

# Burring Machine 42J

## Burring and Wiring Machine 42J

### BURRING MACHINE

This machine is generally used by sheet metal workers and tinsmiths for turning a flange on the bodies of tinware etc or for turning up an edge on circular or irregular shaped components to prepare for a "knock up" seam. There is easy lateral adjustment for the top head and a hardened steel gauge. The interchangeable hardened steel heads are 45 mm diameter.

Maximum thickness will handle in soft mild steel is 0.8 mm. Complete with bench stand.

Approximate weight — 16 kg.



BURRING



WIRING



LOBSTER BACK

### BURRING AND WIRING MACHINE

This machine is complete with four pairs of standard turn up or wiring heads and two top closing heads suitable for 4 mm, 5 mm, 6 mm and 8 mm diameter wire, and one pair standard burring heads.

Used in the manufacture of tinware etc and general sheetmetal work, for turning over an edge and enclosing a wire as indicated in the diagrams.

Complete with bench stand.

Approximate weight — 19 kg.

The machine can be supplied without the burring heads or the full complement of wiring heads.

Also available as optional extra Lobster Back Heads — 2 mm, 3 mm, 5 mm, 6 mm, 8 mm.



### Paning or Setting Down Machine 44J

Used by sheet metal workers and tinsmiths for turning in the edge of bottoms of buckets, billycans and similar articles when working on a "knock up" seam. This machine follows on after the operation in the Model 42J Burring Machine. When the bottoms are assembled to the bodies the seam is turned into an angle which prepares for the final closing operation.

Complete with bench stand.

Diameter of steel heads — 100 mm.

Approximate weight — 19 kg.

# Beading or Swaging Machines

## 43J

### HAND OPERATED

Used by sheetmetal workers for rolling ornamental or strengthening beads, usually on cylindrical work or other components. Also used for closing down "knock up" seams on the bottoms of sheet metal containers.

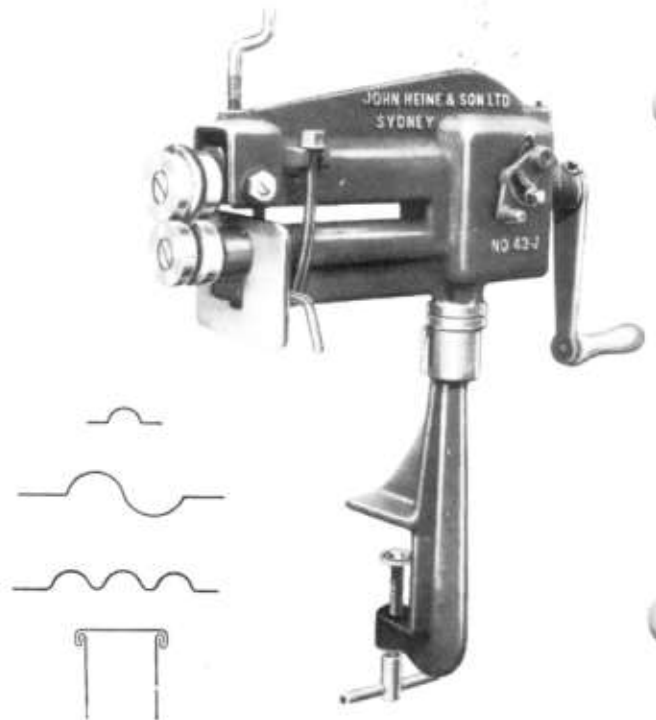
This deep throat machine is of sturdy cast iron construction and features machine cut gears. Heads can be changed quickly and there is easy lateral adjustment of the top head. The machine comes complete with a steel yoke to reduce deflection when beading the heavier gauges in narrower widths, a large area gauging plate and bench stand. The machine is normally supplied with one pair of standard heads to be selected from the following:

10 mm, 13 mm, 20 mm or 25 mm single bead.

Triple bead or ogee bead: Bottom closing heads.

If no head type is nominated, 10 mm single bead is supplied. 8 mm pitch **crimping heads** are also available at extra cost.

Diameter of heads	57
Maximum thickness will bead in soft steel	1.0
Throat depth (without yoke)	280
Weight — kg	38



## 45J Series 2

### POWER OPERATED

Heavy duty, motorised machine for rolling ornamental or strengthening beads in straight or cylindrical components. The drive is through a "beltless wedge action" direct into the vee grooves of the main drive wheel. Rotation of the beading heads is controlled from a foot pedal.

The machine is of one piece cast frame construction with a deep throat and easy lateral adjustment of the top shaft for accurate head alignment.

Designed for bench mounting. If required the machine can be supplied with its own stand — price on application. Standard equipment includes a large area gauging plate, a steel yoke to reduce deflection when beading the heavier gauges in narrower widths, motor and switchgear.

The machine is normally supplied with one pair of standard heads to be selected from the following:

10 mm, 13 mm, 20 mm or 25 mm single bead.

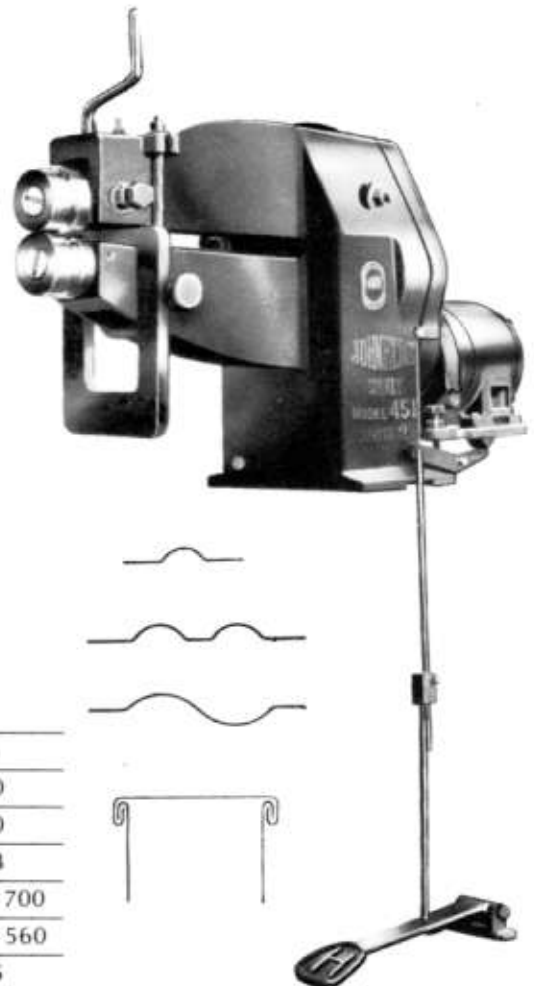
13 mm double bead.

Ogee bead or bottom closing heads.

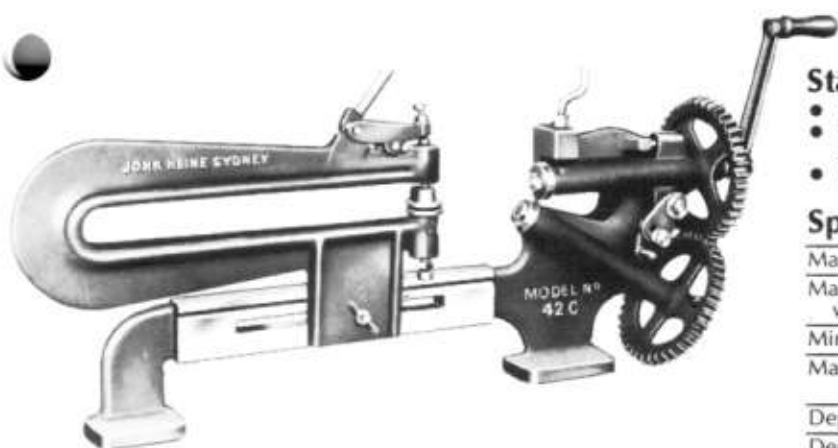
If no head type or size is nominated, 10 mm single bead is supplied.

#### SPECIFICATIONS:

Maximum thickness will bead in soft steel	1.6
Diameter of heads	90
Depth of throat (without yoke)	460
Operating speed (metres per minute)	8
Motor — KW x RPM	1.1 x 700
Overall dimensions L to R x F to B	1170 x 560
Height	765
Weight — kg	255
Shipping measurement — cubic metre	0.6



# Circle and Ring Cutting Machine 42C



Manually operated bench mounted machine for the rapid production of circles and rings from square blanks.

## Standard Features:

- Blank is clamped between pallet plates to avoid disfiguration.
- There is a simple lateral adjustment of the top shaft for setting the cutters.
- An adjustable gauge is provided for easy blank location.

## Specifications:

Maximum diameter circle from square blank	635
Maximum diameter circle from square blank with corners removed	810
Minimum circle diameter	95
Maximum thickness — soft steel	1.2
— aluminium	2.5
Depth of throat in cutting head	150
Depth of throat in bow	450
Weight — kgs	57
Shipping measurement (cubic metre)	0.15

# Rotary Shear 40C



Robust, inexpensive, bench mounted machine for single cut slitting to any length.

The machine is complete with:

- A machined table with an adjustable gauge.
- Large diameter cutters.
- Machine cut gears.
- Motor drive, switchgear and gear guard.

## Specifications:

Maximum material thickness — soft steel	1.6
— soft aluminium	3
— 302 stainless	1.0
Maximum width of cut	450
Cutting speed — metre per minute	20
Motor kW	0.75
Weight kgs	127
Shipping measurement (cubic metre)	0.4

# Rotary Shear and Circle Cutter 40C



This circle cutting machine incorporates the rotary shear head with flat belt drive. Ideal machine for high volume production of circles for press operations. Machine can also be used for slitting. Pallet plates are used to clamp the material and one action clamps the sheet and sets cutters in motion.

The machine is complete with:

- Adjustable blank location gauge.
- Mechanical screw adjustment of the bow.
- Slitting table and gauge.
- Motor drive, switchgear and belt guard.
- Leg unit.

## Specifications:

Maximum material thickness — soft steel	1.6
— soft aluminium	3.0
— 302 stainless	1.0
Maximum diameter of circle from square blank with corners removed	915
Minimum circle diameter	127
Throat depth of cutting head from cutters	508
Throat depth of bow from centre of pallets	585
Weight kgs	330
Shipping measurement (cubic metre)	1.4

# Guillotine Squaring Shears

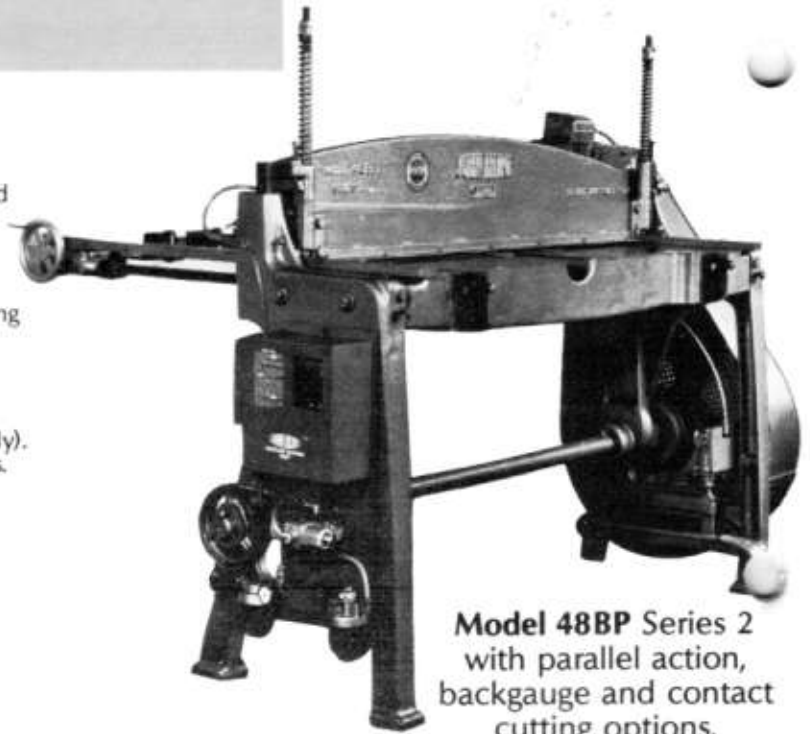
LIGHT DUTY — TREADLE OR MOTOR DRIVEN

TREADLE OPERATED — **48B** Series 2  
MOTOR DRIVEN — **48BP** Series 2

- Strong, precision built, quick acting, mechanically operated machines for clean accurate cutting of sheet metal and other materials.
- One shear blade clearance setting cuts cleanly all thicknesses up to the capacity of the machine.
- One piece side frames and extra long guides for the cutting beam ensure accurate alignment of the shear blades.
- Ideal machines for production and jobbing work.

Machines come complete with:

- Tungsten steel single edged shear blades.
- Automatic clamping attachment. (Motorised machines only).
- Front gauge and extension brackets, back and side gauges.
- Tension bar on shear beam to assist in blade setting.
- Motor switchgear and flywheel guard.



**Model 48BP Series 2**  
with parallel action,  
backgauge and contact  
cutting options.

SPECIFICATIONS	48B	48BP
Maximum cutting length	1250	1250
Capacity:		
— soft steel	1.6	1.6
— aluminium, A3203 H14	3.0	3.0
— 302 stainless	1.0	1.0
Strokes per minute (continuous run)	—	100
Motor kW	—	2.2
Weight — kg	380	610
Shipping measurement — cubic metre	1.8	2.3

A manual clamping attachment is optional extra on treadle operated machines.



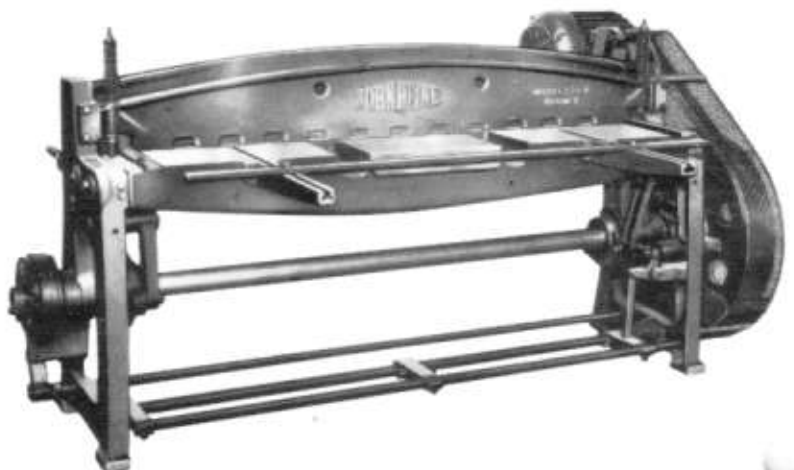
**166B** Series 3  
MOTOR DRIVEN

## SPECIFICATIONS:

Maximum cutting length	1880
Maximum material thickness	
— soft steel	2.0
— aluminium	3.5
— stainless steel	1.2
Strokes per minute (continuous run)	80
Motor kW	2.2
Weight — kg	1780
Shipping dimension — cubic metre	4.2

## MACHINE ALSO INCLUDES:

- Cam actuated independent spring loaded pressure pin clamping system.
- Cam controlled braking of the shear beam.
- Provision for maintaining the lower blade at the correct height without the use of packing strips.
- Full length operating pedal.
- Motor, switchgear and flywheel guard.



## OPTIONAL EQUIPMENT:

The following options are available for all the above machines.

- Spare shear blades.
- Fine screw adjusting blocks for back gauge.
- Contact cutting for high production shearing.
- Manually operated parallel back gauge unit.

Sizes range from 1065 mm to 1320 mm long.

All machines are of high quality manufacture with robust cast legs and end frames.

Gears are machine cut and each machine features a swing out top roller for easy component removal and independent adjustment at each end of the deflector roll enabling tapered work to be performed.

The rollers in all machines are grooved so that pre-wired sheets, either inside or outside, can be curved.

- NARROW WIDTHS OF THICKER MATERIAL CAN BE CURVED.

SPECIFICATIONS	20H	45H
Maximum length will curve	1065	1320
Maximum thickness at full length		
— soft steel	1.0	1.2
— aluminium	2.0	2.5
— 302 stainless	0.6	0.7
Roll diameter	50	75
Weight — kg	102	320
Shipping measurements — cubic metre	0.45	1.8



Model 20H

## Grooving Machines

Hand operated machines for closing down longitudinal side seams on sheet metal containers.

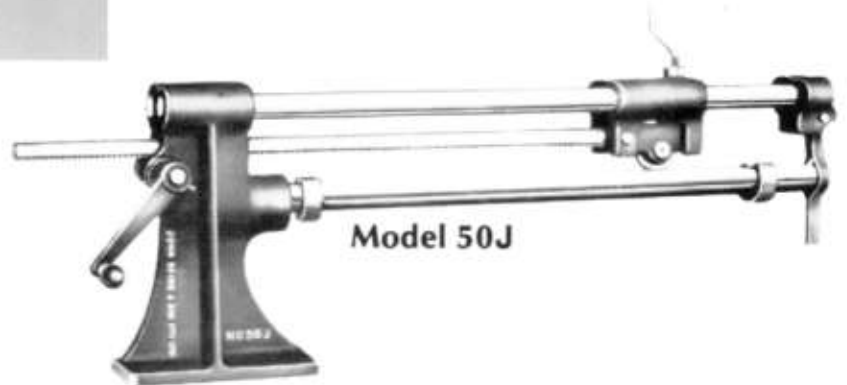
Seaming roller is adjustable for material thickness and closing pressure.

Seaming mandrel supported by swinging yoke.

Machine cut gears give smooth operation.

Outside seam is standard.

Inside seam optional extra. Special length machines can be made to order.



Model 50J



Model 51J

SPECIFICATIONS	50J	51J
Maximum length of seam	900	1270
Diameter of grooving mandrel	55	100
Maximum material thickness — mild steel	0.8	1.2
Weight — kg	152	470
Shipping measurement — cubic metre	0.36	0.64

### OPTIONAL

These machines can be motorised if required. Price on application.



# Cramp Folders and Benders



**Model 166H Series 1**

High quality, manually operated heavy duty machines for bending and folding sheet metal.

**WELL DESIGNED COMPONENTS ENSURE RIGIDITY AND A CONSISTENT BEND ALONG THE FULL LENGTH.**

Suitable for jobbing or production work.

**STANDARD FEATURES:**

- Balanced clamping beam and bending flap for easier operation.

- Adjustable stop for repetition work.
- Back gauge and extension brackets.
- Wide and narrow bending bars — narrower bar suitable for return bends down to 13 mm wide.
- Bending flap is adjustable for square or radius corners.

**OPTIONS:**

- Air or hydraulic operation.
- Special clamping steels for radius bends.

SPECIFICATIONS	264H Series 1	166H Series 1	168H Series 1
Maximum length will bend	1225	1830	2450
Maximum thickness at full length			
— soft steel	2.0	2.0	1.6
— aluminium	4.0	4.0	3.0
— 302 stainless	1.6	1.6	1.2
Adjustment of clamping beam	45	50	50
Lift of clamping beam	45	76	76
Weight — kg	457	1220	1576
Shipping measurement — cubic metre	1.9	2.7	3.6

# Pan Brakes

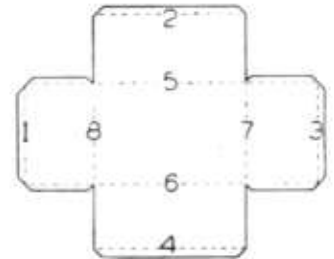
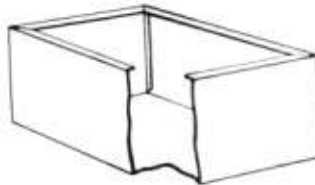
High quality, manually operated, heavy duty machines for folding sheet metal boxes, trays, shelving, etc.

**WELL DESIGNED COMPONENTS ENSURE RIGIDITY AND A CONSISTENT BEND ALONG THE FULL LENGTH.**

Suitable for jobbing or production work.



Model 72H Series 3



#### Width of Clamping Fingers

271H Series 1 — 70, 75, 80, 90, 95, 100 (2), 110, 115, 120, 130, 140

72H Series 3 — 70, 75, 80, 90, 95, 100 (2), 110 (2), 115 (2), 120 (2), 130 (2), 140 (2)

**OPTIONS:** Air or hydraulic operation.

#### Standard features:

- Balanced clamping beam and bending flap for easier operation.
- Adjustable stop for repetition work.
- Back gauge and extension brackets.
- Wide and narrow bending bars — narrow bar suitable for return bends down to 13 mm wide.

- Adjustable bending flap.
- Heavy duty clamping fingers. Wide range of widths each with a replaceable toe steel. Fingers are located against an accurately machined face on the clamping beam and positioned by means of a single clamping screw. Fingers are easy to remove or relocate.

SPECIFICATIONS	271H Series 1	72H Series 3
Maximum length will bend	1225	1840
Maximum thickness at full length		
— soft steel	2.0	2.0
— aluminium	4.0	4.0
— 302 stainless	1.6	1.6
Maximum depth of box or pan	200	200
Lift of clamping beam	50	50
Weight — kg	605	1271
Shipping measurement — cubic metre	1.9	2.9

# Angle Benders



Popular hand operated machines for right angle bending and rectangular box section forming, complete with top and bottom forming steels for 90° bend.

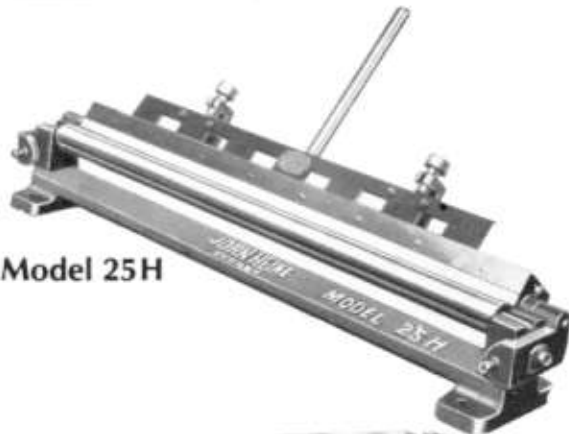
Special forming steels can be fitted for different angles or radii. Bottom die block can be machined for different grooves.

Complete with back gauging.  
Suitable for bench mounting.

SPECIFICATIONS	75H Series 2	34H Series 2
Maximum length of bend	515	965
Capacity — mild steel CRC	0.8	1.0
Minimum size box will form	90 sq	180 sq
Weight — kg	50	140
Shipping measurement — cubic metre	0.09	0.17

# Bench Folders

Model 25H



## MODEL 25H

Quick acting bench folder for producing hooks for lock seaming or similar work.

Can be adjusted to produce radius folds in preparation for wiring. Complete with gauge for repetition work.

## MODEL 77H

Inexpensive bench folder suitable for technical colleges and model work. Unlimited width of fold.

Clamping steel can be notched to allow shallow trays to be formed.

Model 77H



SPECIFICATIONS	25H	77H
Maximum length of fold	940	610
Capacity — mild steel CRC	0.8	0.6
Width of hook or fold	22	Unlimited
Weight — kg	64	19
Shipping measurement — cubic metre	0.11	0.03



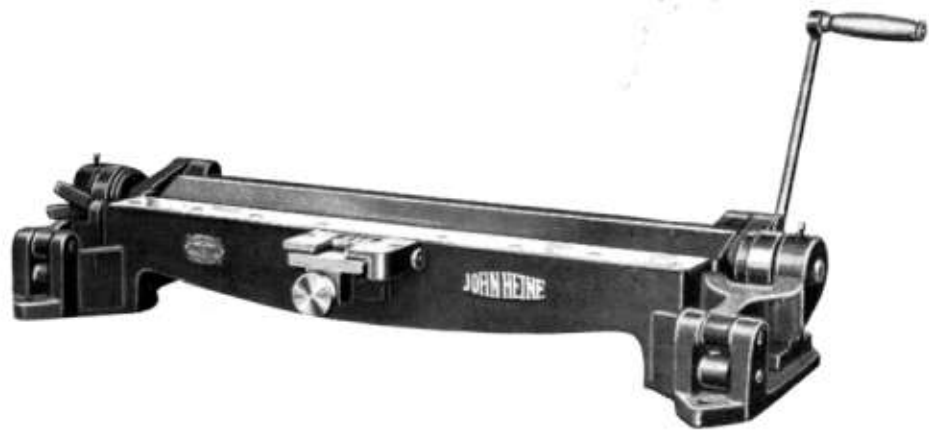
# Precision Bench Folder 57H

High quality, quick acting precision folding machine for light sheet metal, suitable for bench mounting.

Incorporates hardened steel gauging with centralised and graduated adjustment to show width of fold.

Clamps and folds in one action.

Suitable for single or double folds and will close or hem previously formed hooks. 'U' section bends can also be formed.



SPECIFICATIONS	57H
Maximum length of fold	785
Capacity — mild steel HRC	0.8
— 302 stainless	0.5
Width of fold	2 to 22
Stops provided for	45° and 90° angles
Weight — kg	90
Shipping measurement — cubic metre	0.09

# Throatless Shear 60C

Ideal machine for irregular or straight cuts in flat sheet metal of any length or width to the maximum thickness specified. Designed for bench mounting. The machine includes fine adjustment for setting the hardened and ground cutters after regrinding. A great asset in jobbing work.

SPECIFICATIONS	60C
Capacity — sheet steel CRC	1.6 mm
— sheet steel HRC	1.2 mm
Weight — kg	20
Shipping measurement — cubic metre	0.05

