

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	INITIAL RELEASE	10/15/08	SSL
	B	ITEM 8 WAS QTY 4; ITEM 11 WAS AX-2118; ITEM 12 WAS AX-2113	07/21/10	DRP

MALE BUTTON LOCK ROLL SET

20-24 ga



LOCATING SPOT ON EXIT GUIDE BAR TO FACE OPERATOR

INSTALLATION INSTRUCTIONS:

1. INSTALL ROLLERS, MARKED "T1" & "B1", ONTO THE SHAFTS AT THE INFEED SIDE OF MACHINE, PLACING "T1" ON THE UPPER SHAFT AND "B1" ON THE LOWER SHAFT.
2. REPEAT THE ABOVE PROCEDURE FOR THE REMAINING ROLLERS IN NUMERIC ORDER.
3. **ALL ROLLERS MARKED "T" SHOULD BE ON THE TOP SHAFTS AND ROLLERS MARKED "B" SHOULD BE ON THE BOTTOM SHAFTS.**
4. **ALL ROLLER MARKINGS MUST FACE OUTWARD, OR TOWARDS THE OPERATOR.**
5. MOUNT IDLER ASSEMBLY, ITEM 13, ONTO TWO SHAFTS LOCATED AT POSITIONS T5 & T6 AS SHOWN ON SHEET 2. SECURE WITH BOLT PROVIDED.
6. MOUNT ENTRANCE GUIDE BAR (ITEM 11) ON THE INFEED SIDE OF THE MACHINE. GUIDE BARS TO BE BOLTED INTO THREADED HOLES IN TABLETOP OF MACHINE, (0.938" FROM THE FRONT EDGE OF THE ROLLERS).
7. MOUNT THE EXIT GUIDE BAR (ITEM 12) ON THE EXIT SIDE OF THE MACHINE. GUIDE BARS TO BE BOLTED INTO THREADED HOLES IN TABLETOP OF MACHINE, (0.510" FROM THE FRONT EDGE OF THE ROLLERS).

RAMS 2014 - AUXILIARY MACHINE

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	AX-2101-B	ROLLER, B1, Male Button Lock, SQ. DRIVE	1
2	AX-2101-T	ROLLER, T1, MALE BUTTON LOCK, SQ. DR.	1
3	AX-2102-B	ROLLER, B2, Male Button Lock, SQ. DRIVE	1
4	AX-2102,3,4-T	ROLLER, T2,3,4, MALE BUTTON LOCK, SQ. DR.	3
5	AX-2103-B	ROLLER, B3, Male Button Lock, SQ. DRIVE	1
6	AX-2104-B	ROLLER, B4, Male Button Lock, SQ. DRIVE	1
7	AX-2105,6-B	ROLLER, B5 & B6, Male Button Lock, SQ. DRIVE	2
8	2054	ADJUSTING BOLT:1/4-20 THREAD	6
9	AX-2107,8,9-T	ROLLER, T7,8,9, MALE BUTTON LOCK, SQ. DR.	3
10	AX-2107,8,9-B	ROLLER, B7,8,9, Male Button Lock, SQ. DRIVE	3
11	AX-2118-2	GUIDE BAR, MALE BUTTON, INLET	1
12	AX-2113-1	GUIDE BAR, MALE BUTTON, EXIT	1
13	AX-2105-T	IDLER ASSY, T5, MALE BUTTON LOCK	1

DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± 1/16 ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ±.01 THREE PLACE DECIMAL ±.005		<table border="1"> <tr> <th>DATE</th> <th>NAME</th> </tr> <tr> <td>10/13/08</td> <td>SSL</td> </tr> <tr> <td></td> <td></td> </tr> <tr> <td></td> <td></td> </tr> <tr> <td></td> <td></td> </tr> <tr> <td></td> <td></td> </tr> </table>	DATE	NAME	10/13/08	SSL									HORIZON SYSTEMS MACHINING 9121 58TH PLACE KENOSHA, WI 53144 PH: 262-605-1122 FAX: 262-605-1198
DATE	NAME														
10/13/08	SSL														
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF HORIZON SYSTEMS MACHINING. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF HORIZON SYSTEMS MACHINING IS PROHIBITED.	MATERIAL: SEE BOM SIZE: C DWG. NO.: RAMS AUX-2100 REV: B	SCALE: 1:1.75 SHEET 1 OF 2													