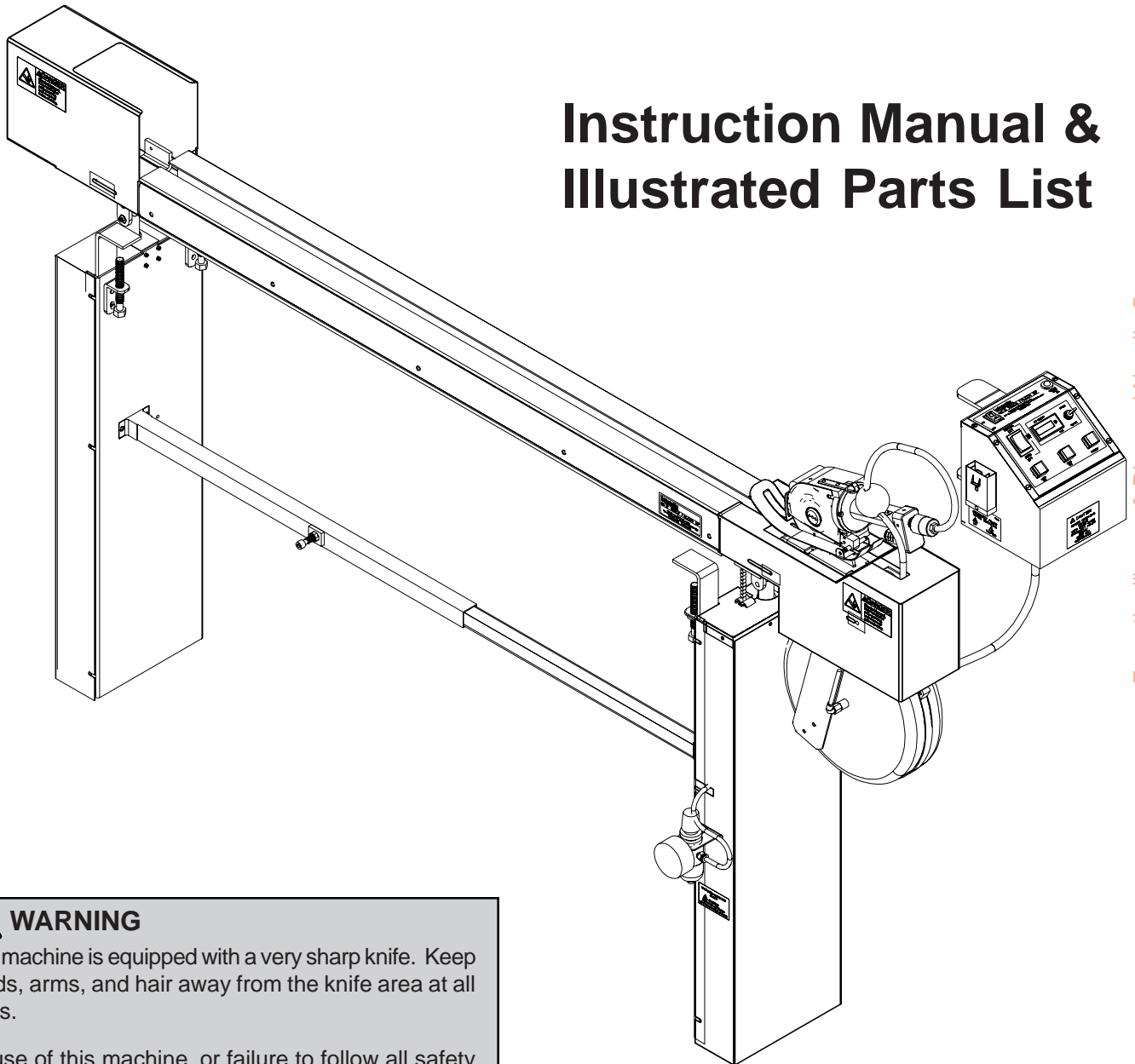


EASTMAN®

THE EASTMAN®
Auto Track Falcon
Pneumatic
MODEL ATF-IIP

Instruction Manual & Illustrated Parts List



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.

From the library of: Diamond Needle Corp

Eastman®
MANUAL CUTTING PRODUCTS

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

Website: www.EastmanCuts.com

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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.

The Auto Track Falcon IIP with Pneumatic Lift is designed to raise track with force. To prevent injury, all personnel should be instructed to wear safety glasses and stand well clear of track when in operation.

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.

From the library of: Diamond Needle Corp

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

The **Auto Track Falcon IIP** 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.

INSTALLATION

ATF-IIP System Installation

The ATF-IIP weighs approx. 130 lbs, (59 Kg.) uncrated for a 72" machine. Open shipping crate and inspect all parts as shown on Page 11.

The parts included are:

- (1) Part and Instruction Manual.
- (1) ATF-IIP Falcon Cutter.
- (1) Track Assembly.
- (1) Rear Lift Assembly & Cover or Rear Track Clamp.
- (1) Front Lift Assembly & Cover or Front Track Clamp.
- (2) Support Tubes.
- (1) Digital Control Box.
- (1) Control Box Harness.
- (1) Attachment Plug.
- (1) Hardware Package.
- (*)Optional Accessories.

Track & Lift Installation

Remove track from crate and place on table with track edge parallel to seam in your cutting table. Use a framing square, or similar tool to check machine for cut of fabric exactly as desired. Clamp the track to table. Remove the two track end covers to aid in installing the lift assemblies.

Remove the front and rear lift covers by loosening the (6) six screws on the side of each cover. Set covers aside. Mount the lift assemblies to the table as shown. Thread the lift chain through the support tubes and holes in the lift frames. Secure the support tubes in place. Raise the lift brackets to the track and secure the track to the lifting brackets. Feed the track wire/airline harness through the rubber grommet in operators side lift bracket. Connect the air lines and wires to the back of the lift assembly. Check label for proper locations. Install the lift chain as described in the lift chain replacement section on page 9. Replace covers.

Atf-IIP Falcon Cutter Installation



The cutter is equipped with a very sharp knife. Remove the knife when working in this area. Failure to keep hands, arms and hair away from the knife area may result in serious personal injury.

Place the cutting head on the track mount and secure in place with (2) two mounting screws. Holes are provided in the cover for easy access. Hook the air line strain relief ball to the cutter. Attach the airline to the cutter.

Control Box Installation

Clamp control box to the table in the desired location. Connect the large control box harness to the bottom of the control box and to the back of the lift assembly.

Air Line Hook-Up

The ATF-IIP requires a minimum 1/2" air supply line at 70-90 psi compressed air connected properly to the filter regulator. Locate the regulator on the front lift assembly and connect the air line with a 1/4 N.P.T. Quick Connect or equivalent.

Power Connection

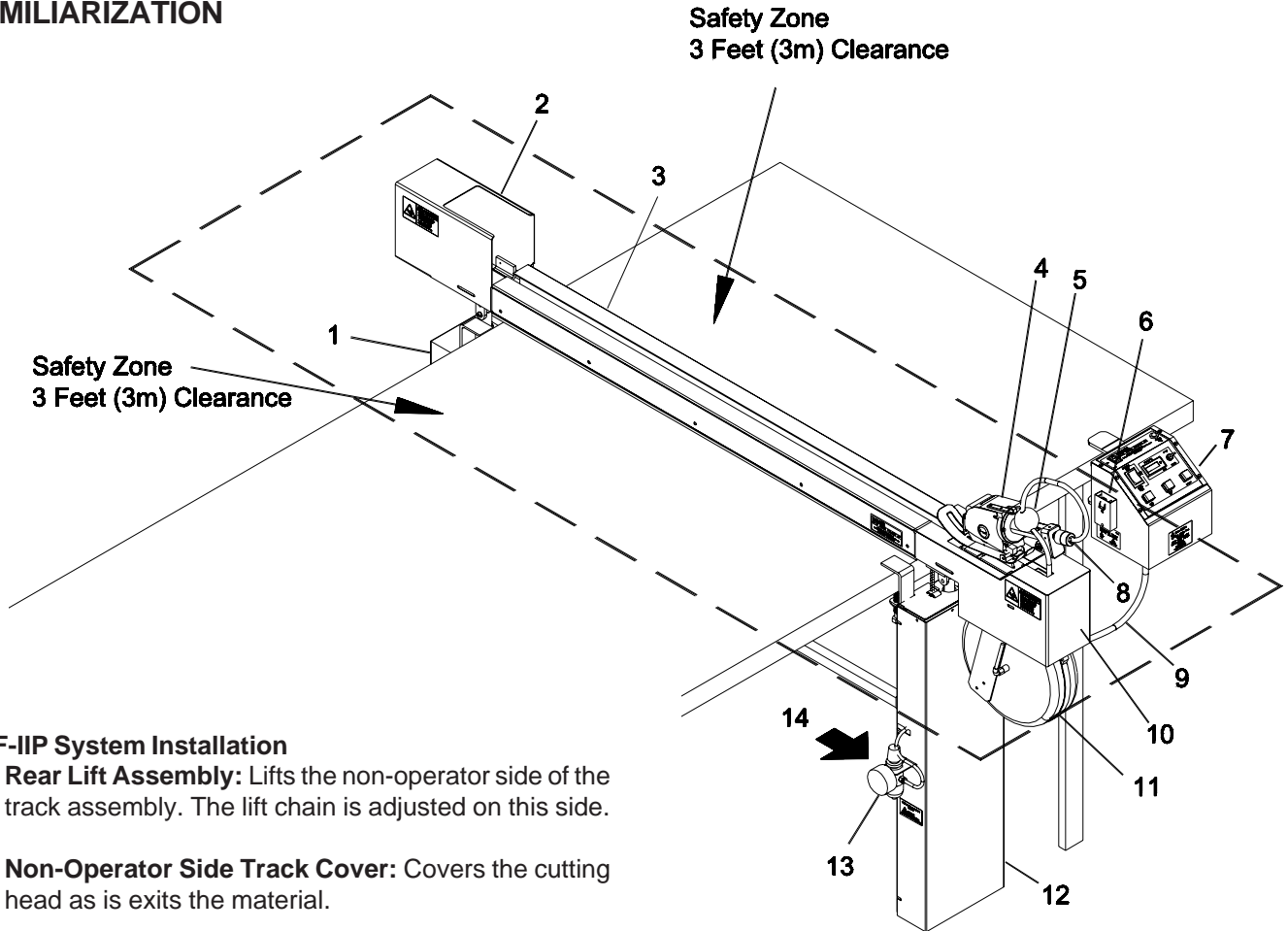


Check to be sure the power supply is the same voltage rating as stamped on the control box terminal block.

Note: Voltage varying more than 10% (11v for 110 volt machine, 22v for 220 volt machine) may damage your system's electronics.

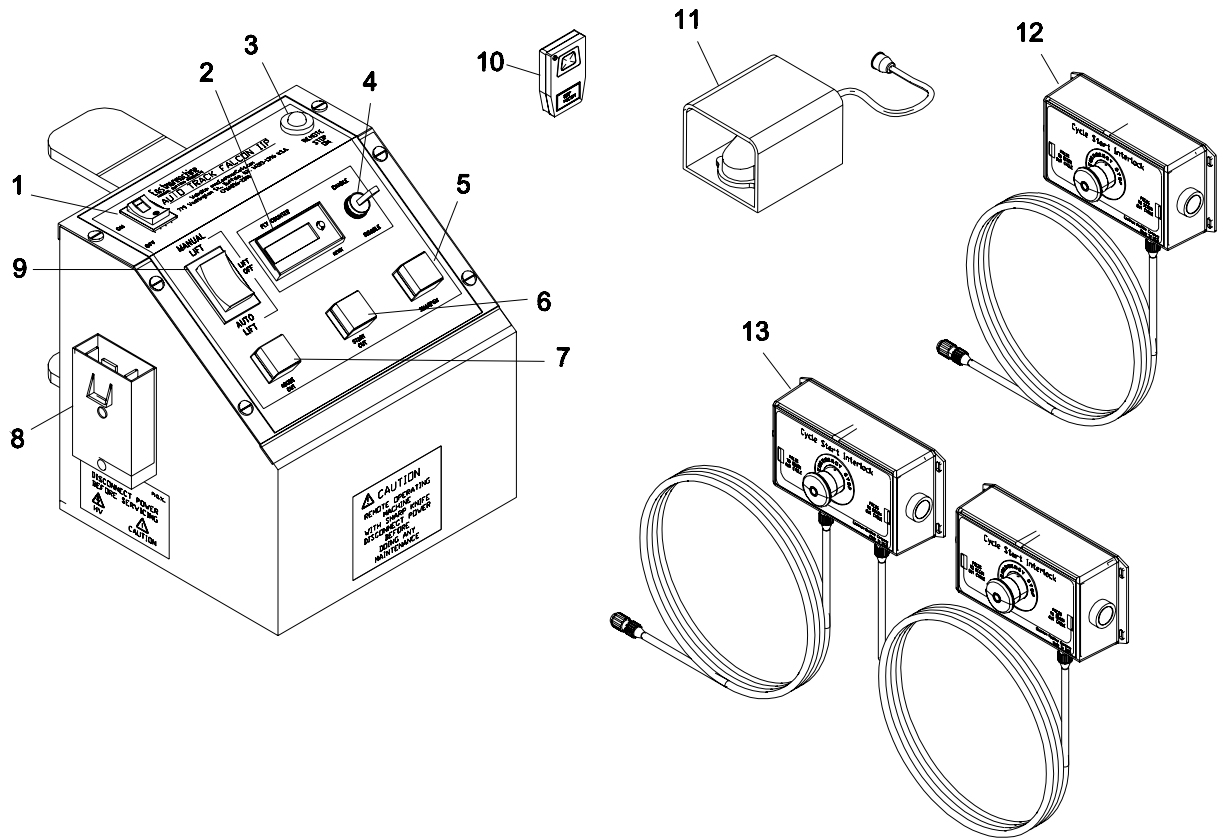
Electrical connections to this machine must be made by a qualified electrician familiar with applicable codes and regulations. To prevent electrocution, a ground lead must be connected to terminal "E" on the attachment plug. Refer to page 24 for electrical connection information.

FAMILIARIZATION



ATF-IIP System Installation

1. **Rear Lift Assembly:** Lifts the non-operator side of the track assembly. The lift chain is adjusted on this side.
2. **Non-Operator Side Track Cover:** Covers the cutting head as it exits the material.
3. **Track Assembly:** Moves the cutting head across the table to provide a straight cut through the material.
4. **Pneumatic 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).
5. **Strain Relief Ball:** Reduces strain on the air line connectors during the cut cycle.
6. **Electrical Terminal Block:** Electrical connection is made here. Check for proper voltage before connecting the attachment plug.
7. **Control Box:** Controls the operation of the cutting system. Note: Optional remote start devices available.
8. **Quick Disconnect:** Connects air supply to the cutting head. Allows for quick changing of the cutting.
9. **Control Box Harness:** Connects the control box to the front lift tower.
10. **Operator Side Track Cover:** Covers the home position on the track. Side access holes are provided for easy access to cutting head mounting bolts.
11. **Retractable Air Line Reel:** Provides air supply to cutting head while cutter moves across the track.
12. **Front Lift Assembly:** Lifts the operator side of the track assembly. Contains all air control valves required for operation.
13. **Filter Regulator:** Air supply connection is made here. Adjust Pressure as required. Auto drain feature removes moisture from incoming air supply.
14. **Compressed Air Source:** Proper air supply is essential for optimal performance. Requirements: 70-90 PSI Compressed Air @ 25 scfm.



Control Box

1. **Main Power:** Activates power to all circuits. Red light is on when switch is at ON position.
2. **Ply Counter:** Counts the number of plies cut. Press reset button to set count to zero.
3. **Remote Stop Indicator:** Red light is on when an optional remote stop button is depressed.
4. **Enable / Disable:** Enables the ply counter. Set to Disable to cut fabric flaws without changing the count.
5. **Sharpen:** Allows cutter blade to spin without traveling across the table. To sharpen knife, press button in and hold down button on side of Falcon Cutter with constant pressure. Hold for 10 seconds, then release.
6. **Start Cut:** Press button to begin cutting cycle.
7. **Abort Cut:** Press to stop cutting cycle and return cutter to home position.
8. **Terminal Block:** Connect electrical power here.
9. **Auto/Manual Lift:** Switches lift to Auto ,Off or Manual Lift Mode. Manual position will lift the track when pressed. Off position will disable the lift. Auto position will lift the track when the cutting head reaches the non-operator side of the track.
10. **Radio Remote Control Start:** (Optional) Press remote hand held "Start Cut" button to begin cutting cycle.
11. **Foot Pedal Start:** (Optional - not shown) Press with foot to begin cutting cycle.
12. **2-Button Cycle Start Interlock:** (Optional - not shown) Press and hold both green buttons to begin cut cycle. Press red emergency stop button to stop cut cycle and abort cut.
13. **4-Button Cycle Start Interlock:** (Optional - not shown) Press and hold (4) green buttons to begin cut cycle. Press red emergency stop button to stop cut cycle and abort cut.

OPERATION



CAUTION

Before connecting power supply, make sure voltage rating is same as stamped on terminal block. Damage to control unit may result if incorrect power supply is used.

Activate main power by pressing Power “ON-OFF” switch to ON position. The power light will go on. Connect air supply line to the filter regulator. Adjust pressure as required.

Check the Lift switch for desired position. Check the Ply Counter; reset to zero if required. Check the enable/Disable switch for desired position. Cutting can now take place.

Pull material to desired length beyond track. Press start button on control box or remote start (optional). Falcon Cutter will start and travel down the track. When cutter stops and reverses, the lift mechanism raises track and drops down to clamp end of material. Counter records each complete cycle.



WARNING

The air lift is designed to raise track with force. To prevent injury, personnel should stand well clear of track when in operation. All operators should be trained in the operation of the machine prior to use.

IMPORTANT: To stop the Auto Track Falcon IIP at any point during operation, press the power ON-OFF switch to OFF position or hit the optional emergency stop button located on the cycle interlock box.
To resume cutting, press power ON-OFF switch to on position then press start cut.

Non-Lift Type Operation

The Non-Lift Auto Track Falcon IIP operates in the same manner as with lift except the track is permanently mounted to the table and will not lift to clamp the fabric.

OPERATING ADJUSTMENTS

This machine is adjusted and tuned at the factory for optimal performance. No adjustments other than normal setup are necessary. However, if after continued use the performance level becomes unacceptable, the following procedures should be carried out before repairs are considered.

Travel Cut Speed

The cutting speed will vary depending on material to be cut. To adjust cutting speed, locate the “Speed Control Valve” on the non-operator side track. Using a screwdriver, turn the screw counterclockwise to increase the speed of cutter moving down the track and clockwise to decrease speed. If cutter tends to lag when cutting, less speed is required.

Air Regulator (System 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.

Lift Pressure Regulator

Located under the front lift cover. The lift pressure regulator, when adjusted properly will produce a quiet, smooth lifting motion. Using an allen wrench; adjust pressure by turning clockwise to increase pressure and counterclockwise to decrease pressure. After adjustment is made, tighten locking cap in place.

Down Speed

Located on the on the air cylinder, behind the front lift cover. The speed control valve adjusts the down speed of the lift. To adjust, remove the front cover and locate the speed control valve. Turn screw counterclockwise to increase speed or clockwise to decrease down speed.



CAUTION

Improper adjustment can cause personal injury or damage to your machine. Adjustment should be made by qualified personnel.

MAINTENANCE

NOTE: All maintenance procedures may be performed with cutting head installed in track. It is not necessary to remove Falcon from Auto Track IIP mechanism.

CAUTION

Before performing any of the following procedures, make sure that the attachment plug and air line 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 and air line is disconnected from air 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.**

Knife Sharpening


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

WARNING

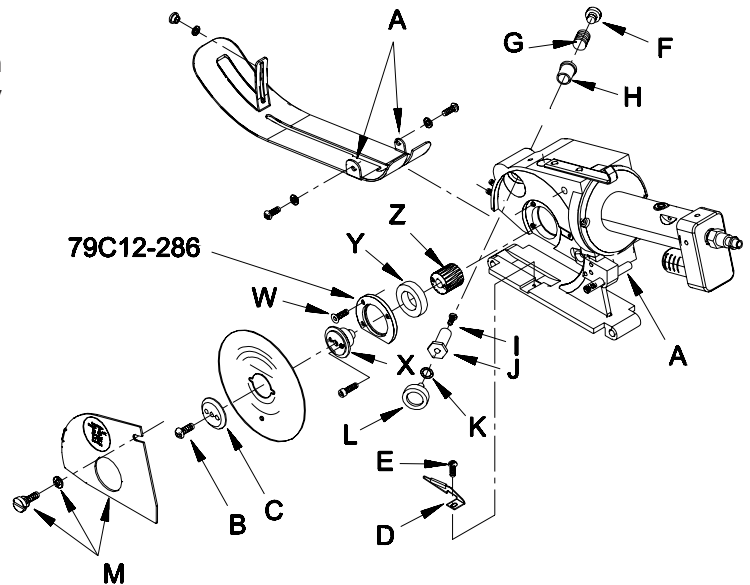
Before performing any of the following procedures, make sure that the attachment plug and air supply is disconnected from the system.

Knife Replacement

Remove pressure foot from knife standard by removing two (2) screws and two (2) washers at "A". Remove thumb nut at front of cutter. Remove side knife cover "M". Place small drift pin or screwdriver through hole in knife to prevent rotation. Remove knife bolt "B" and knife flange cover "C". Carefully lift out and discard used knife blade.

 **Warning:** Discard used knife with care!

Insert new knife blade, bevel side in, by sliding it under shear plate "D". Make sure slots in knife align with tabs on knife hub



and that knife is seated flush on hub. Replace all parts in reverse order and check that all fasteners are tightened securely before resuming operation.

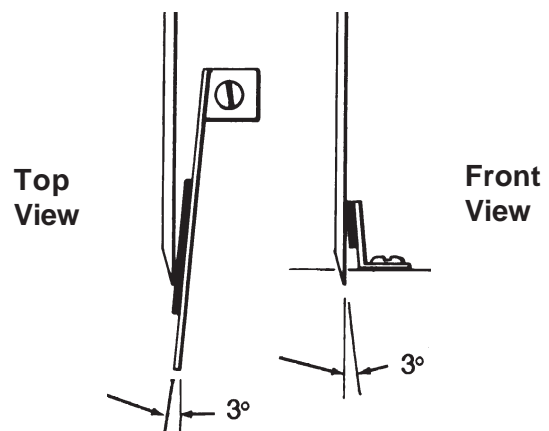
NOTE: It is not necessary to remove cutting machine from track or shear plate from machine when replacing knife.

Shear Plate Replacement

Remove knife as described above. Align Falcon Cutter with screw "E" accessible thorough slot in track. Remove screw "E" and shear plate "D". Replace with new shear plate and reassemble in reverse order. Adjust shear plate and check tightness of "E" before resuming operation.

Shear Plate Adjustment

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



Sharpener Replacement

Remove knife as described above. Insert screwdriver into slotted head of sharpener button "F" and hold bushing "J" in place. Turn screw counterclockwise to remove button "F" and spring "G". Remove screw "I" to separate bushing "J", spring washer "K" and emery wheel "L". Replace emery wheel and reassemble in reverse order. Check that screw "F" is tightened securely.

Lubrication of Knife Gear

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

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

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

Control Box Fuse Replacement

The Fuse is located on the control board inside the control box. Remove (6) screws holding the control panel. Swing open the control panel. Remove the old fuse and replace with fuse of identical rating.

Lift Chain Replacement and Adjustment

Remove the front and rear lift covers. Loosen front and rear chain clamps "C" and remove old lift chain. Insert end of lift chain (701-25) under front chain clamp "C" and secure. Thread chain under front idler sprocket "A", over idler sprocket "B" and under rear chain clamp. With track sitting on table, pull chain hand tight and secure chain clamps. If required, loosen clamp collar "D", pull clamp collar hand tight and secure clamp collar to remove any excess slack in chain. Replace front and rear lift covers.

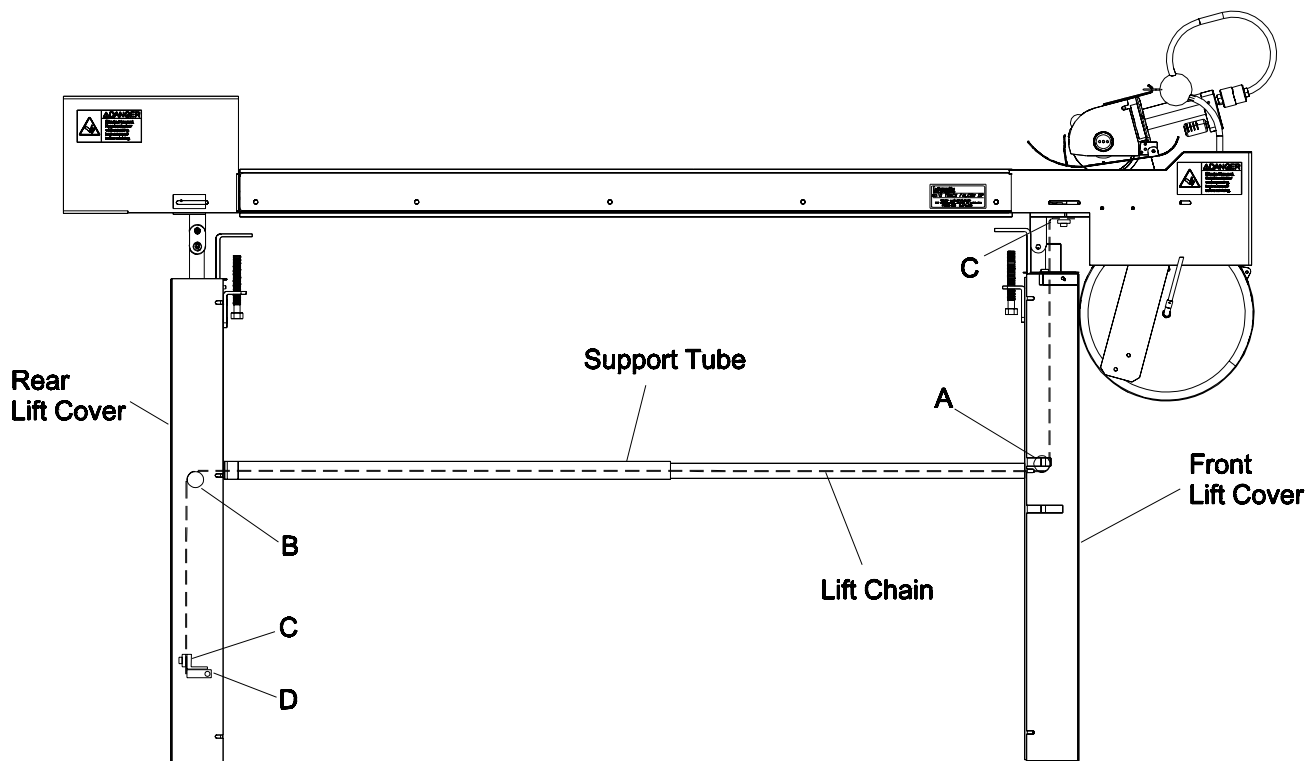
Service

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 **Auto Track Falcon IIP** 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.

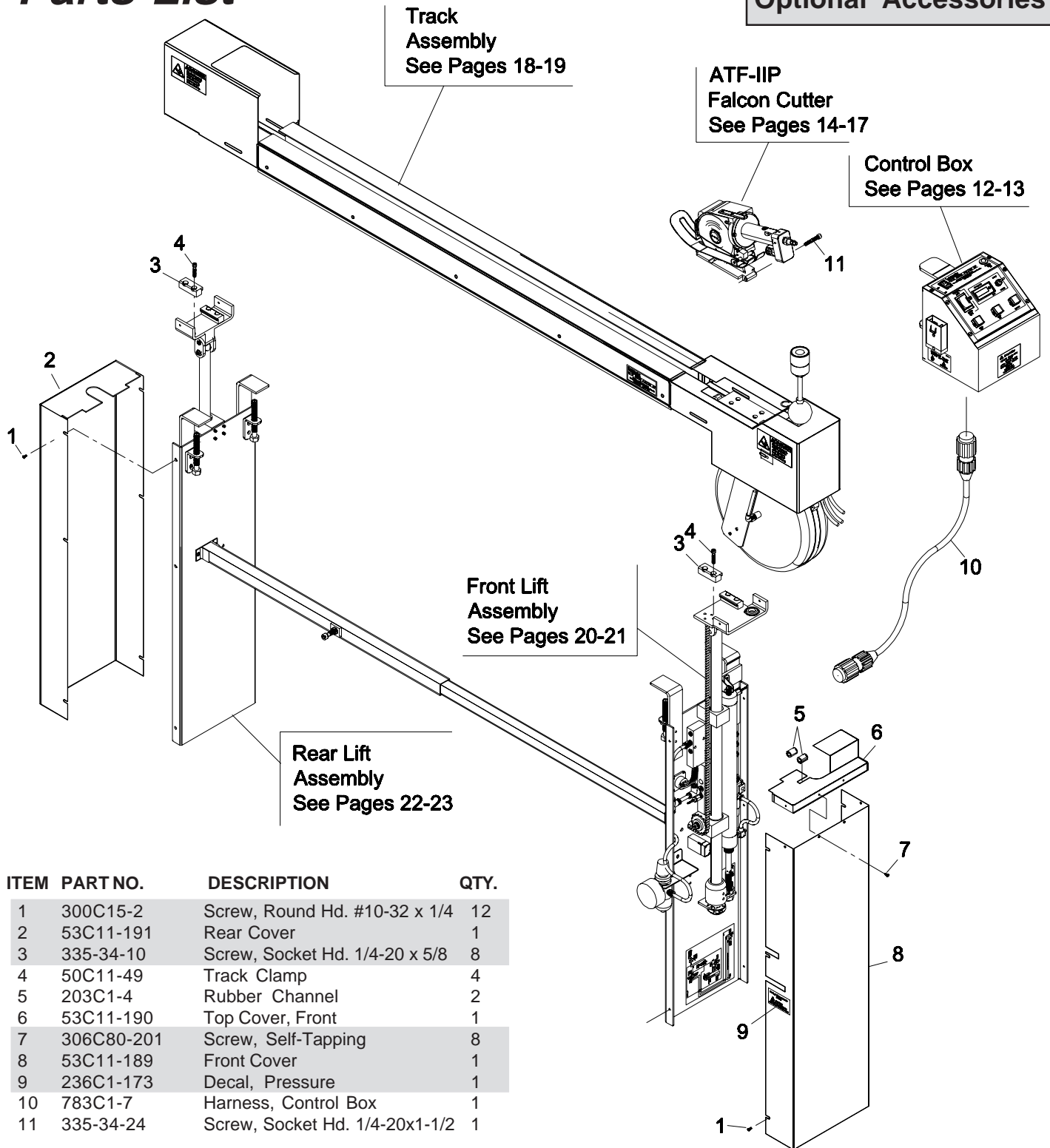
IMPORTANT: Always specify machine model and serial number when ordering parts for faster more efficient service.

TROUBLESHOOTING

Problem	Solution
Cutter does not return after cut	a) Away limit switch to close to end of track; move switch closer to center of track. b) Loose connection; check away limit switch connection.
Sharpen switch inactive	a) Home limit switch to close to end of track; move switch closer to center of track (approx. 3 1/4"). b) Loose connection; check home limit switch connection.
Counter double counts	a) Away limit switch to close to center of track; move switch closer to end of track (approx. 3 1/4").
Track lifts slow or late	a) Low lift pressure; Increase lift pressure located inside front tower.
Track will not lift in auto	a) Damaged up limit switch; inspect connections and replace up limit switch.
Track will not lower in auto	a) Damaged up limit switch; inspect connections and replace up limit switch. b) Improper cam setting in front tower; adjust as required.
Track lifts with excess force	a) High lift pressure setting; decrease lift pressure located inside front tower.
Track lifts unevenly	a) Loose lift chain; level track and tighten lift chain.
Cutter does not turn	a) Low system air pressure; increase air pressure at filter/regulator. b) Loose connection; check control box harness connection. c) Heavy shear plate pressure; release shear plate pressure by adjusting shear plate.
Cutter moves but returns immediately	a) Loose connection; check away limit switch connection. b) Damaged away limit switch; replace limit switch.
Cutter pushes material when cutting	a) Travel speed too fast; decrease cutter travel speed. b) Dull cutter blade; sharpen blade.
No response from control box	a) Machine not plugged into power source; connect attachment plug. b) Improper power supply; check for proper supply voltage. c) Blown fuse; replace fuse located in control box. d) No air pressure; check air pressure to machine.
Remote Stop light on	a) Remote stop activated; check cycle start interlock boxes. b) Remote interlocks improperly connected; check connections. c) Wrong switch setting on PC board; check switch setting in control box.

Illustrated Parts List

See Page 25-26
for
Optional Accessories



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ITEM	PART NO.	DESCRIPTION	QTY.
1	300C15-2	Screw, Round Hd. #10-32 x 1/4	12
2	53C11-191	Rear Cover	1
3	335-34-10	Screw, Socket Hd. 1/4-20 x 5/8	8
4	50C11-49	Track Clamp	4
5	203C1-4	Rubber Channel	2
6	53C11-190	Top Cover, Front	1
7	306C80-201	Screw, Self-Tapping	8
8	53C11-189	Front Cover	1
9	236C1-173	Decal, Pressure	1
10	783C1-7	Harness, Control Box	1
11	335-34-24	Screw, Socket Hd. 1/4-20x1-1/2	1

MS - Machine Size

Eastman
MANUAL CUTTING PRODUCTS

Control Box

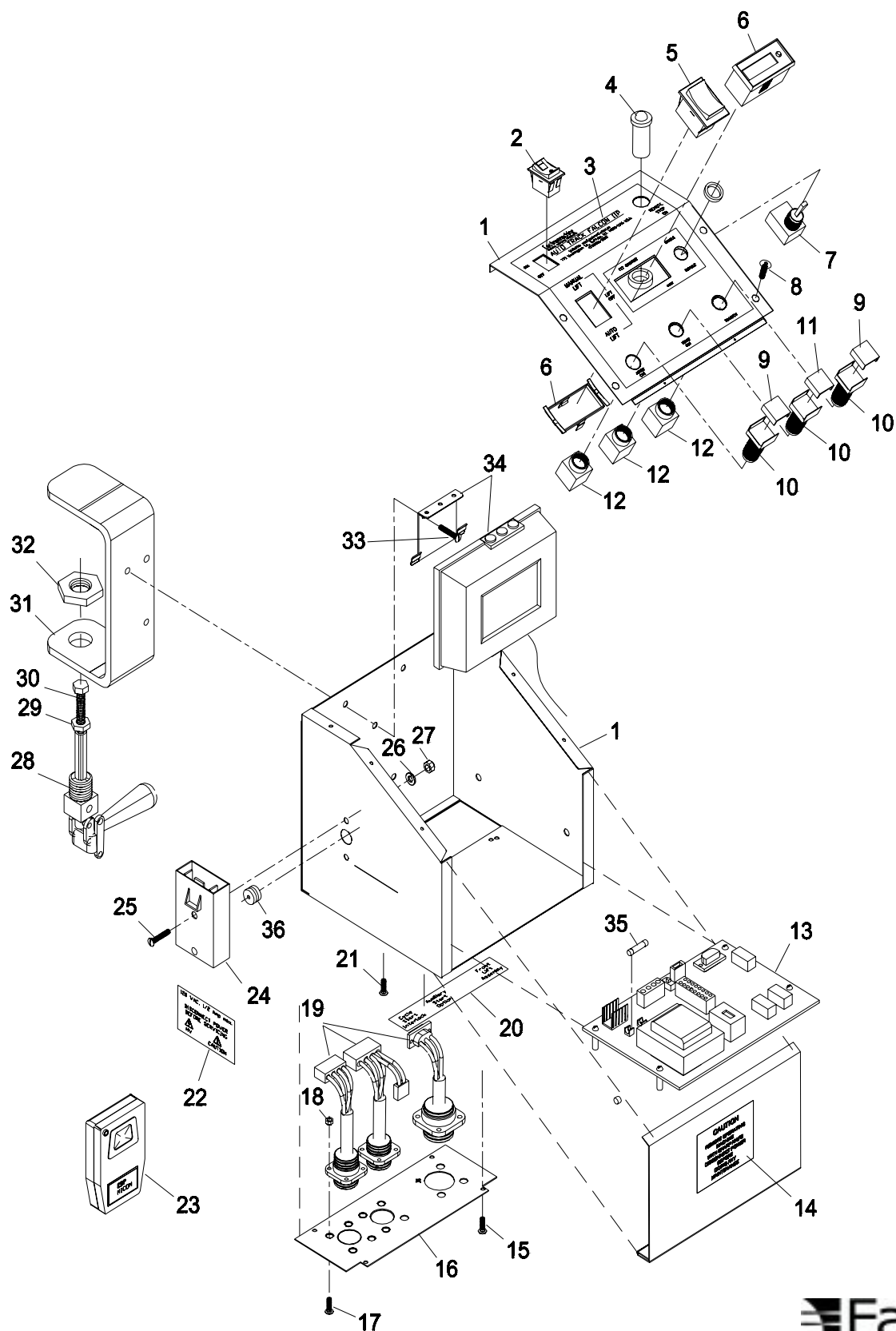
707C2-16-110**707C2-16-220**

ITEM	PART NO.	DESCRIPTION	QTY.
1	182C14-15	Control Box, (Shell only) ATF-IIp	1
2	11-4188	Switch, Main Power	1
3	236C1-170	Decal Sheet, ATF-IIp	1
4	31-27003	Indicator Light, Red	1
5	580C1-217	Switch, Lift	1
6	194C1-6	Counter	1
7	11-4185	Counter Switch, Enable/Disable	1
8	306C80-203	Self Tapping Pan Hd.	6
9	11-4194	Lens, White	2
10	11-4190	Actuator, Switch	3
11	11-4195	Lens, Green	1
12	11-4192	Contact Block	3
13	660C4-20	PC Board Assembly, ATF-IIp	1
14*	236C1-110	Label, Caution	1
15	300C10-2	Screw, Round Hd. #6-32 x 1/4	4
16	276C2-40	Plate, Control Box Connectors	1
17	300C10-4	Screw, Round Hd. #6-32 x 3/8	12
18	203-86	Nut, Hex #6-32	16
19	660C3-213	Connection Plate Harness Kit	1
20	236C1-170	Decal Sheet, ATF-IIp	1
21	300C10-2	Screw, Round Hd. 6-32 x 1/4	4
22	236C1-170	Decal Sheet, ATF-IIp	1
23*	273C1-2	Remote Control (optional)	1
24	508C1-102	Terminal Block, Ass'y 110 V	1
	508C1-101	Terminal Block, Ass'y 220 V	1
25	302C15-8	Screw, Flat Hd.#10-32 x 1 1/8	2
26	402-010	Washer, Lock #10	2
27	203-102	Hex Nut, #10-32	2
28	9088-006	Clamp Push/Pull 3/4" Dia.	1
29	203-36	Nut, Hex 5/16-18	1
30	335-36-36	Screw, Socket Hd. 5/16-18x2-1/4	1
31	BC-30436	Clamp Support Bracket	1
32	217-52	Nut, Lock 3/4-16	1
34*	830C1-89	Wireless Receiver	1
35	11-1335	Fuse, MDQ-3/10 amp.	1
36	9015-006	Grommet	1

* Indicates Optional Items

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.



ATF-IIP Falcon Cutter

519C1-1507

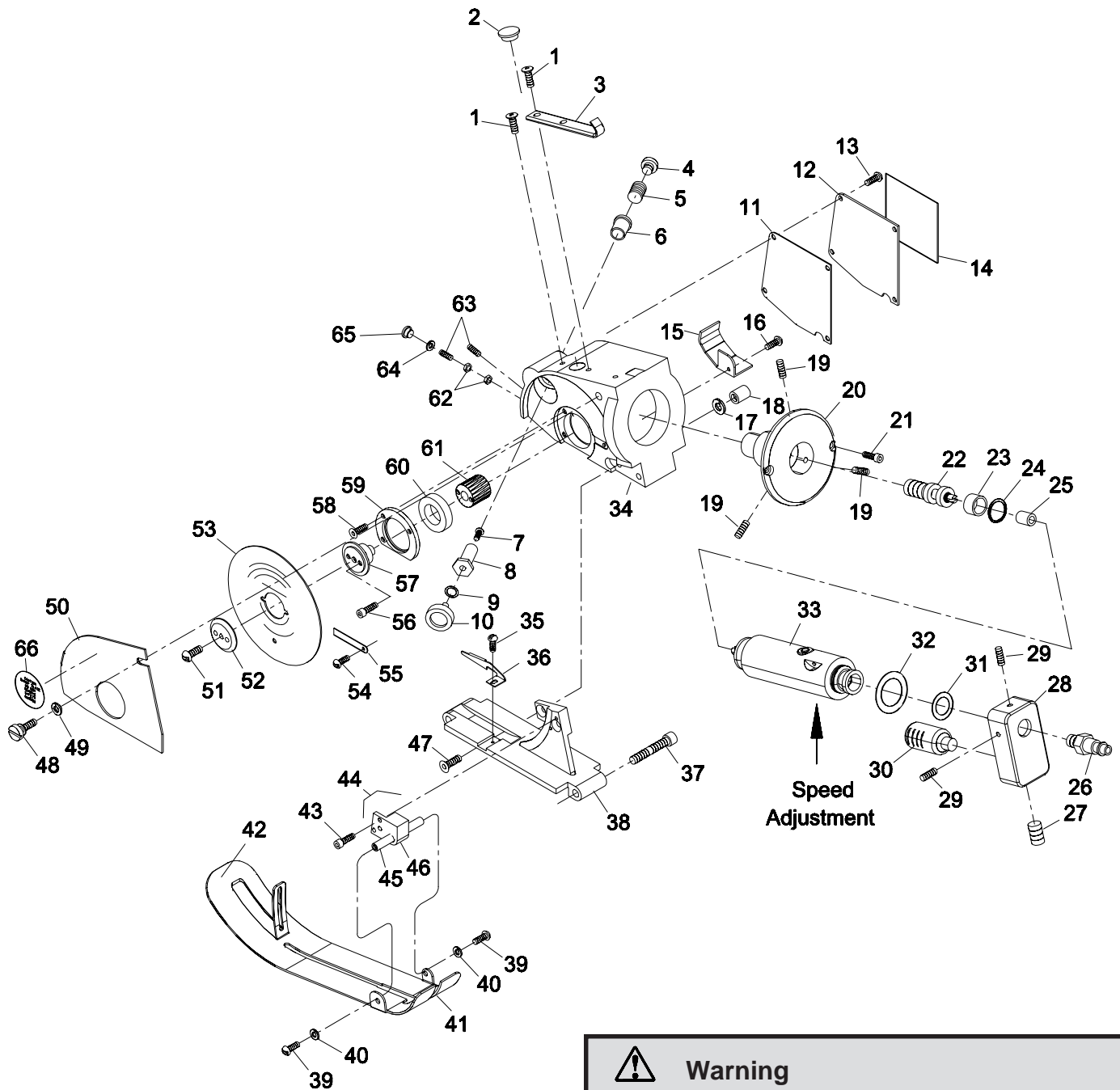
ITEM	PART NO.	DESCRIPTION	QTY.
1	333-102-8S	Screw, Button Hd. #10-32 x 1/2	3
2	54C4-44	Snap Hole Plug	1
3	33C10-70	Strain Relief Hook	1
4	20C12-160	Sharpener Screw	1
5	34C10-158	Sharpener Spring	1
6	21C6-4	Sharpener Bushing	1
7	301C10-9	Screw, Fillister #6-32 x 3/16	1
8	21C5-5	Sharpener Bushing, Hex	1
9	12C15-57	Spring Washer	1
10	541C1-17	Emery Wheel	1
11	8C15-4	Side Cover Gasket	1
12	53C2-113	Side Cover	1
13	305C8-1	Screw, Binding Hd. #4-40 x 1/4	7
14	236C1-110	Label, Caution	1
15	53C2-131	Cover, Switch Hole	1
16	301C8-6	Screw, Fillister Hd. #4-40 x 3/16	1
17	12C1-49	Washer, Lock #10	2
18	4C1-197	Nut, #10-32 Allen	2
19	20C13-78	Setscrew, #8-32 x 1/4	3
20	29C6-184	Housing Adaptor	1
21	335-93-8	Screw, Socket Hd. #8-32 x 1/2	2
22	653C1-5	Worm, Shaft & Bearing Assembly	1
23	55C4-98	Spacer, Bearing	1
24	18C6-35	Snap Ring, Internal	1
25	822C1-1	Coupling, Shaft	1
26	100-11-3	Quick Disconnect, Male	1
27	27-H0409	Plug, 1/8 npt	1
28	67C6-12	Muffler Mount	1
29	309C15-2	Setscrew, #10-32 x 1/4	2
30	251C3-7	Muffler/Silencer, 1/8 npt	1
31	116C3-16	Gasket Ring, Small	1
32	116C3-15	Gasket Ring, Large	1
33	517C1-842-3	Air Motor, .1 hp.	1

ITEM	PART NO.	DESCRIPTION	QTY.
34	528C4-11	Housing With Cover Assembly	1
35	305C8-4	Screw, Binding Hd. #4-40 x 1/8	1
36	726C1-28	Shear Plate With Blank	1
37	335-34-24	Screw, Socket Hd. 1/4-20 x 1-1/2	2
38	505C2-109	Base Plate, Quick Change	1
39	300C12-2	Screw, Round Hd. #8-32 x 1/4	2
40	12C1-21	Washer, Internal Locking, #8	2
41	68C2-17	Pressure Foot	1
42	211C1-12	Tape, Warning Orange	1
43	308C10-2	Screw, Socket Hd. #6-32 x 1/2	2
44	833C6-3	Bracket Ass'y, Pressure Foot	1
45	55C4-105	Handle Lever Spacer	1
46	62C2-2	Pressure Foot Bracket	1
47	302C15-19	Screw, Flat Hd. #10-32 x 1	2
48	20C7-1	Thumb Screw	1
49	12C1-49	Washer, Lock #10	1
50	25C4-195	Side Knife Guard	1
51	300C15-3	Screw, Round Hd. #10-32 x 3/8	1
52	53C11-107	Knife Flange	1
53	80C1-141	4" Knife, Carbon	1
54	305C8-2	Screw, Binding Hd. #4-40 x 3/8	1
55	79C12-317	Lint Deflector	1
56	301C5-1	Screw, Fillister Hd. #3-48 x 3/4	2
57	83C4-26	Knife Flange	1
58	302C8-1	Screw, Flat Hd. #4-40 x 3/8	3
59	79C12-286	Bearing Retainer Plate	1
60	90C6-53	Ball Bearing, Knife Flange	1
61	87C7-37	Fibre Knife Gear	1
62	4C2-82	Nut, Hex #6-32	2
63	20C13-56	Setscrew, #6-32 x 3/4	2
64	12C15-95	Washer, Flat #6	1
65	20C5-21	Clamp Screw	1
66	79C2-61	Decal, Guard Caution	1

From the library of: Diamond Needle Corp

NOTE:

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



From the library of: Diamond Needle Corp



Warning

This machine is equipped with a very sharp knife. Remove the knife when working in this area. Failure to keep hands, arms and hair away from the knife area may result in serious personal injury.

Always handle knives with care. Safely dispose of used knives.

ATF-IIP Falcon Heavy Duty Cutter

519C1-1509

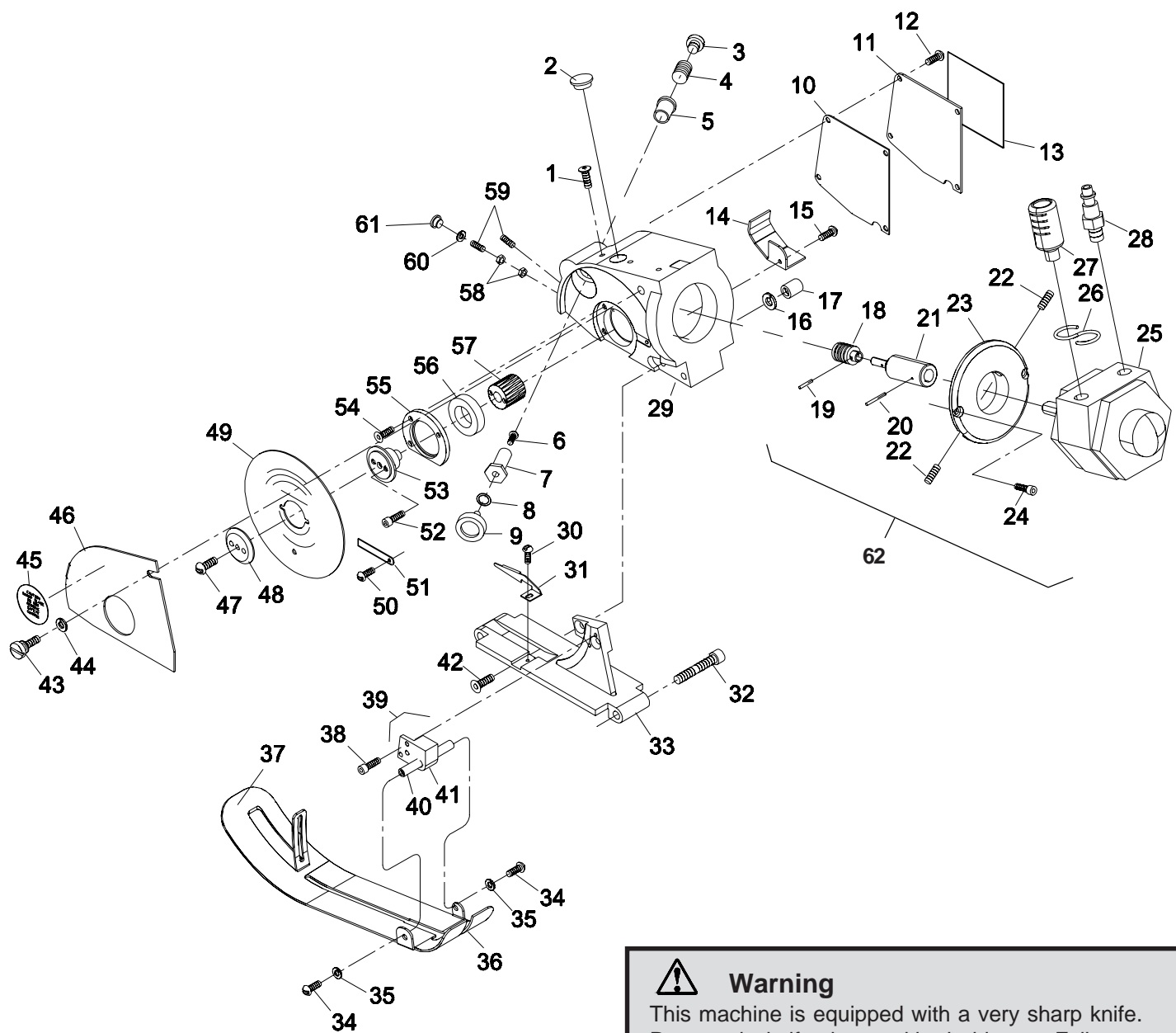
ITEM	PART NO.	DESCRIPTION	QTY.
1	333-102-8S	Screw, Button Hd. #10-32 x 1/2	3
2	54C4-44	Snap Hole Plug	2
3	20C12-160	Sharpener Screw	1
4	34C10-158	Sharpener Spring	1
5	21C6-4	Sharpener Bushing	1
6	301C10-9	Screw, Fillister #6-32 x 3/16	1
7	21C5-5	Sharpener Bushing, Hex	1
8	12C15-57	Spring Washer	1
9	541C1-17	Emery Wheel	1
10	8C15-4	Side Cover Gasket	1
11	53C2-113	Side Cover	1
12	305C8-1	Screw, Binding Hd. #4-40 x 1/4	7
13	236C1-110	Label, Caution	1
14	53C2-131	Cover, Switch Hole	1
15	301C8-6	Screw, Fillister Hd. #4-40 x 3/16	1
16	12C1-49	Washer, Lock #10	2
17	4C1-197	Nut, #10-32 Allen	2
18	87C7-45	Worm Gear	1
19	17C15-133	Rollpin 1/16 X 3/8	1
20	511-2-10	Rollpin 1/16 X 5/8	1
21	11C12-136	Extension Shaft	1
22	309C18-3	Setscrew, #1/4-28 x 1/4	2
23	29C6-185	Housing Adaptor, HD. Motor	1
24	336-93-10	Screw, Socket Hd. #8-32 x 5/8	2
25	517c1-1283	HD. Air Motor, Atf-iip	1
26	50C11-50	S-Hook	1
27	251C3-7	Muffler/Silencer, 1/8 npt	1
28	100-11-3	Quick Disconnect, Male	1
29	528C4-11	Housing With Cover Assembly	1
30	305C8-4	Screw, Binding Hd. #4-40 x 1/8	1
31	726C1-28	Shear Plate With Blank	1

ITEM	PART NO.	DESCRIPTION	QTY.
32	335-34-24	Screw, Socket Hd. 1/4-20 x 1-1/2	2
33	505C2-109	Base Plate, Quick Change	1
34	300C12-2	Screw, Round Hd. #8-32 x 1/4	2
35	12C1-21	Washer, Internal Locking, #8	2
36	68C2-17	Pressure Foot	1
37	211C1-12	Tape, Warning Orange	1
38	308C10-2	Screw, Socket Hd. #6-32 x 1/2	2
39	833C6-3	Bracket Ass'y, Pressure Foot	1
40	55C4-105	Handle Lever Spacer	1
41	62C2-2	Pressure Foot Bracket	1
42	302C15-19	Screw, Flat Hd. #10-32 x 1	2
43	20C7-1	Thumb Screw	1
44	12C1-49	Washer, Lock #10	1
45	79C2-61	Decal, Guard Caution	1
46	25C4-195	Side Knife Guard	1
47	300C15-3	Screw, Round Hd. #10-32 x 3/8	1
48	53C11-107	Knife Flange	1
49	80C1-141	4" Knife, Carbon	1
50	305C8-2	Screw, Binding Hd. #4-40 x 3/8	1
51	79C12-317	Lint Deflector	1
52	301C5-1	Screw, Fillister Hd. #3-48 x 3/4	2
53	83C4-26	Knife Flange	1
54	302C8-1	Screw, Flat Hd. #4-40 x 3/8	3
55	79C12-286	Bearing Retainer Plate	1
56	90C6-53	Ball Bearing, Knife Flange	1
57	87C7-40	Fibre Knife Gear	1
58	4C2-82	Nut, Hex #6-32	2
59	20C13-56	Setscrew, #6-32 x 3/4	2
60	12C15-95	Washer, Flat #6	1
61	20C5-21	Clamp Screw	1
62	517C3-14	H.D.Air Motor Ass.y, (adaptor not included)	1

From the library of: Diamond Needle Corp

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.



From the library of: Diamond Needle Corp



Warning

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Track Assembly

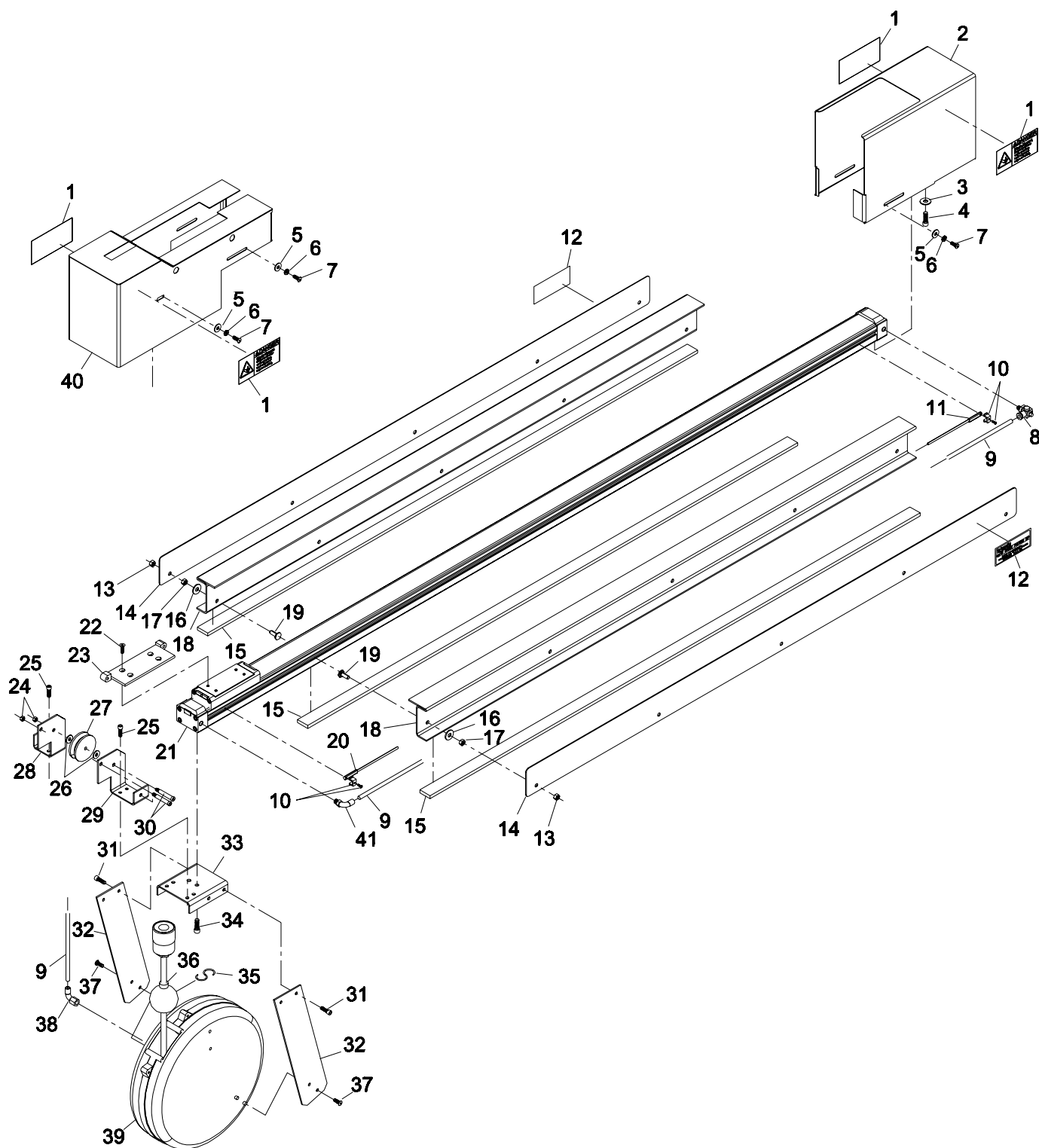
823C1-64-MS

ITEM	PART NO.	DESCRIPTION	QTY.
1	236C1-171	Decal, Blade Hazard	4
2	53C11-194	Track Cover, Non-Operator Side	1
3	410-34	Washer, Flat 1/4	2
4	335-34-6	Screw, Socket Hd. 1/4-20 x 3/8	2
5	410-010	Washer, Flat #10	6
6	402-010	Washer, Lock #10	6
7	333-102-8	Screw, Button Hd. #10-32 x 1/2	6
8	251C3-4	Speed Control Valve	1
9*	100-10-6	Tubing, Black, 1/4"	A/R
10	98C4-42	Clip, Track Switch Retainer	2
11	580C2-59-MS	End Switch Assembly	1
12	236C1-174	Decal, Atf-IIP	2
13	217-34	Nut, Thin Elastic Stop, 1/4-20	A/R
14	53C11-195-MS	Track Side Cover	2
15*	211C1-2	Foam Tape	A/R
16	410-34	Washer, Flat 1/4	A/R
17	216-34	Nut, Flange Lock, 1/4-20	A/R
18	193C1-40-MS	Track, ATF-IIP	2
19	BC-12699	Stud Plate	A/R
20	580C2-58	Home Switch Assembly	1
21	BC-40224-MS	Rodless Cylinder Track	1
22	332-99-8	Screw, Flat Hd. #10-24 x 1/2	4
23	67C5-4	Quick Change Mount, Track Side	1
24	211-34	Nut, Elastic Stop 1/4-20	2
25	335-102-6	Screw, Socket Hd. #10-32 x 3/8	4
26	411-34-1	Washer, Fiber	2
27	152C1-50	Pulley, Round Belt Style	1
28	62C16-347	Left Pulley Mount	1
29	62C16-348	Right Pulley Mount	1
30	355-34-24	Screw, Shoulder, 1/4 x 1-1/2	2
31	335-102-6	Screw, Socket Hd. #10-32 x 3/8	4
32	62C16-346	Reel Mount, Side	2
33	62C16-345	Mount, Reel Assembly	1
34	335-34-6	Screw, Socket Hd. 1/4-20 x 3/8	2
35	196-003	S-Hook, 1-1/4	1
36	50C11-50	Hose Clamp, 3/8	1
37	333-102-6	Screw, Button Hd. #10-32 x 3/8	4
38	100-13-9	Fitting, Female Elbow, 1/4" Tube	1
39	751C1-7	Air Line Reel	1
40	53C11-193	Track Cover, Operator Side	1
41	100-13-1	Fitting, Male Elbow, 1/4" Tube	1

MS - Machine Size

A/R - As Required

* Sold per foot



From the library of: Diamond Needle Corp

Front Lift Assembly

840C1-13

ITEM	PART NO.	DESCRIPTION	QTY.
1	335-34-10	Screw, Socket Hd. 1/4-20 x 5/8	4
2	50C11-49	Track Clamp	2
3	4C2-58	Nut, Hex 1/4-20	1
4	833C2-12	Front Lift Bracket	1
5	207C1-5	Grommet, 5/8"	1
6	311C14-4	Screw, Shoulder, 5/16 x 1-1/4	1
7	701-25	Lift Chain, (ms + 42")	A/R
8	50C11-48	Chain Clamp Bar	1
9	308C8-2	Screw, Socket Hd. #4-40 x 5/16	1
10	12C15-14	Washer, Flat #10	2
11	12C1-49	Washer, Lock #10	2
12	335-102-14	Screw, Socket Hd. #10-32 x 7/8	2
13	70C4-57	Guide Tube	1
14	100-11-2	Fitting, 1/4"npt, 1/4 Push-On	4
15	112C2-2	Solenoid Valve, 3-Way	1
16	300C10-10	Screw, Round Hd. #6-32 x 1	2
17	251C3-2	Speed Control Muffler	2
18	100-18-30	Reducing Regulator, 1/8"npt	1
19	833C6-6	Cylinder Hanger Bracket	1
20	658C1-6	Bearing Block Ass'y, Upper	1
21	275C4-1	Pivot Bracket Ass'y	1
22	12C1-19	Washer, Lock 1/4	4
23	331-34-8	Screw, Hex Hd. 1/4-20 x 1/2	4
24	254C1-2	Tie Mount, 3/4"	2
25	275C1-1	Lift Cylinder	1
26	251C3-4	Speed Control Valve	1
27	658C1-8	Bearing Block Ass'y, Lower	1
28	64C1-19	Cam, Up Limit Switch	1
29	309C14-5	Setscrew, #10-24 x 3/8	2
30	206-41	Nut, Jam 7/16-20	2
31	308C20-1	Screw, Socket Hd. 1/4-28 x 5/8	1
32	5C5-25	Clamping Collar	1
33	62C16-339	Collar Bracket, Front	1
34	12C1-21	Washer, Lock #8	2
35	308C12-2	Screw, Socket Hd. #8-32 x 1/2	2
36	355-38-8	Screw, Shoulder, 3/8 x 1/2	1
37	411-38-1	Washer, Fiber 3/8	2
38	278C1-7	Idler Sprocket, 1/4" Pitch	1
39	335-86-16	Screw, Socket Hd. #6-32 x 1	2
40	112C2-5	Solenoid Valve, 5 Port 3-Way	1
41	100-14-11	Swivel Tee, 1/4"npt, 1/4 Push-on	1
42	100-14-1	Union Tee, 1/4 Push-on	1
43	236C1-173	Decal Sheet, Front Lift	1
44	46C3-54	Mounting Block, Limit Switch	1

ITEM	PART NO.	DESCRIPTION	QTY.
45	11-1169	Up limit Switch	1
46	300C8-6	Screw, Round Hd. #4-40 x 3/4	2
47	254C1	Cable Tie, 4"	5
48	12C15-78	Washer, Flat #8	2
49	79C12-440	Front Lift Plate	1
50	100-11-2	Fitting, 1/4"npt, 1/4 Push-On	1
51	253C2-3	Air Regulator w/Auto Drain	1
52	62C16-316	Mounting Bracket, Regulator	1
53	308C15-3	Screw, Socket Hd. #10-32 x 3/8	2
54	308C12-2	Screw, Socket Hd. #8-32 x 1/2	2
55*	4C2-58	Nut, Hex 1/4-20	1
56*	12C1-19	Washer, Lock 1/4	1
57*	12C15-108	Washer, Flat 1/4	1
58*	826C1-17-MS	Support Tube	1
59*	308C18-3	Screw, Socket Hd. 1/4-20 x 3/4	1
60*	308C18-9	Screw, Socket Hd. 1/4-20 x 1/2	1
61	660C3-216	Front Lift Harness	1
62	305C8-1	Screw, Binding Hd. #4-40 x 1/4	4
63	260C4-6	Fitting, 1/8"npt, 1/4 Push-On	1
64	100-17-1	Bulk Head Union, 1/4 Push-On	3
65	308C15-2	Screw, Socket Hd. #10-32 x 1/2	6
66	12C1-49	Washer, Lock #10	2
67	12C15-14	Washer, Flat #10	2
68	112C2-6	Solenoid Valve, 5 Port 2-Way	1
69	27-H0410	Plug, 1/4"npt	1
70	335-86-16	Screw, Socket Hd. #6-32 x 1	2
71	310C28-1	Bolt, Hex Hd. 1/2-13 x 4	2
72	206-43	Nut, Hex 1/2-13	2
73	50C11-34	Clamp Base	2
74	302C18-3	Screw, Flat Hd. 1/4-20 x 3/4	4
75	100-10-6	1/4" O.D. Tubing	8
76	62C16-308	Hanger Bracket	1

MS - Table Width

A/R - As Required

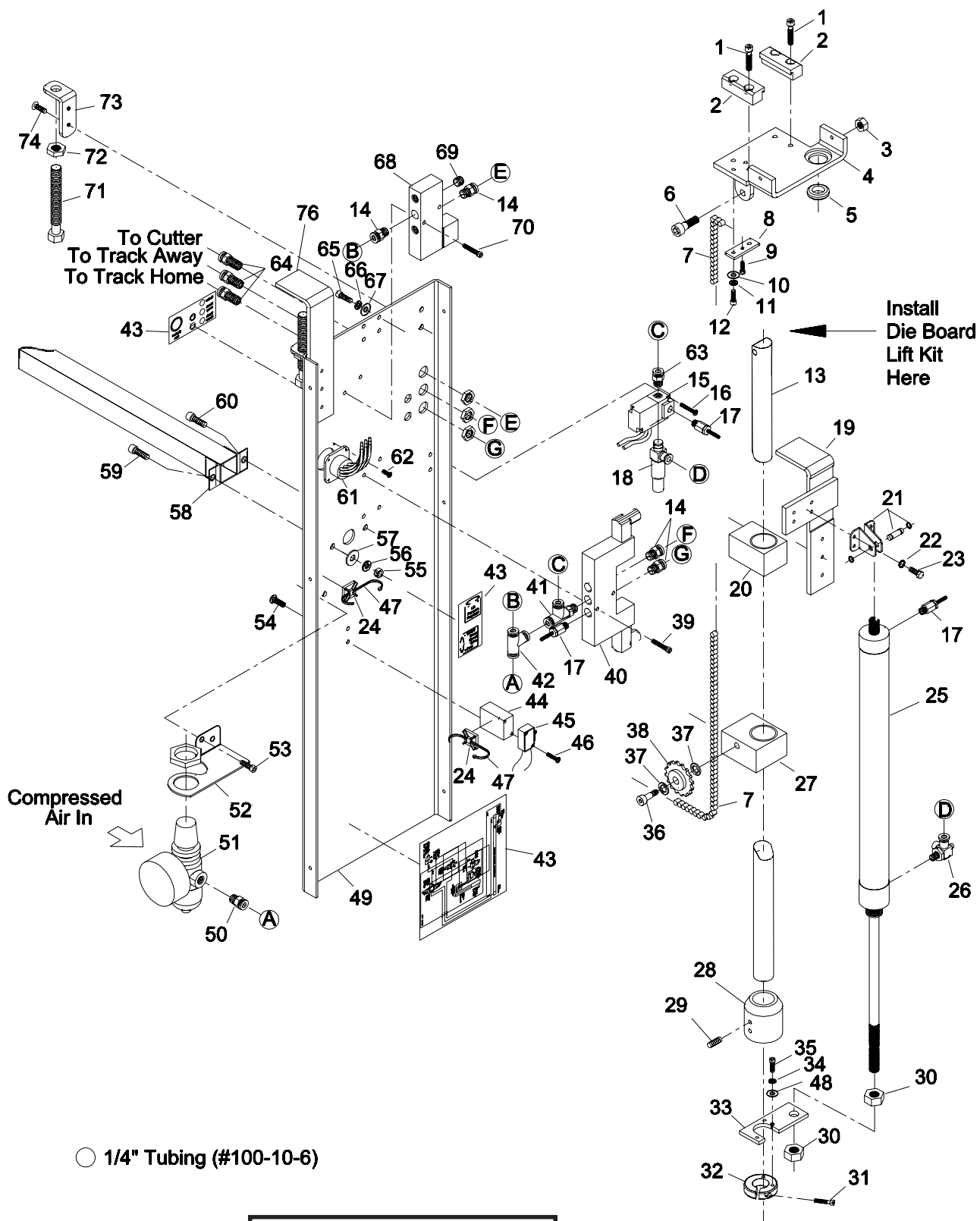
* - Not included in this Assembly.

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.



Note: See Page 9 For Chain Lift Threading Diagram.

Eastman
MANUAL CUTTING PRODUCTS

Rear Lift Assembly

840C1-14

ITEM	PART NO.	DESCRIPTION	QTY.
1	335-34-10	Screw, Socket Hd. 1/4-20 x 5/8	4
2	50C11-49	Track Clamp	2
3	833C2-11	Rear Lift Bracket	1
4	77C1-71	Connecting Link	2
5	311C14-4	Screw, Shoulder Socket 5/16 x 1-1/4	2
6	4C2-58	Nut, Hex 1/4-20	2
7	70C4-62	Guide Tube	1
8	658C1-6	Bearing Block Assy, Top	1
9	658C1-8	Bearing Block Assy, Bottom	1
10	411-38-1	Washer, Fibre	2
11	278C1-7	Idler, Sprocket	1
12	355-38-8	Screw, Shoulder Socket 3/8 x 1/2	1
13*	701-25	Lift Chain, (MS + 42")	A/R
14	308C8-2	Screw, Socket Hd. #4-40 x 5/16	1
15	335-102-14	Screw, Socket Hd. #10-32 x 7/8	2
16	50C11-48	Chain Clamp Bar	1
17	308C12-2	Screw, Socket Hd. #8-32 x 1/2	2
18	12C1-21	Washer, Lock #8	2
19	12C15-78	Washer, Flat #8	2
20	62C16-313	Collar Bracket	1
21	5C5-25	Clamping Collar	1

ITEM	PART NO.	DESCRIPTION	QTY.
22	308C20-1	Screw, Socket Hd. 1/4-28 x 5/8	1
23	79C12-433	Back Frame	1
24*	335-39-16	Screw, Socket Hd. 3/8-24 x 1	1
25*	206-39	Nut, Jam 3/8-24	1
26*	826C1-18	Support Tube	1
27*	308C18-3	Screw, Socket Hd. 1/4-20 x 3/4	1
28	308C18-9	Screw, Socket Hd. 1/4-20 x 1/2	1
29	308C15-2	Screw, Socket Hd. #10-32 x 1/2	1
30	12C1-49	Washer, Lock #10	1
31	12C15-14	Washer, Flat #10	1
32*	12C15-108	Washer, Flat 1/4	1
33*	12C1-19	Washer, Lock 1/4	1
34*	4C2-58	Nut, Hex 1/4-20	1
35	308C15-2	Screw, Socket Hd. #10-32 x 1/2	4
36	12C1-49	Washer, Lock #10	4
37	12C15-14	Washer, Flat #10	4
38	310C28-1	Clamp Screw, 1/2-13	2
39	206-43	Nut, Jam 1/2-13	2
40	302C18-2	Screw, Flat Hd. 1/4-20 x 1/2	4
41	50C11-34	Clamp Base	2
42	62C16-308	Hanging Bracket	2
43	12C15-14	Washer, Flat #10	2
44	12C1-49	Washer, Lock #10	2

Lift Chain Sold by the Foot.

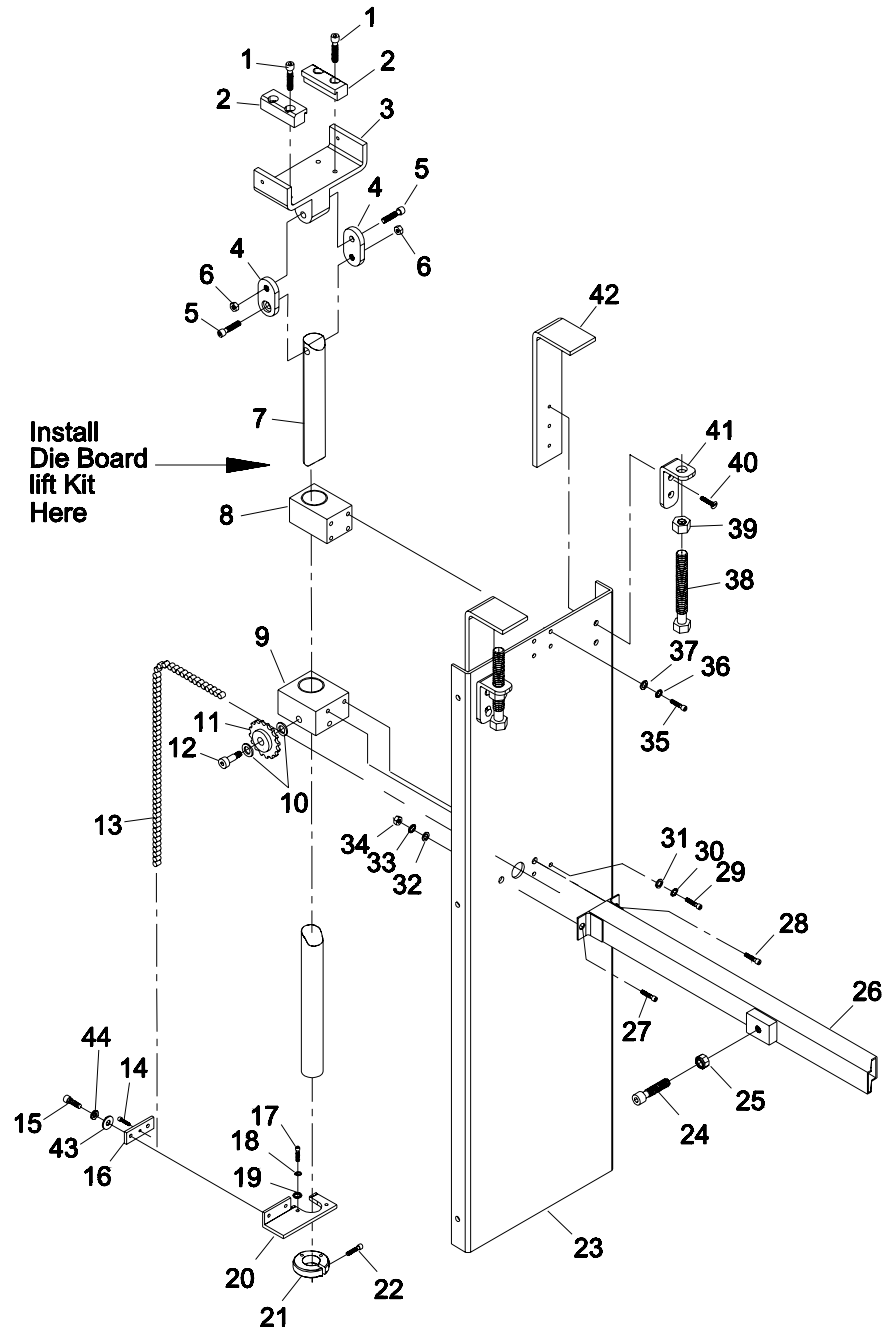
MS - Table Width.

* - Not included in this Assembly.

NOTE:

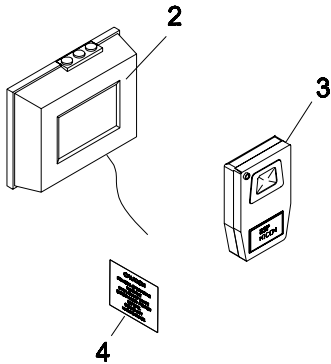
Please specify model and serial number of machine when ordering parts.
Item numbers are for reference only.
Please specify PART NUMBERS when ordering replacement parts.

Note: See Page 9 For Chain Lift Threading Diagram.

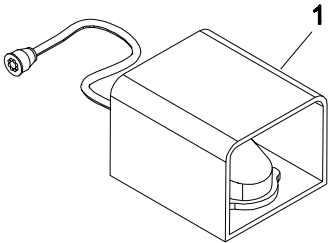


Accessories

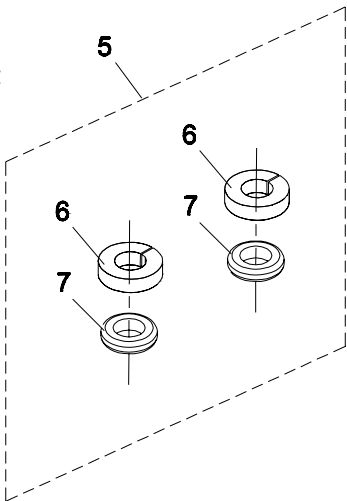
Wireless Remote
Start Assembly



FootPedal
Start Assembly

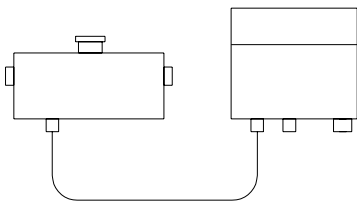


Die Board
Track Lift Kit



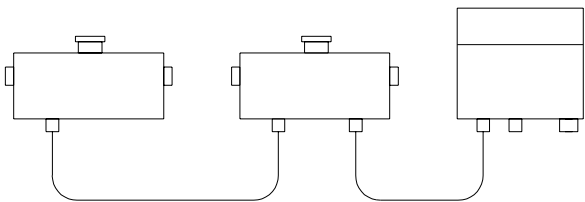
ITEM	PART NO.	DESCRIPTION	QTY.
1	580C2-56	25' Footpedal Start Assembly	1
	580C2-57	50' Footpedal Start Assembly	1
2	830C1-89	Wireless Remote Receiver	1
3	273C1-2	Remote Transmitter	1
4	236C1-110	Remote Label	1
5	820C1-122	Die Board Lift Kit	1
6	5C5-25 S	Adjusting Collar	2
7	207C1-6	Cushion	2
8	783C1-36-4	Interlock Cable, 4' Long	1
	783C1-36-10	Interlock Cable, 10' Long	1
9	707C2-17-2	2 Button Add-in Cycle Start Box Ass'y	1
10	580C1-224	E-Stop Switch, Red, N.C.	1
11	91-26011	Stop Decal	1
12	236C1-172	Decal, Cycle Start Box	1
13	580C1-223	Push Button Switch, Green, N.O.	2
14	182C14-17-1	Cycle Start Box, Main, 2/1	1
	182C17-17-2	Cycle Start Box, Add-in, 2/2	1
15	300C8-9	Screw, Round Hd. #4-40 x 3/16	A/R
16	11-4737	Connector, 4-Pin	A/R
	11-4707	Crimp Pin	A/R
17	11-4200	Contact Block, Green, N.O.	2
18	11-4201	Contact Block, Red, N.C.	1
19	707C2-17-2	2 Button Add-in Cycle Start Box Ass'y	1

A/R - As Required.



2 Button Interlock Connection

2 Button Cycle Start
Interlock Assembly
580C2-60-2

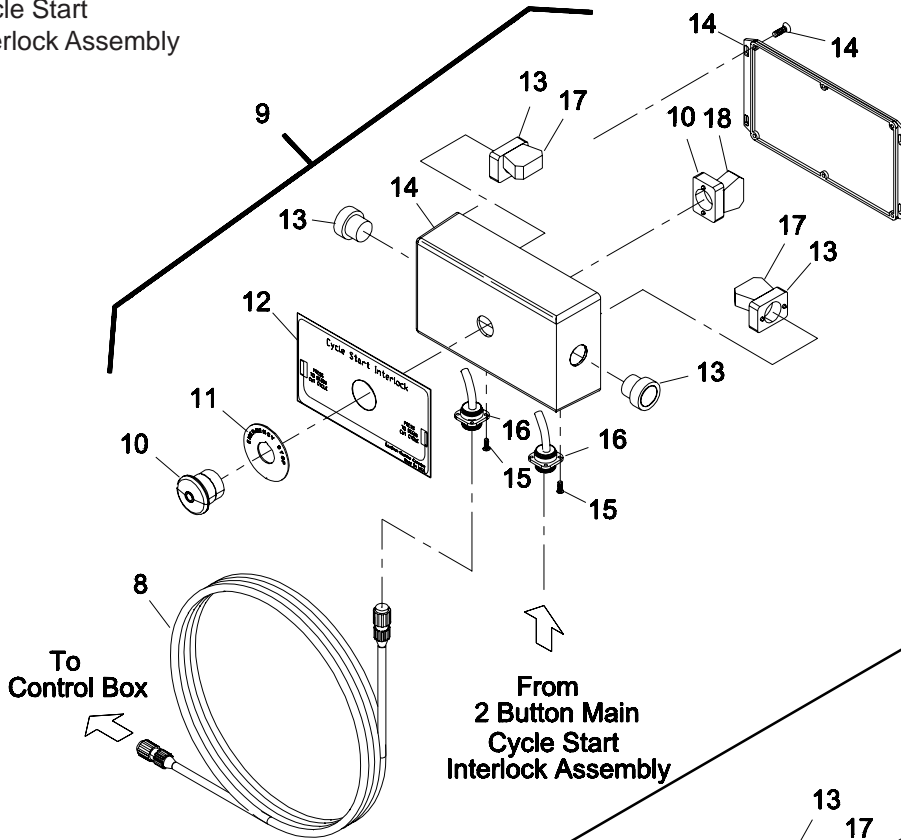


4 Button Interlock Connection

4 Button Cycle Start
Interlock Assembly
580C2-60-4

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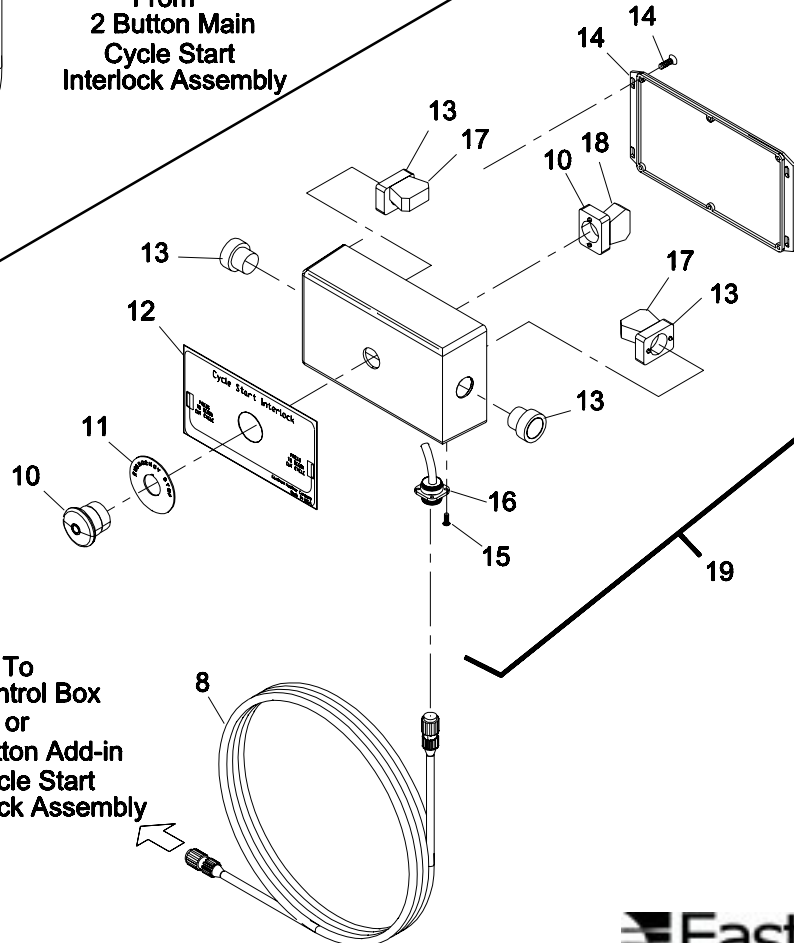
2 Button Add-in
Cycle Start
Interlock Assembly



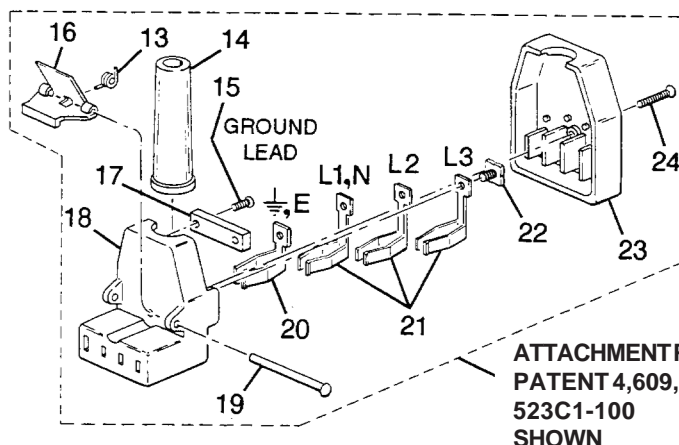
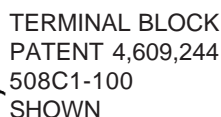
To Control Box
or
2 Button Add-in
Cycle Start
Interlock Assembly

2 Button Main
Cycle Start
Interlock Assembly

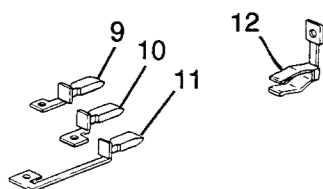
From
2 Button Main
Cycle Start
Interlock Assembly



From the library of: Diamond Needle Corp



Electrical connections to this device should be made by a qualified electrician who is familiar with applicable codes and regulations. To ensure operators safety, a ground lead must be connected to terminal "E" on the attachment plug. Disconnect this equipment from electrical power before proceeding with any disassembly for adjustment, inspection or repair.

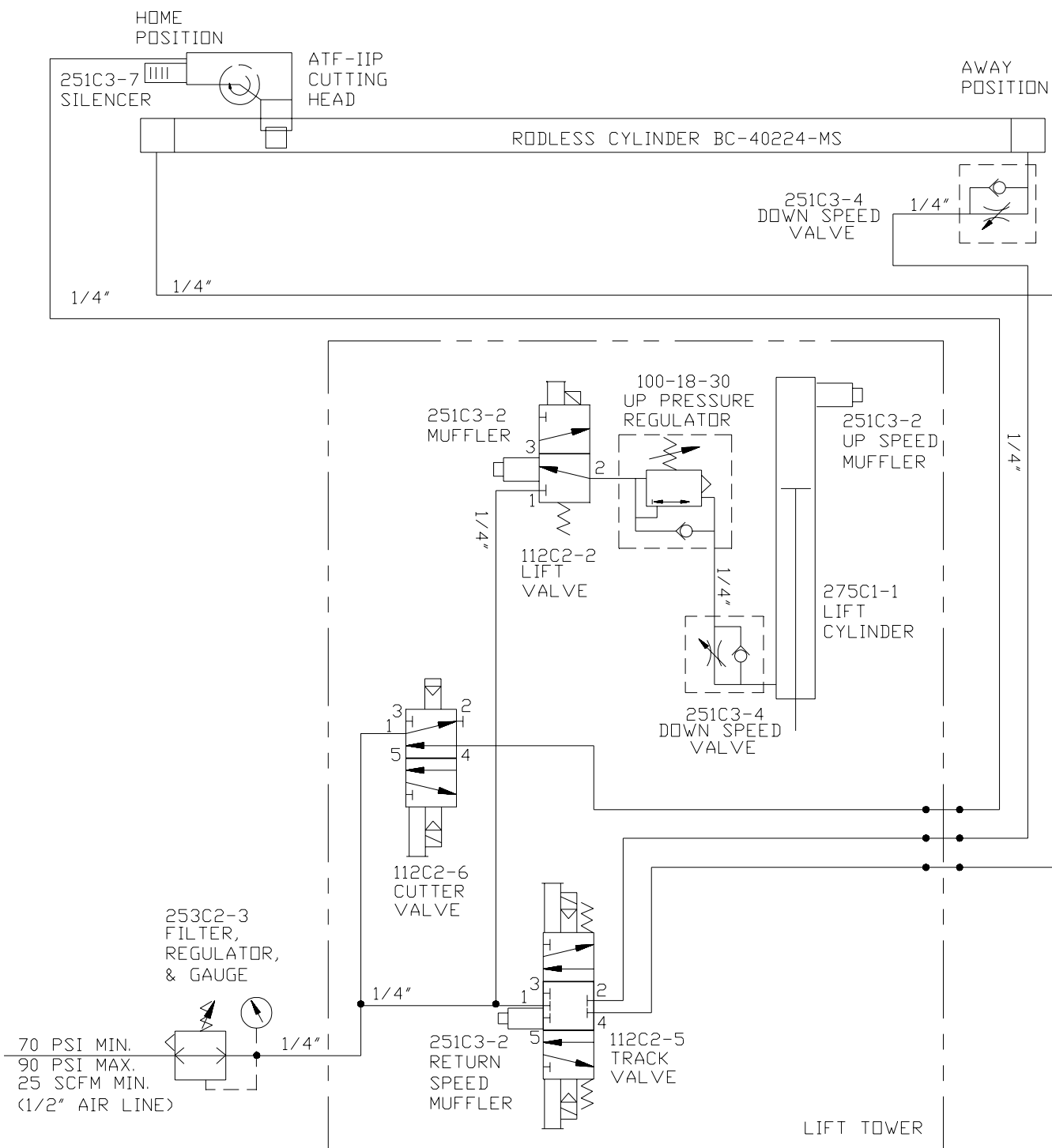


1	302C15-8	Screw, 10-32 x 1 1/8 Flat Hd.	2	2	2	2	2
2	-----	Terminal Block Top	51C1-63	51C1-64	51C1-65	51C1-66	51C1-67
3	20C13-103	U-Lock Screw	4	4	3	3	3
4	667C1-22	Terminal Contact w/Pin E	1	1	1	1	1
5	667C1-23	Terminal Contact w/pin L1, N	1	1	1	--	--
6	667C1-24	Terminal Contact w/Pin L2	1	1	--	1	--
7	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 Diagram

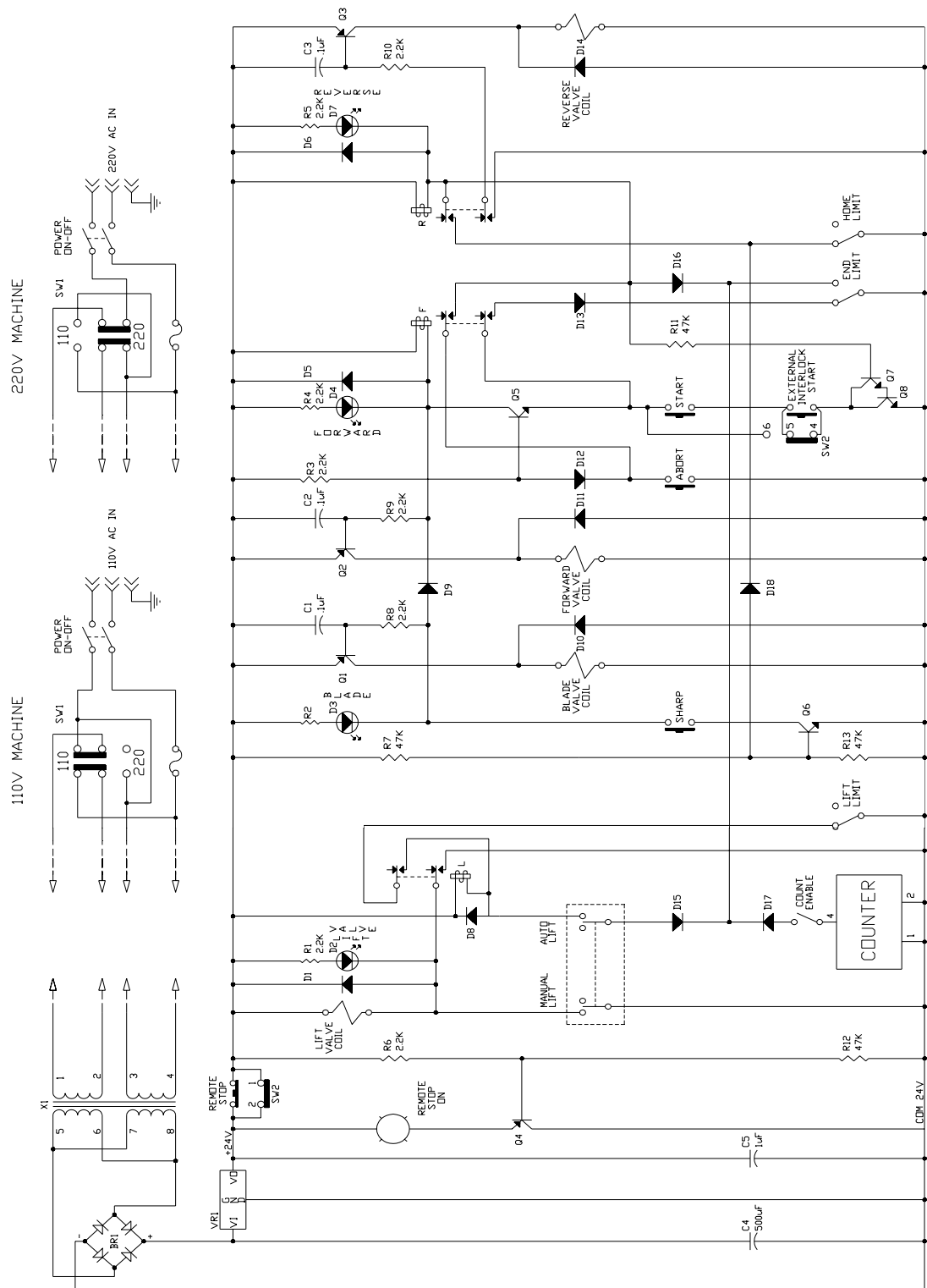
Blueprint No.

668C2-6

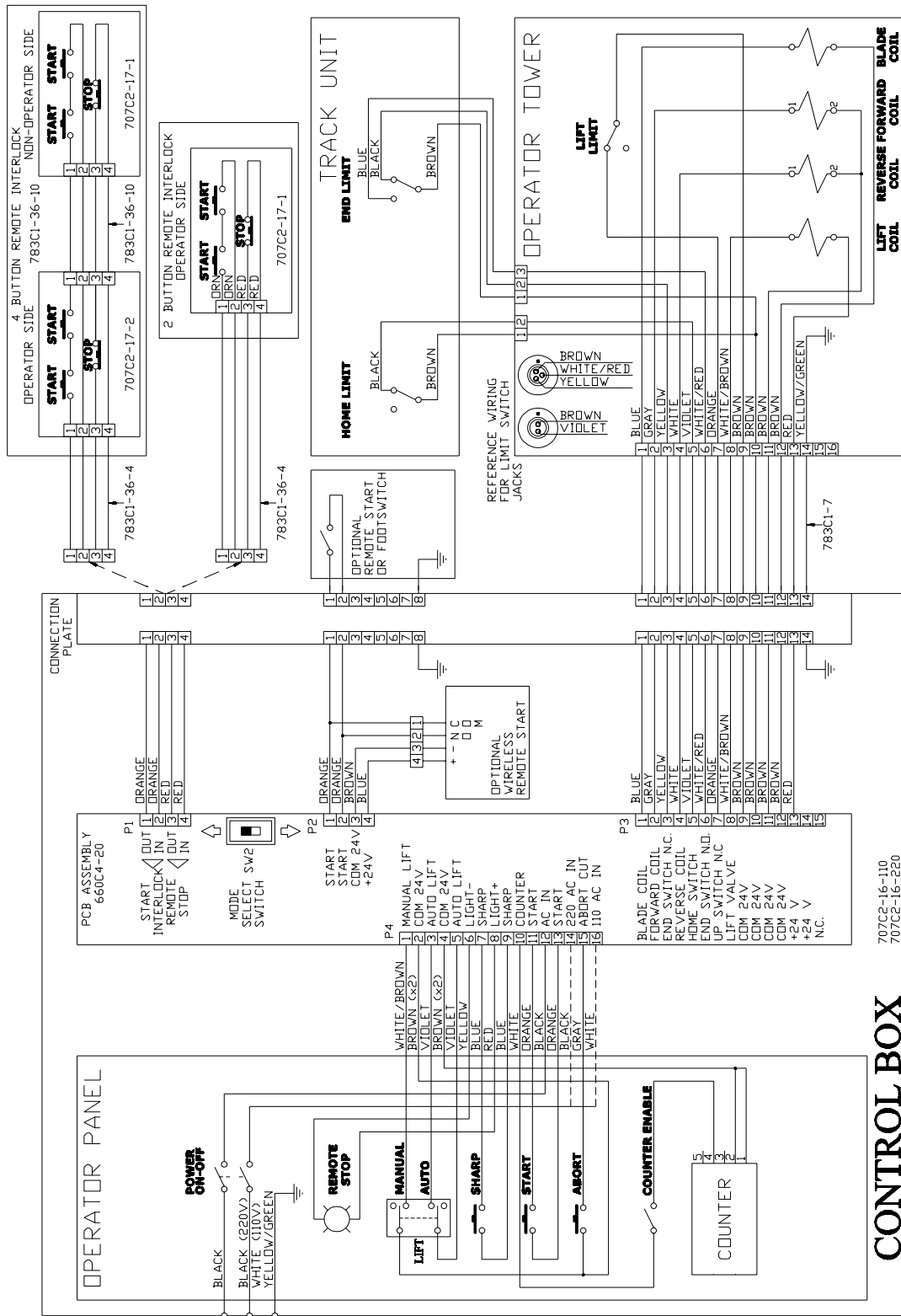


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Wiring Schematic



Wiring Diagram Blue Print No. 668C1-264



Notes

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Machine Serial No.: _____
Machine Voltage: _____
Date of Purchase: _____

[illegible]

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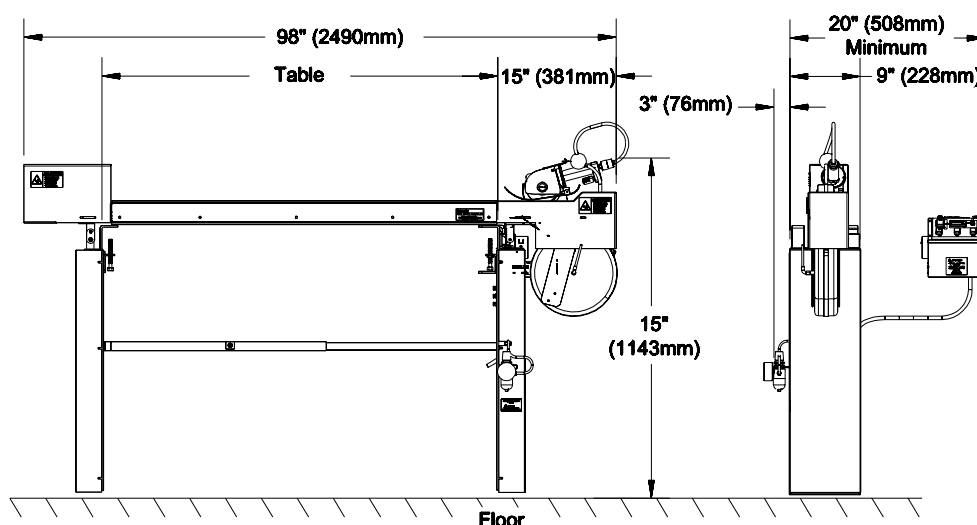
TECHNICAL DATA

Eastman® Auto Track Falcon Pneumatic

Auto Track Falcon Pneumatic (Model ATF-IIP)

Max. Machine Cycle Speed for 72" (1828mm) machine 5 seconds/cycle
Cutting Capacity 1/2" up to 1 1/4" (compressible goods)
Blade Size 4" (10.2 cm)
Horsepower 10 hp, .14 hp
Operating Voltage 110V/220V; (50/60 cycles)
Air Supply 70-90 PSI @ 25 SCFM
Power Requirement 110v @ 1/2 amps
 220v @ 1/2 amps
Machine Weight (72" machine) Approx. 130 lbs. (59 kg)
Operating DB Level (noise) 84db @ 2 feet
Safety Zone See page 5

* Relative to the type and quality of fabric, machine size, traverse speed, etc.



Limited Warranty. Eastman warrants to the buyer that the equipment shall be free from defects in materials or workmanship for a period of 180 days commencing on the date of invoice. Any goods or parts claimed by the buyer to be defective must be returned to Eastman, freight charges prepaid, within the 180 day warranty period. If Eastman determines that the goods or parts are defective in materials or workmanship, Eastman's sole obligation under this warranty shall be, at Eastman's sole option, to repair or replace the defective goods or parts or to provide the buyer a credit equal to the portion of the purchase price allocable to the defective goods or parts. This warranty shall not apply if defects are caused by product misuse or neglect, if the machine has been altered or modified by the buyer, or if other than genuine Eastman belts, emery wheels, knives or parts are used in the machine. THIS WARRANTY IS THE ONLY WARRANTY APPLICABLE TO THIS PURCHASE. SELLER DISCLAIMS ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

Limitation of Liability. Eastman's liability to the buyer, and the buyer's remedies from Eastman, whether in contract, negligence, tort, under any warranty or otherwise, shall be limited to the remedies provided in the foregoing Limited Warranty. In no event shall Eastman have any responsibility or liability to the buyer for (a) any special, indirect, incidental, or consequential damages, including, but not limited to, loss of use, revenue, or profit, even if Eastman has been advised of the possibility of such damages, or (b) any claim against the buyer by any third party. The price stated for the product sold is a consideration for limiting Eastman's liability.



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