



**ROUND KNIFE  
MACHINES**

**CLASS 534, 548  
AND 562**



**CAUTION**

**MACHINE EQUIPPED  
WITH  
SHARP BLADE**

**INSTRUCTION BOOK**

**Eastmanmachine  
COMPANY**

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EASTMAN DEPENDABILITY, EASTMAN QUALITY AND EASTMAN SERVICE ARE YOUR GUARANTEE THAT EASTMAN CUTTERS CUT CUTTING COSTS. THERE'S AN EASTMAN FOR EVERY CUTTING NEED.



## MAINTENANCE INSTRUCTIONS



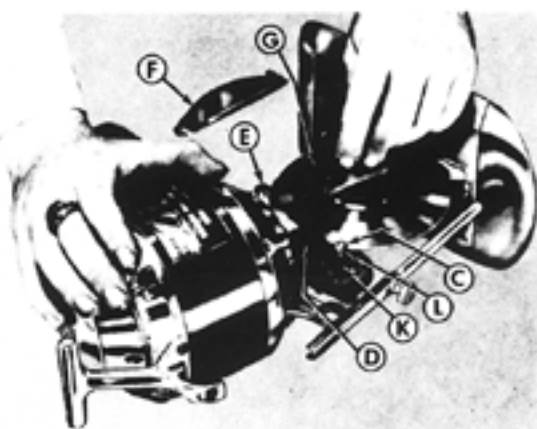
The purchaser must instruct all operators on the proper use of the equipment. All standard industrial safety measures and equipment should be provided to protect the operator. Operators must be cautioned that improper use of this equipment can cause bodily injury. If you do not have qualified operators 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. All Eastman machines shown in this catalogue are equipped with sharp blades and extreme caution should be used when this machine is put into use. Use control levers and handles only when operating or handling machine. When machine is not in operation the front knife guard should be kept in the lowered position. When making a cut the knife guard should be raised only enough to clear the material being cut. When this equipment is not being utilized, the power supply should be disconnected from the equipment.

### TO OPERATE MACHINE

Turn the switch to the on position; if cutter does not start immediately, return the switch to the off position. Check the line output and be sure that the unit is plugged in properly and is making full contact, then repeat procedure. Do not attempt to start this unit while it is in the material being cut.



SPANNER WRENCH

SMALL PIN

### WARNING

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

### MAINTENANCE PROCEDURES

- 1 Be sure that the rollers of the base plate 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.

### TO REPLACE THE KNIFE

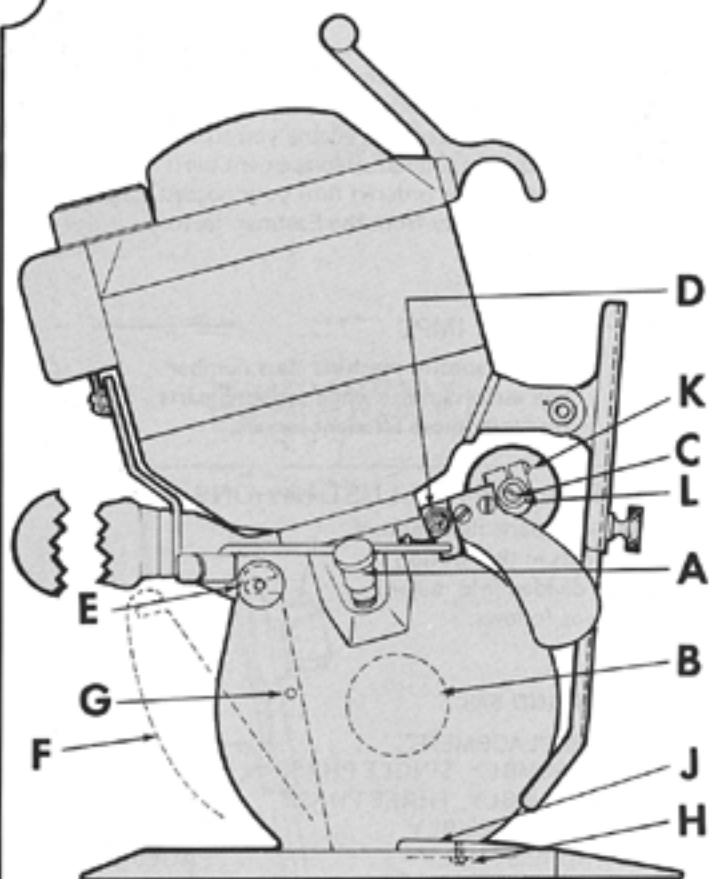
Loosen thumb screw "E" and swing guard "F" to outward position as shown on dotted lines. Turn the knife so the small hole lines up with hole "G" in the standard. Insert the small pin that is with the supplies in hole "G". Remove the lock nut that retains the blade with the special spanner wrench. When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

### CAUTION

Discard used sharp knives with care.

### TO ADJUST 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 retightened to accomplish this adjustment.



## CAUTION

Do not use sewing machine oil or detergent oil. It is entirely too light for cutting machine lubrication. For best results use specially compounded Eastman Oil or at least a good grade of No. 30 motor oil. Do not oil Base Plate Rollers.

## REPLACEMENT KNIVES

Knife Diameter	Carbon Steel	High Speed Steel	High Speed Steel Grooved	High Speed Steel Teflon Coated	Model Used On
3-1/2	80C1-26	-	-	-	-
4	80C1-50	80C1-59 HS	80C1-59 HSG	80C1-59 HST	534, 548
5	80C1-101	80C1-101 HS	80C1-101 HSG	80C1-101 HST	534, 548
5-1/4	80C1-61	80C1-61 HS	80C1-61 HSG	80C1-61 HST	548
6	80C1-39	80C1-39 HS	80C1-39 HSG	80C1-39 HST	548, 562
7-1/2	80C1-77/100	80C1-77/100 HS	80C1-77/100 HSG	80C1-77/100 HST	562

Knife Diameter	Carbon Slotted	Double-Bevel Hi-Speed
7-1/2	80C1-120	80C1-154

## LUBRICATION

### TWICE A DAY

Oil emery wheel spindles at "C".  
DO NOT USE AN EXCESS AMOUNT OF OIL.

### ONCE A DAY

Lubricate gears, screw grease cup "A" down one-half turn. Refill cup, as required with Eastman Gear Lubricant special formula (242C2).

### ONCE A MONTH

Grease knife gear bearing at "B", remove bearing locknut with spanner wrench and 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 bearing. Do not use Eastman Gear Lubricant for ball bearings or Eastman Lubriko grease for gears.

## 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 setscrew "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.

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