HVAC Rollforming and Sheet Metal Equipment

Manufactured in the U.S.A.

Vicon Machinery LLC
Where superior duct work begins.
Where superior duct work begins.™

The Vicon line of HVAC Rollforming and Sheet Metal Equipment is the industry proven solution for all of your duct shop needs. Backed by the Vicon name and over 40 years of engineering experience, you can be assured that every Vicon machine is designed and built to provide years of quality service and customer satisfaction. All Vicon machinery is 100% manufactured in the USA in our 50,000 square foot manufacturing facility located in Pevely, MO. Every member of the Vicon team is committed to delivering American made quality equipment and superior customer service to the industry – bearing in mind the necessary components for complete customer success. Innovative technology, impeccable workmanship, and unrivaled support – we pride ourselves as the leader in complete turn-key solutions.

Our commitment...
Keep manufacturing where it belongs.
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The Vicon V8 Eight-Station Pittsburgh Rollformer can be optionally tooled with either Right Angle Flange, 4-in-1 or Acme Lock Rolls. All V8 rollformers produce seams that exceed the standards set by SMACNA.

<table>
<thead>
<tr>
<th>Model</th>
<th>Left Outboard (Female)</th>
<th>Speed</th>
</tr>
</thead>
<tbody>
<tr>
<td>V8-P20</td>
<td>Small Pittsburgh 20-28 Ga (5/16” pocket), 1” Notch</td>
<td>90 FPM</td>
</tr>
<tr>
<td>V8-P18</td>
<td>Large Pittsburgh 18-24 Ga (7/16” pocket), 1-3/8” Notch</td>
<td>90 FPM</td>
</tr>
<tr>
<td>V8-P16</td>
<td>Large Pittsburgh 16-20 Ga (7/16” pocket), 1-3/8” Notch</td>
<td>45 FPM</td>
</tr>
</tbody>
</table>

**Features & Benefits**

- Quietest machine in the industry
- Eight forming stations for all roll sets - no opening roll on any roll set
- Large, heavy duty bearings with inner races and grease fittings protect roll shafts and extend bearing life of the machine
- Slide out shaft design allows for easy maintenance
- Heavy duty 1” diameter stress proof roller shafts
- Woodruff shaft keys for added strength and precise alignment
- 5 HP motor coupled to an industrial oil bath worm gear drive for longevity
- Heavy duty roller chain drive, no belts
- Heavy duty motor starter with thermal protection overloads

**Options**

- Right Angle Flange Rolls
  20-28 Ga. (1/4” - 7/16”)
  16-24 Ga. (1/4” - 7/16”)

- 4-in-1 Rolls (22 Ga. - 28 Ga.) to produce clinch, small standing seam, 7/16” flange and male 1/4 edge

- Acme Lock (Double Seam) Rolls
  (20 Ga.-28 Ga.) or (16 Ga.-22 Ga.)

- 5 Gallon Sealant System for sealing Pittsburgh Lock (1 Gun)

- 5 HP Single Phase Motor (90 FPM)

- 3 HP Single Phase Motor (60 FPM)
  (18 gauge and lighter)

- Additional options available
V8 Snaplock Rollforming Machines

**features & benefits**

- Quietest machine in the industry
- Eight forming stations for all roll sets - no opening roll on any roll set
- Large, heavy duty bearings with inner races and grease fittings protect roll shafts and extend bearing life of the machine
- Slide out shaft design allows for easy maintenance
- Heavy duty 1” diameter stress proof roller shafts
- Woodruff shaft keys for added strength and precise alignment
- 5 HP motor coupled to an industrial oil bath worm gear drive for longevity
- Heavy duty roller chain drive, no belts
- Heavy duty motor starter with thermal protection overloads

The VICON V8 Eight-Station Snaplock Rollformer can be tooled with either Button Punch Snaplock or Round Pipe Snaplock. All V8 rollformers produce seams that exceed the standards set by SMACNA.

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**Model** | **Type** | **Left Outboard (Female)** | **Right Outboard (Male)** | **Speed**
--- | --- | --- | --- | ---
V8-SL20 | Button Punch Snaplock | Snaplock 20-28 Gauge, 1-3/8” Notch | Male Button Punch 20-28 Gauge, 7/16” Notch | 90 FPM
V8-RPSL | Round Pipe Snaplock | Modified Reeves Lock 24-30 Gauge | Modified Reeves Lock 24-30 Gauge | 90 FPM

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V8 Button Punch Snaplock

V8 Round Pipe Snaplock

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**options (Pittsburgh & Snaplock)**

▶ Crossover System:

Two machines tooled and positioned to allow for faster production rates of Pittsburgh & Snaplock
The Vicon V8 Slip & Drive Rollformer produces connections that exceed the standards set by SMACNA. This eight station rollformer is equipped with Flat “S” and Drive Cleat tooling inboard and can be equipped with your choice of outboard tooling such as Pittsburgh, Snaplock, 4-in-1, or Acme Lock rolls depending on shop requirements. An optional high speed slitter is available to produce slips and drives from scrap metal, saving labor and material.

**Features & Benefits**

- Quietest machine in the industry
- Eight forming stations for all roll sets - no opening roll on any roll set
- Large, heavy duty bearings with inner races and grease fittings protect roll shafts and extend bearing life of the machine
- Slide out shaft design allows for easy maintenance
- Heavy duty 1" diameter stress proof roller shafts
- Woodruff shaft keys for added strength and precise alignment
- 5 HP/3 Phase motor coupled to an industrial oil bath worm gear drive for longevity
- Heavy duty roller chain drive, no belts
- Heavy duty motor starter with thermal protection overloads
- 90 FPM Pitch Speed

**Options**

- Slitter Attachment
- 5 Gallon Sealant System for sealing Pittsburgh Lock (1 Gun)
- 5 HP Single Phase Motor (90 FPM)
- 3 HP Single Phase Motor (60 FPM)
- Additional options available
# V8 Outboard Optional Tooling

<table>
<thead>
<tr>
<th>Outboard Tooling Options</th>
<th>Location</th>
<th>Profile</th>
</tr>
</thead>
<tbody>
<tr>
<td>Female Snaplock 20-30 Gauge, 5/8” Pocket, 1-3/8” Notch</td>
<td>Left</td>
<td><img src="image" alt="Female Snaplock" /></td>
</tr>
<tr>
<td>Male Snaplock 20-30 Gauge, 7/16” Notch</td>
<td>Right</td>
<td><img src="image" alt="Male Snaplock" /></td>
</tr>
<tr>
<td>Small Pittsburgh 20-28 Gauge, 5/16” Pocket, 1” Notch</td>
<td>Left</td>
<td><img src="image" alt="Small Pittsburgh" /></td>
</tr>
<tr>
<td>Large Pittsburgh 18-24 Gauge, 7/16” Pocket, 1-3/8” Notch</td>
<td>Left</td>
<td><img src="image" alt="Large Pittsburgh" /></td>
</tr>
<tr>
<td>Large Pittsburgh 16-20 Gauge, 7/16” Pocket, 1-3/8” Notch</td>
<td>Left</td>
<td><img src="image" alt="Large Pittsburgh" /></td>
</tr>
<tr>
<td>Right Angle Flange 20-28 Gauge 1/4” - 7/16”</td>
<td>Right</td>
<td><img src="image" alt="Right Angle Flange" /></td>
</tr>
<tr>
<td>Right Angle Flange 16-24 Gauge 1/4” - 7/16”</td>
<td>Right</td>
<td><img src="image" alt="Right Angle Flange" /></td>
</tr>
<tr>
<td>4-in-1 Rolls - 22-28 Gauge, 5/8” Tap-In, 5/8” Standing Seam, 9/16” Male Seam, 1/4” Male Pittsburgh</td>
<td>Right</td>
<td><img src="image" alt="4-in-1 Rolls" /></td>
</tr>
<tr>
<td>Acme Lock (Double Seam) 20-28 Gauge</td>
<td>Right</td>
<td><img src="image" alt="Acme Lock" /></td>
</tr>
<tr>
<td>Acme Lock (Double Seam) 16-22 Gauge</td>
<td>Right</td>
<td><img src="image" alt="Acme Lock" /></td>
</tr>
</tbody>
</table>

**Note:** Additional profiles are available, inquire within.
The Vicon TDX 16 Station Rollformer is tooled to produce the T-25b transverse flange (four-bolt) connection. This profile has been evaluated by the SMACNA Testing and Research Institute and meets testing criteria as called for in SMACNA’s HVAC Duct Construction Standards.

The TDX Rollformer is equipped with one set TDX tooling mounted left outboard and has one inboard and one outboard roll space available for optional tooling based on shop requirements.

**Features & Benefits**

- Sixteen (16) Forming Stations for superior quality
- 18 – 26 Ga. Material Capacity – no adjustments necessary between gauges (16 ga option available)
- 70 FPM Forming Speed
- Independent adjustment at each forming station with pre-set spring tension
- Large, heavy duty bearings with inner races and grease fittings protect roll shafts and extend bearing life of the machine
- Slide out shaft design allows for easy maintenance
- Heavy duty 1-1/4” diameter stress proof roller shafts
- Woodruff shaft keys for added strength and precise alignment
- Hardened infeed guides reduce wear from plasma cut edge
- 7.5 HP Motor coupled to industrial oil bath gear reducer for quiet longevity
- Heavy duty roller chain drive, no belts

**Tooling Options**

<table>
<thead>
<tr>
<th>Tooling Options</th>
<th>Location</th>
<th>Profile</th>
</tr>
</thead>
<tbody>
<tr>
<td>1-1/8” 20-24 Gauge Standard Standing “S”</td>
<td>Inboard</td>
<td><img src="image1" alt="Tooling Option 1" /></td>
</tr>
<tr>
<td>TDX Clip 2-1/4” Material 20-22 ga 16 Station 12 Station</td>
<td>Inboard Outboard</td>
<td><img src="image2" alt="Tooling Option 2" /></td>
</tr>
<tr>
<td>1-5/8” 16-20 Gauge 2-in-1 Standing Seam</td>
<td>Outboard</td>
<td><img src="image3" alt="Tooling Option 3" /></td>
</tr>
<tr>
<td>1-1/8” 18-24 Gauge 3-in-1, Tap-In-Lock, Standing Seam &amp; Right Angle Flange (10 Stations)</td>
<td>Outboard</td>
<td><img src="image4" alt="Tooling Option 4" /></td>
</tr>
<tr>
<td>2” x 2” Angle, 16 Gauge Capacity</td>
<td>Outboard</td>
<td><img src="image5" alt="Tooling Option 5" /></td>
</tr>
<tr>
<td>16-20 Gauge 7/16” Pittsburgh (8 Stations), 1-3/8” Notch</td>
<td>Outboard</td>
<td><img src="image6" alt="Tooling Option 6" /></td>
</tr>
<tr>
<td>18-26 Gauge 7/16” Pittsburgh (8 Stations), 1-3/8” Notch</td>
<td>Outboard</td>
<td><img src="image7" alt="Tooling Option 7" /></td>
</tr>
<tr>
<td>Special Option Available TDX 16-24 Gauge Capacity 50 FPM</td>
<td>Outboard</td>
<td><img src="image8" alt="Tooling Option 8" /></td>
</tr>
<tr>
<td>TDX “C” 18-26 Gauge (T-25a)</td>
<td>Outboard</td>
<td><img src="image9" alt="Tooling Option 9" /></td>
</tr>
</tbody>
</table>
The Vicon TDX-II 12 Station Rollformer is tooled to produce the T-25a transverse flange (four-bolt) connection. This profile has been evaluated by the SMACNA Testing and Research Institute and meets testing criteria as called for in SMACNA’s HVAC Duct Construction Standards.

The TDX-II Rollformer is equipped with one set TDX-II tooling mounted left outboard standard and has one inboard and one outboard roll space available for optional tooling based on shop requirements.

**Features & Benefits**

- Twelve (12) Forming Stations
- 18 – 26 Ga. Material Capacity – no adjustments necessary between gauges
- 50 FPM Forming Speed
- Large, heavy duty bearings with inner races and grease fittings protect roll shafts and extend bearing life of the machine
- Slide out shaft design allows for easy maintenance
- Heavy duty 1-1/4” diameter stress proof roller shafts
- Woodruff shaft keys for added strength and precise alignment
- Hardened infeed guides reduce wear from plasma cut edge
- 5 HP Motor coupled to industrial oil bath gear reducer for quiet longevity
- Heavy duty roller chain drive, no belts

<table>
<thead>
<tr>
<th>Tooling Options</th>
<th>Location</th>
<th>Profile</th>
</tr>
</thead>
<tbody>
<tr>
<td>1-5/8” 20-22 Gauge Standing “S”</td>
<td>Inboard</td>
<td><img src="image" alt="1-5/8” 20-22 Gauge Standing “S”" /></td>
</tr>
<tr>
<td>TDX Clip 20-22 Gauge 2-1/4” Material</td>
<td>Inboard or Outboard</td>
<td><img src="image" alt="TDX Clip 20-22 Gauge 2-1/4” Material" /></td>
</tr>
<tr>
<td>TDX-II “C” Style 18-26 Gauge (T-25a)</td>
<td>Outboard</td>
<td><img src="image" alt="TDX-II “C” Style 18-26 Gauge (T-25a)" /></td>
</tr>
<tr>
<td>1-5/8” 16-20 Gauge 2-in-1 Standing Seam</td>
<td>Outboard</td>
<td><img src="image" alt="1-5/8” 16-20 Gauge 2-in-1 Standing Seam" /></td>
</tr>
<tr>
<td>1-1/8” 18-24 Gauge 3-in-1, Tap-In-Lock, Standing Seam &amp; Right Angle Flange (10 Stations)</td>
<td>Outboard</td>
<td><img src="image" alt="1-1/8” 18-24 Gauge 3-in-1, Tap-In-Lock, Standing Seam &amp; Right Angle Flange (10 Stations)" /></td>
</tr>
<tr>
<td>2” x 2” Angle 16 Gauge Capacity</td>
<td>Outboard</td>
<td><img src="image" alt="2” x 2” Angle 16 Gauge Capacity" /></td>
</tr>
<tr>
<td>16-20 Gauge 7/16” Pittsburgh (8 Stations), 1-3/8” Notch</td>
<td>Outboard</td>
<td><img src="image" alt="16-20 Gauge 7/16” Pittsburgh (8 Stations), 1-3/8” Notch" /></td>
</tr>
<tr>
<td>18-26 Gauge 7/16” Pittsburgh (8 Stations), 1-3/8” Notch</td>
<td>Outboard</td>
<td><img src="image" alt="18-26 Gauge 7/16” Pittsburgh (8 Stations), 1-3/8” Notch" /></td>
</tr>
</tbody>
</table>
V12 Rollformer & Optional Tooling

Model V12

The Vicon V12 Rollformer is a twelve station base machine and can be custom configured based on shop requirements.

**Features & Benefits**

- Twelve (12) Forming Stations
- 50 FPM Forming Speed
- Large, heavy duty bearings with inner races and grease fittings protect roll shafts and extend bearing life of the machine
- Slide out shaft design allows for easy maintenance
- Heavy duty 1-1/4” diameter stress proof roller shafts
- Woodruff shaft keys for added strength and precise alignment
- Hardened infeed guides reduce wear from plasma cut edge
- 5 HP Motor coupled to industrial oil bath gear reducer for quiet longevity
- Heavy duty roller chain drive, no belts

<table>
<thead>
<tr>
<th>Tooling Options</th>
<th>Location</th>
<th>Profile</th>
</tr>
</thead>
<tbody>
<tr>
<td>1-5/8&quot; 20-22 Gauge Standing “S”</td>
<td>Inboard</td>
<td><img src="image.jpg" alt="Inboard" /></td>
</tr>
<tr>
<td>1-1/8&quot; 20-24 Gauge Standard Standing “S”</td>
<td>Inboard</td>
<td><img src="image.jpg" alt="Inboard" /></td>
</tr>
<tr>
<td>1/2&quot; 22-26 Gauge Standing “S”</td>
<td>Inboard</td>
<td><img src="image.jpg" alt="Inboard" /></td>
</tr>
<tr>
<td>TDX Clip 20-22 Gauge</td>
<td>Inboard or Outboard</td>
<td><img src="image.jpg" alt="Inboard or Outboard" /></td>
</tr>
<tr>
<td>1-5/8&quot; 16-20 Gauge 2-in-1 Standing Seam</td>
<td>Outboard</td>
<td><img src="image.jpg" alt="Outboard" /></td>
</tr>
<tr>
<td>1-1/8&quot; 18-24 Gauge 3-in-1, Tap-In-Lock, Standing Seam &amp; Right Angle Flange (10 Stations)</td>
<td>Outboard</td>
<td><img src="image.jpg" alt="Outboard" /></td>
</tr>
<tr>
<td>2”x 2” Angle, 16 Gauge Capacity</td>
<td>Outboard</td>
<td><img src="image.jpg" alt="Outboard" /></td>
</tr>
</tbody>
</table>

Other standard tooling options are available with custom tooling profiles.
The Vicon Coil Strip Feed Line can be configured in several ways for production of various profiles. Coil metal stock is uncoiled, straightened and cut to length either before or after the rollform machine depending on the application. The line is controlled by the Vicon PC Control to ensure accurate finished parts and can be synchronized to the Vicon office program.

The coil cradles and machine guides are configured so that the material to be processed is pre-aligned. This added feature minimizes your set-up time.

Vicon can also manufacture coil strip feed lines to produce single wall turning vanes for elbows.

**features & benefits**

- Dual Drop in style Uncoiler shown. Other types of decoilers available.
- Vicon PC Cut-to-Length Control
- Hydraulically driven three (3) roll straightener with additional entrance and exit pinch rolls
- Hydraulic Press with straight shear or contoured dies
- Hole Punch available
- Hydraulic Power Unit
- Length tolerance of ± 1/16”
- 60” Dual Transfer Conveyor supports blanks during the shearing process and feeds blanks up to 60” long into the rollformer
- Tooling profile will determine the required rollformer and processing speeds

**options**

- 120” Dual Transfer System
- Micro processor multi-batch controller

![S&D](image1.png)

![TDX Clip](image2.png)

![1/2” Standing “S”](image3.png)

![1-1/8” Standing “S”](image4.png)

![1-5/8” Standing “S”](image5.png)

![2” x 2” Angle](image6.png)
Plasma Feeder

Save operating costs by reducing scrap and eliminating labor through the use of the VICON Plasma Feeding System. Uncoils, straightens, beads and feeds your various material gauges to your plasma cutting machine.

With the VICON style drum mandrel, the VICON Plasma Feeder is an innovative solution for the easy loading underfed coils. Convenient removable coil keeper end plate is light enough for just one person to attach it to the drum mandrel. A coil can be changed in under five minutes.

Coils will be spooled on VICON’s exclusive patented Coil Drum Assemblies for the fastest coil loading possible. The underfed unit is designed with pneumatic “backup” wheels at each coil station for positive feed-up of each coil and safe band removal on new coils. Roller track system supports the material of the desired coil up to the infeed guide ramp on the plasma feed unit.

<table>
<thead>
<tr>
<th>Overall Length*</th>
<th>One Cradle</th>
<th>Two Cradles</th>
<th>Three Cradles</th>
<th>Four Cradles</th>
<th>Five Cradles</th>
<th>Six Cradles</th>
</tr>
</thead>
<tbody>
<tr>
<td>Underfed Cradle System</td>
<td>17’10”</td>
<td>22’2”</td>
<td>26’6”</td>
<td>30’10”</td>
<td>35’2”</td>
<td>39’6”</td>
</tr>
<tr>
<td>Overfed Cradle System</td>
<td>12’4”</td>
<td>16’8”</td>
<td>21’0”</td>
<td>25’4”</td>
<td>25’4”</td>
<td>25’4”</td>
</tr>
</tbody>
</table>

*Not including Plasma machine

features & benefits

• Capable of handling up to 6 underfed coil cradles
• 16 ga. to 28 ga. mild steel capacity
• Coil widths from 48” to 60” standard
• 12,000 lbs coil capacity
• Hydraulic coil drive for smoother acceleration and deceleration of coils, utilizing auto coil reversal rewind technology
• Powered infeed guide ramp for safe, hands-free coil feeding
• Pneumatic backup wheels at each coil station for safe band removal and positive coil feeding
• Choice of beading either up or down to suit shop standards
• Will feed other existing plasma cutting systems

options

► Individual coil drives on each cradle
► Overfed coil cradles available to reduce floor space
► 72” coil width

With VICON patented style coil spools, coils can be loaded in under 5 minutes.
The Vicon Pittsburgh Seam Closer reliably closes the Pittsburgh seam on duct work ranging from 16 – 26 Ga. and 12” to 60” in length. The heavy-duty “Single V” forming roll closes the Pittsburgh seam from either side, eliminating the need to turn the duct section over to align the Pittsburgh edge with the forming wheels thus saving time and labor.

**features & benefits**

- 16 to 26 Gauge material capacity
- 12” to 60” duct length
- “Single V” Forming Roll with heavy duty bearings and shafts will close the Pittsburgh seam from either side eliminating the need to turn duct section over to align the Pittsburgh edge with the forming wheels
- Grease fittings on the forming roll for longevity
- Easy to clean sealant from forming roll
- Counter balanced top clamp head for easy set-up (no tools required)
- Large, heavy-duty removable clamp pads for easy clean up of duct sealant
- Large, heavy-duty roller chain drive (no cables)
- Easy operation with manual or automatic Push Button Control
- Hydraulic Power Unit (not shown)
- 3 HP Motor (Single or 3-Phase Voltage)

Replaces most existing seam closers without pit modifications. Pit dimensions provided upon request.
Duct Beader

**Model V-2060-BD (20 Ga)**

- **Model V-2060-BD**
  - 20 Gauge Mild Steel Capacity, 60” wide
  - 12 inch bead increments
  - Chain Drive
  - 30 FPM
  - ¼ HP Motor, 115 volt single phase

- **Model V-1860-BD (18 Ga)**
  - 18 Gauge Mild Steel Capacity, 60” wide
  - 12 inch bead increments
  - Chain Drive
  - 40 FPM
  - ½ HP Motor, 115 volt single phase

**Features & Benefits**

- Duct Beader
  - 20 gauge mild steel capacity, 60” wide
  - 12 inch bead increments
  - Chain drive
  - 30 FPM
  - 1/4 HP motor, 115 volt single phase

- **Model V-1860-BD (18 Ga)**
  - 18 gauge mild steel capacity, 60” wide
  - 12 inch bead increments
  - Chain drive
  - 40 FPM
  - 1/2 HP motor, 115 volt single phase

**Options**

- Foot pedal

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Duct Brake

**Model V-TDX-B**

The Vicon Duct Brake forms TDX flanged duct work with quick and easy positioning and 90 degree bending of L-Duct Section, Full Wrapper Duct, and Fittings.

**Features & Benefits**

- 16 Gauge x 5’ Bending Capacity
- Maximum 2” Liner Capacity when forming lined duct
- 6” x 6” minimum full wrapped, unlined duct size
- Pneumatic forming cycle, single foot switch operation for TDX or S&D
- Manual or push button controls
- Timer to control bend sequences
- Precision heavy duty construction
- Adjustable height table for TDX, S&D and Raw
- Slip & Drive capability
- Front support apron
- Retractable notch positioning guide for self-aligning bend location and easier part removal
- 80 PSI / 5 CFM
- 115 Volt / Single Phase

**Options**

- 36” Manual Backgauge
Pneumatic Cheekbender
Model V2418CB

features & benefits

• Designed to form a 90° flange on either side of the unit

![Illustration of 90° flange]

(Optional Button Punch available)

• 18 Gauge mild steel maximum capacity
• 24” wide bending capacity
• Foot pedal control
• Inclined face for ease of use & better ergonomics
• Open ended allowing formation on either side as well as longer flanges with additional cycles
• Welded tubular frame
• Replaceable, hardened wear plate for use with plasma cut edge
• Slide out gauge allows for 1/4” or 7/16” bend

Edge Notcher
Model V-EN-20 (20 Ga)
Model V-EN-18 (18 Ga)

features & benefits

• 18 or 20 Gauge mild steel capacities available
• Variable notch depth up to 1-1/4”
• Variable notch spacing (Factory set at 3/4”)
• Automatically progresses flat parts or round pipe
• Voltage – 110/1/60; 1 HP Motor (20 ga model)
  – 220/1/60; 2 HP Motor (18 ga model)
• Bench mounting recommended
Vicon’s full line of HVAC manufacturing systems are specially engineered to help duct shops compete in today’s highly competitive environment.

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