LIGHT WEIGHT **ROUND KNIVES TYPE BBS32 TYPE BBB32** (PAGE 6) **CAUTION MACHINE EQUIPPED WITH SHARP BLADE TYPE D2H** (PAGE 8) (PAGE 12) TYPE D2 (PAGE 8) hickadee I

INSTRUCTION BOOK AND PARTS LIST

DESCRIPTION



BBS – Equipped with single Sharpener and Shear Plate where continuous honing of Knife is desired. 3 1/4" Hexagon Knife.



BBB32 – Has a 3 1/4" Knife for increased capacity and an adjustable Throat Plate.

CAUTION -

Read instructions carefully before starting motor. Be sure that voltage and current are the same as stamped on nameplate. All Eastman machines shown in this catalogue are equipped with sharp blades and extreme caution should be used when this machine is put into use. When this equipment is not being utilized, the power supply should be disconnected from the equipment.

TO OPERATE MACHINE

Turn machine to ON position; if cutter does not start immediately return switch to OFF position. Check the line output and be sure that the unit is plugged in properly and is making full contact. Do not attempt to start this unit while it is in the material to be cut.

WARNING

Before performing any of the following procedures, make sure that the attachment plug has been disconnected from power source.

KNIFE REPLACEMENT

BBS32 (page 5) – To remove knife, lay machine on side and carefully insert blade of screwdriver into fan of the motor and using Spanner Wrench (95C1-19) inserted into Locknut (4C1-175) or (4C1-182), turn counterclockwise and remove Locknut – replace knife making sure the word "Eastman" faces outward.

BBB32 – To remove knife, line up hole in knife and hole in standard, insert pin and use Spanner Wrench (95C1-21). Turn counterclockwise and remove. Replace knife with Eastman name facing outward.

CAUTION -

Discard used sharp knives with care.

THROAT PLATE ADJUSTMENT

BBB32 (Page 7) – These machines are equipped with an adjustable Throat Plate (79C5-249) and it is important that the edge of the knife be as close as possible without touching edge of knife and equally straddling the blade. Two (2) Screws located on bottom of base can be loosened and tightened for this adjustment.

SHEAR PLATE ADJUSTMENT

BBB (Page 5) – When adjusting the shear plate on the Model BBB, adjusting screw (20C6-26) in a clockwise manner will increase the spring tension on the shear plate; adjusting the screw in a counterclockwise manner will reduce the spring tension.

LUBRICATION

BBB32 - BBS32

OIL – Fill oil cup (72C4-2) daily and a small drop of SAE 30 nondetergent motor oil at each end of Sharpener Adjusting Bushing.

GREASE – To lubricate, remove Plug (54C4-35) page 5 or page 7 and inject small quantity of Eastman Gear Lubricant Special Formula (242C2) at 90 day intervals for intermittent use. Every six months the (20C12-145) (BBB32) and (20C12-165) (BBS32) screws that retain the knife gear should be removed and the knife gear taken out and inspected thoroughly to insure that no thread or lint build-up is in or around the gear area.

- CAUTION

Do not use sewing machine oil or detergent oil. It is entirely too light for cutting machine lubrication. For best results use specially compounded Eastman Oil or at least a good grade SAE 30 motor oil. Do not oil base plate rollers.

Do not overload with grease as machine will run hot at gear assembly. Remove knife and gear and remove excessive grease.

MAINTENANCE PROCEDURES

- Keep rollers of the base plate free of lint. Motor should be blown clear of lint and dust weekly using air hose at 90 P.S.I.
- Periodically check terminal pins on the terminal block and the terminal in the attachment plug to insure full contact.
- When replacing the knife on your cutting unit be sure to clean out any lint build up between knife and standard.
- 4. If the cutting unit seems to lag or run hot when not cutting, run machine with knife removed to check for overgreasing or any obstructions.
- 5. When changing knife or cleaning machine check all screws and nuts for tightness.
- Carefully remove spring loaded brushes replace brushes when worn to less than .165 inches (4.2mm) or if springs are less than .350 inches (9.00mm).
- When your machine performance does not appear to be up to par, contact your Eastman Machine authorized dealer.

MOTOR BRUSH REPLACEMENT

When replacing brushes (36C1-13) in the motor, carefully remove the (54C4-43) brush caps, remove the (34C1-58) brush with springs and replace brushes accordingly.

KNIFE SHARPENING

BBB32R – BBS32 – Connect power cord and switch motor on. To obtain a fine, keen edge on the blade, press lightly on sharpener lever or button with a constant pressure.

KNIFE SHARPENER REPLACEMENT

BBB32 - BBS32

CAUTION -

Disconnect from electric power source when servicing.

As the emery wheels wear away and become farther apart, they must be adjusted. Proceed as follows:

- 1. Slightly loosen four (4) slotted screws (300C8-2) holding adjusting bushings in place.
- 2. With fingers, turn adjusting bushings (20C6-23) until emery wheels are as close together as possible without touching and centered over knife. Both wheels should grind at the same time when pressed lightly against knife with a maximum 1/32 inch clearance between wheels. The sharpened edge (bevel) should be no more than 1/16 inch.
- 3. Tighten four (4) screws.

TO REPLACE EMERY WHEELS BBS32

- Remove left hand cap 2 screws (300C8-2)
 lift out emery wheel with bushing.
- 2. Remove screw (20C13-30).
- 3. Coat new emery wheel spindle with oil and re-assemble to arm (620C1-21).
- 4. Repeat above steps for right hand emery wheel.

NOTE

Left and Right caps must be replaced in the same manner that they were removed.

BBB32

- Remove cap (35C5-45) and lift out emery wheel and bushing. Then remove screw (304C10-3) from left hand emery wheel and pull out emery wheel (541C1-10). Replace wheels and re-assemble.
- 2. Adjust wheels as outlined for BBR.

BBS32

Remove sharpener (637C1-23) from machine and disassemble as shown in diagram page 5 – replace emery wheel (541C1-22). Lubricate – re-assemble – re-install.

220 VOLT MACHINES

When using the 220 volt machine on three phase outlets, use adaptor (509C1-54) by simply mounting this adaptor on the (25C5-49) single phase attachment plug. The two live leads of the (615C1-5) three phase attachment plug can be utilized for the power this machine requires.

KNIFE GUARD ADJUSTMENT

Knife guards (25C4-144) and (25C4-106) should be regulated in a manner that only allows the material to pass through the material to be cut.

REPLACEMENT BLADES

Machine Type	Size	Part N Carbon	umber High Speed	Blade Type
BBS32	2 1/2"	80C1-114 80C1-138*	80C1-114HS —	Round Hex
BBB32	3 1/4"	80C1-84*	80C1-84HS	Round
D2 D2H	2 1/4"	_	80C1-147HS* 80C1-149HS	Round Hex
BUZZ	2-1/32"	_	80C1-123HS* 80C1-133HS	Semi Square Octagon

^{*}Standard Blade

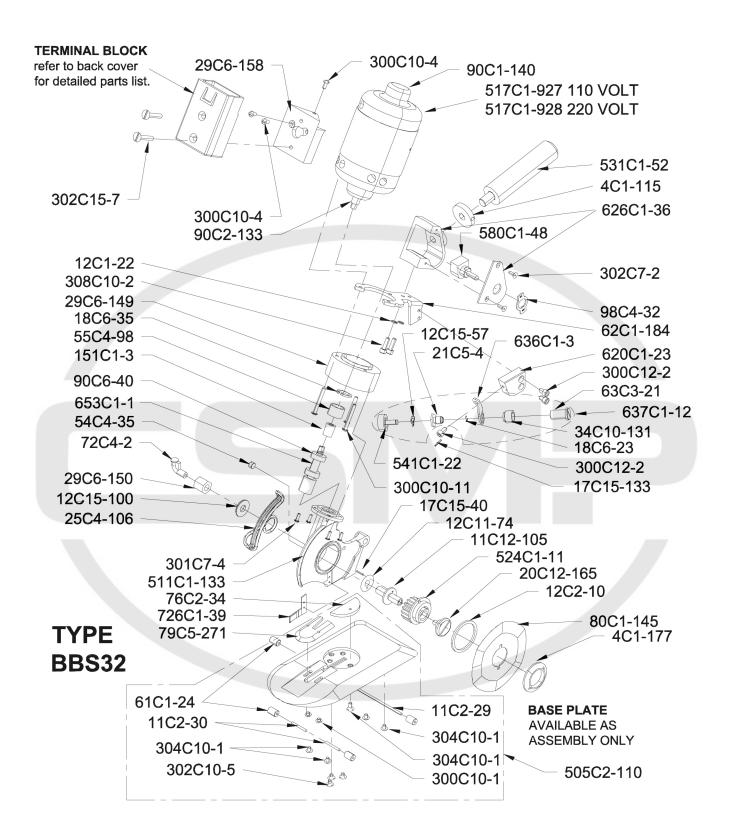
ILLUSTRATED PARTS LIST



TYPE BBS32

Note: Please specify model and serial number of machine when ordering parts.

Part No.	No. Req'd	Description
4C1-115	1	HANDLE LOCKNUT
4C1-177	1	KNIFE LOCKNUT
4C2-101	2	WIRE NUT
11C2-29		REAR ROLLER SHAFT
11C2-30		FRONT ROLLER SHAFT
12C1-22		WASHER, SHAKE PROOF
12C2-10		FELT WASHER FOR STAND
12C11-74		SPACING WASHER
12C15-57		SPRING WASHER
12C15-100		WASHER FOR WORM GEAR SHAFT
17C15-40		PIN IN STANDARD
17C15-133		PIN, ROLL 1/16 X 3/8
18C6-23		SNAP RING
18C6-35		RETAINING RING
20C12-165		THRUST SCREW
21C5-4		EMERY WHEEL BUSHING
25C4-106		KNIFE GUARD
29C6-149		MOTOR ADAPTOR
29C6-150		OIL CUP ADAPTOR
29C6-158		TERMINAL BLOCK ADAPTOR
34C1-58		BRUSH SPRING
34C10-131		SHARPENER SPRING
36C1-13		BRUSH
54C4-35		GREASE PLUG
54C4-43		BRUSH PLUG
55C4-98		SPACER BEARING
61C1-24		PLATE ROLLER SHELL
62C1-184		HANDLE BRACKET
63C3-21		SHARPENER BUTTON
72C4-2		OIL CUP
76C2-34		PLATE FILLER
79C5-271		THROAT PLATE
80C1-145		KNIFE
90C1-140		BEARING HOUSING REAR
90C2-133		BEARING HOUSING FRONT
90C6-40		BALL BEARING, WORMSHAFT
98C4-32		ON/OFF CLIP
151C1-3		COUPLING MOTOR
300C10-1		SCREW, 6-32 X 3/16 ROUND HEAD
300C10-4		
300C10-11		SCREW, 6-32 X 11/16 ROUND HEAD
300C12-2		
301C7-4		SCREW, 4-36 X 5/16 FILLISTER HEAD
302C10-4		SCREW, 6-32 X 5/16 FLAT HEAD
302C10-5		SCREW, 6-32 X 3/8 FLAT HEAD
302C7-2		SCREW, 4-36 X 1/4 FLAT HEAD
302C15-7		SCREW, 10-32 X 1 FLAT HEAD
304C10-1		SCREW, 10-32 X 17 EAT HEAD
308C10-1		
505C2-110		FLAT PLATE ROLLER
511C1-133		STANDARD
517C1-133		MOTOR (120 VOLT ONLY)
517C1-927		MOTOR (220 VOLT ONLY)
524C1-11		KNIFE GEAR
531C1-52		
541C1-22		SHARPENING STONE
541C1-22 542C1-99		
		ARMATURE (120 VOLT ONLY)
542C1-100		ARMATURE (220 VOLT ONLY)
580C1-48 620C1-23		SWITCH
626C1-36		SWITCH BASE & BRACKET ASSEMBLY
636C1-3 637C1-12	1	SHARPENER BRACKET
726C1-39		SHARPENER, COMPLETE
12001-38	1	SHEAR PLATE ASSEMBLY

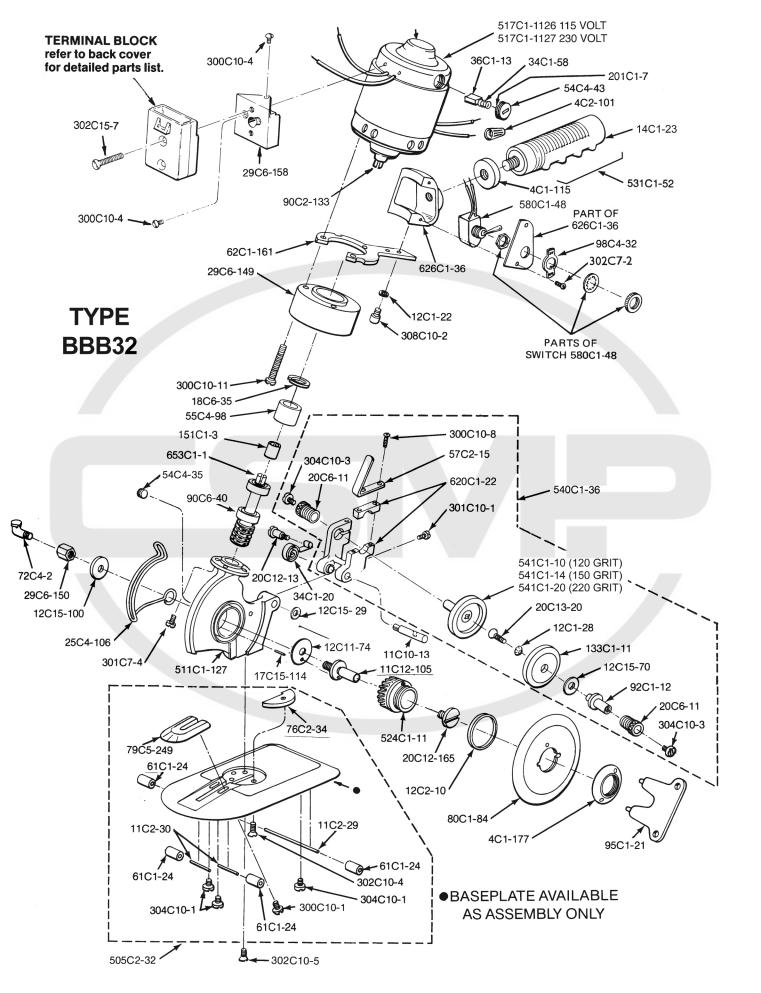


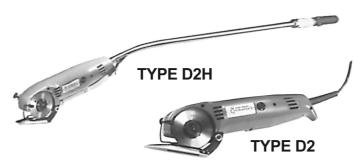
ILLUSTRATED PARTS LIST



PLEASE SPECIFY MACHINE NAME AND SERIAL NUMBER WHEN ORDERING PARTS.

PART NO.	DESCRIPTION
4C1-115	HANDLE LOCKNUT
4C1-177	KNIFE LOCKNUT
4C2-101	WIRE NUT (2 Req'd)
1102-29	REAR ROLLER SHAFT
	FRONT ROLLER SHAFT (2 Req'd)
11010-13	SHARPENER SHAFT
11012-105	
1201-22	WASHER SHAKE PROOF (2 Req'd)
1201-20	LOCK WASHER (2 Reg'd) FELT WASHER FOR STAND
1202-10	FELI WASHER FOR STAND
12011-74	SPACING WASHERFLAT WASHER
12015-29	DADED WASHED
12015-70	PAPER WASHER PAPER WASHER
1401 02	RED HANDLE GRIP
17015 114	PIN IN STANDARD
1806 35	DETAINING DING
20C6 11	RETAINING RING WHEEL ADJUSTING SCREW (2 Reg'd)
2000-11	SHARPENER SPRING SCREW
20012-13	THE STANFORM
20012-100	THRUST SCREW SCREW SHARPENER (2 Req'd)
2504-106	KNIFE GUARD
2004-100	
2006 150	OIL CUP ADAPTER
2006 150	TERMINAL BLOCK ADAPTER
2401 20	SHARPENER SPRING
2401-20	BRUSH SPRING (2 Reg'd)
3604 43	BRUSH (2 Req'd)
5001-13	CDEACE DLUC
5404-35	GREASE PLÚG
5404-43	BRUSH PLUG (2 Req'd)
5504-98	SPACER BEARING
0104-10	SHARPENER LEVERPLATE ROLLER SHELL (4 Req'd)
0004 404	PLATE ROLLER SHELL (4 Req d)
7204.0	HANDLE BRACKET
7204-2	OIL CUP
7602-34	PLATE FILLER
79C5-249	THROAT PLATE
80C1-84	KNIFE
9001-140	BEARING HOUSING REAR
9002-133	BEARING HOUSING FRONT
	BALL BEARING, WORMSHAFT
9201-21	WRENCH
9804-32	ON/OFF CLIP
13301-11	UNMOUNTED EMERY WHEEL (2 Req a)
15101-3	COUPLING MOTOR
20101-7	BRASS EYELET (2 Req'd)
300010-1	
300010-4	SCREW, 6-32 X 3/8 ROUND HEAD (4 Req d)
300010-8	
300010-11	SCREW, 6-32 X 11/16 ROUND HEAD (3 Req'd)
30107-4	SCREW, 4-36 X 5/16 FILLISTER HEAD (4 Req'd)
301010-1	SCREW, 6-32 X 1/4 FILLISTER HEAD
302010-4	SCREW, 6-32 X 5/16 FLAT HEAD (2 Req'd)
302010-5	
302015-7	
30207-2	SCREW, 4-36 X 1/4 FLAT HEAD (2 Req'd)
304C10-1	
304C10-3	
308C10-2	SCREW, 6-32 X 1/2 SOCKET HEAD (2 Req'd)
	FLAT PLATE – ROLLER
511C1-126	STANDARD
	MOTOR 115 VOLT
	MOTOR 230 VOLT
	KNIFE GEAR
531C1-52	HANDLE
540C1-36	EMERY WHEEL ARM WITH WHEELS
541C1-10	(120 GRIT) EMERY WHEEL ASSEMBLY (2 Req'd)
541C1-14	(150 GRIT) EMERY WHEEL ASSEMBLY (2 Req'd)
541C1-20	(220 GRIT) EMERY WHEEL ASSEMBLY (2 Reg'd)
542C1-99	ARMATURE 115 VOLT
	ARMATURE 230 VOLT
580C1-48	SWITCH
620C1-22	EMERY WHEEL ARM
	SWITCH BASE & BRACKET ASSEMBLY
o53U1-1	WORMSHAFT





DESCRIPTION

Your new Chickadee D2 or D2H is designed for increase performance and capacity, with a minimum of maintenance and service when not subjected to abnormal use.

CAUTION

Read instructions carefully before starting motor. Be sure that voltage and current are the same as stamped on nameplate.

TO OPERATE MACHINE

Turn machine to on position; if cutter does not perform properly check line output and be sure the unit it plugged in properly making full contact. Do not attempt to start this unit while it is in material to be cut.

WARNING

Before performing any of the following procedures, make sure that the attachment plug has been disconnected from power source.

REMOVE AND REPLACE THE KNIFE

Insert a pin thru knife against bottom of machine housing and with a large screwdriver, remove screw (300C12-3) and flange (53C11-112). DISCARD WORN SHARP KNIFE WITH CARE and install new blade with the Eastman facing outward.

To obtain a fine keen edge on the blade, press lightly on sharpener button with a constant pressure.

LUBRICATION

Follow this procedure yearly for intermittent use, or every six months for continuous use. Remove knife, remove retainer plate (79C12-276) (2 screws) with gear intact. Then remove screw (20C13-99) emery wheel (541C1-24) and wipe away any grit deposits. Apply a light coat of Eastman Lubricko Grease (242C2-2) to parts and reassemble. Then add small quantity of Eastman Lubricko Grease to gears and shaft. Saturate wick (191C1-37) with good quality SAE 30 non-detergent motor oil when changing blade.

DISASSEMBLY

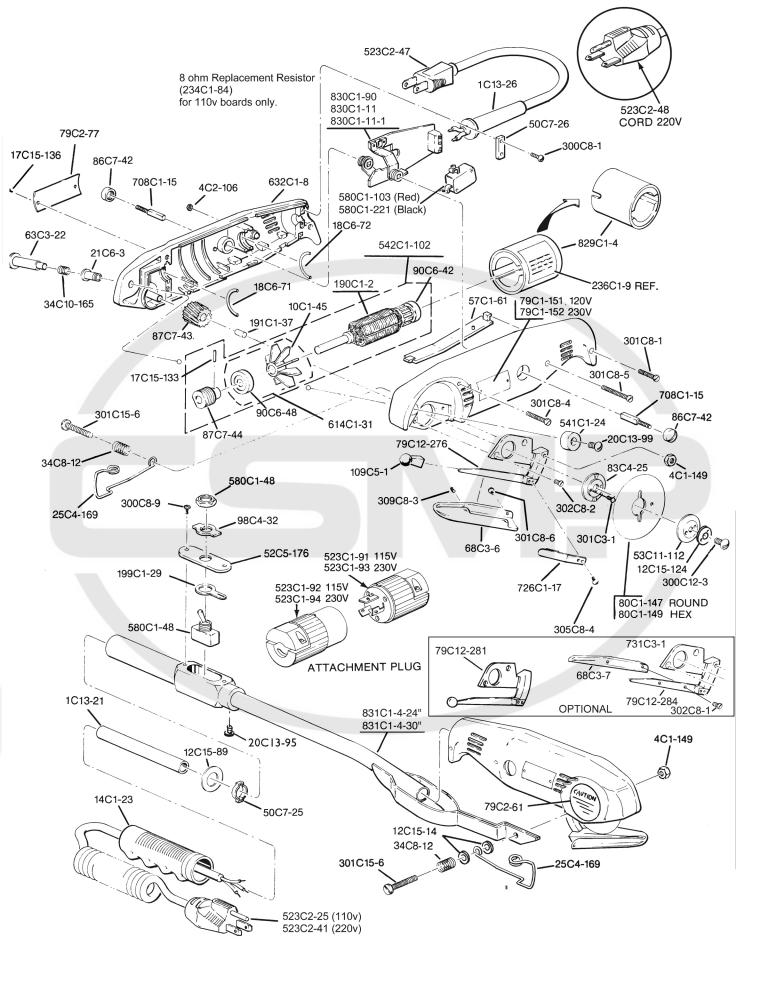
Remove knife. Remove two (2) flat head screws (302C8-2) and gear retaining plate (79C12-276) from housing.

Note: it is not necessary to loosen two fillister head screws (301C3-1) from knife flange.

Remove brush caps and brushes. Completely remove three fillister head screws (308C1-1, 308C1-4, 308C1-5) from housing and lift off left side motor housing, leaving motor parts in right side housing. Clean lint and dirt from motor housing and grease from gear cavity.

ILLUSTRATED PARTS LIST

PART NO. 10:13-21 10:13-26 10:13-26 10:13-26 10:13-26 10:149 10:149 10:149 10:145 10:149 10:145 10:15-14 10:145 10:15-14 10:145 10:15-14 10:145 10:15-14 10:145 10:15-14 10:145 10:15-124 10:15-133 10:16-133 10:16-133 10:16-133 10:16-133 10:16-133 10:16-136 10:16-136 10:16-136 10:16-139		DESCRIPTION
1C13-26 CORD SLEEVE C4C1-149 HEX NUT C4C2-106 HEX NUT C4C2-106 HEX NUT C1C15-14 WASHER, FLAT #10 L2C15-89 WASHER, ELAT #10 L2C15-89 WASHER, BLADE RETAINER L2C15-124 WASHER, BLADE RETAINER L4C1-23 HANDLE GRETAINER L4C1-23 HANDLE GRETAINER L7C15-133 ARMATURE PIN L7C15-133 ARMATURE PIN L7C15-133 ARMATURE PIN L7C15-136 PIN LABEL (4 REQUIRED) L8C6-71 FRONT 'O' RING HALF (2 REQUIRED) L8C6-72 BACK 'O' RING HALF (2 REQUIRED) L8C6-72 BACK 'O' RING HALF (2 REQUIRED) L8C6-73 SHARPENER BUSHING L9C16-3 SHARPENER BUSHING L9C16-3 SHARPENER BUSHING L9C16-3 SHARPENER SPRING L9C16-3 SHARPENER SPRING L9C16-3 SHARPENER SPRING L9C16-5 CORD CLAMP D-24 L9C16-5 CORD CLAMP D-25 L9C5-176 BASE SWITCH L9C16-1 SWITCH LEVER L9C16-1 SWITCH LPUR L9C16-1 SWITCH LEVER L9C16-1 SWITCH L9C1 L9C16-1 SWITCH LPUR L9C16-1 S	PART NO.	DESCRIPTION SLEEVE
4C1-149 HEX NUT 10C1-45 FAN 10C1-45 FAN 10C1-45 WASHER, BLADE RETAINER 14C1-23 WASHER, BLADE RETAINER 14C1-23 HANDLE GRIP 17C15-133 ARMATURE PIN 17C15-136 PIN LABEL (4 REQUIRED) 18C6-72 BACK O'RING HALF (2 REQUIRED) 20C13-99 PAN HEAD SCREW 21C6-33 SHARPENER BUSHING 25C4-169 KNIFE GUARD 25C5-176 BASE SWITCH 25C4-169 KNIFE GUARD 25C5-176 BASE SWITCH 25C5-177 NARROW PRESSURE FOOT 25C1-152 PLATE NO. 230V 25C2-161 CAUTION PLATE 25C2-177 NARROW PRESSURE FOOT 25C1-152 PLATE NO. 230V 25C2-161 CAUTION PLATE 25C2-177 NARROW PRESSURE 25C5-176 BASE SWITCH 25C2-177 ROUND KNIFE 2 1/4" 25C1-12284 GEAR RETAINING PLATE 25C1-1240 KNIFE GEAR 25C1-149 HEX KNIFE 2 1/4" 25C1-12284 GEAR RETAINING PLATE 25C1-149 HEX KNIFE 2 1/4" 25C1-12284 GEAR RETAINING PLATE 25C1-1240 KNIFE FLANGE 25C1-149 HEX KNIFE SARW 25C1-149 KNIFE HEAD 25C1-	1C13-26	CORD SI FEVE
C2-106	4C1-149	HEX NUT
1001-45 12015-14 12015-14 12015-14 12015-14 12015-189 12015-124 12015-124 12015-124 12015-124 12015-124 12015-123 12015-123 12015-123 12015-123 12015-123 12015-123 12015-123 12016-123 12016-123 12016-123 12016-125 12	4C2-106	HEX NUT
12C15-124 WASHER, BLADE RETAINER 14C1-23 HANDLE GRIP 17C15-133 PARMATURE PIN 17C15-136 PIN LABEL (4 REQUIRED) 18C8-71 FRONT O' RING HALF (2 REQUIRED) 18C8-72 BACK O' RING HALF (2 REQUIRED) 18C8-72 BACK O' RING HALF (2 REQUIRED) 12C13-99 PAN HEAD SCREW 12C16-3 SHARPENER BUSHING 12C16-3 SHARPENER SPRING 14C10-165 SHARPENER 14C10-165 SHARPENER SPRING 14C10-165 SHARPENER SPRING 14C10-165 SHARPENER SPRING 14C10-165 SHARPENER SPRING 14C10-165 SHARPENER 14C10-165 SHARPENER SPRING 14C10-165 SHARPENER SPRING 14C10-165 SHARPENER SPRING 14C10-165 SHARPENER SPRING 14C10-165 SHARPENER 14C10-165 SHARPENER 14C10-165 SHARPENER SPRING 14C10-165 SHARPE	10C1-45	FAN
12015-124 WASHER, BLADE RETAINER 12015-133 ARMATURE PIN 17015-133 ARMATURE PIN 17015-136 PIN LABEL (4 REQUIRED) 1806-72 BACK "O" RING HALF (2 REQUIRED) 1806-72 SHARPENER BUSHING 1806-84 SHARPENER BUSHING 1806-84 SPRING 180	12C15-14	WASHER, FLAT #10
1401-23	12C15-89	WASHER
17C15-133	12C15-124	WASHER, BLADE RETAINER
17C15-136	1401-23	HANDLE GRIP
BACK	17015-133	DIN LAREL (A DECLIDED)
BACK	18C6-71	FRONT "O" RING HALF (2 REQUIRED)
20C13-99 PAN HEAD SCREW 21C6-3 SHARPENER BUSHING 25C4-169 KNIFE GUARD 34C3-12 SPRING 34C10-165 SHARPENER SPRING 50C7-26 CORD CLAMP D-2H 50C7-26 CORD CLAMP D-2H 52C5-176 BASE SWITCH 53C11-112 KNIFE COVER FLANGE 57C1-61 SWITCH LEVER 63C3-2 SHARPENER BUTTON 68C3-6 PRESSURE FOOT 79C1-151 PLATE NO. 230V 79C1-152 PLATE NO. 230V 79C1-152 PLATE NO. 230V 79C2-61 CAUTON PLATE 79C2-77 RARROW PRESSURE FOOT 79C1-2276 GEAR RETAINING PLATE FOR NARROW FOOT 80C1-147 ROUND KNIFE, 2 1/4" 83C4-25 KNIFE FLANGE 86C7-42 BRUSH CAP (2 REQUIRED) 87C7-43 KNIFE GEAR 87C7-44 WORM GEAR 87C7-45 PLATE 109C5-1 TIP SHEAR 109C5-1 TIP SHEAR 109C5-1 TIP SHEAR 109C5-1 TIP SHEAR 109C5-1 TIP SH	18C6-72	BACK "O" RING HALF (2 REQUIRED)
21C6-3 SHARPENER BUSHING 25C4-169 KNIFE GUARD 34C10-165 SHARPENER SPRING 34C10-165 SHARPENER SPRING 50C7-25 CORD CLAMP D-21 50C7-26 CORD CLAMP D-21 52C5-176 BASE SWITCH 53C11-112 KNIFE COVER FLANGE 57C1-61 SHASE SWITCH 53C11-112 KNIFE COVER FLANGE 57C1-61 SHASE SWITCH 63C3-22 SHARPENER BUTTON 68C3-6 PRESSURE FOOT 79C1-151 PLATE, NO. 120V 79C1-152 PLATE, NO. 230V 79C2-61 CAUTION PLATE 79C12-276 GEAR RETAINING PLATE FOR NARROW FOOT 80C1-147 ROUND KNIFE 2 1/4" 80C1-147 ROUND KNIFE 2 1/4" 80C1-149 HEX KNIFE 2 1/4" 80C1-149 HEX KNIFE 2 1/4" 80C4-2 BRUSH CAP (2 REQUIRED) 87C7-43 KNIFE EARR 87C7-44 WORM GEAR 90C6-42 REAR BEARING 90C6-42 REAR BEARING 90C6-42 REAR BEARING 90C6-42 REAR BEARING 90C6-43 FRONT BEARING 90C6-44 REAR BEARING 90C6-45 SCREW, 4-40 X 3/8 ROUND HEAD 100C1-2 ARMATURE 120V 191C1-37 WICKING FELT 199C1-29 SCREW, 4-40 X 3/8 ROUND HEAD 100C1-2 ARMATURE 120V 191C1-37 SCREW, 4-40 X 3/8 ROUND HEAD 100C1-2 SCREW, 4-40 X 3/8 ROUND HEAD 100C1-2 SCREW, 4-40 X 3/8 ROUND HEAD 100C1-3 SCREW, 4-40 X 3/16 ROUND HEAD 100C3-3 SCREW, 4-40 X 3/16 ROUND HEAD 100C3-3 SCREW, 4-40 X 3/16 ROUND HEAD 100C3-1 SCREW, 4-40 X 3/16 FILLISTER HEAD 101C3-1 SCREW, 4-40 X 3/16 FILLISTER HEAD 101C3-1 SCREW, 4-40 X 3/16 FILLISTER HEAD 101C3-1 SCREW, 4-40 X 3/16 ROUND HEAD 101C3-1 SCREW, 4-40 X 3/16 FILLISTER HEAD 101C3-1 SCREW, 4-	20C13-99	PAN ĤEAD SCREW
25C4-169 KNIFE GUARD 34C8-12 SPRING 34C10-165 SHARPENER SPRING 50C7-26 CORD CLAMP D-2H 50C7-26 CORD CLAMP D-2H 50C7-26 CORD CLAMP D-2H 52C5-176 BASE SWITCH 53C11-112 KNIFE COVER FLANGE 57C1-61 SWITCH LEVER 63C3-21 SHARPENER BUTTON 68C3-6 PRESSURE FOOT 79C1-151 PLATE. NO. 120V 79C1-151 PLATE. NO. 120V 79C1-152 PLATE. NO. 220V 79C2-61 CAUTION PLATE 79C2-77 GARTAINING PLATE FOR NARROW FOOT 79C2-161 CAUTION PLATE 79C12-276 GEAR RETAINING PLATE FOR NARROW FOOT 80C1-147 ROUND KNIFE. 2 1/4" 80C1-149 HEX KNIFE 2 1/4" 83C4-25 KNIFE FLANGE 86C7-42 BRUSH CAP (2 REQUIRED) 87C7-44 WORM GEAR 87C7-45 REAR SHANING 90C6-48 FRONT BEARING 90C6-1 TIP SHEAR PLATE 109C5-1 TIP SHEAR PLATE 109C5-1 TIP SHEAR PLATE 109C5-1 TIP SHEAR PLATE 109C5-1 TIP SHEAR PLATE 109C1-2 ARMATURE 120V 191C1-37 WICKING FELT 109C1-2 ARMATURE 120V 191C1-37 SCREW, 4-40 X 3/8 ROUND HEAD (2 REQUIRED) 300C8-9 SCREW, 4-40 X 3/4 FILLISTER HEAD 301C3-1 SCREW, 2-56 X 1/2 FILLISTER HEAD (2 REQUIRED) 301C3-1 SCREW, 4-40 X 3/8 FILLISTER HEAD 301C3-1 SCREW, 4-40 X 3/8 FILLISTER HEAD 301C3-1 SCREW, 4-40 X 3/8 FILLISTER HEAD 301C3-2 SCREW, 4-40 X 3/8 FILLISTER HEAD 301C3-3 SCREW, 4-40 X 3/4 FILLISTER HEAD 301C3-4 SCREW, 4-40 X 3/8 FILLISTER HEAD 301C3-5 SCREW, 4-40 X 3/8 FILLISTER HEAD 301C3-6 SCREW, 4-40 X 3/8 FILLISTER HEAD 301C3-1 SCREW, 4	21C6-3	SHARPENER BUSHING
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88C3-6 PRESSURE FOOT 79C1-151 NARROW PRESSURE FOOT 79C1-151 PLATE, NO. 120V 79C1-152 PLATE, NO. 120V 79C2-61 CAUTION PLATE 79C2-77 NAME PLATE 79C12-276 GEAR RETAINING PLATE 79C12-284 GEAR RETAINING PLATE FOR NARROW FOOT 80C1-147 ROUND KNIFE, 2 1/4" 80C1-149 HEX KNIFE, 2 1/4" 80C1-140 WORM GEAR 80C6-42 BRUSH CAP (2 REQUIRED) 87C7-43 KNIFE GEAR 90C6-42 REAR BEARING 90C6-42 REAR BEARING 90C6-43 FRONT BEARING 90C6-44 WORM GEAR 90C6-44 WORM GEAR 90C6-44 WORM GEAR 90C6-42 REAR BEARING 90C6-43 FRONT BEARING 90C6-44 WORM GEAR 90C6-44 WORM GEAR 90C6-42 REAR BEARING 90C6-43 FRONT BEARING 90C6-44 WORM GEAR 90C6-42 REQUIRED 90C6-42 REQUIRED 90C6-43 WICKING FELT 199C1-29 LUG 90C1-2- ARMATURE 120V 191C1-37 WICKING FELT 190C1-2- ARMATURE 120V 191C1-37 WICKING FELT 90C1-2- ARMATURE 120V 191C1-37 WICKING FELT 90C1-2- ARMATURE 120V 191C1-37 WICKING FELT 90C1-2- ARMATURE 120V 191C1-37 WICKING FELT 190C1-2- ARMATURE 120V 191C1-37 WICKING FELT 190C1-2- ARMATURE 120V 191C1-3- SCREW, 4-40 X 3/8 ROUND HEAD 20C1-2-3 SCREW, 4-40 X 3/8 ROUND HEAD 301C3-1 SCREW, 4-40 X 3/8 ROUND HEAD 301C3-1 SCREW, 4-40 X 3/8 FILLISTER HEAD 301C3-1 SCREW, 4-40 X 1/2 FILLISTER HEAD 301C3-1 SCREW, 4-40 X	6202.22	SWITCH LEVER
S8C3-7		
79C1-151		
79C1-152 PLATE. NO. 230V 79C2-61 CAUTION PLATE 79C2-77 NAME PLATE 79C12-276 GEAR RETAINING PLATE 79C12-284 GEAR RETAINING PLATE FOR NARROW FOOT 80C1-147 ROUND KNIFE, 2 1/4" 80C1-147 ROUND KNIFE, 2 1/4" 80C1-149 HEX KNIFE, 2 1/4" 80C1-149 HEX KNIFE, 2 1/4" 80C1-149 HEX KNIFE, 2 1/4" 80C1-25 KNIFE FLANGE 86C7-42 BRUSH CAP (2 REQUIRED) 87C7-43 KNIFE GEAR 87C7-44 WORM GEAR 90C6-42 REAR BEARING 90C6-42 REAR BEARING 90C6-42 REAR BEARING 90C6-57 ALLEN KEY 98C4-32 ON/OFF PLATE 109C5-1 TIP SHEAR PLATE 109C5-1 TIP SHEAR PLATE 109C1-2 ARMATURE 120V 191C1-37 WICKING FELT 199C1-29 LUG 300C8-1 SCREW, 4-40 X 3/8 ROUND HEAD (2 REQUIRED) 300C8-9 SCREW, 4-40 X 3/16 ROUND HEAD 300C12-3 SCREW, 4-40 X 1/2 FILLISTER HEAD 301C3-1 SCREW, 2-56 X 1/2 FILLISTER HEAD (2 REQUIRED) 301C8-1 SCREW, 2-56 X 1/2 FILLISTER HEAD (2 REQUIRED) 301C8-6 SCREW, 4-40 X 3/36 FILLISTER HEAD 302C8-1 SCREW, 4-40 X 3/36 FILLISTER HEAD 301C8-6 SCREW, 4-40 X 3/36 FILLISTER HEAD 302C8-1 SCREW, 4-40 X 3/36 FILLISTER HEAD 302C8-2 SCREW, 4-40 X 3/36 FILLISTER HEAD 302C8-3 SCREW, 4-30 X 3/4 FILAT HEAD (2 REQUIRED) 302C8-2 SCREW, 4-40 X 3/36 FILLISTER HEAD 302C8-3 SCREW, 4-40 X 3/36 FILLISTER HEAD 302C8-1 SCREW, 4-40 X 3/36 FILLISTER HEAD 301C8-6 SCREW, 4-30 X 3/4 FILLISTER HEAD 302C8-1 SCREW, 4-40 X 3/36 FILLISTER 302C8-1 SCREW, 4-40 X 3/36 FILLISTER 302C8-1 SCREW,		
79C2-61	79C1-152	PLATE. NO. 230V
Type		
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80C1-149		
83C4-25 86C7-42 87C7-43 87C7-44 87C7-44 80C6-42 8EAR BEARING 90C6-48 90C6-48 FRONT BEARING 95C5-7 ALLEN KEY 98C4-32 00N/0FF PLATE 109C5-1 11P SHEAR PLATE 199C1-29 300C8-1 300C8-1 30C8-9 3CREW, 4-40 X 3/8 ROUND HEAD (2 REQUIRED) 300C8-9 3CREW, 4-40 X 3/8 ROUND HEAD 300C12-3 SCREW, 4-40 X 3/8 ROUND HEAD 301C3-1 SCREW, 2-56 X 1/2 FILLISTER HEAD (2 REQUIRED) 301C8-1 301C8-1 3CREW, 4-40 X 3/4 FILLISTER HEAD 301C8-6 SCREW, 4-40 X 3/4 FILLISTER HEAD 302C8-1 SCREW, 4-40 X 3/4 FILLISTER 302C8-1	80C1-147	ROUND KNIFE, 2 1/4"
86C7-42 BRUSH CAP (2 REQUIRED) 87C7-43 KNIFE GEAR 87C7-44 WORM GEAR 90C6-42 REAR BEARING 90C6-42 REAR BEARING 90C6-43 FRONT BEARING 90C6-44 SEAR BEARING 90C6-45 FRONT BEARING 90C6-46 FRONT BEARING 90C6-47 ALLEN KEY 98C4-32 ON/OFF PLATE 109C5-1 TIP SHEAR PLATE 109C5-1 TIP SHEAR PLATE 109C1-2 ARMATURE 120V 191C1-37 WICKING FELT 199C1-29 LUG 300C8-1 SCREW, 4-40 X 3/8 ROUND HEAD (2 REQUIRED) 300C8-9 SCREW, 4-40 X 3/16 ROUND HEAD 300C12-3 SCREW, 2-56 X 1/2 FILLISTER HEAD (2 REQUIRED) 301C8-1 SCREW, 2-56 X 1/2 FILLISTER HEAD (2 REQUIRED) 301C8-1 SCREW, 4-40 X 3/4 FILLISTER HEAD 301C8-5 SCREW, 4-40 X 3/4 FILLISTER HEAD 301C8-6 SCREW, 4-40 X 3/4 FILLISTER HEAD 301C8-6 SCREW, 4-40 X 3/4 FILLISTER HEAD 302C8-1 SCREW, 4-40 X 3/8 FLAT HEAD (2 REQUIRED) 302C8-1 SCREW, 4-40 X 3/8 FLAT HEAD (2 REQUIRED) 302C8-2 SCREW, 4-40 X 3/8 FLAT HEAD (2 REQUIRED) 305C8-4 SCREW, 4-40 X 3/8 FLAT HEAD (2 REQUIRED) 305C8-4 SCREW, 4-40 X 3/8 FLAT HEAD (2 REQUIRED) 305C8-4 SCREW, 4-40 X 3/8 FLAT HEAD (2 REQUIRED) 305C8-4 SCREW, 4-40 X 1/8 SOCKET HEAD 523C1-91 ATTACHMENT PLUG 120V FEMALE 523C1-92 ATTACHMENT PLUG 120V FEMALE 523C1-93 ATTACHMENT PLUG 230V FEMALE 523C1-94 ATTACHMENT PLUG 230V FEMALE 523C1-95 CORD 120V 523C2-41 CORD 230V 523C2-41 CORD 230V 523C2-41 CORD 230V 523C2-41 CORD 230V 523C2-44 EMERY WHEEL ASSEMBLY 542C1-102 ARMATURE ASSEMBLY 542C1-102 ARMATURE ASSEMBLY 542C1-103 RED, SWITCH, D-2 580C1-221 BLACK, SWITCH, D-2 580C1-221 BLACK, SWITCH, D-2 580C1-103 RED, SWITCH, D-2 580C1-104 BRUSH WSPRING (2 REQUIRED) 726C1-17 SHEAR PLATE W/CARBIDE 731C3-1 GEAR RETAINING NARROW FOOT ASSEMBLY 830C1-11 (110V ONLY) CIRCUIT BOARD ASSEMBLY 830C1-11 (110V ONLY) CIRCUIT BOARD ASSEMBLY 830C1-11-1 (110V ONLY) CIRCUIT BOARD ASSEMBLY		
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87C7-44	86C7-42	BRUSH CAP (2 REQUIRED)
90C6-42 REAR BEARING 90C6-48 FRONT BEARING 90C6-48 FRONT BEARING 95C5-7 ALLEN KEY 98C4-32 ON/OFF PLATE 109C5-1 TIP SHEAR PLATE 109C1-2 ARMATURE 120V 191C1-37 WICKING FELT 199C1-29 LUG 300C8-1 SCREW, 4-40 X 3/8 ROUND HEAD (2 REQUIRED) 300C8-9 SCREW, 4-40 X 3/76 ROUND HEAD 301C3-1 SCREW, 2-56 X 1/2 FILLISTER HEAD (2 REQUIRED) 301C8-1 SCREW, 4-40 X 1/2 FILLISTER HEAD 301C8-4 SCREW, 4-40 X 1/2 FILLISTER HEAD 301C8-5 SCREW, 4-40 X 3/4 FILLISTER HEAD 301C8-6 SCREW, 4-40 X 3/4 FILLISTER HEAD 301C8-6 SCREW, 4-40 X 3/4 FILLISTER HEAD 301C8-6 SCREW, 4-40 X 3/4 FILLISTER HEAD 301C8-1 SCREW, 4-40 X 3/4 FILLISTER HEAD 301C8-2 SCREW, 4-40 X 3/4 FLAT HEAD (2 REQUIRED) 302C8-2 SCREW, 4-40 X 3/4 FLAT HEAD (2 REQUIRED) 305C8-4 SCREW, 4-40 X 3/4 FLAT HEAD (2 REQUIRED) 305C8-4 SCREW, 4-40 X 1/8 SINDING HEAD (2 REQUIRED) 309C8-3 SCREW, 4-40 X 1/8 SOCKET HEAD 523C1-91 ATTACHMENT PLUG 120V MALE 523C1-92 ATTACHMENT PLUG 230V FEMALE 523C1-94 ATTACHMENT PLUG 230V FEMALE 523C1-94 ATTACHMENT PLUG 230V FEMALE 523C2-25 CORD 120V 523C2-41 CORD 230V 523C2-41 CORD 230V 523C2-41 CORD 230V 523C2-46 CORD 230V EUROPE 523C2-47 CORD ASSEMBLY 230V DOMESTIC 523C2-48 CORD ASSEMBLY 230V DOMESTIC 523C2-48 CORD ASSEMBLY 230V DOMESTIC 523C1-91 RED SWITCH, D-2 580C1-102 REQ SWITCH, D-2 580C1-103 RED, SWITCH, D-2 580C1-104 READ 580C1-105 READ 580C1-107 SHEAR PLATE W/CARBIDE 781C3-1 SEAR PLATE W/CARBIDE		
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190C1-2 191C1-37 199C1-29 300C8-1 300C8-1 300C8-2 300C8-9 30C8-9 30C8-9 30C8-1 30C8-1 30C8-9 30C8-1 30C8-9 30C8-9 30C8-9 30C8-9 30C8-9 30C8-1 30C8-1 30C8-9 30C8-0 301C3-1 30C8-0 301C3-1 30C8-0 301C3-1 301C8-1 301C8-1 301C8-1 301C8-2 301C8-3 301C8-3 301C8-4 301C8-5 301C8-6 301C8-6 301C8-6 301C8-6 301C8-6 301C8-6 301C8-6 301C8-1	109C5-1	TIP SHEAR PLATE
191C1-37	190C1-2	ARMATURE 120V
300C8-1	191C1-37	WICKING FELT
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726C1-17	632C1-8	HOUSING, COMPLETE W/SWITCH LEVER
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829C1-4		
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830C1-90 (220V ONLÝ)CIRCUIT BOARD ASSEMBLY	830C1-90	(220V ONLY)CIRCUIT BOARD ASSEMBLY
831C1-4-24 24" HANDLE & TUBE ASSEMBLY	831C1-4-24.	24" HANDLE & TUBE ASSEMBLY
831C1_4_30 30" HANDLE & TURE ASSEMBLY.	831C1-4-30 .	30" HANDLE & TUBE ASSEMBLY
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ASSEMBLY

Install circuit board in right motor housing. Place armature of correct voltage into magnet ring (829C1-1). Insert armature and magnet by passing rear end of armature between brush holders on circuit board.

Note that notch in magnet ring must mate with stud in right housing for proper fit. Rotate magnet ring until slot "clicks" into stud.

Fit switch lever into recess at bottom of right housing. Check functioning of switch by squeezing lever when in place. Place left housing over right housing with slight pressure. Replace three screws into left housing. Pack gear cavity 3/4 full of Eastman grease. Replace gear retaining plate. Squeeze one drop of oil into knife screw hole. Replace knife with Eastman facing outward. Insert brushes and brush caps.

Repairs to these machines should be made by a qualified person familiar with safe repairs of electrical devices. Exercise extreme caution when working with, or near the blade as the cutting edge is extremely sharp. Be sure to disconnect machine from power supply and remove knife before continuing with adjustments or repairs.

To sharpen knife, press lightly on sharpener button with constant pressure, while machine is running. Lubricate wick (191C1-37) with Eastman oil when replacing blade or once each month.

REPLACE MOTOR BRUSHES

Remove black brush caps (86C7-42) from sides of housing with a large bladed screwdriver. Gently pull on springs to remove brushes. If brushes are stuck, tap machine gently on padded surface to loosen brushes.

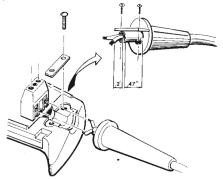
Replace brushes if worn to less than 5/32" (4.2mm) or if spring is less than 11/32" (9.0 mm). Replace brush caps and tighten gently.

ADJUSTMENT OF SHEAR PLATE

Shear plate (726C1-17) should contact knife at sharpened edge *only*. Clearance of back of shear plate is .010" (.25mm) and can be checked with feeler gage.

REPLACE CORD

Disassemble machine per instructions. Loosen two screws in terminal block and remove two screws (300C8-1) in cord clamp. Gently pull cord from terminal block. Strip outer jacket on new cord to .4" (12mm). Strip insulation on wires to .2" (5mm). Insert wire leads into terminal block and tighten two screws. Replace and secure cord clamp (50C7-26), making sure clamp bears on outer jacket of wire as shown. Reassemble per instructions.



FAN AND FRONT BEARING REMOVAL

Measure and record distance of fan and front bearing from rear bearing. Position armature assembly in collar jig, as shown. Lightly heat gear (87C7-44) at pin (17C15-133) to release adhesive.

CAUTION -

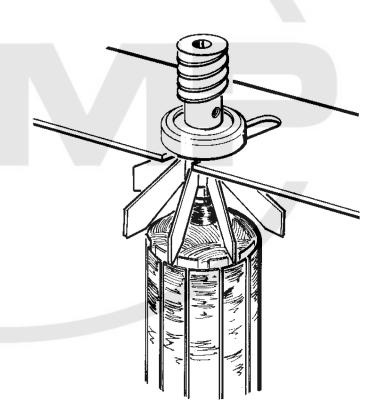
Do not heat entire armature.

Press worm from armature shaft with drift pin. Remove front bearing from armature shaft.

CAUTION –

Do not allow armature to fall from collar jig.

Remove fan by gently twisting and pulling fan from armature shaft.



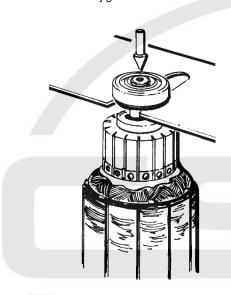
INSTALLATION OF FAN, FRONT BEARING AND WORM GEAR

Apply adhesive (Loctite 242 recommended) to inside diameter of fan, (10C1-45) bearing (90C6-48) and worm (87C7-44). Use steel tube with 1/4" I.D. to press fan, bearing and worm onto armature shaft. Make sure parts are returned to original position as recorded in FAN AND BEAR-ING REMOVAL, above.

Pin in worm must be aligned with slot in armature shaft for proper assembly.

REAR BEARING REMOVAL

Position armature in collar jig as shown. Use steel rod to press armature shaft through bore of bearing. Do not allow armature to fall from jig.



INSTALLATION OF REAR BEARING

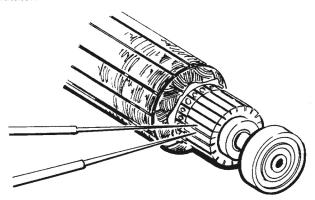
Lubricate armature shaft. Use 1/4" I.D. steel tube to press rear bearing down to shoulder on armature shaft.

Support armature at front end and protect shaft from bending during reassembly.

ELECTRICAL TESTS OF ARMATURE

Repeated blown fuses or burned resistor may indicate failed armature.

Use multimeter to check adjacent bar to bar resistance of commutator as shown. Check each bar around entire commutator.



VOLTAGE

230v 115v

RESISTANCE

20 ohms

10 ohms

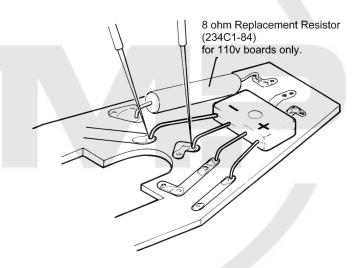
IF READINGS ARE 10% ABOVE OR BELOW STANDARDS, REPLACE ARMATURE.

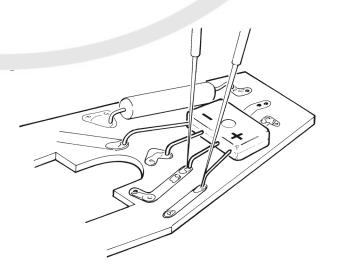
ELECTRICAL TESTS OF RECTIFIER

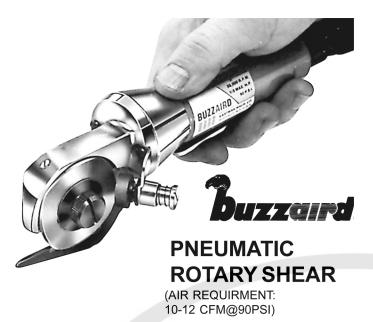
Set multimeter to 1,000 ohm scale. Measure resistance between negative and adjacent lead as shown. Reading should be 5-50 ohms. Reverse multimeter probes. Reading should be 1,000,000 (1 million) ohms minimum.

Repeat above procedure on remaining leads as shown. Readings should be identical to above.

Any readings other than above indicate failed rectifier and circuit board must be replaced.







DESCRIPTION

The Buzzaird Rotary Shear has been carefully designed by the Eastman Machine Company to efficiently cut a variety of fabrics and provide many years of trouble free service. This pneumatic cutter is equipped with a heavy duty pneumatic motor and can be used primarily for heavier types of material that cannot be cut with our now world-famous Chickadee Machine. The maximum output is 1/3 horsepower and should run at 90 psi with a 20,000 rpm motor speed. This machine should not be run with less than 60 psi.

BALL TIP AND SHEAR PLATE FOOT OPTIONAL*

A ball tip (109C5-1) for cutting loosely woven materials and shear plate foot (68C3-4) for additional support and cutting accuracy are optional. To attach shear plate foot to shear plate (726C1-5) use allen key (95C5-7) as illustrated.

WARNING

Before performing any of the following procedures, make sure the air line has been disengaged.

TO LUBRICATE

A few drops of 30 weight, non-detergent machine oil twice a day while operating are all that is required to keep the buzzaird lubricated. The parts illustration (page 13) clearly indicates the three recommended lubrication points. To lubricate gears, remove plug (point C), inject grease once a day. Eastman Gear Lubricant Special Formula (242C2) is recommended. Be sure oil felt (191C1-26) is kept clean and moist with oil.

TO REMOVE KNIFE

Remove lock nut (4C1-194) turn counter-clockwise and lift knife from the gear. When replacing knife (80C1-123) be sure the knife is installed so that the Eastman name is in the outward position.

ILLUSTRATED PARTS LIST

PART NO. 4C1-194	DESCRIPTION
4C1-194	
461-194	KNIFE LOCK NUT
4C3-12	ADJUSTING NUT
12C15-57	SPRING WASHER
12016 07	THRUST WASHER
120 15-74	ITRUST WASHER
12C15-95	WASHER FOR KNIFE GUARD
*17C9-10	LOCK PIN
	PIN
17015-127	
18C6-23	RETAINING RING
18C6-35	RETAINING RING
2003-21	CLAWF 3CREW
20C12-117	
20C13-56	SCREW, 6-32 X 3/4 SOCKET SET
20013 63	SET SCDEW
20013-03	SET SCREW SHARPENER BUSHING
2105-4	SHARPENER BUSHING
25C4-150	KNIFE GUARD
*25C/_102	PELLICAN STYLE KNIFE GUARD
2304-132	F LLICAN OT TLL KINI L GOARD
2906-142	MOTOR ADAPTER SWIVEL SHARPENER MOTOR ADAPTER
*29C6-178	SWIVEL SHARPENER MOTOR ADAPTER
3/1010-131	SHARPENER SPRING
*04040454	LOCK PIN SPRING
"34C10-154.	LOCK PIN SPRING
34C10-163	KNIFE SPRING
54C4-35	PLUG
6202 21	SHARPENER BUTTON
*0000-21	SHANFLINEIT DOTTON
^68C3-4	SHEAR FOOT
*68C3-18	SHEAR FOOT EXTENSION
80C1-123	(4-SIDED) KNIFE
8001-127	(ROUND) KNIFE
0001-127	(ROUND) KNIFE
8001-133	(OČTAGON) KNIFE
	` <u>/</u>
*95C5-7	ALLEN KEY
*95C5-7	ALLEN KEY
*95C5-7 *109C5-1	ALLEN KEY
*95C5-7 *109C5-1	ALLEN KEY BALL TIP
*95C5-7 *109C5-1	ALLEN KEY BALL TIP
*95C5-7 *109C5-1 191C1-26 200C1-11-1 300C12-6	
*95C5-7 *109C5-1 191C1-26 200C1-11-1 300C12-6	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW FIT HD #4-40 X 3/4
*95C5-7 *109C5-1 191C1-26 200C1-11-1 300C12-6	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW FIT HD #4-40 X 3/4
*95C5-7 *109C5-1 191C1-26 200C1-11-1 300C12-6 *302C8-1	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW,FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED)
*95C5-7 *109C5-1 191C1-26 200C1-11-1 300C12-6 *302C8-1 *309C8-1 517C1-842-1	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW,FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED) AIR MOTOR
*95C5-7 *109C5-1 191C1-26 200C1-11-1 300C12-6 *302C8-1 *309C8-1 517C1-842-1 524C1-10	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW,FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED) AIR MOTOR (BRASS) KNIFE GEAR
*95C5-7 *109C5-1 191C1-26 200C1-11-1 300C12-6 *302C8-1 *309C8-1 517C1-842-1 524C1-10	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW,FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED) AIR MOTOR (BRASS) KNIFE GEAR
*95C5-7 *109C5-1 191C1-26 200C1-11-1 300C12-6 *302C8-1 *309C8-1 517C1-842-1 524C1-10	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW,FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED) AIR MOTOR (BRASS) KNIFE GEAR
*95C5-7 *109C5-1 191C1-26 200C1-11-1 300C12-6 *302C8-1 *309C8-1 517C1-842-1 524C1-10 524C1-21	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW,FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED) AIR MOTOR (BRASS) KNIFE GEAR KNIFE GEAR SHARPENING STONE
*95C5-7. *109C5-1 191C1-26 200C1-11-1. 300C12-6 *302C8-1 *309C8-1 517C1-842-1 524C1-10 524C1-21 524C1-21 536C1-3.	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW, FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED) AIR MOTOR (BRASS) KNIFE GEAR KNIFE GEAR SHARPENING STONE SHARPENER BRACKET
*95C5-7 **109C5-1 **109C5-1 **191C1-26 ***200C1-11-1 **309C8-1 **309C8-1 **517C1-842-1 **524C1-21 **524C1-21 **5636C1-3 **636C1-17	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW,FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED) AIR MOTOR (BRASS) KNIFE GEAR KNIFE GEAR SHARPENING STONE SHARPENER BRACKET SWIVEL SHARPENER BRACKET
*95C5-7 **109C5-1 **109C5-1 **191C1-26 ***200C1-11-1 **309C8-1 **309C8-1 **517C1-842-1 **524C1-21 **524C1-21 **5636C1-3 **636C1-17	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW,FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED) AIR MOTOR (BRASS) KNIFE GEAR KNIFE GEAR SHARPENING STONE SHARPENER BRACKET SWIVEL SHARPENER BRACKET
*95C5-7 **109C5-1 **109C5-1 **191C1-26 ***200C1-11-1 **309C8-1 **309C8-1 **517C1-842-1 **524C1-21 **524C1-21 **5636C1-3 **636C1-17	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW,FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED) AIR MOTOR (BRASS) KNIFE GEAR KNIFE GEAR SHARPENING STONE SHARPENER BRACKET SWIVEL SHARPENER BRACKET
*95C5-7 *109C5-1 191C1-26 200C1-11-1. 300C12-6 *302C8-1 *309C8-1 517C1-842-1 524C1-10. 524C1-21 541C1-22 636C1-3. *636C1-17 637C1-12	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW,FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED) AIR MOTOR (BRASS) KNIFE GEAR KNIFE GEAR KNIFE GEAR SHARPENING STONE SHARPENER BRACKET SWIVEL SHARPENER, COMPLETE SWIVEL SHARPENER, COMPLETE
*95C5-7 *109C5-1 191C1-26 200C1-11-1 300C12-6 *302C8-1 *309C8-1 517C1-842-1 524C1-10 524C1-21 541C1-22 636C1-3 *636C1-17 637C1-12 637C1-37	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW,FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED) AIR MOTOR AIR MOTOR (BRASS) KNIFE GEAR KNIFE GEAR KNIFE GEAR SHARPENING STONE SHARPENER BRACKET SWIVEL SHARPENER BRACKET SWIVEL SHARPENER, COMPLETE SWIVEL SHARPENER, COMPLETE STANDARD HOUSING
*95C5-7 *109C5-1 *191C1-26 *200C1-11-1 *300C12-6 *302C8-1 *309C8-1 *517C1-842-1 524C1-10 *524C1-21 *541C1-22 *636C1-3 *636C1-17 *637C1-12 *637C1-37 *647C1-16	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW, FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED) AIR MOTOR AIR MOTOR (BRASS) KNIFE GEAR KNIFE GEAR KNIFE GEAR SHARPENING STONE SHARPENER BRACKET SWIVEL SHARPENER BRACKET SHARPENER, COMPLETE SWIVEL SHARPENER, COMPLETE STANDARD HOUSING WORM, COMPLETE
*95C5-7 *109C5-1 *191C1-26 *200C1-11-1 *300C12-6 *302C8-1 *309C8-1 *517C1-842-1 524C1-10 *524C1-21 *541C1-22 *636C1-3 *636C1-17 *637C1-12 *637C1-37 *647C1-16	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW, FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED) AIR MOTOR AIR MOTOR (BRASS) KNIFE GEAR KNIFE GEAR KNIFE GEAR SHARPENING STONE SHARPENER BRACKET SWIVEL SHARPENER BRACKET SHARPENER, COMPLETE SWIVEL SHARPENER, COMPLETE STANDARD HOUSING WORM, COMPLETE
*95C5-7 *109C5-1 *191C1-26 *200C1-11-1 *300C12-6 *302C8-1 *309C8-1 *309C8-1 *517C1-842-1 524C1-21 *541C1-22 *636C1-3 *636C1-17 *637C1-12 *637C1-37 647C1-1 *720C1-42	ALLEN KEY BALL TIP OIL FELT OIL FELT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW,FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED) AIR MOTOR (BRASS) KNIFE GEAR KNIFE GEAR KNIFE GEAR SHARPENING STONE SHARPENER BRACKET SWIVEL SHARPENER BRACKET SHARPENER, COMPLETE SWIVEL SHARPENER, COMPLETE STANDARD HOUSING WORM, COMPLETE KNIFE ROD, COMPLETE
*95C5-7 *109C5-1 *191C1-26 *200C1-11-1 *300C12-6 *302C8-1 *309C8-1 *309C8-1 *517C1-842-1 524C1-21 *541C1-22 *636C1-3 *636C1-17 *637C1-12 *637C1-37 647C1-1 *720C1-42	ALLEN KEY BALL TIP OIL FELT OIL FELT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW,FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED) AIR MOTOR (BRASS) KNIFE GEAR KNIFE GEAR KNIFE GEAR SHARPENING STONE SHARPENER BRACKET SWIVEL SHARPENER BRACKET SHARPENER, COMPLETE SWIVEL SHARPENER, COMPLETE STANDARD HOUSING WORM, COMPLETE KNIFE ROD, COMPLETE
*95C5-7 *109C5-1 *191C1-26 *200C1-11-1 300C12-6 *302C8-1 *309C8-1 *309C8-1 524C1-21 524C1-21 524C1-21 536C1-3 *636C1-17 637C1-12 *637C1-37 647C1-1 653C1-1 720C1-42 *726C1-34 *726C1-37	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW,FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED) AIR MOTOR (BRASS) KNIFE GEAR KNIFE GEAR KNIFE GEAR SHARPENING STONE SHARPENER BRACKET SHARPENER BRACKET SHARPENER, COMPLETE SWIVEL SHARPENER, COMPLETE STANDARD HOUSING WORM, COMPLETE KNIFE ROD, COMPLETE SHEAR PLATE
*95C5-7 *109C5-1 *191C1-26 *200C1-11-1 300C12-6 *302C8-1 *309C8-1 *309C8-1 524C1-21 524C1-21 524C1-21 536C1-3 *636C1-17 637C1-12 *637C1-37 647C1-1 653C1-1 720C1-42 *726C1-34 *726C1-37	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW,FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED) AIR MOTOR (BRASS) KNIFE GEAR KNIFE GEAR KNIFE GEAR SHARPENING STONE SHARPENER BRACKET SHARPENER BRACKET SHARPENER, COMPLETE SWIVEL SHARPENER, COMPLETE STANDARD HOUSING WORM, COMPLETE KNIFE ROD, COMPLETE SHEAR PLATE
*95C5-7 *109C5-1 *109C5-1 *109C5-1 *200C1-11-1 *300C12-6 *302C8-1 *309C8-1 *517C1-842-1 *524C1-10 *524C1-21 *541C1-22 *636C1-3 *636C1-17 *637C1-12 *637C1-12 *637C1-17 *637C1-14 *637C1-37 *647C1-1 *653C1-1 *720C1-42 *726C1-34 *726C1-37 *726C1-38	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW, FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED) AIR MOTOR AIR MOTOR (BRASS) KNIFE GEAR KNIFE GEAR KNIFE GEAR SHARPENING STONE SHARPENER BRACKET SHARPENER, COMPLETE SWIVEL SHARPENER, COMPLETE SWIVEL SHARPENER, COMPLETE STANDARD HOUSING WORM, COMPLETE KNIFE ROD, COMPLETE KNIFE ROD, COMPLETE SHEAR PLATE PELLICAN STYLE SHEAR PLATE
*95C5-7 *109C5-1 *191C1-26 *200C1-11-1 *300C12-6 *302C8-1 *309C8-1 *517C1-842-1 524C1-10 *524C1-21 *541C1-22 *636C1-3 *636C1-17 *637C1-12 *637C1-37 647C1-1 *653C1-1 *726C1-34 *726C1-37 *726C1-38 *726C1-37 *726C1-41	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW, FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED) AIR MOTOR (BRASS) KNIFE GEAR KNIFE GEAR KNIFE GEAR SHARPENING STONE SHARPENER BRACKET SHARPENER, COMPLETE SWIVEL SHARPENER, COMPLETE SWIVEL SHARPENER, COMPLETE SWIVEL SHARPENER, COMPLETE STANDARD HOUSING WORM, COMPLETE KNIFE ROD, COMPLETE SHEAR PLATE PELLICAN STYLE SHEAR PLATE DULL POINT SHEAR PLATE
*95C5-7 *109C5-1 *191C1-26 *200C1-11-1 300C12-6 *302C8-1 *309C8-1 *309C8-1 524C1-21 524C1-21 524C1-21 *636C1-3 *636C1-17 *637C1-12 *637C1-37 647C1-1 653C1-1 *726C1-34 *726C1-34 *726C1-34 *726C1-41 *817C1-1	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW,FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED) AIR MOTOR (BRASS) KNIFE GEAR KNIFE GEAR KNIFE GEAR SHARPENING STONE SHARPENER BRACKET SHARPENER BRACKET SHARPENER, COMPLETE SWIVEL SHARPENER, COMPLETE STANDARD HOUSING WORM, COMPLETE KNIFE ROD, COMPLETE KNIFE ROD, COMPLETE SHEAR PLATE PELLICAN STYLE SHEAR PLATE 30 DEGREE SHEAR PLATE DULL POINT SHEAR PLATE FXHAUST OVER HOSE
*95C5-7 *109C5-1 *191C1-26 *200C1-11-1 300C12-6 *302C8-1 *309C8-1 *309C8-1 524C1-21 524C1-21 524C1-21 *636C1-3 *636C1-17 *637C1-12 *637C1-37 647C1-1 653C1-1 *726C1-34 *726C1-34 *726C1-34 *726C1-41 *817C1-1	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW,FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED) AIR MOTOR (BRASS) KNIFE GEAR KNIFE GEAR KNIFE GEAR SHARPENING STONE SHARPENER BRACKET SHARPENER BRACKET SHARPENER, COMPLETE SWIVEL SHARPENER, COMPLETE STANDARD HOUSING WORM, COMPLETE KNIFE ROD, COMPLETE KNIFE ROD, COMPLETE SHEAR PLATE PELLICAN STYLE SHEAR PLATE 30 DEGREE SHEAR PLATE DULL POINT SHEAR PLATE FXHAUST OVER HOSE
*95C5-7. *109C5-1	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW, FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED) AIR MOTOR AIR MOTOR (BRASS) KNIFE GEAR KNIFE GEAR KNIFE GEAR SHARPENING STONE SHARPENER BRACKET SHARPENER BRACKET SHARPENER, COMPLETE SWIVEL SHARPENER, COMPLETE SWIVEL SHARPENER, COMPLETE STANDARD HOUSING WORM, COMPLETE KNIFE ROD, COMPLETE KNIFE ROD, COMPLETE SHEAR PLATE SHEAR PLATE JOULL POINT SHEAR PLATE EXHAUST OVER HOSE SWIVEL SHARPENER UPGRADE KIT
*95C5-7. *109C5-1	ALLEN KEY BALL TIP OIL FELT DRIVER FOR MOTOR SHAFT SCREW, 8-32 X 1/2 ROUND HEAD (2 REQUIRED) SCREW, FLT. HD. #4-40 X 3/4 SCREW, 4-40 X 1/4 (2 REQUIRED) AIR MOTOR (BRASS) KNIFE GEAR KNIFE GEAR KNIFE GEAR SHARPENING STONE SHARPENER BRACKET SHARPENER, COMPLETE SWIVEL SHARPENER, COMPLETE SWIVEL SHARPENER, COMPLETE SWIVEL SHARPENER, COMPLETE STANDARD HOUSING WORM, COMPLETE KNIFE ROD, COMPLETE SHEAR PLATE PELLICAN STYLE SHEAR PLATE DULL POINT SHEAR PLATE

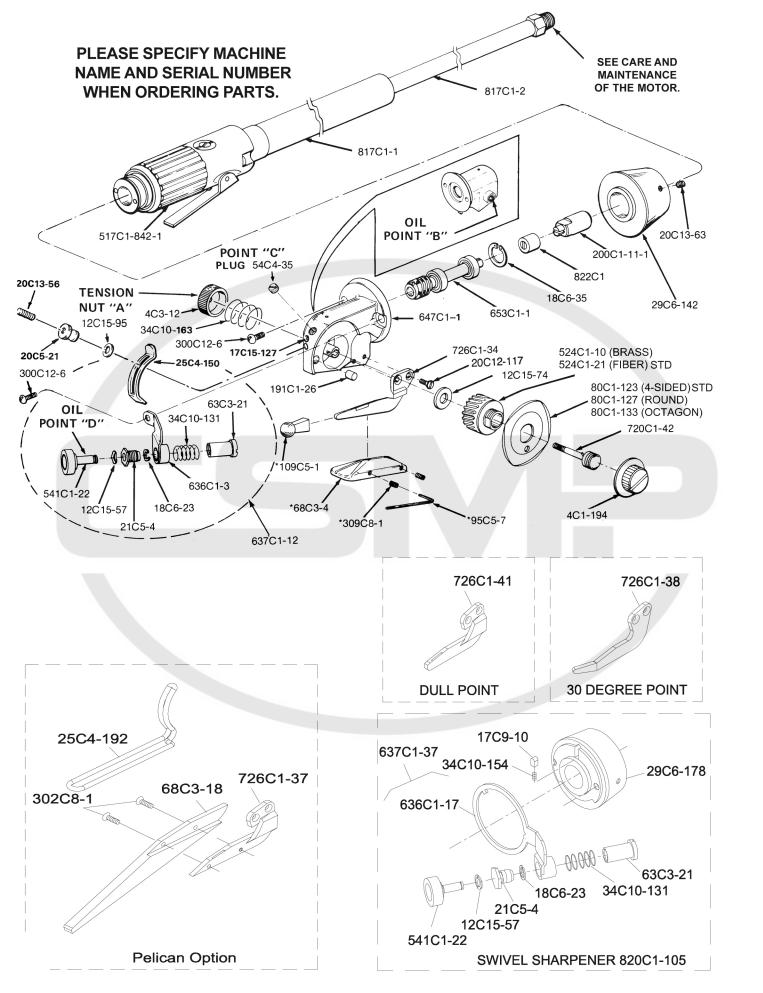
^{*}These parts furnished on special order.

TO REPLACE SHARPENING STONE

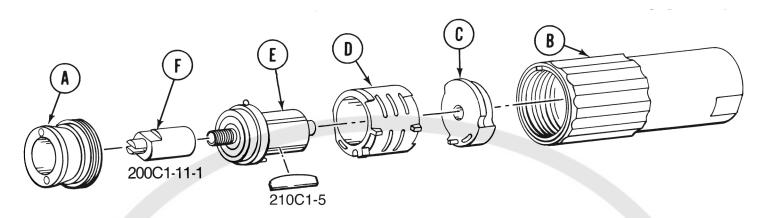
Sharpening stone may be replace as required without disassembling cutting head. Remove knife lock nut (4C1-194) and knife (80C1-123). Remove sharpener button (63C3-21) and sharpener spring (34C10-131) from rear of sharpener assembly. Sharpening stone and bushing assembly can then be removed from front of sharpener bracket (636C1-3). Remove retaining ring (18C6-23) from shaft of sharpening stone (541C1-22) and remove stone. Note: This procedure is reversed when reassembling.

CARE AND MAINTENANCE OF THE MOTOR

An air line oiler and filter should be used for the best performance of this pneumatic motor. The motor must be lubricated and free of moisture. If an air line oiler and filter is not available, a few drops of SAE 5 spindle oil should be used several times a day in the air input line.



INSTRUCTIONS FOR REPLACING DRIVER 200C1-11-1



- 1. Remove retaining nut "A" from housing "B", while holding housing in a soft jawed vise by the flats. Insert spanner wrench and turn counter clockwise to remove nut.
- 2. Slide driver assembly "C", "D", "E" and "F" out of housing.
- BEFORE PROCEEDING FURTHER Not the orientation of the pins in the bearing housings "C" and "E", with respect to the pockets in the sleeves "D". THESE PARTS MUST BE AS-SEMBLED IN EXACTLY THE SAME WAY.
- 4. Rear bearing housing "C" is pressed on stub shaft of "E". To remove, clamp bearing housing in soft jawed vise. NEVER CLAMP SLEEVE DIAMETER "D" AS THIS MIGHT CAUSE THE SLEEVE TO CRACK. With a drift pin slightly smaller than the shaft diameter, lightly tap shaft out of the bearing housing.
- 5. The sleeve "D" will now slide off assembly "E" and "F".
- 6. Remove the driver "F" by clamping rotor at the vane diameter "E" in a soft jawed vise and turn counter clockwise with a wrench on the flats of driver "F".
- 7. Re-assemble in reverse of the above procedure. After completing assembly, check for free rotation of driver "F". Remedy any binding or chatter caused by the rear bearing housing being too tight by inserting a drift pin and tap end of stub shaft on "E" lightly to loosen assembly.

Safety Information

Throughout this manual, safety information is presented by use of the terms *Warning, Caution*, and *Note*. These terms have the following meanings:

WARNING

A warning contains critical information regarding potential safety hazards that can occur during proper use or misuse of the machine. Failure to follow these procedures may result in serious personal injury to the user.

CAUTION

A caution contains instructions for the use or maintenance of the machine. Failure to follow these procedures may result in damage to the machine.

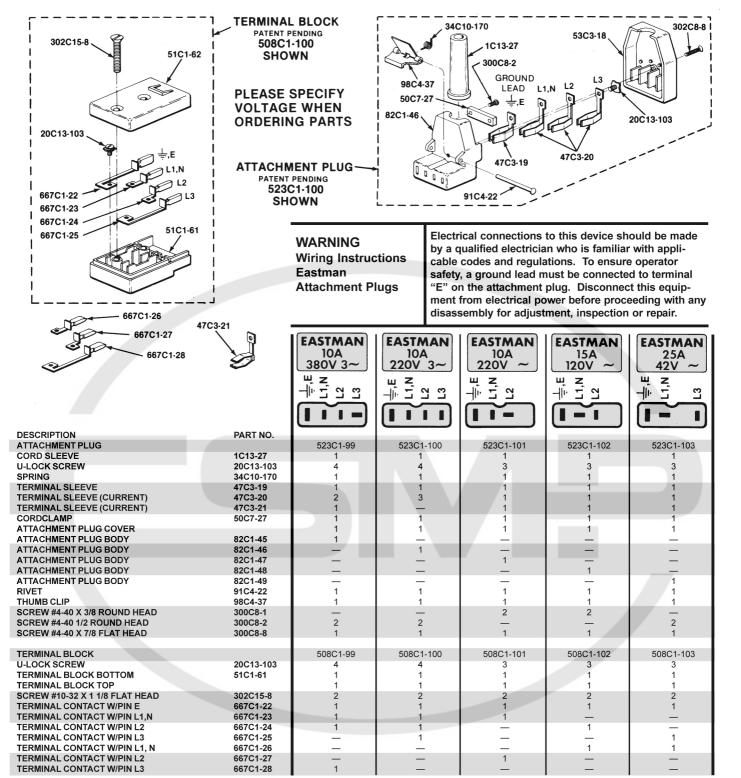
SAFETY AND INDEMNIFICATION

During the life of the machine, the purchaser agrees to provide to all machine users (including its own employees and independent contractors) all relevant safety information, including warning labels and instruction manuals. The purchaser also agrees to maintain the safety features and working condition of the machine, and to adequately train all users in the safe use and maintenance of the machine. The purchaser agrees to defend, protect, indemnify, and hold Eastman Machine Company harmless from and against all claims, losses, expenses, damages, and liabilities to the extent that they have been caused by the purchaser's failure to comply with the terms and instructions of this manual.

GENERAL SAFETY PRECAUTIONS

WARNING

- This machine is equipped with a very sharp and dangerous knife. Keep hands, arms, and hair away from the knife area at all times. When the machine is not in use, keep the knife guard lowered at all times. Safety glasses and appropriate clothing may prevent serious personal injuries.
- Disconnect the power and air supply from the machine when it is not in use or during routine maintenance, including lubrication.
- The purchaser must instruct all operators in the proper use
 of the machine according to the instructions on the machine
 and in this manual. This training must include instruction on
 the potential safety hazards arising from the use or misuse
 of the machine. In addition to such training, the purchaser
 should provide written work instructions as necessary to
 ensure correct use of the machine for specific cutting applications.
- The purchaser must provide appropriate safety measures and equipment as recommended in this manual. Observe all statutory requirements concerning the use of hazardous machinery that apply to your location.
- Do not modify this machine or disable safety features. Unauthorized modification may result in serious personal injuries to the user. Electrical connections to this machine must be made by a qualified electrician familiar with applicable codes and regulations. To prevent electrocution, a ground lead must be connected to terminal "E" on the attachment plug.
- This machine may be equipped with a remote start interface.
 Misuse of this machine or use of this machine as part of another machine may result in serious personal injuries to the user.
- Safety labels must be kept clean and legible at all times. Call the Eastman Machine factory to order replacement labels.



Limited Warranty. Eastman warrants to the buyer that the equipment shall be free from defects in materials or workmanship for a period of 180 days commencing on the date of invoice. Any goods or parts claimed by the buyer to be defective must be returned to Eastman, freight charges prepaid, within the 180 day warranty period. If Eastman determines that the goods or parts are defective in materials or workmanship, Eastman's sole obligation under this warranty shall be, at Eastman's sole option, to repair or replace the defective goods or parts or to provide the buyer a credit equal to the portion of the purchase price allocable to the defective goods or parts. This warranty shall not apply if defects are caused by product misuse or neglect, if the machine has been altered or modified by the buyer, or if other than genuine Eastman belts, emery wheels, knives or parts are used in the machine. THIS WARRANTY IS THE ONLY WARRANTY APPLICABLE TO THIS PURCHASE. SELLER DISCLAIMS ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

Limitation of Liability. Eastman's liability to the buyer, and the buyer's remedies from Eastman, whether in contract, negligence, tort, under any warranty or otherwise, shall be limited to the remedies provided in the foregoing Limited Warranty. In no event shall Eastman have any responsibility or liability to the buyer for (a) any special, indirect, incidental, or consequential damages, including, but not limited to, loss of use, revenue, or profit, even if Eastman has been advised of the possibility of such damages, or (b) any claim against the buyer by any third party. The price stated for the product sold is a consideration for limiting Eastman's liability.