

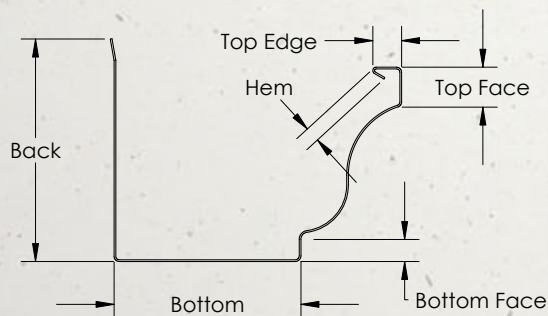
[1770A]



The 1770A 5" K-Style gutter machine utilizes the finest technology available. Three powered skate roller stations mean less pressure and less adjusting, producing a consistently straight gutter, and an anti-dent block assures dent-free cuts every time. Plus, the 1770A transports easily and also features removable sides for easy access.



[1770A Profile Dimensions]



Back	3.75" and 3.88"
Bottom	3.31"
Bottom Face	0.38"
Top Face	0.63"
Top Edge	0.63"
Hem	0.25"

Profile Specifications

Available 5" K-Style Rain Gutter Profiles:

- 5" K-Style Gutter with Straight Back
- 5" K-Style Gutter with Free Float Hook
- 5" K-Style Gutter with Bottom Beads

Profile Dimensions:

- Refer to Knudson Engineering Data or Knudson Profile Drawing for Specifications

Material Types:

- Steel Galvanized, Painted, Pre-Finished, Bare
- Aluminum Painted, Pre-Finished
- Copper Bare

Material Thickness:

- Steel 0.015" to 0.018" (.38 to .45-mm)
- Aluminum 0.023" to 0.032" (.57 to .81-mm)
- Copper 16 to 20-oz (.53 to .69-mm)

Material Strength:

- Steel Max Tensile Strength = 48-ksi (330 Mpa)
Max Yield Strength = 33-ksi (230 Mpa)
- Aluminum Max Tensile Strength = 33-ksi (230 Mpa)
Max Yield Strength = 28-ksi (190 Mpa)
- Copper Max Tensile Strength = 33-ksi (230 Mpa)
Max Yield Strength = 28-ksi (190 Mpa)

Strip Width:

- Minimum 11.25" (298-mm)
- Maximum 12.00" (304-mm)

Machine Specifications - Mechanical Systems

Dimensions:

- Length 96.00" (2440-mm)
- Width 21.00" (530-mm)
- Height 19.50" (500-mm)
- Height 35.00" (890-mm) including uprights
- Height 44.00" (1120-mm) including spool
- Weight 960-lbs (435-kg)

Roll-Forming Details:

- Eight (8) Powered Roll-Forming Stations
- Four (4) Station Auxiliary Box-Forming Unit

Production Speed:

- 35'/min Nominal (60 Hz Electric Motor @1725 rpm)
- 29'/min Nominal (50 Hz Electric Motor @1425 rpm)

Drive Train:

- Power Source: Electric Motor
- Power Take-Off: Worm Gear Reducer
- Drive/Forming Rollers: Gear/Sprocket/Roller Chain Drive
- Main Drive Speed: 54 rpm @ 2.50" Drive Dia (60 Hz Electric Motor @1725 rpm)
- Main Drive Speed: 44 rpm @ 2.50" Drive Dia (50 Hz Electric Motor @1425 rpm)

Shear Assembly:

- Manually Operated Guillotine Style
- Manually Operated Rack and Pinion Style (optional)
- Manually Operated Cam-Actuated Guillotine Style (optional)

Coil Handling Equipment:

- Spool: 12" Wide/16" ID
- Double Uprights
- Multi-Width Coil Cradle
- Triple Uprights

Airborne Noise Emissions:

- Equivalent continuous A-weighted sound pressure level = less than 70 dB (A)

Machine Specifications - Electrical Systems

Electric Power:

- Line Voltage = 100 to 115 VAC / 200 to 230 VAC (+/- 10%)
- Line Current = 15 Amps
- Line Frequency = 60 / 50 Hz (+/- 1%)
- Line Phase = single phase
- Full Load Current = 12.6 to 14.2 Amps (115 VAC) / 6.3 to 7.1 Amps (230 VAC)
- Fuse Rating = 5 Amps (optional: CE Package)
- Electrical Drawing = 31-0020110 (115 VAC) / 31-0020104 (230 VAC)
- Electrical Drawing = 31-0020109 (115 VAC) / 31-0020105 (230 VAC) (Safety Wiring)
- Electrical Drawing = 31-0020108 (optional: CE Package)
- Electrical Enclosure IP Rating = N/A

Control System:

- Directional Control / Electric Motor Control: Three (3) Position Drum Switch
- Direction Select Switch, Jog/Stop/Run Switch, Jog Button, E-Stop (CE Package)

Safety Features:

- E-Stop Switch
- Top and Side Covers
- Bottom Pan (CE Package)
- Spool Locks

Machine Specifications - Operating Environment

Ambient Air Temperature:

- +41 to +131-deg Fahrenheit (+5 to +55-deg Celsius)
- Up to 24 hours at 122-deg Fahrenheit (50-deg Celsius)

Humidity Range:

- No Restrictions

Altitude Range:

- No Restrictions

Vibration Shock and Bump:

- Minimal vehicular transport on maintained roads
- Off-road transportation not recommended

Transportation and Storage:

- -13 to +131-deg Fahrenheit (-25 to +55-deg Celsius)
- Up to 24 hours at +158-deg Fahrenheit (+70-deg Celsius)

Explosive Atmosphere:

- Should not be operated in any kind of explosive atmosphere