LS-5 DUCT LINER SIZER

ITEM#  DESCRIPTION
28009  Blade
28012  Cross Cut Assembly (Without handle)
28013  Blade with Hub
28014  Crank Handle
28015  Slitting Assembly W/ Blade Roller
28016  Measuring Tape
28017  Liner Spool
28025  Slitter Support Casting
28026  Blade Hub
28027  Spring Hold Downs
28028  Slitter Drive Shaft
28029  Blade Roller
28030  12" Octagon Collar
28031  Pipe
28032  Drive Roller
28033  Idler Roller
28034  Feed Guide
28035  Locking Thumbscrew
28036  Handle Grip
28037  Nylon roller
28038  Nylon Roller Bolt
28039  Blade Hub Bolt
28040  Adjustment Knob
28041  Feed Shelf
28042  Roller Handle
28043  Sprockets
28044  Chain
28045  Cross Cut Handle
28046  Sandpaper Kit

ADJUSTMENTS & MAINTENANCE
1) LUBRICATION: The bearings at each end are made of porous bronze. They may be lubricated with a light oil.
2) The cross bar which supports the slitting assemblies should be lubricated as needed with a dry lubricant.
3) Replacement blades and parts can be ordered from your Duro Dyne Distributor.
4) If any slippage occurs or more pressure is required to feed oversized or heavier rolls, simply push up slightly on the Idle Roller Handle while turning the crank arm.

LIMITED WARRANTY
Duro Dyne Machinery is manufactured by skilled mechanics, utilizing the latest production techniques. Each unit has been rigorously tested prior to packaging and shipment in order to ensure trouble free operation.

Your Duro Dyne machine has a 90 day warranty against defects in workmanship or material. Any component found to be defective will be repaired or replaced, at manufacturer's discretion, at no cost, if faulty component is returned freight prepaid to the nearest Duro Dyne Service Department. Warranty does not apply to expendable parts, cutting blades, etc, of repairs, due to improper maintenance or operational procedures.

All warranty claims must be accompanied by the serial number, date of purchase, and the name of distributor purchased from.
IMPORTANT: DO NOT TIGHTEN THE NUTS UNTIL THE UNIT IS COMPLETELY ASSEMBLED.

A) Assemble the cutting frame with the legs as shown in Diagram I. (Use 16 1/4 x 3/4 bolts with a lock washer under the nut and a flat washer under the bolt head.)
   1) Each frame Part "A" overlaps each frame Part "B" at the corners. (Frame parts "A" are in pairs of a right and a left.)
   2) All legs "C" attach to the outside edges of the frame.

B) Attach the cutting head to the frame using 4 1/4 x 3/4 bolts with a lock washer under the nut and a flat washer under the bolt head.
   1) The Cross cut blade is toward the front of the machine.
   2) Attach the handle to the cross cut assembly as shown in Diagram II.

C) Place one 12" octagon sheet metal collar on each piece of 1" pipe. (See Diagram III.) Put a roll of liner on the pipe. Add another sheet metal collar to the pipe.

D) Place the pipe in the pipelocks on the frame. (See Diagram I.)

E) Feed one roll of the liner into the unit.

F) Center the liner on the pipe so that it feeds evenly into the machine. Line up the collars with the insulation feed guides on the machine head table. Push the collars up against the roll of liner. Please allow 1/4" to 1/2" clearance between the liner and the collars. Lock the collars in place. The unit is ready for use.

Diagram II
Cross Cut Handle

Diagram III
Liner Rack

Diagram V
Cross Cut Trolley

Diagram VI
LS Conversion for Left Hand Operation

BLADE REPLACEMENT & ADJUSTMENT INSTRUCTIONS

IMPORTANT: THE BLADE IS VERY SHARP; USE CARE IN MAKING ADJUSTMENTS.

A) Cross Cut Trolley: Attach the blade to the holder bar using the shoulder screw and locking nut. Position the blade into the track so it protrudes into the track about 1/2". Tighten the hex head nut and screw on the cross cut trolley (Diagram V).

B) Slitting Blade:
   1) Position the blade assembly at either end of the head. Tighten the thumbscrew knob. (Diagram IV).

   2) Attach the blade to the holder bar using the shoulder screw and locking nut. Position the blade in the blade roller: Insert the slitting blade about 3/32" to 1/8" into the blade roller slot. Tighten the hex head screw on the slitter blade casting.

   3) Check the blade assembly adjustment at the center and the opposite side of the head. The blade must rotate freely. If binding occurs at either of these positions, readjust.

NOTE: ALL THE BLADE HEIGHT ADJUSTMENTS HAVE BEEN MADE AT THE FACTORY ALL BLADES ARE INTERCHANGEABLE.

LS CONVERSION FOR LEFT HAND OPERATION

Diagram VI
Lower Drive Roller

1) Remove the crank handle (A).
2) Loosen the set screw (B), extend the shaft (H) about 1", retighten the set screw.
3) Remove the shaft collar (C), and position the crank handle (A) in place of the shaft collar. Tighten the set screw (D) in the crank handle leaving about 1/32" play. NOTE: There should be an overall lateral play in the Drive Assembly of at least 1/32".
4) Place the shaft collar on opposite side of the drive roll (D) where the crank handle was positioned. The Shaft collar will secure the chain guard.

5) Remove the dog stop (E). Reverse position of the pin by pressing through to the other side of the dog. Replace the dog stop on opposite side of the LS (G). The Dog must fall freely.

6) Remove the upper roll lift handle (F) and replace on opposite side of the LS (G).

Be sure that all of the set screws are firmly tightened on flat area on shaft before operating machine.
ASSEMBLY INSTRUCTIONS

Assembly as shown in Diagram II.

1) Attach the cutting head to the frame using 4 1/4 x 3/4 bolts with a lock washer under the nut and a flat washer under the bolt head.

2) Each frame Part "A" overlaps each frame part "B" at the corners. (Frame parts "A" are in pairs of a right and a left.)

3) The Cross cut blade is toward the front of the machine.

4) Insert the crank handle onto the lower drive roller shaft. Tighten the set screw. (Diagram IV).

5) Remove the shaft collar (C), and position the 3) crank handle (A) in place of the shaft collar. NOTE: There should be about 1/32" lateral play in the Drive Assembly of the LS (G).

6) Loosen the set screw (B), extend the shaft (H) 2) about 1" to 2", and tighten the set screw (B) in the crank handle (A) and the shaft (H) will protrude into the drive assembly of the LS (G). The Dog must fall freely.

7) Remove the upper roll lift handle (F) and replace the Dog stop (E) with the pin by pressing through to the other side of the Dog stop (E). Remove the dog stop (E). Reverse position of the Dog stop (E). The Dog must be able to slide freely on the pin by pressing through to the other side of the dog. Replace the dog stop on opposite side of the LS (G).

8) LS CONVERSION FOR LEFT HAND OPERATION ARE INTERCHANGEABLE.

9) CARE IN MAKING ADJUSTMENTS.

IMPORTANT:

DO NOT TIGHTEN THE NUTS UNTIL INSULATION FITS BETWEEN COLLARS

ATTACH THE HANDLE TO THE CROSS CUT FRAME

1) The Cross Cut blade is toward the front of the machine.

2) Feed one roll of the liner into the unit. (See Diagram I.)

3) Place the pipe in the pipelocks on the frame. (Diagram II.)

4) Place one 12" octagon sheet metal collar on the metal collar to the pipe. (Diagram III.)

5) Center the liner on the pipe so that it feeds evenly into the machine. Line up the collars between the liner and the collars. Lock the roll of liner. Please allow 1/4" to 1/2" clearance with the insulation feed guides on the machine even into the machine.

6) Insulation fits between collars in place. The unit is ready for use.

THE UNIT IS COMPLETELY ASSEMBLED.

IMPORTANT:

DO NOT TIGHTEN THE NUTS UNTIL ALL LEGS "C" ATTACH TO THE OUTSIDE EDGES OF PIPE LOCKS (WITH HUB) #28013.

7) Feed one roll of the liner on the pipe. Add another sheet each piece of 1" pipe. (See Diagram III.) Put a rotating chain guard. 

8) Attach the handle to the cross cut frame.

PARTS LOCATION

Slitting Assembly (With Blade Roller) #28015

Liner Spool 4' - #28018 5' - #28019

Cutting Head (Side View)

Slitter Blade Adjustment

28070 Chain
28070 Sprockets

28025 Slitter Support Casting

Blade 28009
(with hub) #28013

28027 Spring Hold-Downs

28026 Hub

28030 Blade Roller

12" Octagon Collar #28031

Pipe
4' #28032
5' #28033

Locking Thumbscrew #28043

28066 Slitting Blade Thumbscrew Knob

28026 Hub

28027 Spring Hold-Downs

28030 Blade Roller

28026 Hub
**Adjustments & Maintenance**

1) **Lubrication:** The bearings at each end are made of porous bronze. They may be lubricated with a light oil.

2) The cross bar which supports the slitting assemblies should be lubricated as needed with a dry lubricant.

3) Replacement blades and parts can be ordered from your Duro Dyne Distributor.

4) If any slippage occurs or more pressure is required to feed oversized or heavier rolls, simply push up slightly on the Idle Roller Handle while turning the crank arm.

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LS PARTS & SPECIFICATIONS

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