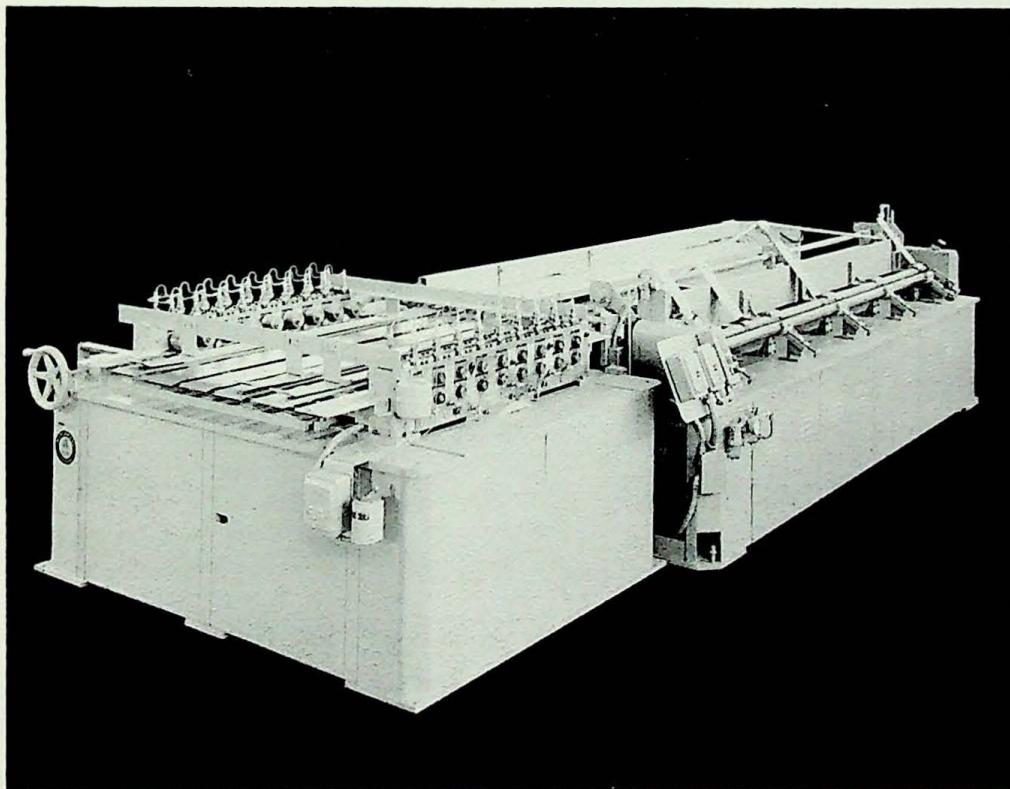


new

MAPLEWOOD

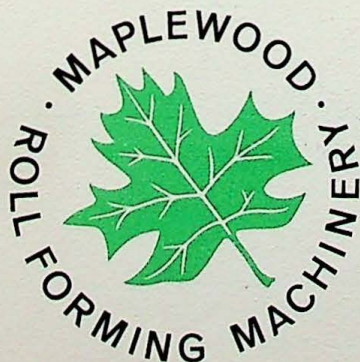
OCT 7 1969

PIPE & ELBOW MACHINES



Star-Tex Machinery Company
3905 Peachtree Rd. Mesquite, Texas 75149
Phone A.C. 214 236-0863

Star-Tex Machinery Company
3905 Peachtree Rd. Mesquite, Texas 75149
Machine Tools Woodworking Machinery Industrial Supplies
8300 SOVEREIGN ROW DALLAS, TEXAS 75247
(214) 638-4050



MAPLEWOOD DIVISION

DIVISION OF GREENLEE BROS. & CO

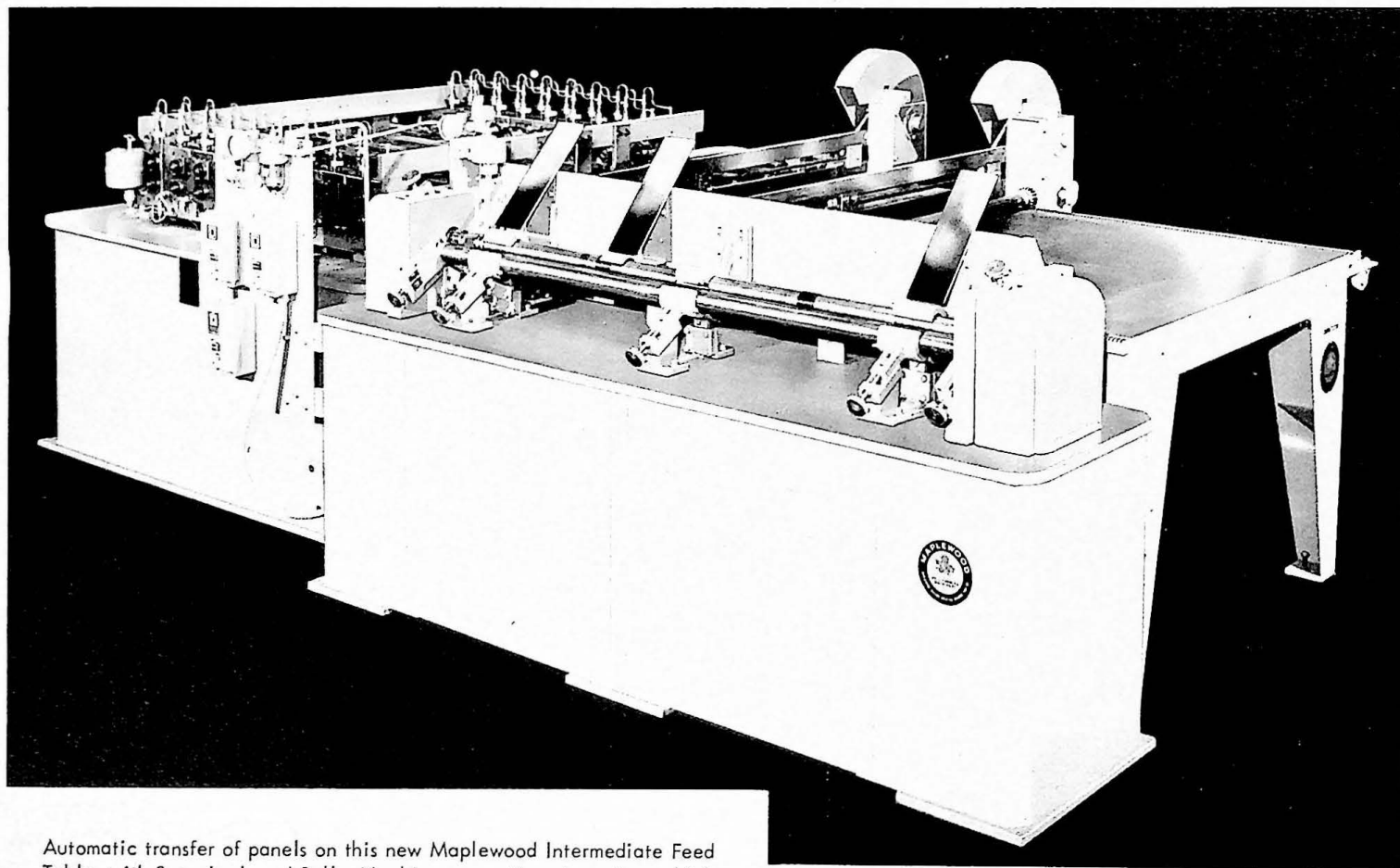
2500 Kishwaukee St., Rockford, Ill. 61101 U.S.A

A Unit of Ex-Cell-O Corporation 

**M
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MAPLEWOOD

SNAP LOCK PIPE PRODUCTION LINE



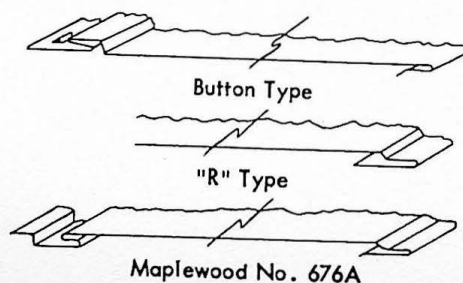
Automatic transfer of panels on this new Maplewood Intermediate Feed Table, with Snap Lock and Roller Machines operating at maximum high speeds, increases production of pipe and duct sections to as much as... 12 - 5 ft. lengths 6" diameter in one minute. Here are brief facts about the 3 new Maplewood machines that comprise this high production unit : G-924 PANEL TYPE SNAP LOCK MACHINE... forms snap locks on... various width sheets simultaneously. This is a 9 station machine with a 24 gauge capacity equipped with needle bearings, hardened and ground spindles, a micrometer dial type upper spindle adjustment for more easily changing from one gauge to another, a 3 HP. 3 Ph. 220/440 volt 60 cycle Electric Motor. Bijur one shot oiling system.

THE H.G. 5' ROLLER MACHINE rolls 4" to 14" diameter pipe after locks are formed on flat sheets... operates on 2 HP. 3 Ph. 220/440 volt, 60 cycle Electric Motor.

NEW MAPLEWOOD AUTOMATIC INTERMEDIATE FEED TABLE... transfers panels from the snap lock machine to the roller machine and makes possible snap lock forming, rolling, beading and crimping in one continuous high speed automatic operation. It is operated by two 1/2 HP. 3 Ph. 220/440 volt 60 cycle Electric Motors.

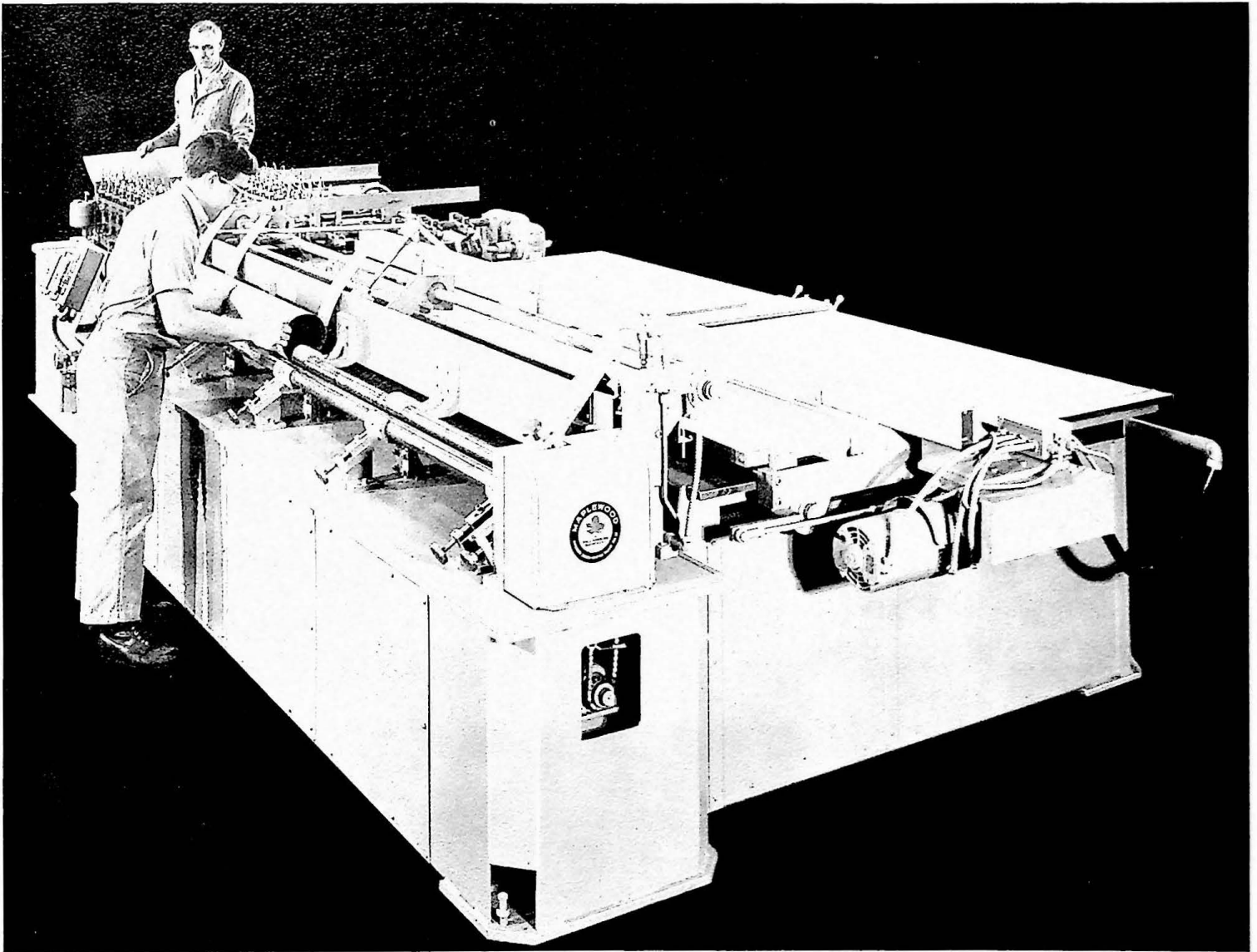
CONVENIENT CONTROLS..... Controls for all three of the above machines are grouped on a single panel.

Capacity : For 5', 3', or 2' Pipe, 4" through 14" diameter.



NEW

HIGH SPEED OFT-HG 10 AUTOMATIC TRANSFER TABLE



The heart of this Maplewood Snap Lock Pipe production line is a completely new concept - the high-speed OFT Automatic Transfer Table.

This revolutionary new transfer table increases line speed (50% more in comparison with the GHA feed table on opposite page) and eliminates the necessity of wide spacing of blanks entering the G-924 panel type snap lock machine. The transfer table and the pipe roll are mounted on a common base to assure permanent accuracy of alignment.

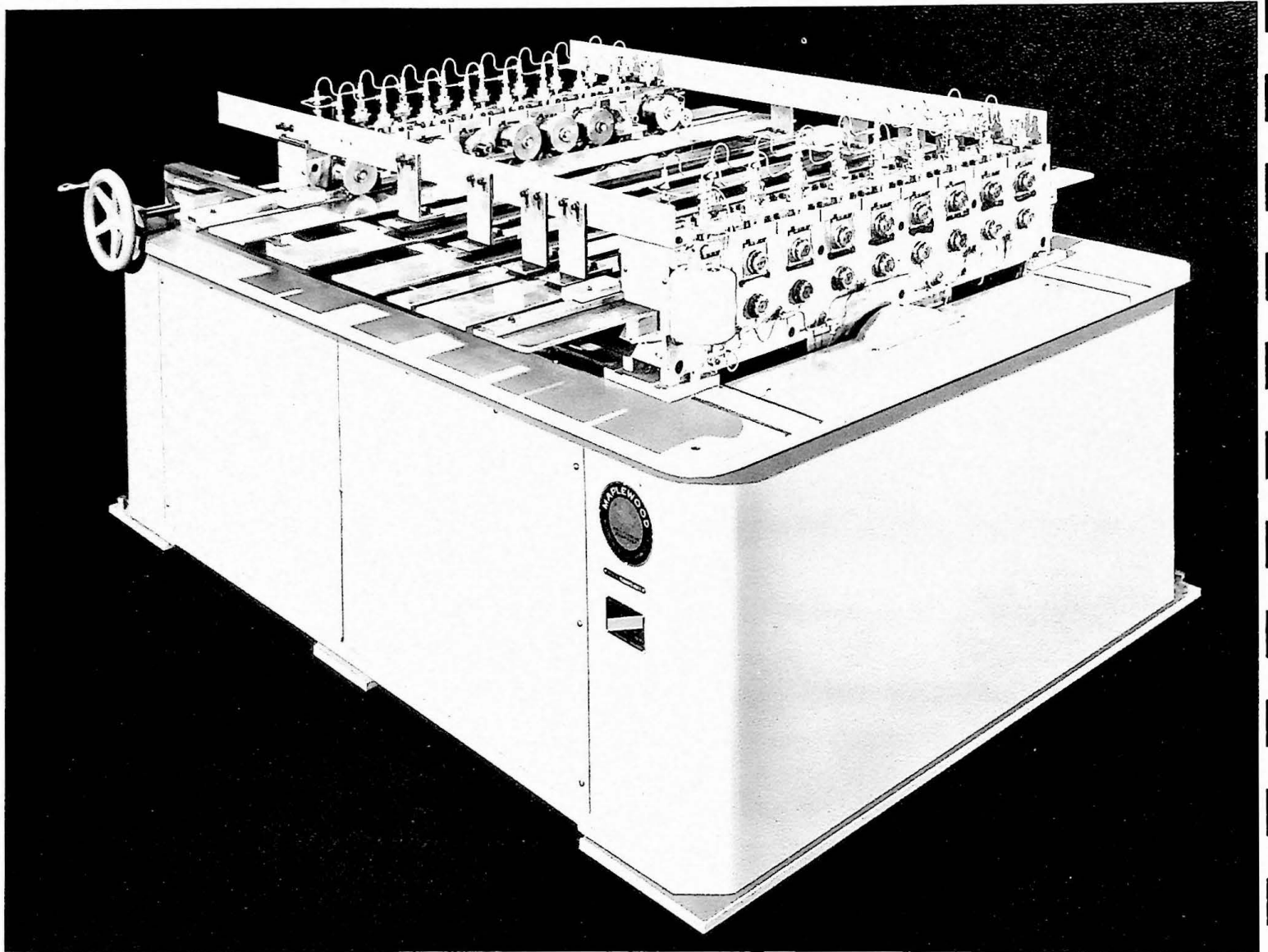
OFT-HG 10 Automatic Transfer Table & Pipe Roll

2-1/2 HP., 3 Ph. 220/440 Volt
60 cycle Geared Motors

Capacity: for 10', 5', 3', or 2'
Pipe, 4" through 14" diameter

This modern, high-speed Maplewood line makes possible snap lock forming, rolling, beading and crimping in one continuous automatic operation with production rates up to 50,000 feet of rolled, crimped and beaded snap lock pipe per 8 hour shift.

G-924 PANEL TYPE SNAP LOCK MACHINE



Forms Snap Locks On Various Width Sheets Simultaneously

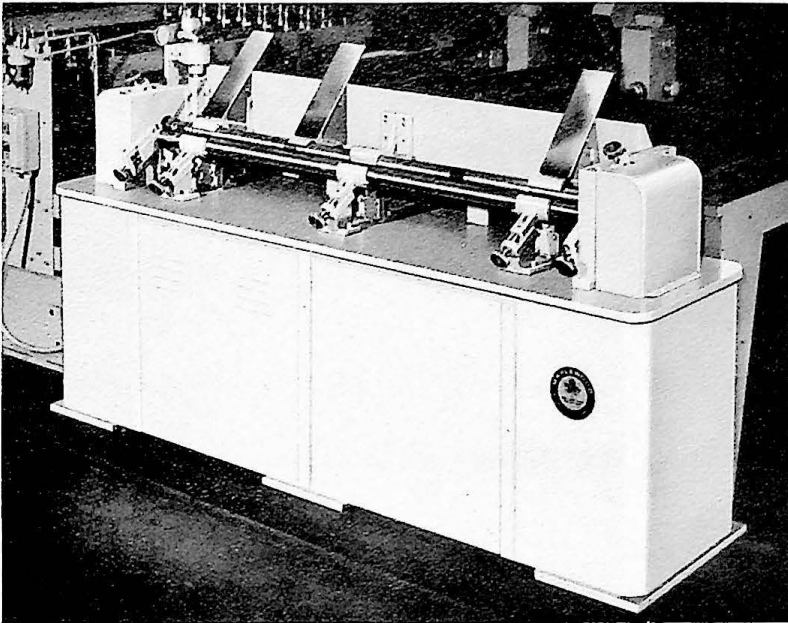
The new G-924 Panel Snap-Lock Machine is a high production machine designed to increase output and cut costs in the fabrication of pipe and duct sections. It is equipped with a micrometer dial-type upper-spindle adjustment for more easily changing from one gauge to another. The roll shafts also have thrust bearings, assuring uniform sections at all times.

This 9 station model forms snap locks on various width sheets simultaneously at high speeds. In combination with a Maplewood Automatic Intermediate Feed Table and a Roller Machine it forms a single production unit and makes possible snap lock forming, rolling, beading and crimping in one continuous high-speed automatic operation. It can streamline your operations and produce more pipe and duct sections per hour at greatly reduced costs.

SPECIFICATIONS

Capacity: "R" Lock, 28-30 ga.
 Maplewood No. 676 A, 24-26-28-30 ga.
 Button Lock 24-26-28-30 ga.
 9 Forming Stations on each Head
 2-3/4" Vertical Distance between Spindles
 5" Horizontal Distance between Spindles
 1" Dia. Spindles, Hardened and Ground
 Needle Bearings
 Forming Speed - 100 F.P.M.
 Manual Starter with Push Button Controls
 Bijur One-Shot Lubricating System
 Individual Upper Spindle Adjustments
 9" - 46" Blank (4" to 14" Diameter Pipe)
 Accommodation between Housings
 Floor Space 36" Length - 78" Width
 3 H.P., 3 Phase, Slow Speed Motor 230 R.P.M.
 Welded Steel Frame, Steel Housings, Steel
 Cut and Heat Treated Gears

H.G.-5 & H.G.-10 PIPE ROLLER MACHINES

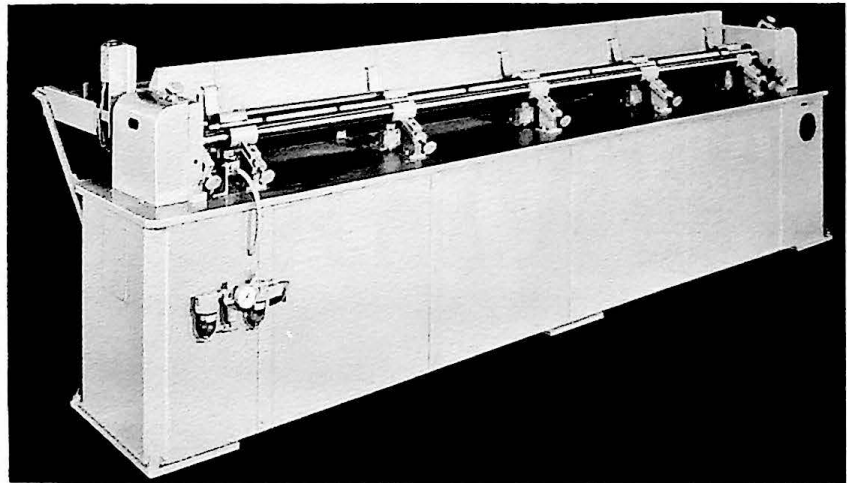


Roll, Crimp & Bead in One Pass

Here is a versatile high production machine that will roll, crimp and bead 4" diameter and larger pipe. Operating in conjunction with our Model G-924 Panel Type Snap Lock Machine and Automatic Intermediate Feed Table, or independently with manual feed table, it will greatly reduce cost of fabricating pipe and duct sections. The machine, operating at 95 F.P.M. rolls, crimps...and beads 24 gauge and lighter mild steel in one pass.

SPECIFICATIONS

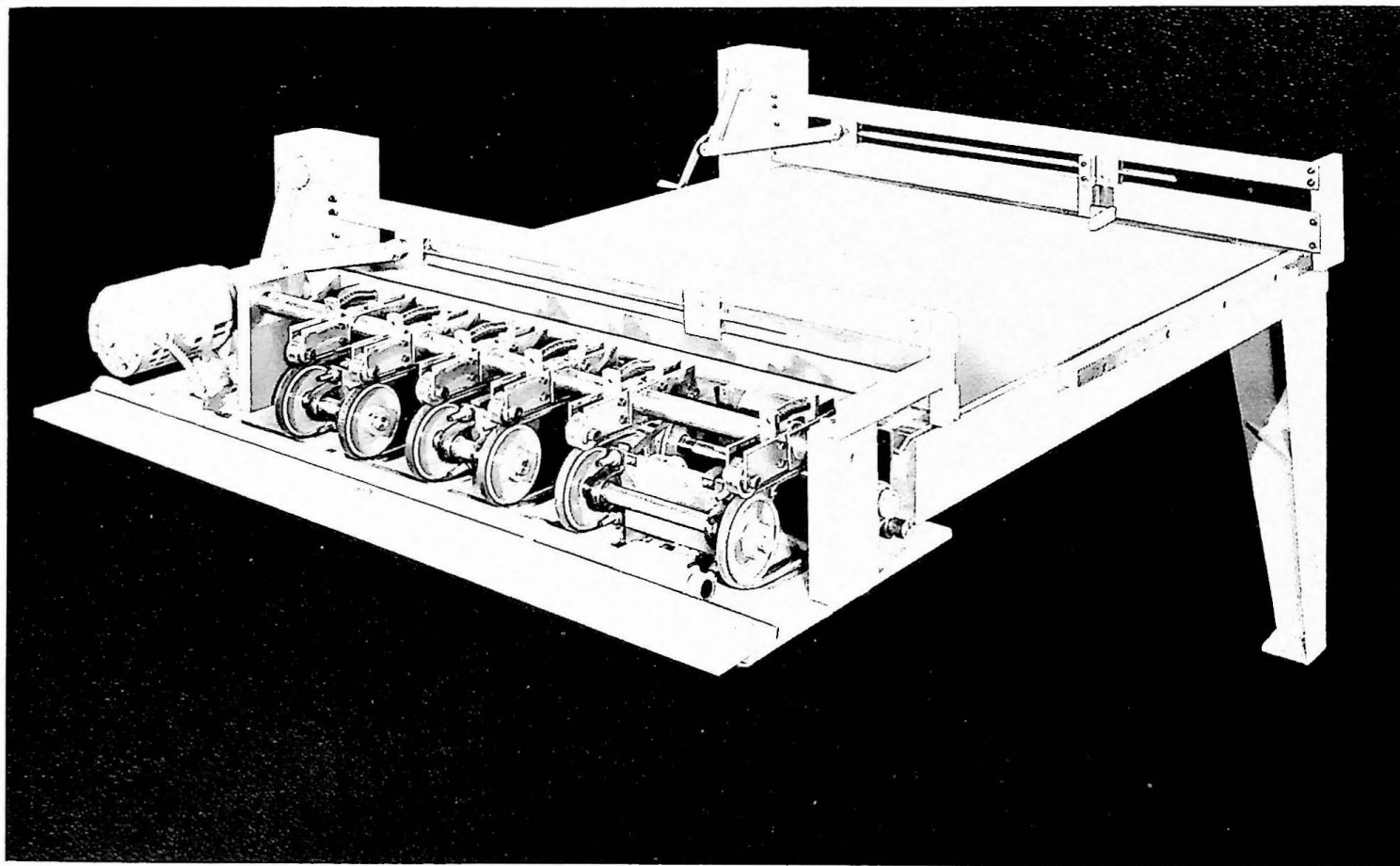
Model H.G. -5 with Micro Switch Trip
Air Lubricator, Filter and Pressure Gauges
24 Ga. Capacity (Mild Steel)
2" Roll Diameters
All Rolls Powered
Anti-Friction Bearings
Forming Speed - 95 F.P.M.
Manual Starter, with Push Button Station
Pressure Grease Type Lubricating Fittings
60" Blank Accommodations between Housings
Floor Space - 90" Length - 24" Width
2 H. P., 3 Phase, 60 Cycle, 220/440 Volt Motor
Direct Chain Drive
Welded Steel Frame, Steel Housings, Steel Cut
and Heat Treated Gears



SPECIFICATIONS

Model H. G. -10 with Micro Switch Trip
Air Lubricator, Filter and Pressure Gauges
24 Ga. Capacity (Mild Steel)
2" Roll Diameters
All Rolls Powered
Anti-Friction Bearings
Forming Speed - 95 F.P.M.
Manual Starter, with Push Button Station
Pressure Grease Type Lubricating Fittings
120" Blank Accommodations between Housings
Floor Space - 156" Length - 30" Width
2 H.P., 3 Phase, 60 Cycle, 220/440 Volt Motor,
Direct Chain Drive
Welded Steel Frame, Steel Housings, Steel Cut
and Heat Treated Gears

GHA-5 & GHA-10 AUTOMATIC INTERMEDIATE FEED TABLE



Here is a completely new design that enables pipe and duct manufacturers to increase production and cut fabricating costs.

The new Maplewood Automatic Intermediate Feed Table produces more pipe and duct sections per hour through less handling and automatic transfer of panels. By automatically transferring the panels from the snap-lock machine to the roller machine, it makes possible snap-lock forming, rolling, beading and crimping in one continuous high-speed automatic operation. It permits the operation of snap-lock and roller machines at maximum high speeds, another aid in reducing costs. An Automatic Intermediate Feed Table combined with other Maplewood machines may be the combination that can increase your output and cut your costs in the fabrication of pipe and duct sections.

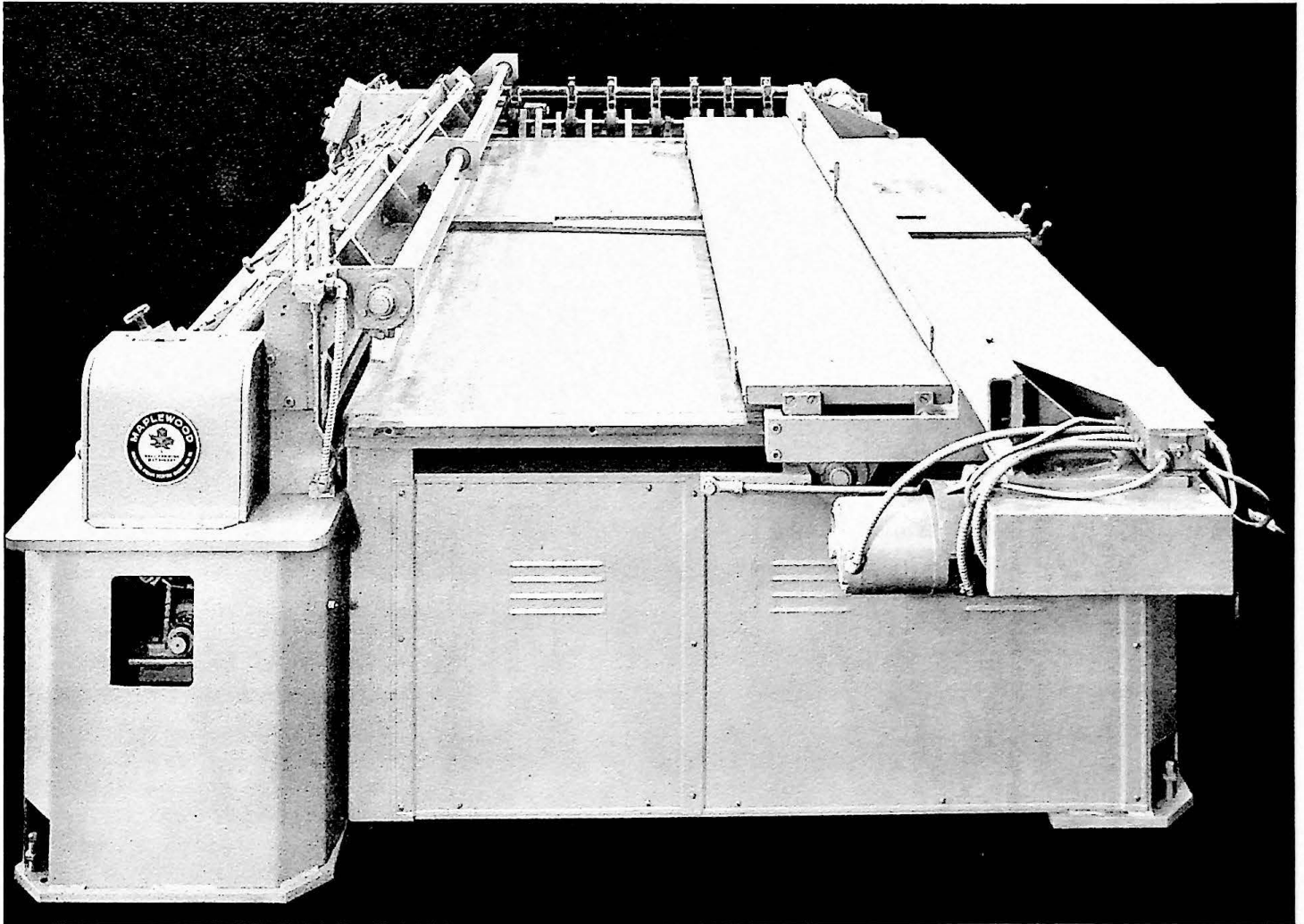
S P E C I F I C A T I O N S

Two 1/2 H.P. 3 Ph. 220/440 Volt 60 cycle Geared Motors

MODEL GHA-5. For 5 ft., 3 ft. or 2 ft. Pipe

MODEL GHA-10. . . For 10 ft., 5 ft., 3 ft. or 2 ft. Pipe

COMBINATION OFT-HG 10 AUTOMATIC TRANSFER TABLE & PIPE ROLL



SPECIFICATIONS

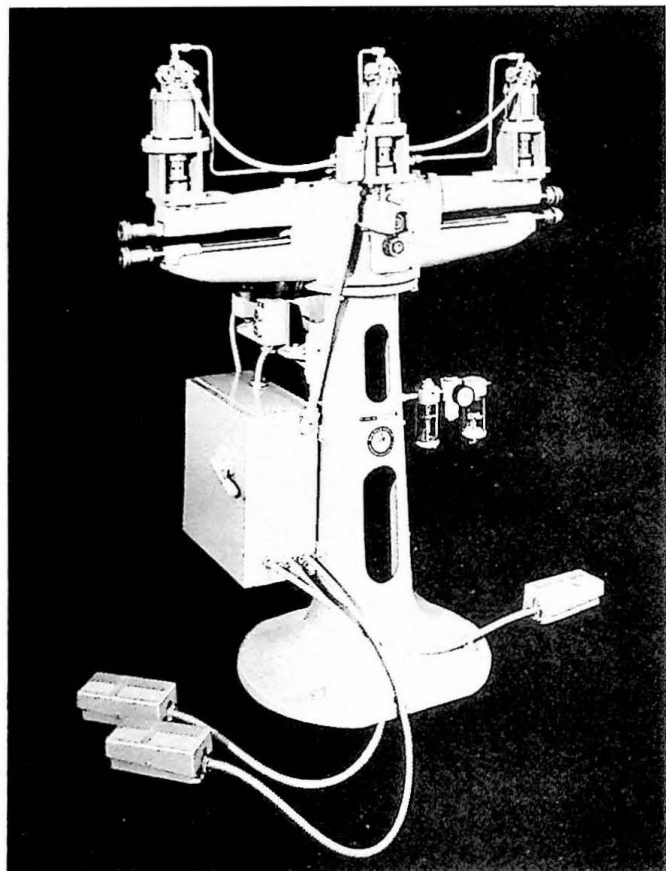
Two 1/2 HP, 3 ph., 220/440 Volt, 60 cycle Geared Motors

Capacity: For 10', 5', 3', or 2' Pipe, - 4" through 14" diameter.

This revolutionary new addition to the Maplewood pipe line insures maximum output at lower costs to the company who requires higher production to fill their customer's demands for snap lock pipe.

Mounting the transfer table and the pipe roll on a common base assures permanent accuracy of alignment. This concept permits a 50% increase in line speed in comparison to the GHA feed table (opposite) and eliminates the necessity of the wide spacing of blanks entering the "G-924" panel type snap loc machine. These innovations now make production rates up to - 50,000 feet of rolled, crimped, and beaded snap lock pipe per 8-hour shift, a reality.

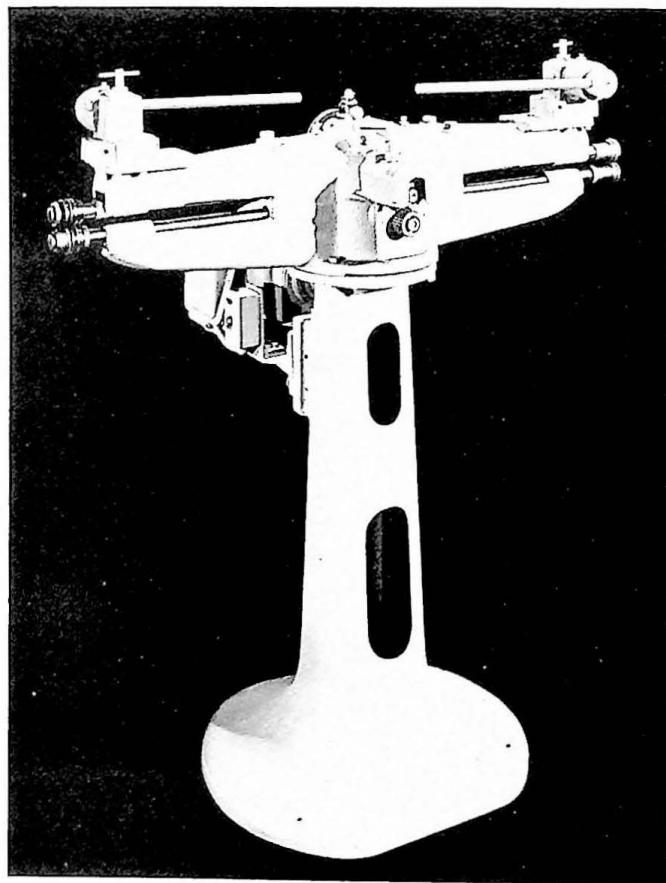
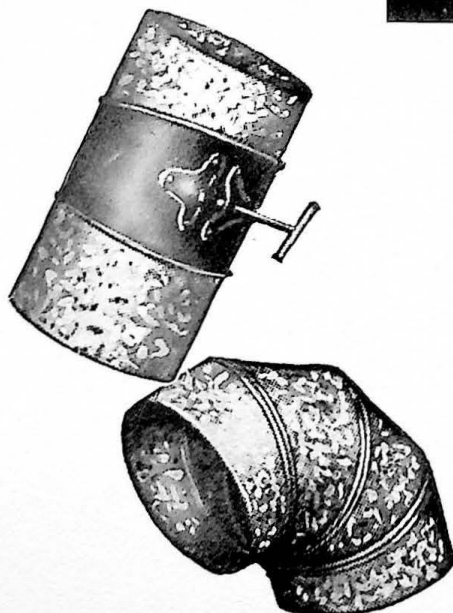
MODEL C & CA ELBOW MACHINE



Model CA - Air Operated

PRODUCE ADJUSTABLE
ELBOWS IN LESS THAN
ONE MINUTE!

The newly designed Maplewood Elbow Machine has an exclusive air-cylinder on each station for lowering the upper roll shaft. The machine cuts and beads each segment in one revolution of the tube and makes a complete elbow without change of rolls. Elbow jigs are available for all sizes from 3" to 36". This is a high production machine that will increase elbow output and bring new profits to all furnace and sheet metal shops.

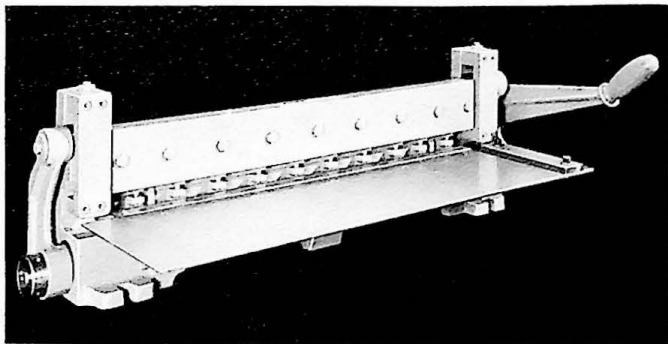


Model C - Manual

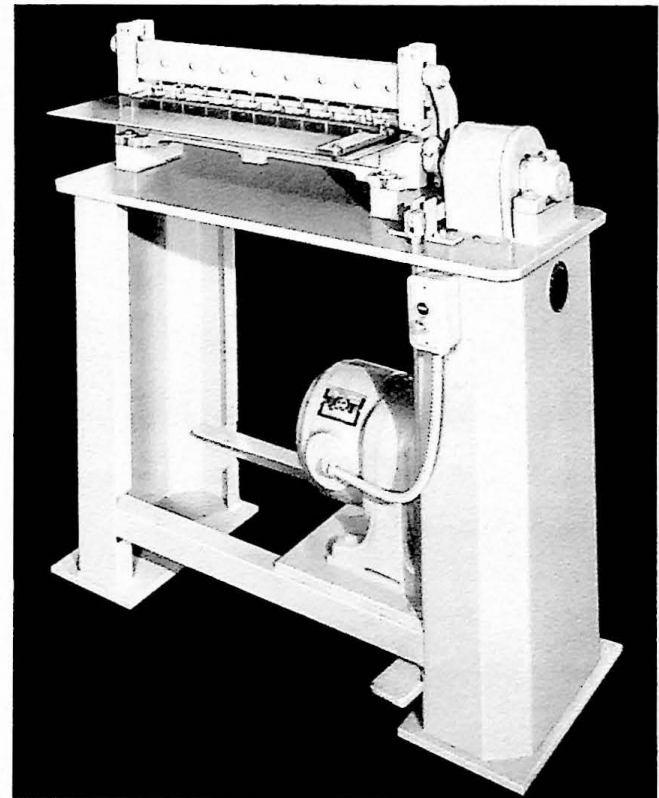
SPECIFICATIONS

MODEL C & MODEL CA AIR-OPERATED
24 Gauge Capacity
Bronze Worm Gears & Bushings
Hardened Worm
3 to 1 Ratio Gearing
4 End Thrust Bearings
1 HP Motor with 3 Speed Arrangements
Top Speed on Roll Shafts 190 r.p.m. (87 F.P.M.)
Shipping Weight - 600 lbs.
Standard Equipment includes Motor, Stand and Crimping Rolls. Model CA also includes air cylinders, switches and regulator.

MODEL "P" HAND GAP GANG PUNCH



MODEL "MP" POWER GAP PUNCH



This is a new and improved machine, especially designed for multiple punching sheets of any length up to 24". The punches and the dies are interchangeable. The stripper and the die are constructed in one piece, and the punch is always in the stripper, resulting in a quick and easy adjustment, by simply loosening a few bolts.

Staggered timing of the punches, as they penetrate the metal, assures greater ease of operation. Holes punched $\frac{3}{8}$ " from the edge of the sheet to the center of the hole, or less, if desired. Minimum centers between punches $\frac{5}{8}$ ".

This accurate Direct Drive quick-acting Gap Gang Punch is economical and convenient to use, quickly paying for itself in time and labor saved.

S P E C I F I C A T I O N S

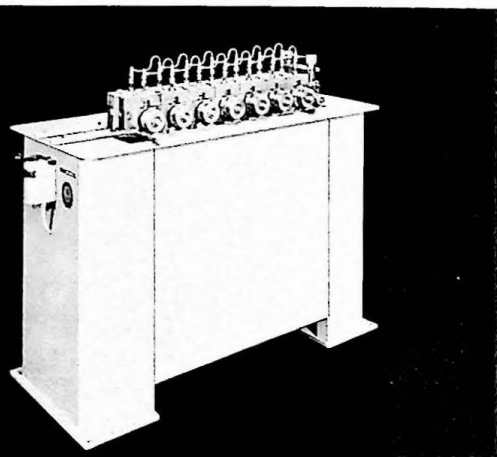
MODEL P HAND GAP GANG PUNCH

Capacity:	
(10) $\frac{9}{64}$ " holes through 24 gauge-mild steel and lighter	
Distance between housing	24-1/2"
Minimum centers between punches	$\frac{5}{8}$ "
Front table	8" x 27-1/2"
Length	33-1/2"
Width	14"
Height	9-1/2"
Weight	135 lbs.

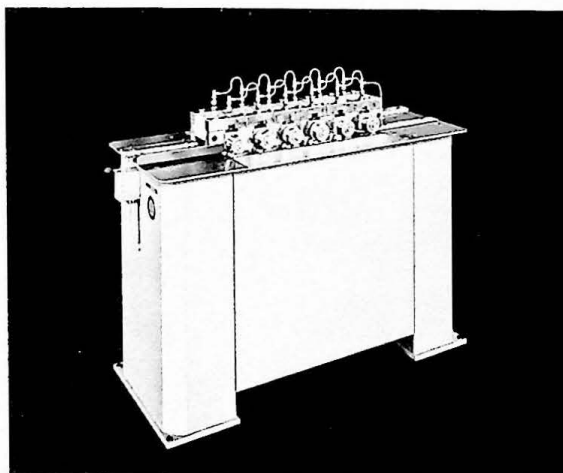
MODEL "MP" POWER GAP PUNCH

Capacity:	
(10) $\frac{9}{64}$ " holes through 24 gauge-mild steel and lighter	
Distance between housing	24-1/2"
Minimum centers between punches	$\frac{5}{8}$ "
Front Table	8" x 27-1/2"
Length	41"
Width	16"
Height	41"
Weight	600 lbs.
Powered by $\frac{3}{4}$ HP 3 Phase 220/440 Volt 125 r.p.m.	
Gear Motor and controls.	

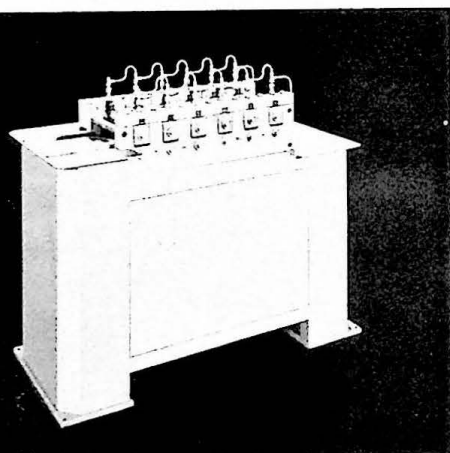
MAPLEWOOD MODEL "NR-6" & "NR-7" 1-2 or 3 POSITION MACHINE



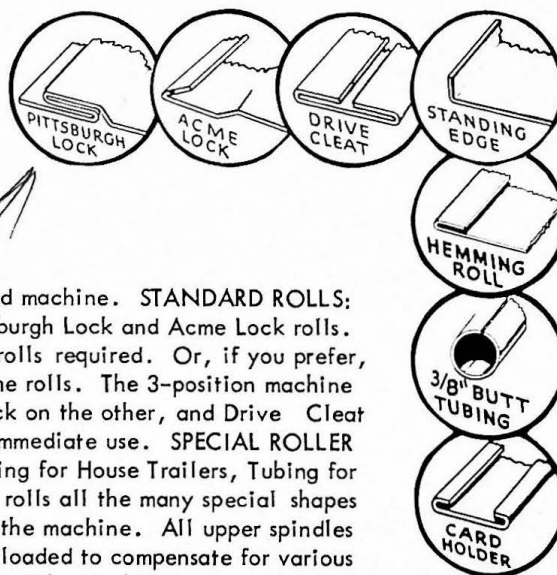
2 POSITION



3 POSITION



1 POSITION



PITTSBURGH LOCK-CAPACITY 20 GAUGE

Here is another versatile, high production Maplewood machine. **STANDARD ROLLS:** The 2-position machine can be furnished with Pittsburgh Lock and Acme Lock rolls. Both shapes set up for immediate use - no change of rolls required. Or, if you prefer, standard set of Drive Cleat rolls can replace the Acme rolls. The 3-position machine can produce Pittsburgh Lock on one side, Acme Lock on the other, and Drive Cleat down the middle. All rolls set up at all times for immediate use. **SPECIAL ROLLER DIES** can be furnished for the forming of Trim Molding for House Trailers, Tubing for Antennas, Edgings for Trunks, Card Holders, etc. It rolls all the many special shapes illustrated, and many others, within the capacity of the machine. All upper spindles have individual adjustment as well as being spring loaded to compensate for various thicknesses of metal. Eliminates constant adjustment of the machine.

SPECIFICATIONS

6 or 7 Forming Stations
1" Diameter Spindles
2-1/2" Vertical Spindle Centers
4-1/2" Horizontal Spindle Centers
Forming Speed -40,70 or 100 F.P.M.
Needle Bearings
Bijur One Shot Oiling System
Maplewood Gear Reducer

Individual Upper Roll Adjustments
Floor Space 48" Length-19-1/2" Width
40" Height
Approximate Weight
1 & 2 Position Machine -750 lbs.
3 Position Machine -850 lbs.
Starting & Reversing Switch
1-1/2 HP 3 Phase Motor

MAPLEWOOD MODEL "D-5" ROTARY COMBINATION MACHINE

These two Rotary Combination machines are ideal for sheet metal fabrication. Standard rolls are available for

- CRIMPING
- BEADING
- COMBINATION CRIMPING & BEADING
- ELBOW EDGING
- SLITTING
- TURNING
- WIRING
- STRETCHING
- EDGE STRAIGHTENING
- BURRING

Special rolls are also available for various formations.

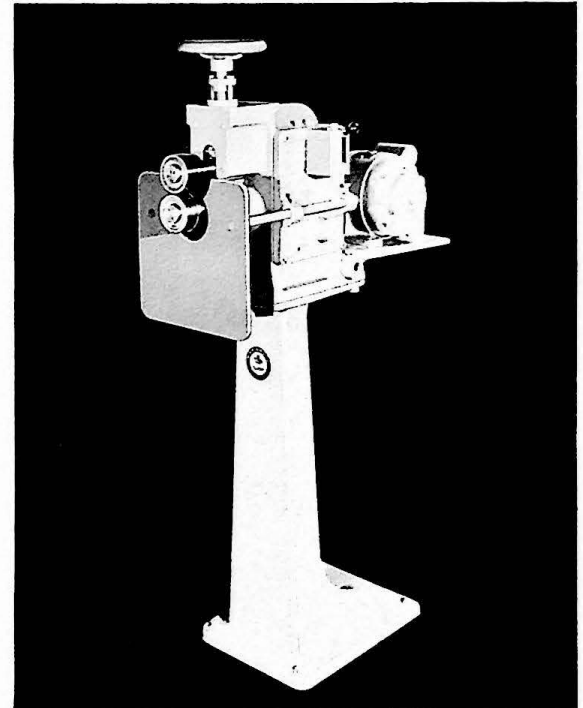
Upper Spindle Control is Optional in both Hand Wheel and Air Cylinder machines.

The Air Cylinder Model "D-5" leaves both hands free for each manipulation of the various operations.

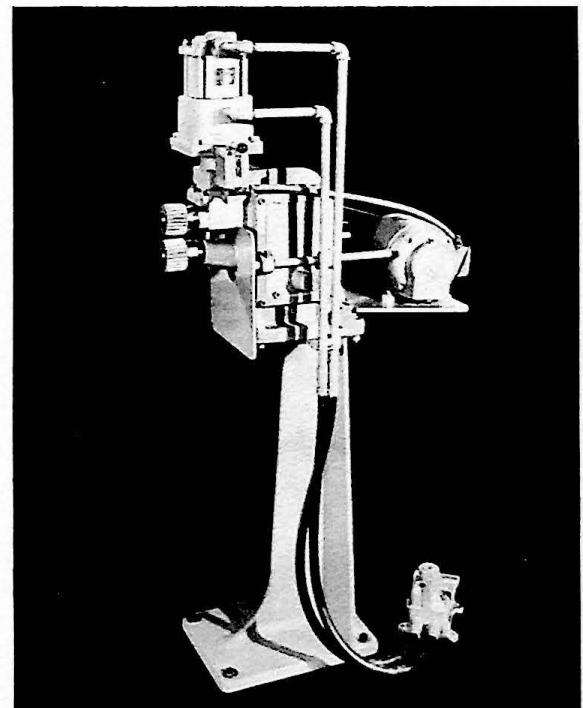
SPECIFICATIONS

- Vertical Spindle Centers - 3"
- Width of Rolls - 2"
- Depth of Throat - 5"
- Diameter of Spindles - 1-1/4"
- Forming Speeds - 35 or 70 f.p.m.
- Weight - 400 lbs.
- Capacity - 16 Gauge mild steel
- Cast Iron Head
- Cast Iron Pedestal
- Steel Cut Gears
- Steel Spindles
- Size of Motor - 3/4 HP, 220/440 Volt
- 3 Phase, AC, 1725 RPM
- Motor and Operating Switch

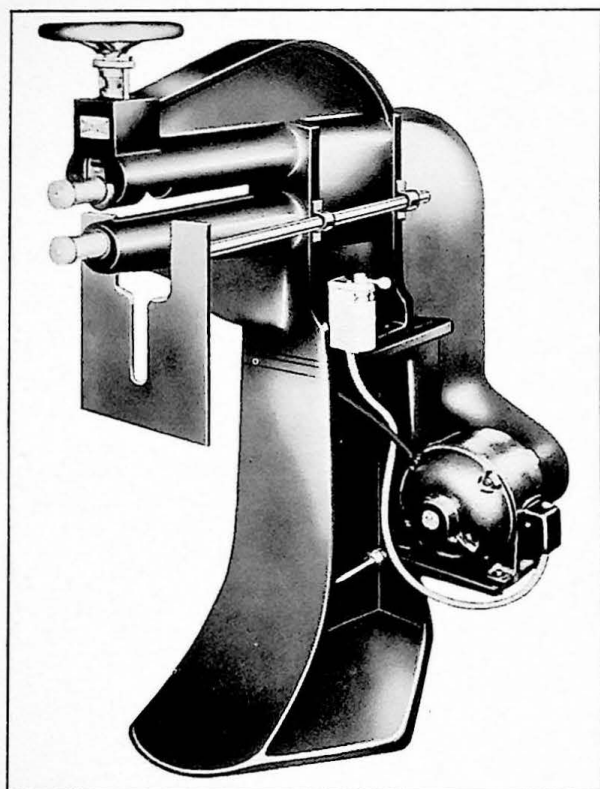
WITH HAND WHEEL



WITH AIR CYLINDER



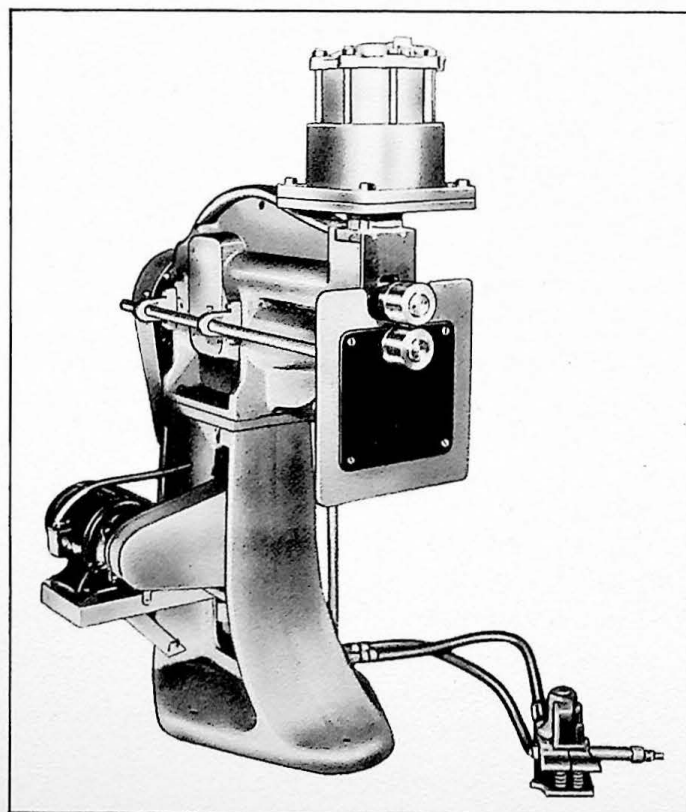
MODEL "D-12" • "D-18" • "D-20" **HEAVY DUTY COMBINATION MACHINE**



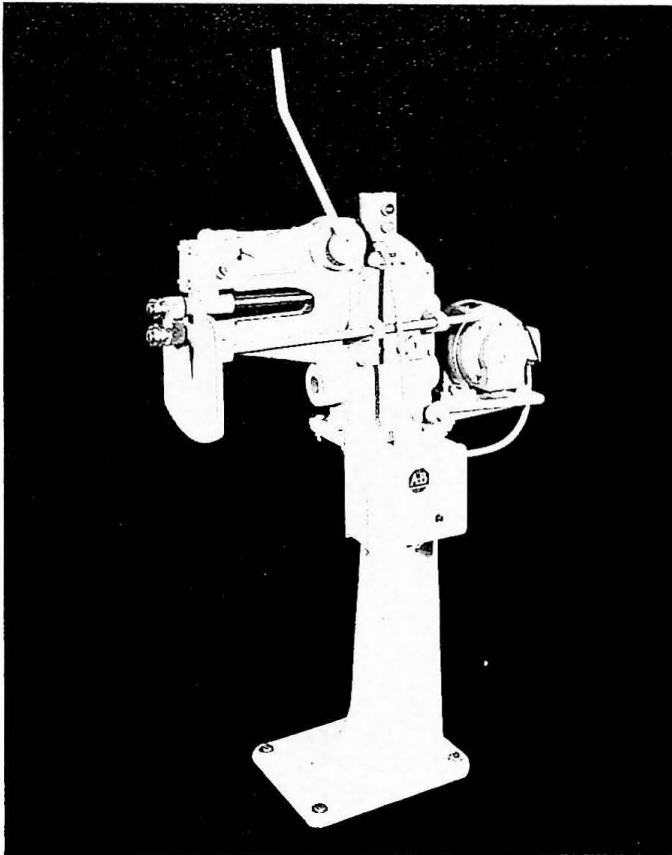
These heavy duty machines are adaptable to many special applications such as cutting out barrel heads, multiple beading and flanging of stool rims, cylinder slitting and operations on flood-light rims, irrigation pipe couplings, filter tubes, tank heads, etc. Standard Forming Rolls are available for Crimping, Single Beading, O.G. Beading, Combination Crimping and Beading, Slitting, Burring, Edge Straightening, Turning and Wiring. Machines have rigid cast iron head and base, combination V-Belt and Chain Drive, polished and ground steel shafts, machine cut steel gears totally enclosed, and they are equipped with either single phase or 3 phase motor and reversing controls. They can be equipped with air cylinder and double action foot control, which leaves both hands free for handling and guiding the work. Rolls are available for all 3 models .

SPECIFICATIONS

	D-12	D-18	D-20
Diameter of Rolls	4-1/4"	3-1/2"	4-1/4"
Vertical Centers	4-1/4"	3-1/2"	4-1/4"
Size of Motor	2 H.P.	1 H.P.	2 H.P.
Floor Space	30"x42"	32"x42"	32"x42"
Working Height	41-1/4"	39-3/4"	43-5/8"
Reversible Switch	x	x	x
Spindle Diameters	1-3/4"	1-3/4"	1-3/4"
Capacity	10 gauge C.R.S.	14 gauge C.R.S.	12 gauge C.R.S.
Depth of Throat	12"	18"	20"
Approx. Weight	1100 lbs.	1000 lbs.	1300 lbs.



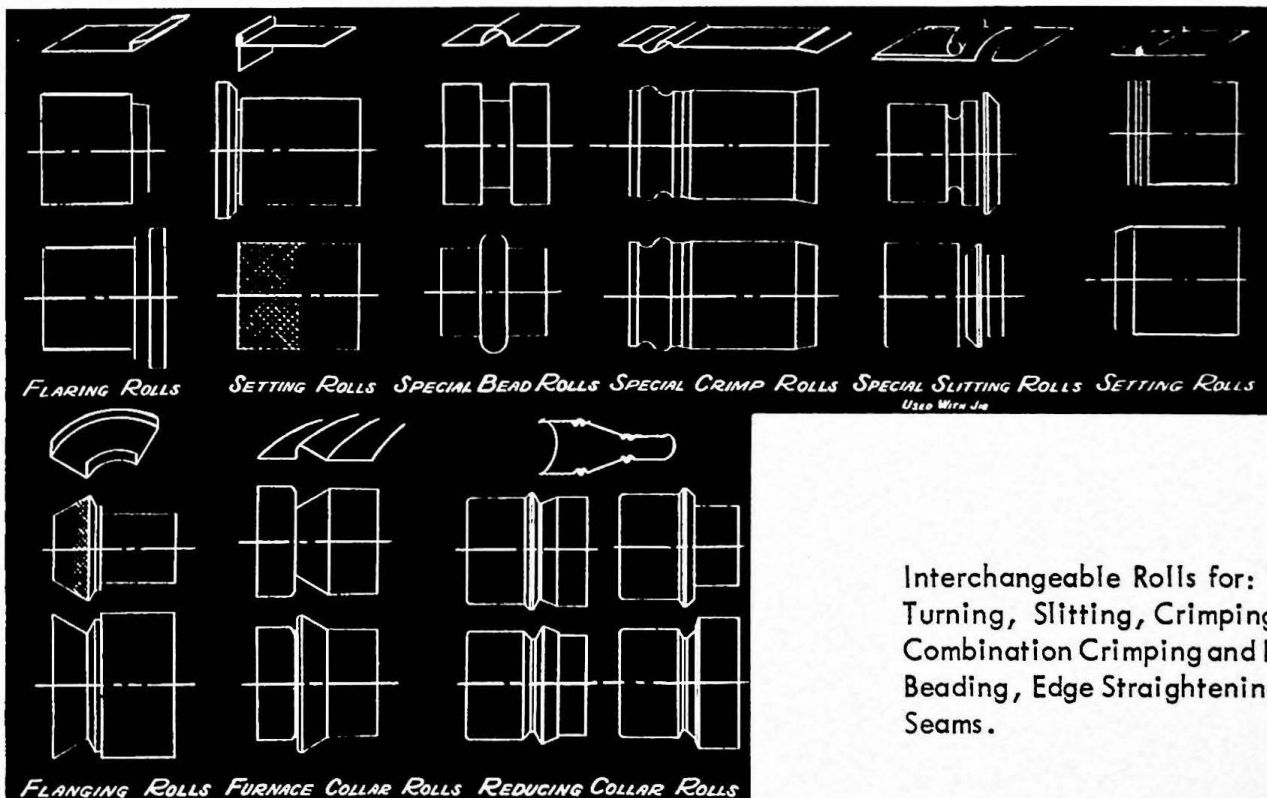
MAPLEWOOD MODEL "D-13" **ROTARY COMBINATION MACHINE**



This All Purpose Model "D-13" is ten machines in one with interchangeable rolls. Makes adjustable 4 Piece Elbows at 90° in sizes 3"-12" and 2 Piece 45° Angles in sizes 6"-12". Also 3 Piece 45° Angles in sizes 3", 4" and 5". Note: -Accessories for making Adjustable Elbows are interchangeable on Model "C" Elbow Machine.

SPECIFICATIONS

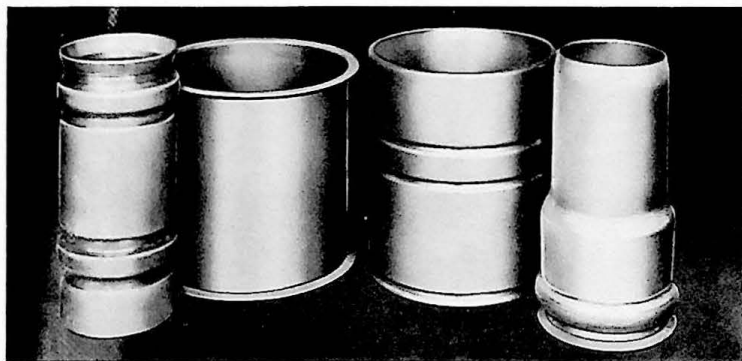
- .Rotary Type Model Combination Machine -
- Furnished as Bench Model or with Floor Pedestal
- .24 Ga. Capacity for Elbows
- 22 Ga. on Single Operations
- .Rigid Frame, Cast Iron Construction
- .Polished and Ground Steel Shafts - Steel Cut Gears -
- Completely enclosed in Housing
- .2 Adjustments for Rolls
- .New Positive Eccentric Locking Device
- .13" Throat Depth
- .Length - 27" (With Motor mounted -36"); Height - 20";
- Width 14"
- .Weight - 222 lbs.
- .1/2 H.P., Single Phase Motor and Switch



SPECIAL
D-13
ROLLS

Interchangeable Rolls for: Wiring, Burring, Turning, Slitting, Crimping, O G Beading, Combination Crimping and Beading, Single Beading, Edge Straightening, Setting Down Seams.

PARALLEL SHAFT ROTARY TYPE HEAVY DUTY MACHINES



PARALLEL SHAFT
ROTARY TYPE
HEAVY DUTY
MACHINE

EQUIPPED
WITH AIR CYLINDER
AND FOOT OPERATED
CONTROLS

This is a high speed rotary type machine for flanging, beading, corrugating, or similar special operations on light gauge cylindrical shapes. The upper shaft does not pivot but remains parallel with the bottom shaft during all phases of the operations and is adjustable for various pitch diameter roller dies.

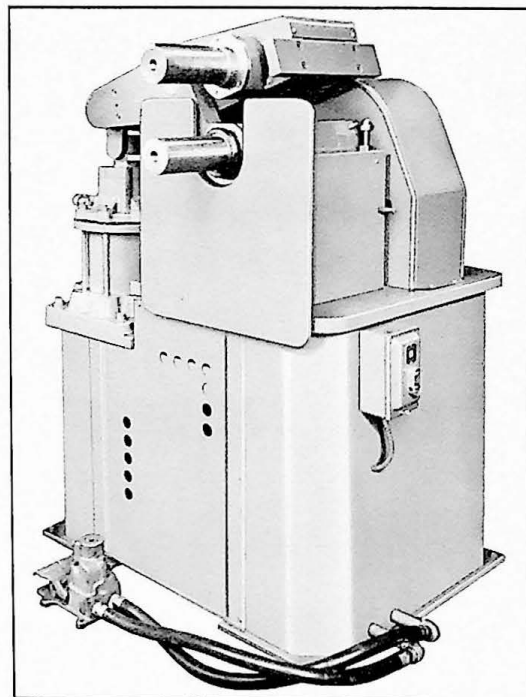
AVAILABLE WITH:

1-1/2" Diameter Shafts for 3-1/2" Diameter Rolls #1 Machine

2-1/2" or 3" Diameter Shafts for 5" Diameter Rolls #2 Machine

3" Diameter Shafts for 6-1/8" Diameter Rolls #3 Machine

Special extended spindles can be adapted for special applications.

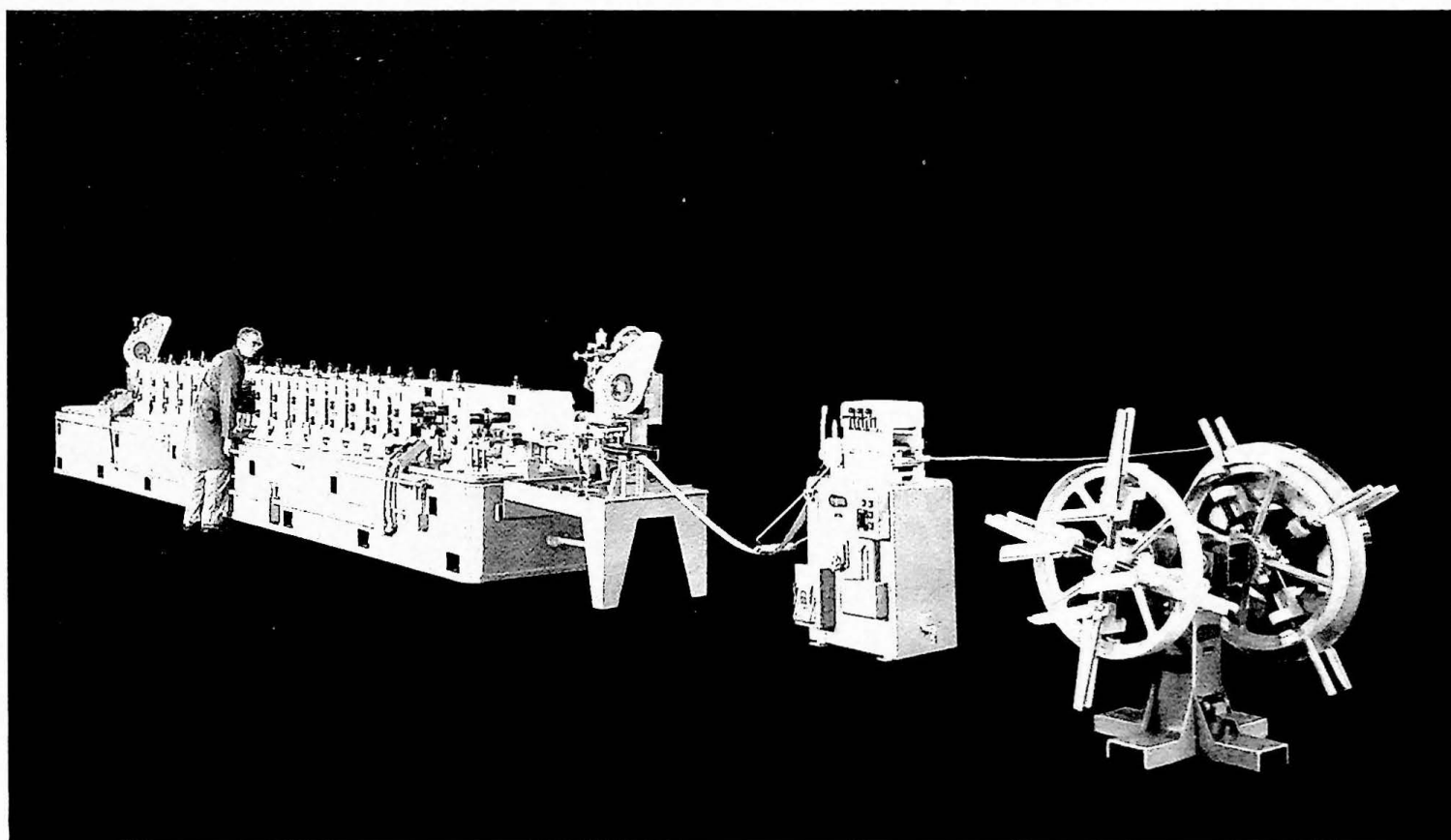


#1 - #2 - #3 MACHINES

SPECIFICATIONS FOR #2 MACHINE

5" Roll Diameter
2-1/2" or 3" Shaft Diameter (Roll Shaft)
6-15/16" Shaft Extension
Tapered Roller Bearings
Maximum Lift of Upper Shaft 2"
2 H. P. Slow Speed Gear Motor -
60 Cycle 3 Phase 220/440 Volt
Low Pressure Air Cylinder Operated
Thru 2 Way Foot Control
Forming Speed 54 FPM
Floor Space 38" x 49"
Weight - 2,171 lbs.
Hardened Spindles and
Steel Cut Gears, Welded Steel Frame

SPECIAL MULTIPLE STATION ROLL FORMING MACHINES



The Maplewood Model MWB Cold Roll Forming Machine shown above is one of a complete line of machinery for special applications up to 10 ga. mild steel capacity manufactured by Maplewood Division. These machines are capable of high volume production of an infinite variety of shapes .



Rockford Machine Tool Co., Rockford, Illinois have been manufacturers of machine tools for more than half a century. Their highly successful engineering and production skills in the manufacture of high production machinery for the metalworking industry is now being utilized in the design and manufacture of a complete line of roll forming equipment.

Pipe and duct manufacturers are assured that the "Maplewood" machines illustrated and described in this catalog are the finest machines of their type and that they will perform successfully the specific operations within the specifications of the machine. Each machine embodies the superior technical advancements of the latest techniques in modern design and production. Quality built by skilled mechanics of the finest materials, they will give many years of efficient service, greatly speed production and lower overall fabricating costs.

There is no obligation to consult a "Maplewood" engineer for the machine...or combination of machines that can streamline your operations and greatly reduce your overall roll forming and sheet metal costs.



MAPLEWOOD DIVISION

DIVISION OF GREENLEE BROS. & CO

2500 Kishwaukee St., Rockford, Ill. 61101 U.S.A.

A Unit of Ex-Cell-O Corporation 

sold by

Catalog No. 1704

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