

THE EASTMAN®
Falcon IV End Cutter
With Lifting Mechanism

Please read completely before attempting to operate your **Falcon IV End Cutter**.



WARNING

This machine is equipped with a very sharp knife. Keep hands, arms, and hair away from the knife area at all times.

Misuse of this machine or failure to follow all safety instructions on this machine and in the instruction manual may result in serious personal injuries.

Instruction Manual and Parts List

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779 Washington St., Buffalo, N.Y. 14203-1396 U.S.A. • (716)856-2200 • Fax (716)856-1140 or (716)856-2068
Manufacturers of Eastman Cloth Cutting and Cloth Spreading Machines

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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.

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.

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Installation

Before operating machine, read these instructions carefully. Familiarize yourself with all functions and adjustments of this equipment.

The **Falcon IV** is shipped partially disassembled with all the necessary parts for proper setup and operation. To get the best performance, familiarize yourself with all the functions and adjustments of this equipment. Before any operation can take place, it is important that you carefully read and follow the instructions in this manual in the same sequence in which they are presented.

Falcon IV System Installation

The Falcon IV weighs approx. 130 lbs, (59 Kg.) uncrated for a 72" machine. Open shipping crate and inspect all parts as shown.

The parts included are:

- (1) Part and Instruction Manual.
- (1) Falcon Cutter.
- (1) Track Assembly.
- (1) Rear Lifter Assembly (Optional)
- (1) Front Lifter Assembly (Optional)
- (1) Attachment Plug.
- (*)Optional Accessories.

Warning

This machine is equipped with a sharp knife. Keep hands away from knife area at all times. Use handle and control lever when operating or handling the machine. Knife guard should be raised only enough to clear the material being cut. When not in use, knife guard should be set at the lowest position..

DO NOT OPERATE THIS MACHINE WITH KNIFE GUARD REMOVED.

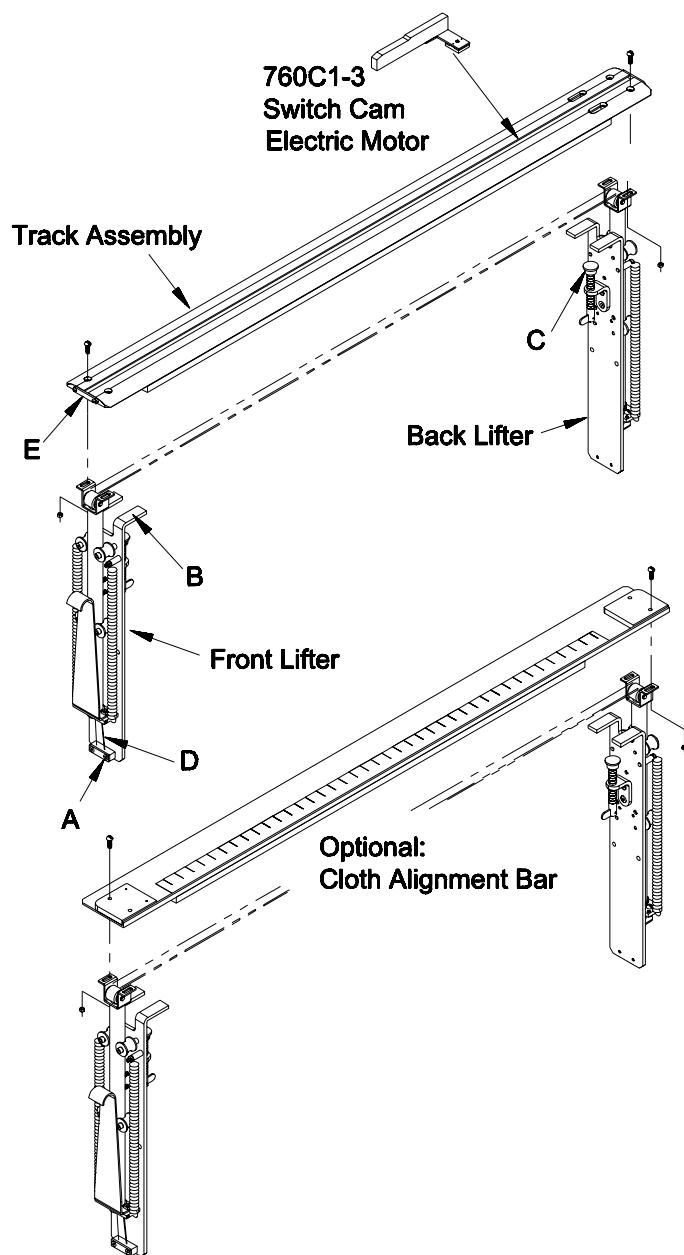
Caution

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

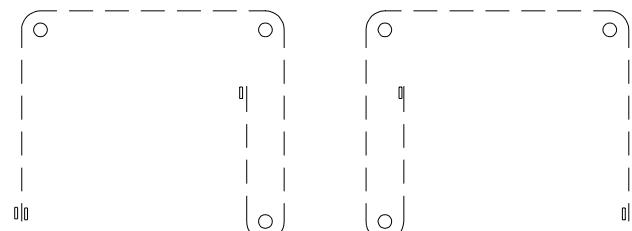
End Cutter, Track & Lifter Installation

Remove your Falcon End Cutter from the shipping package. Locate and loosen the lift belt clamping screws (A). Mount the front lift assembly (B) and back lift assembly (C) to the cutting table. Pull the lift belt (D) tight and secure the clamping screws (A). Place the track in place and secure to the lifting mechanism. The track should be mounted squarely to the table.

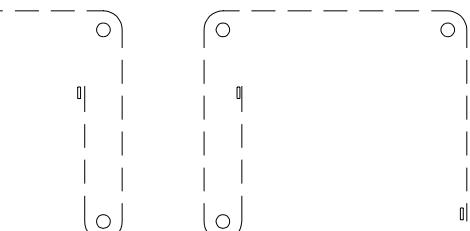
Loosen the track latch screws (E) and swing latch up. Slide the switch cam in the track as shown. Slide the Falcon End Cutter in the track. Swing down the latch and secure in place. Connect electric power line. The Falcon End Cutter is ready for operation.



Operator Side Manual Lift



Operator Side Air Lift



Belt Threading Diagram

Operation

Load the roll of material on a roll rack. Pull the material over the falcon track and to the desired length. Pull the Falcon Cutter across to cut the material and return to the home position. Lift the track using the lift handle. The cut end of the material will lay under the track. The track will hold the material in position. The next ply can now be spread.

Familiarization

Falcon IV System

- Rear Lift Assembly:** Lifts the non-operator side of the track assembly. The lift Belt is adjusted on this side.
- Track Assembly:** Used to guide the cutting head across the table to provide a straight cut through the material.
- Falcon Cutting Head:** Cuts material when moving across the track. The quick change feature reduces down time during maintenance. Optional cutting head styles available (consult factory).
- Electrical Terminal Block:** Electrical connection is made here. Check for proper voltage before connecting the attachment plug.
- Front Lift Assembly:** Lifts the operator side of the track assembly. Lift handle to raise track.
- Filter Regulator:** Air supply connection is made here. Adjust Pressure as required. Auto drain feature removes moisture from incoming air supply. (Air Lifter Only)

Maintenance



CAUTION

Before performing any of the following procedures, make sure that the attachment plug is disconnected from this system.

Knife Motor



WARNING

This machine is equipped with a sharp knife. Keep hands away from knife area at all times. DO NOT handle cutting machine at any time unless terminal block is disconnected from power supply. Knife guard should be raised only enough to clear the material being cut. When machine is not in use, knife guard should be set at its lowest position. DO NOT OPERATE THIS MACHINE WITH SAFETY GUARDS REMOVED.

Air Regulator (System Lift Pressure)

To adjust pressure, pull the "Adjust" knob up and turn

clockwise to increase pressure and counterclockwise to decrease pressure. After adjustment is made, push knob down to lock in place.

Knife Sharpening

Turn Power switch to ON (use CAUTION when sharpening blade). The Falcon Cutter remains in its home position and the blade turns. To obtain a fine, keen edge on the blade, Simultaneously press and hold sharpen button while pressing lightly against sharpener button which is located on the side of the Falcon Cutter. Press and hold button with constant pressure for 10 seconds, then release.



WARNING
Before performing any of the following procedures, make sure that the attachment plug is disconnected from the system.

Knife Replacement

Lay machine on its side, knife slide up. Place a small drift or screwdriver through the hole to keep from rotating, and remove knife bolt. Remove knife guard and lift out the knife.



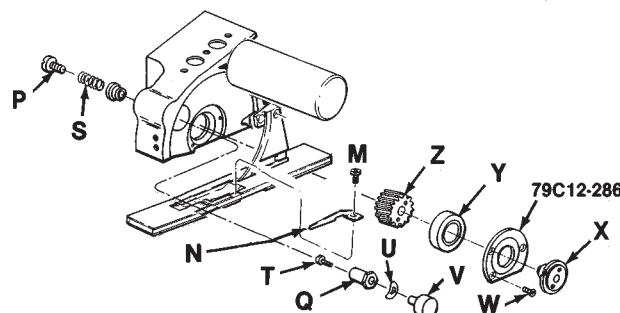
Warning:
This knife is sharp. Use proper precautions against cutting hands while handling. Discard used knife with care!

Insert new knife blade, bevel side in, by sliding it under shear plate "N". Make sure slots in knife align with tabs on knife hub and that knife is seated flush on hub. Replace all parts in reverse order and check that all fasteners are tightened securely before resuming operation.

NOTE: It is not necessary to remove cutting machine from track or shear plate from machine when replacing knife.

Shear Plate Replacement

Remove knife blade (see knife replacement). Remove screws "M" and shear plate "N". Replace with new shear plate and reassemble in reverse order. Adjust shear plate and check tightness of "M" before resuming operation.

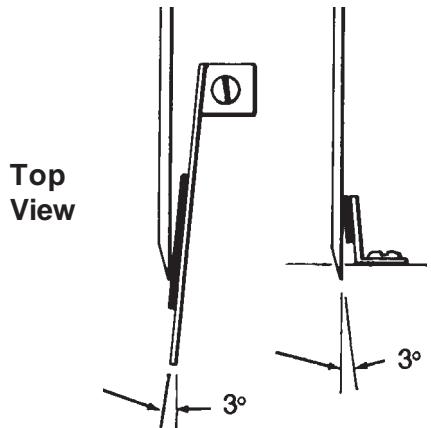


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Shear Plate Adjustment

After replacing shear plate, adjust angle of spring so carbide contacts knife edge at a 3 degree angle. Refer to diagrams for explanation of proper angle.



Sharpener Replacement

To replace sharpener stone, first remove knife blade (see knife replacement). Insert screwdriver into slotted head of sharpener button "P" and hold hex bushing "Q" in place. Turn counter clockwise and remove sharpener button and spring "S". Set these parts aside for later reassembly. Remove screw "T" to separate hex bushing, spring washer "U" and emery wheel "V". Replace emery wheel and reassemble in reverse order. Check that screw "P" is tightened securely.

Motor Brush Replacement

Remove (4) four screws, cover plate and cover insulation, being careful not to damage insulation material. Loosen and disengage (2) two screws holding down micro switch and lift out switch being careful to retain the two switch spacers. Remove (2) two screws and carefully lift out the combined assembly of the motor brush card circuit board. Movement of the parts will be restricted by wires but have adequate length to work without disconnecting. Loosen (2) two brush screws and remove the motor brush pigtails from under the fasteners. Turn brush card over and slide brushes out of guides.

When inserting new brushes, bevel corner at wire pigtails must face slot in brush holder. Pigtails run through slot to screw fastener. Wrap pigtails around screw fasteners and tighten. Turn assembly back to its original position. With your fingers, separate brushes enough to fit around commutator bars and begin working the assembly inside cavity insulation. Continue working assembly down until it is flat to inside of standard and brushes snap into position around commutator. Replace (2) two screws holding down circuit board and motor brush card. Replace switch spacers and switch and secure with (2) two screws. Replace cover insulation and cover and fasten with (4) four screws.

Micro Switch Replacement

Remove cover plate and cover insulation. Remove (2) two switch screws and lift out microswitch being careful not to lose switch spacers. Remove leads and re-solder the leads of the new switch. Replace parts in reverse order.

CAUTION

Excessive soldering heat will damage switch.

Fuse Replacement

With cover plate and cover insulation removed, fuse is visible. Lift burned out fuse out of fuse holder and replace with identical fuse. Replace cover plate and insulation.

CAUTION

Replace only with identically rated fuse. Use of different fuse may cause electrical hazard or damage electronic parts.

Lubrication of Knife Gear

Knife gear "Z" should be removed and replaced if necessary or repacked with grease every three months.

Remove knife as described above, to expose bearing retainer plate 79C12-286. Insert a #10-32 x 1 1/2" screw into center of knife flange "X" so that gear, bearing and knife flange can be removed as one unit. Remove three (3) screws "W" and lift out gear assembly. Inspect and replace gear "Z" if necessary or repack gear teeth ONLY with grease. Reassemble in reverse order making sure that bearing "Y" is seated squarely before securing knife flange "X" and retainer plate.

IMPORTANT: Use of too much grease when repacking knife gear "Z" may result in undue strain on knife motor.

Service

Daily:

- Clean work area.
- Clean track assembly.
- Clean and lubricate guide tubes with light machine oil.
- Check blade and sharpening stone for wear.

Weekly:

- Check for any unusual wear and determine why.
- Check entire machine for loose nuts and bolts.

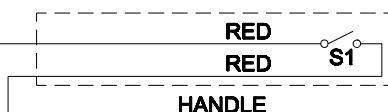
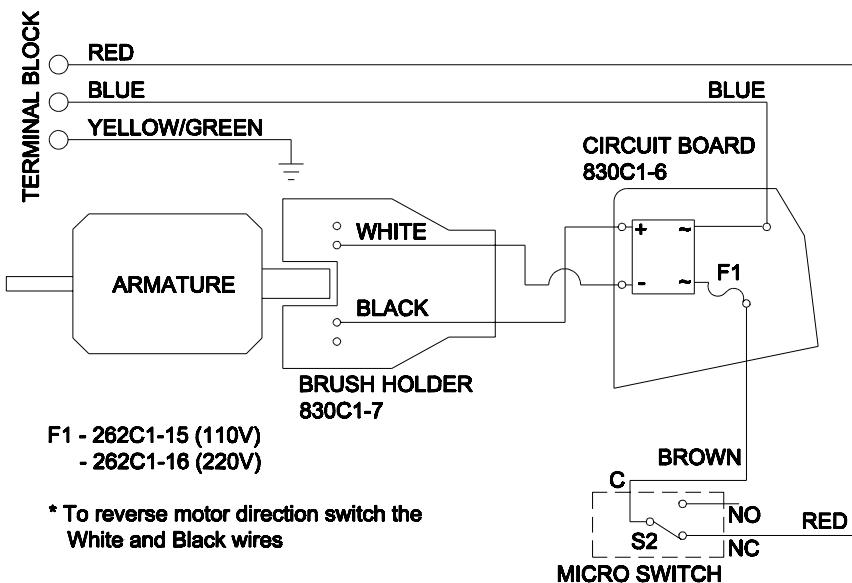
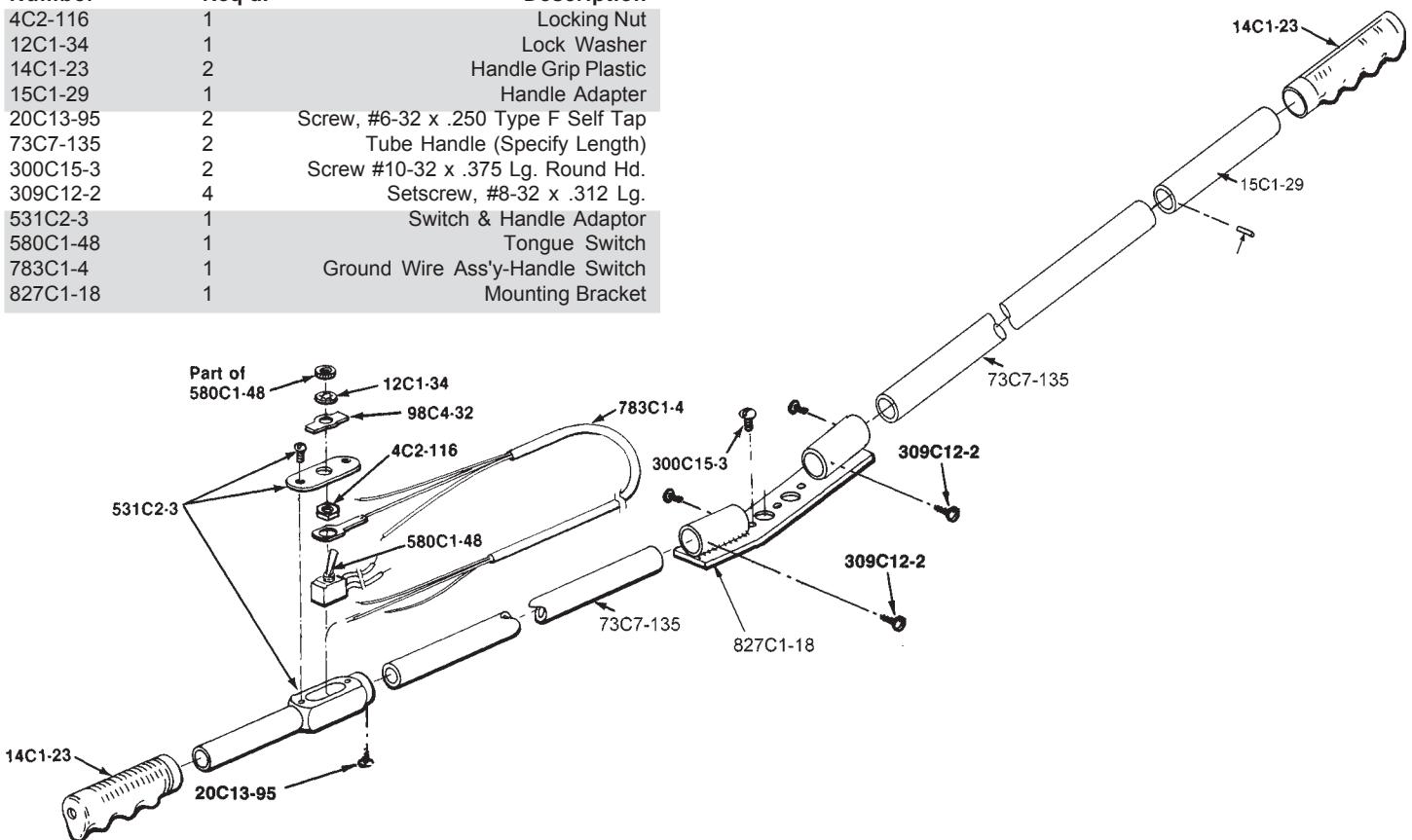
Ordering Replacement Parts

Your Eastman Falcon IV has been carefully designed to provide many hours of trouble free operation. The comprehensive exploded part illustrations have been carefully prepared to enable you to easily order replacement parts, as required. Replacement parts for this machine may be ordered through your nearest Eastman representative or directly from the Eastman factory.

Push/Pull Option

820C1-83

Part Number	No. Req'd.	Description
4C2-116	1	Locking Nut
12C1-34	1	Lock Washer
14C1-23	2	Handle Grip Plastic
15C1-29	1	Handle Adapter
20C13-95	2	Screw, #6-32 x .250 Type F Self Tap
73C7-135	2	Tube Handle (Specify Length)
300C15-3	2	Screw #10-32 x .375 Lg. Round Hd.
309C12-2	4	Setscrew, #8-32 x .312 Lg.
531C2-3	1	Switch & Handle Adaptor
580C1-48	1	Tongue Switch
783C1-4	1	Ground Wire Ass'y-Handle Switch
827C1-18	1	Mounting Bracket



Wiring Diagram
Blue Print No. 668C1-266

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Part Number	No. Req'd.	Description
1C13-26	1	Cord Sleeve
4C1-198	2	Hex Nut #4-40
4C1-197	2	Allen Nut #10-32
4C2-116	1	Locking Nut
8C13-81	1	Cavity Insulation
8C15-4	1	Cover Insulation
10C1-47	1	Motor Fan
12C1-34	1	Lock Washer
12C1-49	2	Lock Washer
12C15-57	1	Spring Washer
12C15-95	1	Flat Washer #6
12C15-106	1	Spring Washer
14C1-23	1	Handle Grip Plastic
15C13-64	1	Stud, Counter Weight
17C15-133	2	Roll Pin
18C6-74	1	Tolerance Ring
20C3-31	2	Tie Rod Screw
20C5-21	1	Clamp Screw
20C13-95	1	Screw, #6-32 x .250 Type F Self Tap
20C13-103	2	U-Lock Screw
20C12-160	1	Sharpener Screw Button Hd.
20C13-56	1	Set Screw #6-32 x 6
21C5-5	1	Sharpener Bushing (Hex)
21C6-4	1	Sharpener Bushing
25C4-180	1	Knife Guard
34C10-158	1	Sharpener Spring
34C10-172	2	Brush Spring
50C7-27	1	Cord Clamp
53C2-113	1	Cover Plate
53C11-107	1	Knife Flange Cover
53C11-136	1	Cover, Counterweight
55C4-113	2	Switch Spacer
61C2	1	Motor Shell
73C7-146-L	1	Tube Handle (Specify Length)
79C1-120	1	Falcon Nameplate Label, 110v
79C1-121	1	Falcon Nameplate Label, 220v
79C2-61	1	Decal, Guard Caution
79C2-62	1	Decal, Sharp Blade Caution
79C12-286	1	Bearing Retaining Plate
79C12-317	1	Lint Deflector
80C1-141	1	Knife 4" Round
83C4-26	1	Knife Flange
87C7-40	1	Knife Gear
87C7-45	1	Worm-4 Lead
90C1-165	1	Bearing Housing
90C4-81	4	Needle Bearing
90C6-48	1	Ball Bearing Front
90C6-50	1	Ball Bearing Rear
90C6-53	1	Ball Bearing Knife Flange
98C4-32	1	On-Off Switch Clip
115C1-15	4	Wear Disc, Bearing Skate
136C1-26	1	Counterweight

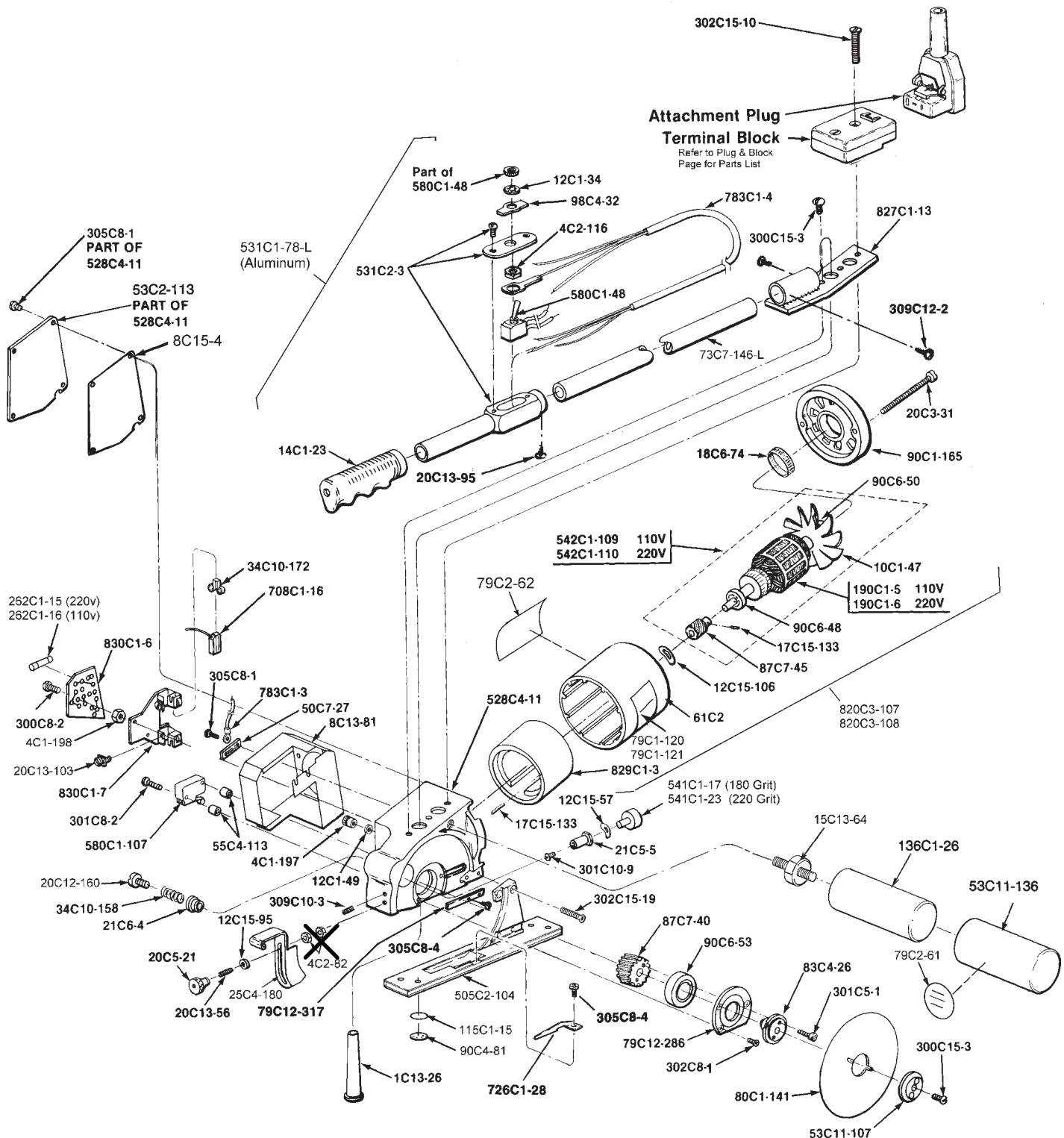
Part Number	No. Req'd.	Description
190C1-5	1	Armature, 110v
190C1-6	1	Armature, 220v
262C1-15	1	Fuse, 1-1/2 amp. (220v)
262C1-16	1	Fuse, 3 amp (110v)
300C8-2	2	Screw #4-40x .500 Lg. Round Hd.
300C15-3	2	Screw #10-32 x .375 Lg. Round Hd.
301C5-1	2	Screw #3-48 x .750 Lg. Fillister Hd.
301C8-2	2	Screw #4-40 x .875 Fillister Hd.
301C10-9	1	Screw #6-32 x .188 Lg. Fillister Hd.
302C8-1	3	Screw #4-40 x .375 Lg. Flat Hd.
302C15-10	2	Screw #10-32 x 1.375 Flat Hd.
302C15-19	2	Screw #10-32 x 1.000 Lg. Soc Flat Hd.
305C8-1	8	Screw #4-40 x .250 Lg. Blinding Hd.
305C8-4	3	Screw #4-40 x .125 Lg. Blinding Hd.
309C10-3	1	Setscrew #6-32 x .500 Lg.
309C12-2	2	Setscrew #8-32 x .312 Lg.
505C2-104	1	Base Plate Assembly, Bearing Skate
528C4-11	1	Standard With Cover Assembly
531C1-78-L	1	Operator Handle Assembly, Aluminum
531C2-3	1	Switch & Handle Adaptor
541C1-17	1	Emery Wheel, 180 Grit
541C1-23	1	Emery Wheel, 220 Grit
542C1-109	1	Armature Assembly, 110v
542C1-110	1	Armature Assembly, 220v
580C1-48	1	Tongue Switch
580C1-107	1	Track Switch
708C1-16	2	Motor Brush
726C1-28	1	Shear Plate Assembly
783C1-3	1	Ground Wire Ass'y., Green/Yellow
783C1-4	1	Ground Wire Ass'y-Handle Switch
820C3-107	1	Falcon Motor, 110v
820C3-108	1	Falcon Motor, 220v
827C1-13	1	Handle Bracket Assembly
829C1-3	1	Magnetic Ring Assembly
830C1-6	1	Circuit Board
830C1-7	1	Brush Card Assembly

A/R - As Required

* - Not included in this Assembly

L = Length

NOTE: Please specify model and serial number of machine when ordering parts.
Item numbers are for reference only.
Please specify PART NUMBERS when ordering replacement parts.

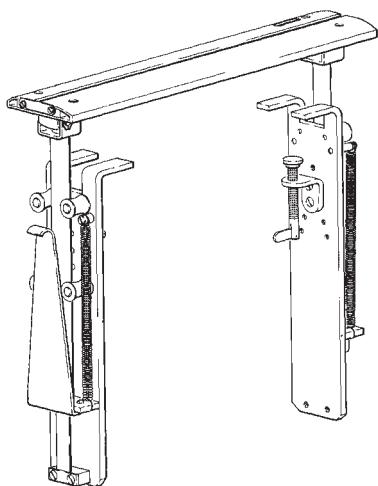


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Track & Lifter Assembly

ITEM	PART NO.	DESCRIPTION	QTY.
1	302C18-2	Screw, Flat Head 1/4-20 X 1/2	2
2	79C12-296	Slider Plate, Bias Track "only"	1
3	171C1-25	Lift Locking Bracket	1
4	308C15-2	Screw, Socket Hd. #10-32 X 1/2	2
5	-		
6	760C1-3	Switch Bracket, Electric "only"	1
7	64C1-12	Switch Cam, Electric "only"	1
8	300C15-3	Screw, Round Head #10-32 x 3/8	1
9	17C15-134	Roll Pin	2
10	119C4-42	Support Plate	1
11	46C3-20	Clamp Block	1
12	302C15-3	Screw, Flat Head #10-32 x 1/2	2
13	823C1-12-TS	Falcon Track Assembly	1
	823C1-33-TS	Falcon Track Assembly, 96" & larger	1
	823C2-1-TS	Falcon Track Assembly, Bias "only"	1
14	20C12-156	Latch Screw	4
15	97C3-38	Track Latch	2
15A	67C6-1	Latch Mount, 96" & larger	2
16	300C18-4	Screw, Round Head 1/4-20 x 5/8	4
17	193C1-14-TS	Falcon Track, Solid	1
	193C1-19-TS	Hollow Falcon Track, 96" & larger	1
	193C1-25-TS	Bias Falcon Track	1
18	C9-27 Q	Track Wear Strip	A/R
19	211C1-2	Foam Tape	A/R
20	840C1-1	Lifter Assembly	1
	840C2-1	Bias Lifter Assembly	1
21	4C2-58	Nut, Hex 1/4-20	4
22	18C6-47	Grip Ring	6
23	763C1-27	Lift Tube	2
24	11C2-54	Shaft, Belt Roller	3
25	12C15-108	Washer, Flat 1/4	6
26	41C5-12	Belt Roller, Front	1
26A	41C5-14	Belt Roller, Back	1
26B	41C5-15	Belt Roller, Lower	1

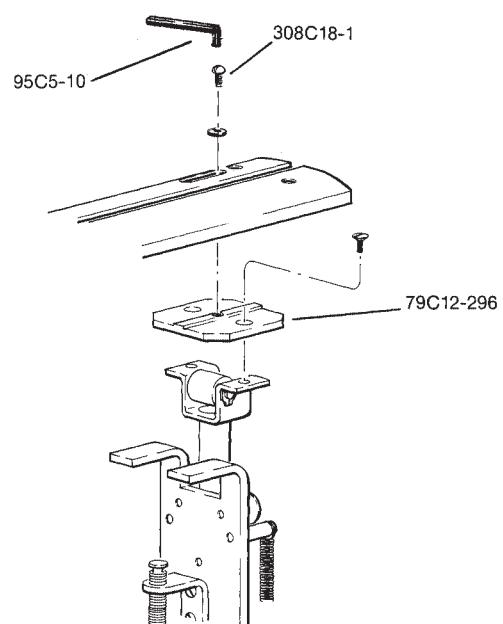


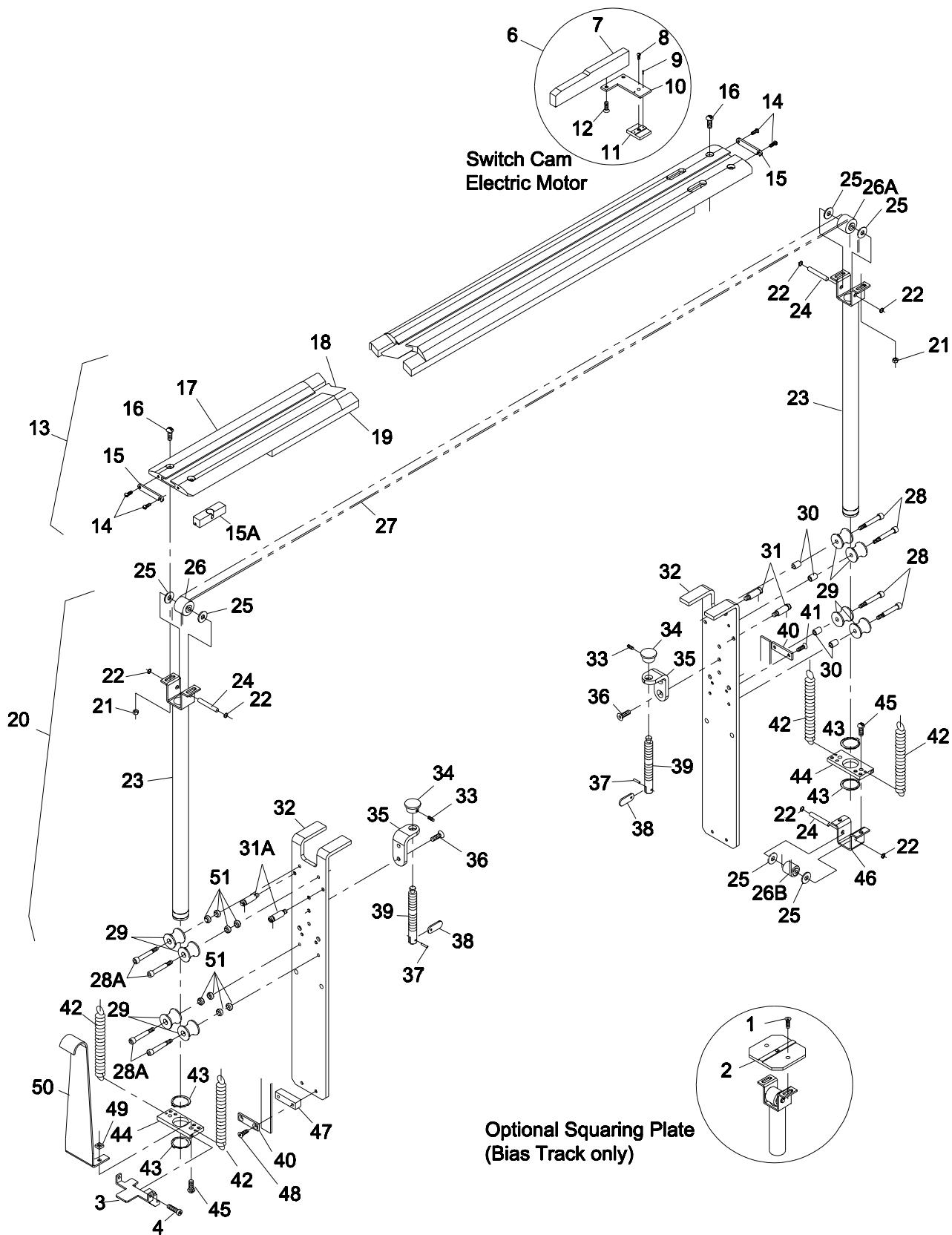
ITEM	PART NO.	DESCRIPTION	QTY.
27	181C4	Lift Belt	A/R
28	311C14-2	Screw, Shoulder, 1/4 x 1-1/4	4
28A	311C14-1	Screw, Shoulder, 1/4 x 3/4	4
29	70C4-45	Roller Guide	8
30	55C4-118	Roller Spacer	4
31	15C13-59	Stud, Lift Spring, Long	2
31A	15C13-56	Stud, Lift Spring, Short	2
32	79C12-295	Main Frame, Lift Assembly	2
33	20C13-4	Setscrew #8-32 x 3/16	2
34	191C2-1	Swivel Pad	2
35	50C11-34	Clamp Base	2
36	302C18-2	Screw, Flat Head 1/4-20 x 1/2	4
37	17C15-126	Roll Pin 1/8 x 1/2	2
38	57C7-49	Clamp Lever	2
39	20C5-22	Clamp Screw	2
40	33C10-59	Belt Holder	2
41	302C15-3	Screw, Flat Head #10-32 x 1/2	2
42	34C10-181	Spring	4
43	18C6-65	Grip Ring, Large	4
44	35C7-35	Plate, Spring Mount	2
45	300C18-4	Screw, Round Head 1/4-20 x 5/8	4
46	62C16-265	Roller Bracket	1
47	55C4-117	Spacer, Front Belt Clamp	1
48	302C15-7	Screw, Flat Head #10-32 x 1	2
49	4C2-119	Square Nut, 1/4-20	2
50	22C3-9	Lift Handle	1
51	12C15-14	Spacer, Short	8

A/R - As Required

TS - Table Size

Please specify Table Width when ordering

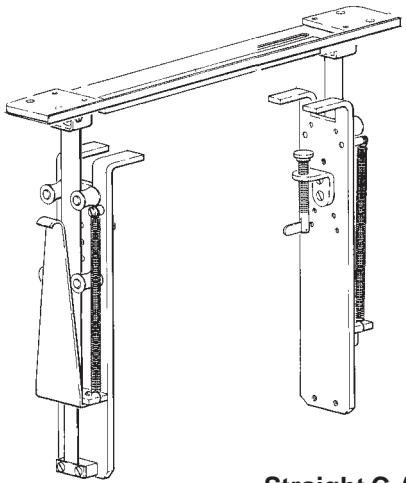




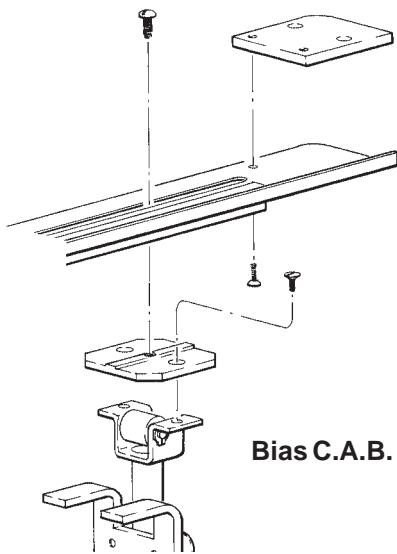
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Cloth Alignment Bar & Lifter Assembly



Straight C.A.B.



Bias C.A.B.

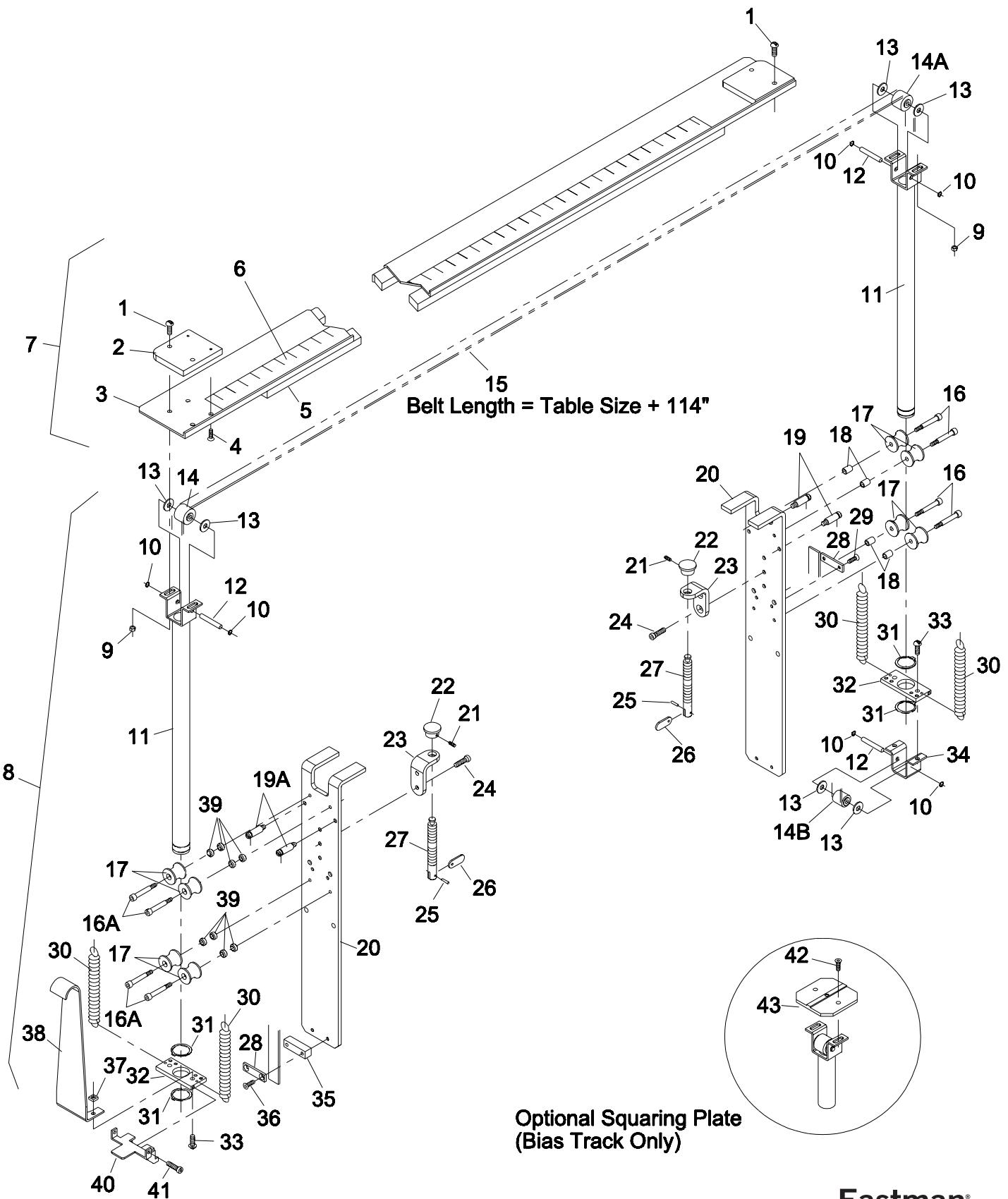
ITEM	PART NO.	DESCRIPTION	QTY.
1	300C18-4	Screw, Round Head 1/4-20 x 5/8	*8
2	136C1-24	Bar Weight	2
3	78C3-2	Cloth Alignment Bar	1
	78C3-5	Cloth Alignment Bar, Bias Cut only	1
4	302C10-10	Screw, Flat Head #6-32 x 7/16	8
5	211C1-2	Foam Tape	A/R
6	185C1-227	Scale, Inches	1
	185C1-240	Scale, 240 cm	*1
	185C1-236	Scale, Units	*1
7	839C1-1	CAB Assembly	1
	839C2-1	Bias CAB Assembly	1
8	840C1-2	Cab Lifter Assembly	1
	840C2-2	Bias Cab Lifter Assembly	1
9	4C2-58	Nut, Hex 1/4-20	4
10	18C6-47	Grip Ring	6
11	763C1-27	Lift Tube	2
12	11C2-54	Shaft, Belt Roller	3
13	12C15-108	Washer, Flat 1/4	6
14	41C5-12	Belt Roller, Front	1
14A	41C5-14	Belt Roller, Back	1
14B	41C5-15	Belt Roller, Lower	1
15	181C4	Lift Belt	A/R
16	311C14-2	Screw, Shoulder, 1/4 x 1-1/4	4
16A	311C14-1	Screw, Shoulder, 1/4 x 3/4	4
17	70C4-45	Roller Guide	8
18	55C4-118	Roller Spacer	4
19	15C13-59	Stud, Lift Spring, Long	2
19A	15C13-56	Stud, Lift Spring, Short	2
20	79C12-295	Main Frame, Lift Assembly	2
21	20C13-4	Setscrew #8-32 x 3/16	2
22	191C2-1	Swivel Pad	2
23	50C11-34	Clamp Base	2
24	302C18-2	Screw, Flat Head 1/4-20 x 1/2	4
25	17C15-126	Roll Pin 1/8 x 1/2	2
26	57C7-49	Clamp Lever	2
27	20C5-22	Clamp Screw	2
28	33C10-59	Belt Holder	2
29	302C15-3	Screw, Flat Head #10-32 x 1/2	2
30	34C10-181	Spring	4
31	18C6-65	Grip Ring, Large	4
32	35C7-35	Plate, Spring Mount	2
33	300C18-4	Screw, Round Head 1/4-20 x 5/8	4
34	62C16-265	Roller Bracket	1
35	55C4-117	Spacer, Front Belt Clamp	1
36	302C15-7	Screw, Flat Head #10-32 x 1	2
37	4C2-119	Square Nut, 1/4-20	2
38	22C3-9	Lift Handle	1
39	12C15-14	Spacer, Short	8
40	171C1-25	Lift Locking Bracket	1
41	308C15-2	Screw, Socket Hd. #10-32 X 1/2	2
42	302C18-2	Screw, Flat Head 1/4-20 X 1/2	2
43	79C12-296	Slider Plate, Bias Track "only"	1

A/R - As Required

TS - Table Size

* -Not Included

Please specify Table Width when ordering



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Air Lift Assembly

840C1-18

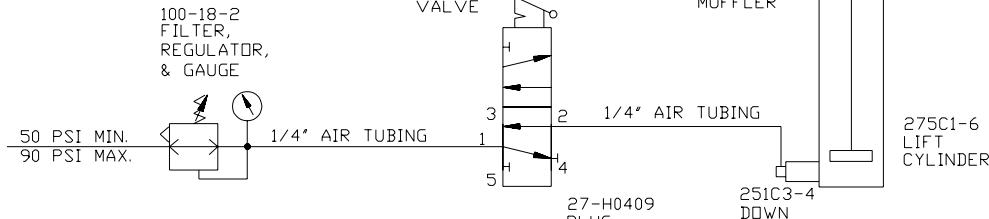
ITEM	PART NO.	DESCRIPTION	QTY.
1	100-19-9	Mounting Bracket	1
2	100-18-2	Air Regulator	1
3	100-13-7	Swivel Elbow, 1/8 npt x 1/4 Push-on	3
4	27-H0409	Plug, 1/8" npt	1
5	67-26115-1	Air Control Valve	1
6	54-26156-1	Plate, Valve Mount	1
7	236C1-176	Decal, Air Lift Control	1
8	373-99-12	Hex Self Tap Screws	2
9	27-02996-1	1/4" Air Line	A/R
10	18C6-47	Grip Ring	6
11	763C1-27	Lift Tube	2
12	11C2-54	Shaft, Belt Roller	3
13	12C15-108	Washer, Flat 1/4	6
14	41C5-14	Belt Roller, Top	2
14A	41C5-15	Belt Roller, Lower	1
15	181C4	Lift Belt	A/R
16	311C14-2	Screw, Shoulder, 1/4 x 1-1/4	8
17	70C4-45	Roller Guide	8
18	55C4-118	Roller Spacer	4
19	34C1-63	Spring, .453 x 7/16 F.L.	4
20	79C12-295	Main Frame, Lift Assembly	2
21	20C13-4	Setscrew #8-32 x 3/16	4
22	191C2-1	Swivel Pad	4

ITEM	PART NO.	DESCRIPTION	QTY.
23	205C1-2	Clamp Base, Wide	2
24	308C18-9	Screw, Socket Head 1/4-20 x 1/2	4
25	17C15-126	Roll Pin 1/8 x 1/2	4
26	57C7-49	Clamp Lever	4
27	20C5-22	Clamp Screw	4
28	33C10-59	Belt Holder	2
29	302C15-3	Screw, Flat Head #10-32 x 1/2	2
30	308C15-2	Screw, Socket Head #10-32 x 1/2	4
31	18C6-65	Grip Ring, Large	3
32	35C7-35	Plate, Spring Mount	1
33	300C18-4	Screw, Round Head 1/4-20 x 5/8	2
34	62C16-265	Roller Bracket	1
35	55C4-117	Spacer, Front Belt Clamp	1
36	302C18-3	Screw, Flat Head #10-32 x 3/4	2
37	840C1-19	Front Air Lift Assembly	1
38	840C1-20	Back Air Lift Assembly	1
39	79C11-7	Lift Clamp Block Plate	1
40	275C4-1	Pivot Bracket	2
41	251C3-2	Speed Muffler, (Up Speed)	1
42	275C1-6	Lift Cylinder	1
43	251C3-4	Flow Control Valve (Down Speed)	1
44	12C1-19	Lock Washer, 1/4	4
45	308C18-9	Screw, Socket Head 1/4-20 x 1/2	4
46	79C11-8	Cylinder Mount	1

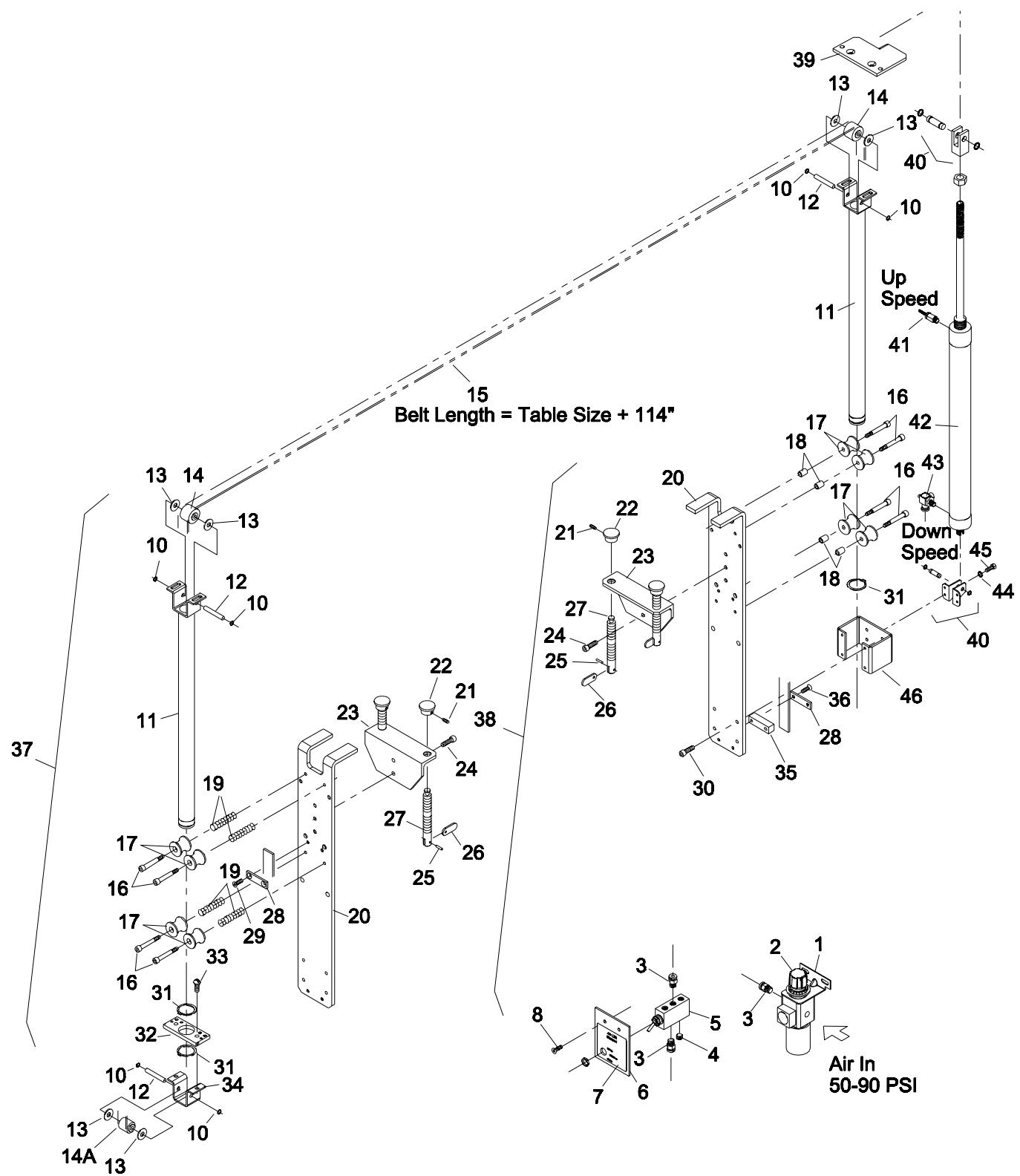
A/R - As Required

Air Lift Operation

Connect the air source (50-90 psi) to the air regulator. Test the lift for proper operation. If required, adjust the up/down lift speed, see figure 3. The speed muffler on the top port of the air cylinder will control the up speed. The flow control valve on the lower port of the air cylinder will control the down speed. After testing is complete the machine is ready for operation.



CAUTION
Disconnect and Relieve
Air Pressure before servicing

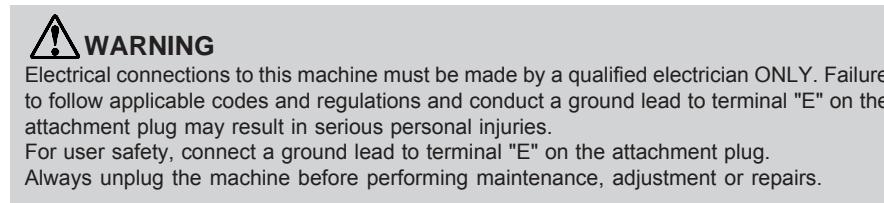
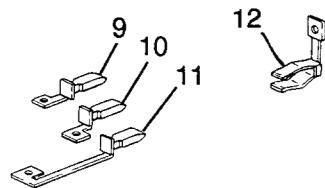
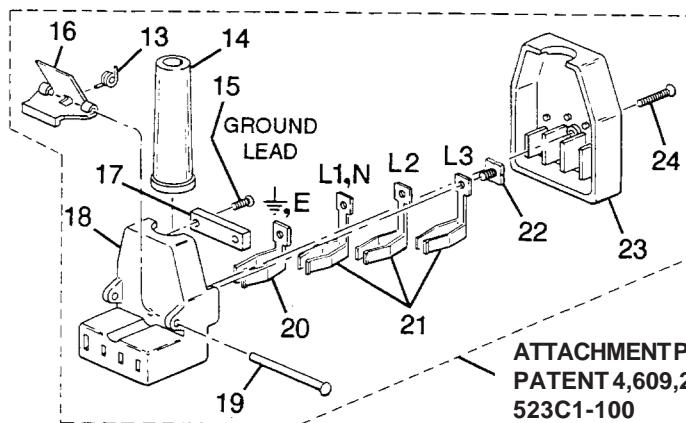
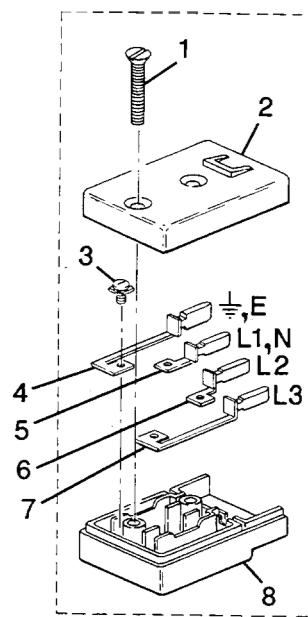


27-02996-1 1/4" o.d. Air Tubing

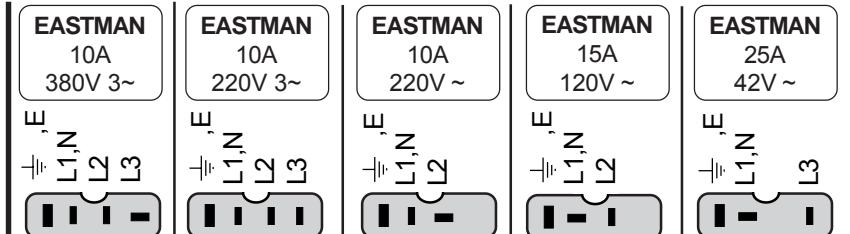
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Electrical Connections


ITEM PART NO. DESCRIPTION

1	302C15-8	Screw, 10-32 x 1 1/8 Flat Hd.	2	51C1-63
2	-----	Terminal Block Top	2	51C1-64
3	20C13-103	U-Lock Screw	4	51C1-65
4	667C1-22	Terminal Contact w/Pin E	1	51C1-66
5	667C1-23	Terminal Contact w/pin L1, N	1	51C1-67
6	667C1-24	Terminal Contact w/Pin L2	1	-----
7	667C1-25	Terminal Contact w/Pin L3	1	-----
8	51C1-61	Terminal Block Bottom	1	-----
9	667C1-26	Terminal Contact w/Pin L1, N	1	-----
10	667C1-27	Terminal Contact w/Pin L2	1	-----
11	667C1-28	Terminal Contact w/Pin L3	1	-----
12	47C3-21	Terminal Sleeve (current)	1	-----
13	34C10-170	Spring	1	-----
14	1C13-27	Cord Sleeve	1	-----
15	300C8-2	Screw, 4-40 x 1/2 Round Hd.	2	-----
16	98C4-37	Thumb Clip	1	-----
17	50C7-27	Cord Clamp	1	-----
18	-----	Attachment Plug Body	82C1-45	82C1-46
19	91C4-22	Rivet	1	1
20	47C3-19	Terminal Sleeve	1	1
21	47C3-20	Terminal Sleeve (current)	2	1
22	20C13-103	U-Lock Screw	4	3
23	-----	Attachment Plug Cover	53C3-19	53C3-20
24	302C8-8	Screw, 4-40 x 7/8 Flat Hd.	1	1
25	-----	Terminal Block Complete	508C1-99	508C1-100
26	-----	Attachment Plug Complete	523C1-99	523C1-100



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