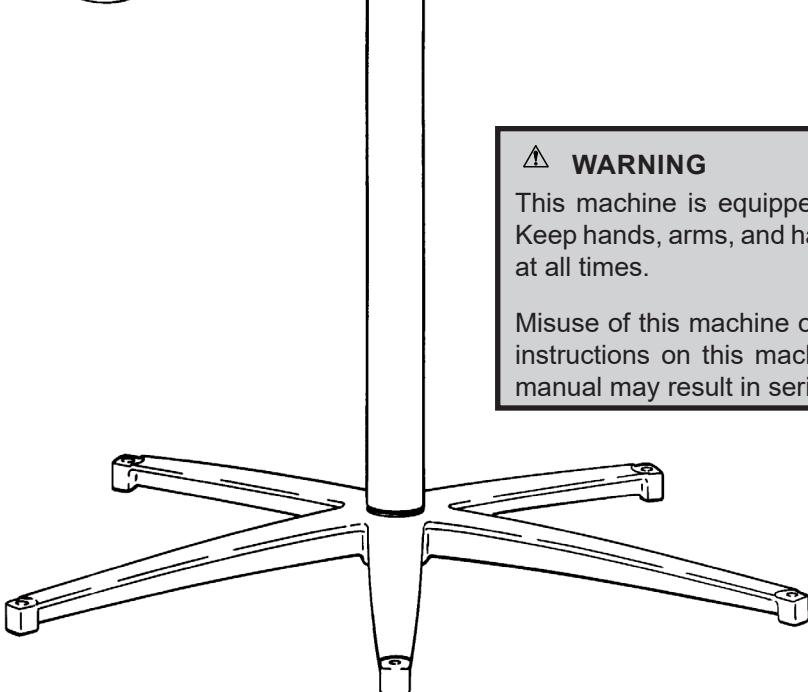
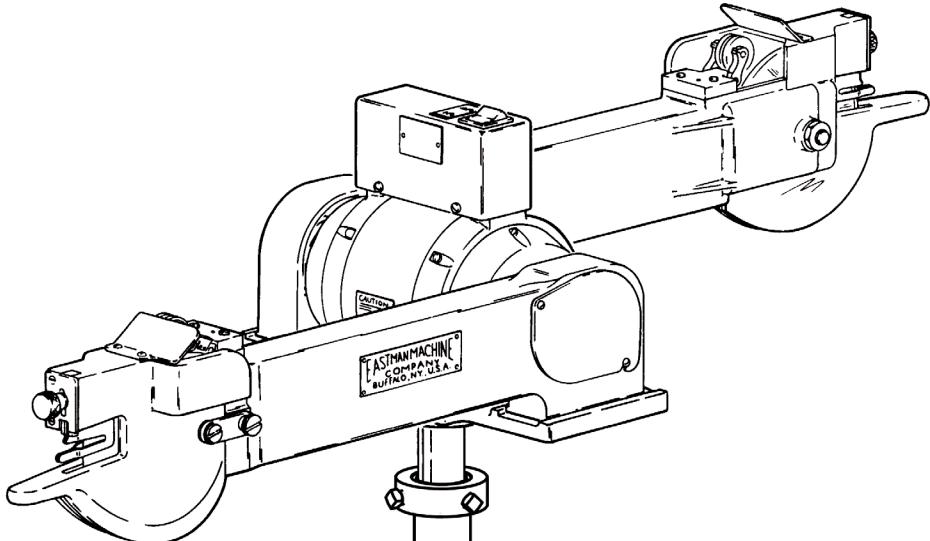


Eastman®

# Rag Cutter

MODEL WE



**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 BOOK AND PARTS LIST

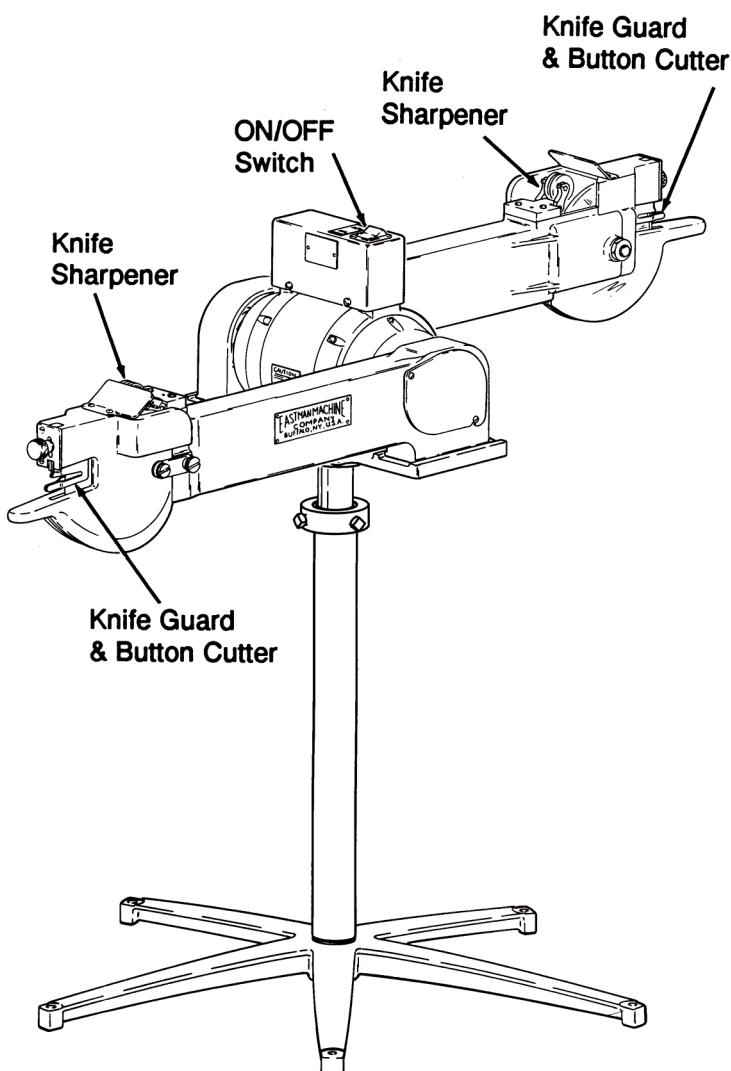
Eastman®

779 Washington St., Buffalo, N.Y. 14203-1396 U.S.A. • (716)856-2200 • Fax (716)856-1140 or (716)856-2068

# Operation, Lubrication And Care

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

The purchaser must instruct all operators on the proper use of the equipment. All standard industrial safety measures and equipment should be provided to protect the operator. Operators must be cautioned that improper use of this equipment can cause bodily injury. If you do not have qualified operators to instruct new persons, contact your Eastman sales representative or write to Eastman Machine factory direct.



## CAUTION

Read instructions carefully before starting motor. Be sure that voltage and current are the same as stamped on nameplate. This machine is equipped with sharp blade and extreme caution should be used when this machine is put into use. Use control levers and handles only when operating machine. When making a cut, the knife guard should be raised only enough to clear the material being cut. When machine is not in operation the knife guard should be kept in the lowered position. When this equipment is not being utilized, the power cord should be disconnected from the power source.

Your Eastman Rag Cutter is shipped partially disassembled with all the necessary parts for set up and operation. Before any operation can take place the installation procedure must be followed.

## INSTALLATION

Remove all parts from boxes and spread out in work area to begin assembly procedure. Place the stand on the floor and firmly secure the threaded end of the pipe support to the stand, see stand assembly on page 14 of this manual.

After the pipe support and the stand are assembled the motor and base can be mounted. Place the motor base on the top of the adjusting rod. Insert adjusting rod into the motor base, with flat side on rod to line up with setscrew on base. Secure setscrew in base.

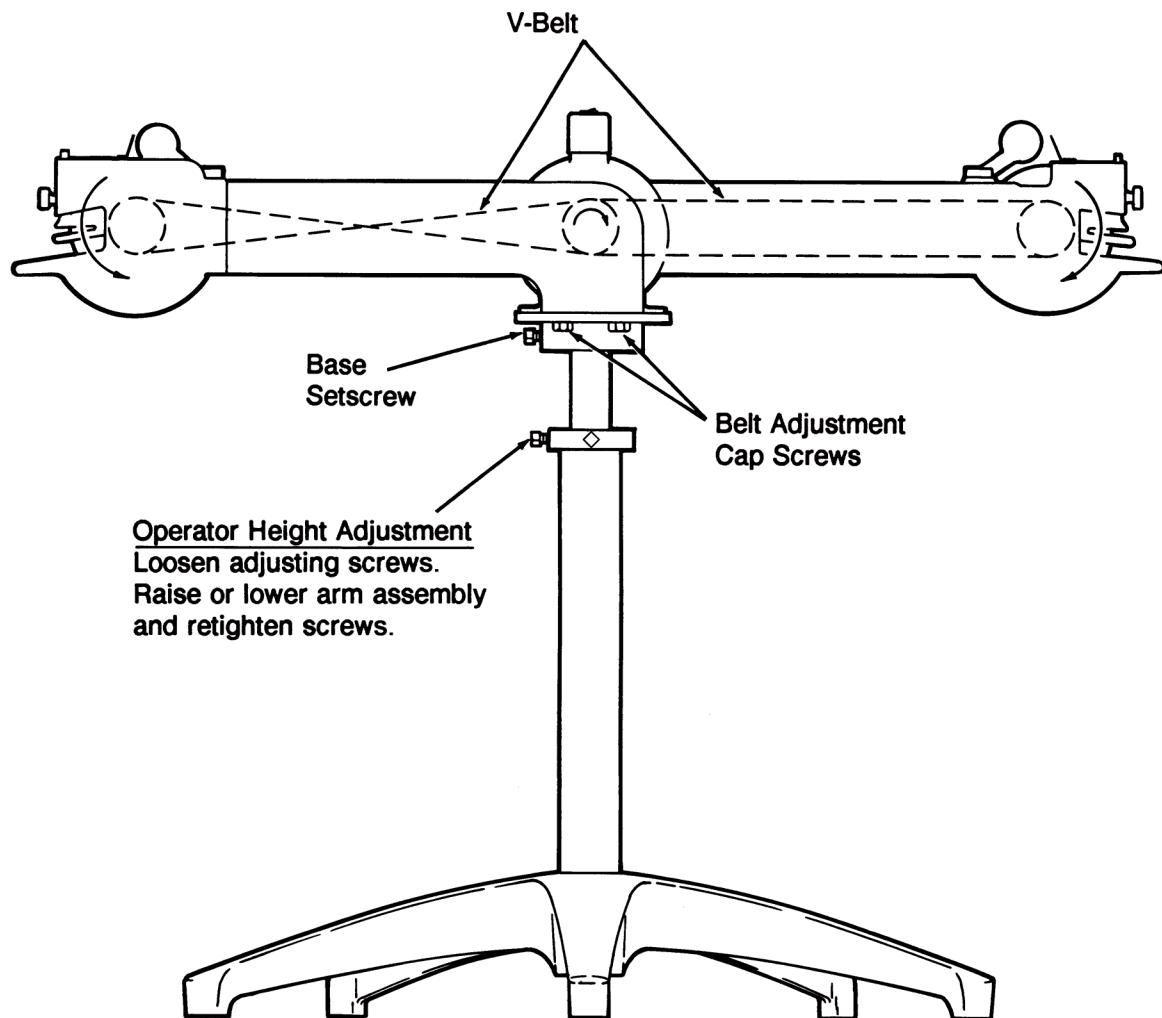
To assemble arms to motor base, first match color on bottom of arm to color on motor base. Remove two (2) cap screws from arm assembly. Place V-belt on motor pulley and mount arm assembly onto motor base with cap screws loosely secured (the V-belt for the red color must first be twisted for proper rotation of blade). Pull arm forward, just enough to prevent belt from slipping, and tighten cap screws. See diagram below for proper belt configuration.

**NOTE:** Belts appear to be excessively loose because of the V-belt and pulley configuration. To check for proper tension; deflection should be measured at the center of either arm and measure 2 1/2" (6.25 cm.) from the bottom upward.

#### CAUTION

Check direction of knife when fully assembled. Be sure cutting edge of knife moves in downward direction. If knife moves in upward direction loosen cap screws and push arm back to release tension on belt. Remove side pulley cover. Remove belt from motor pulley end twist belt and replace on motor pulley. Pull arm forward and tighten cap screws. Replace belt cover and check for proper belt tension. Adjust belt tension if necessary.

After machine is assembled and operating properly the Rag Cutter machine should now be secured to floor. Five 3/8" screws are required to properly fasten the stand to the floor.

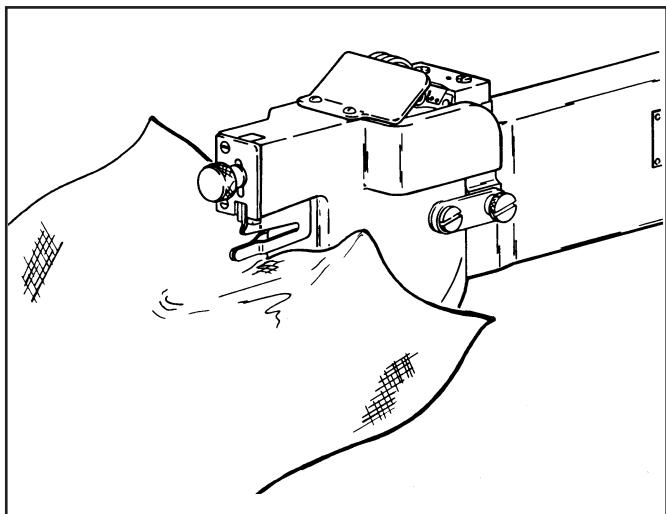


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## OPERATING INSTRUCTIONS

Loosen thumb screw for adjustment of knife guard. Raise guard enough to clear material to be cut and tighten thumb screw.

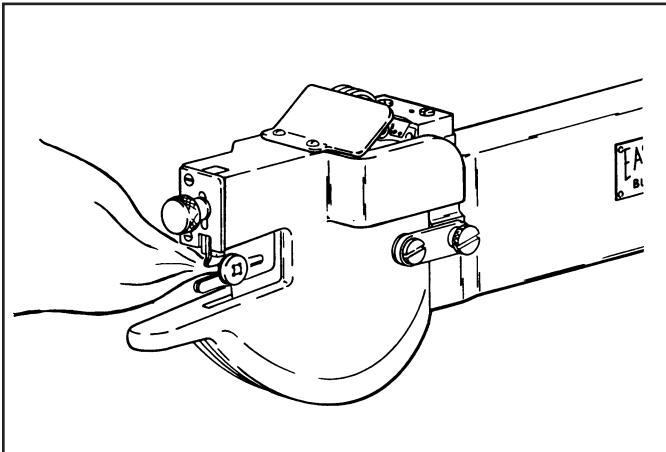
Switch machine to ON position, if cutter does not start immediately, return switch to OFF position. Check the line output and be sure the power cord is plugged in properly and is making full contact. Then repeat procedure. After knife has gathered full speed, material can now be cut.



To remove buttons, place button in slot on knife guard and slide cloth back into blade as shown.

### ⚠ CAUTION

When cutting material and removing buttons extreme caution must be used as machine is equipped with sharp blade.



## MAINTENANCE PROCEDURES

**WARNING:** Before performing any of the following procedures, disconnect power cord from power source.

Use air hose or bellows with proper eye shields and blow lint out of knife guard and sharpener twice a week. Remove knife guard and clear out lint around knife and pulley assembly once a week. To prevent undue accumulation of lint, do not oil bearings or pulley.

## LUBRICATION

Oil emery wheel spindles twice daily with specially compounded Eastman oil (242C1). Do not use an excess amount of oil. Motor and pulley bearings are grease sealed and require no lubrication.

## KNIFE SHARPENING

Remove material to be cut from machine. Switch machine to on position. To obtain a fine, keen edge on blade, press lightly on sharpener lever with a constant pressure. Hold lever until blade is sharp (10 seconds), then release.

## KNIFE REPLACEMENT

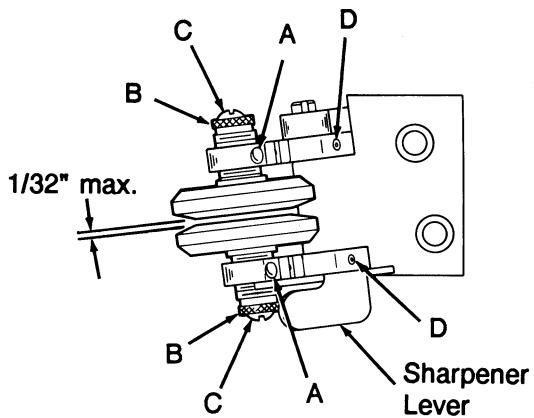


SPANNER WRENCH  
95C1-13

REMOVAL PIN  
17C11

Loosen thumb screw and pull guard forward off arm. Insert knife Removal Pin (17C11) into hole in knife pulley to prevent knife from turning. Remove knife locknut with the special Spanner Wrench (95C1-13), furnished with machine. When installing a new knife, be sure the name Eastman Machine Company is facing outward. Secure knife locknut. Install guard onto arm and tighten thumb screw. Refer to page 11 for replacement knives.

**⚠ CAUTION:** Discard used sharp knives with care.



**CAUTION:** Discard used sharp knives with care!

#### EMERY WHEEL ADJUSTMENT

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

To adjust, loosen slotted head screws "A". With fingers, turn adjusting bushings "B" 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. Tighten slotted head screws "A".

#### EMERY WHEEL REPLACEMENT

With front of machine facing serviceman, knife guard in down safe position, remove right hand grinding wheel and arm by loosening setscrew "D" and sliding arm off shaft. Remove slotted head screw "C" and replace grinding wheel with spindle in right hand arm. Do not remove left hand arm from machine. Remove slotted head screw "C" from left hand arm and replace grinding wheel with spindle. Re-assemble right hand arm to shaft and adjust wheels to knife as described above. Refer to page 12 for replacement of Emery Wheels.

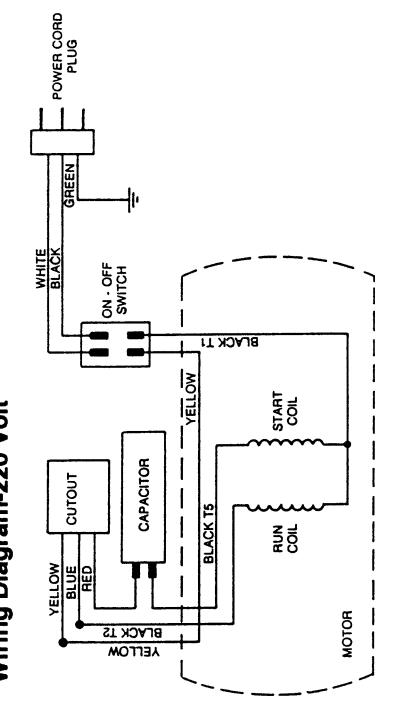
#### BELT REPLACEMENT AND ADJUSTMENT

With power cord disconnected remove knife. Loosen two (2) screws on pulley cover and swing cover out of way. Loosen two (2) belt adjustment cap screws and move arm back toward motor. Remove old V-belt.

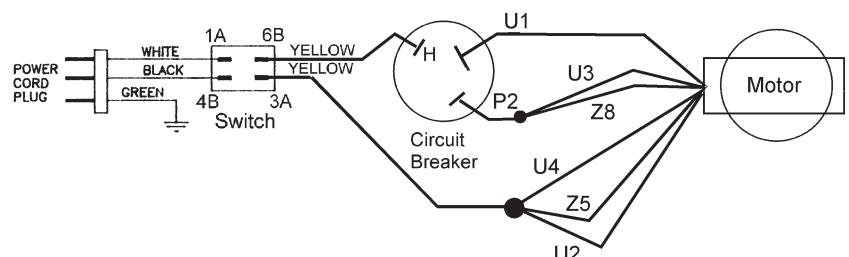
Install new V-belt. Pull arm forward enough to prevent belt from slipping, then tighten cap screws. Check tension of belt. The belt should measure 2 1/2" (6.25 cm.) up from the bottom center of arm. Replace pulley cover and secure screws. Replace knife and guard.

**CAUTION**

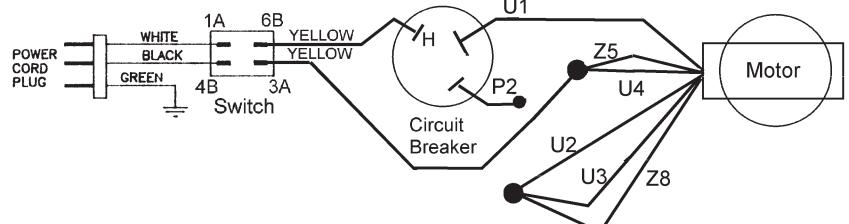
Check knife direction. Knife must move in downward direction. If not, remove belt from motor pulley, twist belt and replace belt on motor pulley.



#### Wiring Diagram -110 Volt (1/2hp Only)

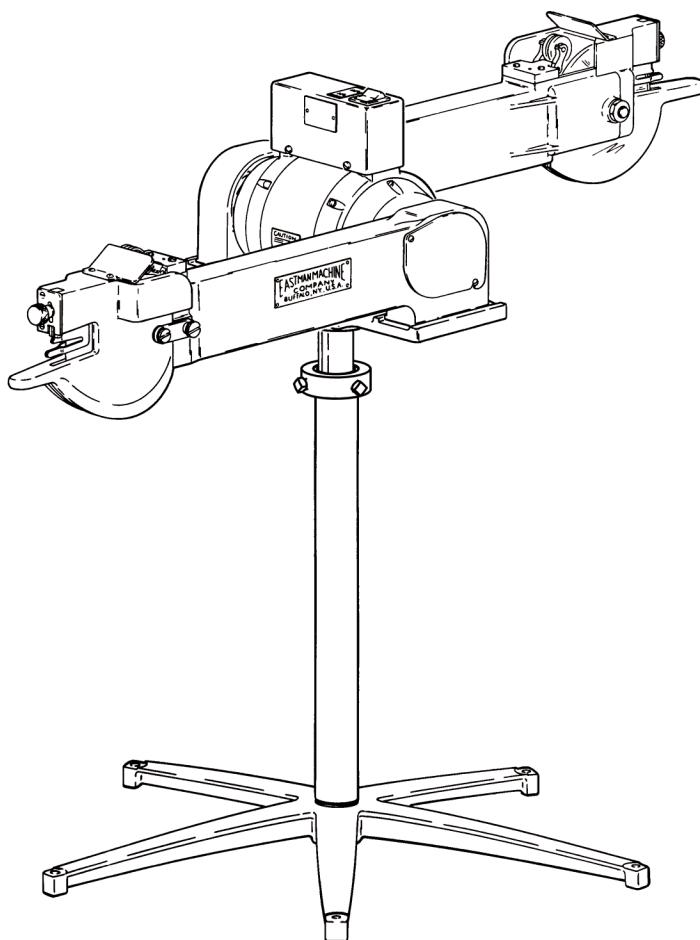


#### Wiring Diagram -220 Volt (1/2hp Only)



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## Illustrated Parts List



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

**IMPORTANT:** machine model and serial number  
Always specify when ordering parts for faster more efficient service.

### **Index** **EXPLODED PARTS ILLUSTRATIONS**

The exploded parts illustrations and parts lists in this section have been divided into major assemblies as follows:

Knife Replacement .....	Page 4
Emery Wheel Replacement .....	Page 5
Motor & Control Box Assembly .....	Page 8
Single & Double Arm Assembly .....	Page 10
Sharpener Assembly .....	Page 12
Stand Assembly .....	Page 14

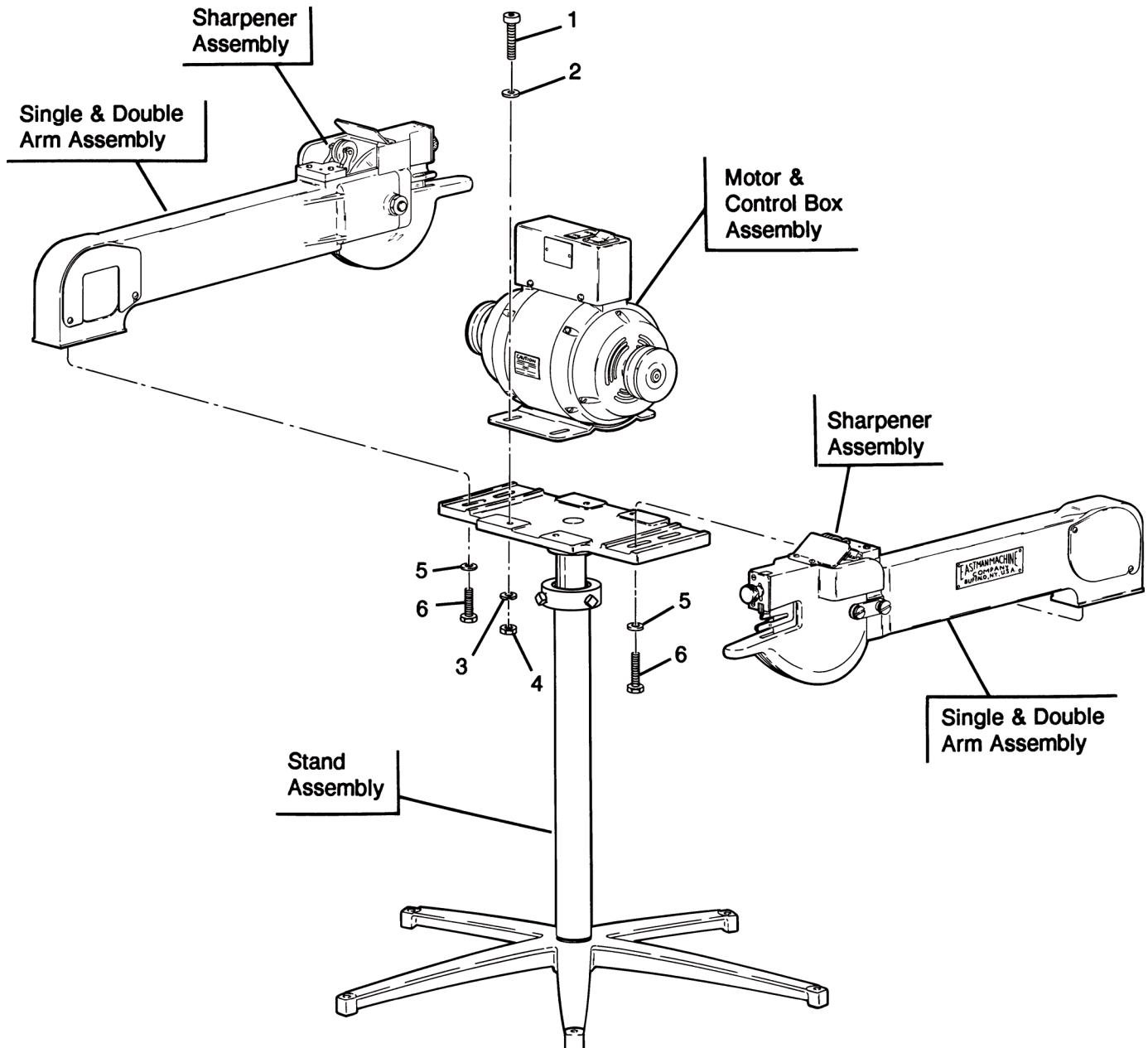
**NOTE:** Three different abrasive Emery Wheel grits (designed to provide you with a selection of edges) may be ordered for this machine. See page 12 of this manual for more information.

ITEM	PART NO.	DESCRIPTION	QTY.
1	20C13-1	Screw, Hex Head Cap 5/16-18 x 1 1/4	4
2	12C15-46	Washer, Flat 5/16	4
3	12C15-85	Washer, Lock 5/16	4
4	4C2-103	Nut, Hex 5/16-18	4
5	12C15-46	Washer, Flat 5/16	4
6	20C13-12	Screw, Hex Head Cap 5/16-18 x 1	4

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

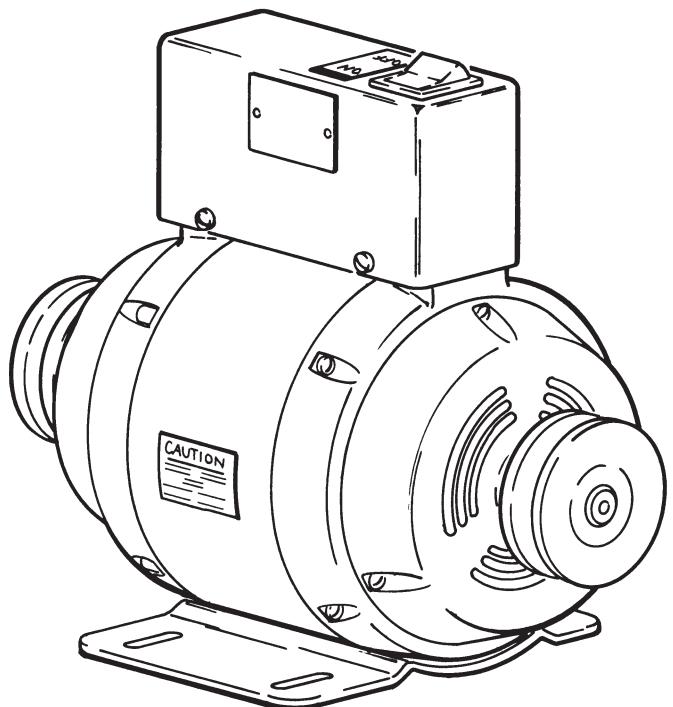
Item numbers are for reference only.

Please specify PART NUMBERS when ordering replacement parts.



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## Motor Assembly & Control Box Illustrated Parts List



### Motor Assembly

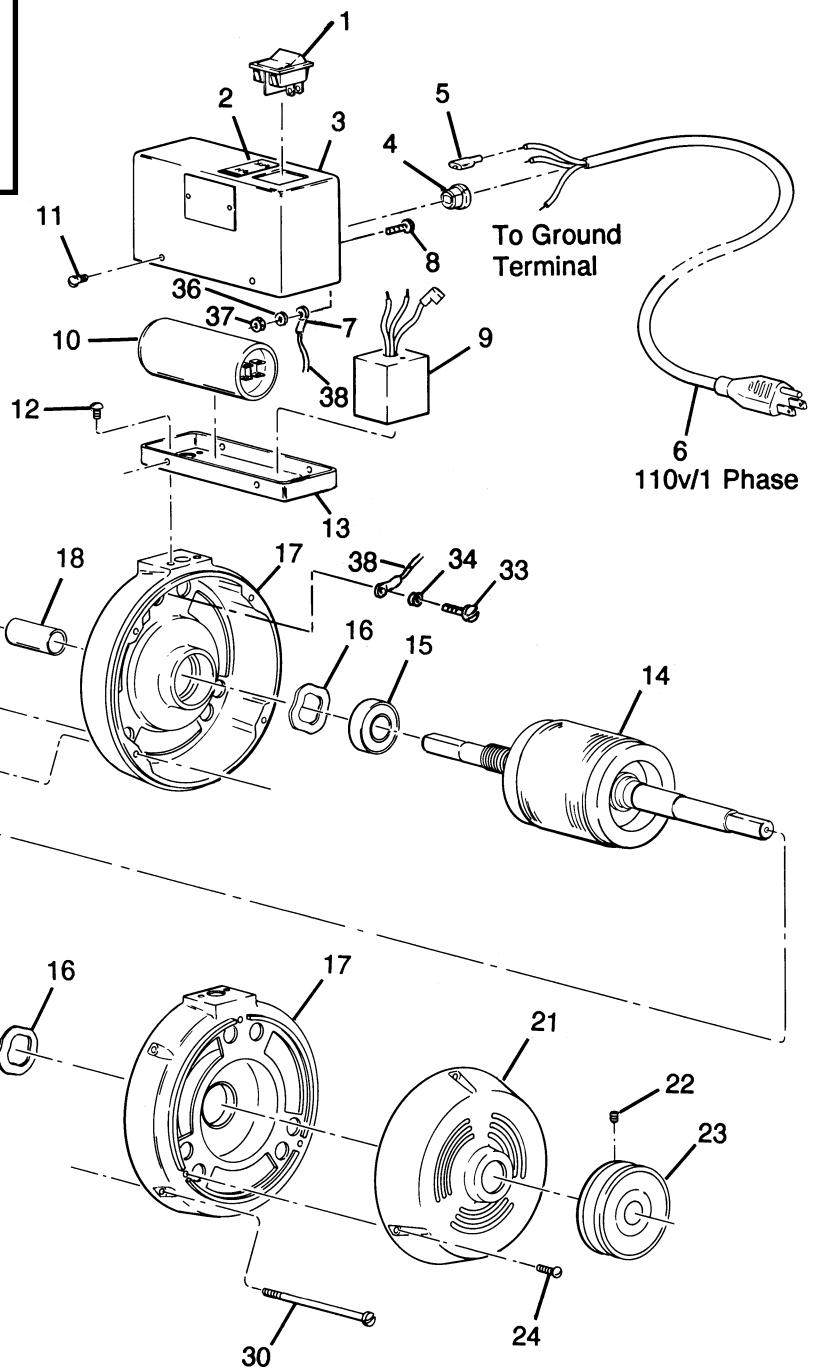
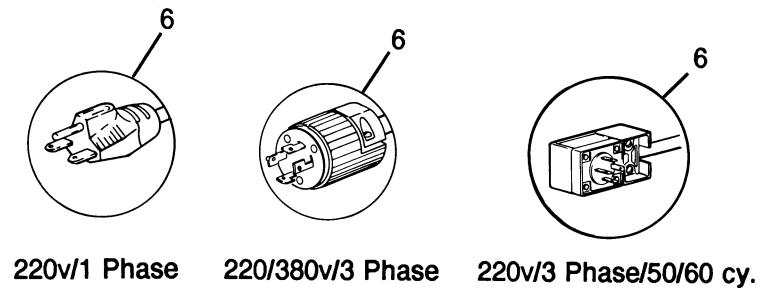
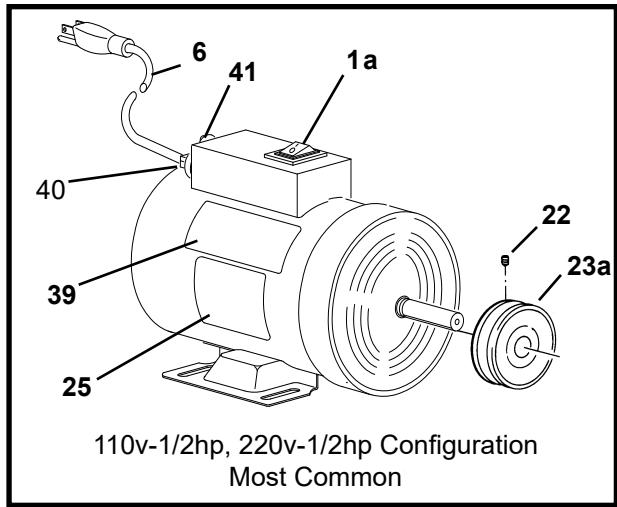
Part No.	Rating	
517C1-1218	(110v/60cy/1ph)	Shown
517C1-1220	(220v/60cy/1ph)	
517C1-1222	(220v/50cy/1ph)	
517C1-1268	**(110v/1/2hp)	
517C1-1270	**(220v/1/2hp)	

### Motor Assembly w/Motor Base

517C1-520	(220v/60cy/3ph)
517C1-521	(220v/50cy/3ph)
517C1-519	(220/380v/50cy/3ph)
517C1-1219	(110v/60cy/1ph)
517C1-1221	(220v/60cy/1ph)
517C1-1223	(220v/50cy/1ph)
517C1-1269	**(110v/1/2hp)
517C1-1271	**(220v/1/2hp)

ITEM	PART NO.	DESCRIPTION	QTY.
1	580C1-188	Switch, Lighted (110v/1ph)	1
	580C1-189	Switch, Lighted (220v/1ph)	1
1a	580C1-226	**Switch, Dual Voltage	1
2	236C1-137	Label, On-Off	1
3	122C1-37	Switch Housing	1
4	21C14-22	Strain Relief Bushing	1
5	47C4-47	Terminal Lug	6
6	523C2-56	**Power Cord (110v/1ph)	1
	523C2-48	**Power Cord (220v/1ph)	1
	523C2-23	Power Cord (220v/3ph)	1
	508C1-84	Plug (220/380v/3ph)	1
	145C2-1	Cord (220/380v/3ph)	1
7	199C1-27	Wire Lug	1
8	20C13-115	Ground Screw 10-32 x 1/4	1
9	597C3-6	Cutout, Solidstate (110v/1ph)	1
	597C3-7	Cutout, Solidstate (220v/1ph)	1
	N/A	Cutout, Solidstate (220v/3ph)	1
10	706C1-4	Capacitor (110v/1ph)	1
	706C1-5	Capacitor (220v/1ph)	1
	N/A	Capacitor (220v/3ph)	1
11	306C80-204	Screw, Pan Head,	
		Self Tapping 10 x 1/4	4
12	300C15-4	Screw, Round Head	
		10-32 x 1/2	2
13	62C16-307	Base Housing	1
14	513C3-236	Rotor with Shaft	1
15	90C6-65	Motor Bearing	2
16	12C1-62	Spring Washer	2
17	90C1-167	Bearing Housing	2
18	1C15-47	Sleeve Spacer	4
19	4C1-179	Nut Screw	4
20	10C1-49	Motor Fan	1
21	53C7-35	Cover, Bearing	2
22	20C13-6	Setscrew, 5/16-18 x 1/2	2
23	152C1-4	Pulley, Motor, 1/2" Bore	2
23a	152C1-5	Pulley, Motor, 5/8" Bore	2
24	301C8-1	Screw Fillister Head	
		4-40 x 1/2	6
25	79C2-62	Label, Caution	2
26	514C4-246	Stator with Band	
		(110v/60cy/1ph)	1
	514C4-247	Stator with Band	
		(220v/60cy/1ph)	1
	514C4-248	Stator with Band	
		(220v/50cy/1ph)	1
	N/A	(220v/3ph)	0
27	20C13-113	Screw, Mounting	2
28	52C5-227	Motor Base	1
29	79C11-3	Nut Plate	1
30	20C3-35	Screw	4
31	47C4-76	Wire Nut (not shown)	4
32	783C1-3	Ground Wire Assembly	1
33	305C10-1	Screw	1
34	12C1-32	Lock Washer #6	1
36	12C1-49	Lock Washer #10-32	1
37	4C2-91	Hex Nut, #10-32	1
38	783C1-14	Wire Assembly	1
39	79C02-83	Decal, Rag Cutter	1
40	170C1-1	Wire Grommet	1
41	580C1-220	Overload Switch	1

\*\* Most Common

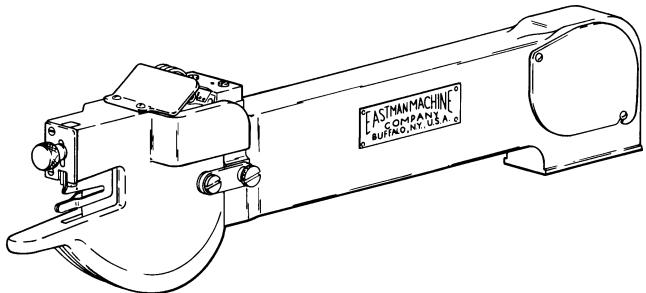


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## Arm Assembly

(697C1-5)

### Illustrated Parts List



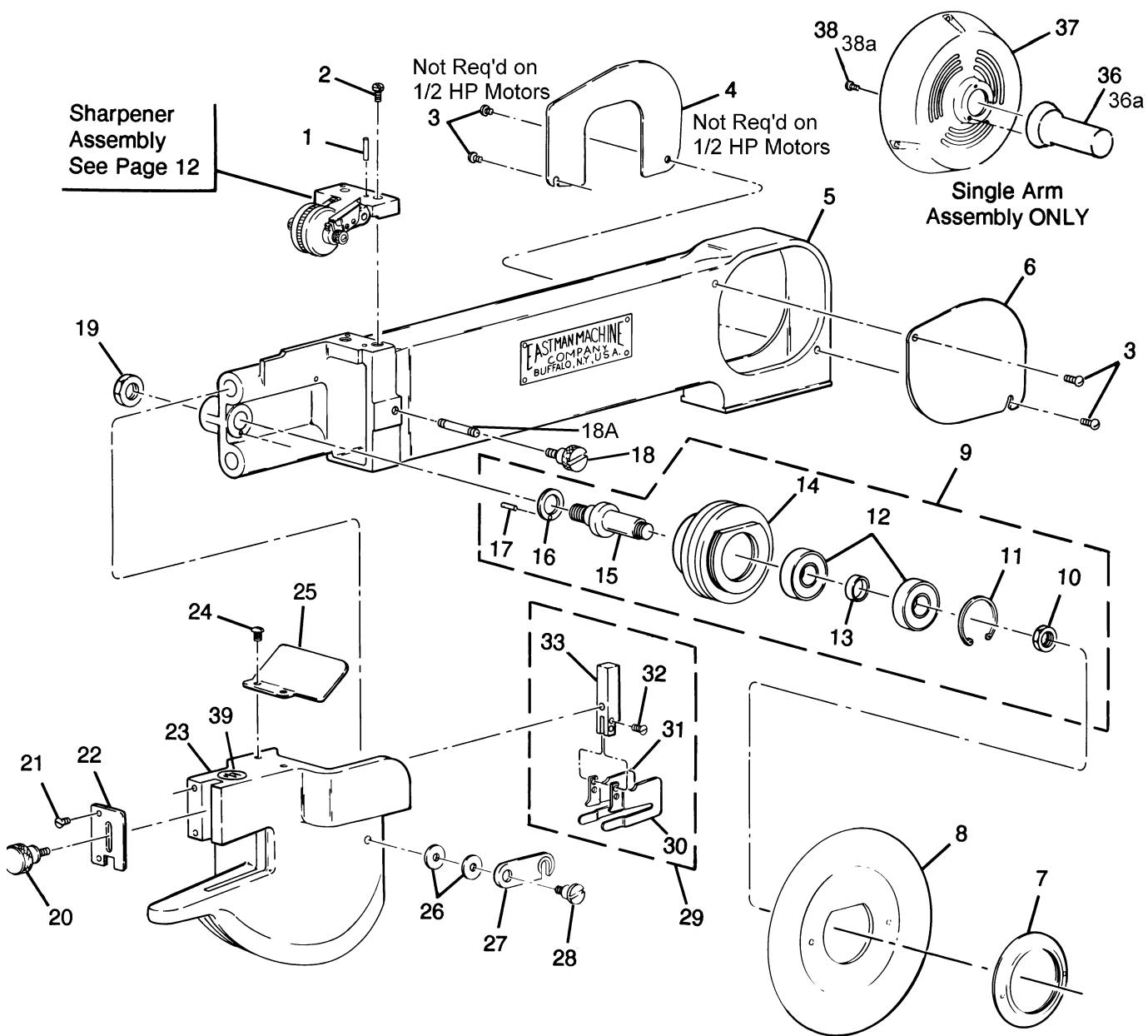
ITEM	PART NO.	DESCRIPTION	QTY.
1	17C1	Pin	2
2	301C18-1	Screw, Fillister Head 1/4-20 x 7/8	2
3	300C15-2	Screw, Round Head 10-32 x 1/4	4
4	53C11-157	Cover Over Pulley	1
5	35C7-30	Arm, Rag Cutter	1
6	53C11-9	Cover	1
7	4C1-82	Knife Locknut	1
8	*	6" Knife	1
9	602C1-8	Knife Pulley Assembly	1
10	4C1-118	Shaft Locknut	1
11	18C6-22	Retaining Ring	1
12	90C6-46	Bearing	2
13	55C4-31	Spacer	1
14	152C1-24	Pulley, Knife (only)	1
15	11C12-17	Pulley Shaft	1
16	12C11-64	Spacing Washer .005 Thick	A/R
	12C11-65	Spacing Washer .010 Thick	A/R
	12C11-66	Spacing Washer .015 Thick	A/R
	12C11-67	Spacing Washer .032 Thick	A/R
17	17C15-123	Pin, Roll	1
18	4C2-147	Thumb Nut	1
18A	65C6-95	Stud, Threaded	1
19	4C1-74	Locknut, Outer Pulley	1
20	20C12-35	Thumb Screw, Guard	1
21	302C12-3	Screw, Flat Head 8-32 x 3/8	2
22	79C12-88	Retaining Plate	1
23	612C1-31	Knife Guard Assembly	1
24	300C10-2	Screw, Round Head 6-32 x 1/4	2
25	25C4-165	Knife Guard	1
26	12C15-79	Washer	2
27	50C11-26	Clamp	1
28	20C8-8	Pivot Screw	1
29	612C1-56	Guard & Button Cutter Ass'y	1
30	79C12-223	Guard Plate-Front	1
31	79C12-222	Guard Plate-Rear	1
32	302C7-3	Screw, Flat Head 4-36 x 3/8	2
33	65C2-61	Guard Rod	1
34	181C1	V-Belt	1
35	300C10-3	Screw, Round Head 6-32 x 5/16	3
36	25C5-71	Guard Over Shaft	1
36a	25C5-75	Shaft Guard, 1/2 hp Motor	1
37	53C7-45	Cover, Bearing	1
38	300C8-2	Screw	3
38a	320-102-12	Shaft Guard Screw	3
39	79C2-61	Label, Caution	1

**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.

\* - See Chart

A/R - As Required



For best results use only

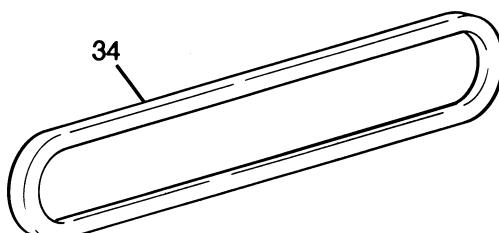
**GENUINE  
EASTMAN Knives**

The guarantee covering your **WE** Rag Cutter is not valid if knives other than those manufactured by Eastman are used.

**6" DIAMETER  
ROUND KNIFE SELECTION CHART**

80C1-39	Carbon Steel
80C1-39HS	High Speed Steel

Teflon coated knives available.  
Order by adding "T" to end of knife number.

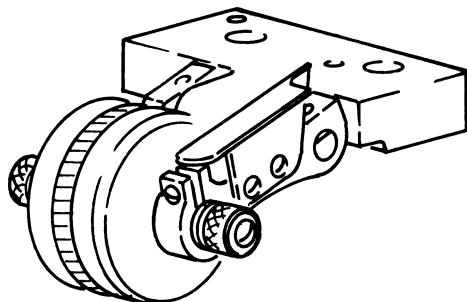


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# Sharpener Assembly

(637C1-31)

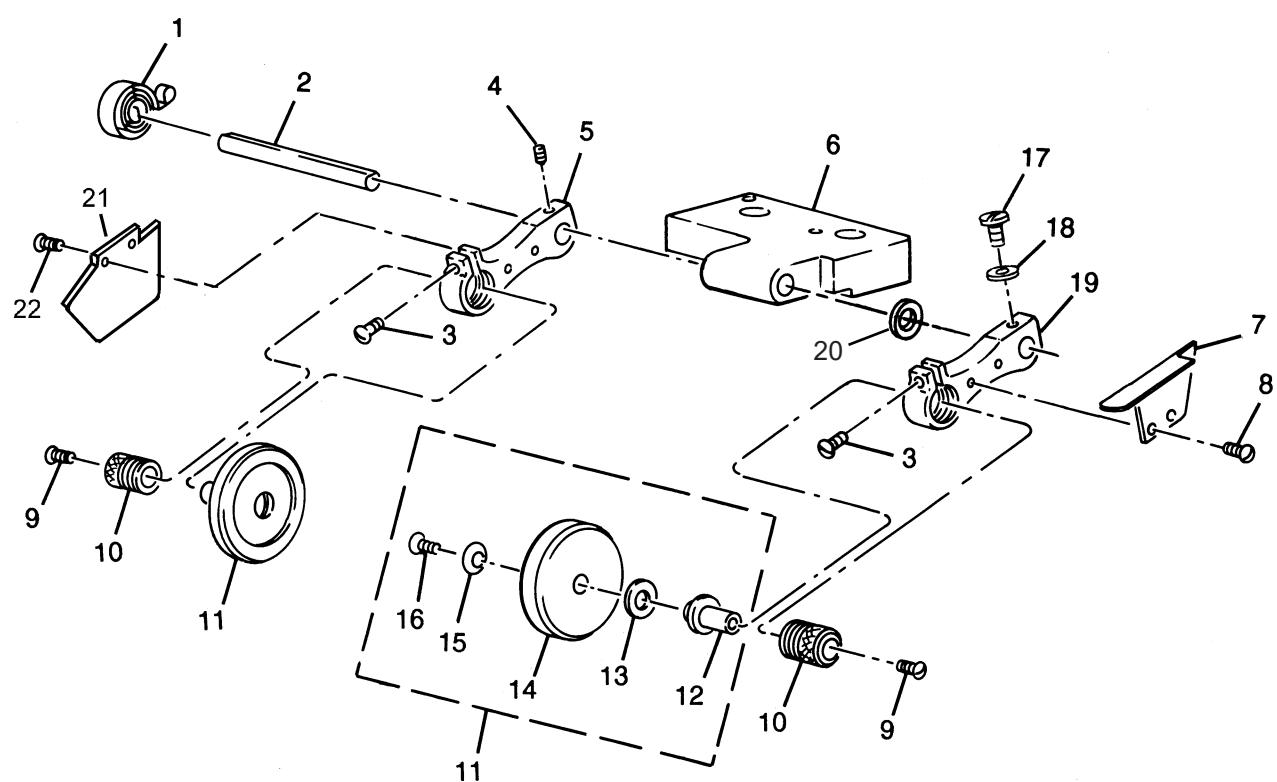
## Illustrated Parts List



ITEM	PART NO.	DESCRIPTION	QTY.
1	34C1-60	Spring, Sharpener	1
2	11C10-20	Shaft Sharpener	1
3	300C10-5	Screw, Round Head #6-32 x 7/16	2
4	309C12-1	Set Screw	2
5	35C5-57	Sharpener Arm	1
6	62C8-36	Bracket, Sharpener	1
7	57C2-25	Lever, Sharpener	1
8	300C8-8	Screw, Round Head 4-40 x 5/16	2
9	304C10-3	Spindle Lock Screw	2
10	20C6-11	Adjusting Screw	2
11	541C1-9	Emery Wheel Assembly (120 Grit)	2
	541C1-13	Emery Wheel Assembly (150 Grit)	2
	541C1-21	Emery Wheel Assembly (220 Grit)	2
12	92C1-12	Spindle	1
13	12C15-70	Washer	1
14	133C1-12	Emery Wheel (120 Grit)	2
	133C1-14	Emery Wheel (150 Grit)	2
	133C1-25	Emery Wheel (220 Grit)	2
15	12C1-28	Brass Washer	2
16	20C13-20	Emery Wheel Screw	2
17	300C12-3	Screw, Round Head 8-32 x 3/8	1
18	12C1-21	Lock Washer	1
19	35C5-65	Sharpener Arm	1
20	12C15-29	Flat Washer	1
21	25C4-191	Side Sharpener Plate	1
22	300C8-8	Screw, Round Head #4-40 x 5/16	2

**NOTE:**

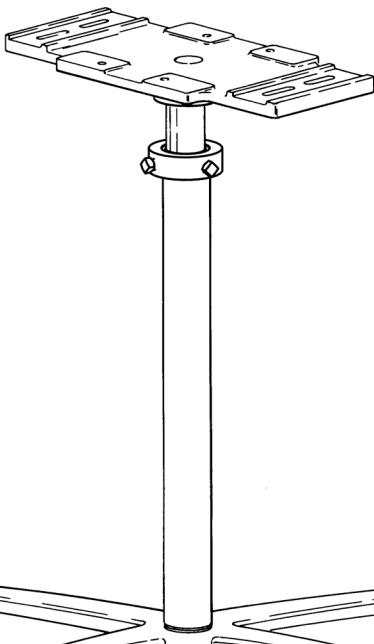
Please specify model and serial number of machine when ordering parts.  
Item numbers are for reference only.  
Please specify PART NUMBERS when ordering replacement parts.



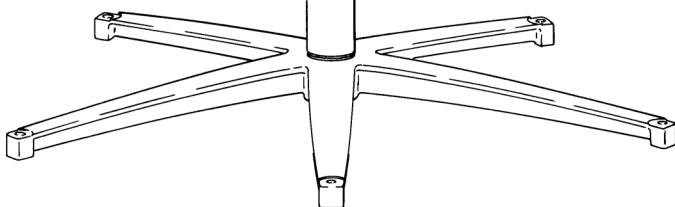
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# **Stand Assembly**

## **Illustrated Parts List**



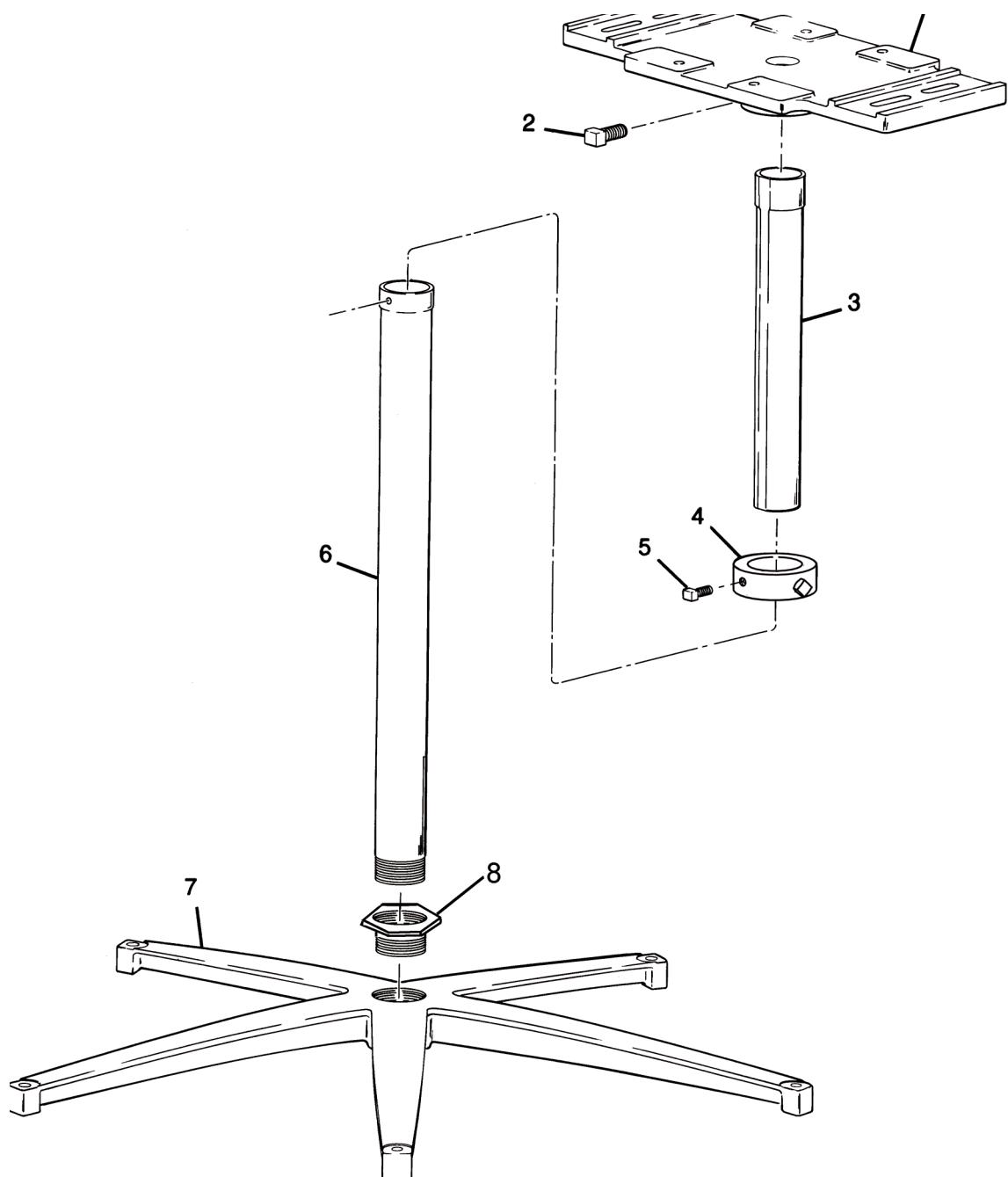
ITEM	PART NO.	DESCRIPTION	QTY.
1	52C5-188	Motor Base	1
2	20C13-10	Screw, Square Head 1/2-13 x 1 1/4	1
3	65C6-21	Adjusting Rod	1
4	5C5-5	Collar	1
5	20C13-9	Screw, Square Head 3/8-16 x 3/4	2
6	119C4-7	Pipe Support	1
7	121C1-12	Stand	1
8	21C10-5	Adapter Bushing	1



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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## EVERYTHING FOR THE CUTTING ROOM FOR FURTHER INFORMATION:

**Eastman Machine Company:** Cloth cutting machines

**CRA:** Cloth spreading machines

**EASI:** Automated cutting and spreading systems

**Eastman Machine Trading Corp:** Cutting room accessories

**Eastman Export:** For the overseas market

**Limited Warranty.** Eastman warrants to the buyer that the *Rag Cutter* 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 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.