

Eastman®

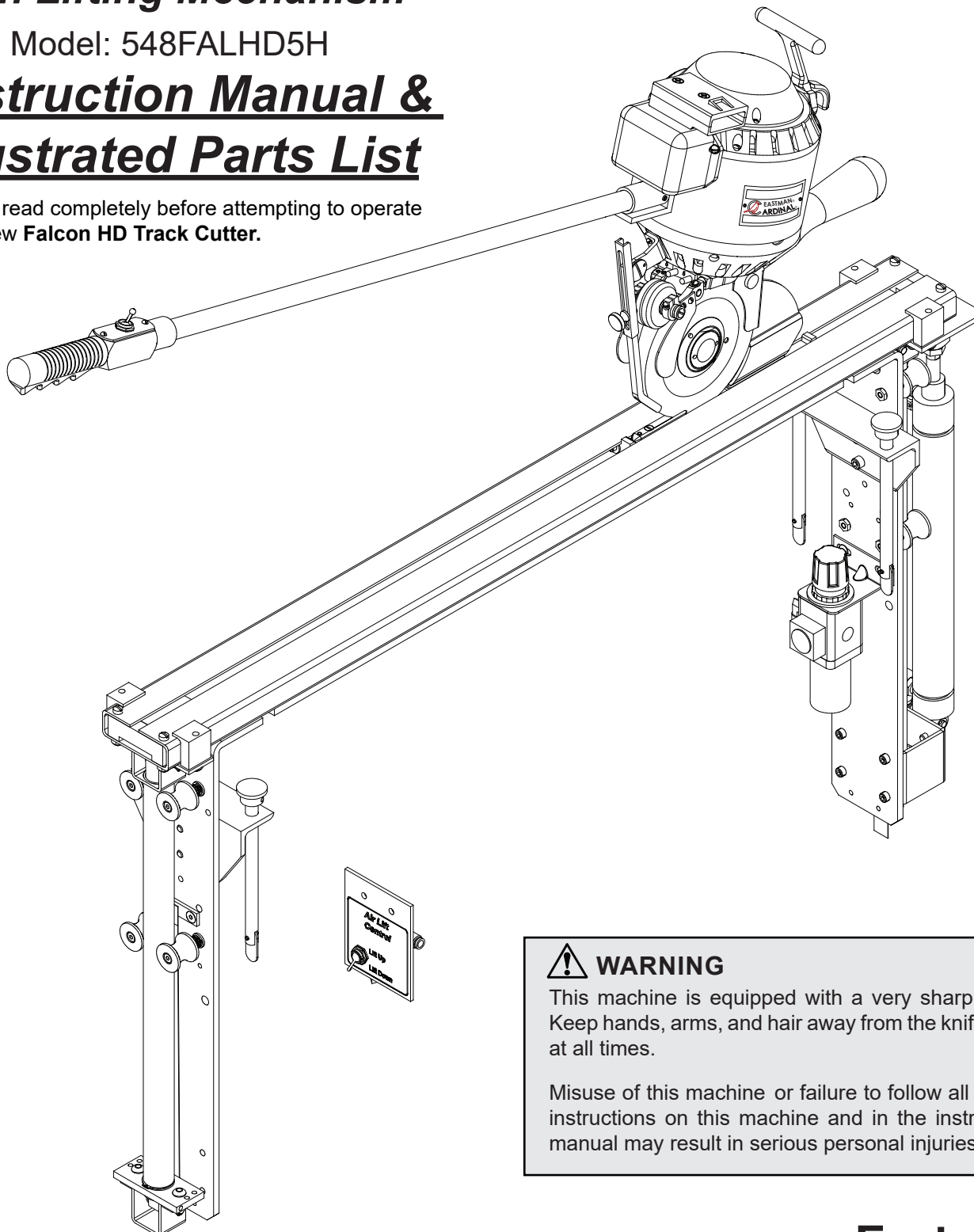
THE EASTMAN®

548 Falcon HD End Cutter **with Lifting Mechanism**

Model: 548FALHD5H

Instruction Manual & **Illustrated Parts List**

Please read completely before attempting to operate your new **Falcon HD Track 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.

Eastman®

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

www.EastmanCuts.com

Table of Contents

Safety Information.....	3	Pictorial Index & Familiarization	8
Safety and Indemnification	3	548 Cardinal Round Knife Familiarization	9
General Safety Precautions	3	548 5H - Single Phase Motors.....	10
Installation.....	4	548 5H - Three Phase Motors	12
548 Falcon End Cutter Installation	4	Sharpener Assembly	14
End Cutter, Track & Lifter Installation	4	Standard Assembly.....	16
Operation.....	5	Press-Foot Attachment, Guard Assembly	18
Familiarization.....	5	Base Plate Assembly.....	19
548 Falcon End Cutter (Air Lift Shown).....	5	Push Handle Assembly, with Switch.....	20
Maintenance.....	5	RK Push Swivel Handle Assembly	21
Knife Motor.....	5	Pull Handle Assembly, with Switch.....	22
Maintenance Procedures.....	5	Push/Pull Handle Assembly	23
Air Regulator (System Lift Pressure).....	5	Air Lifter Assembly	24
Knife Sharpening.....	5	HD Falcon Lifter Assembly - Manual	26
Knife Replacement.....	6	No-Lift, Bracket Mount, HD FAL. Assembly	28
To Adjust the Throat Plate.....	6	HD Track Assembly	29
To Adjust Emery Wheels.....	6	Cloth Alignment Bar & Lifter Assembly.....	30
Service	6	Electrical Connections.....	32
Ordering Replacement Parts.....	6	Pneumatic Air Lift Diagram.....	33
Lubrication Maintenance.....	7	Wiring Diagrams.....	34
		Service Record.....	35
		Technical Data.....	36

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 allocated 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.

Installation

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

The **548 Falcon End Cutter** 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.

548 Falcon End Cutter Installation

The 548 Falcon weighs approx. 90 lbs, (41 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) 548 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.**



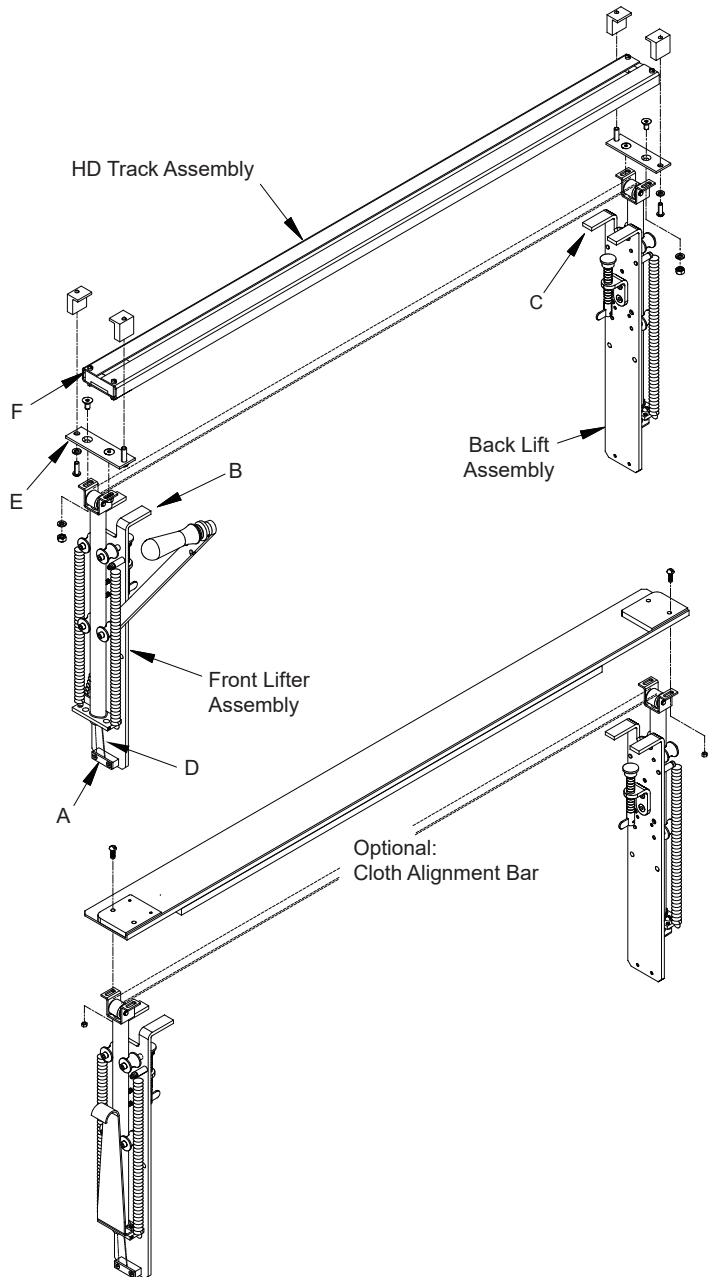
CAUTION

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

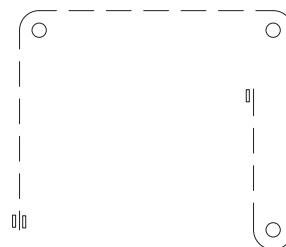
End Cutter, Track & Lifter Installation

Remove your 548 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 (E) to the lifting mechanism. The track should be mounted squarely to the table.

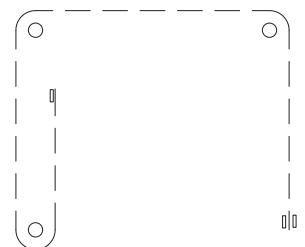
Remove the track stop (F). Slide the 548 Falcon Cutter in the track. Fasten and secure the end stop in place. (Air Lift Only) - Mount user control panel and connect airlines. **CAUTION**, Air Lifter can raise track with dangerous force, stand clear of track assembly when connecting air supply. Connect electric power line. The 548 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

548 Falcon End Cutter (Air Lift Shown)

1. **Rear Lift Assembly:** Lifts the non-operator side of the track assembly.
2. **HD Track Assembly:** Used to guide the cutting head across the table to provide a straight cut through the material.
3. **548 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).
4. **Electrical Terminal Block:** Electrical connection is made here. Check for proper voltage before connecting the attachment plug.
5. **Front Lift Assembly:** Lifts the operator side of the track assembly.
6. **Filter Regulator:** Air supply connection is made here. Adjust Pressure as required. Auto drain feature removes moisture from incoming air supply. (Air Lifter Only)

CAUTION

Machine Equipped
with Sharp Blade

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.

Maintenance Procedures

1. Be sure that the rollers of the skate are kept lint free.
2. Be sure that the terminal pins on the terminal block are kept in good condition to make full contact with the female receptacle.
3. Inspect the operating switch periodically to make sure that it is making full contact when in the "ON" position.
4. When replacing the knife on this cutting unit, be sure that any lint build-up between the knife and the standard is cleaned out.
5. If the cutting unit seems to lag while not cutting, the knife should be removed and the unit should be run without the knife to see if the machine has been over-greased or if there is an obstruction somewhere.

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 548 Falcon Cutter remains in its home position and the blade turns. To obtain a fine, keen edge on the blade, press and hold sharpener trigger lightly, the sharpening stones will contact the blade. Press and hold trigger with constant pressure for 10 seconds, then release. Repeat process as necessary.



WARNING

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

Eastman®

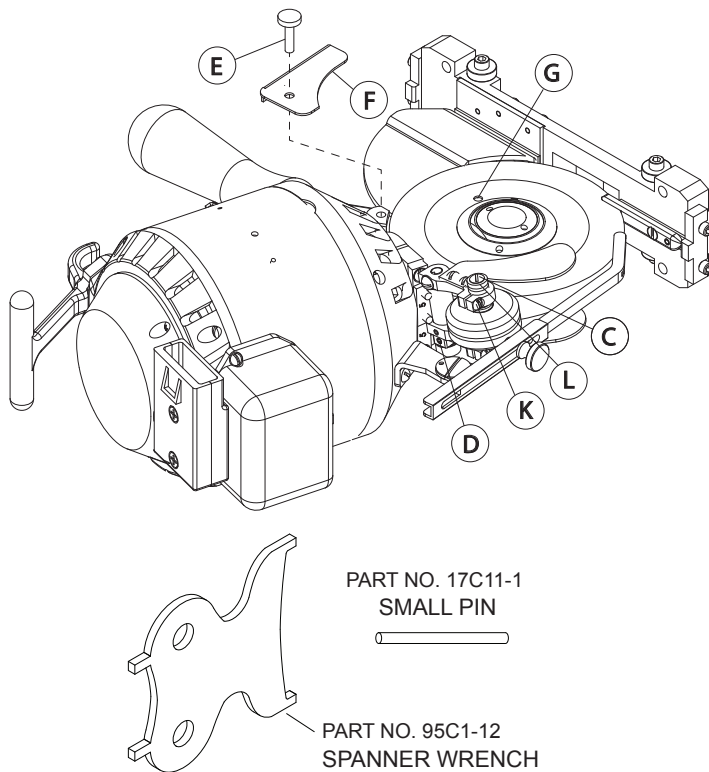
Knife Replacement



WARNING:

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

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



Loosen thumb screw "E" and swing guard "F" to outward position as shown on dotted lines. Turn the knife so the small hole lines up with hole "G" in the standard. Insert the small pin that is with the supplies in hole "G." Remove the lock nut that retains the blade within the special spanner wrench. When installing a new knife, be sure the name "Eastman Machine Company" is facing outward, and that the knife seats on the gear. Install knife lock nut and be sure that throat plate is adjusted as outlined.

To Adjust the Throat Plate

It is very important that the edge of the knife be as close as possible without touching to the forward position in the slot on the throat plate. The slot in the throat plate "J" should straddle the blade and screws "H" can be loosened and re-tightened to accomplish this adjustment.

To Adjust Emery Wheels

As the Emery Wheels wear away and become farther apart, they must be adjusted. Adjust Emery Wheels from both sides to assure proper centering of the wheels over the knife. Proceed as follows:

1. Loosen slotted head screws "K."
2. With fingers, turn adjusting bushings "L" until Emery Wheels are as close together as possible without touching, and are centered over the knife. Both wheels should grind at the same time when pressed lightly against the knife and there should be no more than 1/32"-inch clearance between the two Emery Wheels.
3. Tighten slotted head screws "K".

To Replace Emery Wheels

1. With front of machine facing serviceman, guard rod in down safe position, remove right hand grinding wheel and arm by loosening set screw "D" and sliding arm off shaft.
2. Remove slotted head screw "C" and replace grinding wheel with spindle in right hand arm.
3. No need to remove left hand arm from machine. Remove slotted head screw "C" from left hand arm and replace grinding wheel with spindle.
4. Re-assemble right hand arm to shaft and adjust wheels to knife as covered above.

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.

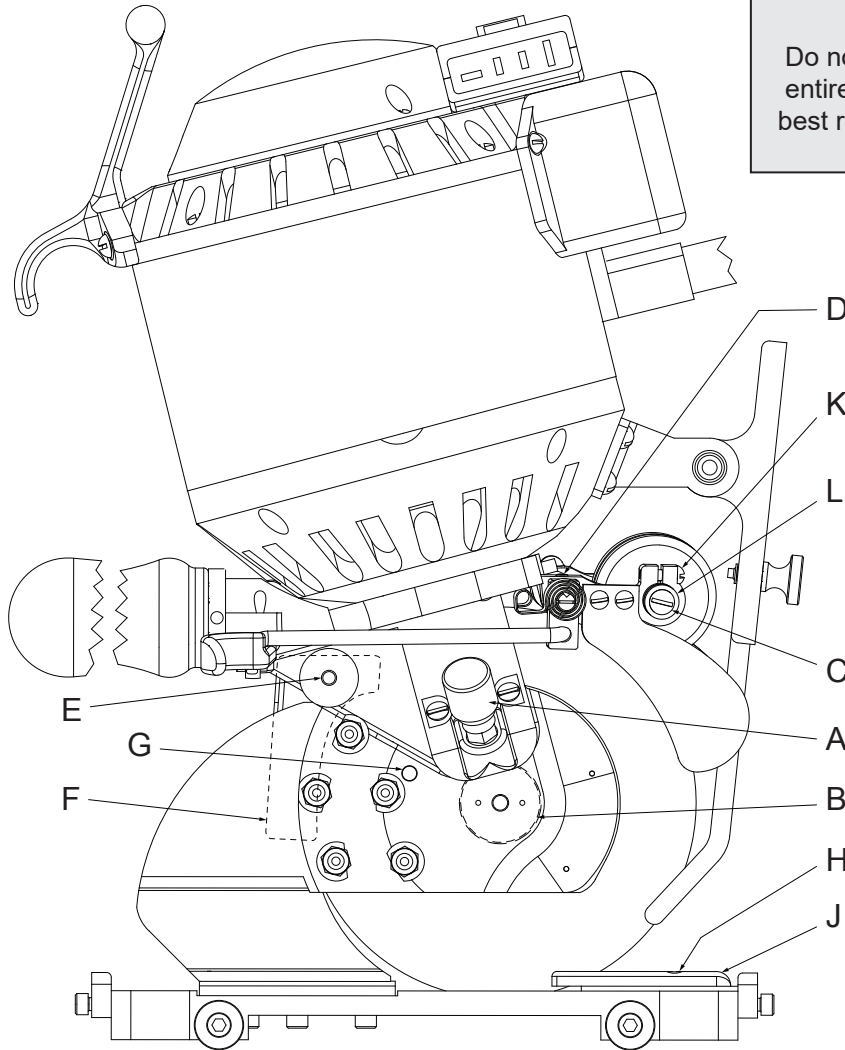
Ordering Replacement Parts

Your Eastman **548 Falcon** 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.



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.



5" REPLACEMENT KNIVES

Carbon Steel	80C1-101
High Speed Steel	80C1-101-HS
High Speed Steel Grooved	80C1-101-HSG
High Speed Steel Teflon Coated	80C1-101-HST

* Replacement Knives for a Model 548 Round Knife Cutter.

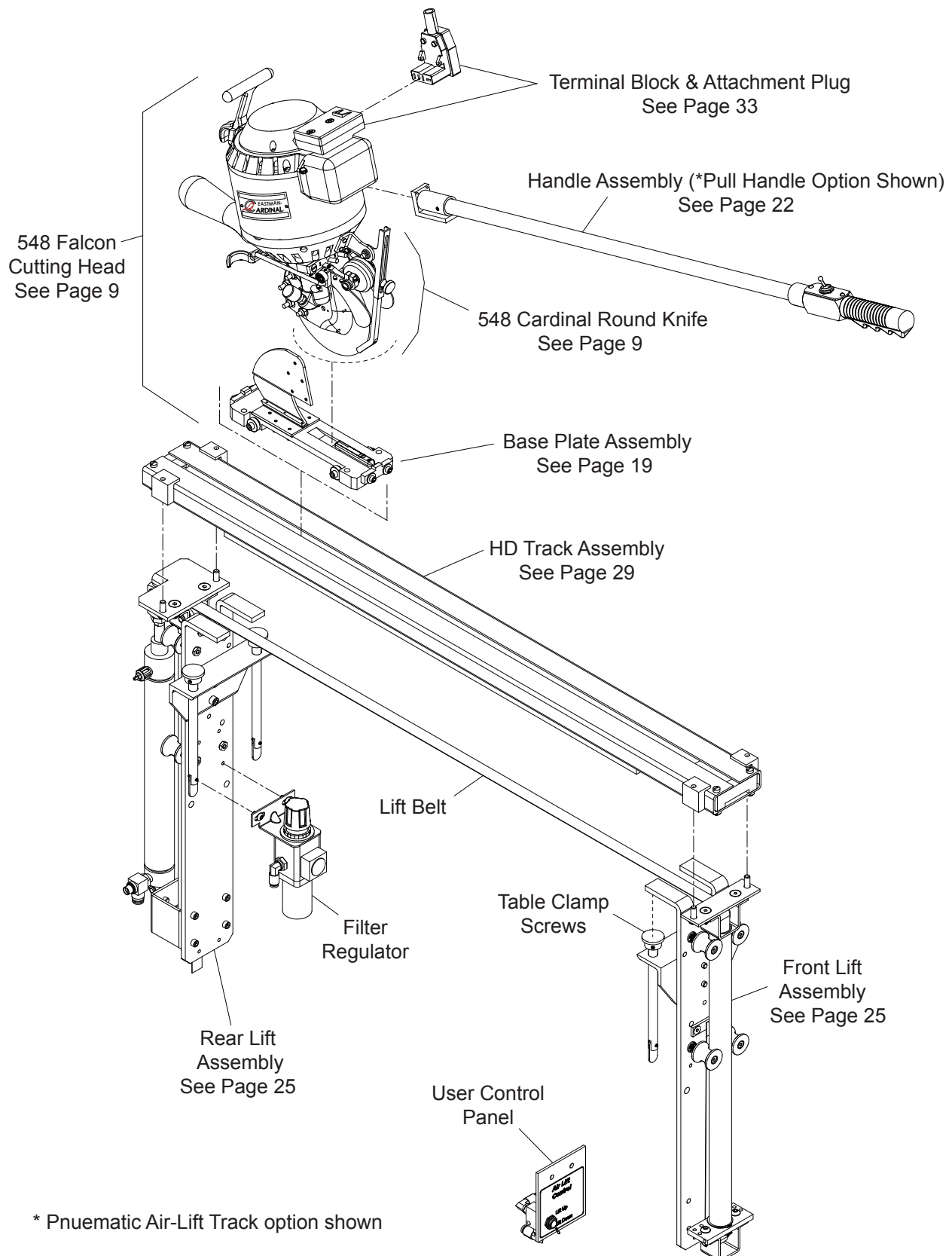
Lubrication Maintenance

TWICE A DAY	ONCE A DAY	ONCE A MONTH
Oil Emery Wheel Spindles at location "C." DO NOT USE AN EXCESS AMOUNT OF OIL	Lubricate gears, screw grease cup "A" down one-half turn. Refill cup, as required with Eastman Gear Lubricant, special formula: (242C2)	Grease knife gear bearing a "B," remove bearing locknut with spanner wrench and add a small amount of Eastman Lubriko grease (242C2-2) from tube.

We recommend our Eastman Gear Lubricant special formula (242C2) for gears and Eastman Lubriko grease (242C2-2) for knife gear ball bearings. Do not use Eastman Gear Lubricant for ball bearings, or Eastman Lubriko grease for gears.

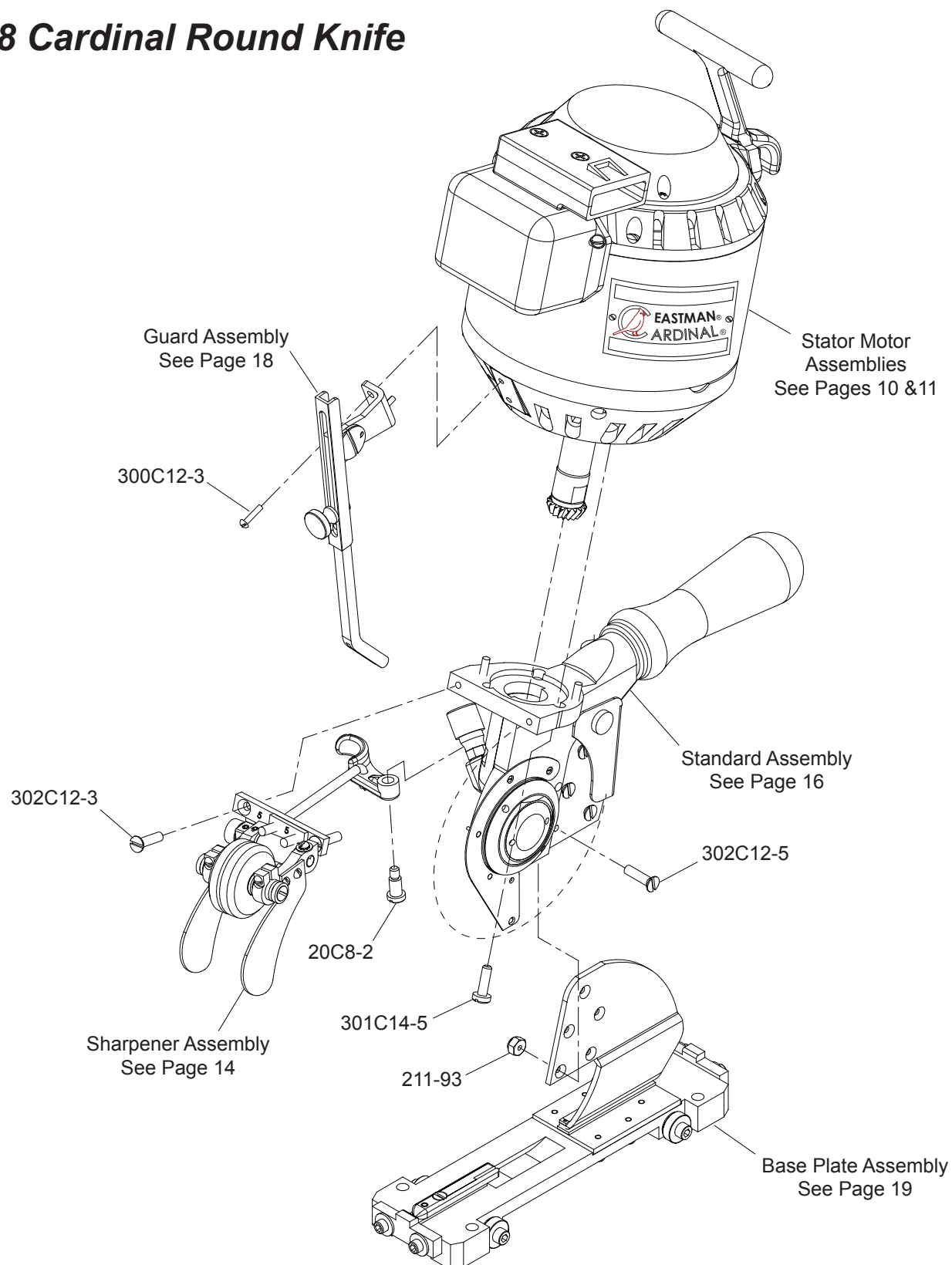
Eastman®

Pictorial Index & Familiarization



Familiarization

548 Cardinal Round Knife



Eastman®

548 5H - Single Phase Motors

(A) 517C1-1101 - (110V, 60Hz, 1Ph, 2Pole)

(B) 517C1-1051 - (110V, 60Hz, 1Ph, 4Pole)

(C) 517C1-1106 - (220V, 50Hz, 1Ph, 2Pole)

(D) 517C1-1109 - (220V, 50Hz, 1Ph, 4Pole)

(E) 517C1-1049 - (220V, 60Hz, 1Ph, 2Pole)

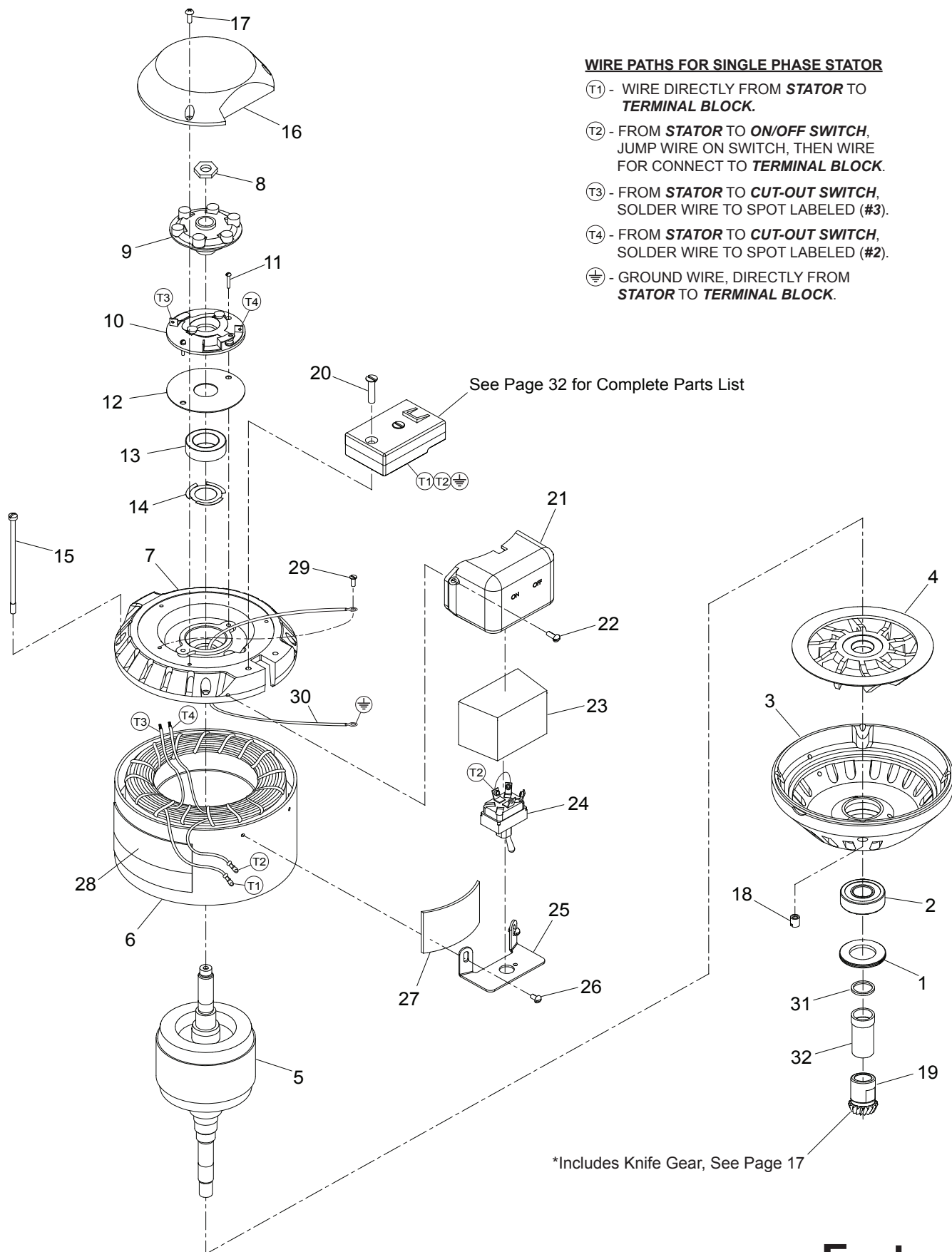
(F) 517C1-994 - (42V, 50Hz, 1Ph, 2Pole)

(G) 517C1-791 - (220V, 50Hz, 1Ph, 2Pole)

ITEM	PART NO.	DESCRIPTION	QTY.	ITEM	PART NO.	DESCRIPTION	QTY.
1	4C1-87	Locknut Front Bearing	1	12	8C5-10	Insulation for Switch	1
2	90C6-29	Bearing Ball	1	13	90C6-46	Bearing Ball	1
3	90C2-143	Bearing Housing, Front	1	14	12C1-12	Washer, Loading Spring	1
4	10C2-27	Fan, Rotor	1	15	20C3-34	Screw, Bearing (Special)	4
5	513C3-233	Rotor Shaft 548 5H	1	16	53C7-36	Cover, Rear Bearing 548	1
6A	514C4-206	Stator & Band, 1106012	1	17	301C10-3	Scr. Round Hd. #6-32x3/8	3
6B	514C4-221	Stator & Band, 1106014	1	18	4C1-118	Locknut, Rear Bearing	1
6C	514C4-208	Stator & Band, 2205012	1	19	675C1-11	Gear Set, 4H & 5H	1
6D	514C4-212	Stator & Band, 2205014	1	20	302C15-8	Scr. Flat Hd. #10-32x1&1/8	2
6E	514C4-207	Stator & Band, 2206012	1	21	53C2-104	Switch Cover 3Ph 548	1
6F	514C4-216	Stator & Band, 0425012	1	22	300C10-4	Scr. Round Hd. #6-32x3/8	2
6G	514C4-208	Stator & Band, 2205012	1	23	8C4-41	Switch Insulation	1
7	589C2-56	Bearing Housing, Rear	1	24	580C1-85	Switch, On/Off	1
8	4C1-118	Locknut, Rear Bearing	1	25	52C5-171	Switch Mounting Bracket	1
9A	597C1-21	Cut-Out Auto 60CY 548	1	26	300C10-2	Scr. Round Hd. #6-32x1/4	2
9B	597C1-23	Cut-Out Auto 60CY 4PL	1	27	8C4-72	Switch Insulation	1
9C	597C1-22	Cut-Out Auto 50CY 625	1	28	79C2-52	Name Plate, Metal	1
9D	597C1-24	Cut-Out Auto 50CY 4PL	1	29	305C10-1	Scr. Binding Hd. #6-32x1/4	1
9E	597C1-21	Cut-Out Auto 60CY 625	1	30	783C1-3	Ground Wire Asm. (Grn/Yel)	1
9F	597C1-21	Cut-Out Auto 60CY 625	1	31	See Chart	Shim Spacer	A/R
9G	597C1-22	Cut-Out Auto 50CY 625	1	32	1C5-33	Drive Gear Spacing Sleeve	1
10	580C1-70	Cut-Out Switch 625	1	A/R = As Required			
11	300C12-3	Scr. Round Hd. #8-32x3/8	2				

Shim Spacer Chart	
12C11-17A	Shim Spacer, .002 Thick
12C11-17B	Shim Spacer, .003 Thick
12C11-17C	Shim Spacer, .004 Thick
12C11-17D	Shim Spacer, .005 Thick
12C11-17E	Shim Spacer, .010 Thick

Item numbers are for reference only.
Please Specify PART NUMBER when
ordering replacement parts.



Eastman®

548 5H - Three Phase Motors

(A) 517C1-1115 - (220V, 60Hz, 3Ph, 2Pole)

(B) 517C1-1118 - (220V, 60Hz, 3Ph, 4Pole)

(C) 517C1-984 - (380V, 50Hz, 3Ph, 2Pole)

(D) 517C1-1243 - (440V, 60Hz, 3Ph, 2Pole)

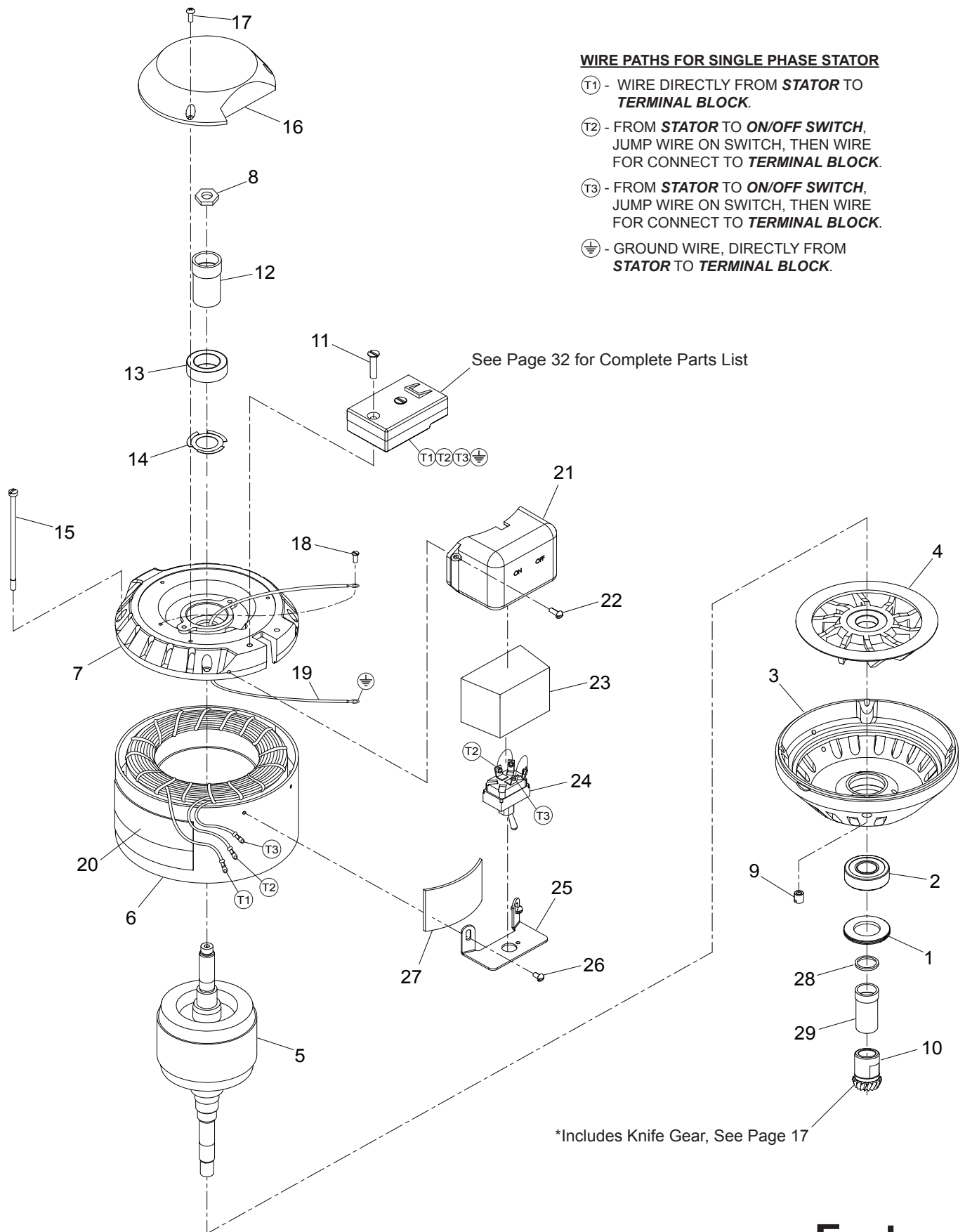
ITEM	PART NO.	DESCRIPTION	QTY.
1	4C1-87	Locknut Front Bearing	1
2	90C6-29	Bearing Ball	1
3	90C2-143	Bearing Housing, Front	1
4	10C2-27	Fan, Rotor	1
5	11C4-318	Rotor Shaft 548 5H	1
6A	514C4-213	Stator & Band, 2206032	1
6B	514C4-215	Stator & Band, 2206034	1
6C	514C4-217	Stator & Band, 3805032	1
6D	514C4-249	Stator & Band, 4806032	1
7	90C1-153	Bearing Housing, Rear	1
8	4C1-118	Locknut, Rear Bearing	1
9	4C1-186	Nut Bearing Screw	4
10	675C1-11	Gear Set, 4H & 5H	1
11	302C15-8	Scr. Flat Hd. #10-32x1&1/8	2
12	1C4-10	Sleeve Cutout, 548	1
13	90C6-46	Bearing Ball	1
14	12C1-12	Washer, Loading Spring	1
15	20C3-34	Screw, Bearing (Special)	4

ITEM	PART NO.	DESCRIPTION	QTY.
16	53C7-36	Cover, Rear Bearing, 548	1
17	301-C10-3	Scr. Round Hd. #6-32x3/8	3
18	305C10-1	Scr. Binding Hd. #6-32x1/4	1
19	783C1-3	Ground Wire Asm. (Grn/Yel)	1
20	79C2-52	Name Plate, Metal	1
21	53C2-104	Switch Cover 3PH, 548	1
22	300C10-4	Scr. Round Hd. #6-32x3/8	2
23	8C4-41	Switch Insulation	1
24A	580C1-85	Switch, 1Ph	1
24B	580C1-85	Switch, 1Ph	1
24C	580C1-98	Switch, 3Ph 629	1
24D	580C1-97	Switch, Dual Voltage	1
25	52C5-171	Switch Mounting Bracket	1
26	300C10-2	Scr. Round Hd. #6-32x1/4	2
27	8C4-72	Switch Insulation	1
28	See Chart	Shim Spacer	A/R
29	1C5-33	Drive Gear Spacing Sleeve	1

A/R = As Required

Shim Spacer Chart	
12C11-17A	Shim Spacer, .002 Thick
12C11-17B	Shim Spacer, .003 Thick
12C11-17C	Shim Spacer, .004 Thick
12C11-17D	Shim Spacer, .005 Thick
12C11-17E	Shim Spacer, .010 Thick

Item numbers are for reference only.
Please Specify PART NUMBER when
ordering replacement parts.



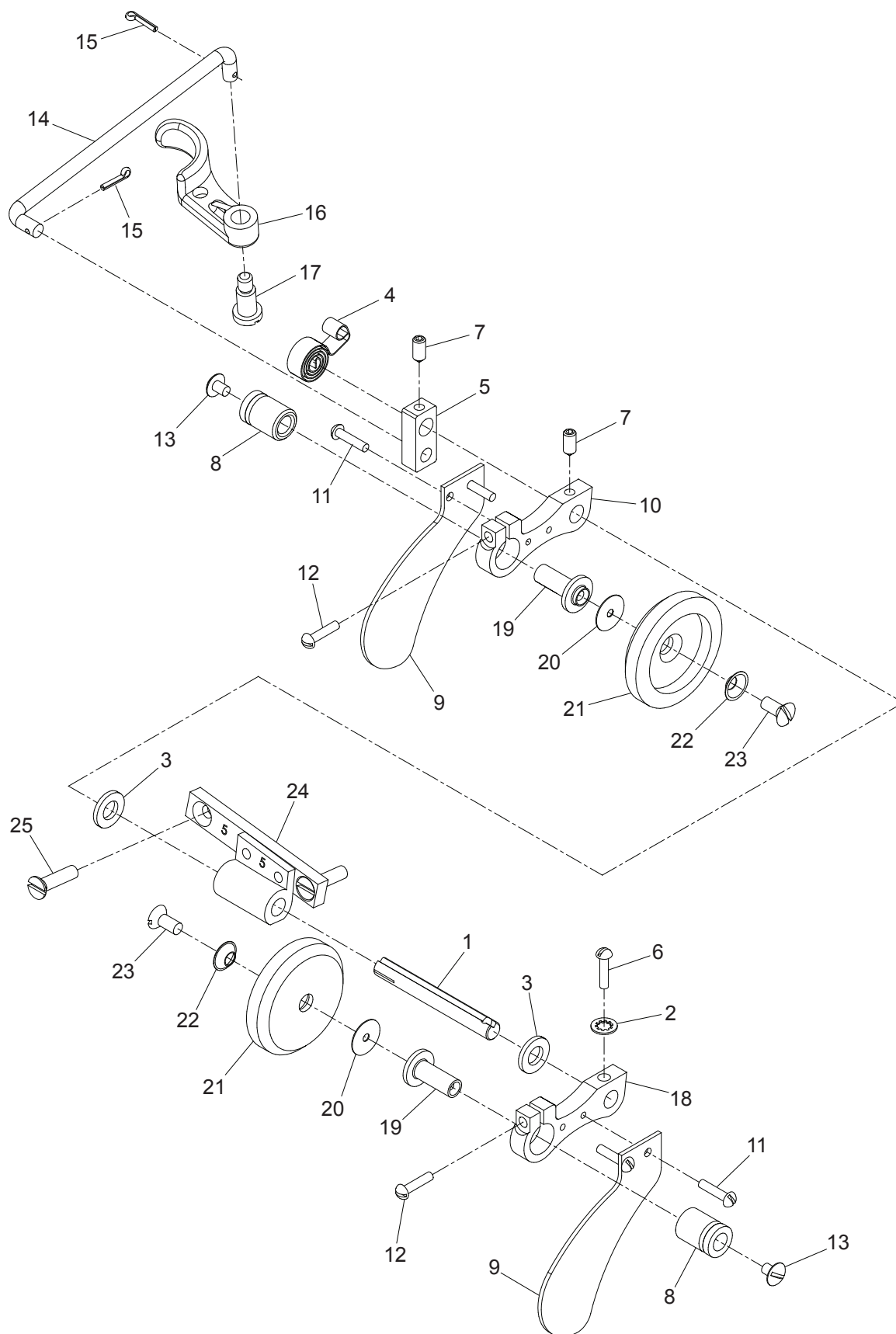
Eastman®

Sharpener Assembly

637C1-26

ITEM	PART NO.	DESCRIPTION	QTY.
1	11C10-19	Sharpener Shaft	1
2	12C1-21	Washer, Lock #8 Int.	1
3	12C15-29	Washer, Flat	2
4	34C1-20	Spring Tensioner	1
5	46C3-13	Block for Sharpening Arm	1
6	300C12-3	Scr. Round Hd. #8-32 x 3/8	1
7	309C12-3	Set Scr.8-32x3/16 Cone Point	2
8	20C6-11	Screw, Machined	2
9	25C4-161	Knife Guard, 548	2
10	35C5-57	Arm Sharpener, Left Hand	1
11	300C8-8	Scr. Round Hd. #4-40x5/16	2
12	300C10-5	Scr. Round Hd. #6-32x7/16	2
13	304C10-3	Scr. Truss Hd. #6-32x3/16	2
14	77C1-67	Connecting Link, Sharpener	1
15	17C15-71	Pin, Cotter 1/16x1/2	2
16	57C2-17	Sharpener Lever	1
17	20C8-2	Sharpener Arm Pivot Screw	1
18	35C5-65	Arm Sharpener, Right Hand	1
19	92C1-12	Spindle, Grinding Wheel	2
20	12C15-70	Washer, Paper	2
21	133C1-12	Grinding Wheel	2
22	12C1-28	Washer, Brass	2
23	20C13-20	Scr. Oval Hd. #8-32x3/8	2
24	636C1-9	Sharpener Bracket Assembly	1
25	302C12-3	Scr. Special #8-32x3/8 F.H.	2

Item numbers are for reference only.
Please Specify PART NUMBER when
ordering replacement parts.



Eastman®

Standard Assembly, Cardinal Round Knife 5"

ITEM	PART NO.	DESCRIPTION	QTY.
1	4C1-81	Knife Locknut	1
2	80C1-101	Knife 5"Ø, Thin, Single Bevel	*1
3	216C1-2	Thread Seal	1
4	4C1-114	Knife Gear Bearing Locknut	1
5	20C4-29	Knife Gear Bearing Screw	1
6	90C6-9	Ball Bearing	1
7	87C2-36	Knife Gear	1
8	12C9-8	SEE CHART	A/R
	12C9-7	SEE CHART	A/R
9	511C1-114	Standard & Plow BK5H	1
10	53C4-65	Gear Cover, 5H	1
11	300C12-7	Scr. Round Hd. #8-32x5/8	2
12	72C4-20	Gits Grease Cup	1
13	4C4	Knife Guard Bolt Nut	1
14	25C4-194	Side Guard, 5" CC & BK	1
15	24C6	Bolt, Knife Guard	1
16	17C1-4	No. 0 Taper Pin	2
17	4C1-111	Machine Handle Lock Nut	1
18	531C1-53	Handle Assembly	1

* = Not Included in Assembly

A/R = As Required

12C9-7

ITEM	PART NO.	DESCRIPTION	THK.	QTY
1	12C9-7 A	Washer Spacer (Shim)	.002	2
2	12C9-7 B	Washer Spacer (Shim)	.003	2
3	12C9-7 C	Washer Spacer (Shim)	.004	2
4	12C9-7 D	Washer Spacer (Shim)	.005	2
5	12C9-7 E	Washer Spacer (Shim)	.010	1
6	12C9-7 F	Washer Spacer (Shim)	.020	1

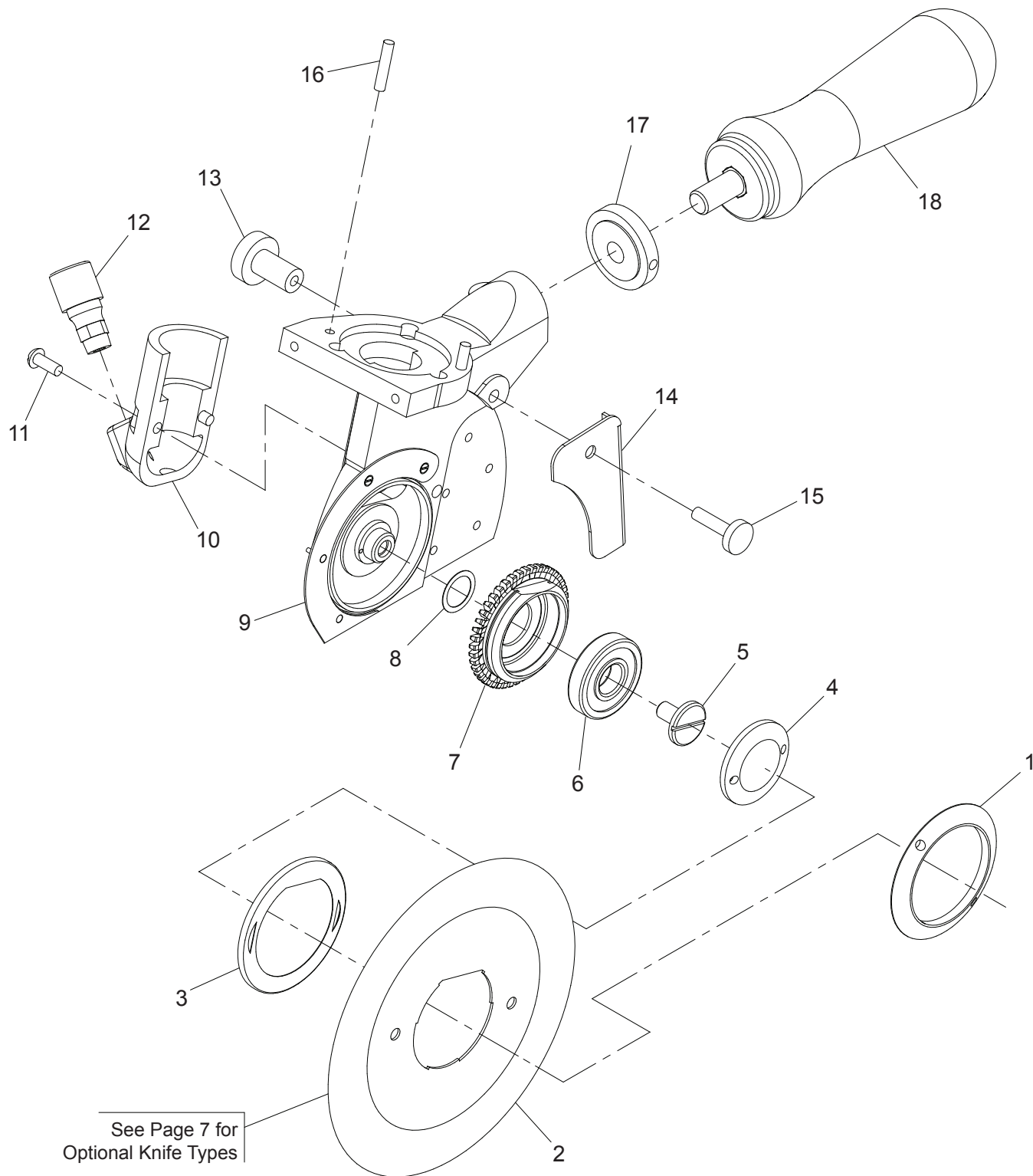
Kit Shim Rebuild 1.031 O.D. .729 I.D.

12C9-8

ITEM	PART NO.	DESCRIPTION	THK.	QTY
1	12C9-8 A	Washer Spacer (Shim)	.002	2
2	12C9-8 B	Washer Spacer (Shim)	.003	2
3	12C9-8 C	Washer Spacer (Shim)	.004	2
4	12C9-8 D	Washer Spacer (Shim)	.005	2
5	12C9-8 E	Washer Spacer (Shim)	.010	1
6	12C9-8 F	Washer Spacer (Shim)	.020	1

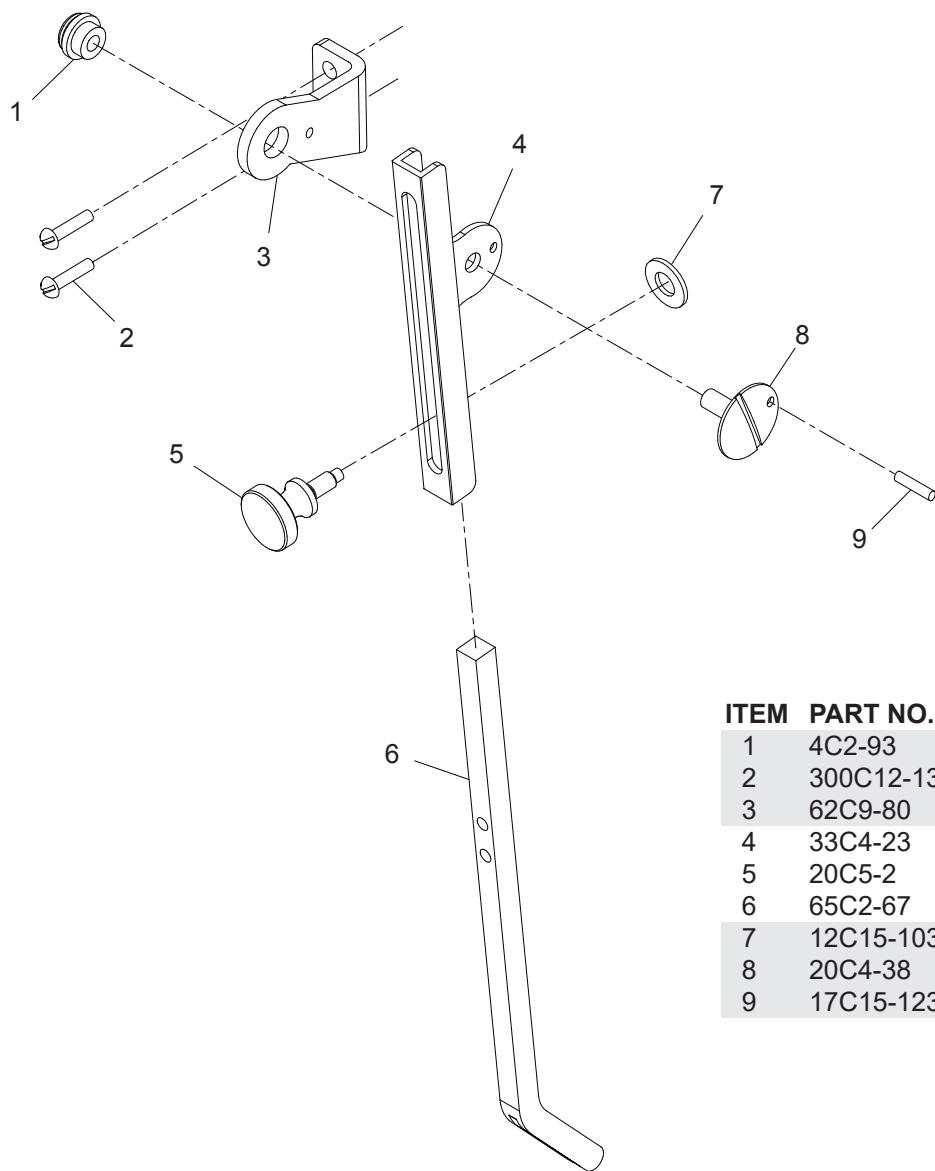
Kit Shim Rebuild .656 O.D. .484 I.D.

Item numbers are for reference only.
Please Specify PART NUMBER when
ordering replacement parts.



Press-Foot Attachment, Guard Assembly

510C2-55

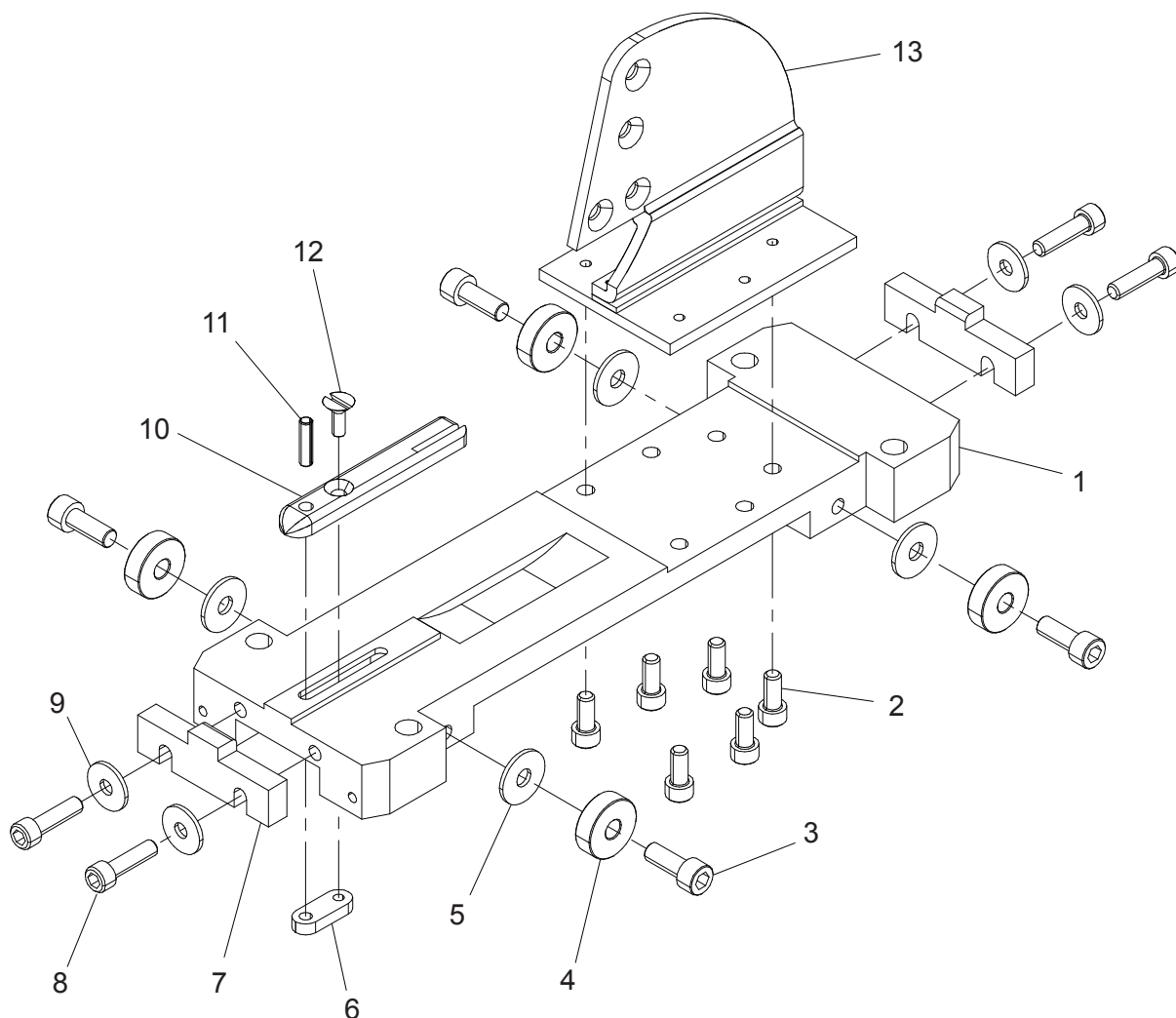


ITEM	PART NO.	DESCRIPTION	QTY.
1	4C2-93	Nut, Elastic Spline	1
2	300C12-13	Scr. Round Hd. #8-32x5/16	2
3	62C9-80	Bracket, Guard Rod Holder	1
4	33C4-23	Guard Rod Holder (4"-5 1/2")	1
5	20C5-2	Guard Rod Screw	1
6	65C2-67	Rod Knife Guard (5"-6")	1
7	12C15-103	Washer, Flat	1
8	20C4-38	Guard Rod Screw	1
9	17C15-123	Pin, Roll 3/32x5/16	1

Item numbers are for reference only.
Please Specify PART NUMBER when
ordering replacement parts.

Base Plate Assembly

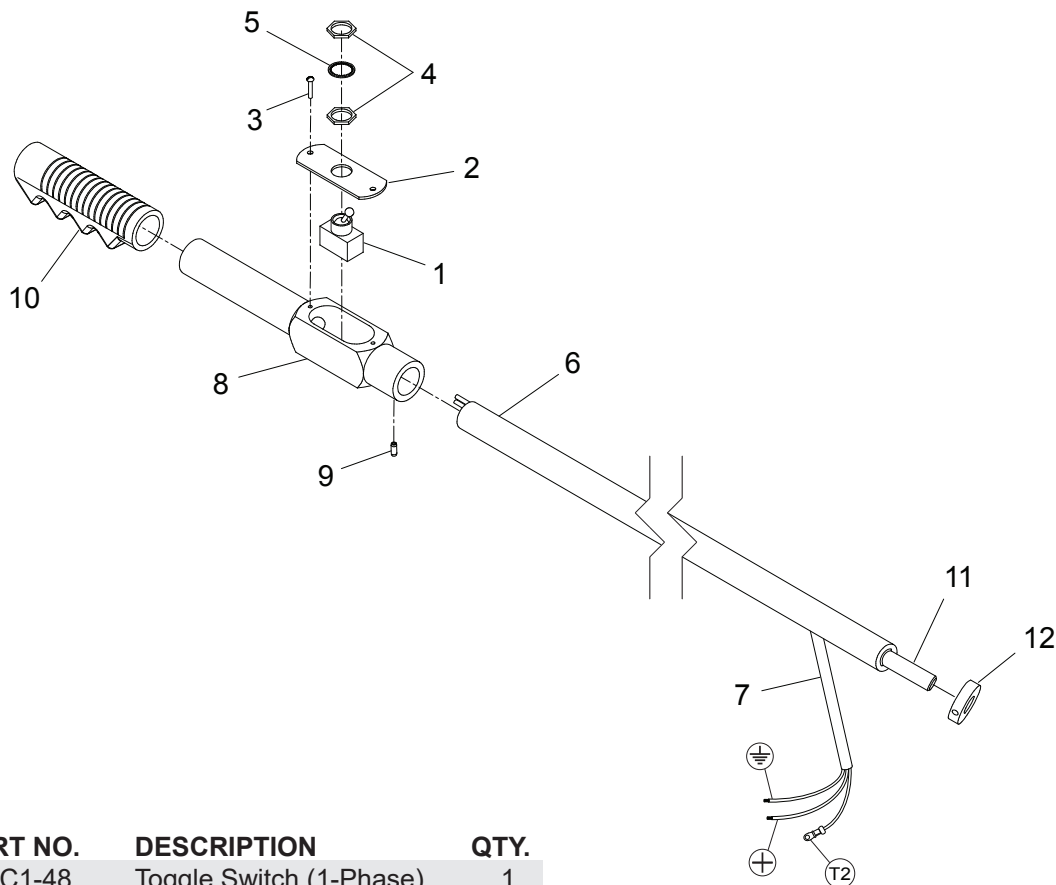
505C2-108



ITEM	PART NO.	DESCRIPTION	QTY.
1	59C3-136	Roller Base, HD Falcon	1
2	308C12-1	Scr. Skt. Hd.Cap #8-32x3/8	6
3	308C15-2	Scr. Skt. Hd.Cap #10-32x1/2	4
4	90C6-42	Bearing Ball	4
5	12C1-49	Washer, Lock #10 Flat	4
6	46C3-34	Block 534 FAL	1
7	70C4-61	Track Guide, HD Falcon	2
8	300C12-7	Scr. Round Hd. #8-32x5/8	4
9	12C1-21	Washer, Lock #8 Int.	4
10	79C5-266	Plate Throat 534 FAL	1
11	17C15-126	Pin, Roll 1/8x1/2	1
12	302C10-5	Scr. Flat Hd. #6-32x3/8	1
13	505C2-100	Base Plate Brkt. 534/548 5H	1

Eastman®

Push Handle Assembly, with Switch 827C1-28



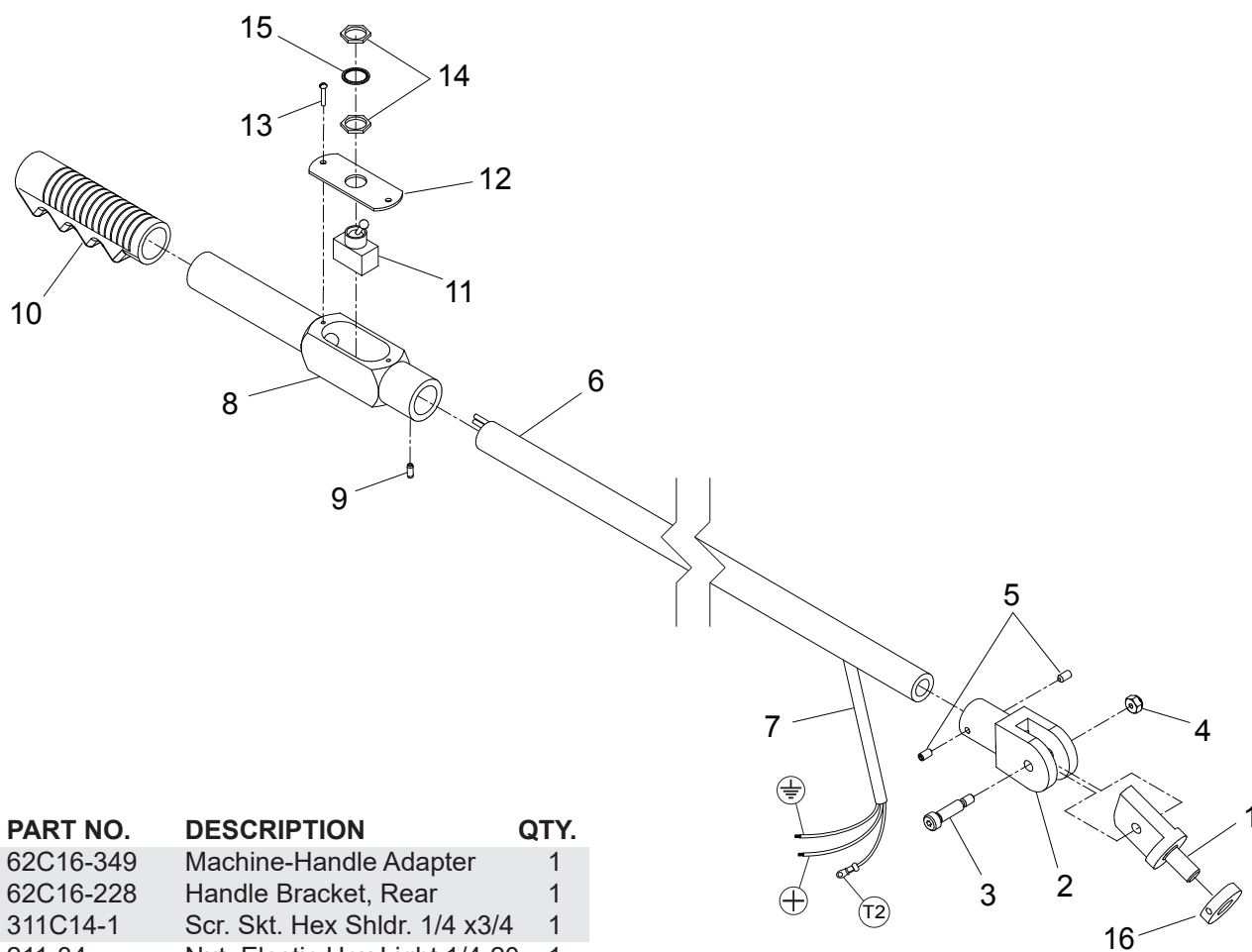
ITEM	PART NO.	DESCRIPTION	QTY.
1	580C1-48	Toggle Switch (1-Phase)	1
	580C1-193	Toggle Switch (3-Phase)	
2	52C5-176	Base Switch Cover Plate	1
3	300C8-9	Scr. Round Hd. #4-40x3/16	2
4	4C2-116	Hex Nut for Toggle Switch	2
5	12C1-34	Lock Washer, 15/32 Int.	1
6	73C7-146-MS	Tube Handle, Aluminum	*
7	C19-520 W	Vinyl Tube, Size 1-B (3)	A/R
8	531C2-3	Handle Asm. - FAL 534, 548	1
9	511-6-12	Roll Pin, .187Ø x .750 Long	1
10	14C1-23	Grip Handle, Plastic	1
11	15C1-8	Stud, Machine Handle	1
12	4C1-115	Locknut Handle	1

* MS = Machine Size

* A/R = As Required

Item numbers are for reference only.
Please Specify PART NUMBER when
ordering replacement parts.

RK Push Swivel Handle Assembly 531C1-96



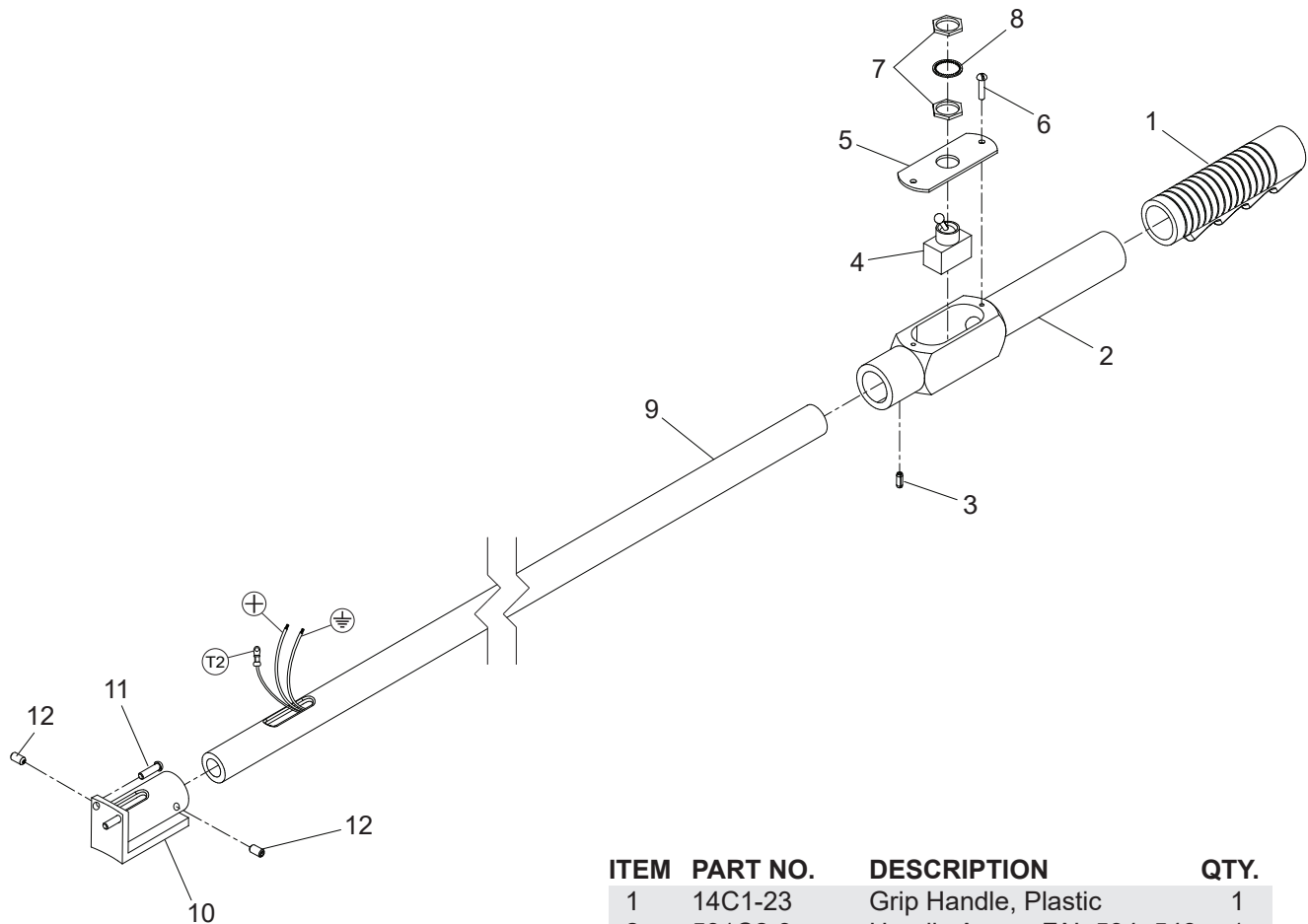
ITEM	PART NO.	DESCRIPTION	QTY.
1	62C16-349	Machine-Handle Adapter	1
2	62C16-228	Handle Bracket, Rear	1
3	311C14-1	Scr. Skt. Hex Shldr. 1/4 x3/4	1
4	211-34	Nut, Elastic Hex Light 1/4-20	1
5	309C12-2	Set Scr. Skt. Hex #8-32x5/16	2
6	73C7-221-MS	RK Push Swivel Handle	*
7	C19-520 W	Vinyl Tube, Size 1-B (3)	A/R
8	531C2-3	Handle Asm. - FAL 534, 548	1
9	511-6-12	Roll Pin, .187Ø x .750 Long	1
10	14C1-23	Grip Handle, Plastic	1
11	580C1-48	Toggle Switch (1-Phase)	1
	580C1-193	Toggle Switch (3-Phase)	
12	52C5-176	Base Switch Cover Plate	1
13	300C8-9	Scr. Round Hd. #4-40x3/16	2
14	4C2-116	Hex Nut for Toggle Switch	2
15	12C1-34	Lock Washer, 15/32 Int.	1
16	4C1-115	Locknut Handle	1

* MS = Machine Size

* A/R = As Required

Eastman®

Pull Handle Assembly, with Switch **827C1-15-MS**



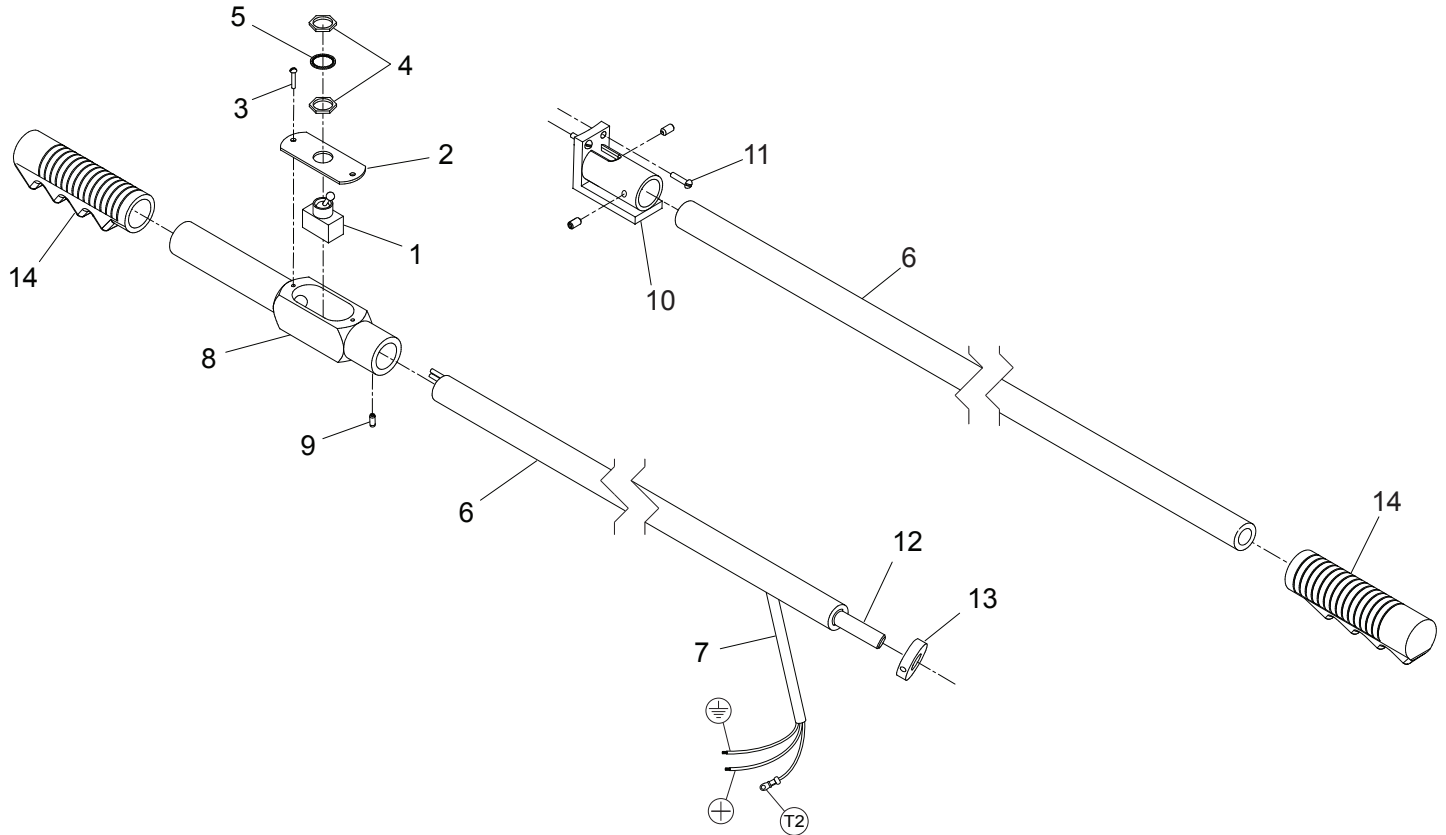
ITEM	PART NO.	DESCRIPTION	QTY.
1	14C1-23	Grip Handle, Plastic	1
2	531C2-3	Handle Asm. - FAL 534, 548	1
3	511-6-12	Roll Pin, .187Ø x .750 Long	1
4	580C1-48	Toggle Switch (1-Phase)	1
	580C1-193	Toggle Switch (3-Phase)	
5	52C5-176	Base Switch Cover Plate	1
6	300C8-9	Scr. Round Hd. #4-40x3/16	2
7	4C2-116	Hex Nut for Toggle Switch	2
8	12C1-34	Washer, Lock 15/32 Int.	1
9	73C7-146-MS	Tube Handle, Aluminum	*
10	827C1-6	Handle Bracket, 534 BK 4TC	1
11	300C14-4	Scr. Round Hd. #10-24x1/2	2
12	309C12-2	Screw,Socket Set #8-32x5/16	2

* MS = Machine Size

Item numbers are for reference only.
Please Specify PART NUMBER when
ordering replacement parts.

Push/Pull Handle Assembly

820C1-127-MS



ITEM	PART NO.	DESCRIPTION	QTY.
1	580C1-48	Toggle Switch (1-Phase)	1
	580C1-193	Toggle Switch (3-Phase)	
2	52C5-176	Base Switch Cover Plate	1
3	300C8-9	Scr. Round Hd. #4-40x3/16	2
4	4C2-116	Hex Nut for Toggle Switch	2
5	12C1-34	Lock Washer, 15/32 Int.	1
6	73C7-146-MS	Tube Handle, Aluminum	*2
7	C19-520 W	Vinyl Tube, Size 1-B (3)	A/R
8	531C2-3	Handle Asm. - FAL 534, 548	1
9	511-6-12	Roll Pin, .187Ø x .750 Long	1

ITEM	PART NO.	DESCRIPTION	QTY.
10	827C1-6	Handle Bracket, 534 BK 4TC	1
11	300C14-4	Scr. Round Hd. #10-24x1/2	2
12	15C1-8	Stud, Machine Handle	1
13	4C1-115	Locknut Handle	1
14	14C1-23	Grip Handle, Plastic	2

* MS = Machine Size

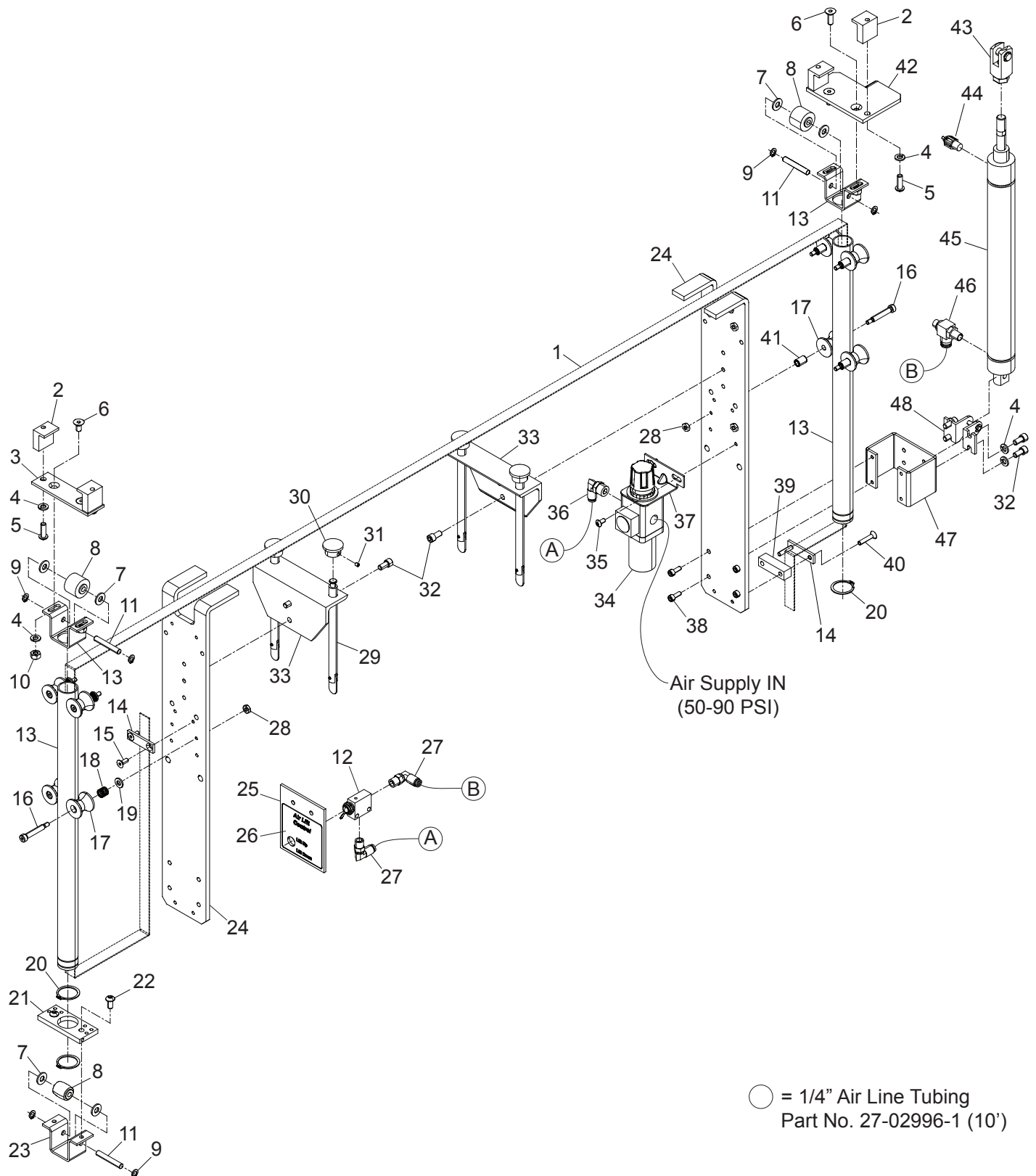
* A/R = As Required

Eastman®

Air Lifter Assembly 840C1-7

ITEM	PART NO.	DESCRIPTION	QTY.	ITEM	PART NO.	DESCRIPTION	QTY.
1	181C4 S	Falcon Belt, (Varying Lengths)	1	26	236C1-176	Decal, Air Lift Control, HD	1
2	46C3-51	Clamp Block, HD Falcon	4	27	100-13-7	Male Elbow Swivel 1/4 x 1/8"	2
3	79C12-426	Clamp Plate, HD Falcon	1	28	4C2-104	Nut, Machined Hex #10-24	8
4	402-34	Washer, Lock 1/4	12	29	773C1	Screw Clamp Assembly	4
5	333-34-12	Scr. Skt. Btn. Hd. 1/4-20x3/4	4	30	191C2-1	Pad Swivel, Lift	4
6	332-34-8	Scr. Skt. Flat Hd. 1/4-20x1/2	4	31	342-93-3	Set Scr. Skt. Hex 8-32x3/16	4
7	12C15-108	Washer, Flat 1/4	6	32	335-34-8	Scr. Socket Hd. 1/4-20x1/2	8
8	41C5-14	Belt Roller, Lift	2	33	205C1-2	Angle Bracket, HD Falcon	2
9	18C6-47	Retaining Ring, Lift Grip	6	34	100-18-2	Filter Regulator	1
10	203-34	Nut, Finishing, Hex 1/4-20	4	35	332-102-6	Scr. Skt. Hd. Flat #10-32x3/8	2
11	11C2-54	Belt Roller Shaft	3	36	100-13-2	Male Elbow Swivel 1/4 x 1/4"	1
12	67-26115-1	Valve, 4 Way - 5 Port, Switch	1	37	100-19-9	Mounting Bracket, Regulator	1
13	763C1-27	Tube Lift Assembly	2	38	335-102-8	Scr. Socket Hd. #10-32x1/2	4
14	33C10-59	Belt Holder, Lift	2	39	55C4-117	Spacer Belt Bias	1
15	332-102-8	Scr. Skt. Flat Hd. #10-32x1/2	2	40	332-102-16	Scr. Skt. Hd. Flat #10-32x1	2
16	311C14-2	Scr. Hex Skt. Shldr. 1/4x1 1/4	8	41	55C4-118	Spacer Roller	4
17	70C4-45	Guide Roller	8	42	79C11-7	Track Mount, Air Lift HD Fal.	1
18	34C1-63	Spring, .453 OD x 7/16 FL	4	43	275C4-2	Piston Rod Clevis	1
19	12C11-84	Washer, Nylon 1/4 OD x 1/16	4	44	251C3-2	1/8 Npt Speed Control Muffler	1
20	18C6-65	Retaining Ring, Lift	3	45	275C1-6	1 1/4" Bore, 9" Stroke Cyl.	1
21	35C7-35	Spring Arm Bias	1	46	251C3-4	Flow Control	1
22	333-34-8	Scr. Skt. Btn. Hd. 1/4-20x1/2	2	47	79C11-8	Cylinder Mount, Air Lift Control	1
23	62C16-265	Bracket Pulley Bias	1	48	275C4-1	Pivot Brkt. for 1 1/4 Bore Cyl.	1
24	79C12-295	Mounting Plate, Bias Track	2				
25	54-26156-1	Bracket, Valve, 4-Way	1				

Item numbers are for reference only.
Please Specify PART NUMBER when
ordering replacement parts.



Eastman®

HD Falcon Lifter Assembly - Manual

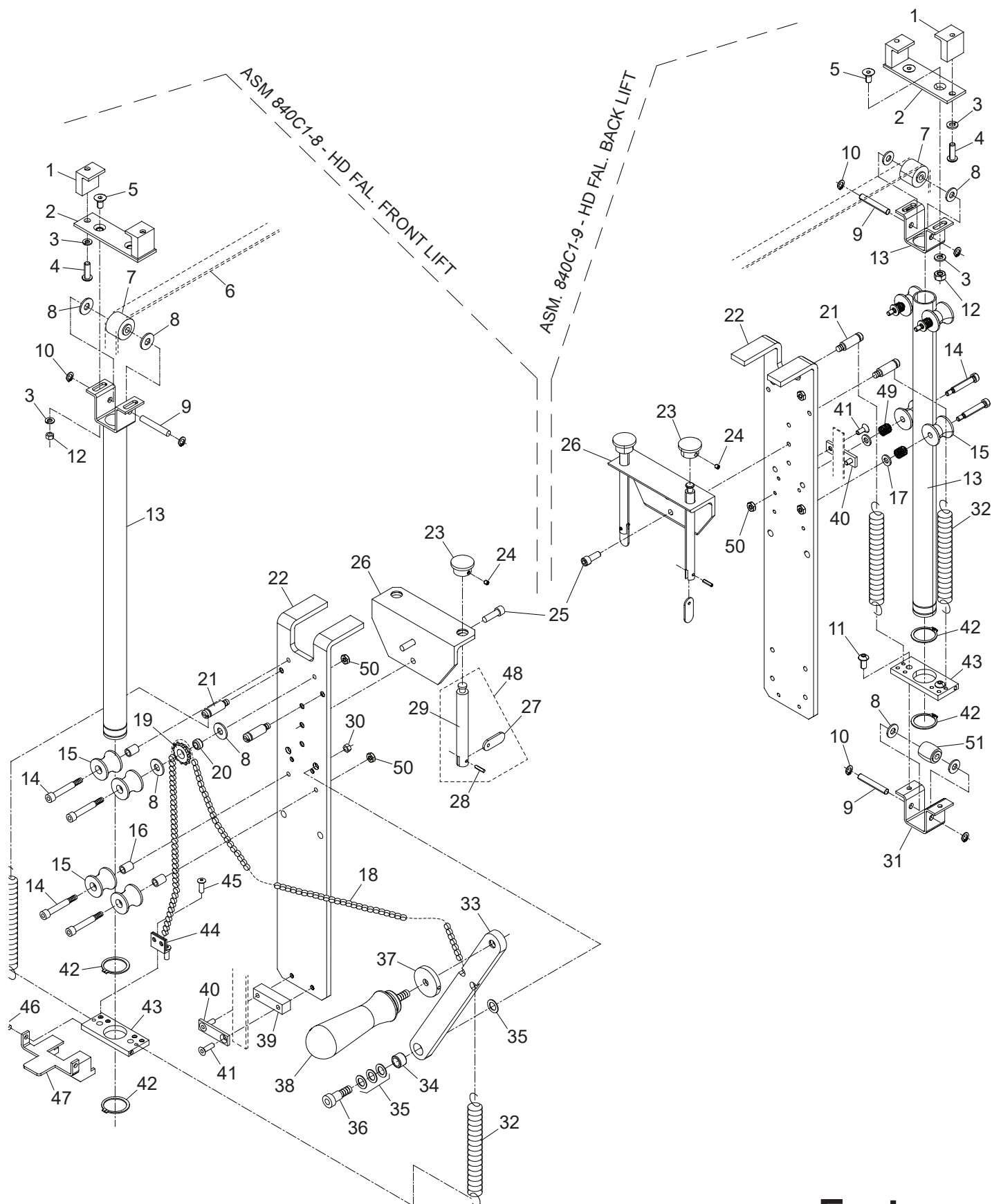
840C1-7

ITEM	PART NO.	DESCRIPTION	QTY.
1	46C3-51	Clamp Block	4
2	79C12-426	Clamp Block Plate	2
3	12C1-19	Washer, Lock 1/4	8
4	307C18-1	Scr. Button Hd. 1/4-20 x 3/4	4
5	302C18-2	Scr. Flat Hd. 1/4-20 x 1/2	4
6	181C4	Lift Belt	A/R
7	41C5-14	Belt Roller	2
8	12C15-108	Washer, Flat	8
9	11C2-54	Roll Shaft	3
10	18C6-47	Grip Ring	6
11	307C18-1	Scr. Button Hd. 1/4-20x3/4	4
12	4C2-58	Nut, Hex 1/4-20	4
13	763C1-27	Lift Tube Assembly	2
14	311C14-2	Scr. Shoulder 1/4x1 1/4	8
15	70C4-45	Guide Roller	8
16	55C4-118	Roller Spacer	3
17	12C11-84	Washer, Nylon	4
18	701-25	Chain, Roller #25	1
	702-25	Chain, Link Connecting #25	3
	703-25	Half Link, Connecting #25	1
19	278C1-6	Sprocket, 1/4p-12t	1
20	90C6-71	Bearing, 1/4" I.D.	1
21	15C13-59	Stud, Lift Spring	4
22	79C12-295	Lift Frame	2
23	191C2-1	Swivel Pad	4
24	20C13-4	Setscrew, #8-32 x 3/16	4
25	308C18-9	Scr. Socket Hd. 1/4-20x1/2	4

ITEM	PART NO.	DESCRIPTION	QTY.
26	205C1-2	Angle Bracket	2
27	57C7-49	Lever	4
28	17C15-126	Roll Pin	4
29	20C5-22	Clamp Screw	4
30	4C2-102	Nut, Hex 5/16-18	1
31	62C16-265	Bracket Pulley Bias	1
32	34C10-181	Extension Spring	4
33	57C4-10	Lift Lever, Standard	1
	57C4-10A	Lift Lever, Extended	1
34	90C6-72	Bearing, 3/8" I.D.	1
35	12C15-123	Washer, Nylon 3/8" I.D.	4
36	311C14-6	Screw, Shoulder, 3/8 x 1/2	1
37	4C1-111	Handle Locknut	1
38	531C1-53	Lift Handle	1
39	55C4-117	Belt Spacer	1
40	33C10-59	Belt Holder	2
41	302C15-7	Scr. Flat Hd. #10-32 x 1	4
42	18C6-65	Retaining Ring	4
43	35C7-35	Lift Plate	2
44	205C1-3	Chain Angle	1
45	307C15-2	Scr. Button Hd. #10-32x1/2	2
46	308C15-2	Scr. Socket Hd. #10-32x1/2	2
47	171C1-24	Locking Bracket	1
48	773C1	Screw Clamp Assembly	4
49	34C1-63	Spring, .453 OD x 7/16 FL	4
50	4C2-104	Nut, Machined Hex #10-24	8
51	41C5-15	Belt Roller, Lower	1

A/R = As Required

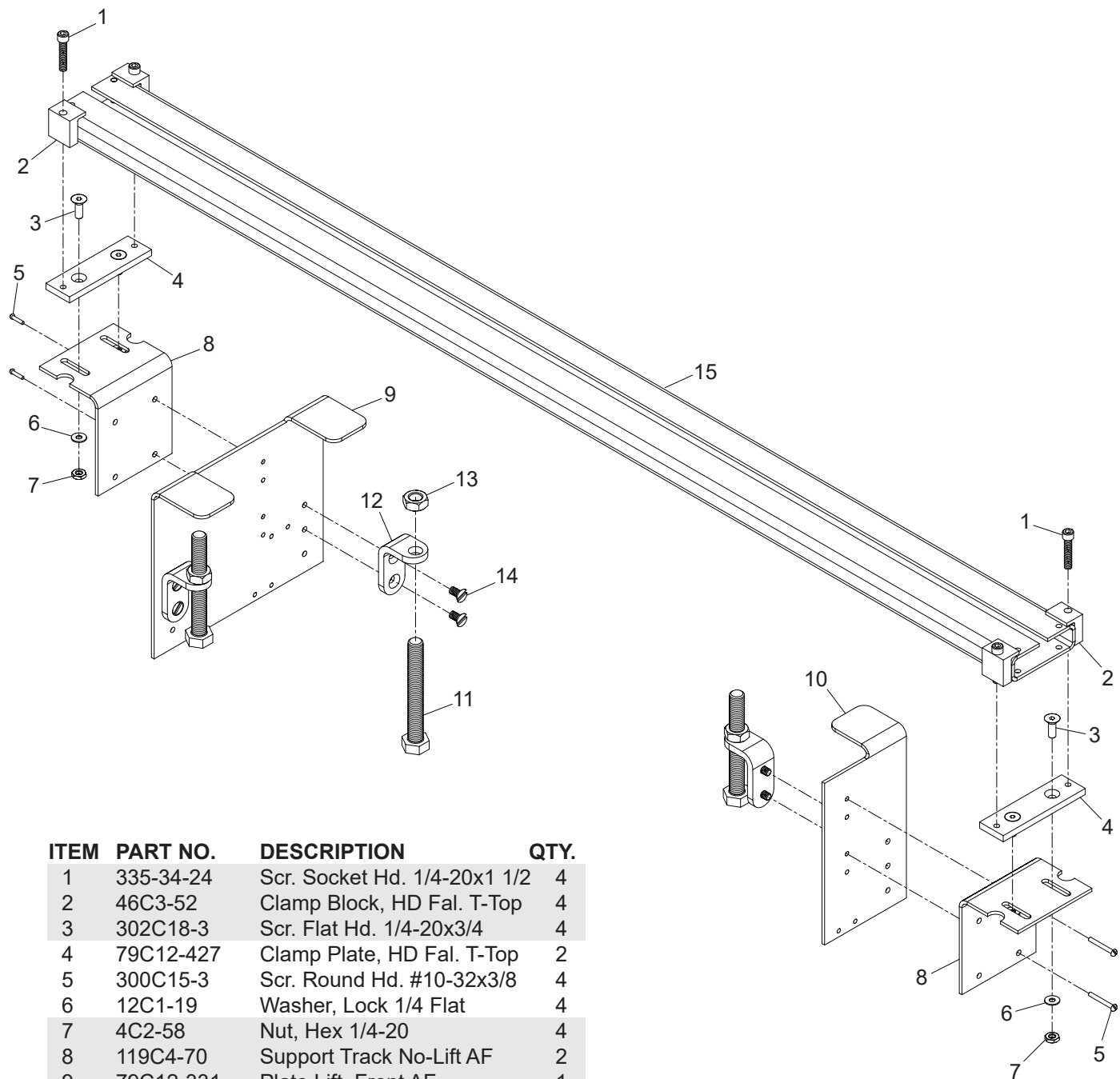
Item numbers are for reference only.
Please Specify PART NUMBER when
ordering replacement parts.



Eastman®

No-Lift, Bracket Mount, H.D. FAL. Assembly

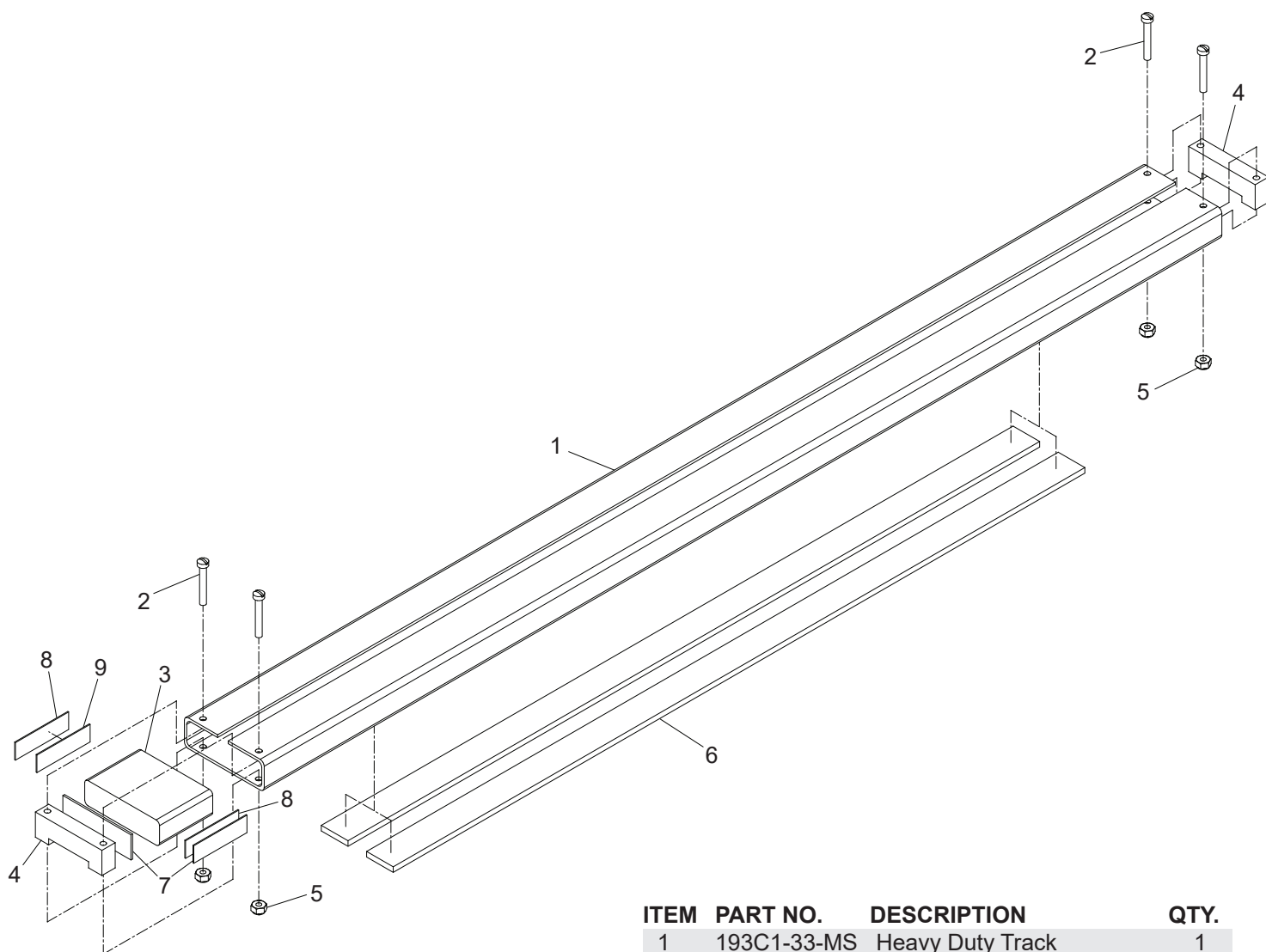
833C2-9



ITEM	PART NO.	DESCRIPTION	QTY.
1	335-34-24	Scr. Socket Hd. 1/4-20x1 1/2	4
2	46C3-52	Clamp Block, HD Fal. T-Top	4
3	302C18-3	Scr. Flat Hd. 1/4-20x3/4	4
4	79C12-427	Clamp Plate, HD Fal. T-Top	2
5	300C15-3	Scr. Round Hd. #10-32x3/8	4
6	12C1-19	Washer, Lock 1/4 Flat	4
7	4C2-58	Nut, Hex 1/4-20	4
8	119C4-70	Support Track No-Lift AF	2
9	79C12-331	Plate Lift, Front AF	1
10	79C12-321	Plate Lift, Rear AF	1
11	310C28-1	Scr. Hex Hd. 1/2-13x4 Full Thd.	3
12	50C11-34	Clamp Base, Lift	3
13	206-43	Nut, Jam Hex 1/2-13	3
14	302C18-2	Scr. Flat Hd. 1/4-20x1/2	6
15	823C1-55-MS	HD Track Assembly	1

HD Track Assembly

823C1-55-MS



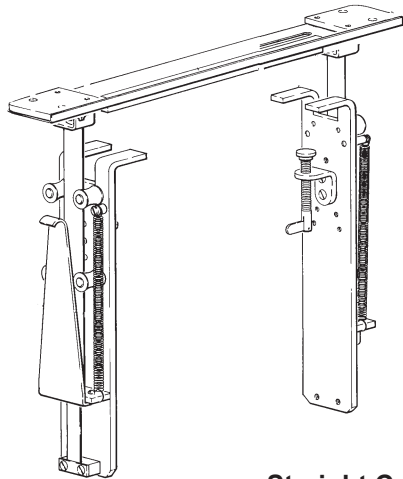
ITEM	PART NO.	DESCRIPTION	QTY.
1	193C1-33-MS	Heavy Duty Track	1
2	301C15-7	Scr. Fillister Hd. #10-32x1/4	4
3	45C2-2	Bumper, Rubber, 2"x2"x.75"	1
4	67C6-9	Stop Block, HD Track	2
5	4C1-149	Nut, Elastic Hex #10-32	4
6	211C1-2	Tape for Misc Track	A/R
7	211C1-17	Double-Sided Tape 1/32" Thk.	A/R
8	211C1-16	Stop Tape, Ruff Top Surface	A/R

MS = Machine Size
A/R = As Required

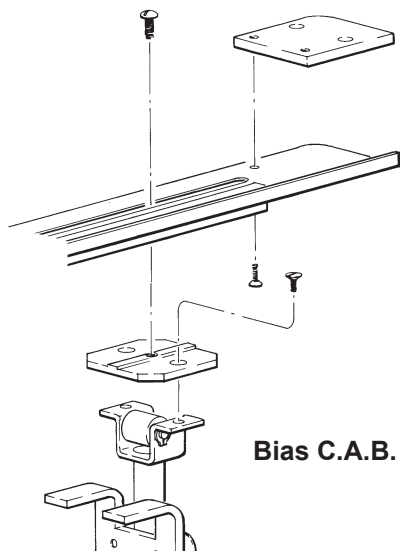
Item numbers are for reference only.
Please Specify PART NUMBER when
ordering replacement parts.

Eastman®

Cloth Alignment Bar & Lifter Assembly FALZB041



Straight C.A.B.



Bias C.A.B.

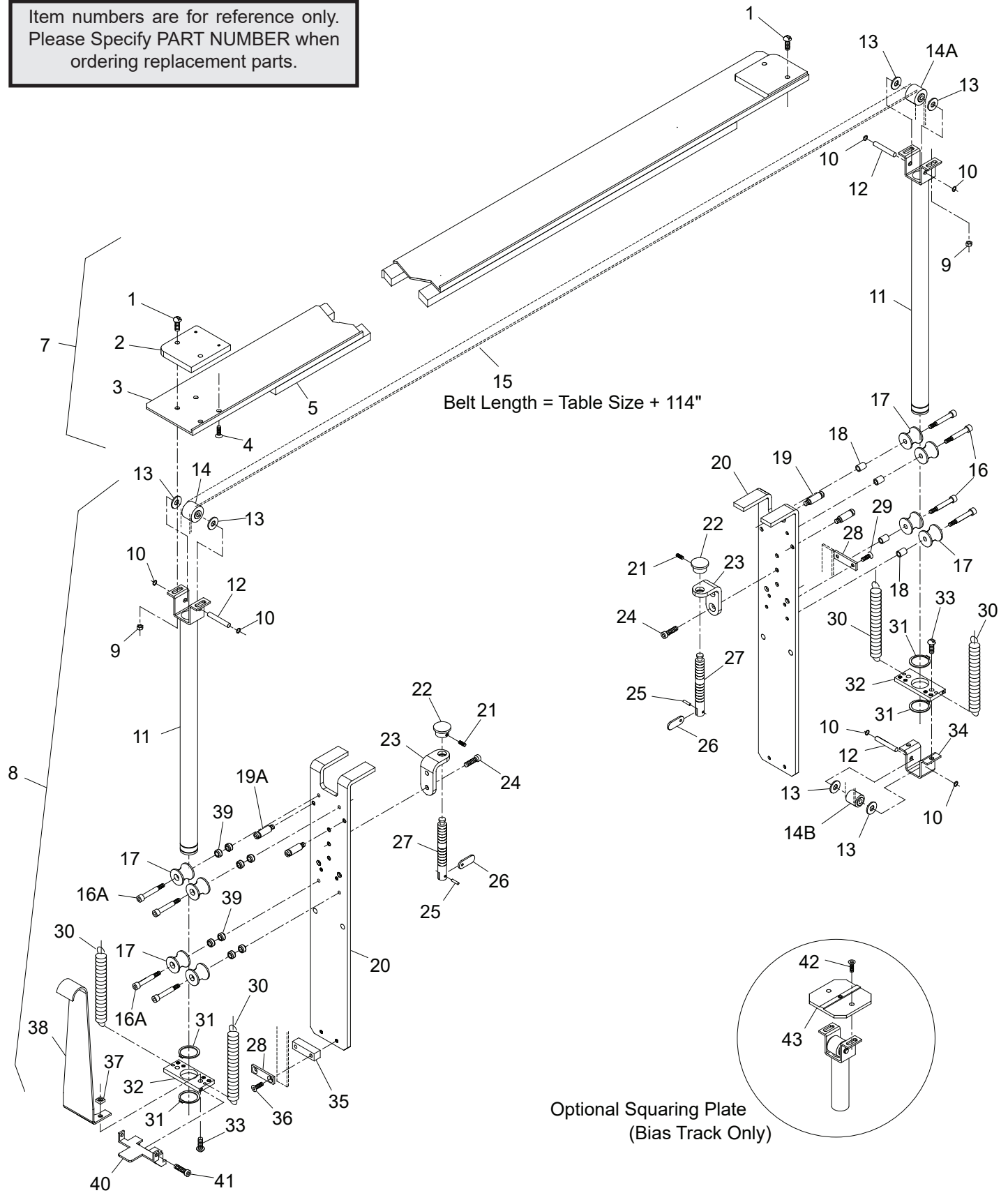
A/R - As Required

TS - Table Size

Please specify Table Width when ordering

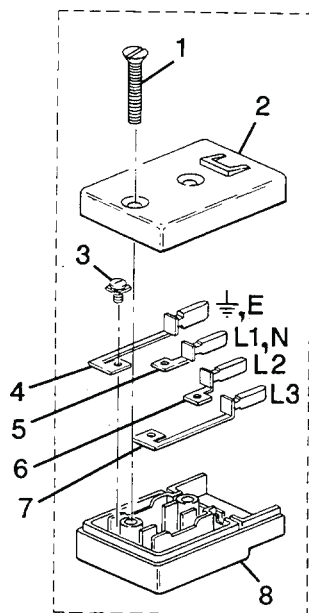
ITEM	PART NO.	DESCRIPTION	QTY.
1	300C18-4	Screw, Round Head 1/4-20 x 5/8	*8
2	136C1-24	Bar Weight	2
3	78C3-2	Cloth Alignment Bar	1
	78C3-5	Cloth Alignment Bar, Bias cut only	1
4	302C10-10	Screw, Flat Head #6-32 x 7/16	8
5	211C1-2	Foam Tape	A/R
7	839C1-1	CAB Assembly	1
	839C2-1	Bias CAB Assembly	1
8	840C1-2	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

Item numbers are for reference only.
Please Specify PART NUMBER when
ordering replacement parts.

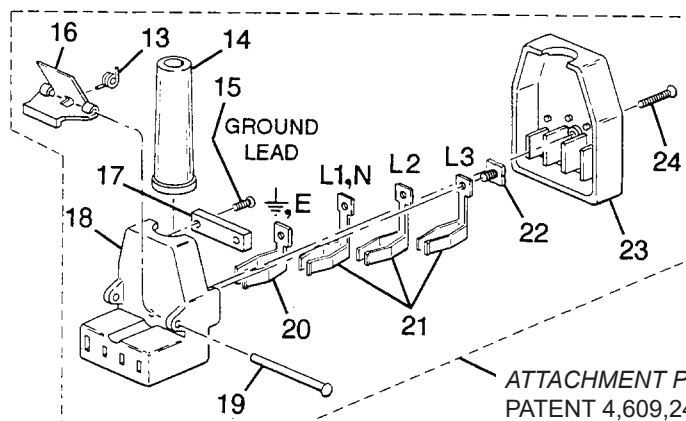


Eastman®

Electrical Connections



TERMINAL BLOCK
PATENT 4,609,244
508C1-100 SHOWN



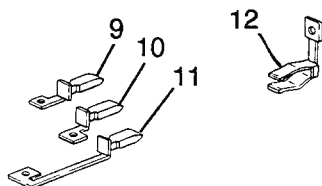
ATTACHMENT PLUG
PATENT 4,609,244
523C1-100 SHOWN

WARNING

Electrical connections to this machine must be made by a qualified electrician ONLY. Failure to follow applicable codes and regulations and conduct a ground lead to terminal "E" on the attachment plug may result in serious personal injuries.

For user safety, connect a ground lead to terminal "E" on the attachment plug.

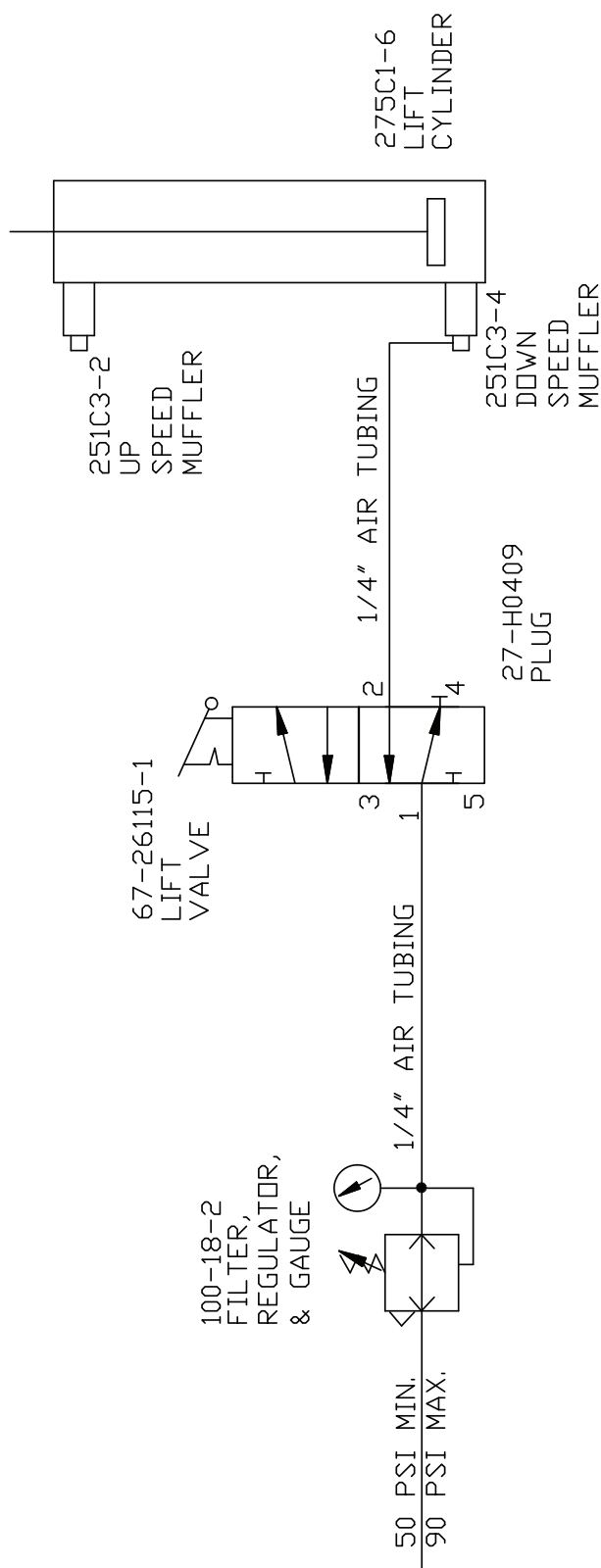
Always unplug the machine before performing maintenance, adjustment or repairs.



ITEM PART NO. DESCRIPTION

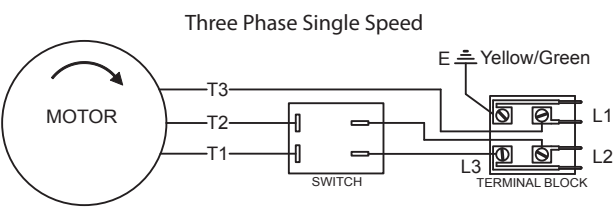
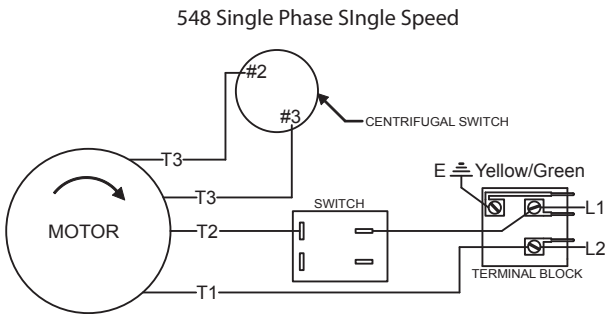
			EASTMAN 10A 380V 3~	EASTMAN 10A 220V 3~	EASTMAN 10A 220V ~	EASTMAN 15A 120V ~	EASTMAN 25A 42V ~
			E, N L1, L2, L3	E, N L1, L2, L3	E, N L1, L2	E, N L1, L2	E, N L1, L3
1	302C15-8	Screw, 10-32 x 1 1/8 Flat Hd.	2	2	2	2	2
2	-----	Terminal Block Top	51C1-63	51C1-64	51C1-65	51C1-66	51C1-67
3	20C13-103	U-Lock Screw	4	4	3	3	3
4	667C1-22	Terminal Contact w/Pin E	1	1	1	1	1
5	667C1-23	Terminal Contact w/pin L1, N	1	1	1	--	--
6	667C1-24	Terminal Contact w/Pin L2	1	1	--	1	--
7	667C1-25	Terminal Contact w/Pin L3	--	1	--	--	1
8	51C1-61	Terminal Block Bottom	1	1	1	1	1
9	667C1-26	Terminal Contact w/Pin L1, N	--	--	--	1	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	--	1	1	1
13	34C10-170	Spring	1	1	1	1	1
14	1C13-27	Cord Sleeve	1	1	1	1	1
15	300C8-2	Screw, 4-40 x 1/2 Round Hd.	2	2	--	--	2
16	98C4-37	Thumb Clip	1	1	1	1	1
17	50C7-27	Cord Clamp	1	1	1	1	1
18	-----	Attachment Plug Body	82C1-45	82C1-46	82C1-47	82C1-48	82C1-49
19	91C4-22	Rivet	1	1	1	1	1
20	47C3-19	Terminal Sleeve	1	1	1	1	1
21	47C3-20	Terminal Sleeve (current)	2	3	1	1	1
22	20C13-103	U-Lock Screw	4	4	3	3	3
23	-----	Attachment Plug Cover	53C3-19	53C3-20	53C3-21	53C3-22	53C3-23
24	302C8-8	Screw, 4-40 x 7/8 Flat Hd.	1	1	1	1	1
25	-----	Terminal Block Complete	508C1-99	508C1-100	508C1-101	508C1-102	508C1-103
26	-----	Attachment Plug Complete	523C1-99	523C1-100	523C1-101	523C1-102	523C1-103

Pneumatic Air Lift Diagram



CAUTION
Disconnect and Relieve
Air Pressure before servicing

Wiring Diagrams



Technical Data

EASTMAN® 548 Falcon HD End Cutter

Cardinal 5" HD Track Cutter:	
Cutting Head.....	Model 548
Weight.....	21 lbs. (9.52kg)
Horsepower.....	.34 hp, 1 ph / .48 hp, 3 ph
Blade Size.....	4" (10.2cm) / 5-1/4" (13.3cm)
Cutting Capacity.....	2-1/8" (5.40cm) / 3-1/8" (7.95cm)
Motors.....	110v, 1 ph / 220v, 1 ph / 220v, 3 ph
Sharpeners Stone Grits.....	120 Heavy; 150 Medium; 220 Fine
Standard Blade.....	Carbon Steel
Optional Blades.....	Double Bevel, Teflon Coated, High Speed Steel, Slotted, Grooved
Single Speed.....	Standard (Dual Speed Not Avail.)
Track Size.....	36" (91.44cm) to 157" (398.78cm)
Cloth Alignment Bar.....	Optional

Limited Warranty. Eastman warrants to the buyer that the Falcon HD End Cutter shall be free from defects in materials or workmanship for a period of 365 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 365-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 allocated 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.