



DOUBLE SEAM LOCK



HOOKED TOGETHER  
FOR ASSEMBLY



DOUBLE SEAM CLOSED  
BY GROOVING TOOL  
OR MALLETING TOGETHER

*The Double Seam* is probably the most common method used in sheet metal shapes, since it can be used for light and heavy gauge materials—30 gauge through 16 gauge.

In all cases the Double Seam is formed and completely assembled in the shape

before it is taken to the job for installation. The pipe is cut there to correct length with hand snips.

The Double Seam can be formed on standard rolls available for LOCKFORMER Pittsburgh Machines. (See chart on Page 3.)

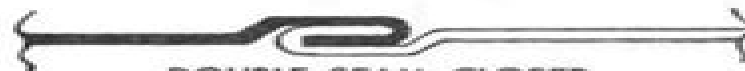
### C. HOW TO MAKE THE DOUBLE-SEAM LOCK



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The Double Seam is also called "Acme lock", "hammer lock" and "pipe lock" in the sheet metal trade. It is normally used in the fabrication and joining of the round pipe or in joining or piecing together two sheets of metal to form a large wrap-around section for square or rectangular ductwork.

The double seam can be run as an auxiliary operation on the Pittsburgh type machines, (Models 20, 22, Super-Speed 20, 18 or 16 gauge LOCKFORMERS), CLEATFORMER 8600 series, SUPER-SPEED CLEATFORMER, or auxiliary of BUTTON-PUNCH SNAP LOCK Machines.

Double Seam locks can be produced in 16 through 30 gauge material, depending on type of rolls and machine to be used.

Type L—16 through 22 gauge

Type S—22 through 28 gauge

The above are all available on Model 16 or 18 gauge LOCKFORMER, or SUPER-SPEED CLEATFORMER or BUTTON-PUNCH SNAP LOCK Machines as auxiliary operations.

Standard Double Seam (20-26 ga.) can be produced on 20 or 22 ga. LOCKFORMER or SUPER-SPEED 20 LOCKFORMER.

# Pittsburgh Lock Sheet Metal Roll Manual

**Victor M. Corman**



## **Pittsburgh Lock Sheet Metal Roll Manual:**

Metal, Construction Industry Series, Student Manual, Preparation Level United States. Office of Education, 1975  
**NAVDOCKS.** , **Catalog** Kelley-Howe-Thomson Company, 1993 Manual of the Railroads of the United States , 1878  
**Manual Training Magazine** Charles Alpheus Bennett, William Thomas Bawden, 1928 Sheet Metal Worker , 1920  
*Poor's Manual of the Railroads of the United States ...* , 1877 The American Architect Specification Manual , 1920  
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web donor whereas a base generically represented by  $b$  is a proton acceptor when acids and bases combine they swap a proton  $h_a$   $b + h_b$  strong acids e.g. sulfuric acid have a very pronounced tendency to transfer a proton to a base whereas weak acids

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web understand that parts of an acid base titration be able to determine the  $K_a$  or  $K_b$  from pH data associated with the titration of a weak acid or base be able to determine the molar mass of a solid monoprotic acid from titration data be able to calculate  $K_{a1}$  and  $K_{a2}$  for a polyprotic acid by the end of this lab students should be able to

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web 1 approximately 3 g of hydrated oxalic acid  $\text{H}_2\text{C}_2\text{O}_4 \cdot 2\text{H}_2\text{O}$  was weighted to the nearest 0.01 g in a 50 ml beaker 2 about 30 ml of distilled water was added to the beaker to dissolve the oxalic acid 3 the solution was transferred into 250 ml volumetric flask the beaker was rinsed and its contents were poured into the flask

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death g7 c a7 dsus d and still we celebrate for you are with us here g d b7 and we believe that we will see you em g7 c when  
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