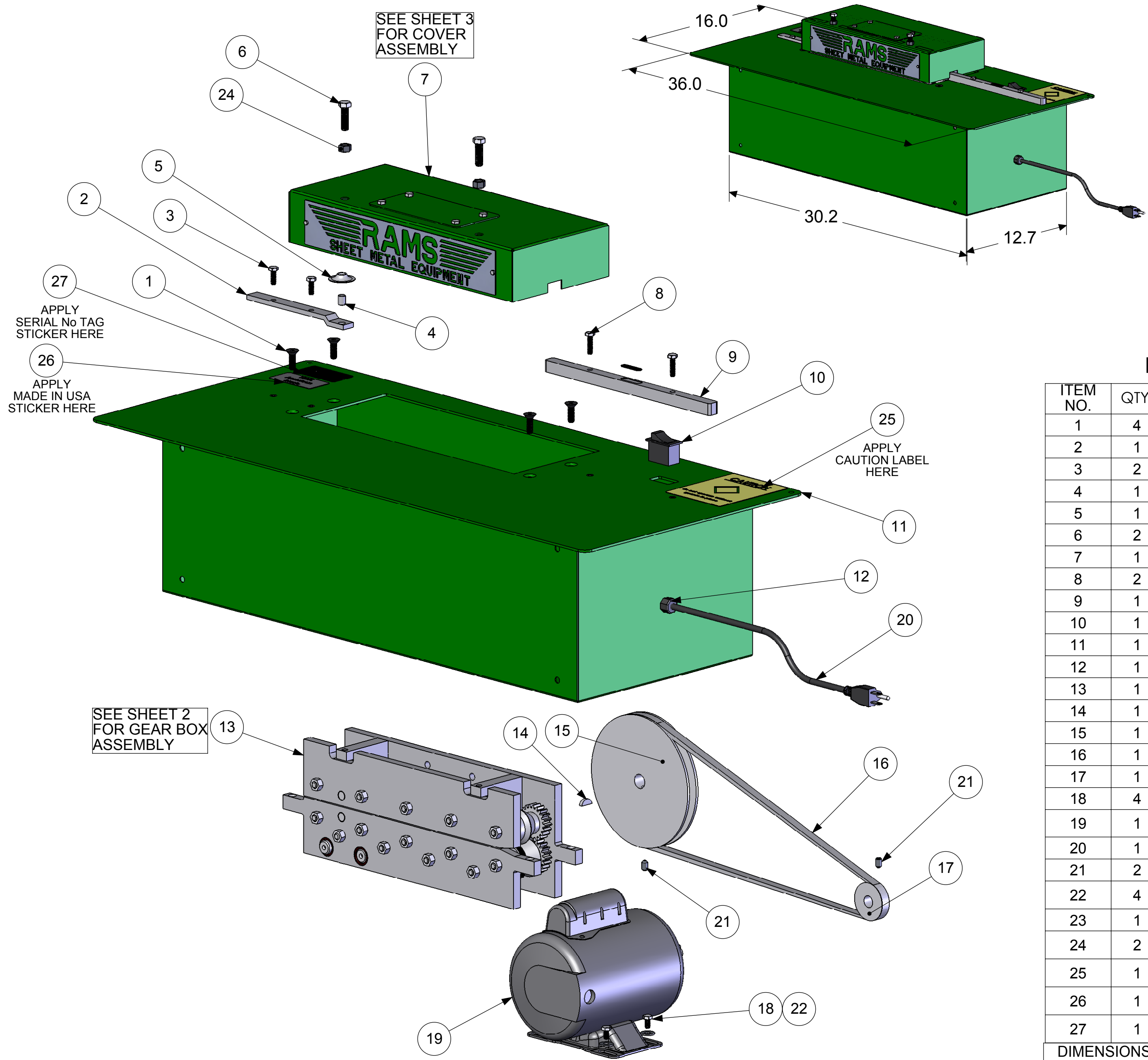


REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
D	ADDED LABELS	12/11/08	SSL



RAMS 24-28 PITTSBURGH MACHINE

ITEM NO.	QTY.	PART NUMBER	Description
1	4	2445	5/16-18 x 1" LONG FHCS
2	1	31909	OPENING ROLLER HOLDER
3	2	2452	HHCS, 1/4-20 X 3/4", ZINC
4	1	2448	3/8" DIA X 1/2" LONG DOWEL PIN
5	1	2424	OPENING ROLL
6	2	2440	HHCS, 3/8-16 X 1 1/4", ZINC
7	1	2421	COVER ASSY, RAMS 24-28 PITTSBURGH
8	2	2446	HHCS, 1/4-20 X 1", ZINC
9	1	36008	GUIDE
10	1	3XS59	TIPPETTE SWITCH
11	1	2420	BOX WELDMENT
12	1	69915K51	CORD GRIP
13	1	200-P1	GEAR BOX, RAMS 24-28 PITTSBURGH
14	1	2041	WOODRUFF KEY 606
15	1	CA700x.750	7" PULLEY
16	1	4L-450	BELT
17	1	CA200	2-INCH PULLEY .625 BORE
18	4	2447	HHCS, 1/4-20 X 1/2", ZINC
19	1	N/A	1/2 HP, 110V MOTOR
20	1	CORD1	POWER CORD
21	2	N/A	SET SCREW, 5/16-18 X 1/2", BLACK
22	4	Flat Washer - Zinc	1/4" x 1 1/4" OD Flat Washer, Zinc Plated
23	1	24 GA MAX	LABEL, 24 GA MAX
24	2	NUT-HEX CS .375-16	NUT-HEX, 3/8-16 CS
25	1	Caution Label	LABEL, CAUTION
26	1	Made in the USA	LABEL, MADE IN USA
27	1	RAMS 24-28	SERIAL No. TAG, RAMS 2428

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

	NAME	DATE
DRAWN	JAS	3/15/06
CHECKED	SSL	12/11/08
ENG APPR.		
MFG APPR.		
Q.A.		

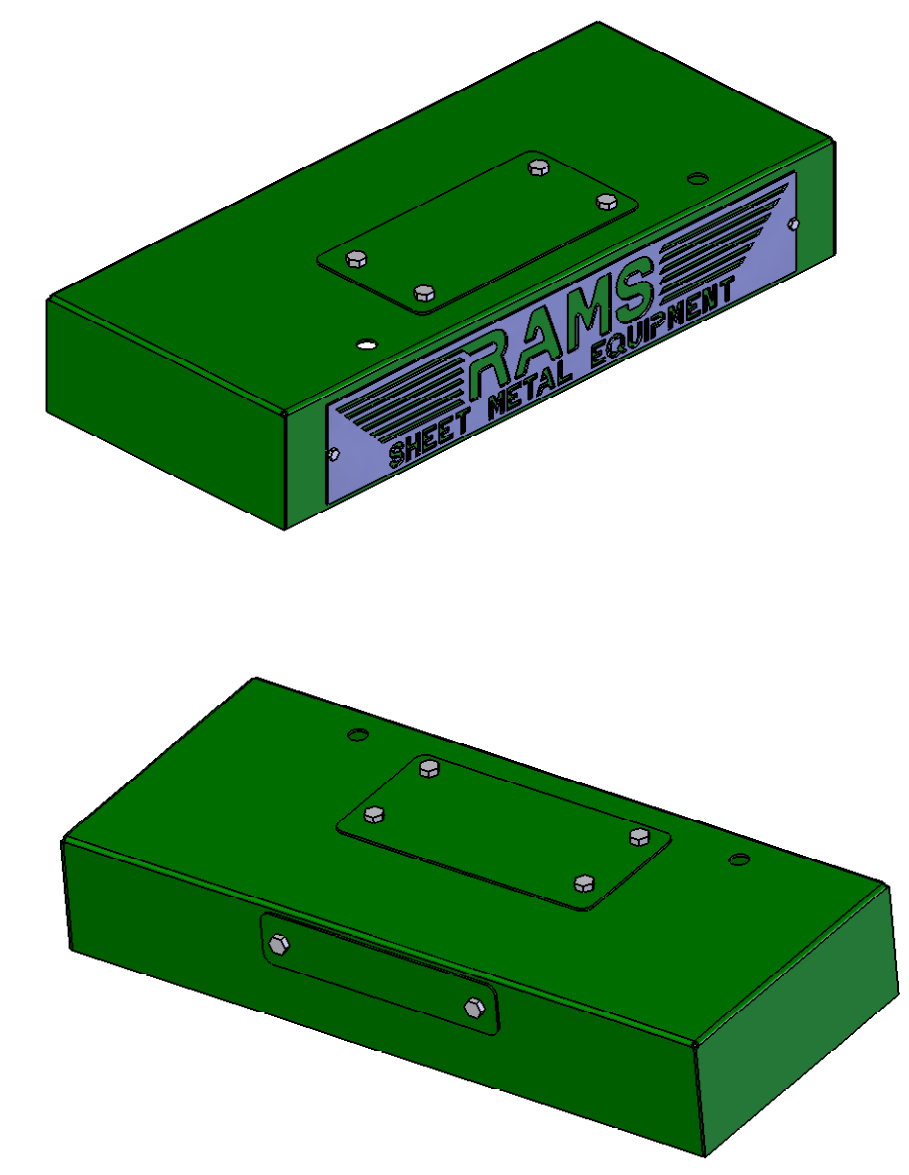
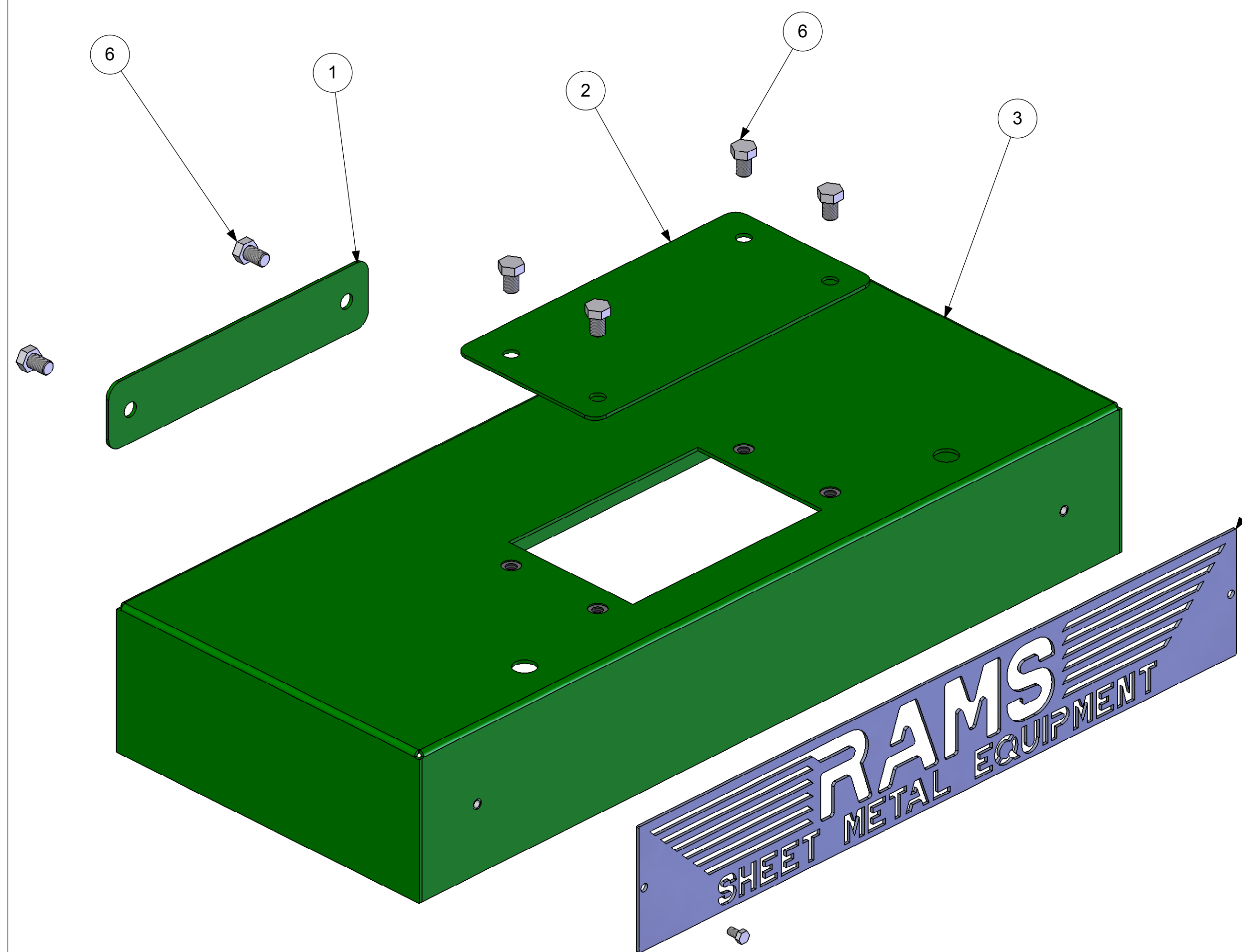
HORIZON SYSTEMS MACHINING
 9121 58TH PLACE
 KENOSHA, WI 53144
 PH: 262-605-1122
 FAX: 262-605-1198

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MATERIAL	SEE BOM
FINISH	N/A
DO NOT SCALE DRAWING	

TITLE: RAMS 24-28 PITTSBURGH MACHINE		
SIZE	DWG. NO.	REV
C	RAMS 24-28	D
SCALE: 1:4		SHEET 1 OF 3

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



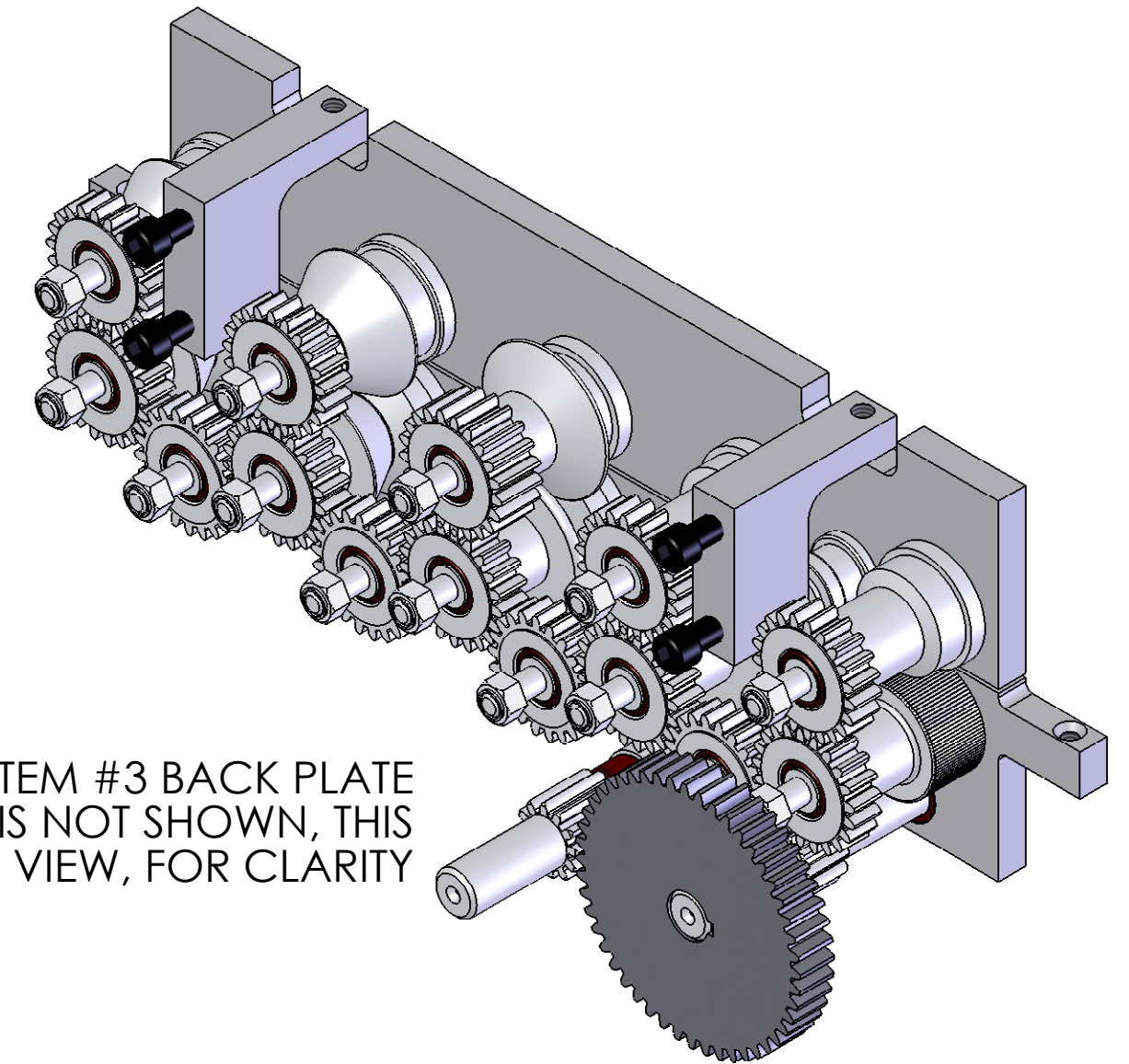
RAMS 24-28 PITTSBURGH MACHINE

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	2421-1	ACCESS COVER	1
2	2421-2	TOP COVER PLATE	1
3	2421-4	COVER	1
4	SMALL LOGO	RAMS MACHINE PLAQUE 2428	1
5	N/A	HHMS, 6-32 X 3/8", ZINC	2
6	HHCS CS .25-20 X .38	HH CAP SCREW, CS 1/4-20 X 3/8	6

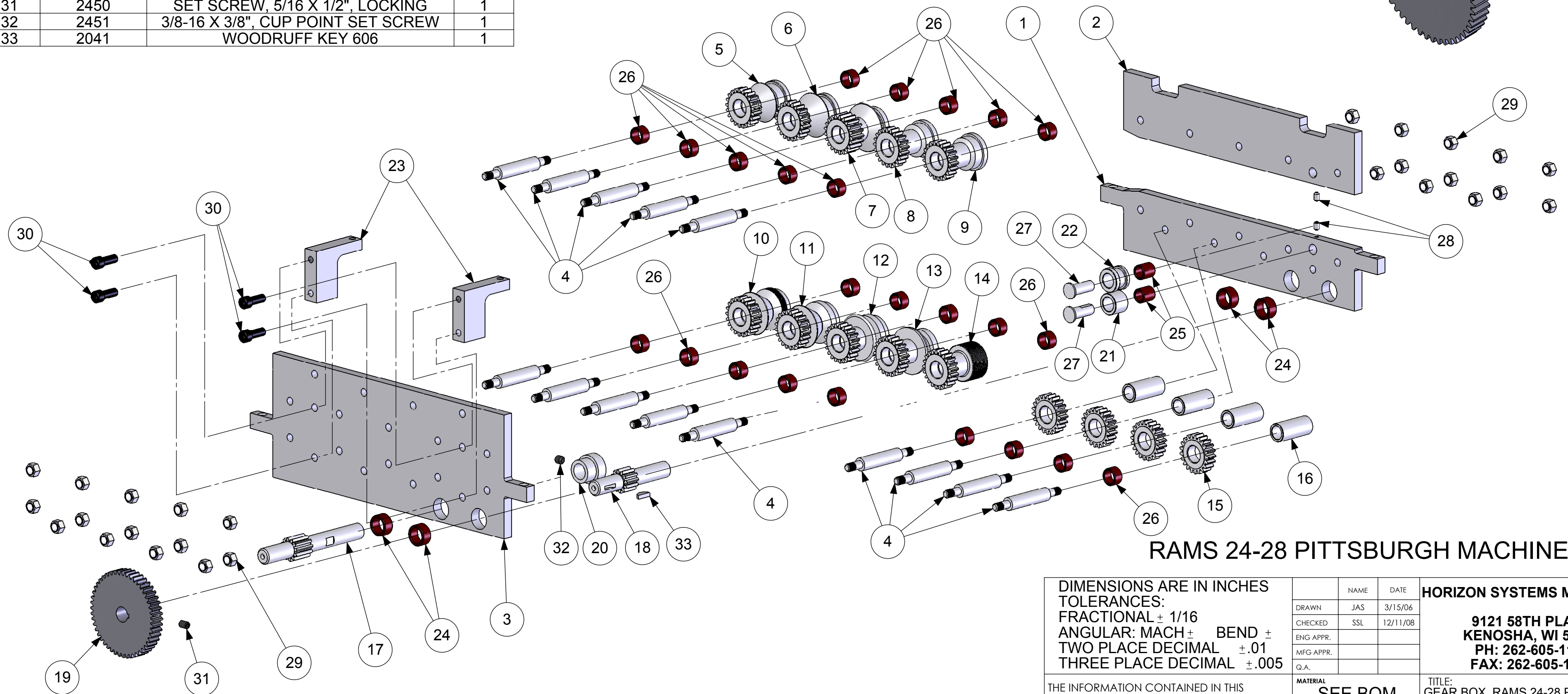
DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± 1/16 ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ±.01 THREE PLACE DECIMAL ±.005	DRAWN JAS 3/15/06 CHECKED SSL 12/11/08 ENG APPR. MFG APPR. Q.A.	HORIZON SYSTEMS MACHINING 9121 58TH PLACE KENOSHA, WI 53144 PH: 262-605-1122 FAX: 262-605-1198
	MATERIAL SEE BOM	TITLE: COVER ASSY, RAMS 24-28 PITTSBURGH
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DO NOT SCALE DRAWING	SCALE: 1:1.5	SHEET 3 OF 3

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	2402	LOWER FRONT PLATE	1
2	2403	UPPER FRONT PLATE	1
3	2401	BACK PLATE	1
4	2438	SPACER	14
5	2414	T1 FORMING ROLLER	1
6	2413	T2 FORMING ROLLER	1
7	2412	T3 FORMING ROLLER	1
8	2410	T4 FORMING ROLLER	1
9	2411	T5 FORMING ROLLER	1
10	2409	B1 FORMING ROLLER	1
11	2408	B2 FORMING ROLLER	1
12	2407	B3 FORMING ROLLER	1
13	2406	B4 FORMING ROLLER	1
14	2405	B5 FORMING ROLLER	1
15	2430	IDLER GEAR	4
16	2438-1	TUBE SPACER	4
17	2415	DRIVE SHAFT 1ST	1
18	2416	DRIVE SHAFT 2ND	1
19	2417	4" DRIVE GEAR	1
20	14624	COLLAR	1
21	2433	LOWER IDLER ROLL	1
22	2432	UPPER IDLER ROLL	1
23	40280	BRACKET	2
24	B128	BEARING	4
25	B812	BEARING	2
26	B-108	BEARING	24
27	2435	IDLER ROLL PIN	2
28	N/A	SET SCREW, 1/4-20 X 1/4", BLACK	2
29	2439	3/8-24 NYLOC HEX NUT	28
30	HW-1052	SHCS, 3/8-16 X 1", BLACK	4
31	2450	SET SCREW, 5/16 X 1/2", LOCKING	1
32	2451	3/8-16 X 3/8", CUP POINT SET SCREW	1
33	2041	WOODRUFF KEY 606	1

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



ITEM #3 BACK PLATE IS NOT SHOWN, THIS VIEW, FOR CLARITY



RAMS 24-28 PITTSBURGH MACHINE

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 FRACTIONAL ± 1/16
 ANGULAR: MACH ± BEND ±
 TWO PLACE DECIMAL ±.01
 THREE PLACE DECIMAL ±.005

	NAME	DATE
DRAWN	JAS	3/15/06
CHECKED	SSL	12/11/08
ENG APPR.		
MFG APPR.		
Q.A.		

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MATERIAL	SEE BOM		
FINISH	N/A		
DO NOT SCALE DRAWING			

TITLE: GEAR BOX, RAMS 24-28 PITTSBURGH		
SIZE	DWG. NO.	REV
C	RAMS 24-28	D
SCALE: 1:4		SHEET 2 OF 3