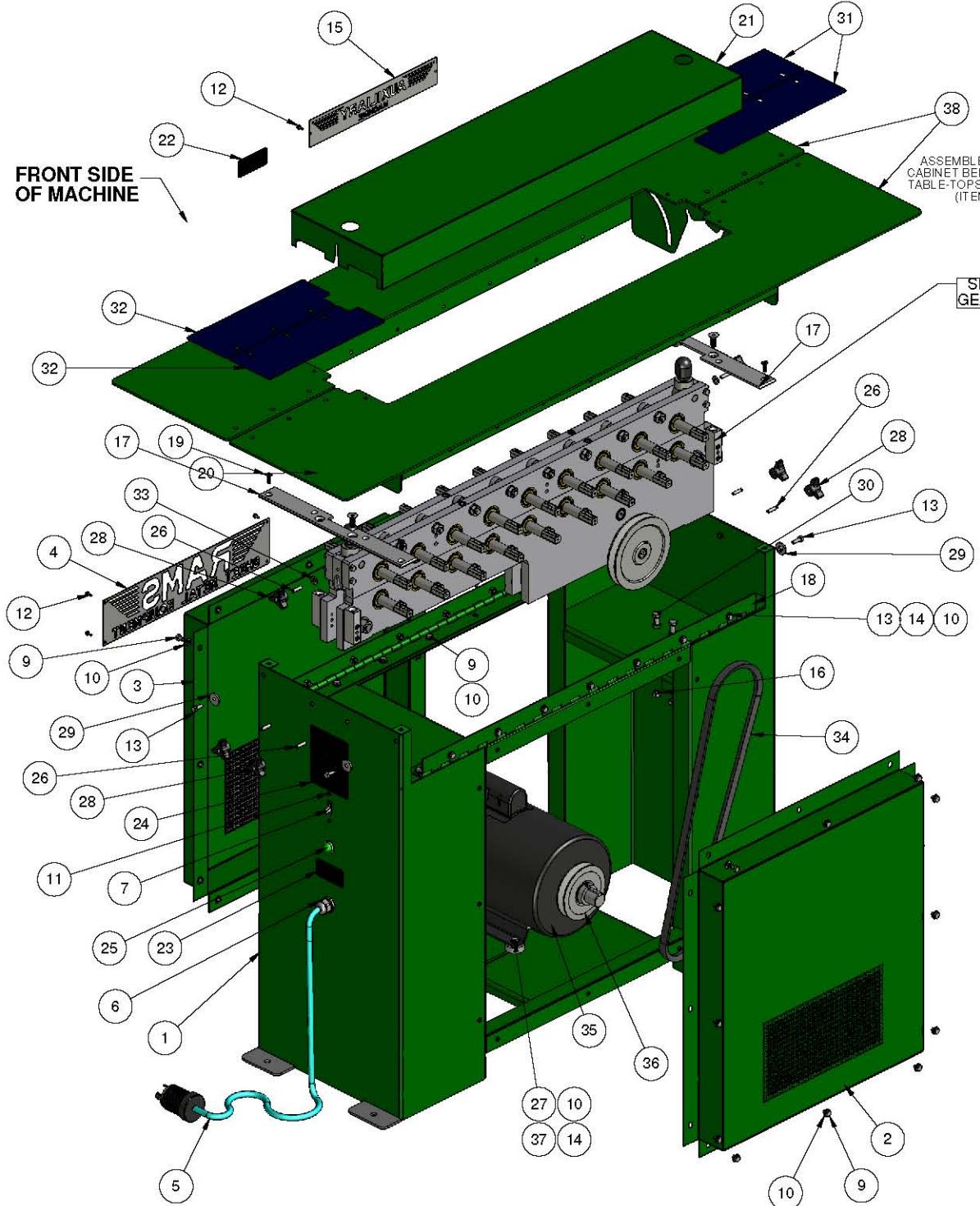


FRONT SIDE OF MACHINE



REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
N/A	A	INITIAL RELEASE	9/30/08	SSL
	B	ADDED/REVISED ITEMS 32 THRU 40	12/11/08	SSL
	C	BK47x1.125 PULLEY WAS BK34x1.125	4/7/2009	SSL
	D	AX-1736 QTY 2 WAS QTY 1 ; DELETED AX-1737	8/22/2009	SSL
	E	ADDED HY-1355; DELETED HY-1340 & HY-1350	10/8/2009	SSL
	F	ITEM 38, AX-1728 WAS REVISED TO REV.C; ITEM 31 WAS AX-1736; ITEM 32 WAS AX-1735	7/14/2010	DRP

RAMS - 2014,AUXILIARY MACHINE

SEE DRAWING AX-1500 FOR GEARBOX ASSEMBLY DETAILS 8

ITEM NO.	PART NUMBER	DESCRIPTION	DEFAULT/QTY.
1	AX-1700	AX CABINET ASSEMBLY	1
2	AX-1201-002	BACK PANEL ASSEMBLY	1
3	AX-1201-001	FRONT PANEL ASSEMBLY	1
4	PITT-22	RAMS LOGO SIGN	1
5	N/A	POWER CORD ASSEMBLY	1
6	69915K57	CORD GRIP	1
7	N/A	30A, 220 VOLT, AC SWITCH	1
8	AX-1500	GEAR BOX ASSEMBLY	1
9	HW-1031	HHCS, 1/4-20 X 3/8", ZINC	40
10	HW-1009	WASHER, 1/4" FLAT, 5/8" O.D., ZINC	60
11	HW-1002	PHMS, 8-32 X 1/2", ZINC	2
12	HW-1026	HHCS, TYPE F THD CUTTING, 8-32 X 3/8", ZINC	6
13	HW-1014	HHCS, 1/4-20 X 3/4", ZINC	18
14	HW-1047	NUT, HEX, NYLOCK, 1/4-20, ZINC	18
15	AX-1016	PLATE, AUX. MACHINE	1
16	HW-1051	NUT, HEX, 3/8-16, ZINC	4
17	AX-1726	PLATE, CABINET TOP	2
18	AX-1740	hinge, 2.5 wide X 38 long	2
19	HW-1045	FHCS, 1/4-20 X 3/4", BLACK OXIDE	4
20	HW-1096	FHCS, 3/8-16 X 1", BLACK	4
21	AX-1725	TOP COVER	1
22	Made in the USA	LABEL, MADE IN USA	1
23	RAMS 2014	SERIAL NUMBER TAGS	1
24	Caution Label	LABEL, CAUTION	1
25	N/A	220 VOLT LIGHT ASSY	1
26	HW-1092	SET SCREW, 1/4-20 X 1", CUP POINT	6
27	HW-1023	HHCS, 1/4-20 X 1.25"	4
28	KLK-10	KNOB, 3-PRONG	6
29	AX-1733	SLEEVE, STOP	4
30	AX-1735	CUSTOM HHCS, 3/8-16 x 1-1/2"	4
31	AX-1736-1	WEAR PLATE, EXIT	2
32	AX-1738-1	WEAR PLATE, ENTRANCE	2
33	HW-1033	WASHER, NYLON, 1/4" I.D. X .687 O.D. X .06 THK	2
34	V-BELT	5L580 V-BELT	1
35	5HP - 184T	5 HP, 1740 RPM, 230V, 182T-215T MOTOR	1
36	BK47x1.125	PULLEY, V-BELT, SINGLE	1
37	HY-1355	WASHER, MOTOR	4
38	AX-1728	TABLE ASSEMBLY	2

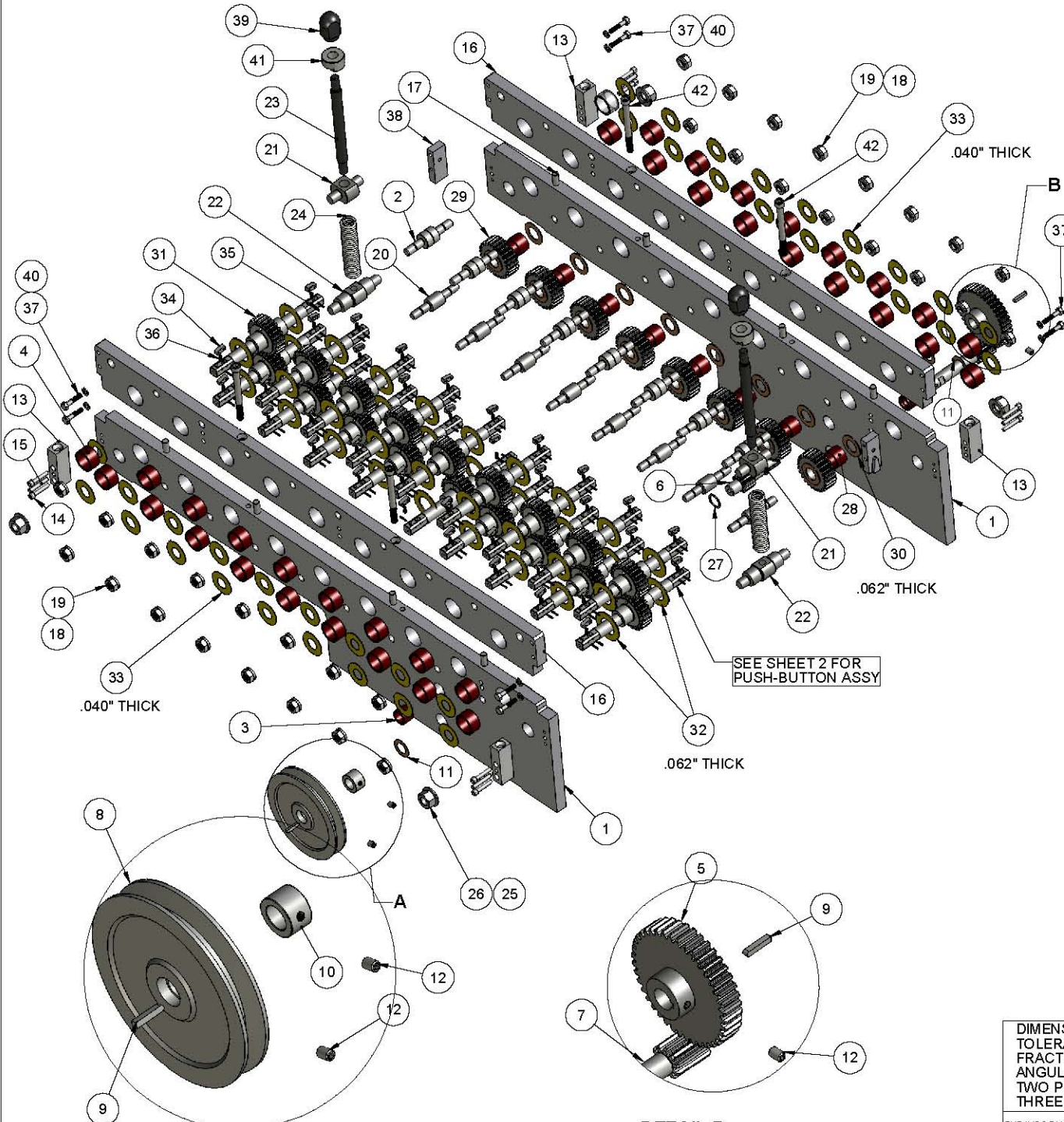
DIMENSIONS ARE IN INCHES
 TOLERANCES:
 FRACTIONAL ± 1/16
 ANGULAR: MACH ± BEND ±
 TWO PLACE DECIMAL ±.01
 THREE PLACE DECIMAL ±.005

NAME	DATE	HORIZON SYSTEMS MACHINING 9121 58TH PLACE KENOSHA, WI 53144 PH: 262-605-1122 FAX: 262-605-1198
DRAWN	8/15/08	
CHECKED	10/8/09	
ENG APPR.		
MFG APPR.		
MATERIAL		TITLE
SEE BOM		AUXILIARY MACHINE
FRSH	SIZE	DWG. NO.
SEE NOTES	C	AX-2014
DO NOT SCALE DRAWING		SCALE: 1:6
		SHEET 1 OF 1

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.

REV	F
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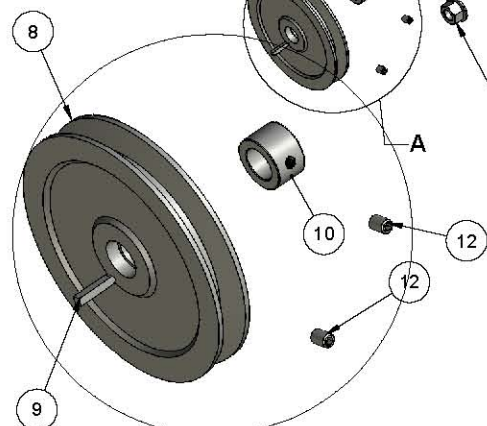
REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
N/A	A	INITIAL RELEASE	9/09/08	SSL
	B	ADD B-1812, AX-2055, 8 AX-1514, QTY 4 WAS QTY 40: HW-1023 WAS HW-1015-1	12/11/2008	SSL
	C	REVISED NOTES, ADDED 3/8 16x4 SHCS, BK62x75 WAS BK60x75	4/15/2009	SSL
	D	REVISED WASHER DESCRIPTIONS	9/24/2009	SSL



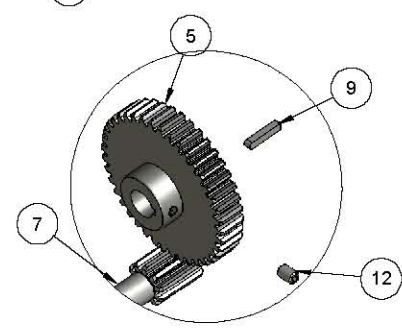
RAMS - 2014, AUXILIARY MACHINE

ITEM NO.	PART NUMBER	DESCRIPTION	Default QTY
1	AX-1503	SIDE PLATE, BOTTOM	2
2	AX-1510	SPACER, SMALL THREADED	8
3	B-1212	NEEDLE ROLLER BEARING	4
4	B-1812	Ø1.125 x Ø1.375 x .75 BEARING	36
5	S&D-1302	#2 DRIVE GEAR	1
6	AX-1303	#3 DRIVE GEAR	1
7	AX-1301	#1 DRIVE GEAR	1
8	BK62x.75	PULLEY	1
9	HW-1040	KEY, 3/16 X 3/16 X 1	2
10	HY-1330	SPACER	1
11	S&D-1506	BRASS WASHER, 1.25 OD X .760 ID X .03	3
12	HW-1093	SET SCREW, 5/16-18 X 1/2, CUP POINT, BLACK	3
13	AX-1004	SUPPORT FOOT	4
14	HW-1076	SHCS, 1/4-20 X 1 1/4", BLACK	8
15	HW-1151	DOWEL PIN, 1/4" X 1 1/2"	4
16	AX-1502	SIDE PLATE, TOP	2
17	HW-1150	DOWEL PIN, 3/8" X 1-1/4"	8
18	HW-1102	WASHER, SPLIT LOCK, 1/2", ZINC	32
19	HW-1108	Hex Nut, 1/2-13	32
20	AX-1513	SPACER, SMALL THREADED	8
21	AX-1511	SPACER, TOP, DRILLED	2
22	AX-1512	SPACER, BOTTOM, TAPPED	2
23	AX-2049	LOCKING BOLT: 1/2-13 THREAD	2
24	HW-2101	SPRING, Ø .984 x 5.0 LONG	2
25	HW-1013	WASHER, FLAT 5/8 X 1.312 O.D.	4
26	HW-1049	NUT, HEX, 5/8-11	4
27	AX-1505	BRASS WASHER, Ø .95 OD X Ø .760 ID X .06 THK	2
28	BRG-1016	NEEDLE BEARING, 7/8 ID X 1 3/16 OD X .75 THK, BH-1412	8
29	AX-1304	BRASS WASHER, 1.50 OD X .885 ID X .06 THK	8
30	AX-1507	BRASS WASHER, 2.00 OD X .760 ID X .06 THK	16
31	AX-1305	SHAFT, ROLLER GEAR	18
32	AX-1506	BRASS WASHER, 2.00 OD X .760 ID X .0625 THK	36
33	AX-1508	BRASS WASHER, 1.625 OD X .760 ID X .04 THK	36
34	AX-1331	PUSH-BUTTON, LOCKING	36
35	HW-1158	ROLL PIN, Ø3/32 x .56	72
36	HW-2100	SPRING, Ø .172 OD x .72 LONG	36
37	HW-1023	HHCS, 1/4-20 X 1.25"	8
38	AX-1504	LOCK PLATE	2
39	AX-2055	CUSTOM NUT, 1/2-13 THD	2
40	HW-1100	WASHER, SPLIT LOCK, 1/4"	8
41	AX-1514	SPACER	2
42	91251A640	SHCS, Ø3/8-16x4"	4

SEE SHEET 2 FOR PUSH-BUTTON ASSY



DETAIL A



DETAIL B

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

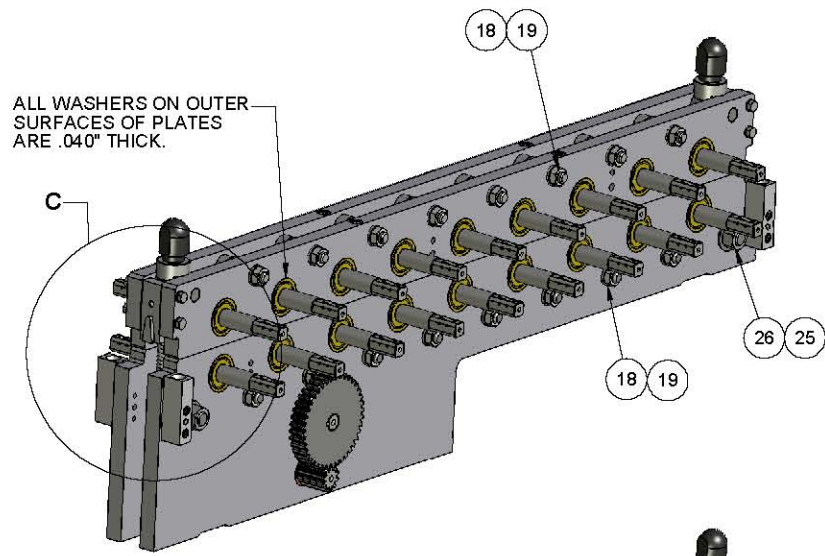
DRAWN	SSL	8/15/08
CHECKED	SSL	9/24/09
ENG APP.		
REG APP.		
G.A.		

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

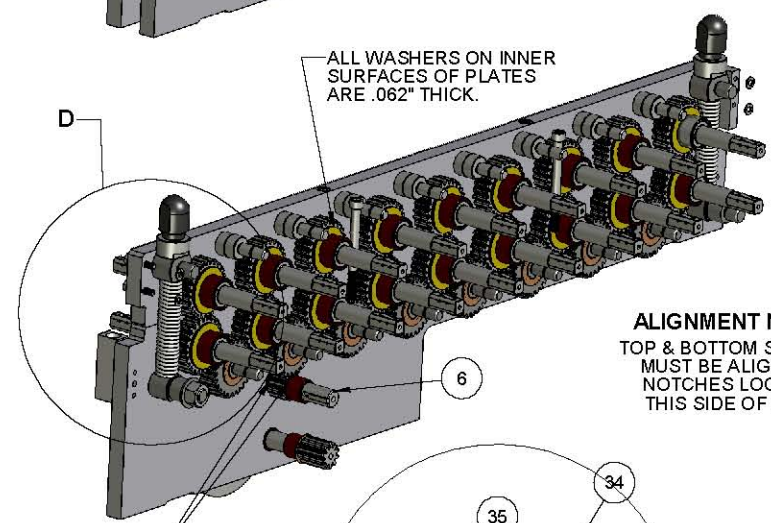
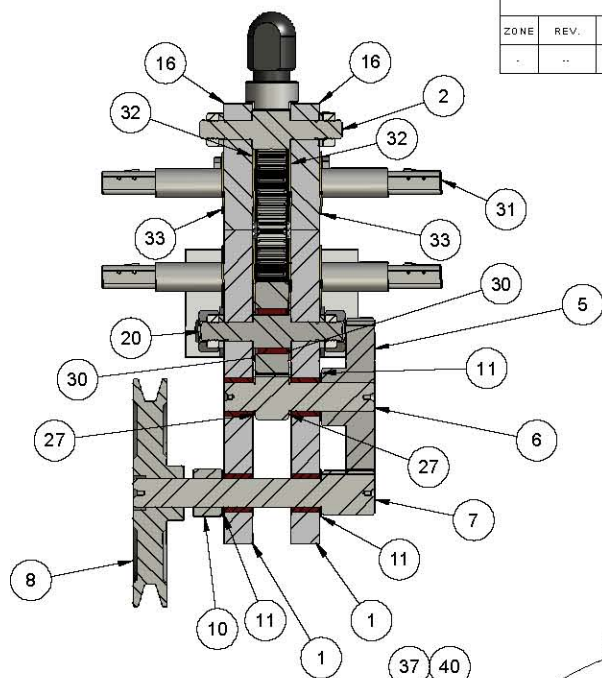
MATERIAL	SEE BOM	TITLE	GEAR BOX ASSEMBLY
SIZE	C	DWG. NO.	AX-1500
REV	D		

DO NOT SCALE DRAWING SCALE: 1:1.5 SHEET 1 OF 2

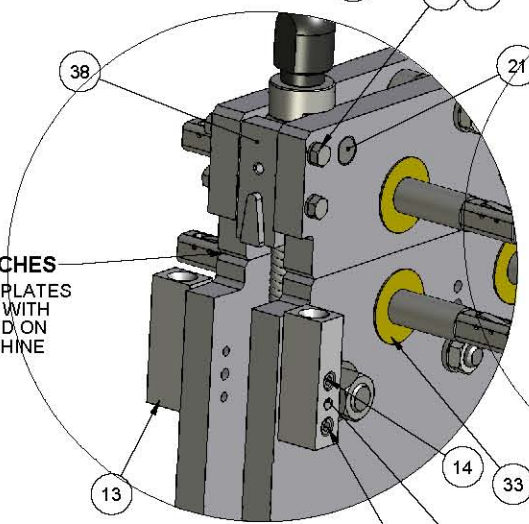
REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
-	-	See Sheet 1	-	-



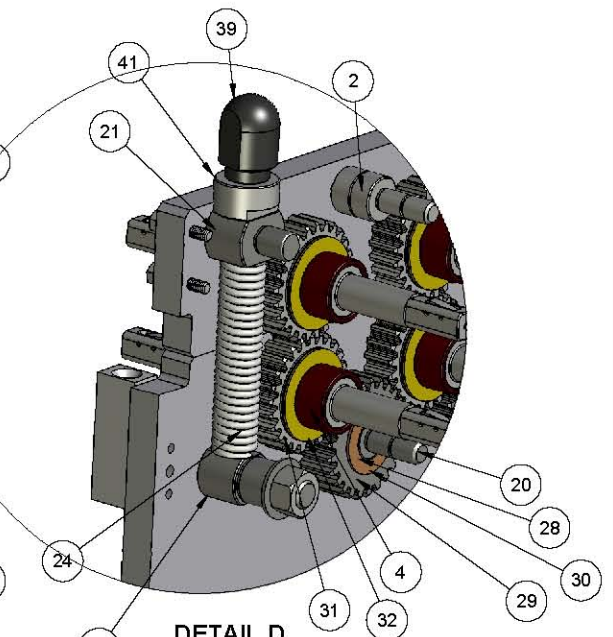
ALL WASHERS ON OUTER SURFACES OF PLATES ARE .040" THICK.



ALL WASHERS ON INNER SURFACES OF PLATES ARE .062" THICK.



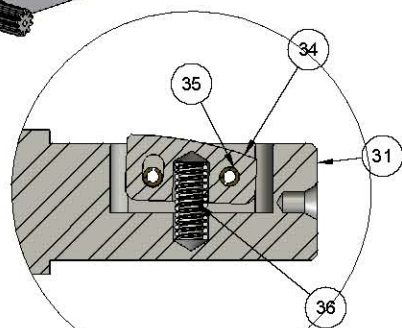
DETAIL C
SCALE 1 : 2



DETAIL D
SCALE 1 : 2

ALIGNMENT NOTCHES
TOP & BOTTOM SIDE PLATES
MUST BE ALIGNED WITH
NOTCHES LOCATED ON
THIS SIDE OF MACHINE

SMALL O.D. BRASS WASHER
ON #3 DRIVE GEAR



PUSH-BUTTON ASSEMBLY
ASSEMBLE SPRING INTO PUSH-BUTTON,
ASSEMBLE PUSH-BUTTON INTO SHAFT,
RETAIN WITH ROLL PINS.
ROLL-PINS MUST BE FLUSH OR BELOW SURFACE OF SHAFT
OR ROLLERS WILL NOT ASSEMBLE ONTO SHAFT

RAMS - 2014, AUXILIARY MACHINE

DIMENSIONS ARE IN INCHES			DRAWN		DATE		HORIZON SYSTEMS MACHINING		
TOLERANCES:			SSL	SSL	9/15/08	9121 58TH PLACE			
FRACTIONAL ± 1/16			CHECKED	SSL	9/24/09	KENOSHA, WI 53144			
ANGULAR: MACH ± BEND ±			ENG APPR.			PH: 262-605-1122			
TWO PLACE DECIMAL ±.01			REG APPR.			FAX: 262-605-1198			
THREE PLACE DECIMAL ±.005			G.A.			TITLE: GEAR BOX ASSEMBLY			
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			RHS #		N/A		C	AX-1500	D
			DO NOT SCALE DRAWING		SCALE: 1:2		SHEET 2 OF 2		