



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

Kelley-Howe-Thomson Company



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**
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Table of Contents Pittsburgh Lock Sheet Metal Roll Manual

1. Understanding the eBook Pittsburgh Lock Sheet Metal Roll Manual
 - The Rise of Digital Reading Pittsburgh Lock Sheet Metal Roll Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Pittsburgh Lock Sheet Metal Roll Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Pittsburgh Lock Sheet Metal Roll Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Pittsburgh Lock Sheet Metal Roll Manual
 - Personalized Recommendations
 - Pittsburgh Lock Sheet Metal Roll Manual User Reviews and Ratings
 - Pittsburgh Lock Sheet Metal Roll Manual and Bestseller Lists
5. Accessing Pittsburgh Lock Sheet Metal Roll Manual Free and Paid eBooks
 - Pittsburgh Lock Sheet Metal Roll Manual Public Domain eBooks

- Pittsburgh Lock Sheet Metal Roll Manual eBook Subscription Services
- Pittsburgh Lock Sheet Metal Roll Manual Budget-Friendly Options
- 6. Navigating Pittsburgh Lock Sheet Metal Roll Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Pittsburgh Lock Sheet Metal Roll Manual Compatibility with Devices
 - Pittsburgh Lock Sheet Metal Roll Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Pittsburgh Lock Sheet Metal Roll Manual
 - Highlighting and Note-Taking Pittsburgh Lock Sheet Metal Roll Manual
 - Interactive Elements Pittsburgh Lock Sheet Metal Roll Manual
- 8. Staying Engaged with Pittsburgh Lock Sheet Metal Roll Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Pittsburgh Lock Sheet Metal Roll Manual
- 9. Balancing eBooks and Physical Books Pittsburgh Lock Sheet Metal Roll Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Pittsburgh Lock Sheet Metal Roll Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Pittsburgh Lock Sheet Metal Roll Manual
 - Setting Reading Goals Pittsburgh Lock Sheet Metal Roll Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Pittsburgh Lock Sheet Metal Roll Manual
 - Fact-Checking eBook Content of Pittsburgh Lock Sheet Metal Roll Manual
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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