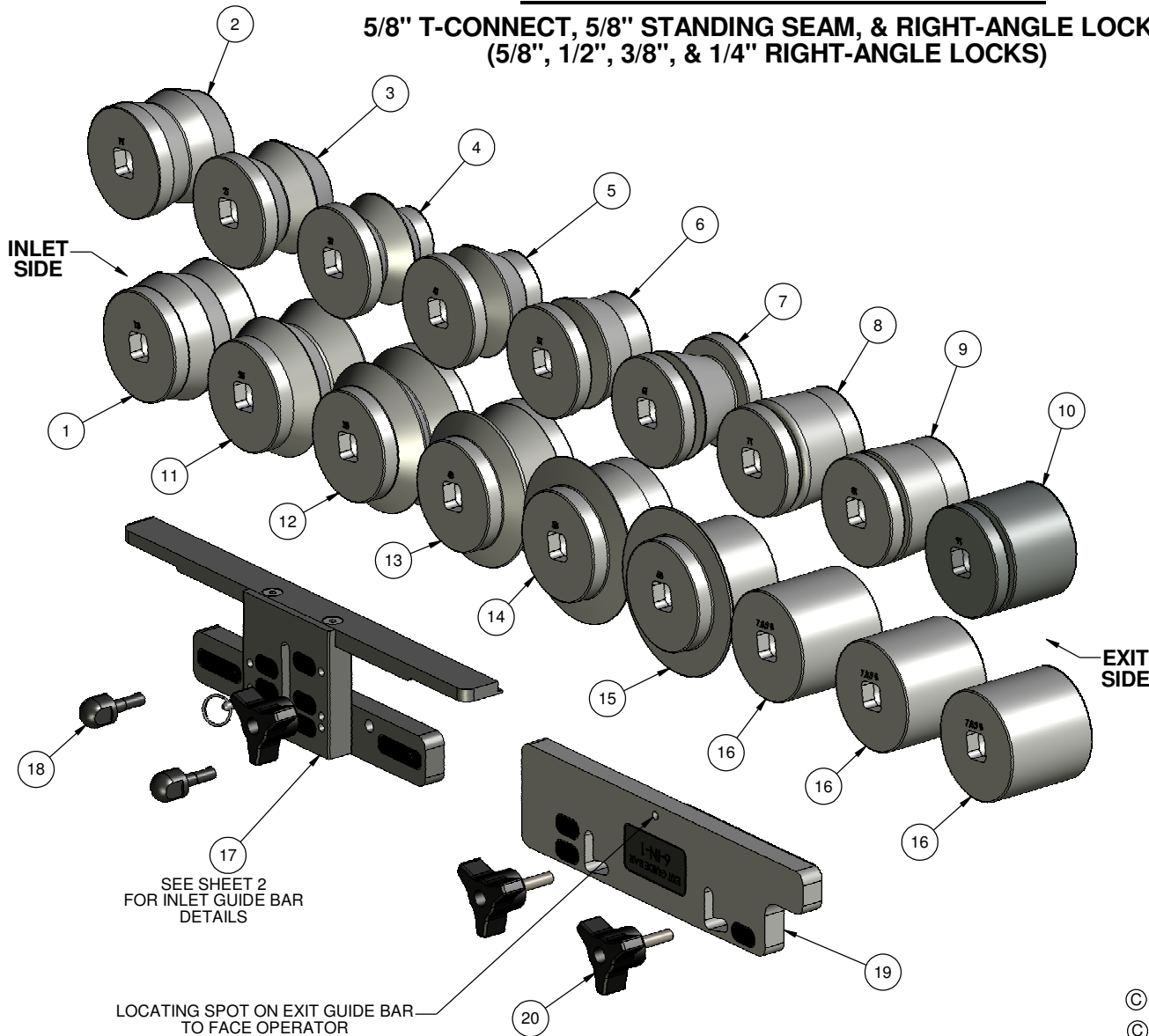


6-IN-1 TAP-IN AUXILIARY ROLL SET

5/8" T-CONNECT, 5/8" STANDING SEAM, & RIGHT-ANGLE LOCKS (5/8", 1/2", 3/8", & 1/4" RIGHT-ANGLE LOCKS)



REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	INITIAL RELEASE	11/20/08	SSL
	B	ADDED LOCATING SPOT TO GUIDE BAR; ADDED SHEET 2	4/15/09	SSL
	C	ITEM 17 WAS REVISED; ITEM 18 WAS QTY 4; ADDED ITEM 20, JCL-395, QTY 2	07/29/10	DRP

INSTALLATION INSTRUCTIONS:

1. INSTALL ROLLERS, MARKED "1T" & "1B", ONTO THE SHAFTS AT THE LEFT SIDE, OR INLET SIDE OF MACHINE, PLACING "1T" ON THE UPPER SHAFT AND "1B" 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 INLET GUIDE BAR (ITEM 17) ON THE STARTING SIDE OF THE MACHINE. ADJUSTABLE T-BAR TO BE FACING OPERATOR.
6. MOUNT EXIT GUIDE BAR (ITEM 19) ON THE FINISHING SIDE OF THE MACHINE. LOCATING SPOT ON GUIDE BAR MUST BE FACING OPERATOR.

ITEM #	PART NUMBER	DESCRIPTION	QTY.
1	AX-1401-B	#1 STATION BOTTOM T-CONNECT ROLLER	1
2	AX-1401-T	#1 STATION TOP T-CONNECT ROLLER	1
3	AX-1402-T	#2 STATION TOP T-CONNECT ROLLER	1
4	AX-1403-T	#3 STATION TOP T-CONNECT ROLLER	1
5	AX-1404-T	#4 STATION TOP T-CONNECT ROLLER	1
6	AX-1405-T	#5 STATION TOP T-CONNECT ROLLER	1
7	AX-1406-T	#6 STATION TOP T-CONNECT ROLLER	1
8	AX-1407-T	#7 STATION TOP T-CONNECT ROLLER	1
9	AX-1408-T	#8 STATION TOP T-CONNECT ROLLER	1
10	AX-1409-T	#9 STATION TOP T-CONNECT ROLLER	1
11	AX-1402-B	#2 STATION BOTTOM T-CONNECT ROLLER	1
12	AX-1403-B	#3 STATION BOTTOM T-CONNECT ROLLER	1
13	AX-1404-B	#4 STATION BOTTOM T-CONNECT ROLLER	1
14	AX-1405-B	#5 STATION BOTTOM T-CONNECT ROLLER	1
15	AX-1406-B	#6 STATION BOTTOM T-CONNECT ROLLER	1
16	AX-1407_8_9-B	#7, 8 & 9 STATION BOTTOM 6-IN-1 ROLLER	3
17	AX-1015	GUIDE BAR, 6-IN-1	1
18	2054	ADJUSTING BOLT:1/4-20 THREAD	2
19	AX-1019	GUIDE BAR, EXIT, 6-IN-1	1
20	JCL-395	KNOB, 3-PRONG, 1/4-20 PLATED STEEL STUD	2

DIMENSIONS ARE IN INCHES
TOLERANCES:
 FRACTIONAL ± 1/16
 ANGULAR: MACH ± BEND ±
 TWO PLACE DECIMAL ±.01
 THREE PLACE DECIMAL ±.005

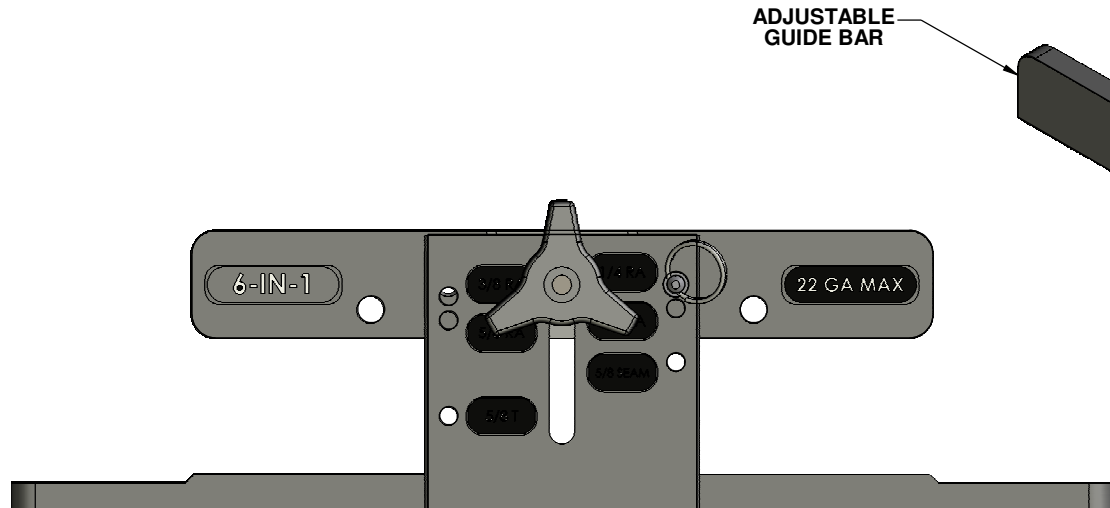
DRAWN	SSL	DATE	9/2/08
CHECKED			
ENG APPR.			
MFG APPR.			
Q.A.			

HORIZON SYSTEMS MACHINING
 9121 58TH PLACE
 KENOSHA, WI 53144
 PH: 262-605-1122
 FAX: 262-605-1198

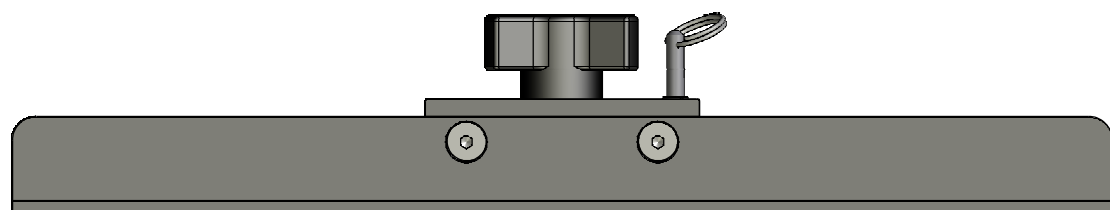
MATERIAL: SEE BOM
 TITLE: 6-IN-1 ROLLERS, SQ. DR.
 SIZE: C
 DWG. NO.: RAMS AUX-1400
 REV: C
 DO NOT SCALE DRAWING
 SCALE: 1:1.75
 SHEET 1 OF 2

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
-	-	See Sheet1	-	-

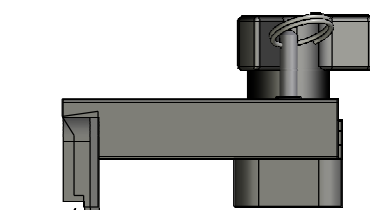
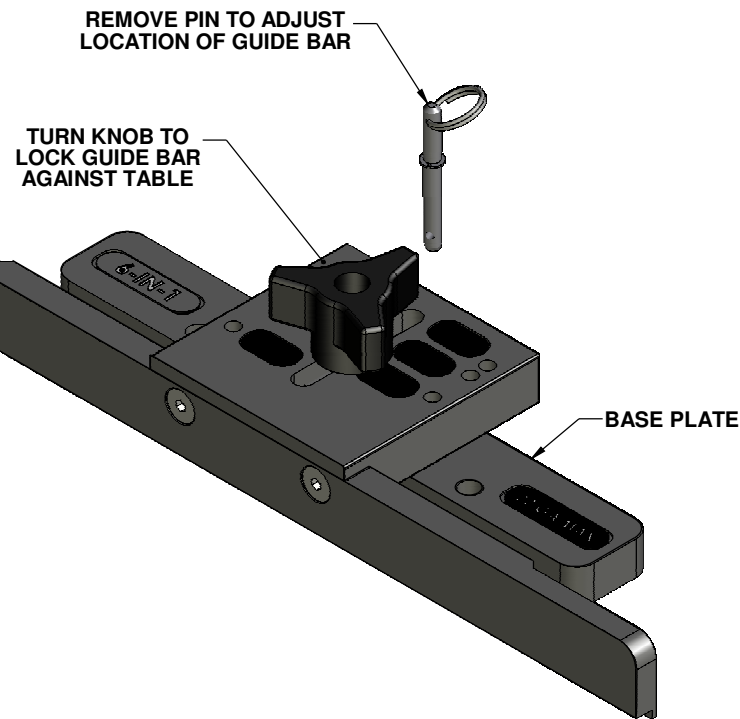
ADJUSTABLE GUIDE BAR FOR 6-IN-1 TAP-IN AUXILIARY ROLL SET



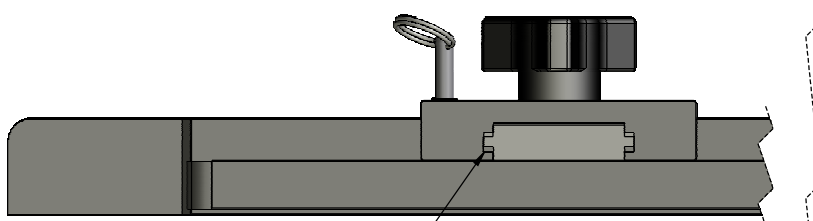
TOP VIEW



FRONT VIEW



SIDE VIEW



DOVETAIL SLOTS LOCK ADJUSTABLE GUIDE BAR INTO BASE PLATE
BACK VIEW

RAMS 2014 - AUXILIARY MACHINE

DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL $\pm 1/16$ ANGULAR: MACH \pm BEND \pm TWO PLACE DECIMAL $\pm .01$ THREE PLACE DECIMAL $\pm .005$			NAME SSL	DATE 9/2/08	HORIZON SYSTEMS MACHINING 9121 58TH PLACE KENOSHA, WI 53144 PH: 262-605-1122 FAX: 262-605-1198	
DRAWN	CHECKED	ENG APPR.	MFG APPR.	Q.A.		
MATERIAL SEE BOM						TITLE 6-IN-1 ROLLERS, SQ. DR.
FINISH N/A						SIZE C
DO NOT SCALE DRAWING					SCALE: 1:1 SHEET 2 OF 2	