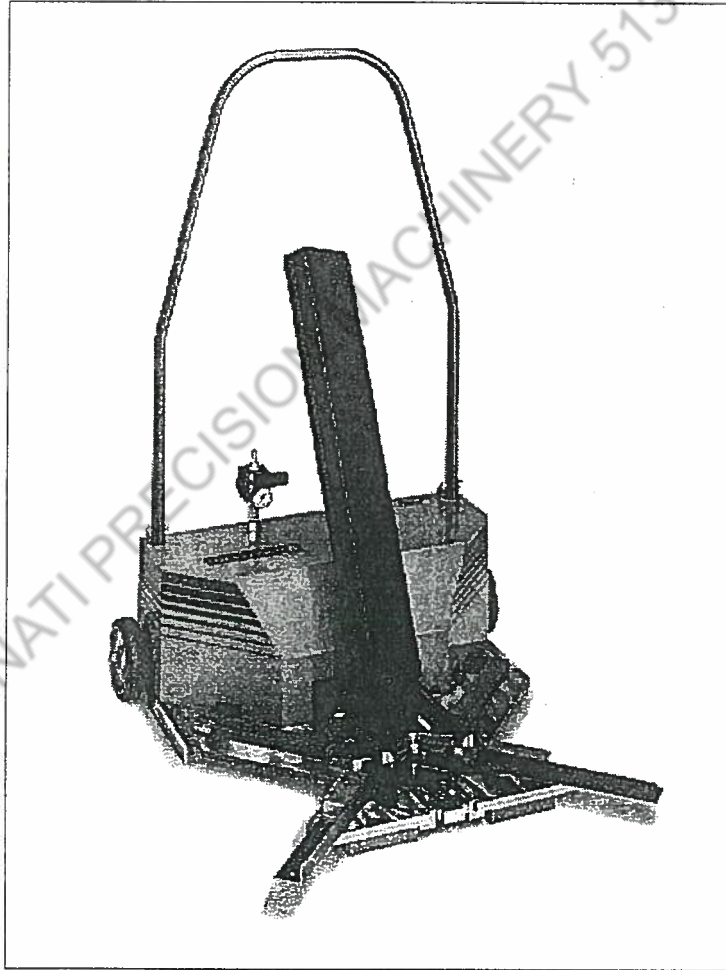


# Operator's Manual

# Corner Caddy™

Patent Numbers  
5,283,944 & 5,321,880



# LOCKFORMER

# SAFETY GUIDELINES



You are not ready to operate this equipment until you have read and understood the safety information in this manual.



## WARNING:

Do not wear loose clothing, neckties, improper gloves, or jewelry while operating this machine. If long sleeves must be worn, avoid loose cuffs or buttons. Tie back or contain long hair.

Wear proper gloves to prevent lacerations caused by sharp edges of stock.

Never operate this equipment unless all covers and guards are properly installed.

Be alert for loose, worn, or broken parts. Never operate this equipment unless it is in good working condition.

Keep hands clear of all pinch points.

Always disconnect the main power supply power and install lock outs when making adjustments or repairs.

When transporting, remember that this machine is front heavy.

**Remember that the information contained in this manual is only a portion of an adequate training program. It must be coupled with specific instructions for your application along with full information of national and local safety regulations that may apply.**

## Site preparation

Provide a clean, dry, lubricated, 100 p.s.i., 5 c.f.m., 3/4 inch pipe air supply line.

NOTE: A dedicated filter, lubricator, and regulator is recommended near the point of operation.

Install a 115 volt, 15 Amp. electrical receptacle at the point of operation in compliance with local and national electrical codes. For further information, contact a certified electrician or the Lockformer Service Department at (630) 964-8000.

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### IMPORTANT

This unit is designed to use only TDF/TDC Corners.

Order TDC corners from your local distributor or contact Iowa Precision at (319) 364-9181.

### NOTE

When using with angular or offset fittings consult Lockformer's Service Department.

# Assembly Instructions

1. Uncrate machine by removing the cardboard wrapper.  
DO NOT DAMAGE THE SHIPPING PLATFORM (A). This platform is designed to be positioned at the front of the unit, thus facilitating easy insertion of duct.
2. Remove any debris, packing material, etc., that may have accumulated during shipping.
3. Remove the four mounting screws (B) as shown in photo no. 1 and carefully remove the machine.
4. Move the machine and accompanying parts to a level assembly area.
5. Slide the handle onto the mounting posts and secure by inserting a snap pin (both sides).
6. Press the air supply inlet/regulator assembly onto the quick disconnect male fitting as shown in photo no. 2.
7. Using the (2) screws (D) provided install the magazine as shown in photo no. 3 (DO NOT OVERTIGHTEN).
8. The arms are mounted for TDC corner installation as shipped. When using TDF corners move each arm to the outer mounting holes as shown in photo 5.
9. Insert the power cord into the machine mounted receptacle (C).
10. Grasp the handle firmly and place one foot against a wheel while tilting backward.  
Transport to the desired operating site. Slowly lower while once again applying foot pressure against a wheel.  
**CAUTION:** This machine is front heavy. Use care when lowering it in place, especially if bystanders are present.
11. Place the shipping platform in front of the machine as shown in photo 4.  
Align the two mounting holes (E) with the holes in the end of the angle iron arms.  
Note: For TDC corners, use the holes spaced at 26 inches. For TDF use holes 26-1/8 inches apart.  
Insert and firmly tighten the two 5/16-18 x 2" mounting screws and washers provided.  
**CAUTION:** When working with very large duct, it is recommended that a proportionally larger platform be built for greater stability.

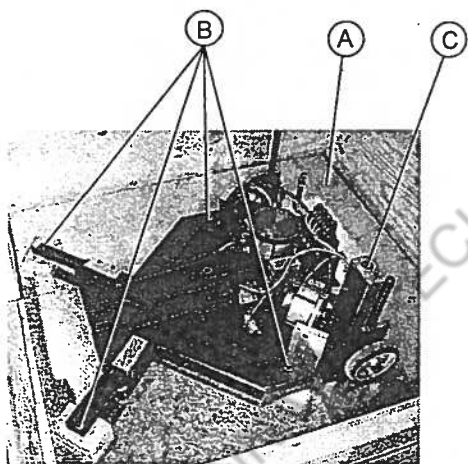


PHOTO 1

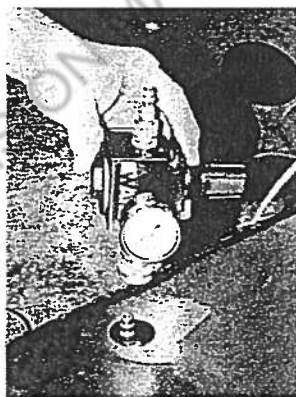


PHOTO 2

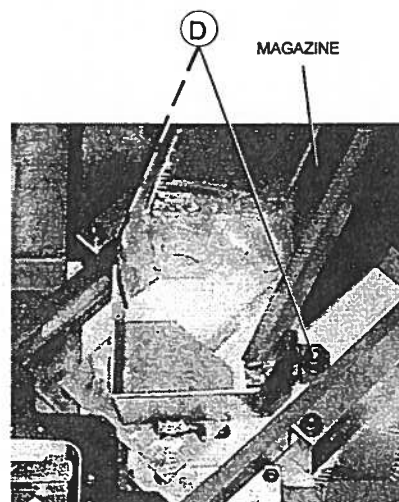


PHOTO 3

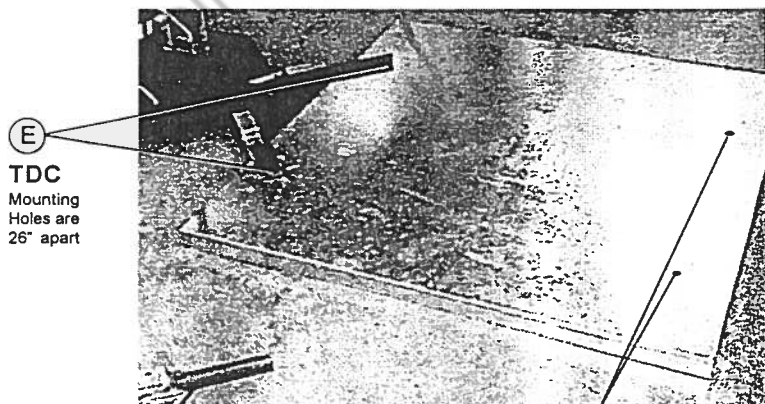


PHOTO 4

TDF Mounting Holes are 26-1/8" apart

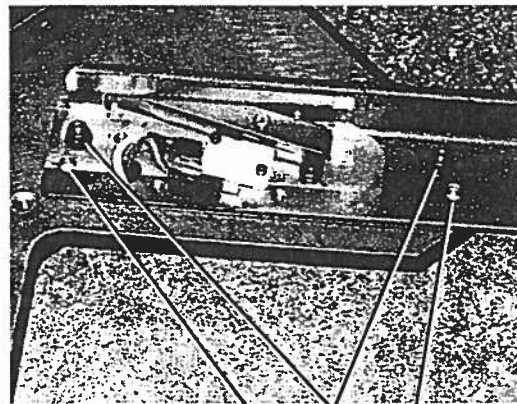


PHOTO 5

TDF TDC TDF

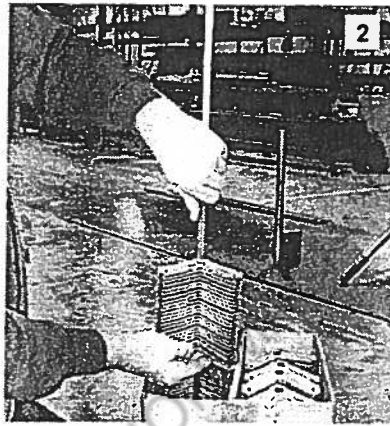
## Operating Instructions

1. Plug power cord into a 115 volt 15 amp. receptacle. A transformer enables the valve solenoids to operate on a 12 volt D.C. circuit.
2. Connect an air supply line to the air inlet.
3. Set the air pressure regulator to 80 to 100 p.s.i.
4. Load the magazine with corners. (Shown below)
5. Insert the duct into the unit. Dual switches automatically load and crimp each corner.
6. Index the duct 90 degrees and repeat the process until all corners are mounted.

### LOADING CORNERS INTO THE MAGAZINE



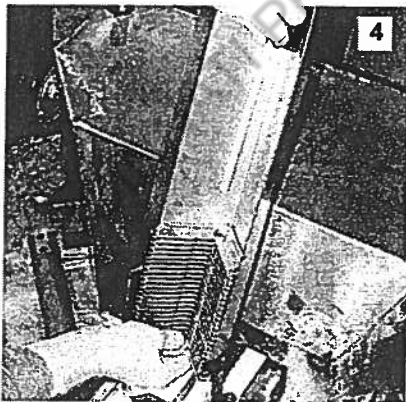
Open a box of corners from the top. With one hand, grasp a 3/8" square by 16" long metal bar (not included) and insert it into the holes of a stack of corners.



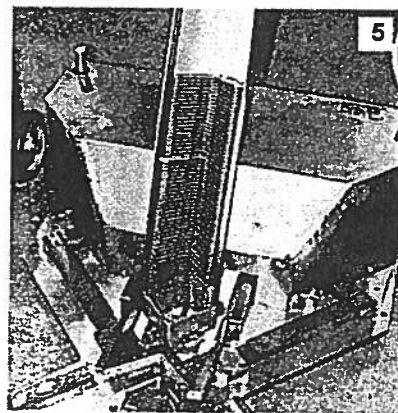
Place your other hand under the stack and lift out of box.



Invert and load the stack onto the lower portion of the magazine as shown.



Remove the square metal bar.



Continue to stack corners as required.

# Feed Speed Adjustment

## CAUTION

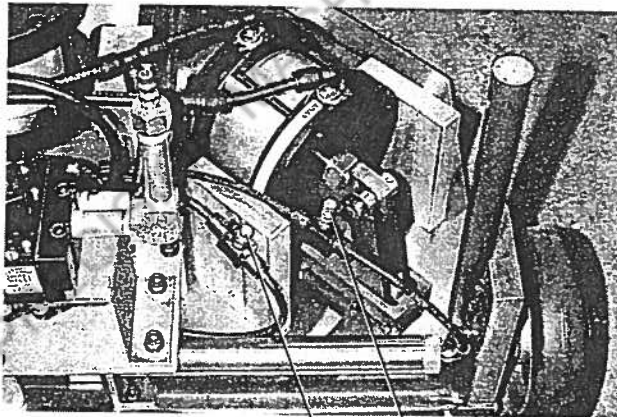
THE SPEED OF THIS UNIT IS FACTORY SET AND SHOULD NOT BE ALTERED. THIS ADJUSTMENT PROCEDURE IS INCLUDED AS A REPAIR FEATURE ONLY. DO NOT ADJUST UNLESS A PROBLEM OCCURS.

When performing adjustments to this machine:

1. Disconnect electrical and pneumatic power and deplete accumulated air.
2. Remove cover.
3. Make adjustments as outlined below.
4. REPLACE THE COVER
5. Test the operation and if necessary repeat the adjustment steps.

Two flow control valves (A) and (B) in the photo below control the speed of the corner feeding mechanism. Turn the flow control valve knobs in small increments to alter the speed.

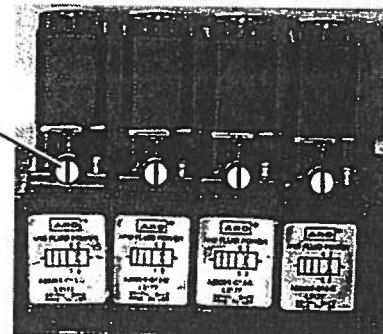
The valve marked (A) controls the advance speed of the feeder. The valve marked (B) controls the retract speed. Tighten the control knobs (clockwise) to slow speed and loosen to increase speed. Make all adjustments in small increments.



## SOLENOID SETTINGS

If the machine activates when connecting electrical power, turn all four solenoid activation switches to their vertical positions as shown in the accompanying photo.

MUST BE VERTICAL FOR PRODUCTION OPERATION





## Parts List

PART NO.	DESCRIPTION	QUANTITY	PART NO.	DESCRIPTION	QUANTITY	PART NO.	DESCRIPTION	QUANTITY
16370	Crimper Pivot Shaft	2	60950	Screw, 1/4x3, Gimlet Point Lag Screw	4	65213	Pipe Plug 3/8NPT,Skd Head	2
16372	Crimper Roller	2	60964	Flat Head Socket Head Screw	1	65728	Tube, Polyflow, 1/4" OD, Black	60
16374	Standoff	3	60967	Flat Head Socket Screw 7/4-20 x 7/8	1	70777	Chain, #41, Link Con	1
16385	Switch Lever Pivot Pin	2	60968	Flat Head Socket Screw 5/16-18 x 1/2	4	71177	Wheel, MC, Master, 2322T16	2
30125	Manifold Platform	1	61000	Nut 6-32	2	72331	Clr, Set, 3/8	2
32446	Valve Assy Bracket	2	61004	Jam Nut 7/16-20 Finished	2	72680	Sprocket, 4189, 1/2" Bore Boston	4
32460	Electrical Box Bracket	1	61124	Jam Nut 3/8 - 24	2	72681	Spring, Lee LCO400-11	2
38044	Shipping Platform	1	61358	Jam Nut Fin 1-1/8	2	73014	Chain, #41, 1/2, 100	43
42072	Modified Shoulder Bolt	2	61367	Nut, 5/16-18, Heavy Hex Nut	4	80573	Cable, Shield, 2 cond, 8760	120
51560	Wheel Bracket Weldment	2	61371	Nut, 3/4-16, Jam Smooth Finished	2	81598	Conn, Wire, #30-210SS, #10	1
51564	Presser Arm - Left	1	61444	Nut, Weld, Spot, 1/4-20 #PN 2113	2	84328	Conn, Female Insulated/ Panduit	2
51565	Presser Arm - Right	1	61935	Flow Control, Legris 77705600	4	84548	Switch, Cherry D44L-RILD	2
51644	Magazine Weldment	1	61938	Elbow, 3/8, 31096018	6	84550	Limit Switch, Grainger 2XC12	2
51658	Cover Weldment	1	61939	Tee, 3/8 Tube, LEGRIS 31046000	2	84638	Replacement Bulb for Part No. 84563	1
60051	Hex Head Screw 5/16-18 x 2	2	61940	Elbow, 1/8NPT, 1/4T, 31095611	4	84923	Electrical Enclosure Assembly	1
60053	Hex Head Screw 5/16-18 x 3-1/2	4	61941	Elbow, 1/4NPT, 1/4T, 31095614	4	AA14580	Lock Pin	1
60096	Hex Head Screw 3/8-16 x 1-1/2	4	61942	Elbow, 1/4NPT, 3/8T, 31096014	4	AA26024	Pressor Block	2
60268	Hex Head Screw 3/4-10 x 3-1/4	2	61943	Adapter, 1/4NPT, PARKER 222P-4-4	2	AA26026	Presser	1
60302	Socket Head Screw 1/4-20 x 5/8	6	61946	Tube, Paraflex, 3/800.E8-64-0100	50	AA26029	Presser Arm End Block	2
60303	Socket Head Screw 1/4-20 x 3/4	4	62000	Washer, Flat, 1/4, 9/16, .062	6	AA26030	Rod End Trunnion	1
60306	Socket Head Screw 1/4-20 x 1-1/2	4	62360	Washer Lock, #10 Med	4	AA26031	Presser Pivot Block Left	1
60310	Socket Head Screw 1/4-20 x 1/4	2	62362	Washer, Lock, 5/16, Med	26	AA26032	Presser Pivot Block Right	1
60312	Socket Head Screw 1/4-20 x 7/8	4	62363	Washer Lock, 3/8 Med	10	AA26033	Presser Cylinder Support	2
60350	Socket Head Screw 5/16-18 x 3/4 Nylock	23	62364	Washer Lock, 1/2, Med	8	AA26034	Crimper Bar	2
60352	Socket Head Screw 5/16-18 x 1	10	62368	Washer Lock, 7/16, Med	1	AA26035	Hold Down Bracket Right	1
60353	Socket Head Screw 5/16-18 x 1-1/4	3	62370	Washer, Lock, 1/4, Med	10	AA26037	Hold Down Bracket Left	1
60355	Socket Head Screw 5/16-18 x 2	5	62559	Stud, 3/8-24.2-1/2 LG 18-8 SS	1	AA26038	Pivot Link Crimper	2
60357	Socket Head Screw 1/4-20 x 1/2	4	62632	Dowel Pin 3/8, 7/8	8	AA26039	Crimp Driver	2
60362	Socket Head Screw 1/4-20 x 2-3/4	4	62633	Dowel Pin 3/8, 1	2	AA26040	Crimper Drive Lever	4
60384	Socket Head Screw 1/4-28 x 1-1/4	4	62636	Dowel Pin 3/8, 2	1	AA26041	Pivot Block	4
60403	Socket Head Screw 3/8-16 x 1-1/4	2	62644	Dowel Pin 3/8, 2-1/4	3	AA26042	Rod End Crimper	2
60417	Socket Head Screw 10-32 x 3/4	10	62744	Cotter Pin, 1/8, 1	2	AA26043	Cylinder Mounting Plate	4
60460	Socket Head Screw 1/2-13 x 1-1/4	8	62772	SHCS, Button, #8-32, 1/4	8	AA26044	Drive Retainer	2
60484	Socket Head Screw 10-24 x 3/4	6	62799	RHMS, 1/4-20, 1/2 With Lock Washer	4	AA26045	Pusher	1
60485	Socket Head Screw 10-32 x 1/2	3	62918	SHCS, 5-40, 5/8	4	AA26046	Chain Bracket	1
60495	Socket Head Screw 10-32 x 3/8	2	62938	SHCS, Button 1/4-20, 1/2	2	AA26047	Pusher Guide	1
60498	Socket Head Screw 5/16-18 x 3/8	4	63064	1/4-20X1-1/4 Button, H D S.C.S.	4	AA26048	Pusher Platform Left	1
60564	Round Head Machine Screw 6-32 x 1/4	3	63072	Snap Pin McMaster 98416A011	2	AA26049	Pusher Platform Right	1
60588	Round Head Machine Screw 6-32 x 1	4	63073	Clevis Pin, McMaster 98306A730	2	AA26050	Chain Bracket	1
60606	Socket Set Screw 10-32 x 1/4	1	63074	T-Nut, 5/16-18, MC MASTER	6	AA26051	Idler Sprocket Plate	1

Continued on the next page

## Parts List (cont.)

PART NO.	DESCRIPTION	QUANTITY	PART NO.	DESCRIPTION	QUANTITY
AA26052	Lock	1	AA60506	FHSHCS, #10-32X3/4	2
AA26053	Lock Linkage	4	AA62001	Washer Flat 5/16, 3/4, 1/16	8
AA26054	Linkage Base Left	1	AA62605	Dowel Pin 28420-500-A-20	2
AA26055	Linkage Base right	1	AA62609	Dowel Pin 28420-500-A-12	4
AA26056	Drive Bar	1	AA65451	Air Cylinder 4.002FCD9X2.25	3
AA26057	Drive Bar Guide	2	AA65452	Air Cylinder 1.50NCD9X2.50	1
AA26058	Lock Cylinder bracket Top	1	AA65454	Air Cylinder SDR-17-6-1/2	1
AA26059	Lock Cylinder Bracket Botton	1	AA65539	Aro Alpha Valve Stack Assy	1
AA26060	Lock Cam	1	AA66420	Bronze Bearing B68-6	8
AA26061	Cam Guide	1	AA66421	Bronze Bearing B610-6	4
AA21068	Side Rail	2	AA66422	Bronze Bearing B68-4	2
AA26069	Front Rail	2	AA66423	Bronze Bearing B812-4	4
AA26070	Switch Lever	2	AA66425	Bronze Bearing B1216-6	1
AA26071	Wire channel	2	AA66426	Bronze Bearing B68-3	8
AA26072	Base Plate	1	AA66428	Bronze Bearing B812-6 Boston	2
AA29832	Cylinder Mounting Angle	1	AA66429	Bronze Bearing B68-8 Boston	2
AA29834	Switch Rail Right	1	AA66430	Bronze Bearing B1012-6 Boston	2
AA29835	Switch Rail Left	1	AA66431	Bronze Bearing B810-4 Boston	4
AA35653	Presser Switch Bracket	1	AA66624	Cam Follower Switch ,Smith HR-3/4-XB	1
AA35654	Pin Retainer	4	AB28047	Handle Per Print	1
AA35657	Switch Cover	2			
AA60004	HHCS, 3/4-16, 1-3/4 LG	1			
AA60358	SHCS, 6-32, 1	2			
AA60378	SHCS, 3/8-16X4- Nylock	4			



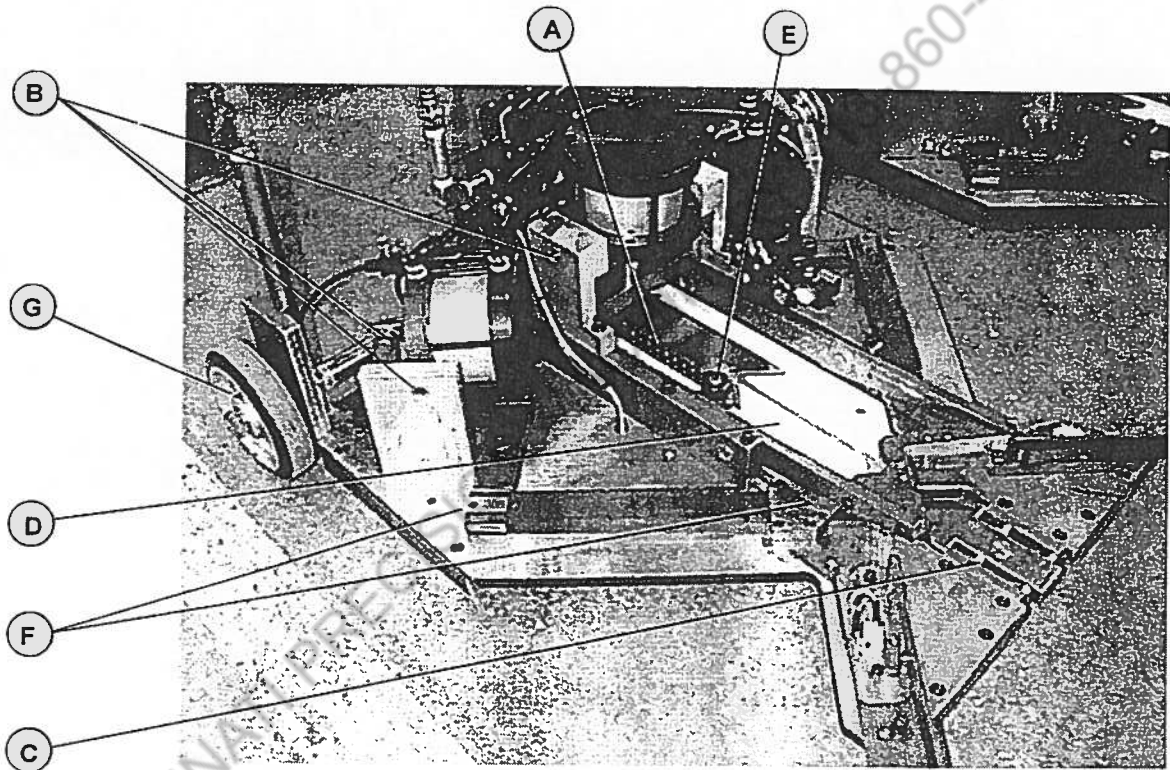
# Maintenance

## CLEANING

For optimum performance this machine should be kept clean. Be sure that all moving parts are free from debris and accumulations of dirt and grease. Wipe clean with a rag and apply a light film of oil to all unpainted surfaces. Storing indoors in a dry environment will help reduce rust and corrosion.

## LUBRICATION

This machine was lubricated prior to shipment. Frequent lubrication will allow this unit to operate efficiently and prolong the life of the moving parts. A lubrication schedule should be established and maintained. Refer to the chart below for lube point locations and minimum lubrication intervals.



THE LUBRICATION POINTS ARE SHOWN ON ONE SIDE OF MACHINE ONLY

ITEM	DESCRIPTION	LUBRICANT	APPLICATION	SCHEDULE
A	CHAIN	LIGHT OIL	MAINTAIN A LIGHT FILM	EVERY 40 HOURS
B	CYLINDER CLEVIS PINS	LIGHT OIL	APPLY A FEW DROPS ONTO PINS	EVERY 40 HOURS
C	CLAMP PIVOT PINS	LIGHT OIL	APPLY A FEW DROPS ONTO PINS	EVERY 40 HOURS
D	TOP OF DELRIN SLIDE BAR	LIGHT OIL	APPLY SEVERAL DROPS TO SURFACE	EVERY 40 HOURS
E	SPROCKETS	LIGHT OIL	APPLY SEVERAL DROPS TO BORE	EVERY 40 HOURS
F	UNDER CRIMP BARS	LIGHT OIL	APPLY SEVERAL DROPS UNDER BARS	EVERY 40 HOURS
G	WHEELS	GREASE	GREASE GUN	MONTHLY
•	ALL MOVING PARTS NOT LISTED ABOVE	LIGHT OIL	AS REQUIRED	EVERY 40 HOURS