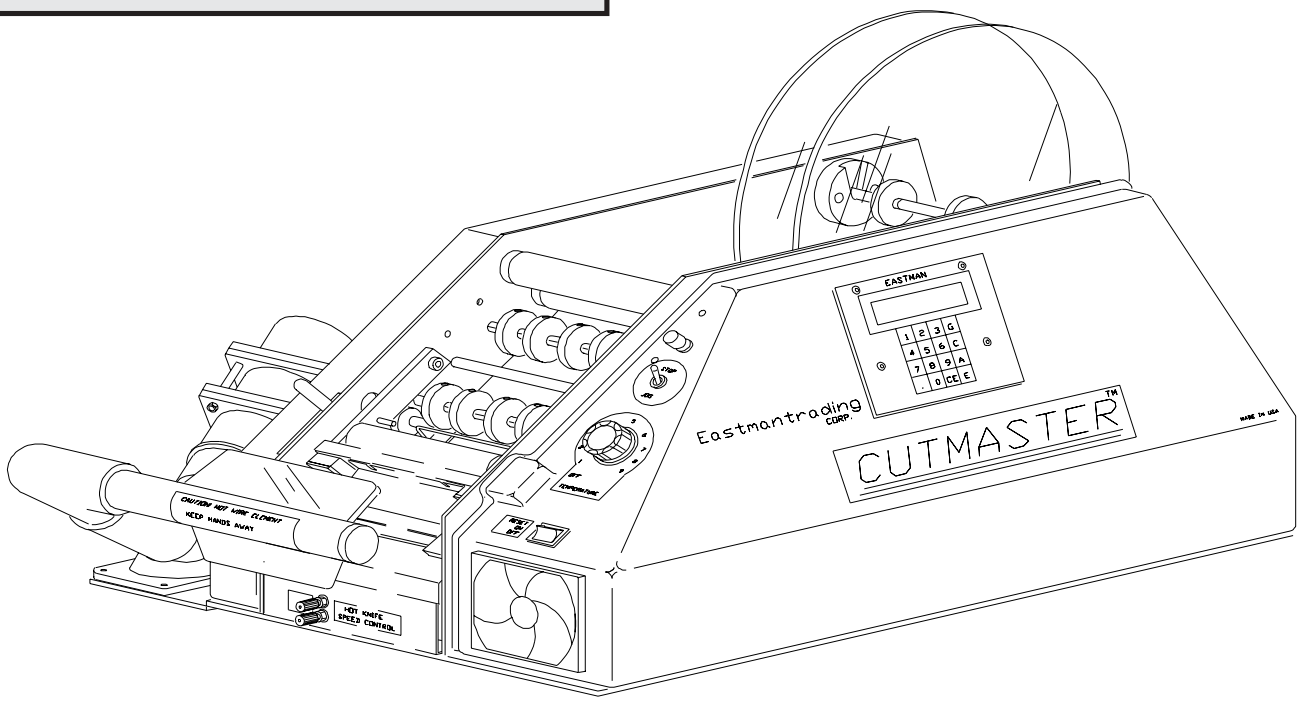
THE EASTMAN ® CUTMASTER Strip Cutting Machine

⚠ WARNING
Safety glasses must be worn at all times when operating or servicing this equipment.



Instruction Manual & Illustrated Parts List

⚠ CAUTION
Machine Equipped with Sharp Blade and HOT Cutting Knife!

Please read completely before attempting to operate your ***EASTMAN CUTMASTER***

Eastman®
Over a Century of Cutting Expertise

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Manufacturers of Eastman Cloth Cutting and Cloth Spreading Machines
Website: www.EastmanCuts.com

Form EMT-21

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IMPORTANT

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

Electrical connections and servicing to this equipment should be made by a qualified electrician who is familiar with applicable codes and regulations. Disconnect this equipment from electrical power source before proceeding with any disassembly for adjustment or repair.

Your Eastman Cutmaster is designed to cut material with a sharp cutting block or a hot knife assembly. The operator must be cautioned to keep hands and loose clothing away from feed rollers, cutting block and hot knife assembly when machine is in operation.

The purchaser must provide:
-a clean compressed air source; 90 psi max/3scfm (Grainger, Sears).
-a standard exhaust hose with 2-7/8 inches inner diameter.

The Eastman ***CUTMASTER*** has been inspected and tested at the factory. The Cutmaster is shipped complete and ready for operation. To get the best performance, familiarize yourself with all 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 which they are presented.

INSTALLATION

The Cutmaster weighs approx. 85 lbs. Remove the Cutmaster from the packaging and place in a well ventilated area. Connect main power cord to the machine. The Cutmaster requires 90 psi compressed air. Locate the air line connection on the back cover and connect the air line with 1/4 N.P.T. Quick Connect or equivalent. Install fume extractor. If the Cutmaster is to be operated with the hot knife, an exhaust hose must be connected. Connect a 2-7/8" inner diameter exhaust hose to the vent tube.

Note: The Exhaust fumes may be hazardous and must be vented to a safe area away from operator. If an additional exhaust fan is used, it may cause erratic temperatures with the hot knife.

OPERATION

When power supply is properly connected, the air line is connected, the fume extractor installed and exhaust hose is attached, the Cutmaster is ready for operation.

Note: The fume extractor sensor on the swing arm and switch magnet on the machine must be in contact before machine will operate.

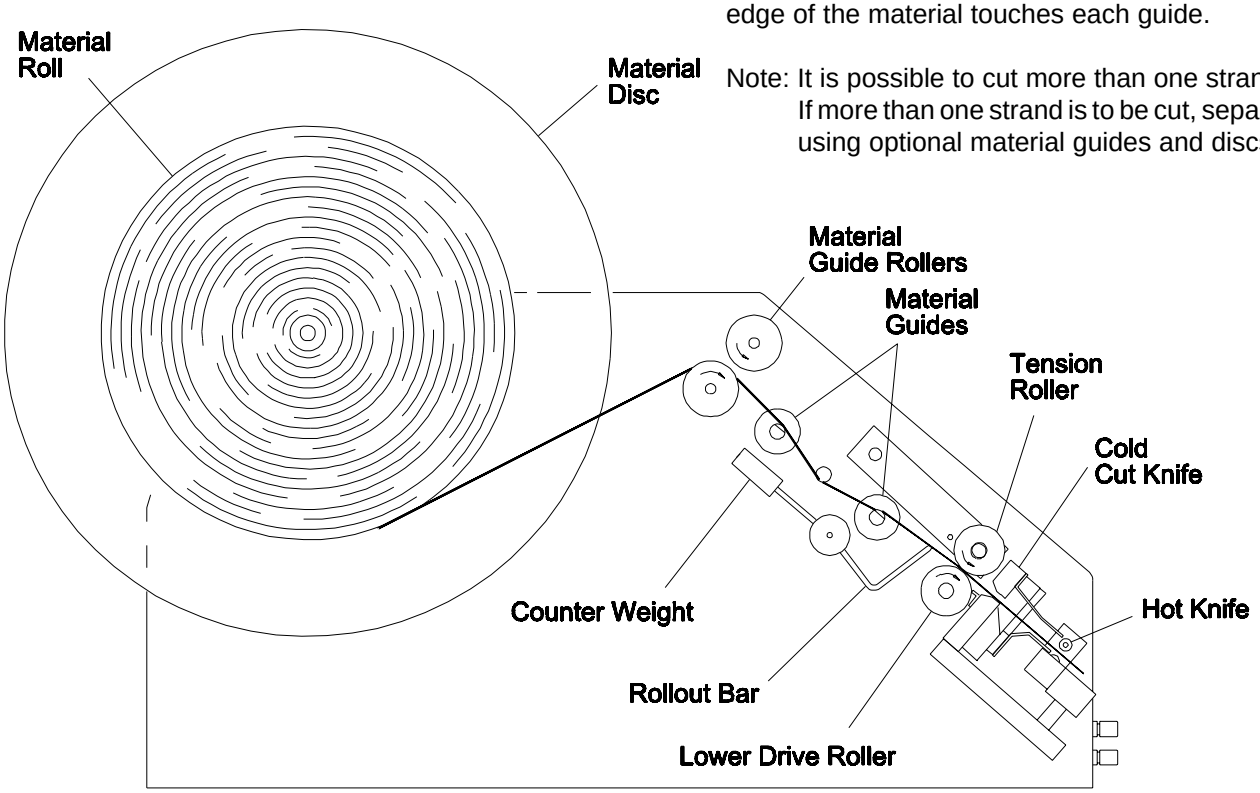
Caution: Operator must keep hands and loose objects away from cutting area.

Loading Fabric

Place the fabric roll between the material discs and center on shaft using the material guides. Load onto machine so material is fed from the bottom up (see fabric threading diagram) and straight through the cutting area.

Feed the material between the guide rollers, over the first set of material guides, under the bar and over the second set of material guides. Hold down the material rollout bar and feed material between the drive rollers (make sure material enters cutting block). Release the tension lever and feed the material past the cutting area. Any loose material must be rolled back onto material roll before the cutting cycle can take place. Adjust material guides so the edge of the material touches each guide.

Note: It is possible to cut more than one strand at a time. If more than one strand is to be cut, separate strands using optional material guides and discs.



Fabric Threading Diagram

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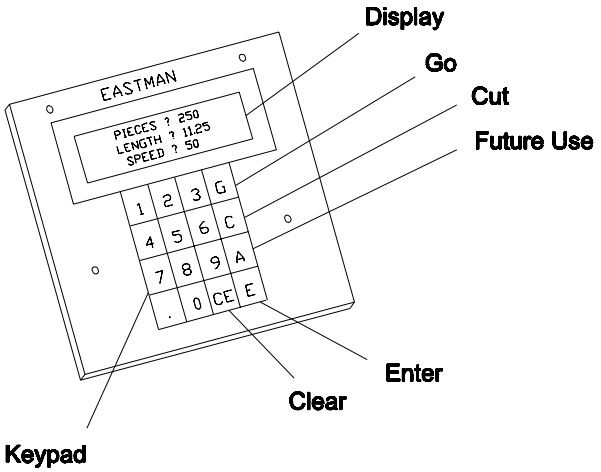
The machine is now loaded and can be programmed for number of pieces, cut length and cutting speed.

Setting the Pieces, Length and Speed
Turn the main power switch to ON position. The blinking cursor will indicate the display is ready. Enter the number of pieces to be cut and press “E” to enter number. Enter length (in inches) of piece to be cut and press “E” to enter number.

Note: The decimal is required with two places, for entry to be accepted. See example.

Enter the machine speed (10 through 99) and press “E” to enter number. To clear the display press the RESET button or “CE” to clear one line.



Keypad Display

Cutting
Before beginning a cut cycle it is recommended to cut sample pieces. After the sample pieces have been checked you are ready to begin cutting.

Cold Cutting
To begin cold cutting turn the temperature control knob to OFF position. Key in the number of pieces, length of piece and machine speed. Press “G” to begin cutting cycle. For a single cut press “C”. To stop the cutting cycle at any time press the STOP button on the front cover.

Hot Cutting

Caution: Hot Knife is HOT

To enable the hot knife, push hot knife on/off switch to ON position. Then use the temperature control knob to set desired heat level. Key in the number of pieces, length of piece and machine speed. Press “G” to begin cutting cycle. For a single cut press “C”. To stop the cutting cycle at any time press the STOP button on the front cover. To return to cold cutting mode, press hot knife on/off switch to OFF position. Let machine cool down for a short period between jobs.

Caution: Hazardous Fumes. Fume extractor must be locked into place and exhaust hose attached to enable machine operation.

Note: To achieve best results, some experimentation may be required. Adjust the temperature control and the speed control valves to achieve a clean acceptable cut.

IMPORTANT: To stop the cutting cycle at any point during operation, press the STOP button on the front cover. Press “G” to resume cutting.

Out Of Material
The Cutmaster will automatically stop when out of material. Reload new fabric roll and press “G” to resume cutting.

Note: Staples and tape may damage your machine. The first piece after resuming cutting cycle may not be correct length.

Simplified Operating Instructions

1) Activate Main Power.
2) Thread material.
3) Select cutting mode.
4) Program number of pieces, press enter.
5) Program length of cut, press enter.
6) Program machine speed, press enter.
7) Engage magnetic sensors between fume extractor and machine.
8) Press “G” to begin.

Fine Adjustments
This machine is adjusted and tuned at the factory for optimal performance. Some materials may require a fine adjustment to achieve acceptable performance. If fine adjustment is required, the following procedures should be carried out before repairs are considered.

Tension Control
To prevent compression of some materials, the drive roller tension can be adjusted. The tension is adjusted by allen head set screws located in both tension arms. Turn the screws clockwise to reduce drive roller tension on the material. The tension should be the same all across the rollers.

Hot Knife Temperature
Hot knife temperature is adjusted by rotating the temperature control knob clockwise for high heat and counterclockwise for lower heat. If the temperature is too low, the cut will be dry and the hot knife will labor when passing through the material. If the hot knife temperature is too high, flaming will occur.

Cutting Motion
The speed control DOWN sets the downward cutting motion of the hot knife. Turn clockwise to decrease the cutting motion and counterclockwise to increase the motion.

Note: Heavy materials require a slower cutting motion.

The speed control UP sets the up return motion of the hot wire. Turn clockwise to decrease the return motion and counterclockwise to increase the motion.

Note: Heavy materials require a slower return motion to recover hot knife temperature.

Speed of Feed
The average speed for most materials is between 50 and 80. The lower the number, the slower the feed of goods will be.

Note: This is motor speed only and does not affect blade speed.

MAINTENANCE

The Cutmaster was designed for maximum production and minimum maintenance. To keep your Cutmaster operating properly it is important to replace any normal wear parts when they show any signs of wear.

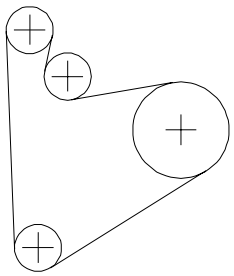
Cleaning
The machine should be kept clean at all times. Blow off entire machine and wipe down with dry cloth. Household cleaners are recommended when cleaning plastic covers and material guide discs. Material guide chute and upper material guide plate should be cleaned daily. After cleaning, place a few drops of Eastman oil (162C2) between cold knife blades for smooth operation.

Filters
Two (2) filters are located on the front cover to allow clean cool air ventilation. The filters must be cleaned or replaced when dirty.

Fuse Replacement
The Cutmaster is equipped with 3 safety fuses to protect the electrical circuits. Two (2) fuses are located on the frame. Remove the front cover to gain access. One (1) fuse is located on the front cover. Disconnect the main power cord. Take out old fuse and replace with fuse of identical rating.

Shield Replacement
The clear shield located on the fume extractor can be cleaned with a household cleaner. To replace the shield remove the two (2) screws and old shield. Replace with new shield and secure screws in place.

Flex Chain Replacement
The Flex Chain requires no oil. Remove the front cover to gain access to flex chain. Hold the self adjusting chain tensioner to remove old chain. Install new flex chain. See chain threading diagram.



Flex Chain Threading Diagram

Drive Belt Replacement
Remove the front cover to gain access to the drive belt and motor. Loosen four (4) screws holding the motor to the base. Slide motor up to release belt tension. Replace old belt with new belt. Slide motor down to create slight pressure on the drive belt and tighten screws. Replace front cover.

Hot Knife Replacement
Disconnect main power cord. Remove the front and back covers. Disconnect Hot Knife from electrical connectors. Remove old hot knife and replace with new hot knife. Inspect old insulating bushings. If damaged or cracked replace with new insulating bushings. Connect electrical connections (connectors must not touch side frame) and secure in place. Replace covers.

Chopper Block Replacement

Caution: Chopper Block has sharp edges.

The cold cutting chopper block is a normal wear part and may need sharpening or replacement. Remove front and back covers. Remove the hot knife electrical connections. Remove four (4) socket head screws holding the chopper body in place. Slide the assembly out to gain access to the two (2) chopper body hold down screws (refer to chopper block and hot knife illustrated parts list). Replace chopper body and reassemble. Contact factory for detailed instruction sheet on removal of cutter block assembly and blade replacement.

Recommended Maintenance Supplies
The recommended maintenance supplies are normal wear parts.

ITEM	PART NO.	DESCRIPTION	QTY.
1	192C1-7	Flex Chain, .1475 p	1
2	181C4-12	Drive Belt	1
3	262C1-6	Fuse, 2 Amp	5
4	262C1-12	Fuse, 8 Amp slow blow	5
5	262C1-17	Fuse, 10 Amp slow blow	5
6	253C3-3	Filter & Cover	1
7	80C1-161	Hot Knife	3
8	21C2-12	Insulating Bushing	2
9	73C9-9	Shield, Clear	1
10	766C1-8	Chopper Block Assembly	1
11	660C3-202	High Temp Hot Knife Harness	2
12	162C2	Eastman Oil, 1 oz.	1

Parts and Servicing
Your Eastman Cutmaster 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 and servicing for this machine may be obtained through your nearest Eastman Trading representative or directly from the Eastman factory.

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

Please have the following information ready:

Machine Name: Cutmaster.
Serial Number: _____
Date of Purchase: _____

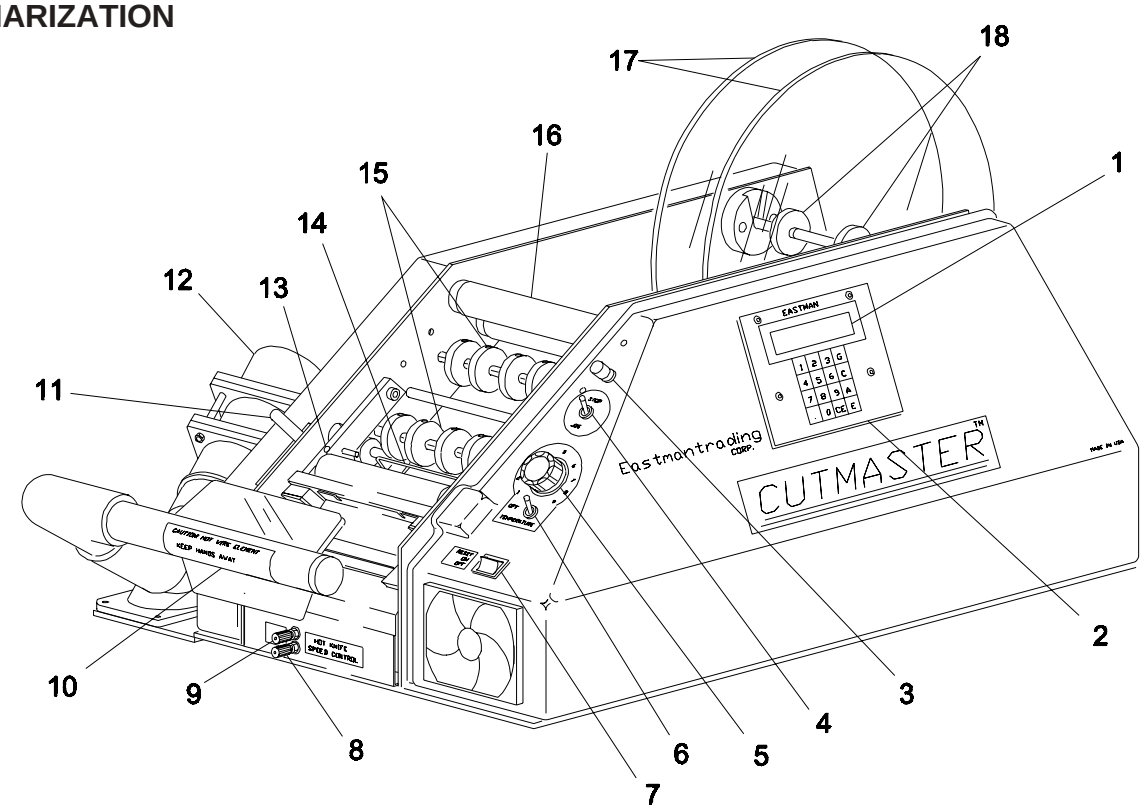
Part No.	Part Description	Qty.

FAMILIARIZATION

1. **Digital Display**- Displays number of pieces to be cut, length of cut and speed of feed.

2. **Keypad**- Press numbers desired for each display.
   Press "E" (enter) to save numbers in each line.
   Press "CE" (clear entry) to clear a single line.
   Press "C" (cut) to make single cut.
   Press "G" (go) to begin cutting cycle.

FAMILIARIZATION



3. **Stop Button**- Press to stop cutting cycle.

4. **Jog Switch**- Hold to advance material or back away material from cutting block and drive rollers.

5. **Hot Knife Temperature Control**- Turn clockwise to set hot knife temperature.

6. **Hot Knife ON/OFF Switch-** Activates hot knife. Push to right for ON and to left for OFF.

7. **Main Power/Reset**- Activates power to all circuits. Display is on when in ON position. Press to reset display at any time.

8. **Speed Control Down**- Turn valve clockwise to set down (cutting) motion of hot knife only. Note: Setting will vary depending on material.

9. **Speed Control Up**- Turn valve clockwise to set up (return) motion of hot knife only. Proper setting will allow hot knife to recover for heavy materials. Note: Setting will vary depending on material.

10. **Fume Extractor**- Removes "Hazardous" fumes from work area. Note: Extractor must be in place before machine will operate.

11. **Material Tension Lever**- Lift to thread material between drive rollers.

12. **Vent Tube**- Connect exhaust hose here to remove "Hazardous" fumes away from work area.

13. **Tension Adjustment Screws**- Adjustment screws reduce or increase operating tension on material. Note: Setting may vary depending on material.

14. **Rollout Bar**- Stops cutting cycle when out of material. Bar must be in down position when operating.

15. **Material Guides**- Guides material through the drive rollers and cutting area. Adjust guides to width of material.

16. **Material Guide Rollers**- Guides material off material roll and into cutting area.

17. **Material Guide Discs**- Place material roll between discs for smooth advancing of material.

18. **End Guides-** Hold material guide discs in place. Only one set required even when loading multiple rolls.

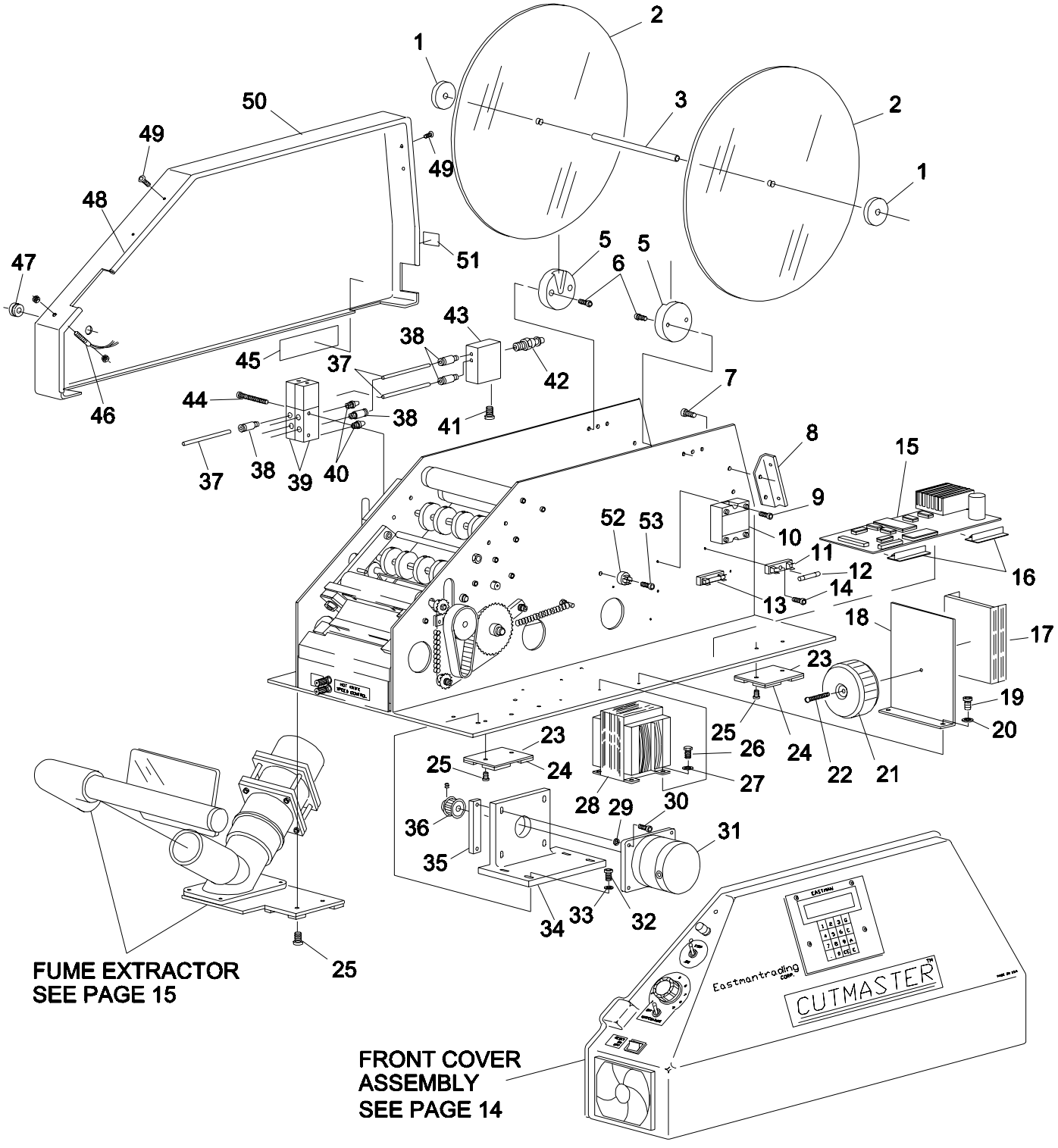
THE EASTMAN ® CUTMASTER Strip Cutting Machine

Pictorial Index

ITEM	PART NO.	DESCRIPTION	QTY.
1	70C4-58	Guide, Material	2
2	70C4-59	Material Disc	2
3	11C12-132	Shaft, Material Disc	1
4	--	Not Required	
5	165C1-1	Hanger	2
6	308C18-9	Screw, Socket Hd. 1/4-20 x1/2	4
7	307C10-3	Screw, Button Hd. 6-32 x 5/8	8
8	62C16-324	Bracket, Cover	4
9	307C10-3	Screw, Button Hd. 6-32 x 5/8	2
10	111C1-18	Relay, 110 Volt only	1
	111C1-19	Relay, 220 Volt only	1
11	33C11-6	Fuse Holder	2
12	262C1-6	Fuse, 2 Amp.	1
13	262C1-12	Fuse, 8 Amp. slow blow	1
14	307C10-3	Screw, Button Hd. 6-32 x 5/8	2
15	830C1-88	P. C. Board	1
16	33C10-68	Holder, P. C. Board	4
17	660C3-204	Power Supply, 110V, Wired Assembly	1
	660C3-205	Power Supply, 220V, Wired Assembly	1
18	62C16-328	Bracket, Power Supply	1
19	308C12-3	Screw, Socket Hd. 8--32 x 5/16	2
20	12C1-35	Washer, Lock #8	2
21	130C1-13	Transformer, 110 Volt	1
	130C1-15	Transformer, 220 Volt	1
22	301C15-8	Screw, Round Hd. 10-32 x 1 3/8	1
23	68C3-17	Plate, Rubber Feet	3
24	68C3-16	Feet, Rubber	12
25	308C18-9	Screw, Socket Hd. 1/4 -20 x 1/2	8
26	308C12-3	Screw, Socket Hd. 8-32 x 5/16	4
27	12C1-35	Washer, Lock #8	4

ITEM	PART NO.	DESCRIPTION	QTY.
28	819C1-18	Transformer, Hot Knife 110V, Wired Assembly	1
	819C1-19	Transformer, Hot Knife 220V, Wired Assembly	1
29	12C15-14	Washer, Flat #10	4
30	308C15-12	Screw, Socket Hd. 10-32 x1	4
31	576C2-635	Motor, Stepper	1
32	308C15-1	Screw, Socket Hd. 10-32 x 5/8	4
33	12C15-14	Washer, Flat #10	4
34	62C16-325	Bracket, Motor	1
35	78C3-7	Nut Plate	2
36	152C1-46	Gear, Motor	1
37	73C7-208	Tubing, 5/32 O.D.	A/R
38	151C1-9	Air Fitting	8
39	112C2-3	Valve, Solenoid	2
40	251C3-5	Muffler	4
41	308C15-2	Screw, Socket Hd. 10-32 x 1/2	2
42	54C4-45	Air Fitting, Quick Connect	1
43	46C3-50	Manifold, Air	1
44	300C8-12	Screw, Round Hd. 4-40 x 1 1/2	2
45	236C1-145	Decal, Warranty	1
46	133C1-29	Sensor, Fume Extractor	1
47	207C1-5	Grommet	1
48	87C1-42	Molding, Edge	A/R
49	307C10-3	Screw, Button Hd. 6-32 x 5/8	8
50	53C11-177	Rear Cover	1
51	236C1-154	Decal, Air Intake	1
52	134C1-18	Rectifier	1
53	307C10-3	Screw, Button Hd. 6-32 x 5/8	1

A/R - As Required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FUME EXTRACTOR
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ASSEMBLY
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CUTMASTER

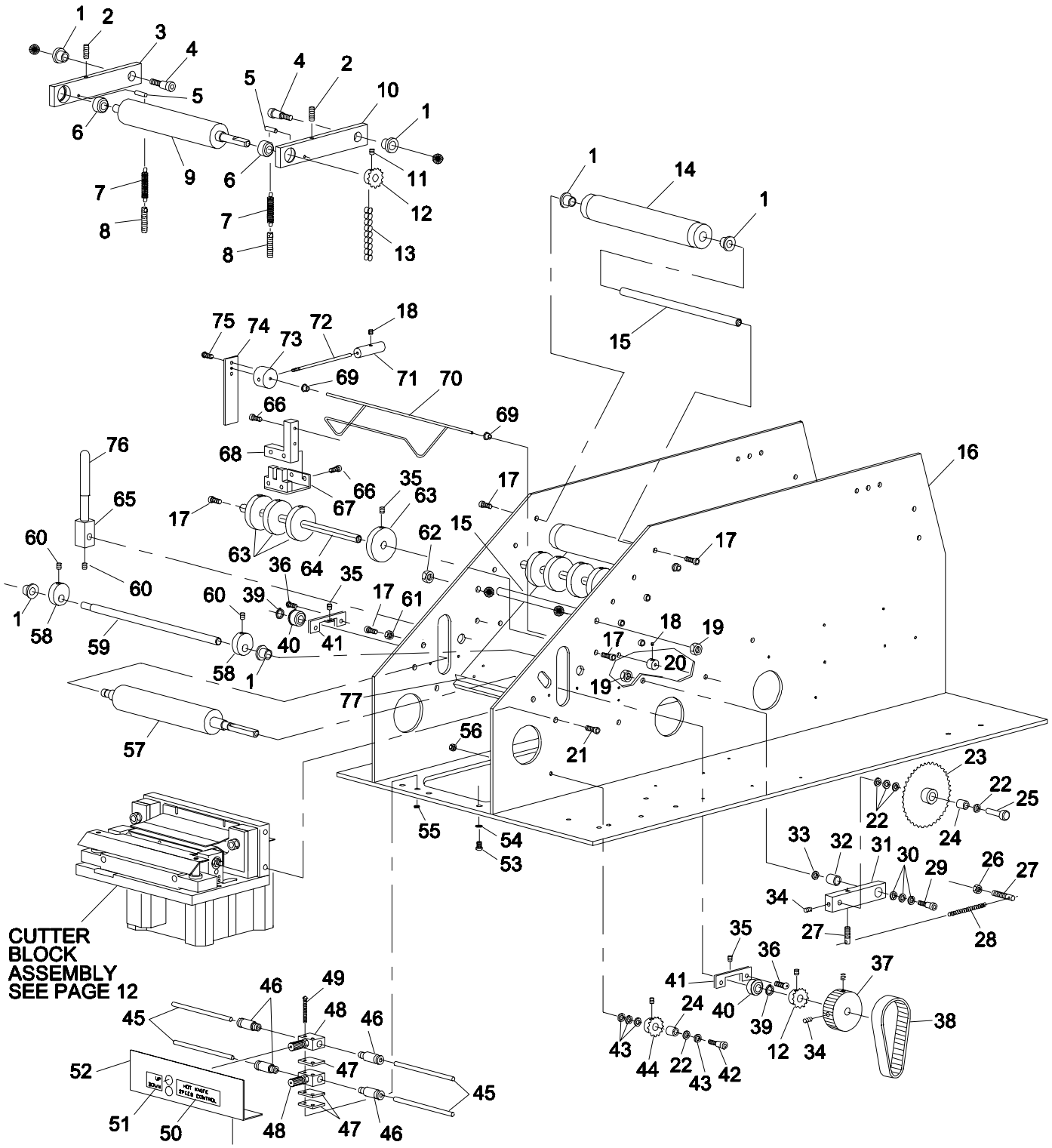
THE EASTMAN ® CUTMASTER Strip Cutting Machine

Pictorial Index (cont'd)

ITEM	PART NO.	DESCRIPTION	QTY.
1	21C14-24	Bushing, Flanged, 3/8" I.D.	6
2	309C12-6	Setscrew, Special, 8-32 x 1/2	2
3	35C7-39	Tension Roller Arm, Left	1
4	24C8-12	Screw, Shoulder 3/8 x 7/8	2
5	189C1-25	Spring Post, 1/8"	2
6	90C6-68	Bearing, Special Control	2
7	34C1-14	Spring	2
8	34C10-202	Spring Anchor	2
9	41C2-20	Roller, Tension Drive	1
10	35C7-40	Tension Arm, Right	1
11	309C8-3	Setcrew	2
12	278C1-4	Sprocket, .1475 p-20t, 3/8 I.D.	2
13	192C1-7	Chain, .1475p	1
14	41C5-17	Roller, Material Guide	2
15	65C6-10	Rod, Threaded	3
16	729C5-13	Frame Assembly, Main	1
17	308C18-12	Screw, Socket Hd. 1/4-20 x 3/8	8
18	309C12-3	Setscrew, 8-32 x 1/8	2
19	4C2-146	Nut, Hex 5/16-18	2
20	5C5-29	Counter Weight	1
21	308C18-9	Screw, Socket Hd. 1/4-20 x 1/2	4
22	12C11-83	Washer, Nylon 1/4 x 1/32 Thick	5
23	278C1-3	Sprocket, .1475p x 48t	1
24	90C6-69	Bearing	2
25	17C2-2	Idler Pin	1
26	4C2-58	Nut, Hex 1/4-20	1
27	34C10-202	Spring Anchor	2
28	34C10-121	Spring, Idler	1
29	311C14-6	Screw, Shoulder 3/8 x 1/2 lg.	1
30	12C15-123	Washer, Nylon 3/8 I.D. x 1/32 Thick	3
31	35C7-41	Idler Arm	1
32	21C14-26	Bushing 3/8 x 1/2 x 3/8 lg.	1
33	12C11-86	Washer, Fibre 3/8 I.D. x 1/64 Thick	1
34	309C12-3	Setscrew, 8-32 x 1/4	3
35	309C12-3	Setscrew, 8-32 x 1/4	9
36	307C8-1	Screw, Button Head	4
37	152C1-45	Drive Pulley, Large	1
38	181C4-12	Drive Belt	1

ITEM	PART NO.	DESCRIPTION	QTY.
39	18C6-84	Retaining Ring	2
40	90C6-66	Ball Bearing, Flanged, 3/8 I.D.	2
41	90C6-67	Bearing Hold Down Bracket	2
42	311C14-5	Screw, Shoulder 1/4 x 1/2	1
43	12C11-84	Washer, Nylon 1/4 x 1/16 Thick	4
44	278C1-5	Sprocket, .1475p - 20t x .438 I.D.	1
45	73C7-208	Tubing, Nylon 5/32 O.D.	A/R
46	151C1-9	Air Fitting, 10-32	4
47	55C4-156	Spacer Plate	3
48	112C2-4	Flow Control Valve	2
49	300C8-11	Screw	2
50	236C1-149	Decal, Hot Knife Speed Control	1
51	236C1-148	Decal, Up Down	1
52	79C12-421	Plate, Front Face	1
53	308C15-2	Screw, Socket Hd. 10-32 x 1/2	2
54	12C15-14	Washer, Flat #10	2
55	4C2-106	Nut, Locking #4-40	2
56	4C2-104	Nut, Hex 10-24	1
57	41C2-19	Roller, Main Drive	1
58	64C1-17	Cam, Tension Arm	2
59	11C12-131	Shaft, Tension Lever	1
60	309C14-5	Setscrew, 10-24 x 3/8	3
61	4C2-58	Nut, Hex 1/4-20	1
62	4C2-146	Nut, Hex 5/16-18	1
63	70C4-60	Material Guide, Adjustable	8
64	65C6-11	Rod, Material Guide	2
65	232C1-4	Tension Lever	1
66	307C10-3	Screw, Button Hd. 6-32 x 5/8	4
67	660C4-18	Material Sensor Assembly	1
68	62C16-327	Bracket, Sensor	1
69	21C14-25	Bushing, Small	2
70	62C16-326	Material Trip Lever	1
71	136C1-34	Counter Weight	1
72	11C12-133	Shaft, Counter Weight	1
73	67C6-8	Mount, Counter Weight	1
74	62C16-331	Optic Flag	1
75	307C10-1	Screw, Button Head 6-32x1/4	2
76	53C11-179	Cover	1
77	25C5-74	Roller Guard	1

A/R - As Required



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Over a Century of Cutting Expertise

Cutter Block & Hot Knife Assembly

766C1-7

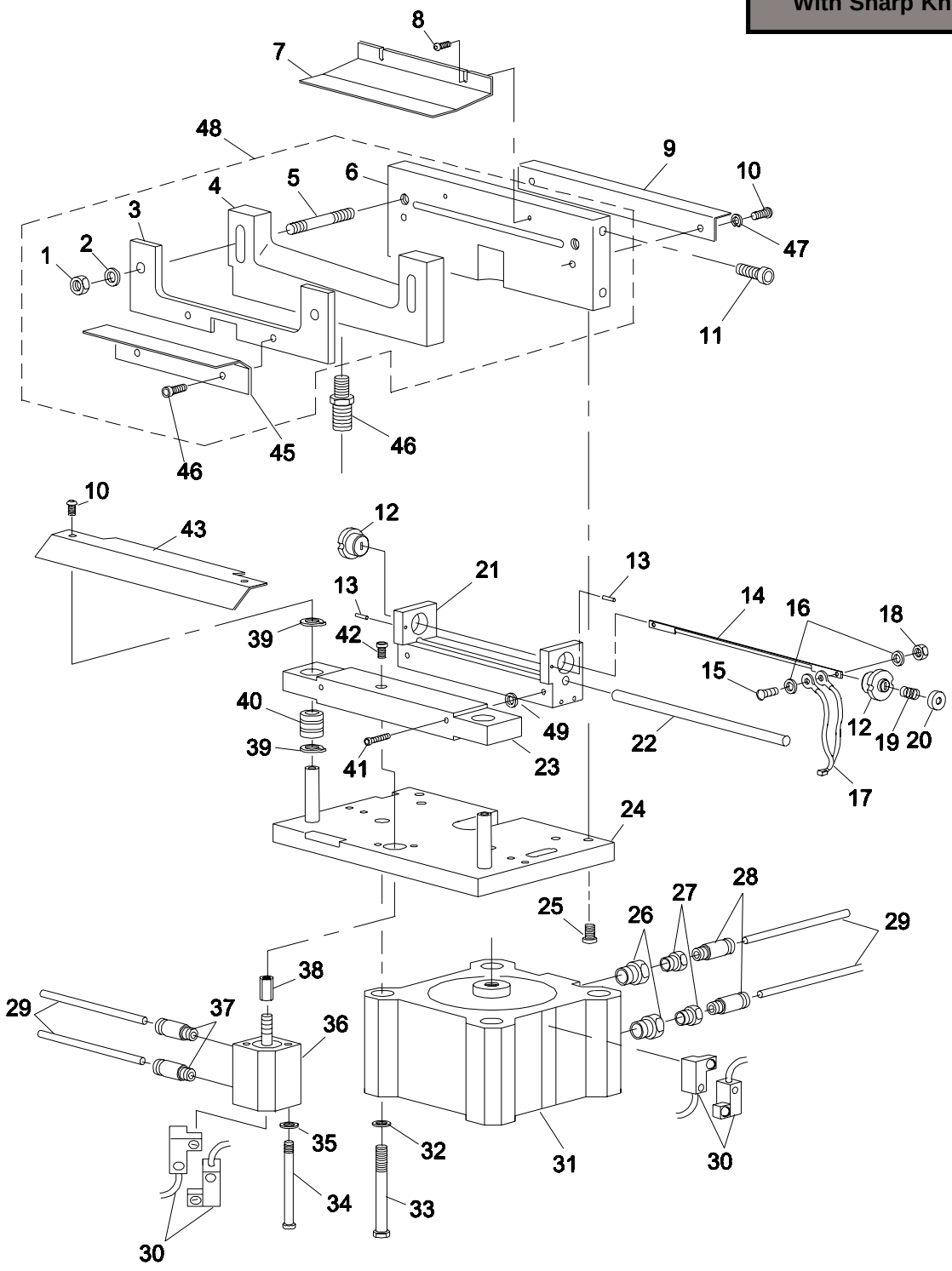
ITEM	PART NO.	DESCRIPTION	QTY.
1	4C2-144	Nut, Elastic Lock 5/16-24	2
2	12C15-46	Washer, Flat 5/16	2
3	79C12-416	Plate, Shear Wear	1
4	80C1-160	Knife, Chopper	1
5	15C13-0	Stud, Chopper Block	2
6	140C1-3	Body, Chopper	1
7	79C12-417	Plate, Upper Material Guide	1
8	307C10-1	Screw, Button Hd. 6-32 x 1/4	2
9	79C12-420	Roller Wiper	1
10	307C15-1	Screw, Button Hd. 10-32 x 1/4	4
11	308C18-9	Screw, Socket Hd. 1/4-20 x 1/2	4
12	21C2-12	Bushing, Insulated	2
13	17C15-123	Pin, Roll 3/32 x 5/16	2
14	80C1-161	Hot Knife	1
15	305C8-2	Screw, Binding Head #4-40 x 3/8	2
16	12C1-31	Washer, Lock #4 Internal Tooth	4
17	660C3-202	Terminal Wire	2
18	4C2-106	Nut, Mach. Screw Hex #4-40	2
19	34C1-63	Spring, Hot Knife	1
20	12C15-84	Washer, Spring Guide	1
21	32C1-23	Yoke, Hot Knife	1
22	113C3-17	Teflon Strip	1
23	119C4-79	Support, Hot Wire Yoke	1
24	729C5-14	Base, Yoke and Chopper Block	1

ITEM	PART NO.	DESCRIPTION	QTY.
25	308C18-10	Screw, Socket Hd. 1/4-20 x 7/8	2
26	21C10-3	Bushing, Adapter,3/8 to 1/4 NPT	2
27	21C10-4	Bushing, Adapter, 1/4 to 1/8 NPT	2
28	151C1-10	Push On Air Fitting, 1/8 NPT	2
29	73C7-208	Tubing, Nylon 5/32 O.D.	A/R
30	580C1-208	Magnetic Switch	4
31	275C1-5	Air Cylinder, Chopper Block	1
32	12C1-47	Washer, Lock 3/8	2
33	310C23-4	Screw, Socket Hd. 3/8-16 x 2-3/4	2
34	300C10-13	Screw, Round Hd. 6-32 x 2	2
35	12C1-22	Washer, Lock #6	2
36	275C1-4	Air Cylinder, Hot Wire	1
37	151C1-9	Push On Air Fitting, 10-32 NPT	2
38	55C4-154	Spacer, Hot Blade Piston	1
39	18C6-83	Retaining Ring	2
40	90C4-80	Bearing, Linear, Yoke	2
41	308C15-12	Screw, Socket Hd. 10-32 x 1	2
42	308C12-4	Screw, Socket Hd. 8-32 x 3/4	1
43	79C12-419	Chute, Material Guide	1
44	308C15-10	Screw, Socket Hd. 10-32 x 1/4	2
45	79C12-418	Plate, Lower Material Guide	1
46	15C13-2	Stud, Cylinder Rod	1
47	12C1-49	Washer, Lock #10	2
48	766C1-8	Chopper Block Assembly	1
49	12C11-83	Washer, Insulating	2

A/R - As Required

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

⚠ CAUTION
Cutter Block Equipped With Sharp Knife.



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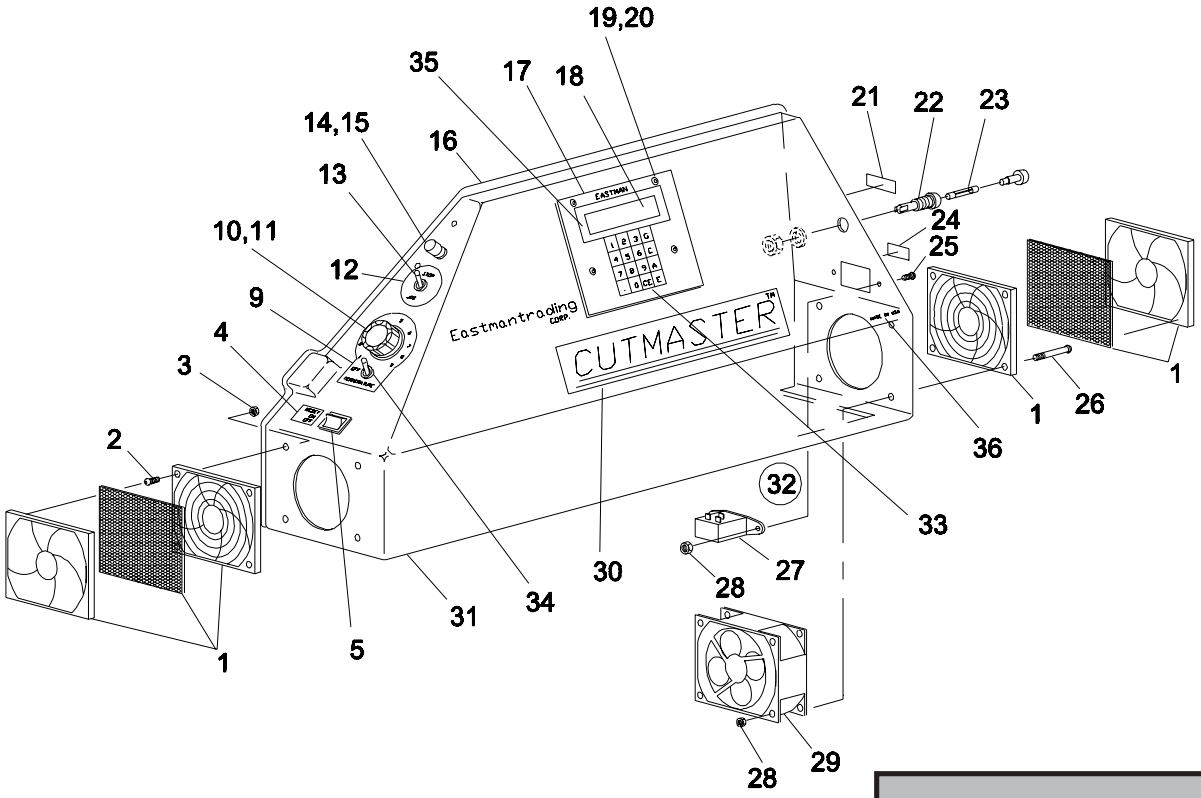
Front Cover Assembly



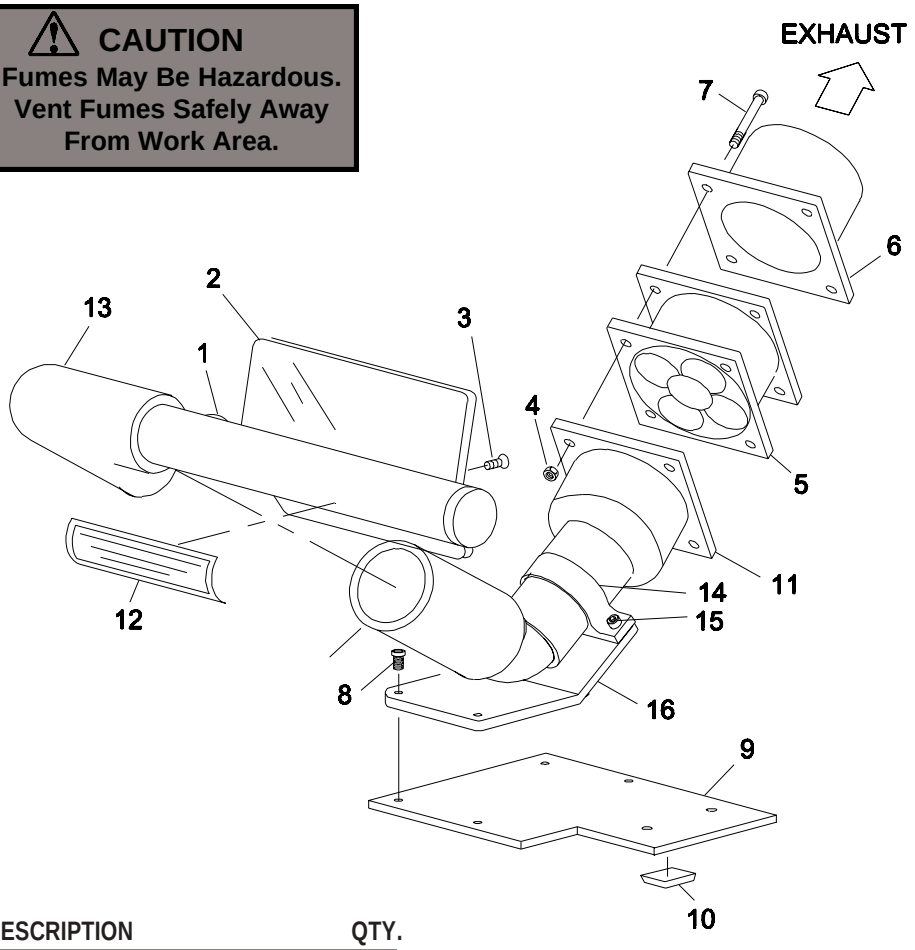
Power Cord Not Shown

ITEM	PART NO.	DESCRIPTION	QTY.
1	253C3-3	Cover & Filter, Fan	2
2	307C10-3	Screw, Button Hd., 6-32 x 5/8	4
3	4C2-82	Nut, Hex, 6-32	4
4	236C1-153	Label, Reset/On/Off	1
5	580C1-216	Switch	1
6	-	-	-
7	-	-	-
8	-	-	-
9	236C1-147	Label, Temp. Control	1
10	251C1-1	Heat Control Module	1
11	13C2-21	Knob, Temp. Control	1
12	236C1-146	Decal, Stop/Jog	1
13	580C1-206	Switch, Jog	1
14	580C1-205	Switch, Stop	1
15	86C7-48	Switch Cap, Red	1
16	87C1-42	Edge Molding (3 ft. lg.)	1
17	53C11-175	Keypad Cover	1
18	660C3-192	Display & Keypad Assembly (inches)	1
	660C3-200	Display & Keypad Assembly (metric)	1
19	55C4-162	Spacer	2

ITEM	PART NO.	DESCRIPTION	QTY.
20	308C8-3	Screw, Socket Hd., 4-40 x 3/4	4
21	236C1-155	Label, 10 Amp. Replacement	1
22	33C11-5	Fuse Holder, External	1
23	262C1-17	Fuse, 10 Amp slow blow	1
24	236C1-157	Label, Voltage 110 Volts	1
	236C1-159	Label, Voltage 220 Volts	1
25	300C8-2	Screw, Slotted, 4-40 x 1/2	2
26	306C8-4	Screw, Slotted, 4-40 x 1-3/4	4
27	253C1-1	Main Power Inlet, Filter Type	1
28	4C2-106	Nut , Locking #4-40	6
29	614C1-33	Fan 110 Volts	1
	614C1-35	Fan 220 Volts	1
30	236C1-156	Decal, CUTMASTER	1
31	53C11-176	Front Cover	1
32	145C1-9	Power Cord, 110 Volt	1
	523C1-93	Power Cord, 220 Volt	1
33	693C1-35	Keypad only	1
34	580C1-78	Hot Knife Switch	1
35	79C12-429	Face Plate	1
36	236C1-162	USA Decal	1

Fume Extractor

⚠ CAUTION
Fumes May Be Hazardous. Vent Fumes Safely Away From Work Area.



ITEM	PART NO.	DESCRIPTION	QTY.
1	161C1-7	Switch Magnet	1
2	73C9-9	Shield, Clear	1
3	319C89-1	Screw, Self Tap, #4 x 3/8	2
4	4C2-83	Nut, Hex 8-32	4
5	614C1-34	Fan, Fume Extractor	1
6	729C5-16	Vent Tube, Exhaust, 2-7/8 O.D.	1
7	300C12-107	Screw, Rd. Hd. 8-32 x 1-3/4	4
8	308C12-2	Screw, Socket Hd. 8-32 x 1/2	4
9	69C3-3	Mounting Plate, Fume Extractor	1
10	68C3-16	Rubber Feet	4
11	73C10-11	Fume Extractor Tube Assembly	1
12	236C1-152	Label, Caution	1
13	729C5-19	Shield Assembly	1
14	73C7-217	Tube Assembly Clamp	1
15	20C13-49	Screw, Socket Hd. 10-32 x 1/2	2
16	73C10-2	Fume Extractor Base	1

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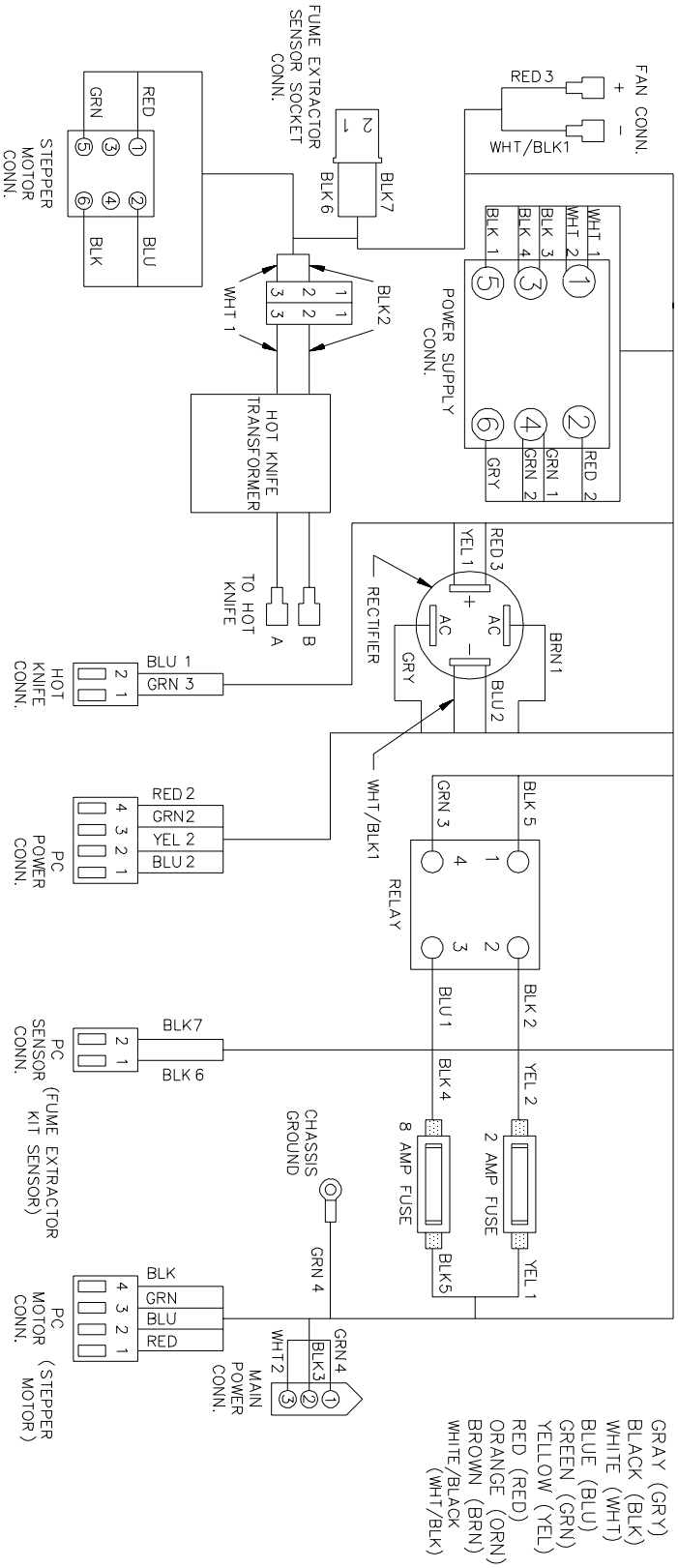
Wiring Diagram



Consult Factory

Troubleshooting Guide

Machine will not roll fabric	-Check if rollout bar is down. -Check rollout optic flag, make sure flag is not engaging with optic sensor (flag is located on left side of machine attached to rollout bar). -Check if fume extractor/guard is properly in place. -Check air connections, ensure that air (90 PSI) is entering machine. -Press RESET button & re-enter information on keypad. -Ensure that fabric is free of excess tension. -Check motor fuse.
Machine will not cycle shear knife.	-Check if fume extractor/guard is properly in place. -Check air connections, ensure that air (90 PSI) is entering machine. -Press RESET button & re-enter information on keypad.
Machine will not cycle hot knife.	-Check if fume extractor/guard is properly in place. -Check air connections, ensure that air (90 PSI) is entering machine. -Press RESET button & re-enter information on keypad. -Check if motion control air valves are adjusted properly.
Machine runs rough at high speeds or runs backwards.	-Press RESET button & re-enter information on keypad. -Press main power button off, then back on.
Hot knife does not heat.	-Check if fume extractor/guard is properly in place. -Check transformer fuse.
Machine does not cut proper lengths or consistent lengths.	-Check programming on keypad/display; enter new information to accommodate difference. -Check for proper tension on tension roller; adjust if necessary. -Ensure that fabric is threaded properly and free of excess tension. -Check that flex chain is threaded properly (located inside front cover).
Short pieces or very fine materials jam under upper material guide plate when cold cutting.	-Reduce speed of machine; set speed on keypad. -Check for proper threading of fabric.
Hot knife does not cut clean through fabric.	-Increase temperature control. -Slow down hot knife cutting motion by turning the "DOWN" air control valve clockwise.
Hot knife does not heat up properly for next cut cycle.	-Slow down "UP" motion by turning air control valve clockwise to allow hot knife time to recover heat. -Check for proper ventilation and keep any wind or drafts away from hot knife.

Troubleshooting Guide

Material bursts into flames during hot cutting stroke.	-Reduce temperature control.
Material strikes hot knife and jams under upper material guide plate.	-Lower upper material guide plate so that material is forced under hot knife.
Material sticks to upper material guide plate or material chute.	-Clean all surfaces and coat with anti-stick agent (WD-40). -For hot cutting, slow down the "UP" motion of hot knife to allow material time to cool slightly.
Hot knife does not travel to full UP or DOWN position.	-Check air connections, ensure that air (90 PSI) is entering machine. -Press RESET button & re-enter information on keypad. -Open UP or DOWN air control valves. -Check magnetic switches (pg. 13, #30), ensure not loose end and LED operating.
Keypad display shows error messages.	-Press the CE button on the keypad and re-enter new information for that line. -Press RESET button to reset computer; enter new information on keypad.
Jog switch does not function.	-Check if rollout bar is in down position. -Check if fume extractor is in proper position. -Check motor fuse. -Check rollout optic flag to be sure it does not engage sensor (located inside back cover).
No keypad display.	-Check if power cord is properly installed. -Check main power fuse in rear of front cover.
Fabric jams in slot between lower material guide plate and material chute.	-Change direction of fabric to feed from bottom of roll. -Ensure proper threading of fabric (see threading instructions). -Place tape over slot (cold cutting only).

TECHNICAL DATA
EASTMAN® CUTMASTER

Maximum Material Thickness ..... .3/16" (4.5 mm)
Maximum Material Width ..... 4" (101.6 mm)
Roll Capacity ..... 15" (380 mm)
(External mount required for larger rolls)
Maximum Piece Count ..... 999,999 pieces
Speed ..... Up to 140'/minute
Maximum Cutting Length ..... 999.99" (approx. 83 ft.)
End Accuracy* ..... +/- .01" (+/-.25 mm)
Machine Weight ..... Approx. 85 lbs. (38.5 kg)
Operating Voltage ..... 110V or 220V
Operating Pressure ..... 90 PSI
Volume of Air Service ..... 3 SCFM

Reference: Production Pieces Per Minute

Piece Length	Pieces/Min Cold	Pieces/Min Hot
1"	70	20
10"	30	10

*Relative to tpye and quality of fabric.

Limited Warranty. Eastman warrants to the buyer that the Cutmaster 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 to 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.

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Printed in U.S.A. 11/2005