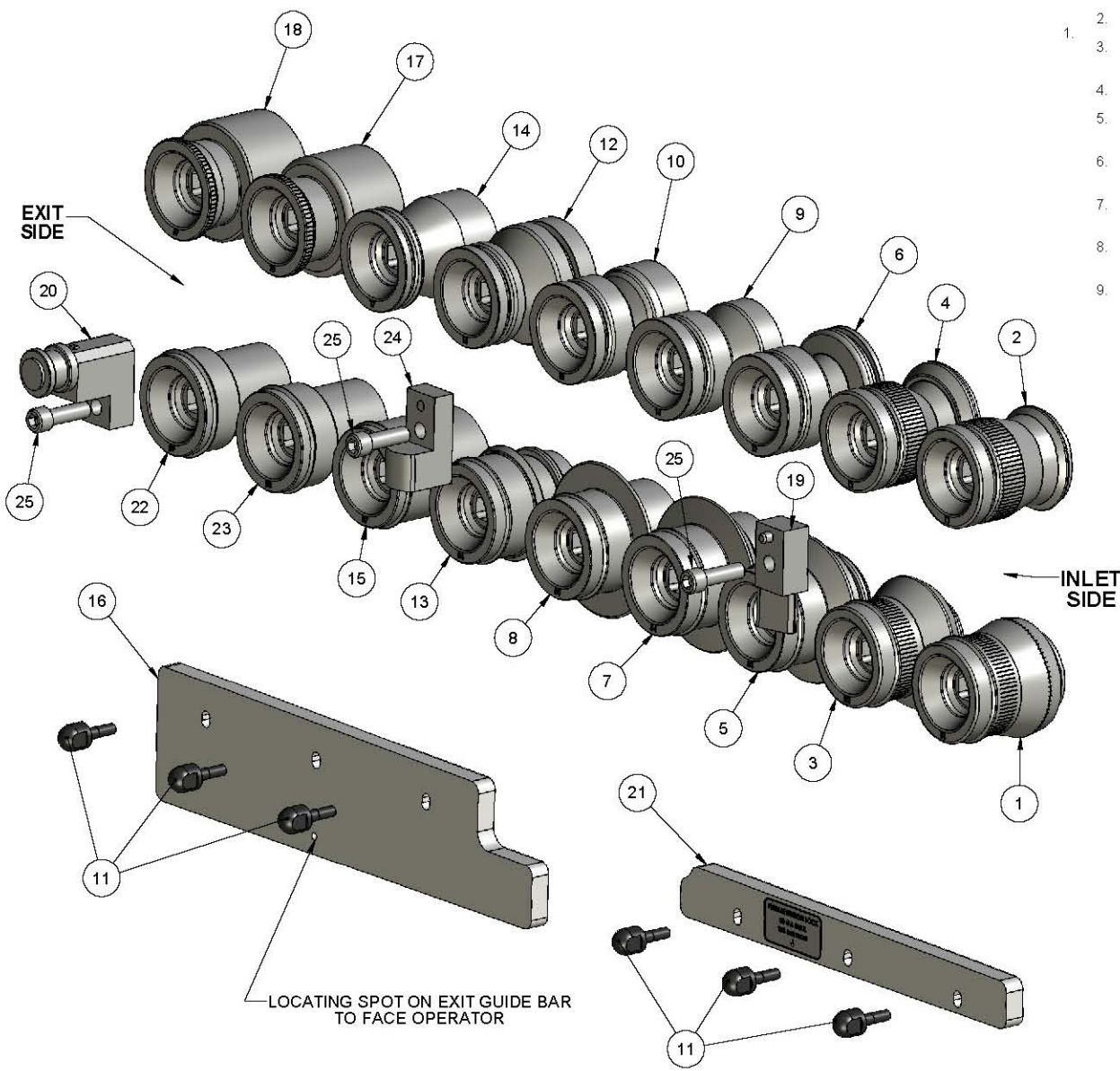


ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	INITIAL RELEASE	10/15/08	SSL
	B	REVISED NOTES	4/8/2009	SSL
	C	ITEM 11 WAS QTY 4; ITEM 16 WAS AX-2213; ITEM 21 WAS AX-2217	07/21/10	DRP

## FEMALE BUTTON LOCK ROLL SET 20-24 qa



**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 ENTRANCE GUIDE BAR (ITEM 21) ON THE INFEED SIDE OF THE MACHINE. GUIDE BARS TO BE BOLTED, (ITEM 11) INTO THREADED HOLES IN TABLETOP OF MACHINE.
6. MOUNT EXIT GUIDE BAR (ITEM 16) ON THE FINISHING SIDE OF THE MACHINE. GUIDE BARS TO BE BOLTED, (ITEM 11) INTO THREADED HOLES IN TABLETOP OF MACHINE.
7. MOUNT FORM BAR, ITEM 19, BETWEEN ROLLERS #2 & #3. DOWEL PIN IN FORM BAR FITS INTO HOLE OF GEARBOX FOR PROPER LOCATION. SECURE WITH BOLT, ITEM 25.
8. MOUNT FORM BAR, ITEM 24, BETWEEN ROLLERS #5 & #6. DOWEL PIN IN FORM BAR FITS INTO HOLE OF GEARBOX FOR PROPER LOCATION. SECURE WITH BOLT, ITEM 25.
9. MOUNT ROLLER ASSEMBLY, ITEM 20, BETWEEN ROLLERS #8 & #9. DOWEL PIN IN ROLLER ASSEMBLY FITS INTO HOLE OF GEARBOX FOR PROPER LOCATION. SECURE WITH BOLT, ITEM 25.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	AX-2201-B	ROLLER, B1, FEMALE BUTTON LOCK, SQ. DR.	1
2	AX-2201-T	ROLLER, T1, FEMALE BUTTON LOCK, SQ. DR.	1
3	AX-2202-B	ROLLER, B2, FEMALE BUTTON LOCK, SQ. DR.	1
4	AX-2202-T	ROLLER, T2, FEMALE BUTTON LOCK, SQ. DR.	1
5	AX-2203-B	ROLLER, B3, FEMALE BUTTON LOCK, SQ. DR.	1
6	AX-2203-T	ROLLER, T3, FEMALE BUTTON LOCK, SQ. DR.	1
7	AX-2204-B	ROLLER, B4, FEMALE BUTTON LOCK, SQ. DR.	1
8	AX-2205-B	ROLLER, B5, FEMALE BUTTON LOCK, SQ. DR.	1
9	AX-2204-T	ROLLER, T4, FEMALE BUTTON LOCK, SQ. DR.	1
10	AX-2205-T	ROLLER, T5, FEMALE BUTTON LOCK, SQ. DR.	1
11	2054	ADJUSTING BOLT:1/4-20 THREAD	6
12	AX-2206-T	ROLLER, T6, FEMALE BUTTON LOCK, SQ. DR.	1
13	AX-2206-B	ROLLER, B6, FEMALE BUTTON LOCK, SQ. DR.	1
14	AX-2207-T	ROLLER, T7, FEMALE BUTTON LOCK, SQ. DR.	1
15	AX-2207-B	ROLLER, B7, FEMALE BUTTON LOCK, SQ. DR.	1
16	AX-2213-1	GUIDE BAR, FEMALE BUTTON, EXIT	1
17	AX-2208-T	ROLLER, T8, FEMALE BUTTON LOCK, SQ. DR.	1
18	AX-2209-T	ROLLER, T9, FEMALE BUTTON LOCK, SQ. DR.	1
19	AX-2214	FORM BAR ASSY, FEMALE BUTTON LOCK	1
20	AX-2216	ROLLER ASSY, FEMALE BUTTON LOCK	1
21	AX-2217-2	GUIDE BAR, FEMALE BUTTON, ENTRANCE	1
22	AX-2209-B	ROLLER, B9, FEMALE BUTTON LOCK, SQ. DR.	1
23	AX-2208-B	ROLLER, B8, FEMALE BUTTON LOCK, SQ. DR.	1
24	AX-2218	FORM BAR ASSY, FEMALE BUTTON LOCK	1
25	HW-1053	SHCS, 3/8-16 X 1 1/4"	3

<p><b>DIMENSIONS ARE IN INCHES</b>  <b>TOLERANCES:</b>                  FRACTIONAL ± 1/16                  ANGULAR: MACH ± BEND ±                  TWO PLACE DECIMAL ±.01                  THREE PLACE DECIMAL ±.005</p>		<table border="1"> <tr><td>DATE</td><td>10/13/08</td></tr> <tr><td>NAME</td><td>SSL</td></tr> <tr><td>DRAWN</td><td>SSL</td></tr> <tr><td>CHECKED</td><td>SSL</td></tr> <tr><td>ENG APPR.</td><td></td></tr> <tr><td>REG APPR.</td><td></td></tr> <tr><td>G.A.</td><td></td></tr> </table>	DATE	10/13/08	NAME	SSL	DRAWN	SSL	CHECKED	SSL	ENG APPR.		REG APPR.		G.A.		<p><b>HORIZON SYSTEMS MACHINING</b>                   9121 58TH PLACE                  KENOSHA, WI 53144                  PH: 262-605-1122                  FAX: 262-605-1198</p>
DATE	10/13/08																
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<p>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.</p>		<p><b>MATERIAL:</b> SEE BOM</p> <p><b>SIZE:</b> N/A</p>	<p><b>TITLE:</b> ROLLERS, FEMALE BUTTON LOCK</p> <p><b>SIZE DWG. NO.:</b> C RAMS AUX-2200</p> <p><b>REV:</b> C</p>														
<p>DO NOT SCALE DRAWING</p>		<p>SCALE: 1:2</p>	<p>SHEET 1 OF 2</p>														

**RAMS 2014 - AUXILIARY MACHINE**