

FasNSmooth® Cutting & Ovalizing Instructions

Because its smooth inner layer is not mechanically fastened on the downward side, traditional cutting methods are not usually successful.



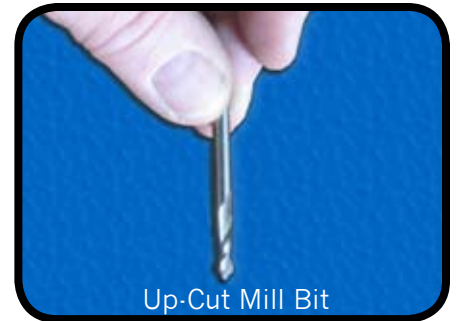
PTS purchased the variable speed **RotoZip®** by **Bosch** for around \$150.00. We first tried the fixed speed model and it works fine. However, the mill bits last much longer when used at 20,000 RPM as compared with the 30,000 RPM fixed speed version. The kit we purchased comes in a carrying case, includes various Bits, a 90° Angle Grinder and three cutting blades: a Dry Diamond Wheel, Metal Wheel and **Masonry Wheel**. We also purchased the CRCT1 **Circle Cutting Guide** for \$18 and an **Up-Cut Mill Bit** for \$12.



90° Angle Grinder



CRCT1 Circle Cutting Guide



Up-Cut Mill Bit

WEAR GLOVES AND EYE PROTECTION WHEN HANDLING/CUTTING ANY LINERS!



Straight Cut -

We tried all three cutting blades and achieved excellent results with the masonry wheel. Therefore, set up the 90° Angle Grinder with the masonry wheel. Make a cut across the liner's corrugations first, then follow the corrugations all the way around the liner. While cutting, **rotate the liner away from you and with the direction of the wheel's rotation**. This method produces a nice, clean cut across both layers of FasNSmooth® and greatly increases the lifetime of the Masonry wheel.

Cutting a Hole for the Universal Take-Off -

Set up the RotoZip® with the Up-Cut Mill bit (none of the bits supplied with the standard kit work well) and the Circle Cutting Guide. Set the guide for the desired hole diameter. **NOTE: The use of the Up-Cut Mill Bit is essential, as it pulls the inner layer of steel against the corrugated layer of FasNSmooth®, producing a clean cut across both layers.**



- Drill a 1/4" where the center of the Universal Take-off will be located in the liner
- Position the rubber guard of the Circle cutting guide into the 1/4" hole
- Turn on the RotoZip® and begin cutting the liner in a clockwise direction. Keep the RotoZip® perpendicular to the liner at all times. You do not need to apply much pressure - let the drill bit do the cutting for you

Ovalizing FasNSmooth® liners -

As with any other liner, use our Ovalizing Machine for this purpose. When the outside diameter of any thin walled liner is reduced beyond a certain point, it tends to develop "crinkles" on the major OD. The same is true when ovalizing FasNSmooth®, it only looks different: the inner layer may begin to "pucker". While this does not reduce the structural stability of the liner, you should be aware of this possibility.



Please Visit www.protechinfo.com for a Demo Video of these Instructions