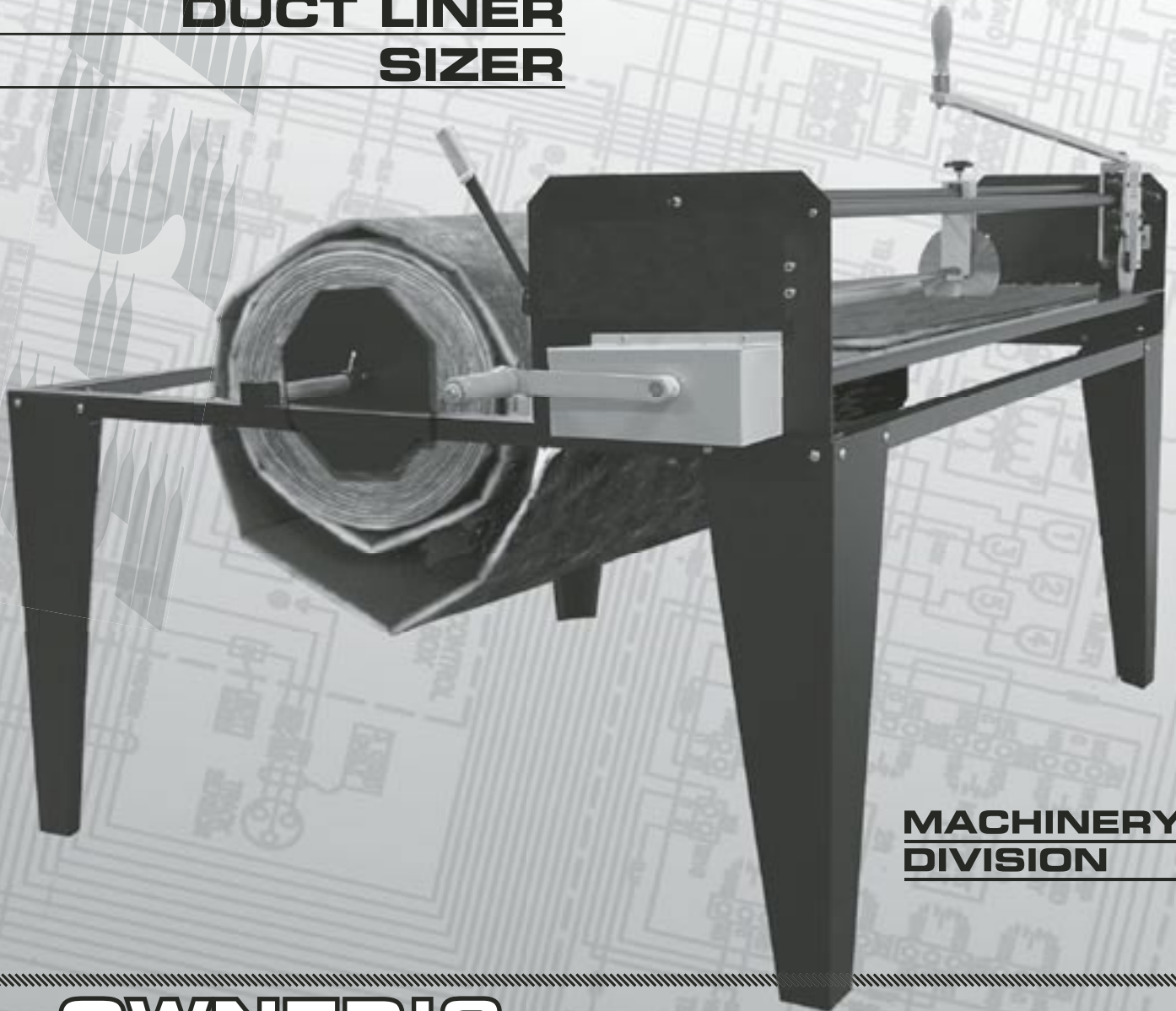


# ***LS-5 DUCT LINER SIZER***

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**DUCT LINER  
SIZER**



**MACHINERY  
DIVISION**

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**OWNER'S  
MANUAL**

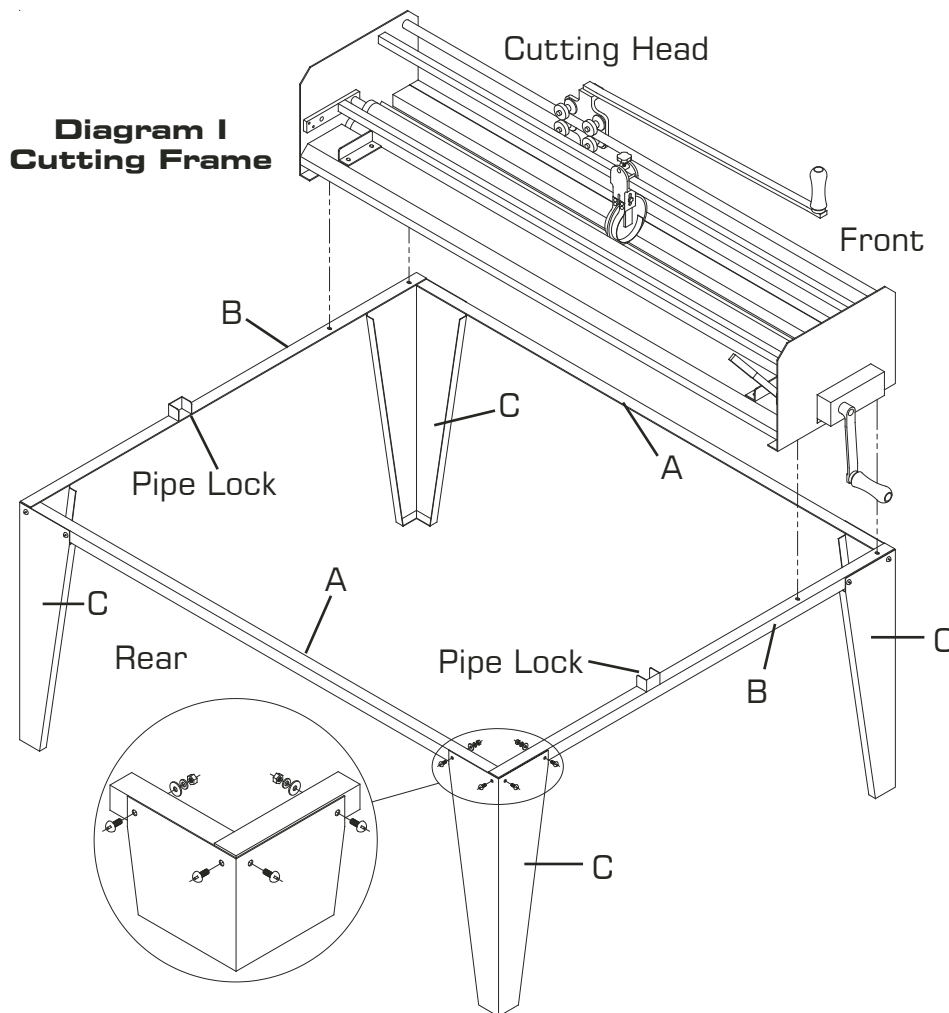
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# ASSEMBLY INSTRUCTIONS

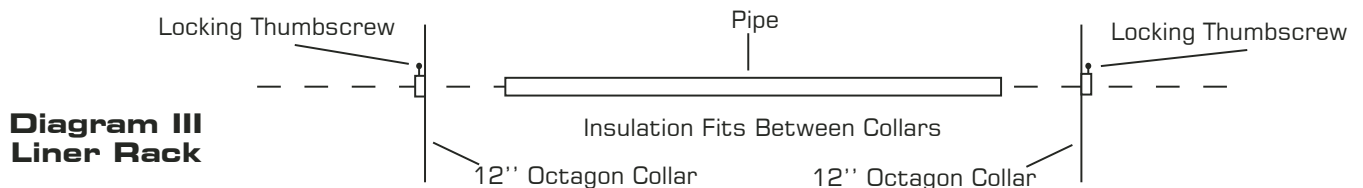
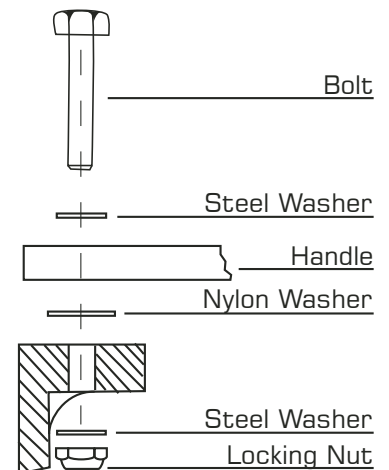
**IMPORTANT:** DO NOT TIGHTEN THE NUTS UNTIL THE UNIT IS COMPLETELY ASSEMBLED.

- A)** Assemble the cutting frame with the legs as shown in Diagram I. (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.

- 3)** Insert the crank handle onto the lower drive roller shaft. Tighten the set screw.
- 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.

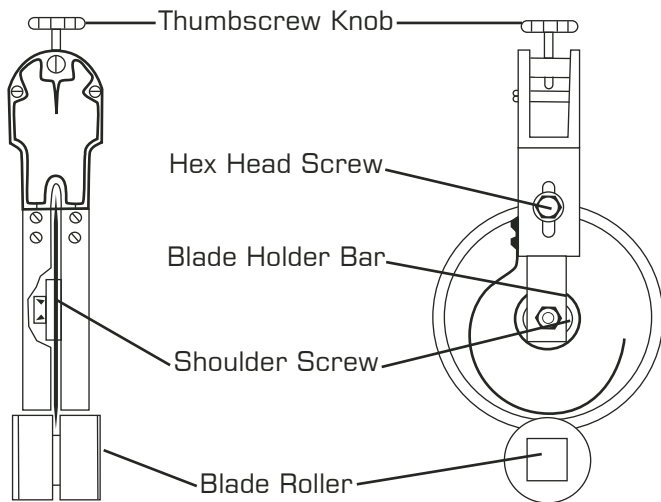


**Diagram II**  
**Cross Cut Handle**

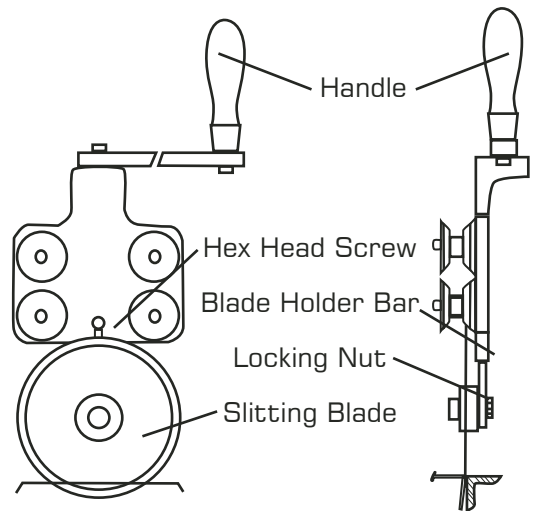


# BLADE REPLACEMENT & ADJUSTMENT INSTRUCTIONS

**Diagram IV  
Sitting Assembly**



**Diagram V  
Cross Cut Assembly**



**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).

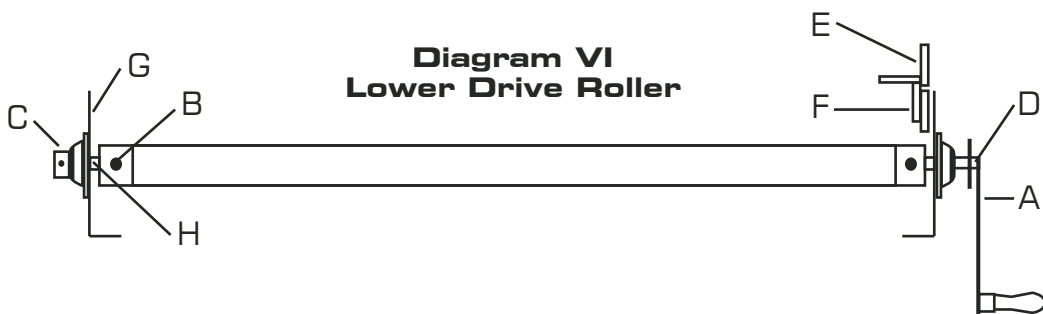
**2)** Attach the blade to the holder bar using the shoulder screw and locking nut. Position the blade in the blade roller. Insert the slitting blade about 3/32" to 1/8" into the blade roller slot. Tighten the hex head screw on the slitter blade casting.

**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**



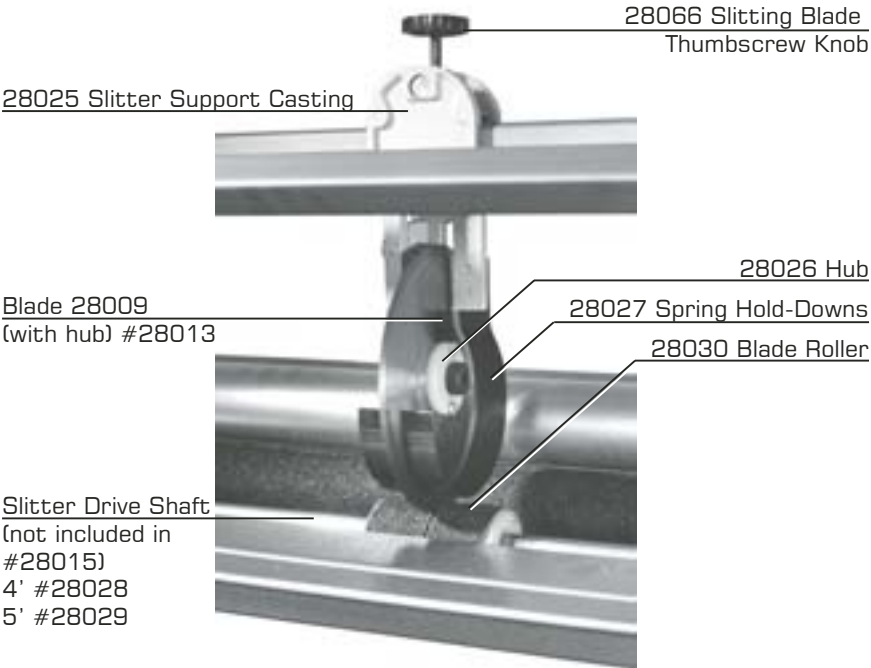
- 1)** Remove the crank handle (A).
- 2)** Loosen the set screw (B), extend the shaft (H) about 1", retighten the set screw.
- 3)** Remove the shaft collar (C), and position the crank handle (A) in place of the shaft collar. Tighten the set screw (D) in the crank handle leaving about 1/32" play. **NOTE:** 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).

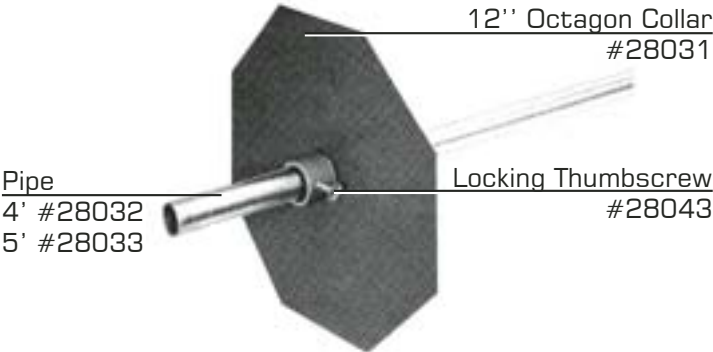
Be sure that all of the set screws are firmly tightened on flat area on shaft before operating machine.

**PARTS LOCATION**

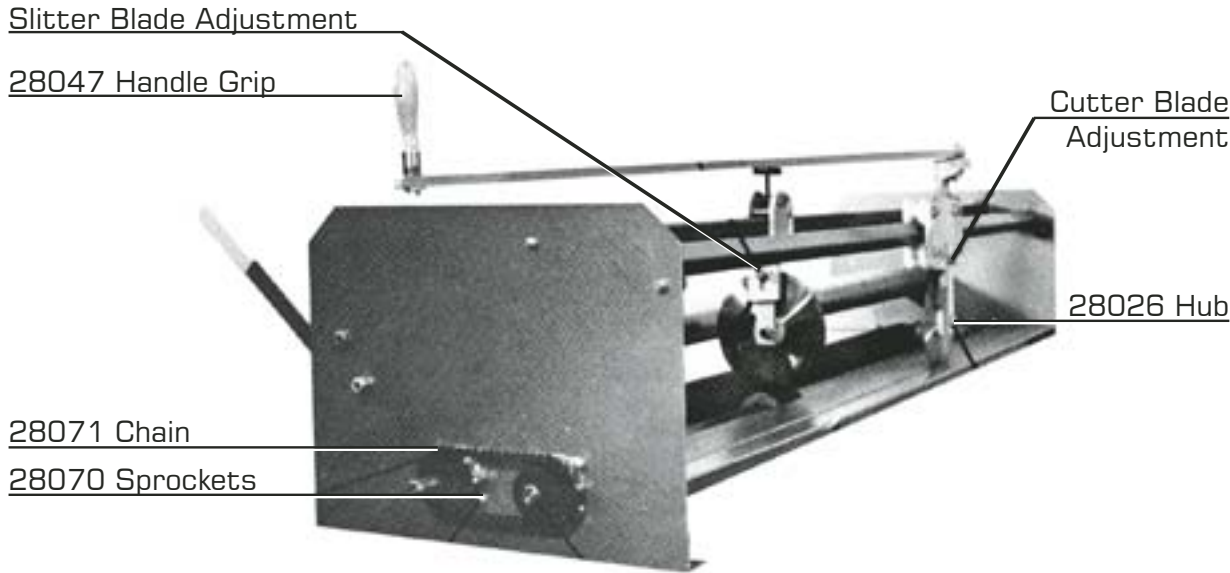
**Slitting Assembly (With Blade Roller) #28015**



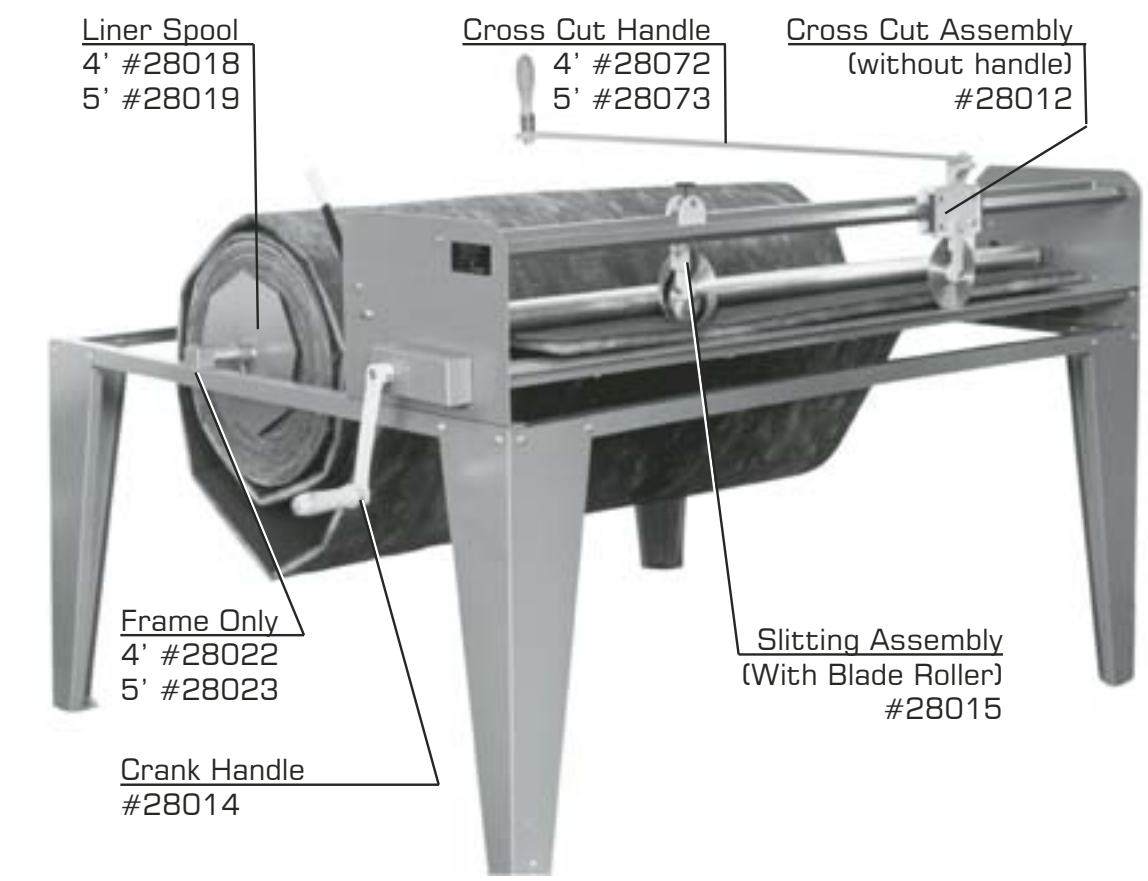
**Liner Spool      4' - #28018    5' - #28019**



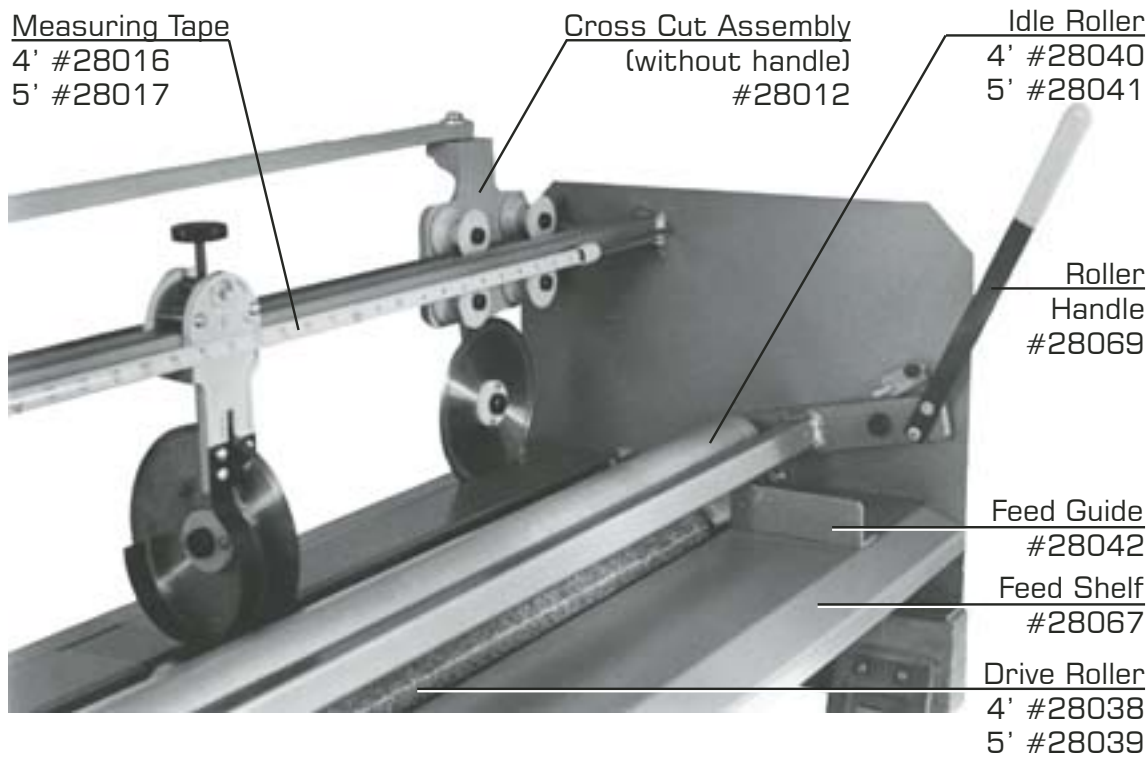
**Cutting Head (Side View)**



**PARTS IDENTIFICATION**



**Cutting Head  
(Top View)**





## LS PARTS & SPECIFICATIONS

ITEM#		DESCRIPTION	ITEM#		DESCRIPTION
LS-4 (4")	LS-5 (5")		LS-4 (4")	LS-5 (5")	
28009	28009	Blade	28040	28041	Idler Roller
28012	28012	Cross Cut Assembly (Without handle)	28042	28042	Feed Guide
28013	28013	Blade with Hub	28043	28043	Locking Thumbscrew
28014	28014	Crank Handle	28047	28047	Handle Grip
28015	28015	Slitting Assembly W/ Blade Roller	28058	28058	Nylon roller
28016	28017	Measuring Tape	28059	28059	Nylon Roller Bolt
28018	28019	Liner Spool	28060	28060	Blade Hub Bolt
28025	28025	Slitter Support Casting	28066	28066	Adjustment Knob
28026	28026	Blade Hub	28067	28068	Feed Shelf
28027	28027	Spring Hold Downs	28069	28069	Roller Handle
28028	28029	Slitter Drive Shaft	28070	28070	Sprockets
28030	28030	Blade Roller	28071	28071	Chain
28031	28031	12" Octagon Collar	28072	28073	Cross Cut Handle
28032	28033	Pipe	28061	28061	Sandpaper Kit
28038	28039	Drive Roller			

## 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 expend able 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.



### MACHINERY DIVISION

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Duro Dyne East Division, Bay Shore, NY

Duro Dyne Midwest Division, Fairfield, OH

Duro Dyne West Division, Santa Fe Springs, CA

Duro Dyne Canada, Lachine, Quebec, Canada

631-249-9000 Fax: 631-249-8346

513-870-6000 Fax: 513-870-6005

562-926-1774 Fax: 562-926-5778

514-422-9760 Fax: 514-636-0328

www.durodyne.com E-mail: durodyne@durodyne.com