

## RAS 21.20



- Cutting
- Bending
- Forming

## RAS 21.20

### The flanging machine for professional duct manufacturers



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

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.**

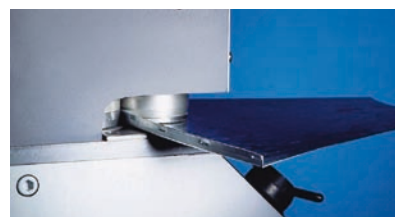
The speed is adjustable between 0 and 9.4 m/min (0 to 30 ft/min). In addition the machine can be operated with 230 V from a standard wall outlet. The machine comes with an extended material support area in front and behind the forming station.

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.

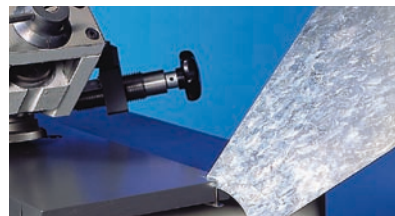
The optional automatic material guiding system helps to create consistent flange heights. Rolls for 8 mm or 10 mm (5/16" or 3/8")

flange heights are available for the automatic material guiding system.

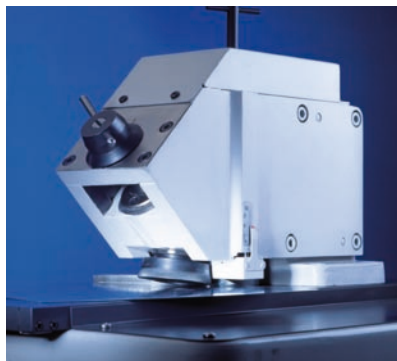
Rolls in the top attachment pierce and offset the buttons for the Snaplock joints in a single pass.



Top attachment pierces and offsets the buttons for Snaplock joints



Pre-bending a flange with an adjustable stop as feeding support



Variable flange height

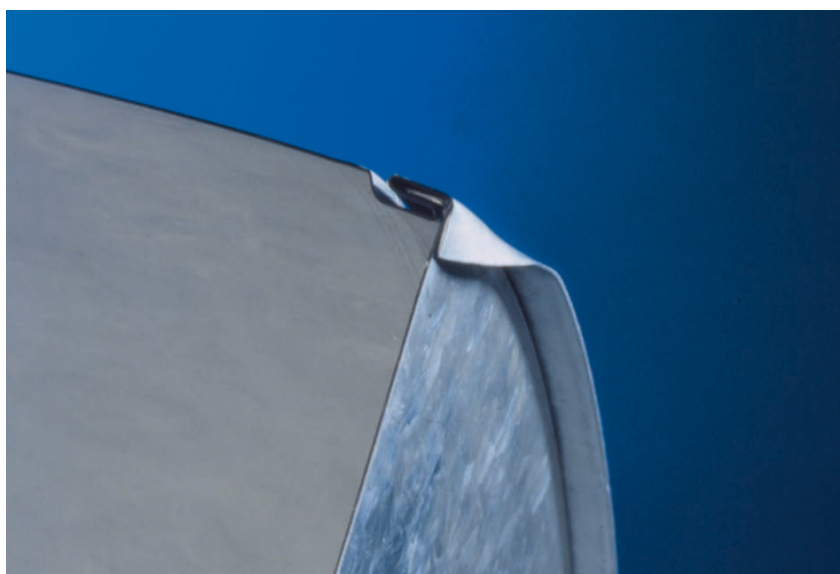


Air duct radius cheeks

## RAS 21.20



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



Pittsburgh joint



Variable material thickness adjustment from 0.5 to 1.5 mm (26 to 16 Ga.)



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)





## RAS 21.20

### Flanging machine



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

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Modifications reserved. Pictures may show options.