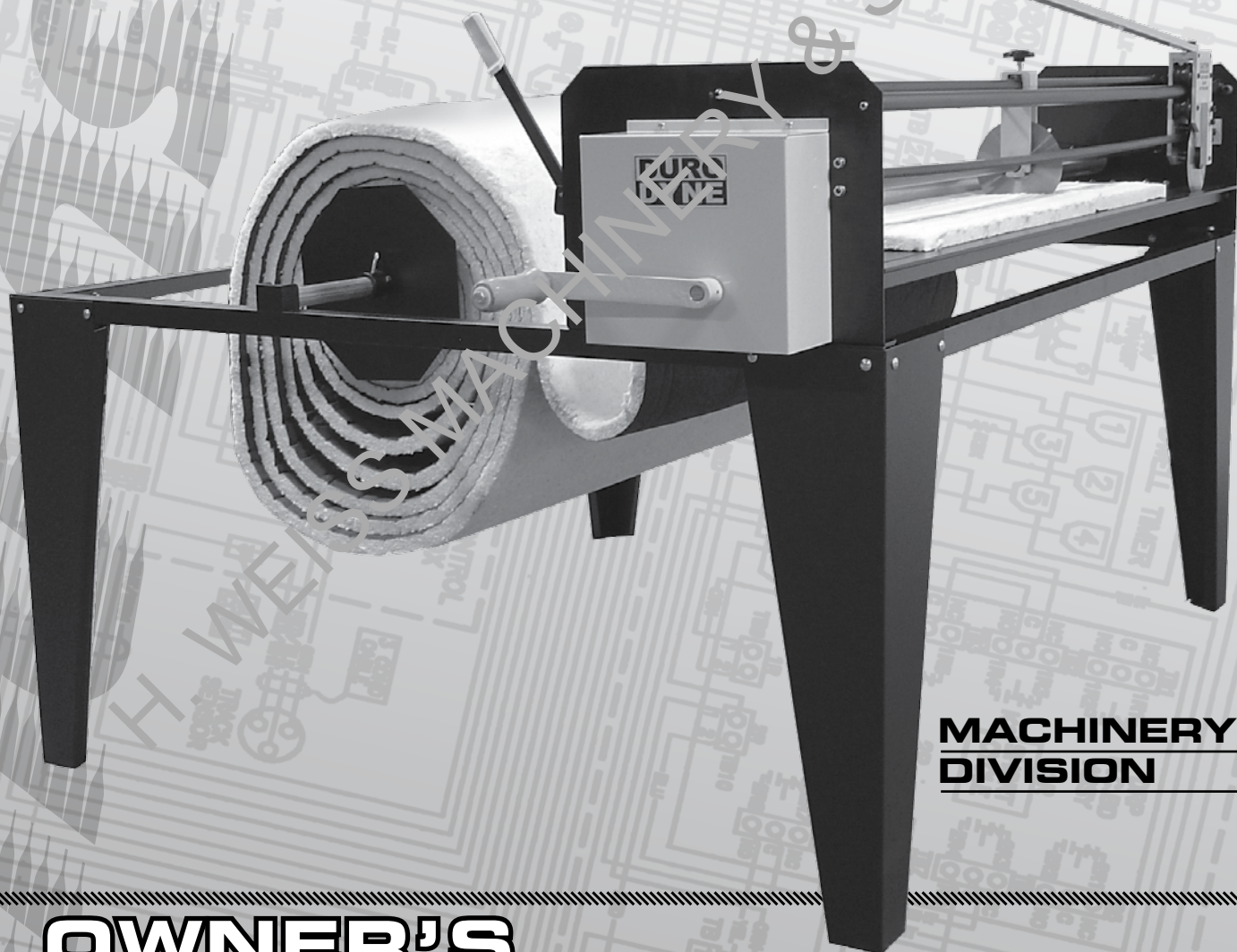


LSU DUCT LINER SIZER

DUCT LINER SIZER



**MACHINERY
DIVISION**

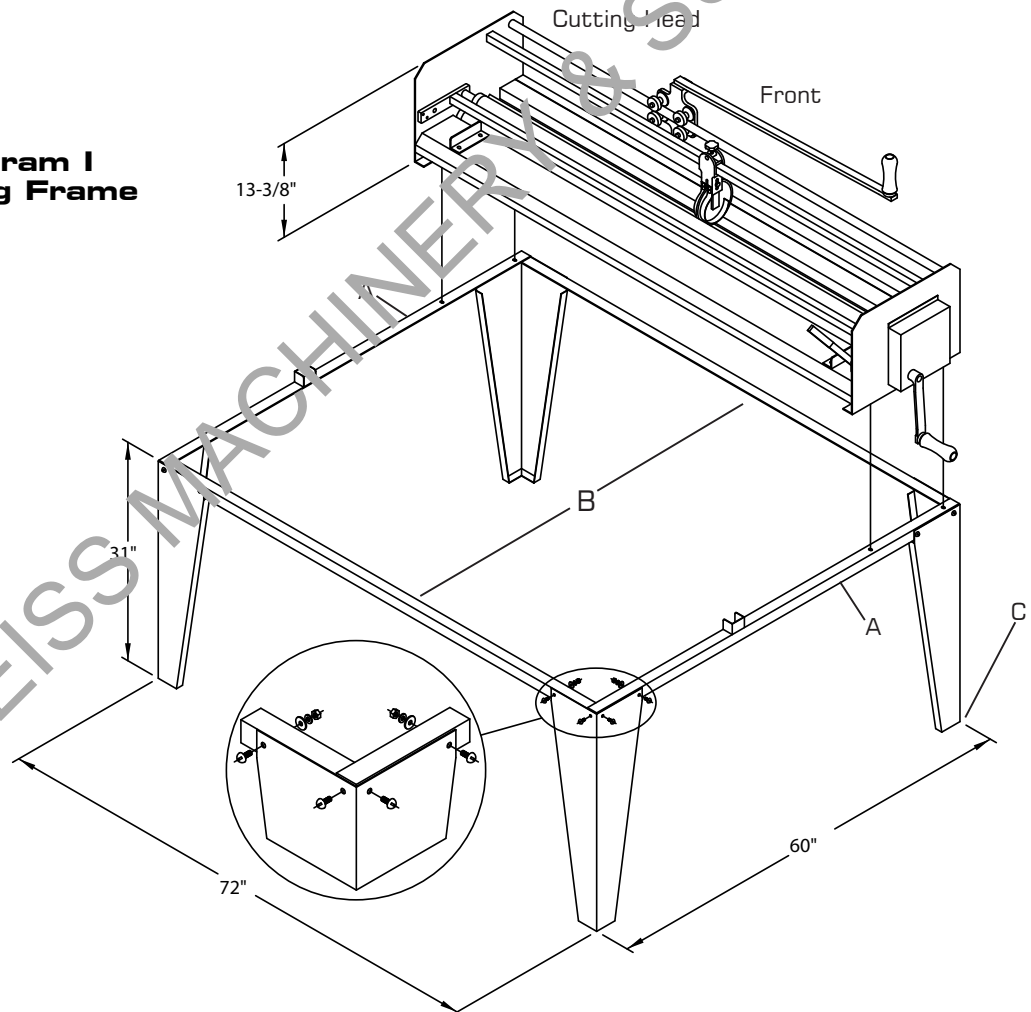
OWNER'S MANUAL

ASSEMBLY INSTRUCTIONS

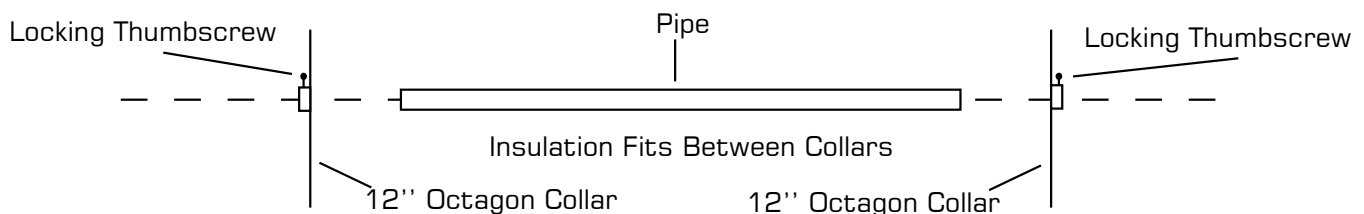
IMPORTANT: DO NOT TIGHTEN THE NUTS UNTIL THE UNIT IS COMPLETELY ASSEMBLED.

- A)** Assemble the cutting frame with the legs as shown in Diagram I below. (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 flat washer under the bolt head. (The cross cut blade is closest to the front of the machine.)
- C)** Attach the handle to the cross cut assembly.
- D)** Insert the crank handle onto the lower drive roller shaft. Tighten the set screw.
- E)** Place one 12" octagon sheet metal collar on the piece of 1" pipe. See Diagram II. Put a roll of liner on the pipe. Add another sheet metal collar to the pipe. (Do not tighten the sheet metal collars.)
- F)** Place the pipe in the pipelocks on the frame.
- G)** Feed the roll of liner into the unit.
- H)** 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. 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 I
Cutting Frame**



**Diagram II
Liner Rack**



SLITTER BLADE REPLACEMENT INSTRUCTIONS

IMPORTANT: THE BLADE IS VERY SHARP; USE CARE WHEN REPLACING

- 1)** Remove the drive assembly cover on the right hand side of the machine.
- 2)** Slide the slitter assembly to the left hand side of the machine.
- 3)** Remove the slitter assembly side plate.
- 4)** Loosen the set screws on the flange bearing securing the slitter blade drive shaft. (two set screws per bearing)
- 5)** Slide the slitter blade drive shaft to the right until the blade can be removed.
- 6)** Place the new blade on the shaft and slide the blade to the left back through the bearing on the left side of the machine. Be sure to stand up the slitter assembly side plate before inserting the shaft through the bearing.
- 7)** Line up the drive gears on the right hand side of the machine and then tighten all flange bearing set screws.
- 8)** Attach the slitter assembly side plate

CROSS CUT BLADE REPLACEMENT INSTRUCTIONS

- 1)** Loosen the cross cut assembly axle bolt and slide it enough to remove the blade assembly. Be sure not to lose the axle shaft bushing.
- 2)** Remove the cross cut blade assembly.
- 3)** Line up the new blade assembly being sure the gears mesh fully.
- 4)** Slide the axle bolt through the blade assembly and tighten it. (It may be necessary to use a pair of needle nose pliers to line up the axle shaft bushing before the axle bolt goes through the blade.)

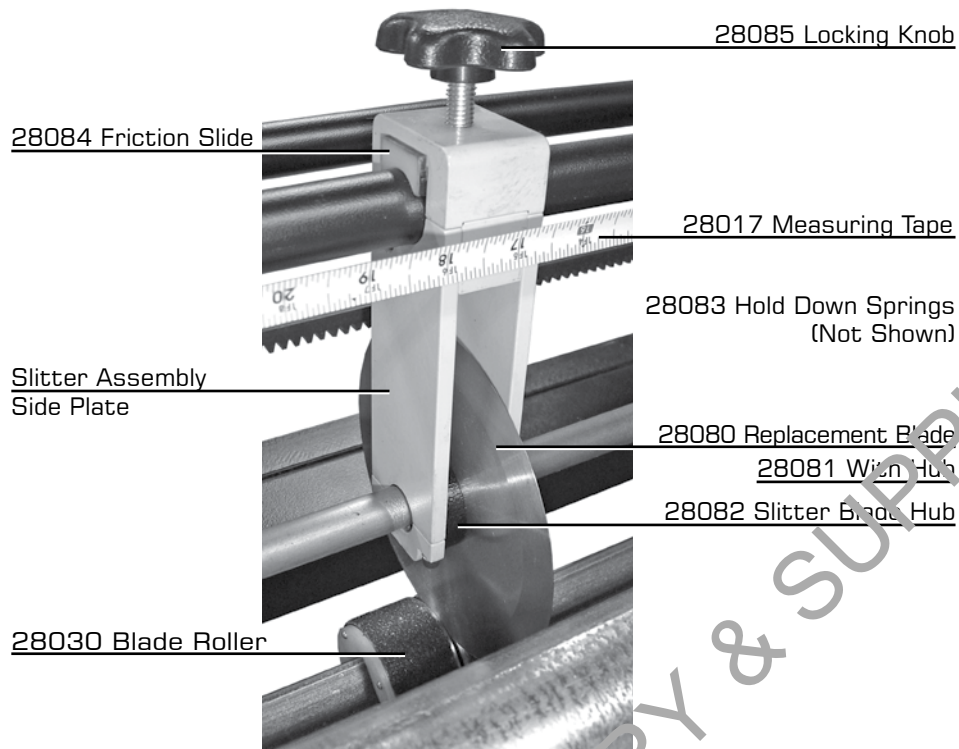
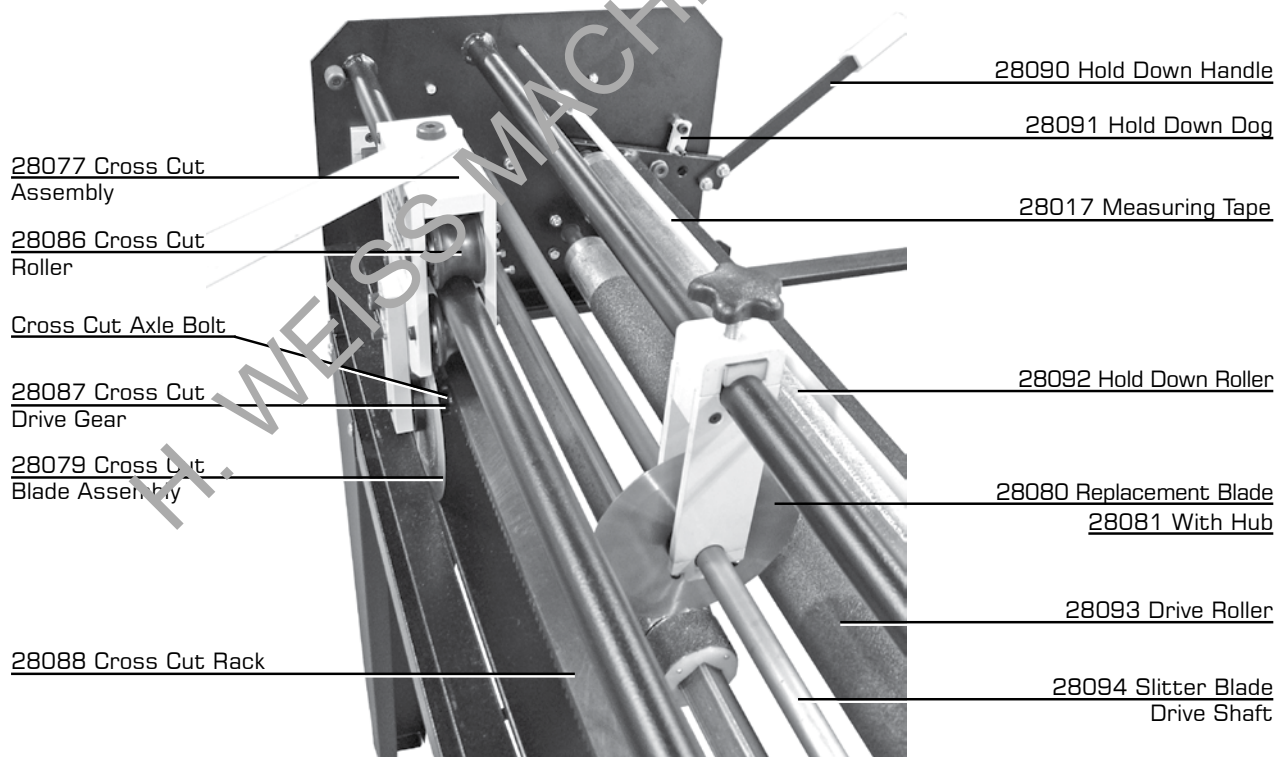
NOTE: ALL THE BLADE HEIGHT ADJUSTMENTS HAVE BEEN MADE AT THE FACTORY ALL BLADES ARE INTERCHANGEABLE.

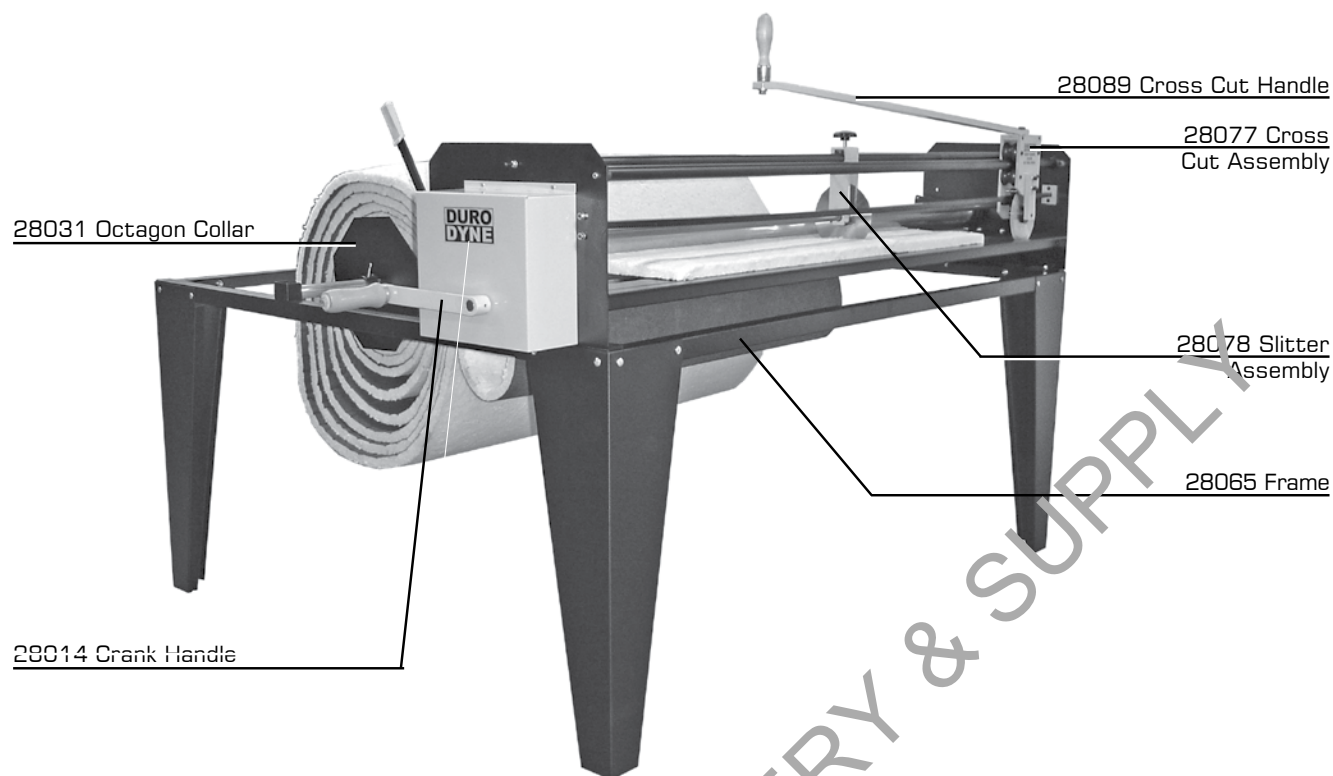
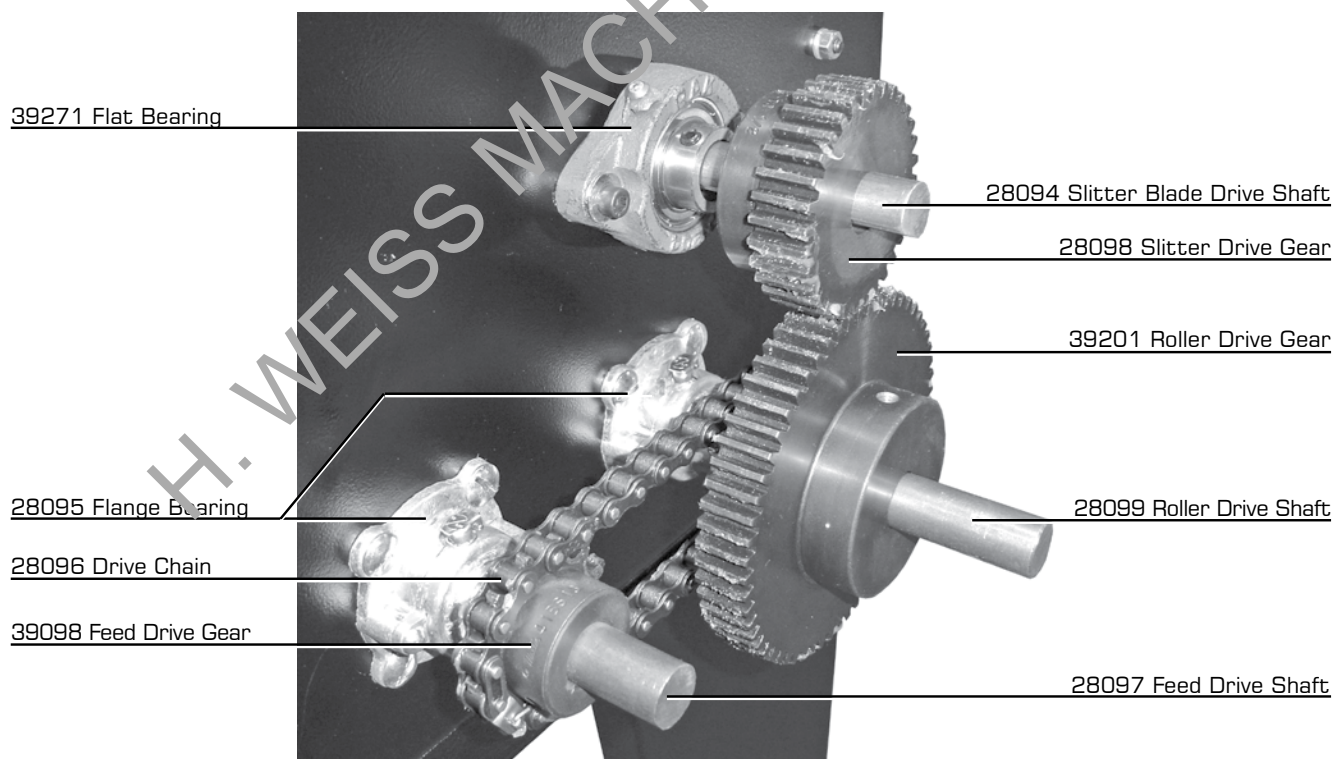
LSU CONVERSION FOR LEFT HAND OPERATION

- 1)** Remove the crank handle from right hand side of the machine.
- 2)** Loosen the two set screws on the slitter roll drive shaft and extend the shaft about 2". Tighten the set screws.
- 3)** Loosen the set screw on the shaft collar. Slide the shaft collar against the bearing leaving about 1/32" play. NOTE: There should be an overall lateral play in the drive assembly of at least 1/32". Tighten the shaft collar set screw.
- 4)** Place the crank handle on the extended slitter roll drive shaft and tighten the set screws.
- 5)** Remove the hold down dog. Reverse the position of the pin by pressing it through to the other side of the dog. Attach the hold down dog on the opposite side of the LSU. The hold down dog must fall freely.
- 6)** Remove the upper hold down handle and attach it on opposite side of the LSU. Be sure that all of the set screws are firmly tightened on the flat areas on the shaft before operating machine.

ADJUSTMENTS & MAINTENANCE

- 1)** 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 local 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 hold down handle while turning the crank arm.

PARTS LOCATION***SLITTER ASSEMBLY******FEED AND CROSSCUT ASSEMBLY***

PARTS LOCATION***OVERVIEW******DRIVE ASSEMBLY***

LSU PARTS & SPECIFICATIONS

Item#	Description	Item#	Description
28077	Cross Cut Assembly (Without handle)	28032	Pipe
28086	Cross Cut Roller	28093	Drive Roller
28088	Cross Cut Rack	28092	Hold Down Roller
28087	Cross Cut Drive Gear	28090	Hold Down Handle
28079	Cross Cut Blade with Gear	28091	Hold Down Dog
28089	Cross Cut Handle	28042	Feed Guide
28078	Slitting Assembly W/ Blade Roller	28094	Slitter Blade Drive Shaft
28080	Blade only	28095	Flange Bearing
28082	Slitter Blade Hub	28096	Drive Chain
28081	Slitter Blade with Hub	28097	Feed Drive Shaft
28083	Spring Hold Downs	28098	Slitter Drive Gear
28084	Friction Slide	28099	Roller Drive Shaft
28085	Locking Knob	39201	Roller Drive Gear
28030	Blade Roller	39098	Feed Drive Gear
28017	Measuring Tape	39271	Flat Bearing
28014	Crank Handle	28061	Sandpaper Kit
28018	Liner Spool	28065	Frame
28031	12" Octagon Collar		

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 the distributor you purchased from.

**MACHINERY DIVISION**

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