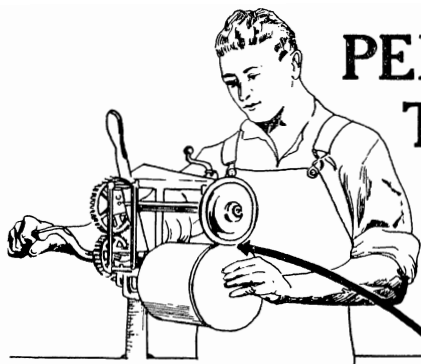


SECTION W

Double Seaming
And
Bottom Fastening Machines



PEXTO TIP No. 10

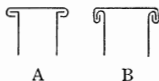
(For Tip 9,
see Page 215)

DOUBLE-SEAMING MACHINE

Increases Profits — Does Better Work

"How to bid lower and make bigger profits" is the title of a business drama enacted daily in progressive metal-working concerns everywhere.

They do it with the aid of Pexto Machines. The saving in time and money over old hand-methods, plus the prestige that neater work brings, permits bids unprogressive concerns can't meet.



Above is shown Pexto Double Seaming Machine No. 644, a versatile type that receives work $15\frac{1}{2}$ inches in depth, and $4\frac{1}{2}$ inches in diameter or larger.

With this machine extra discs are not required for each diameter of vessel to be double-seamed.

Pexto Tip No. 9 showed how the flanges of the body and bottom of the Sheet Metal Waste Can (as left by the Burring Machine) were closed, or "set-down" with the Setting-Down Machine.

The double-seaming operation throws these flanges against the body of the Can, making a water-tight seam.

A—Shows flanges of body and bottom after setting-down operation.

B—Shows the position of flanges after double-seaming.

DOUBLE SEAMING MACHINES

Useful Information

DOUBLE SEAMING MACHINES. After the Setting Down Machine has done its work the flange left by it (see cut "A" Page 301) is turned up against the bottom of the vessel to make both the seam and bottom tight (see cut "C" Page 301). In repair shops this is sometimes done with a mallet over the end of the Double Seaming Stake. If much work is to be done a Double Seaming Machine is a great advantage. We make these in several styles. The only one adapted to all kinds of work is Moore's patent.

MOORE'S DOUBLE SEAMER. The upper roll is raised by means of the crank screw, and the upright lever pulled toward you, then throw to the left until it strikes the stop. Press the bottom of the vessel against the face of the lower roll. Turn down the crank screw till it bends the flange back a little and run it once around, turn down the crank screw further and run it around again. Repeat this process until the angle of the flange agrees with the rear angle of the upper roll. Then raise the upper roll by means of the crank screw, move the lever back as far as it will go. Turn down the crank screw and revolve the rolls as before, until the work is completed. Observing these directions you will soon learn to do perfect work.

HORIZONTAL DISC DOUBLE SEAMERS. Although the Moore's Seamer will do the greatest variety of work without changes, the Stow's and Olmsted's Double Seamers have some advantages in doing certain kinds of work, especially when large quantities of vessels of the same size are to be made, and in making large and deep vessels. The one most highly recommended is Stow's Double Seamer. When made with Setting Down Attachment, it will do the work of the regular Setting Down Machine. Thus made, three heads are furnished; one for setting down, one for double seaming straight work, and one for flaring work. For setting down work the setting down head is put on the horizontal shaft, and a disc, fitting as nearly as possible the inside of the vessel, put on the vertical shaft. The standard is moved toward the head so that when the lever is depressed the flange on the vessel will be squeezed between the head and the setting down roll. It is then set down by depressing the treadle

and turning the crank. In double seaming the same disc is used, but a double seaming head substituted for the setting down head on the horizontal shaft. After the disc and head are brought into position for working together, put on the vessel, depress the treadle and turn the crank until the work is finished.

The heads of Stow's are depressed by a treadle instead of a Crank Screw, which leaves both hands at liberty, and gives it flexibility in passing seams.

Hulbert's No. 637 is built heavy intended for use on large work and heavy iron.

Olmsted's is a strong machine, and as now made, can be used with either treadle or crank screw. It is also furnished, with a deflecting face for stiffening the bottom after the work is Double Seamed.

If undecided as to the best pattern for the work in hand we will cheerfully submit a recommendation on receipt of full particulars.



The flange left, as illustrated in Cut A, is turned up against the body of the vessel with Double Seaming Machine making seam and bottom tight, as shown in Cut C.

When double seaming vessels of heavy material it is necessary to start seam inward while setting down with the Setting Down Machine, as shown in Cut B, facilitating the operation of double seaming.

ALWAYS SPECIFY



301

1819

Huiburt

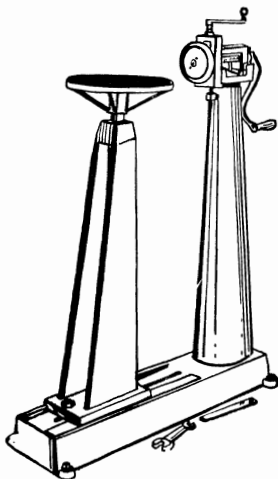
PEXTO

Pattern

1919

DOUBLE SEAMING MACHINE

No. 637



Capacity—No. 22 Gauge Iron and Lighter.

New Number	637
Code Word	Pextohubet
Old Number	336

Shipping Weight.....	approximately lbs.	430
Will receive Work in Depth.....	inches	36
Price		
Shipped boxed regularly.....		

NOTE—Regularly furnished with one 12-inch Disc. Discs of other sizes can be furnished for which an extra charge will be made.

GENERAL DESCRIPTION.

This machine is substantially constructed, intended for heavy work and will double seam vessels 12 inches in diameter and larger. Extra deep, it will prove very serviceable on Tank or Barrel Work.

Important Information Page 299

302

www.TheSheetMetalShop.Com Library

1819

Stows

PEXTO

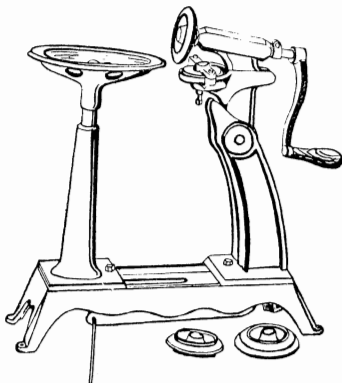
Pattern

1919

DOUBLE SEAMING MACHINE

No 650

WITH SETTING DOWN ATTACHMENT



Capacity—No. 26 Gauge Iron and Lighter

New Number	650	653
Code Word	Pextostew	Pextostow
Old Number	5	15

Shipping Weight.....	approximately lbs.	150	250
Will receive Work in Depth.....	inches	14½	20
Price			
Shipped boxed regularly.....			

NOTE—Setting Down Attachment is easily detached. If not required, specify without Setting Down Attachment. Setting Down Attachment with two Seaming Heads, one Setting Down Head and eleven Discs are furnished. Straight Discs, 5, 5¼, 6, 6½ and 8 inches. Flaring Discs, 4¼, 4¾, 5¼, 6¼, 8¾ and 10¾ inches.

GENERAL DESCRIPTION.

This machine is fitted with Setting Down Attachment, which attachment will set down or press the edge of bottoms on to the flange of body on any vessel that can be double seamed on a machine. Where the work is of a uniform character to a large extent, this machine with Setting Attachment will take the place of a regular Setting Down Machine. Setting Down Attachment can be taken off when not desired.

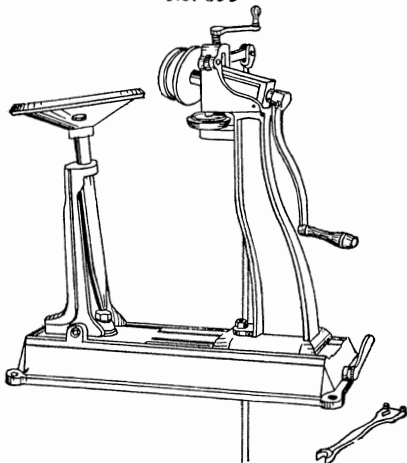
Important Information Page 299

303

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DOUBLE SEAMING MACHINE

No. 655



Capacity—No. 26 Gauge Iron and Lighter.

New Number	655
Code Word	Pextohome
Old Number	655

Shipping Weight.....	approximately lbs.	120
Will receive Work in Depth.....	inches	15
Price		
Shipped boxed regularly.....		

NOTE—Setting Down Attachment is easily detached. If not required, specify without Setting Down Attachment. One Seaming Head with Deflector and eight Discs are furnished. Straight Discs, 4, 5½ and 8½ inches. Flaring Discs, 4½, 6½, 7¾, 8¾ and 11 inches.

GENERAL DESCRIPTION.

This machine is fitted with Setting Down Attachment and will take the place of a regular Setting Down Machine, where the work is of a uniform character, or where many of one kind of pails, etc., are to be set down prior to double seaming. It will prove a very desirable Double Seaming Machine for work in Tinware manufacturing.

For further information, refer to Page 299

1819

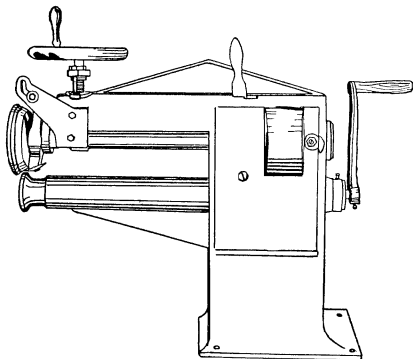
Moore's

PEXTO

Pattern

1919

DOUBLE SEAMING MACHINES No. 640 Series



Capacity—Nos. 640-640½—No. 22 Gauge Iron and Lighter.
Capacity—Nos. 641-641½—No. 24 Gauge Iron and Lighter.
Capacity—Nos. 642-642½—No. 20 Gauge Iron and Lighter.

	Hand	Hand	Hand	Power	Power	Power
New Number	640	641	642	640½	641½	642½
Code Word	640, Pextomood; 641, Pextomoot; 642, Pextomope; 640½, Pextomoult; 641½, Pextomotion; 642½, Pextomotto					
Old Number	0	00	000	0	00	000
Shipping Weight..... approx. lbs.	330	400	560	360	420	590
Size Pulley.....inches				16x3	16x3	16x3
Speed Pulley..... R. P. M.				25	25	25
Will receive work in depth..inches	16½	26	16	16½	26	16
Size Lower Seaming Face..inches	3½	6	6	3½	6	6
Smallest Diameter work than can be double seamed full depth of throat.....	6½	7½	12	6½	7½	12
Price						
Shipped Crated Regularly.....						

NOTE—Nos. 640½, 641½ and 642½ are constructed for Power and fitted with Tight Pulley.

GENERAL DESCRIPTION.

These machines are substantially constructed and intended for heavy work. Their operation is very simple and are most suitable for general double seaming. With these machines extra discs are not required.

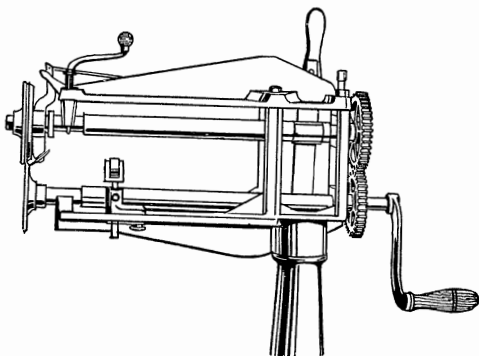
Important Information Page 299

305

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DOUBLE SEAMING MACHINES

Nos. 644 and 646



Capacity—No. 26 Gauge Iron and Lighter.

New Number	644	646
Code Word	Pextomooore	Pextomohre
Old Number	644	646

Shipping Weight.....	approximately lbs.	100	60
Will receive Work in Depth.....	inches	15 ½	10
Size of Lower Seaming Face.....	inches	4 ½	3
Price			
Shipped boxed regularly.....			

GENERAL DESCRIPTION.

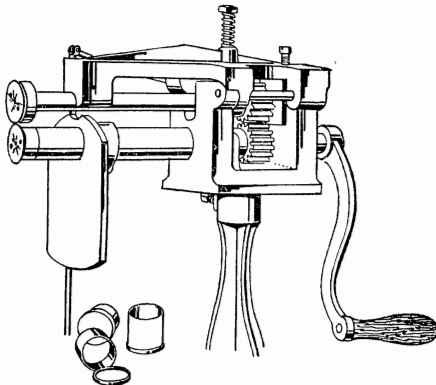
These Double Seaming Machines are adapted for general use. They are well suited to the wants of the trade who desire a machine for small work. The size of the lower face determines the smallest size bottom that can be double seamed. With these machines Extra Discs are not required. They are so simple in construction and easy to operate, that they are preferred for all around double seaming over other types.

Important Information Page 299

PEXTO means value as you know you are buying the same good make and grade that you bought years ago.

BOTTOM FASTENING MACHINE

No. 600



Capacity—No. 27 Gauge Iron and Lighter.

New Number	500
Code Word	Pextopic
Old Number	2

Shipping Weight.....	approximately lbs.	75
Depth Throat to Frame.....	inches	7½
Depth Throat to Gauge.....	inches	6
Diameter of Lower Face.....	inches	1½
Will Crimp Bottoms on Cylinders as small as . . . diam.inches		1¾
Price with Standard.....		
Shipped boxed regularly.....		

NOTE—Furnished with No. 975 Standard, Page 238

GENERAL DESCRIPTION.

These machines are intended for Crimping or Fastening Bottoms to the bodies of Cans, Boxes, etc., where a double seamed bottom is not required. When preparing bottoms for crimping, the edges are turned up at right angles with the Burring Machine and then fitted and crimped fast to the plain body. The Gauges are so arranged as to be adjusted with ease and accuracy and the Top Roller is depressed with a Foot Treadle. When so ordered, they can be arranged to run by power.