mm - 6M
• Diameter Range	8" - 48" / 200 - 1,250mm
• Material Thickness	.020" - .59" / 0.5 - 1.6mm (Welded Pipe)
• Spiral Duct Thickness	Maximum 18 ga. / 1.2mm
• Flange Height	10 - 15mm
• Option	Duct seam spot weld system



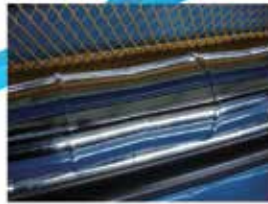
Flanged Spiral Duct



Vanstone Connection

Beading Machines

6 Ft. / 1,820mm, 80" / 2M and 10 Ft. / 3,050mm Models. Cross Beaders, V Bead, Mesa Bead and Z Bead



6 Ft. / 1,825mm capacity Bearer with Japan Style Z Bead



Diamond Bead



Mesa Bead



Z Bead



V Bead



Cleans plasma cutting smoke from parts while beading. Also available as cleaner machine only.

Maximum 18 ga. / 1.2mm
60" / 1,525mm

Corner Machines



Dual Corner Machine



Single Corner Machine

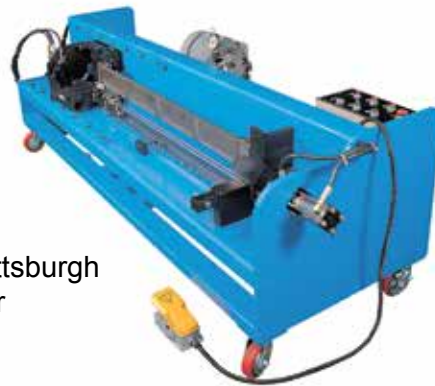
Specification

- Type Dual Type, Single Type
- Duct Height Maximum 5 Feet
- Operation Hydraulic / Pneumatic System
- Flange Type TDCF, PDF 1 Super

Pittsburgh Seam Closer



Verrtical Pittsburgh Seam Closer



Horizontal Pittsburgh Seam Closer

Specification

- Type Vertical, Horizontal
- Duct Height 5 Feet /1525mm 6 Feet /1820mm
- Operation Hydraulic / Pneumatic System
- Thickness Maximum 18 ga. / 1.2mm (Galv. mild steel)

Stitch Welding Machine (SW-1000)



Specification

•Welding Type	Stitch & Continuous Type
•Welding Speed	Maximum 10M/min /33 F.P.M.
•Diameter Range	100 - 1,000mm /4" - 40"
•Length Range	80 - 1,000mm (Option: 1,200mm)
•Material	Galvanized Steel, Stainless Steel, Mild Steel
•Material Thickness	0.2 - 1.0mm (Galvanized Steel) /.020" - .040"
•Seam Overlap	6mm
•Wire Diameter	1.8mm /.074"
•Cooling Type	Water Cooling System
•Transformer	60KVA
•Option	Cooling Unit



Automatic Rounding Machine (RA-600)

De-stacks & rolls



Specification

•Material Width	Maximum 760mm /10"
•Diameter Range	5" - 25" / 120mm - 600mm
•Material Thickness	.012" - .030" / 0.4mm - 1.2mm ((Galv. mild steel)



Spiral Former 2000-S Model

The SF-2000 (S) model has a gear motor drive and uncoiler with drag brake mounted on a common machinery base. Coil entry angle adjustment is motorized. The SF-2000 (S) model includes PLC control. Part length and batch quantity are set at the PLC control. The SF-2000 (S) includes hydraulic forming head clamping for fast diameter change.



Spiral Former 1250

The SF-1250 is our most popular model spiral tube former. This machine uses the same heavy duty cast forming heads as our larger capacity machine. The slitter cutoff system produces clean end cuts.



Model	SF-1250	SF-2000 (S)
Diameter Range	4" x 48" / 100 - 1,250mm	3" - 80" / 75 - 2,000mm
Galvanized Steel	.020" - .040" / 0.5 - 1.0mm	.020" - .047" / 0.5 - 1.2mm
Stainless Steel	.020" - .023" / 0.5 - 0.6mm	.020" - .037" / 0.5 - 0.8mm
Material Width	5.39" / 137mm	137mm(Material Thickness .020" - .040" / 0.5 - 1.0mm) 140mm (Material Thickness .047" / 1.2mm)
Uncoiler	Integrated vertical single type	Integrated vertical single type
Speed	Maximum 135 F.P.M. / 40M	Maximum 80M /min/270 F.P.M.
Material	Galvanized Steel, Stainless Steel, Mild Steel	Galvanized Steel, Stainless Steel, Mild Steel

STANDARD SHEET METAL MACHINERY

Elbow Gore Seaming Machine

EM-1000 and EM-1250 are designed to form and close the gore seams on elbows and other round fittings.



EM-1000



EM-1250



Combi



The Combi dual head version of our Hydraulic machine is designed to form and close the gore seams on elbows and other round fittings. It keeps setup times to the absolute minimum.

	EM-1000	EM-1250	Combi
Diameter Range	8" - 40" / 200 - 1,000mm	8" - 48" / 200 - 1,250mm	8" - 48" / 200 - 1,250mm
Gore Range	Maximum 30"	Maximum 30"	Maximum 30"
Thickness (Galvanized Steel)	.013" - .040" / 0.4 - 1.0mm	.012" - .047" / 0.4 - 1.25mm	.012" - .047" / 0.4 - 1.25mm
Roll Speed	Maximum 135 F.P.M. / 40M/min	Maximum 135 F.P.M. / 40M/min	Flange Max. 65M/min Seam Closing Max. 45M/min /220.F.P.M.
Head	Single	Single	Double

Pipe Flange Machine



Specification

•Diameter Range	500 - 2,000mm /20" - 80" (We also do specials)
•Maximum Flange Height	80mm /13"
•Maximum Material Thickness	0.4mm - 1.2mm (Galvanized Steel) /.012" - .047" 0.4mm - 0.8mm (Stainless Steel) /.012" - .030"
•Punch Size	Maximum 28mm /1 1/8"
•Option	Bell Mouth Program



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Flexible Tube Machine (MIC) [Patented]

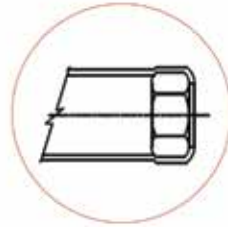


Specification

•Diameter Range	100 - 300mm /4" - 20"
•Coil Width	5mm
•Coil Thickness	0.5mm /.2"
•Coil Diameter	Maximum 800mm /31"
•Fabric Width	50mm /2"
•Fabric Thickness	0.3mm /.012"
•Fabric Diameter	Maximum 700mm /28"
•Uncoiler Type	Vertical
•Feeding Speed	Maximum 70M/min /230 F.P.M.
Cutt-off Type	Manual



Tie Rod Nut Insert Machine



Specification

- | | |
|--------------------|---|
| • Operation System | Hydraulic |
| • Material | Galvanized Steel Pipe, Stainless Steel Pipe |

Lock Forming Tester

The Lock forming machine used by Steel Coil manufacturers for testing material to local forming quality.



Specification

- | | |
|----------------------|--------------------|
| • Material | Galvanized Steel |
| • Material Thickness | |
| • -Double Hem | 0.2 - 1.5mm |
| • -Single Hem | 1.6 - 2mm |
| • Speed | 7M/min / 25 F.P.M. |
| • Forming Shape | Double Hem |
| | Single Hem |



Double Hem



Single Hem

STANDARD SHEET METAL MACHINERY

Brakes & Shears



Jouanel Hydraulic Power Shear
10 Models available



Jouanel Key Brake (Box & Pan)
With quick change form tools



Jouanel CNC Folder
With automatic bend angle control



Roper Whitney Combi Beam
Combination straight brake & pan brake



Roper Whitney 10M 14 Shear
10ft. x 14 ga /3050mm x 1.9MM



JinWoong Technology Seoul, Korea



STANDARD SHEET METAL MACHINERY
1005 N. WASHINGTON STREET
LISBON, IOWA 52253
1-319-408-1111 (GMT -6)
WWW.STANDARDSMM.COM

