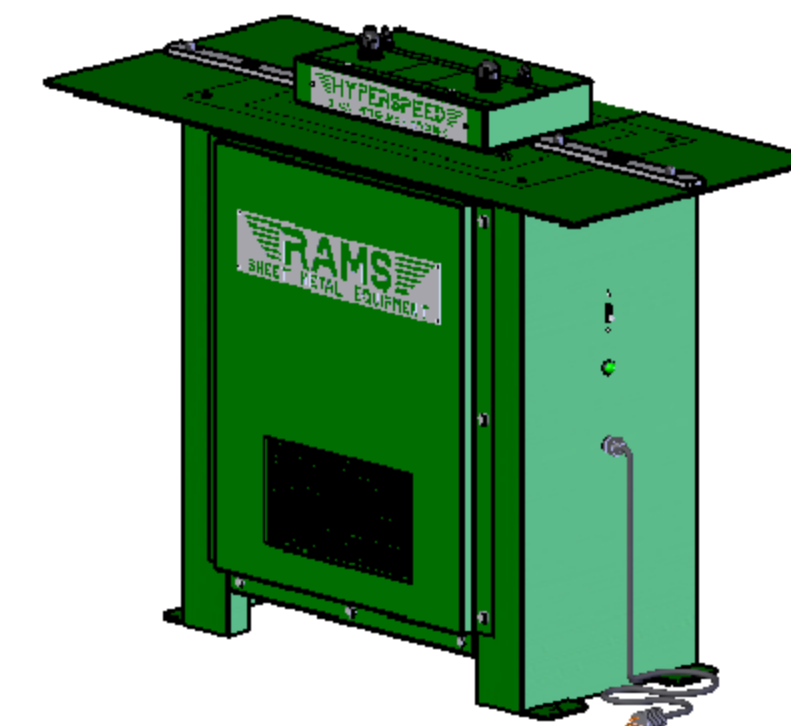
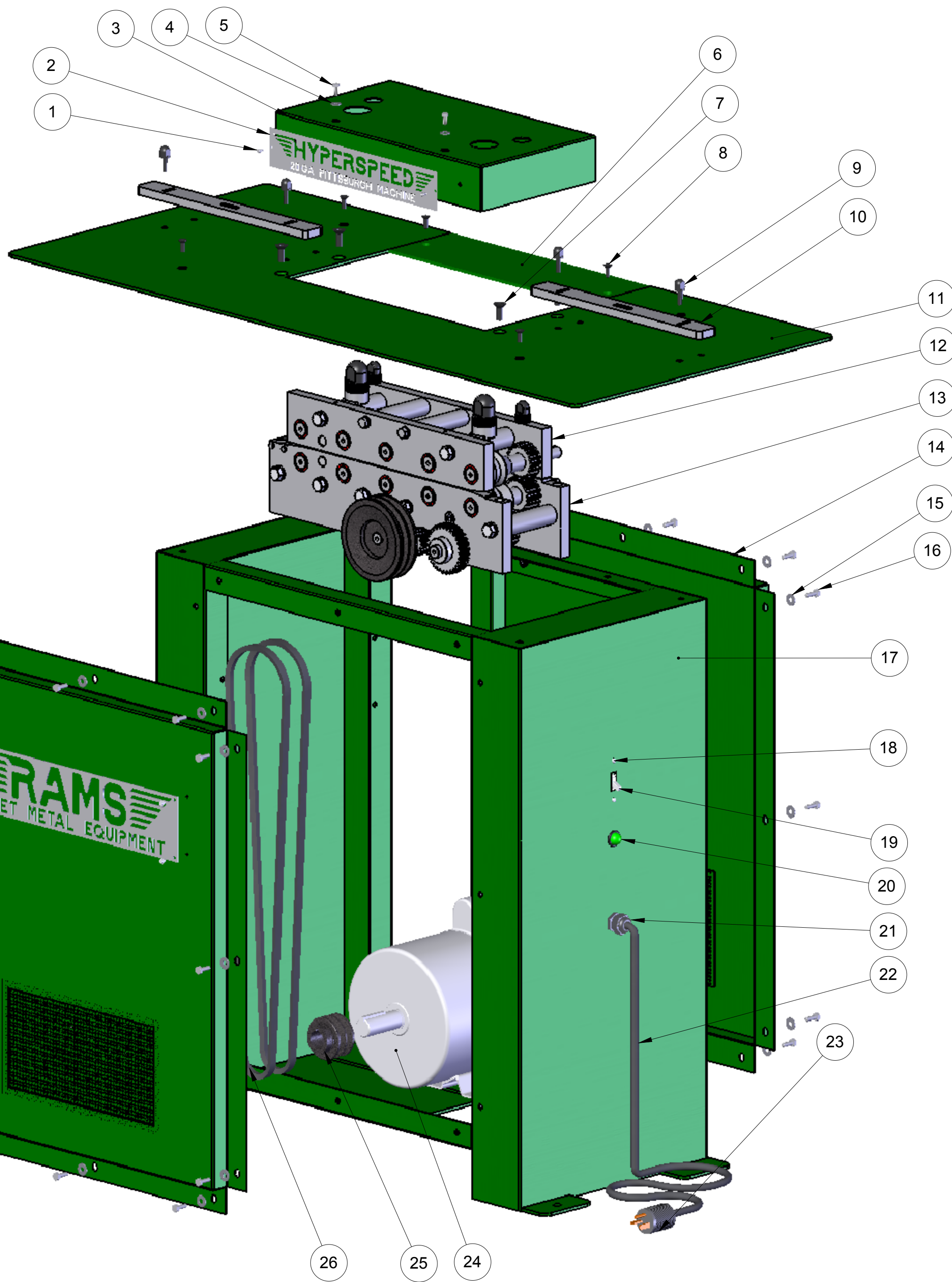


REVISIONS		
REV.	DESCRIPTION	DATE
A	INITIAL RELEASE	2/28/2007
B	CHANGE SWITCH AND CORD GRIP	3/13/2007
C	CORRECT PART NUMBER FROM 6991KK57 TO 69915K57 CHANGE DESCRIPTION TO READ 1/2" NPT CORD GRIP	3/21/2007
D	DELETE PART HY-1300 AND REPLACE WITH HY-1305 AND HY-1310	3/26/2007



RAMS-2012 20 GA HYPERSPEED PITTSBURGH MACHINE

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	2441	6-32 X 1/4" SOCKET HEAD CAP SCREW	2
2	HY-1052	PLATE, HYPERSPEED	1
3	HY-1054	HYPERSPEED TOP COVER ASSY	1
4	N/A	1/2" WASHER, PLAIN, FLAT NARROW	2
5	N/A	HHCS, 1/4-20 X 1/2	2
6	HY-1053	COVER, AUXILARY ACCESS	1
7	2061	3/8-16 x 1" FLAT SOCKET HEAD CAP SCREW	4
8	PITT-21	FHSCS 1/4-20 X .75	6
9	2054	ADJUSTING BOLT: 1/4-20 THREAD	4
10	HY-1055	GUIDE BAR ASSY	2
11	HY-1051	HYPERSPEED TOP PLATE ASSY	1
12	HY-1310	TOP GEAR BOX ASSY	1
13	HY-1305	BOTTOM GEAR BOX ASSY	1
14	HY-1201-002	BACK PANEL ASSEMBLY	1
15	HW-1007	WASHER, FLAT, 1/4" STANDARD, SS	24
16	HW-1014	HHCS, 1/4-20 X .75, SS	24
17	HY-1201	HYPERSPEED CABINET, ASSEMBLED	1
18	HW-1002	PHMS, 6-32 X 1/2"	2
19	N/A	30A, 220 VOLT, AC SWITCH	1
20	N/A	220 VOLT LIGHT ASSY	1
21	69915K57	CORD GRIP	1
22	N/A	13 FT, 12/3 S.O. CORD	1
23	N/A	5466C HUBBELL PLUG, 250 V 20A	1
24	N/A	3 HP, 1750 RPM, 220V, 184T MOTOR	1
25	2AK25X1 1/8	DUAL BELT PULLEY, 2.55" DIA X 1.125" BORE	1
26	AX55	AX55 V-BELT	2
27	HY-1201-001	FRONT PANEL ASSEMBLY	1
28	PITT-22	RAMS LOGO SIGN	1
29	HW-1026	HHCS, TYPE F THD CUTTING, 8-32 X 1/4"	4

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

NAME	DATE
DRAWN RAF	02/28/07
CHECKED	
ENG APPR.	
MFG APPR.	
Q.A.	

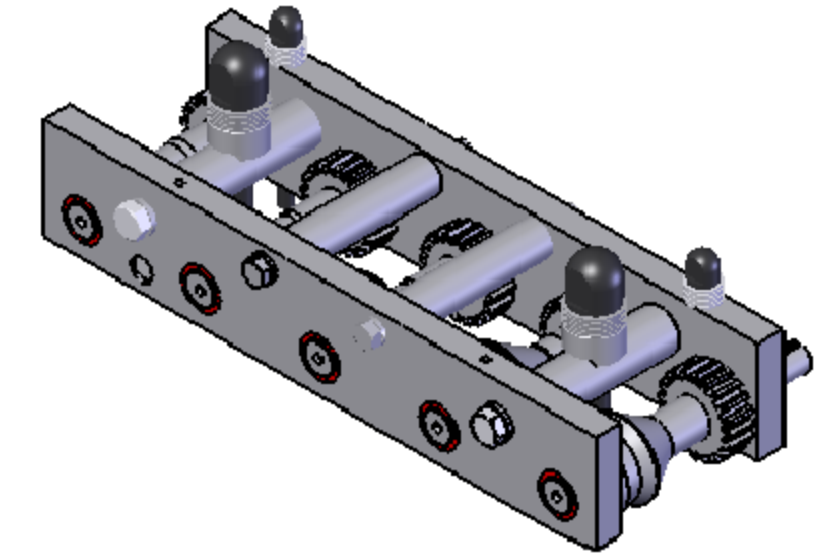
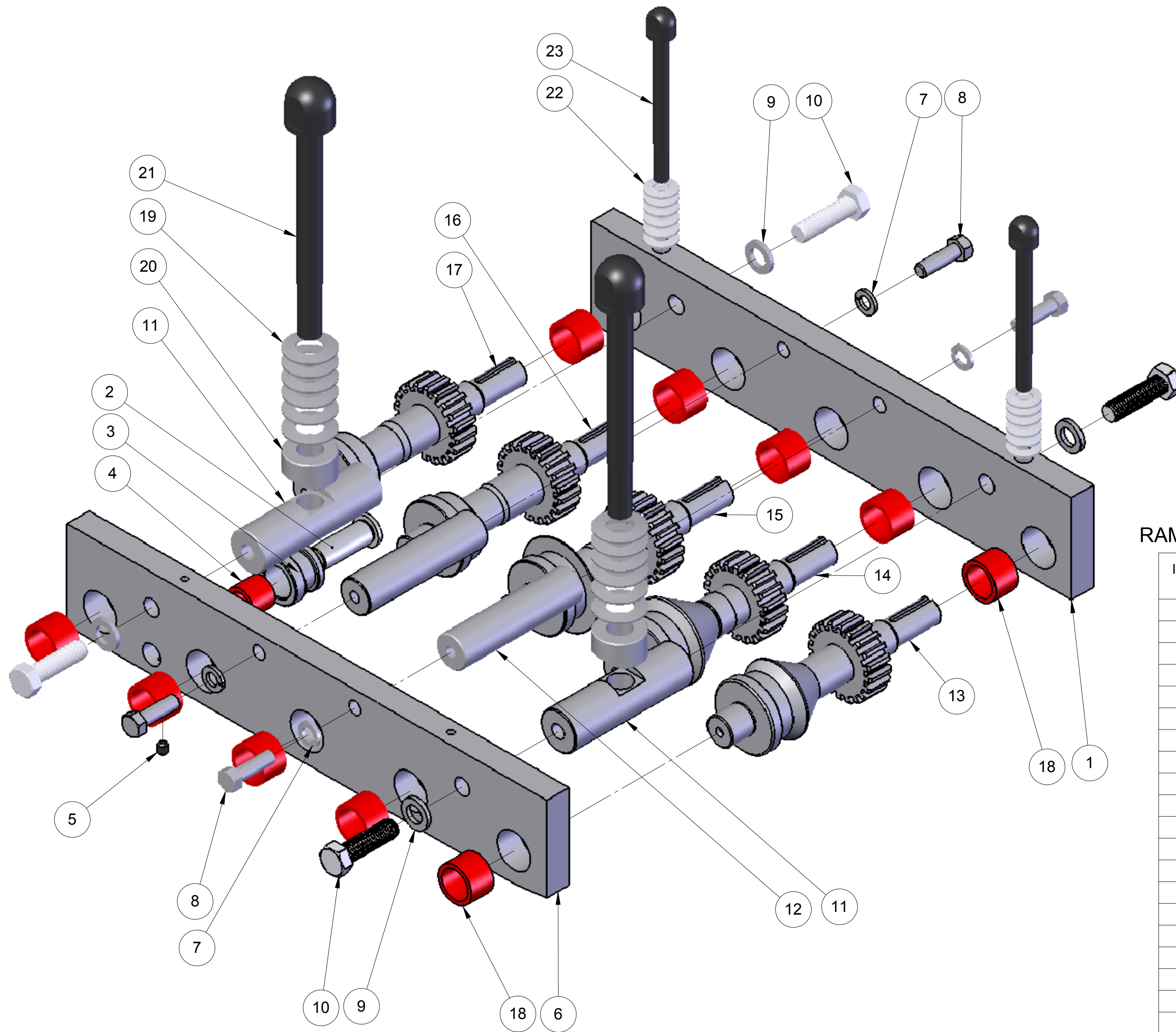
HORIZON SYSTEMS MACHINING
 9121 58TH PLACE
 KENOSHA, WI 53144
 PH: 262-605-1122
 FAX: 262-605-1198

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MATERIAL	SEE BOM
FINISH	N/A
DO NOT SCALE DRAWING	

TITLE: 20 GA. HYPERSPEED PITTSBURGH MACHINE		
SIZE	DWG. NO.	REV
C	HY-2012	D
SCALE: 1:5		SHEET 1 OF 1

REVISIONS		
REV.	DESCRIPTION	DATE
A	INITIAL RELEASE	2/28/2007
B	ADD ADJUSTING BOLTS AND BELVILLE WASHERS TO ASSEMBLY	3/26/2007



RAMS-2012 20 GA HYPERSPEED PITTSBURGH MACHINE

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	2027	TOP PLATE (BACK)	1
2	2012	IDLER ROLL PIN	1
3	2011	IDLER ROLLER	1
4	2069	NEEDLE BEARING # BH-1012	1
5	2035	SET SCREW, 1/4-20 X 5/16"	1
6	2026	TOP PLATE (FRONT)	1
7	N/A	WASHER, LOCK, 3/8"	4
8	N/A	HHCS, 3/8-16 X 1.25	4
9	2033	1/2" LOCK WASHER	4
10	2032	HHCS, 1/2-13 X 1 1/2"	4
11	2017	PLAIN SPACER (DRILLED)	2
12	2070	TOP SPACER	2
13	2001	T1 ROLLER GEAR	1
14	2002	T2 ROLLER GEAR	1
15	2003	T3 ROLLER GEAR	1
16	2004	T4 ROLLER GEAR	1
17	2005	T5 ROLLER GEAR	1
18	2044	NEEDLE BEARING # B-1412	10
19	2050	LARGE BELLEVILLE WASHER	12
20	2021	SADDLE WASHER	2
21	2049	ADJUSTING BOLT: 5/8-11 THREAD	2
22	2051	SMALL BELLEVILLE WASHER	12
23	2052	ADJUSTING BOLT:3/8-16 THREAD	2

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

NAME	DATE
DRAWN RAF	02/28/07
CHECKED	
ENG APPR.	
MFG APPR.	
Q.A.	

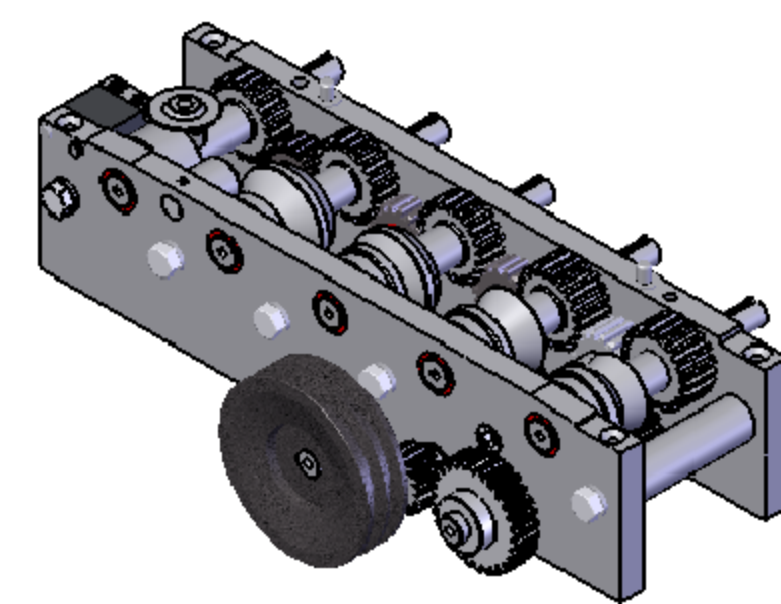
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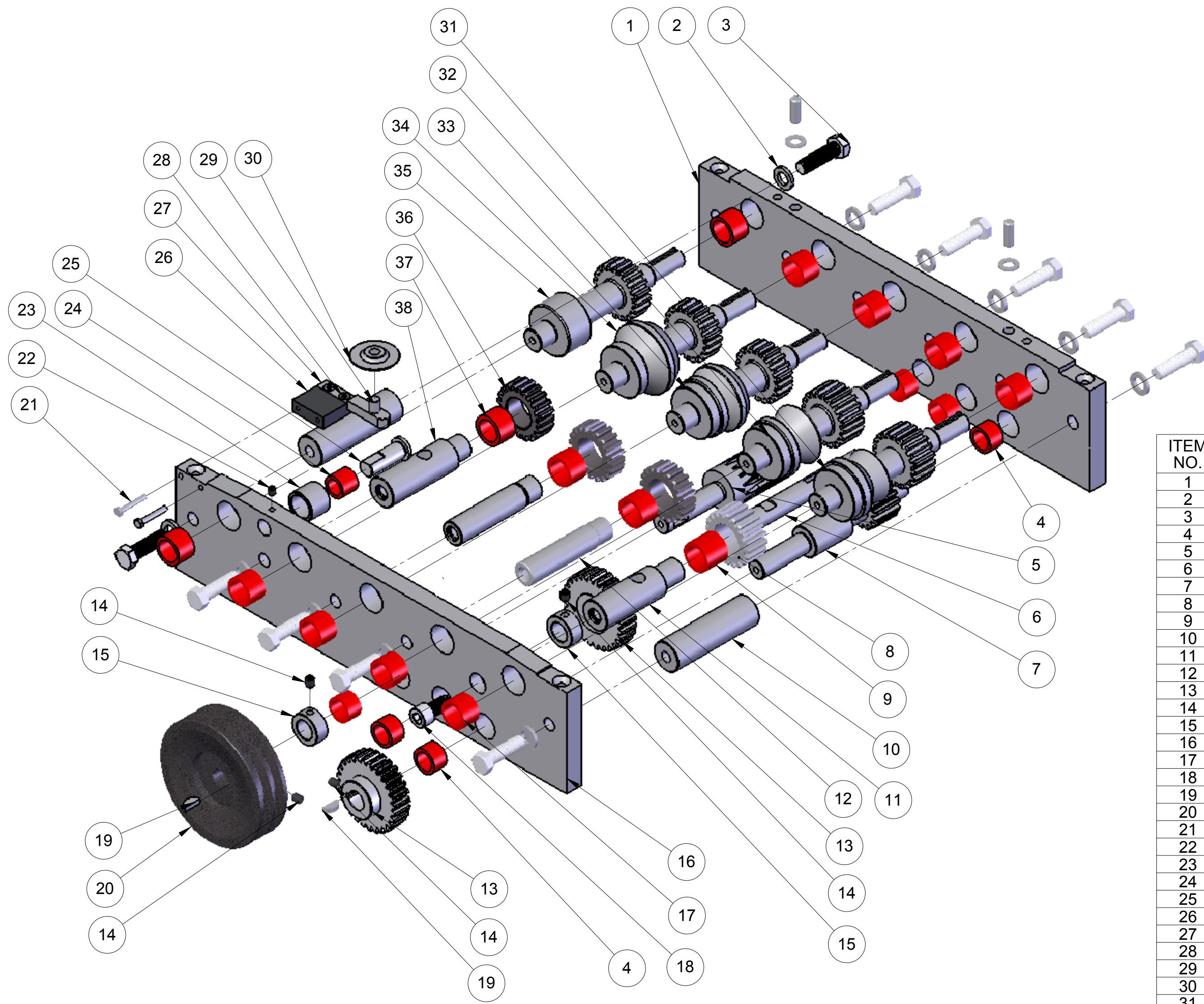
MATERIAL	SEE BOM
FINISH	N/A
DO NOT SCALE DRAWING	

TITLE:	TOP GEAR BOX ASSY		
SIZE	DWG. NO.	REV	
C	HY-1310	B	
SCALE: 1:2	SHEET 1 OF 1		

REVISIONS		
REV.	DESCRIPTION	DATE
A	INITIAL RELEASE	2/28/2007
B	ADD DOWEL PIN AND SPACER TO ASSEMBLY	3/26/2007



RAMS-2012 20 GA HYPERSPEED PITTSBURGH MACHINE



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	HY-1305-005	BOTTOM PLATE (BACK)	1
2	2033	1/2" LOCK WASHER	11
3	2032	HHCS, 1/2-13 x 1 1/2"	11
4	2046	NEEDLE BEARING #JTT-1210	6
5	HY-1305-001	#1 DRIVE SHAFT	1
6	HY-1305-002	#2 DRIVE SHAFT	1
7	HY-1305-003	#3 DRIVE SHAFT	1
8	2015	IDLER GEAR (LARGE)	1
9	2068	NEEDLE BEARING # BH-1416	1
10	2016	PLAIN SPACER	2
11	2019	STEPPED SPACER #2 (TAPPED)	1
12	2020	STEPPED SPACER #3	2
13	HY-1305-004	DRIVE GEAR	2
14	2040	SET SCREW, 5/16-18 X 3/8"	5
15	2039	SPACER	2
16	HY-1305-006	BOTTOM PLATE (FRONT)	1
17	2044	NEEDLE BEARING # B-1412	10
18	2034	1/2-13 X 1" LONG SHCS	1
19	2041	WOODRUFF KEY 606	3
20	2AK51X3/4	DUAL BELT PULLEY, 4.95" DIA X 3/4" BORE	1
21	N/A	HHMS, 10-32 X 1.25	2
22	2035	SET SCREW, 1/4-20 X 5/16"	1
23	2013	IDLER ROLLER	1
24	2069	NEEDLE BEARING # BH-1012	1
25	2012	IDLER ROLL PIN	1
26	2060	OPEN ROLL SPACER	1
27	2059	OPEN ROLL BAR	1
28	N/A	FHCS, 10-32 X 1/2"	2
29	2037	3/8" DIA X 7/8" LONG DOWEL PIN	1
30	2031	OPENING ROLLER	1
31	2006	B1 ROLLER GEAR	1
32	2007	B2 ROLLER GEAR	1
33	2008	B3 ROLLER GEAR	1
34	2009	B4 ROLLER GEAR	1
35	2010	B5 ROLLER GEAR	1
36	2014	IDLER GEAR	3
37	2045	NEEDLE BEARING # BH-1412	3
38	2018	STEPPED SPACER #1 (TAPPED)	1
39	DPM 0.375x1	DOWEL PIN 3/8 DIA X 1 LONG	2
40	SPACER	SPACER-SIDE PLATE	2

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

DRAWN	NAME	DATE
CHECKED	RAF	02/23/07
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MFG APPR.		
Q.A.		

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MATERIAL	SEE BOM	TITLE:	BOTTOM GEAR BOX ASSY
FINISH	SEE NOTES	SIZE	DWG. NO. HY-1305
DO NOT SCALE DRAWING	SCALE: 1:3	REV	B

SHEET 1 OF 1