



MACHINERY FOR

SHEET METAL DUCT MANUFACTURING

WWW.STANDARDSMM.COM

PRODUCT LINE UP

2015



Standard Sheet Metal Machinery • 1005 N Washington Street Lisbon, Iowa 52253 • 1.319.408.1111

Located in Lisbon, Iowa, Standard Sheet Metal Machinery specializes in machinery for the manufacture of spiral round and rectangular duct and fittings with over 40 years of experience. As a family owned business, we strive to meet the needs of sheet metal contractors throughout the world.

In addition to our own Enterprise Plasma Cutter, we sell machines that are manufactured by Jin Woong Technology Ltd. As VP of international sales with Metcoil Systems Corporation, one of our most successful sales offices was our joint venture Metcoil Limited's Korea sales branch located in Seoul Korea. This office was managed by Mr. Kyu Cha. When the joint venture Metcoil Limited closed in the 1990's Mr. Cha started Jin Woong Technology Ltd. located in Seoul, Korea to continue to offer service and parts to Metcoil's duct machinery customers in Korea. From their start, as a service and sales company for Lockformer Engel, and Iowa Precision machines, they evolved into one of the largest manufacturers of spiral and rectangular duct making machinery in the world. Their company name JIN WOONG means *GO FORWARD WITH CONFIDENCE*. This is evident in the machines they design and produce.

ENTERPRISE 500 MKIV

HVAC plasma cutting machine

with: Energy Saving Air Zone Exhaust System



Designed and built in Lisbon, Iowa, the Enterprise 500 plasma cutter is designed to be a replacement plasma cutting machine as well as new addition to your plasma cutting capability. Designed to run on your existing software, the machine is compatible with all major software packages. Using your existing software can lower your overall investment costs.

Enterprise 500 HVAC plasma machines have significant advantages over competitor's plasma designs. Our cutting bridge / gantry is made of lightweight aluminum. This lighter weight aluminum construction allows faster acceleration and deceleration in the corners and higher operating speeds. The cutting bridge is SERVO Motor driven on both ends to eliminate bridge whip. Whip is evident with the heavier steel bridges / single side driven machines when they change direction at similar speeds.

Our SERVO drive controller is digital for the fastest and most precise speed control available. Motor speed reduction is done thru zero maintenance precision gear boxes. The drive control is conversational and allows our engineers to connect and diagnose the machine via the Enterprise touch screen computer control. This remote diagnostic capability can reduce the need for expensive service engineer travel to make repairs or adjustments.

The Enterprise Plasma AIR ZONE* cutting table has five separate cutting zones, each with an exhaust port instead of a single hole exhaust for the center of the table as provided by other makers. Each of our five table cutting zones include computer controlled air intake and exhaust dampers. These dampers direct the exhaust air flow only to the zone directly beneath the cutting torch. Enterprise improved exhaust performance substantially reduces the cutting smoke residue on the bottom of the part when compared to other plasma table designs. The result is cleaner cut parts.

Our AIR ZONE table includes a connection point for outside air intake ducting. This allows you to duct unheated outside air to the table to supply the cutting table exhaust. It is easy to calculate the energy savings of our AIRZONE table design. Divide the cubic feet area of your shop by the cubic feet per minute capacity of the exhaust fan you use. The result is the number of times per hour the heated air in your shop must be replaced while cutting with a conventional plasma table.

The AIR ZONE table gives you several other important advantages. Our plasma table allows you to cut partial sheets without covering the entire table. Our AIRZONE table design also allows you to remove finished parts while cutting.

Single exhaust table designs require you cover the entire table to maintain exhaust suction and you must wait until the entire sheet is cut before removing parts. If you remove parts while cutting you will lose exhaust suction.

Our recommended machine package includes a 100% duty cycle plasma unit from HYPER THERM. Other plasma makers offer machines with power units rated 50% duty cycle or lower. These smaller plasma units will not perform continuous production cutting. If you are willing to accept a plasma source with these limitations we can offer a lesser unit at a reduced price.

RECTANGULAR DUCT PRODUCTION

Starter Duct lines - Square 1, Square 2 and Square 3 models



Square 1

Our most basic duct line includes uncoiling, beading, folding and cut to length. Notching can be added as an option.

Square 2



Square 2 is the first half of a Full Duct Line U or Z floor plan. This machine has motorized uncoilers, beading, notching and shear. Tie rod hole punching is available as an option. This line can be upgraded to a full duct line in the future.



Features common to all JWT starter coil lines

Download capable PLC control

Hydraulic drive notching and cutoff

Heavy Duty construction with durable powder coat finish

Upgrade capable

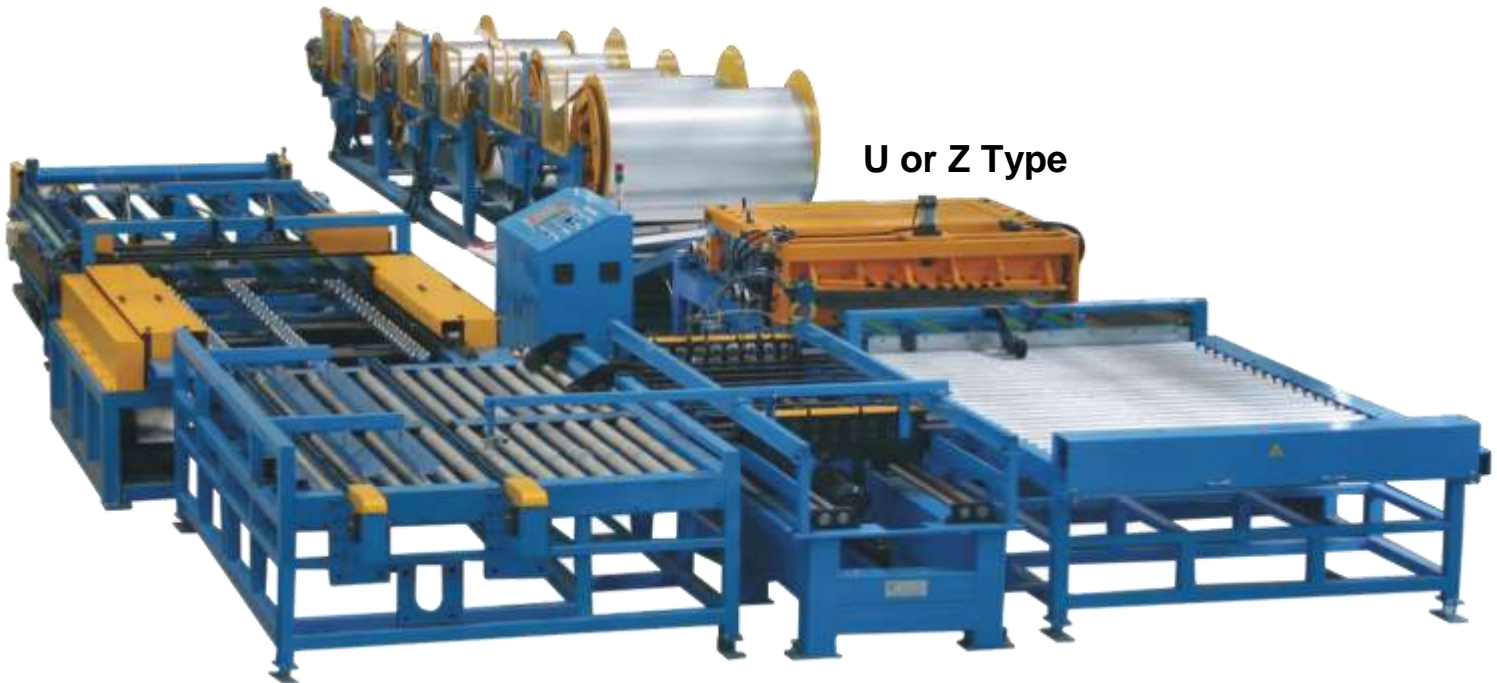
Square 3

Square 3 is the starter portion of a Full Duct Line I type. It adds the forming of the male and female Pittsburgh seams to the duct blank. This machine has motorized uncoilers, beading, notching, male and female Pittsburgh seam forming and cut to length.. Tie rod hole punching is available as an option.



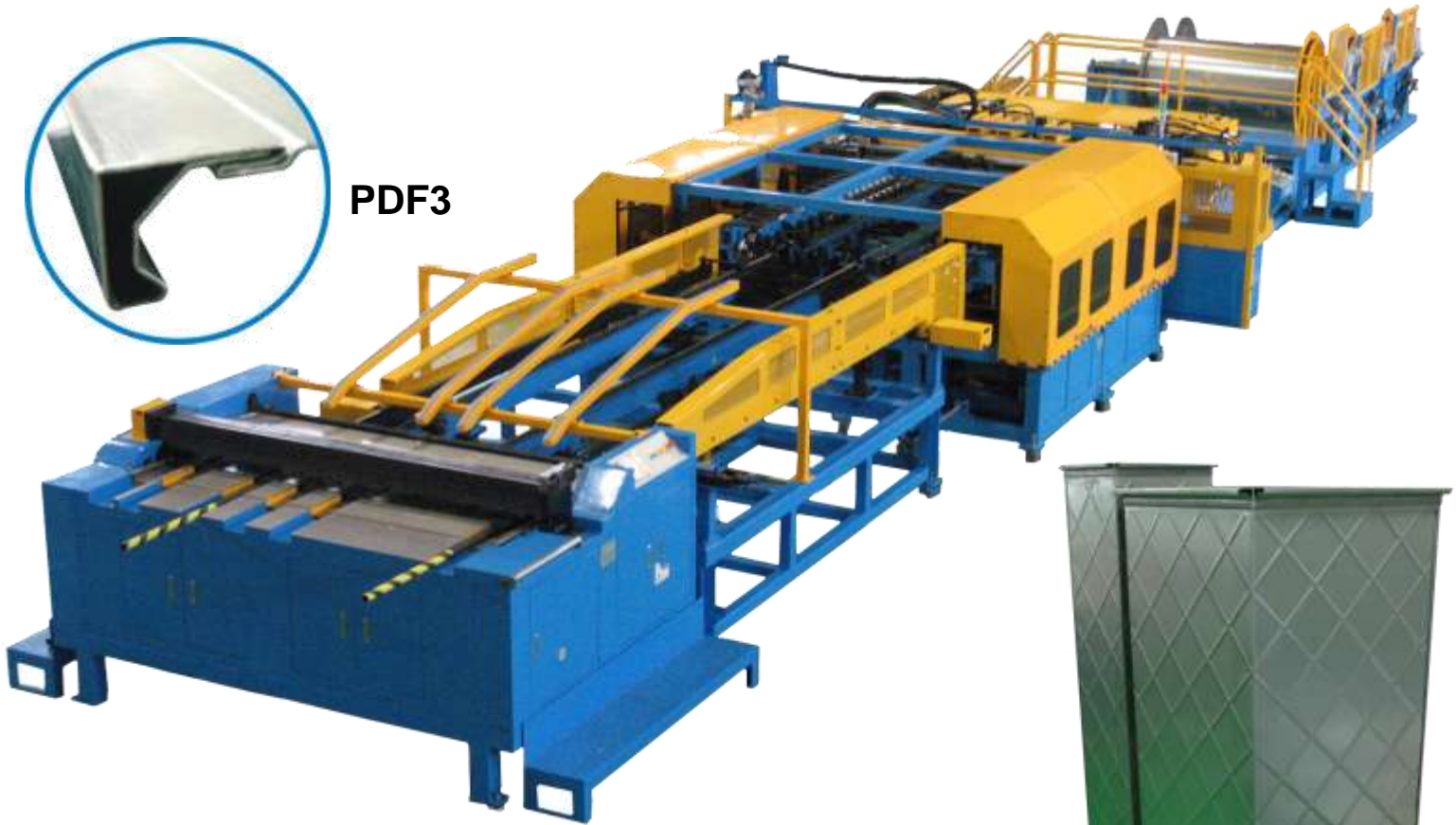


FULL DUCT LINE



- U or Z line configuration
- 5 ton coils - 8 ton coil optional
- Models for 60" / 1,525mm - 72" and 2,000 mm coil widths
- Maximum blank length 120" / 3,050mm
- Pittsburgh seam standard - Snap lock seam (option)
- Tie rod hole punching (option)
- TDCF flange standard - slip and drive connection (option)
- Automatic line setup (option)
- Insulation, glue and *GRIPNAIL* pin spotter

I Type - now available with inline duct seam closing



I Line configuration - straight line

- Diamond beading / embossing available
- Larger one piece wrap ducts - to 5 meter /16 feet
- TDCF - slip and drive - and PDF3 flange connections available
- Auto Folder seam closer - finished ducts on line

TDCF Roll formers - Notchers - Corner insertion machines



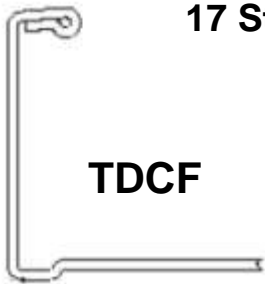
17 Station TDCF roll

Optional profiles

Support channel



Standing S slip



TDCF

Your special profile - call



Notcher for
TDCF and Slip and Drive

TDCF Corner machine dual head

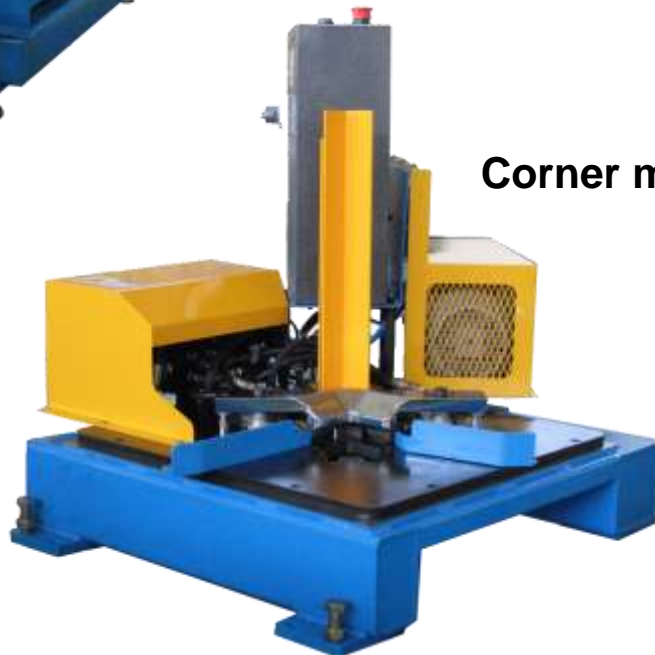


Hydraulic / pneumatic operation

Corner magazines load from floor level

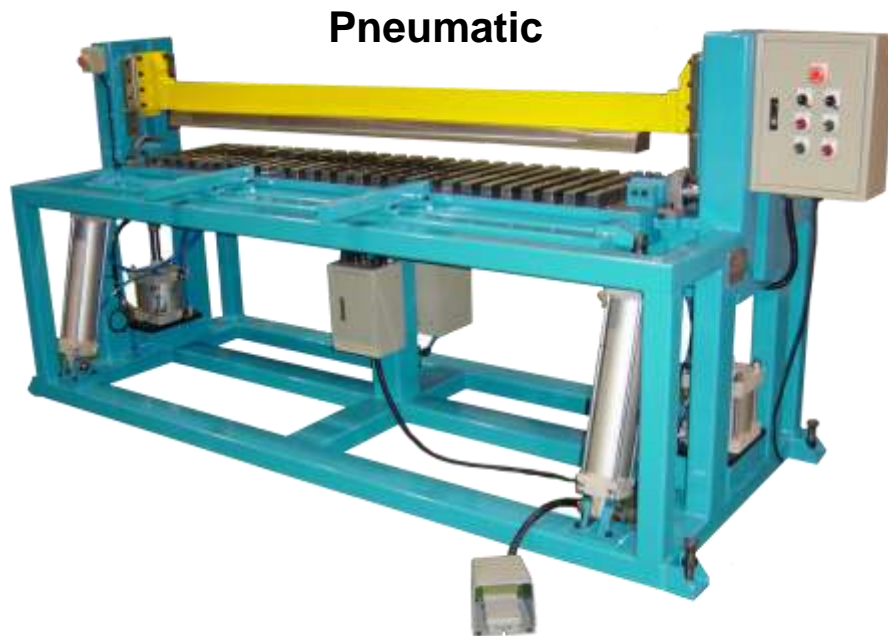
Special corners not required

Secure and good looking crimp



Corner machine single head

TDCF Wrap Brakes - with notch locator for one man operation



Pneumatic / Hydraulic Models

Maximum 72" / 1830mm

Maximum thickness 18ga. / 1.2mm

Hydraulic



Motorized

Max length 10 ft / 3,050mm

Max thickness 16 ga / 1.5mm galv



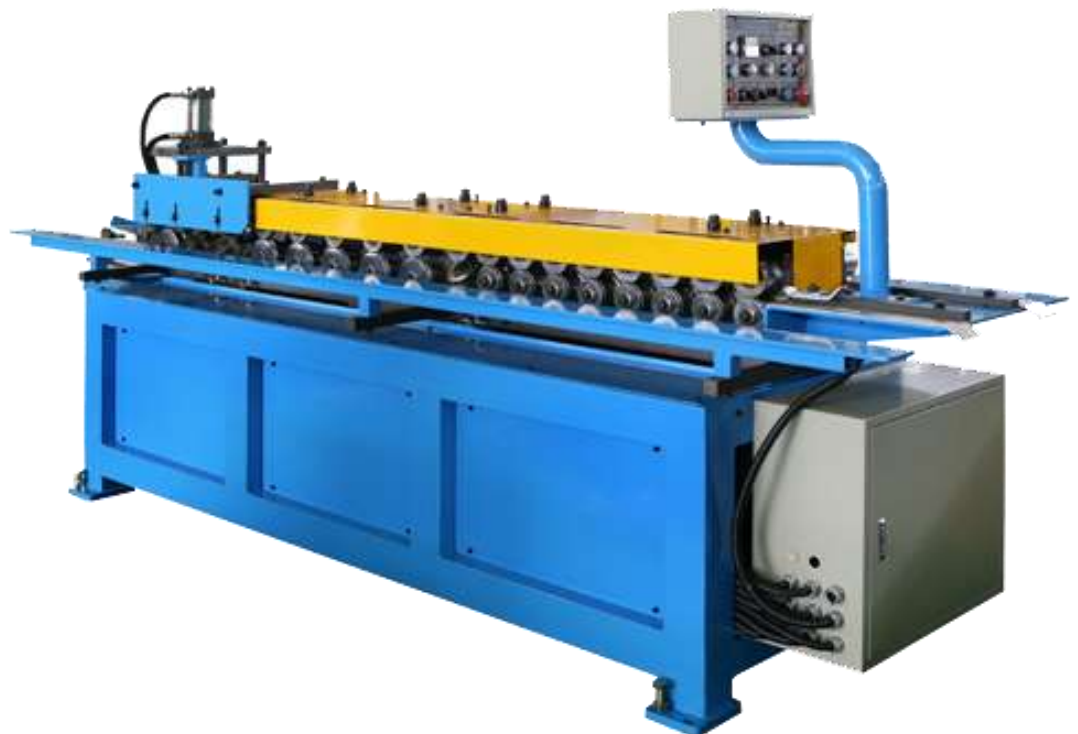


TDCF C lip lines - produce clips from coil or slit and cut to length from sheets.

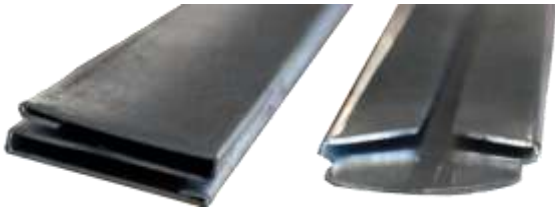


TDCF C lip lines

clips from coil 13 per minute



Roll Formers for Duct Seams and Joints



Slip and Drive cleats

Slip and Drive cleats and snap lock male and female on 4 position machine

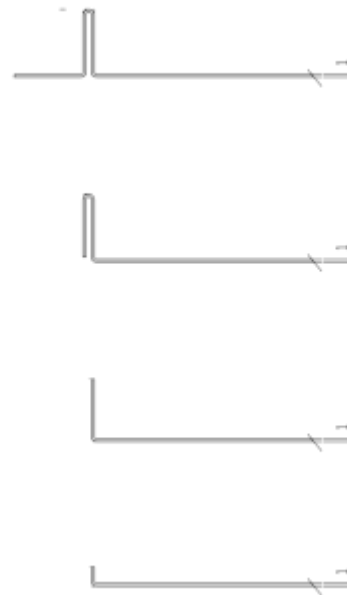
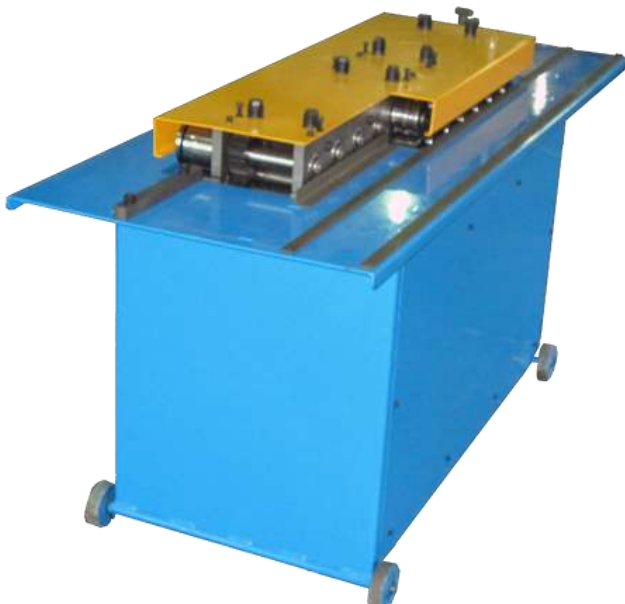


Slip and Drive cleats produced from coil



16 ga Pittsburgh with flanger attachment

711 Roll former - Pittsburgh and standing seam rolls set



Sheet Beaders and Cleaner Bearer*



Mesa Bead



Diamond Bead*



US Style V beads



Cleaner Beaders* - sweeps cutting smoke from the top and bottom surfaces of plasma cut parts while beading.



* Patent applied for/patented



Jouanel Rotary Machines

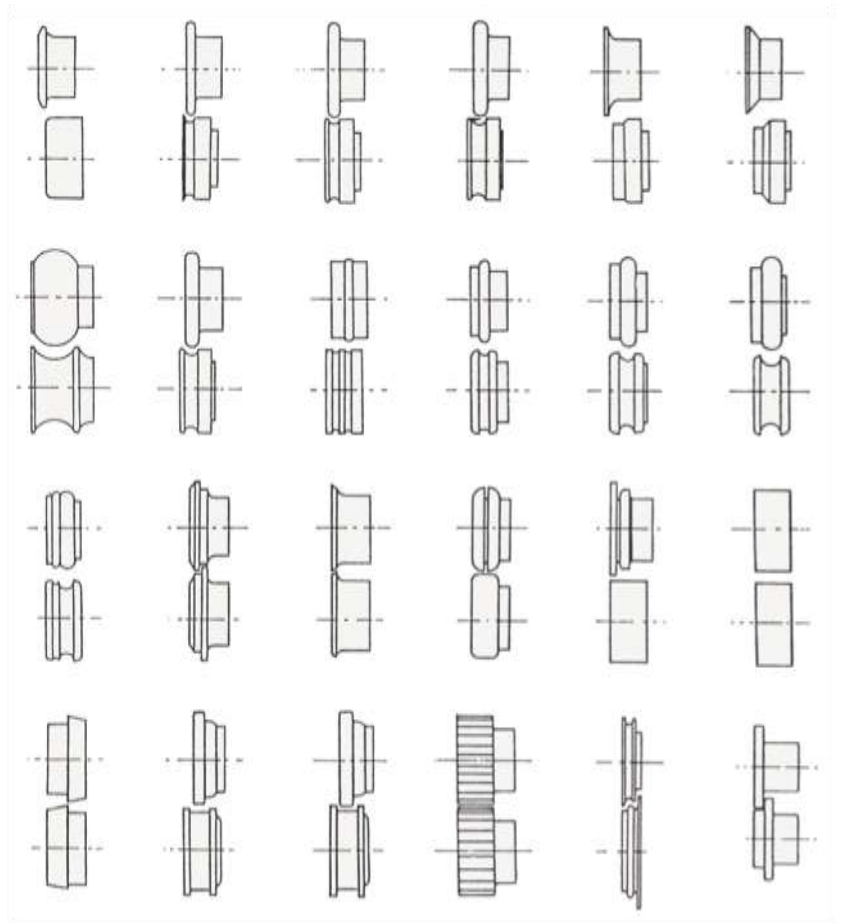
Maximum speed setting at control

Variable speed forward and reverse

Model SB5EVV 18ga / 1.2 maximum

Model SB7RVV 14ga / 1.9 mm

24 roll sets to choose from



SPIRAL ROUND DUCT PRODUCTION MACHINERY

SPIRAL ELBOW LINE* - produces airtight spiral elbows automatically from coil material with nearly 100% material use.



Three models available

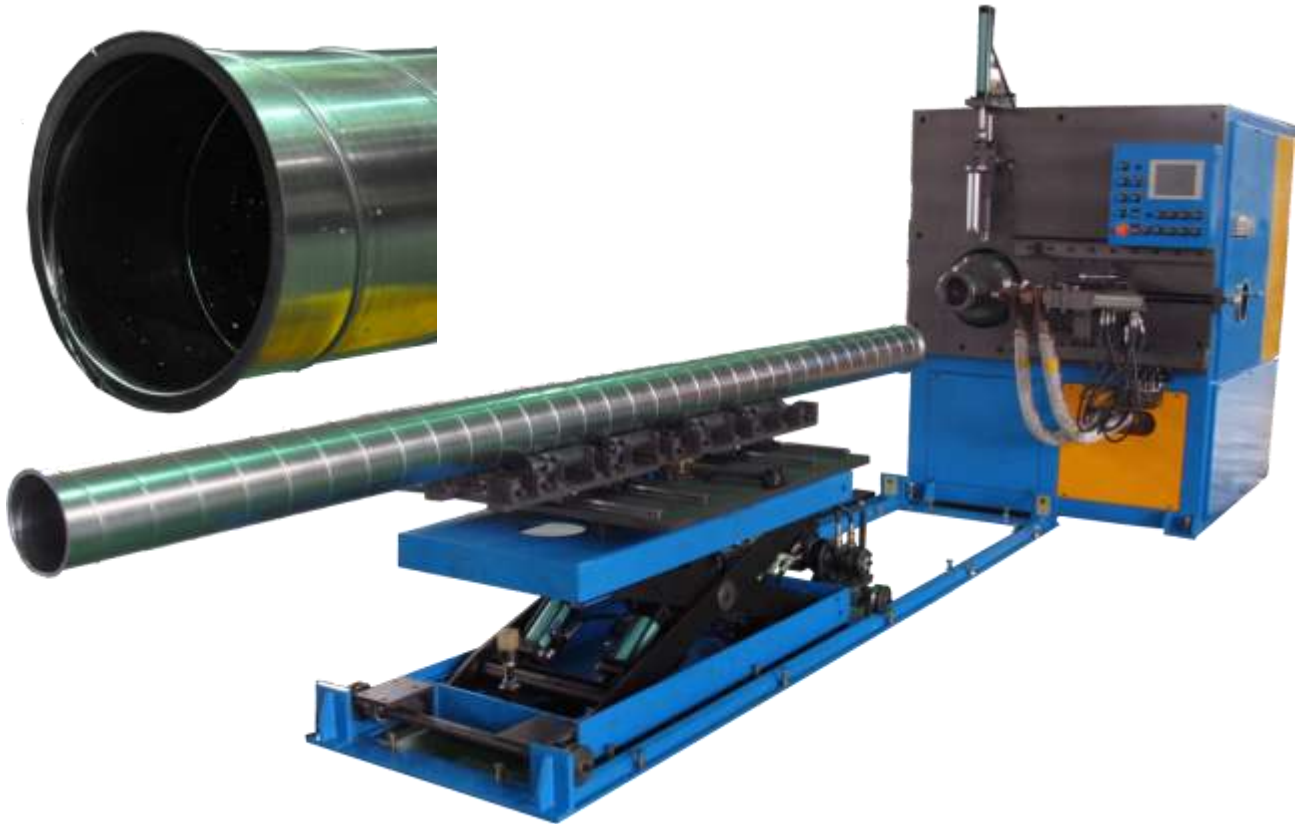
SEL-300 for elbows 4" / 100mm through 13" / 300mm diameter

SEL-450 for elbows 4" / 100mm through 18" / 450mm diameter

SEL-600 for elbows 10" / 250mm through 24" / 600mm diameter

* Patent applied for/patented

SPIRAL Duct Flanger* Model SDF-1250- H - forms duct connection flange on ends of spiral duct and fittings.



- Forms connecting flange on ends of spiral duct
- Speeds up flanging for Vanstone connections
- Diameter range 8" / 200mm through 48" / 1250mm
- Galvanized mild steel up to 18 ga./ 1.2 mm
- Seam welding and duct rotating table options



* Patent applied for/patented

SPIRAL Tube Formers - Model SF-1250



- **Produces spiral duct from 4" through 48 " / 100mm - 1,250 mm diameters**
- **Maximum thickness 1.0mm / 20ga.**
- **Maximum speed 250 FPM / 75 Meters per minute**
- **Machine and uncoiler built on a common frame for permanent coil alignment**
- **Flying slit or saw cutoff available**
- **Motorized coil entry angle adjustment**
- **Auto length scaling**
- **PLC control**

SPIRAL Tube Formers - Model SF-2000 Super



- Produces spiral duct from 4" through 80" / 100mm - 2,000mm diameters
- Maximum thickness 1.2mm / 18ga.
- Maximum speed 250 FPM / 75 Meters per minute
- Machine and uncoiler built on a common frame for permanent coil alignment
- Flying slit and plasma cutoff available
- Push button coil entry angle adjustment
- Push button forming head clamping
- Auto length scaling
- PLC control

SPIRAL Tube Formers - Model RA-600 - Automatic rounding machine

De-stack, feed and rolling machine.



Diameters 6" - 31" / 150 - 800 mm

Maximum 1.2mm / 18 ga galv.

Maximum width 26" / 700mm

65 FPM / 20 Meters per minute

Motor 0.4 Kw

Seam Welding Machine

Stitch and continuous welds

Maximum 33 FPM / 10 Meters per minute

4" / 100mm through 20" / 500mm diameter range

Models for: 40" / 1,000mm

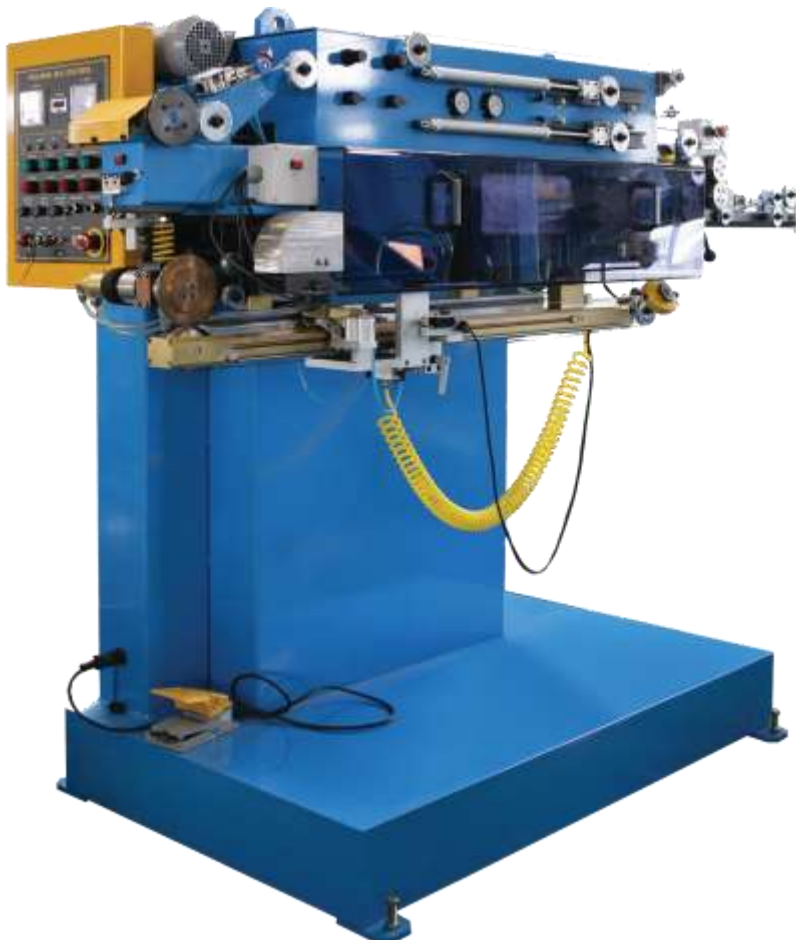
48" / 1,220mm

60" / 1,525mm

Material thickness range: .008" / 0,2mm through 20ga. / 1.0mm

Types: galvanized steel, stainless steel and mild steel

Transformer size 60KVA





EM-1250C Dual Head

Elbow Gore Seam Forming and Locking Machines

Model EM-1250	Hydraulic Powered
Model EM-1250-C	Hydraulic dual head machine
Model EM-1000	Pneumatic Powered



PNEUMATIC



HYDRAULIC



ELBOWS WITH STANDING SEAM GORE SEAMS

Our Elbow machines are available in a Heavy Duty Hydraulic and more economical pneumatic powered models. These machines form and close the gore seams on elbows and other round fittings. We now offer a combination machine with heads for seaming and closing operations to minimize setup times on the machine.

N/C controlled folding machines - computer control of bend angle and dimensions. Form precision parts from **start** to finish in one handling.



Standard equipment

- Foot operated clamp control, for hands free operation
- Switch folding beam control
- Electromechanical angular gauge from 0 to 145°
- 12 mm folding beam including interchangeable 15 mm tool (total width 27 mm)
- Adjustable folding radius
- Dishing device on the table and the folding beam
- Interchangeable clamping tool curved on 35° to provide the U profile
- Clamping stop for safety

Models for up to 10 ft maximum bend length

Thickness up to .10" / 3mm mild steel

Precision back gauge and PLC control optional

ROPER WHITNEY

Generation 2 AUTOBRAKE

WITH CROWNING SYSTEM STANDARD



General Machine Specifications

- 122" / 3100m maximum bend length
- 16ga. / 1.5mm thickness capacity mild steel
- 39.37" / 1 meter Backgauge travel (in under 2 seconds)
- Programmable open height 4.9" / 120mm Maximum
- Open, Closed or teardrop hems without changing tools
- Center crowning cam for improved bend angle accuracy
- Manual cam adjustment and lock
- Adjustable straightness for stepped radius bends
- Variable speed drive
- Rugged ROPER WHITNEY Quality Construction

Titan Touch Screen computer control
High resolution anti glare panel
Industrial grade computer with internal air cooling
Capability to store over one million part programs
....contact us for current specifications

User friendly Titan Control



Built with pride by the Choice of Professionals
ROPER WHITNEY of Rockford
Quality machines from the USA since 1910

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Roper Whitney Power Shears / Jump shears



Model 10M14

10ft. / 3050mm x 14ga. / 2,0mm capacity

Front operated backgauge and material return



Roper Whitney 152 Jump Shears

60" x 16ga capacity

1.5Meter x 1.5mm capacity
galvanized mild steel

We have over 40 years experience with machines for sheet metal fabrication. We specialize in machines for the production of rectangular and spiral round duct and fittings.

If you are looking for a particular machine and don't see it in this book please contact us.

Other items we carry



PCX Combination folder / slitter



Slip on Flange roll form line

STANDARD SHEET METAL MACHINERY

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Machine specifications subject to change without notice