



**TWIN SEAM COMPANY A/S**

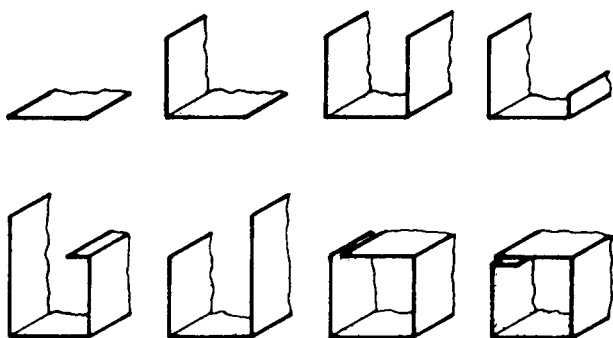
## *Automatic Rectangular Duct Forming Machine*

**TYPE KA 1501 - Autoselect**

**TYPE KA 2001 - Autoselect**



The Autoselect facility  
Automatic production from 4 coil  
dimensions



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## KA 1501 - Autoselect



The machine operates from 4 different coil dimensions, without operator involvement

### Operation and production flow

The production of ductwork is made from one of the 4 different coils which is automatically feeded into the combined straightening and profiling unit. The coils may have different measurements in the material thickness from 0,5 mm to 1,25 mm or in widths from 500 mm to 1500 mm.

The autoselect unit which is fully integrated in the production line is 100% controlled by the main machine's control system and driven by hydraulic motors.

It means that manual handling is not required, because all functions are automatically carried out by the machine. The operator only has to input data either by the keyboard/monitor of the machine or by remote PC.

The specially designed machine control system then takes care of executing the orders and selecting the right material dimensions and continuously shows the production status on the VDU/monitor.

The machine produces the full range of ductwork programs, for instance full box section, U-shape, L-shape, straight cut with or without stiffening ribs.

99 different duct dimensions or programs can be stored in the machine at the same time.

The operator just controls production and retrieves the ducts from the machine.

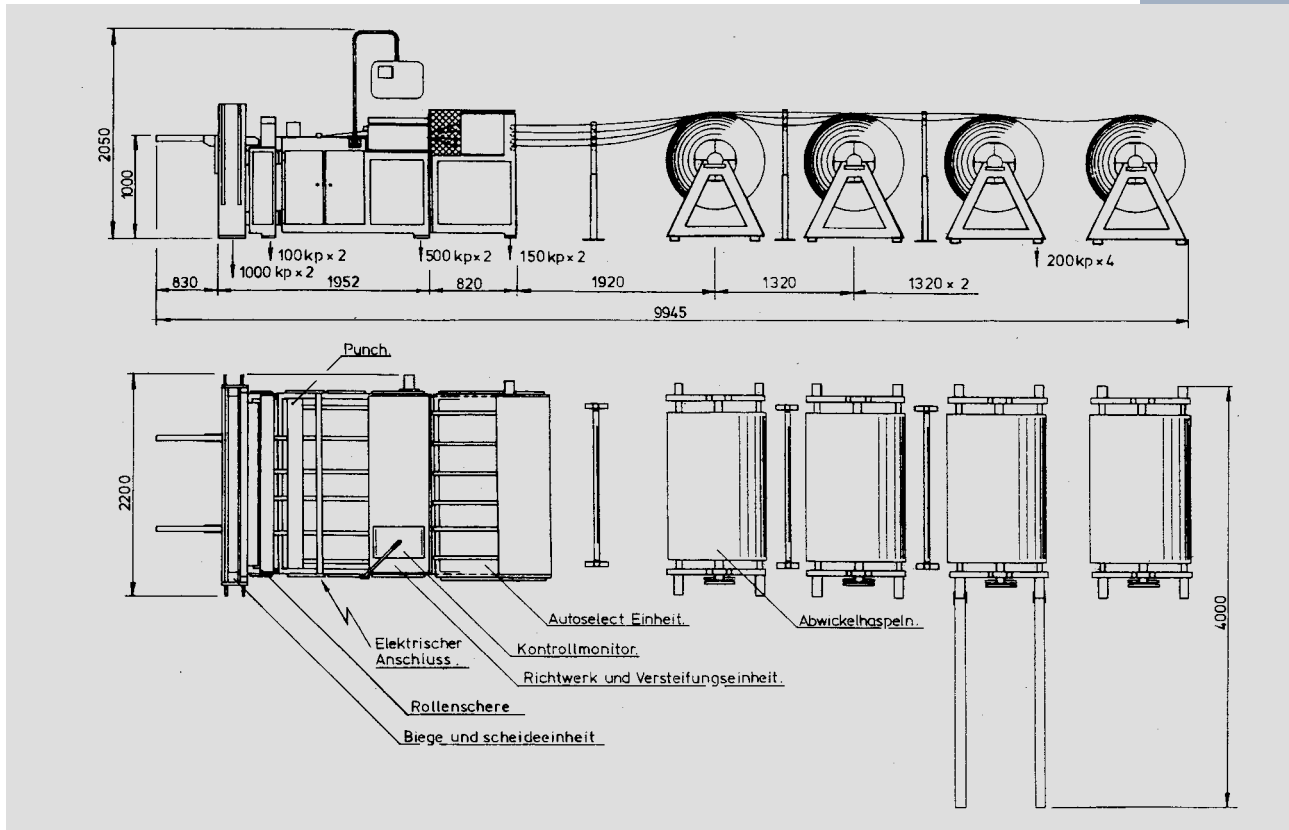
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TWIN SEAM COMPANY A/S
DUCT FORMING MACHINE KA 1501 - AUTOSELECT

----- RECEIPT EDIT -----
RECEIPT Nr :      ITEMS TOTAL :      Z1 :
PRIORITY Nr:      ITEMS REM.  :      Z2 :
                  CHANNEL TYPE:      Z3 :
                  COIL Nr   :      Z4 :
                               Z5 :
                               Z6 :
                               ENTER:
----- TASK STATUS -----
                               EDITING
```

Data Entry  
screen picture



## Measurements and Loads



## Machine Configuration

The Twin Seam Autoselect production line is a modular system and can be configured according to customer requirements. Furthermore the autoselect machine can be upgraded to the KA 3000 production line which produces ductwork up to 3000 mm in length.

The basic KA 1501-Autoselect consists of the following modules:

- 1) Combined cutting and bending unit.
- 2) Straightening and profiling unit.
- 3) Autoselect feeder unit.
- 4) Specially designed industrial multiprocessor control system manipulating the dashboard.
- 5) 4 decoilers for max. 7 tons coil/weight.
- 6) Material separation rollers for protection of the surfaces.



Microprocessor Computer. Operators keyboard.



## Advantages and Options

- Industrial multiprocessor control system for easy and trouble-free operation.
- Up to 99 orders can be stored in the machine at the same time.
- One man operation.
- Automatic execution of production without help from the operator.
- Network connection to T.S. Plasma cutting table.
- High capacity max. 10 tons ductwork per 8 hour shift.
- Automatic shift between the different material dimensions without any operator involved.
- Attractive price/performance ratio.
- T.S. is the leading supplier of automatic duct production lines in Europe.
- Automatic punching tools for reinforcement/ bars.
- Automatic notching units for corner seam and seam notches.
- Remote data input and list printing via PC.
- Expansion of the machine to KA 1500-3000.
- Motorized decoilers.
- Up to 6 decilers.

## Technical specifications: KA 1501/2001 Autoselect 2-8.

Material specifications	Unit	KA 1501-Auto 2	Ka 1501-Auto 4	KA 1501-Auto 8
Number of coils		2	4	8
Max. weight of coil	Tons	7	7	7
Max. width of coil	mm	1500(60'')/2000(80'')	1500(60'')/2000(80'')	1500(60'')/2000(80'')
Max. thickness of sheet	mm	1.25	1.25	1.25
Steel double lock forming quality	Gauge	18	18	18
Min. thickness of sheet	mm	0.5	0.5	0.5
	Gauge	27	27	27
Dimension of largest duct	mm	2500 x 2500	2500 x 2500	2500 x 2500
Dimension of smallest duct	mm	140 x 140	140 x 140	140 x 140
Min. L duct	mm	10 x 120	10 x 120	10 x 120
Max. length of duct	mm	1500/2000	1500/2000	1500/2000
Min. length of duct	mm	500	500	500

### Beading/section

Reinforcement profiling standard

Z-profile or Trapetz  
Special profiles can also be offered



### Output capacity

Production time for average duct work 400 x 400 x 1500	sec.	45 pr. sec.	45 pr. sec.	45 pr. sec.
Time for automatic shift between to material gauges	sec.	20	20	20
Max. discharge speed	m/min	18	18	18

### Electricity

Power consumption	KW	4	4	4
Electrical connection	VAC	3 x 400 V - 50 HZ 0 + earth	3 x 400 V - 50 HZ 0 + earth	3 x 400 V - 50 HZ 0 + earth

### Arrangement

Floor areal require	m <sup>2</sup>	16/20	22/26	34/38
Approximate weight	Tons	4.5/5	5/5.5	8/8.5

Technical data subject to revision without notice.

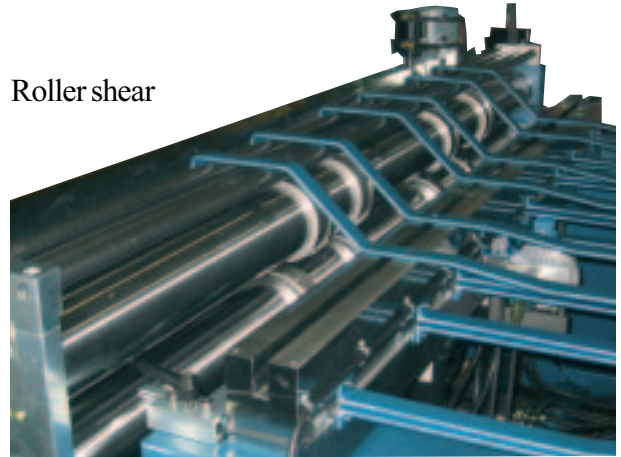


## Order input



The Automatic punch module (option).

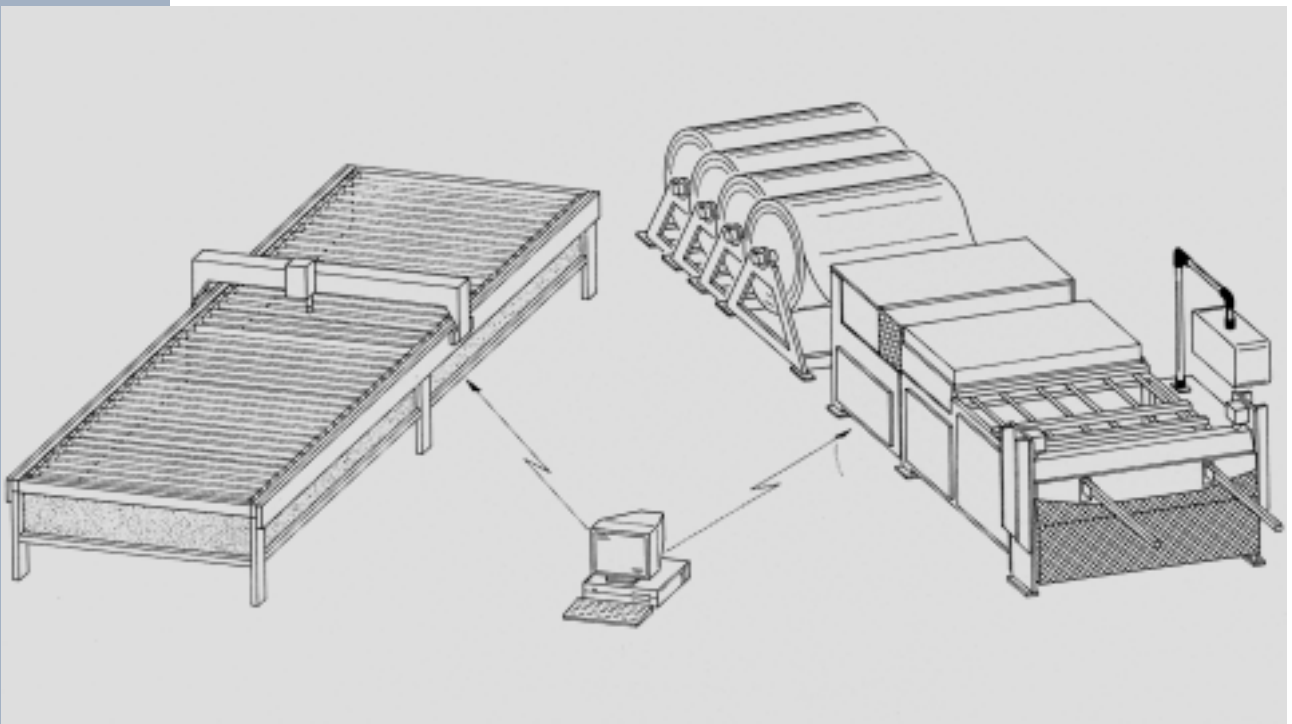
Roller shear



In order to make the input and processing of data, as easy as possible, Twin Seam has developed a **new data entry and processing** software package.

By using this software package, you need only one PC and one program, for both straight ductwork, blanks and fittings.

After entering the data, the software package will sort, process and transmit the needed information (receipts) to the KA 1500 duct forming machine, and the TS-plasma cutting machine, as necessary, for production.



Network connection of duct forming machine and TS plasma cutting table to central PC-Computer.



## The TWIN SEAM product lines



Automatic rectangular duct forming machine type KA 1500-3000



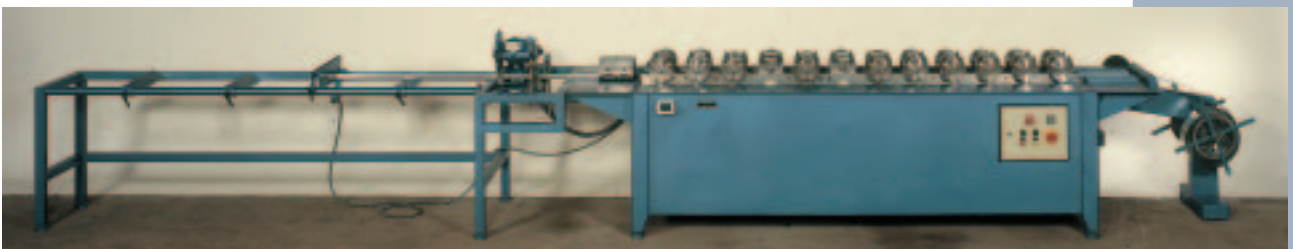
Automatic flexible duct forming machine TS 580



Feeder for plasma cutting system. FE 1500-2000



Automatic rectangular duct forming machine type KA 1501 A4.



Profile rolling machine type TS 16 S.



Automatic rectangular duct forming machine type KA 1500 Shopmaster.



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