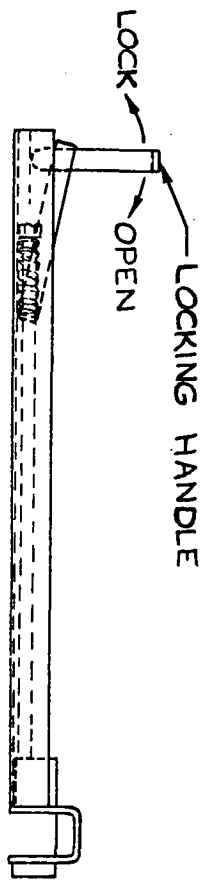


Installation and Operating Instructions

LOCKFORMER

Insulation Cutter

3. Thread insulation under tension roll. Tension can be adjusted to suit thickness being cut by sliding tension roll adjusting angle forward or backward.
4. Set front cutter assembly to desired width; with direct reading tape. NOTE! Tape reads from the left side of the machine.
5. Slide roller cutter to one extreme side of the machine.
6. Set length gauge stop to the desired length and lock toggle to keep setting consistent. See sketch No. 6.

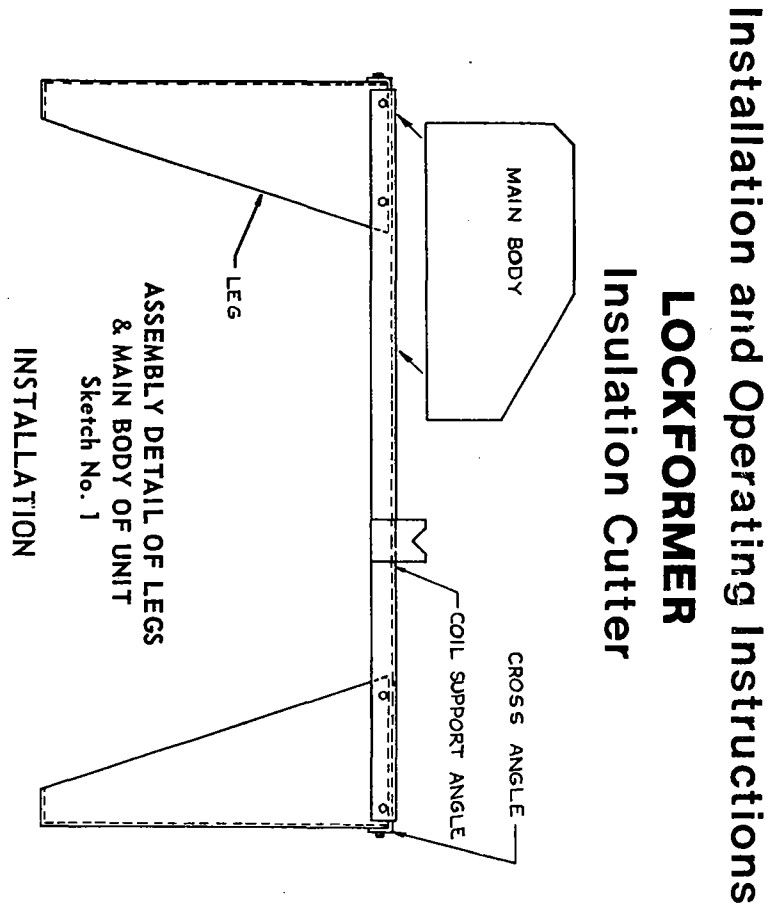


Sketch No. 6 LENGTH BAR ASSEMBLY

7. Pull insulation through the machine and out onto the runout table. Make sure the edge of the insulation is square up against the side gauge but not riding hard against it.
8. Pull material until it butts up against the length gauge.
9. Draw the roller cutter across the material cutting it to length.
10. Pull cut piece straight out of the machine to finish the cut. If this piece is not pulled straight out of the machine a crooked cut will result.
11. Repeat above operation until all pieces of the same size are cut then change blade location and proceed to next size.
12. Occasionally put a drop or two of oil on the cutter blade axles and the cutter rollers.

THE LOCKFORMER COMPANY

711 OGDEN AVENUE • LISLE, ILLINOIS 60532

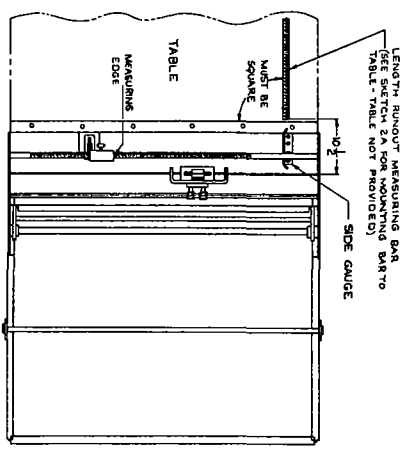


ASSEMBLY DETAIL OF LEGS & MAIN BODY OF UNIT
Sketch No. 1

PRELIMINARY: For convenience in shipping the unit is shipped knocked-down. Before attempting assembly be sure to read the assembly instructions completely.

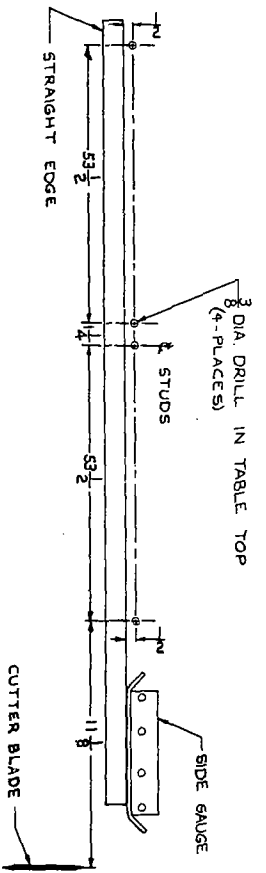
ASSEMBLY INSTRUCTIONS:

1. Begin assembly by bolting (2) legs to each of the coil support angles as illustrated on Sketch No. 1 using the 3/8-16X3/4" Lg. Hex Bolts, Lockwashers and nuts provided.
2. Bolt the cross angles to the leg assembly completed in step (1). See sketch No. 1.



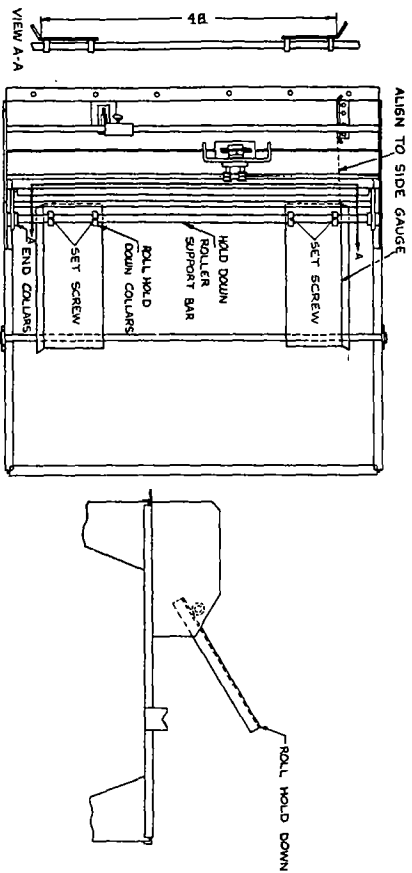
TOP ASSEMBLY
Sketch No. 2

3. The base assembly is now complete. Place the main body assembly in place on top of the base and attach with 3/8-16X3/4" Lg. Hex Bolts, Lockwashers and nuts provided.
4. Tighten all bolts to insure a stable assembly.
5. Place unit against run-out table (not furnished by Lockformer) and fasten with 1/4" carriage bolts and nuts furnished in package. Make sure edge of table is square with front edge of machine. See Sketch No. 2.



MOUNTING OF EDGE BAR GAUGE TO TABLE
Sketch 2A

- Fasten length runout measuring bar to table per sketch No. 2 and No. 2A. Make sure measuring bar is in line with the side gauge and square with the front edge of the machine.
- For operator's convenience the length runout measuring bar can be mounted on either the right or left side of the runout table. The unit as shipped is set-up for having the runout measuring bar on the left side of the table. For installing the measuring bar on the right side of the table remove the side gauge and fasten it to the right side of the machine in the holes provided and proceed as outlined in paragraph No. 6.

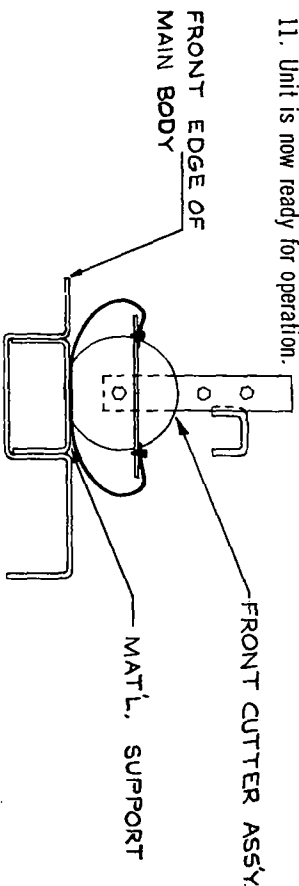


Sketch No. 3
TOP ASSEMBLY SHOWING
HOLD DOWNS IN POSITION

- Slide hold down roller support bar approximately 12" out of the main body and install the left and right hand roll hold downs. Line up the roll hold down with the side gauge and tighten the socket set screws in the collars on the roll hold down. Set the other hold-down 48" from the first unit and fasten in line with the first hold down. Tighten end collars. See Sketch No. 3.

- Place roller cutter assembly in place on rear cutter bar. Slide lower roll up until contact with cutter bar is made. Unit should slide freely on bar and yet be firmly located. Tighten lower roller bolts.

- Place slide cutter in place on front cutter bar with cutter blade engaged in material support. Lock to desired cutting position with thumb screw. See Sketch No. 4.
- Unit is now ready for operation.

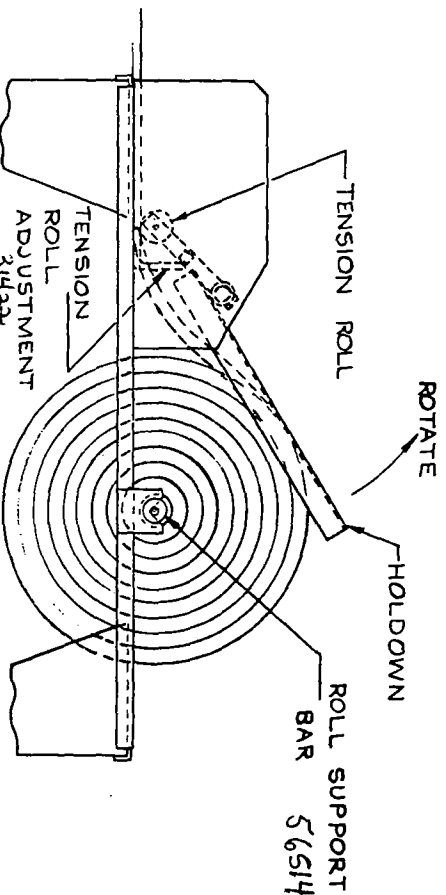


WIDTH CUTTER ASSEMBLY
Sketch No. 4
OPERATING INSTRUCTIONS

Capacity: 1/2" to 2" Thick X 48" Wide Fiberglass duct liner.
Outside diameter of rolls 40" Maximum.

Operation:

- Remove paper wrapper from duct liner roll. Also break off trim edges of roll as required.
- Swing hold down back out of the way. Insert roll support bar into the roll core and place into the roll support as illustrated on Sketch No. 5.



ASSEMBLY WITH INSULATION
ROLL IN POSITION
Sketch No. 5

PARTS LIST

PLEASE USE NEW NUMBER
WHEN ORDERING PARTS



New Part No.	Old Part No.	Description	Pieces Per Unit
56511	IC-101	Leg Assy.	4
56513	IC-102L	Suppt. Angle Assy.	1
56512	IC-102R	Suppt. Angle Assy.	1
29413	IC-103	Cross Ang.	2
56514	IC-104	Roll Shft. Assy.	1
71152	IC-105C	3/4 Ctr.	2
56516	IC-105L	Roll Hid. Dwn. Assy.	1
56515	IC-105R	Roll Hid. Dwn. Assy.	1
56517	IC-106	Mn. Bdy. Wid. Assy.	1
35601	IC-107	Sk. Sprt.	1
21508	IC-110	Cutter Mtg. Bar	2
56525	IC-111	Hid. Dwn. Suppt. Assy.	2
56518	IC-112	Roll Hlder. Assy.	1
42011	IC-113	Press Blt. 60240	2
56519	IC-114	Pressure Roll Assy.	1
19010	IC-115	Pvt. Bar	1
21507	IC-116	Cutter Hndi.	1
39920	IC-118	Lateral Spring	4
56527	IC-119	Cutter Slide Assy.	1
60795	IC-119C	4 x 3/16 Dr. Scr. TP-U	22
29600	IC-120	Side Guide	1
31422	IC-121	Roll Adj. Plt.	1
56520	IC-122	Ga. Assy.	1
21661	IC-122C	Slide Lock	1
56521	IC-122D	Lckng. Rod Assy.	1
22480	IC-122F	Toggle Bar	1
22002	IC-122G	Locking Lever	1
22003	IC-122H	Tension Bar	1
62702	IC-122I	3/16 x 3/4 Gr. Pin	1
62703	IC-122J	3/16 x 1-1/4 Roll Pin	1
71000	IC-122K	Comp. Sprng.	1
31914	IC-124	Slide Plt.	1
19161	IC-125	Roll	4
66400	IC-126	FF620-1 Ampix. Brg.	8
60006	IC-127	1/4-20 x 2-1/4 HHCS	4

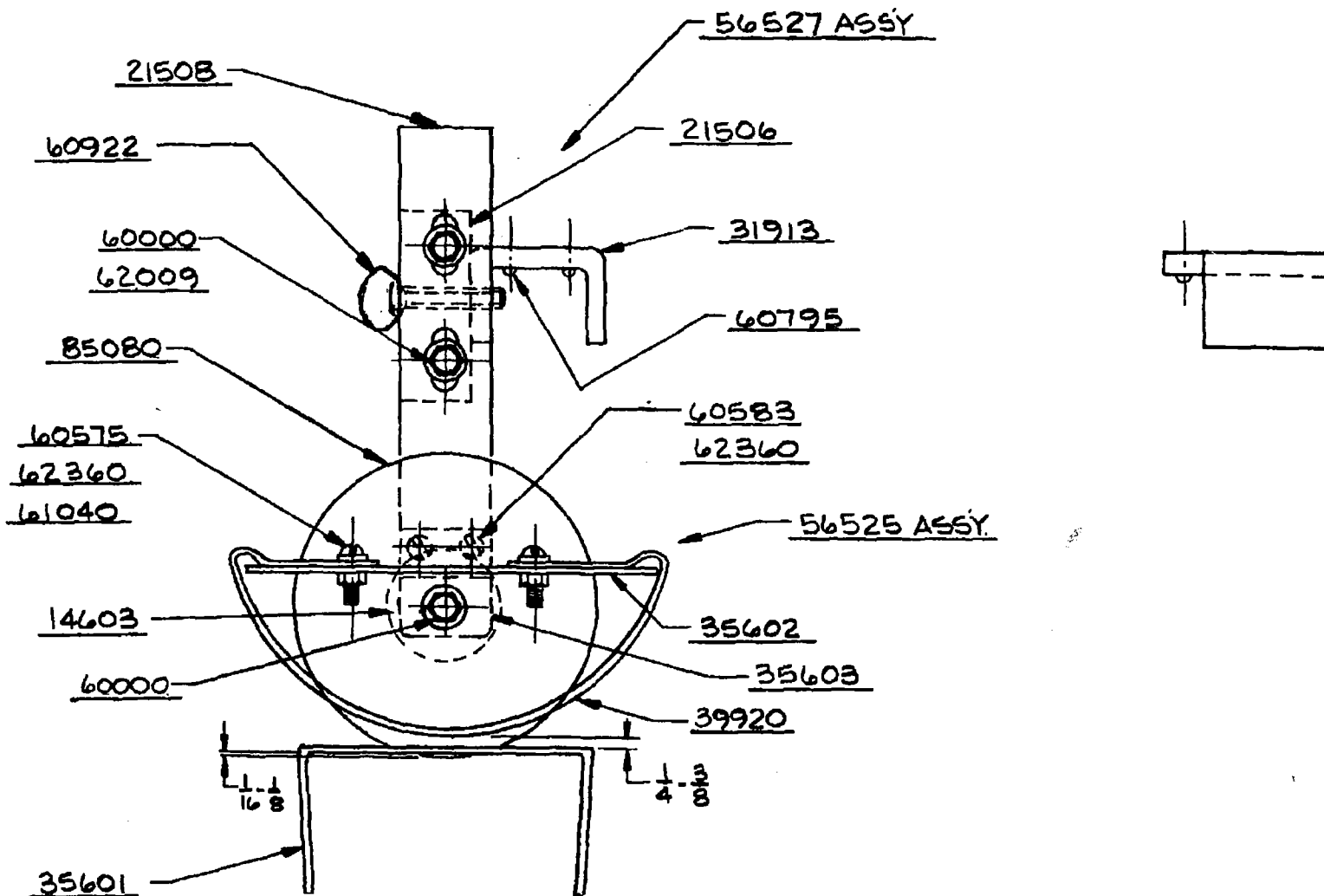
PARTS LIST

PLEASE USE NEW NUMBER
WHEN ORDERING PARTS



New Part No.	Old Part No.	Description	Pieces Per Unit
61060	IC-128	1/4-20 Hn. Fin.	13
62009	IC-129	5/16 Wshr.	8
56522	IC-130	Run Out Ga. Assy.	2
60090	IC-134	3/8 x 3/4 HHCS	20
62363	IC-135	3/8 Lck. Wshr. Med.	20
61120	IC-136	3/8-16 Hn. Hvy. Sf.	20
60875	IC-137	3/8-16 x 1 CB	1
61473	IC-138	3/8-16 Wing Nut	1
62029	IC-139	3/8 x 1/16 Wshr.	1
60852	IC-140	1/4-20 x 2-1/2 CB	6
62000	IC-141	1/4 x 062 Wshr.	4
60922	IC-143	5/16-18 x 1 Thb. Scr.	2
60575	IC-144	10-24 x 3/8 RHMS	12
62360	IC-146	3/16 Lck. Wshr.	12
61040	IC-147	10-24 Hn.	12
60000	IC-148	1/4-20 x 1/2 HHCS	8
62365	IC-149	5/8 Lck. Wshr.	2
70900	IC-150	Rubber Hndi.	1
85164	IC-151	Lckfrm. Logo	2
85168	IC-152	1 C. Name Plt.	1
60484	IC-154	10-24 SHCS	2
13517	IC-155	Axle Spcr.	4
62370	IC-156	1/46 Lck. Wshr.	4
85306	IC-157	Cutter Caution Tag	2
56523	IC-159	Movable Gu. Plt. Assy.	1
56524	IC-160	Strt. Gu. Plt. Assy.	1
14603	IC-109	Arbor Wshr.	2
85080	IC-108	Cutter Blade	2
85140	IC-117	Tape	2

COMPLETE ASSY IS PART# 9349999

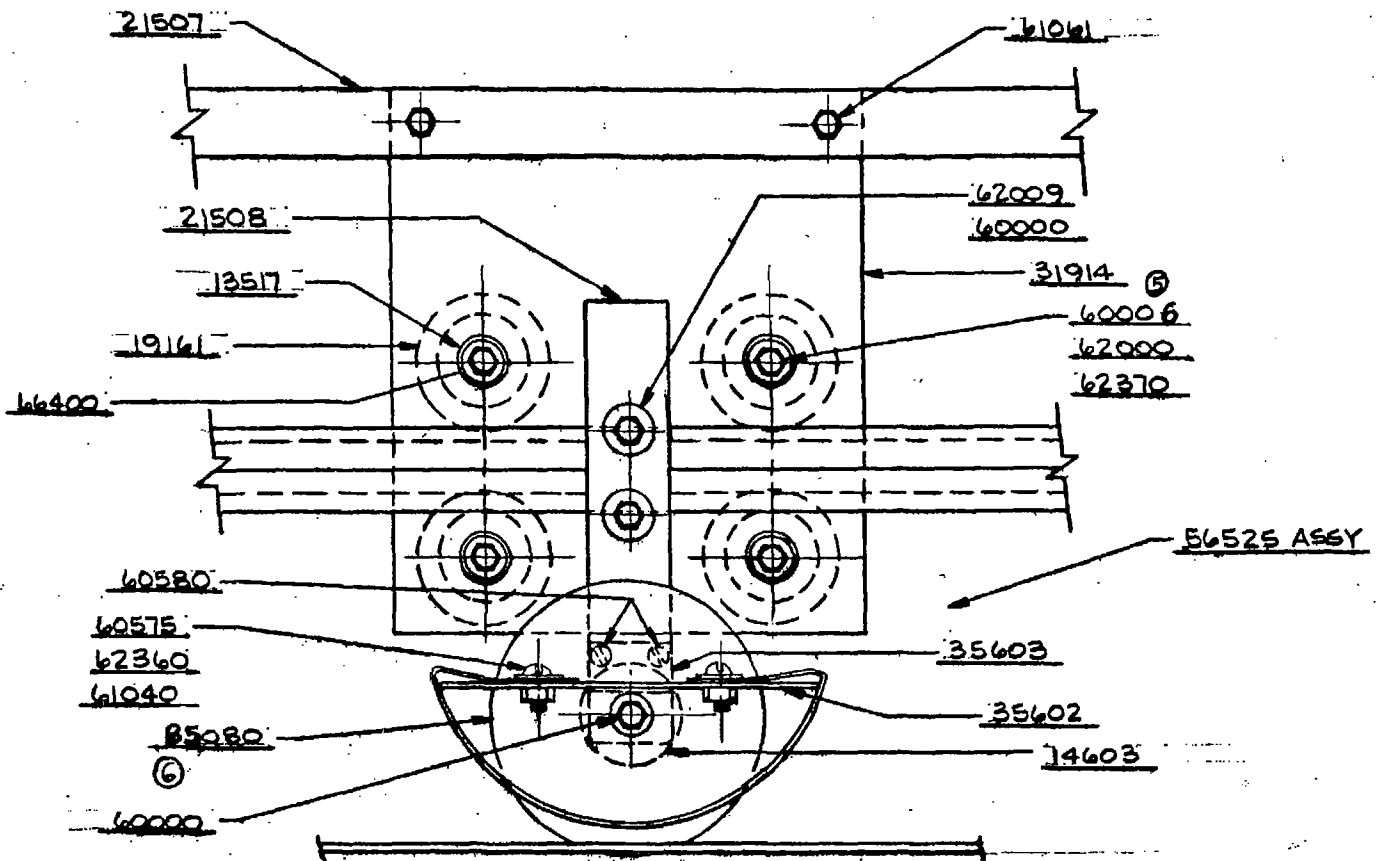


NOTE:
FOR WIDTH CUTS

IBM NO.	PART NO.	DESCRIPTION	AMT
	35601	IC-107 STOCK SPRT	1
	85080	IC-108 CUTTER BLD	1
	14603	IC-109 ARBOR WSHR	1
	21508	IC-110 CUTTER MTG BAR	1
	56525	IC-111 HLD DWN SPRT ASSY	1
	35602	IC-111-A HLD DWN SPRT	1
	35603	IC-111-B CLIP ANGLE	1
	39920	IC-118 LATERAL SPRING	2
	56527	IC-119 CUTTER SLIDE ASSY	1
	31913	IC-119-A CUTTER SLIDE	1
	21506	IC-119-B MOUNTING CLIP	1
	60795	IC-119-C DRIVE SCREW	4
	60922	IC-143 5/16-18x1 THUMB SCR	1
	60583	10-24x5/16 RHMS	2
	62360	IC-146 3/16 LOCK WASHER	6
	61040	IC-147 10-24 HEX NUT	4
	60000	IC-148 1/4-20x1/2 HEX. CAPSCR	2
	60575	IC-144 10-24x3/8 RHMS	4
	62009	5/16 WASHER	2

TOL
2
1

COMPLETE ASSY IS PART # 9349998



IBM. NO.	PART NO.	DESCRIPTION	AMT
85080	IC-108	CUTTER BLD	1
14603	IC-109	ARBOR WSHR	1
21508	IC-110	CUTTER MTG. BAR	1
56525	IC-111	HLD DOWN SPRT ASSY	1
35602	IC-111-A	HLD DOWN SPRT	1
35603	IC-111-B	CLIP ANGLE	1
21507	IC-116	CUTTER HNDL	1
39920	IC-118	LATERAL SPRING	2
31914	IC-124	SLIDE PLT.	1
19161	IC-125	ROLL	4
66400	IC-126	FF 620-1 AMPLX BRG	8
60006	IC-127	1/4-20x2 1/4 HHCS	4
62000	IC-141	1/4 x .062 WSHR	4
61061	IC-142	1/4-20 HN HVY SF	4
60575	IC-144	10-24 x 3/8 RHMS	4
62360	IC-146	3/16 LCK WSHR	6
61040	IC-147	10-24 HN	4
60000	IC-148	1/4-20x 1/2 HHCS	4
70900	IC-150	RUBBER HNDL	2
13517	IC-153	AXLE SPGR	4
62370	IC-156	1/4 LCK WSHR	4
60580		10-24 x 9/16 RHMS	2
62009		5/16 WSHR	8

NOTE:
FOR LENGTH CUTS

FORM # 113