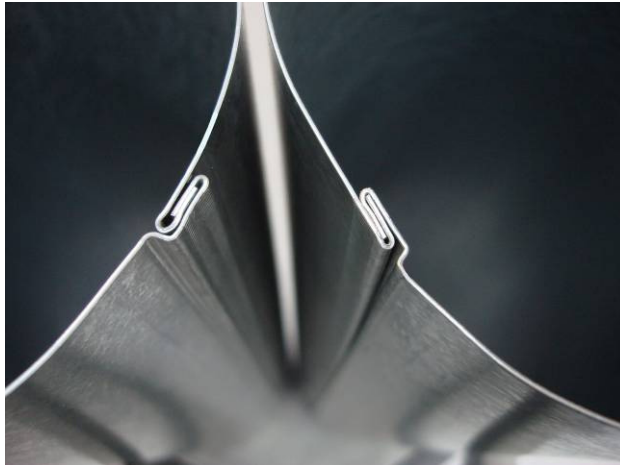




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## Seamed joints on pipes



**Seam combination with longitudinal seam and open hem seam: facing outside (left) and inside (right)**

If you want to make a pipe out of sheet metal and you want to close the rounded material with a seam, there are two options. First, you use the RAS SpeedySeamer and rollform a seam on both ends of the blank. After the first run, you flip the workpiece so that the two seams face in different directions. Then you round the sheet on a rolling machine and hangs the two folds in each other.



**Longitudinal seam plus open hem seam**

Finally you close the seam on RAS 25.15 seam closing machine. Depending on the machine setting the closed fold faces either to the inside or the outside of the pipe. Means: you can either achieve a flat outside or inside surface.

### Cost efficient solution

For a cost efficient solution you can setup the RAS SpeedySeamer with the 11 mm longitudinal seam. As an advantage you need only a

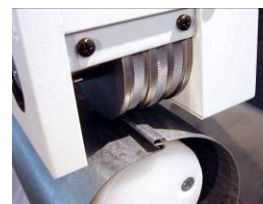
single set of rolls to produce the seams. However, if you hang two longitudinal seams in each other the quantity of material is too much and the seam closing machine deforms the extra material uncontrolled. Moreover, it is hard to predict if the seam closing machine will close the seam outside flush or inside flush.



**Seamed joint with two longitudinal seam: Uncontrolled material deformation close to the joint**

### Perfect visual joint

You will achieve a perfect visual joint by using a longitudinal seam and open hem seam combination. Here, the flange length of the open hem seam needs to be reduced to about 7 mm by adjusting the SpeedySeamer's run-in guide rail. This is also the smallest dimension that can be achieved with the open hem rolls. This option can be used for galvanized steel sheets up to about 0.75 mm.



**Seam facing outside**



**Seam facing inside**

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