RAS 21.20

- Cutting
- Bending
- Forming
The flanging machine for professional duct manufacturers

The RAS 21.20 flanging machine turns up 90 degree flanges on radius cheeks so that the parts are ready for Pittsburgh or Snaplock joints. **Quick. Safe. Efficient.**

The speed is adjustable between 0 and 9.4 m/min (0 to 30 ft/min). In addition the machine can be operated with 230 V from a standard wall outlet. The machine comes with an extended material support area in front and behind the forming station.

The large flanging rolls produce uniform and non-wavy results even on small radii. Using the standard rolls variable flange heights from 6 to 15 mm (1/4" to 5/8") can be formed.

The optional automatic material guiding system helps to create consistent flange heights. Rolls for 8 mm or 10 mm (5/16" or 3/8") flange heights are available for the automatic material guiding system.

Rolls in the top attachment pierce and offset the buttons for the Snaplock joints in a single pass.

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Variable speed 0-9.4 m/min (0-30 ft/min)

Variable flange height

Air duct radius cheeks

Top attachment pierces and offsets the buttons for Snaplock joints

Pre-bending a flange with an adjustable stop as feeding support
Variable material thickness adjustment from 0.5 to 1.5 mm (26 to 16 Ga.) (Option)

Automatic material guiding for flange heights of 8 or 10 mm (5/16” or 3/8”) (Option)

Pittsburgh joint

Snaplock joint

Foot switch: Ideal for the production of large parts (Option)

Spring steel table inserts and special forming rolls for stainless steel applications (Option)
## Technical Data

<table>
<thead>
<tr>
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<th>RAS 21.20</th>
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<tbody>
<tr>
<td>Sheet Thickness (Mild Steel)</td>
<td>0.5 – 1.5 mm  26 Ga. – 16 Ga.</td>
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<tr>
<td>Flange height with standard forming rolls</td>
<td>6 – 15 mm  1/4&quot; – 5/8&quot;</td>
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<tr>
<td>Flange height with automatic material guiding system</td>
<td>8 mm or 10 mm  5/16&quot; or 3/8&quot;</td>
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<tr>
<td>Minimum inside radius (for a 90 degree segment)</td>
<td>100 mm  3.94&quot;</td>
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<tr>
<td>Minimum inside radius (for a 180 degree segment)</td>
<td>130 mm  5.12&quot;</td>
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<tr>
<td>Speed</td>
<td>0 – 9.4 m/min  0 – 30 ft/min</td>
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<tr>
<td>Dimensions (L x W)</td>
<td>600 x 600 mm  24&quot; x 24&quot;</td>
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<tr>
<td>Drive power</td>
<td>0.75 kW  1.09 hp</td>
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<tr>
<td>Weight net</td>
<td>165 kg  365 lbs</td>
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</tbody>
</table>

## Options

- Top attachment for button punch (flange height 10 mm (3/8") required) | 0.5 – 1.0 mm  24 - 20 Ga. |
- Automatic material guiding system up to thicknesses 1.0 mm (20 Ga.) for flange height | 8 mm  5/16" |
- Automatic material guiding system up to thicknesses 1.0 mm (20 Ga.) for flange height | 10 mm  3/8" |
- Foot switch
- Spring steel table inserts for stainless steel applications
- Special forming rolls for stainless steel applications