

ACME DOUBLE SEAM AUXILIARY ROLL SET

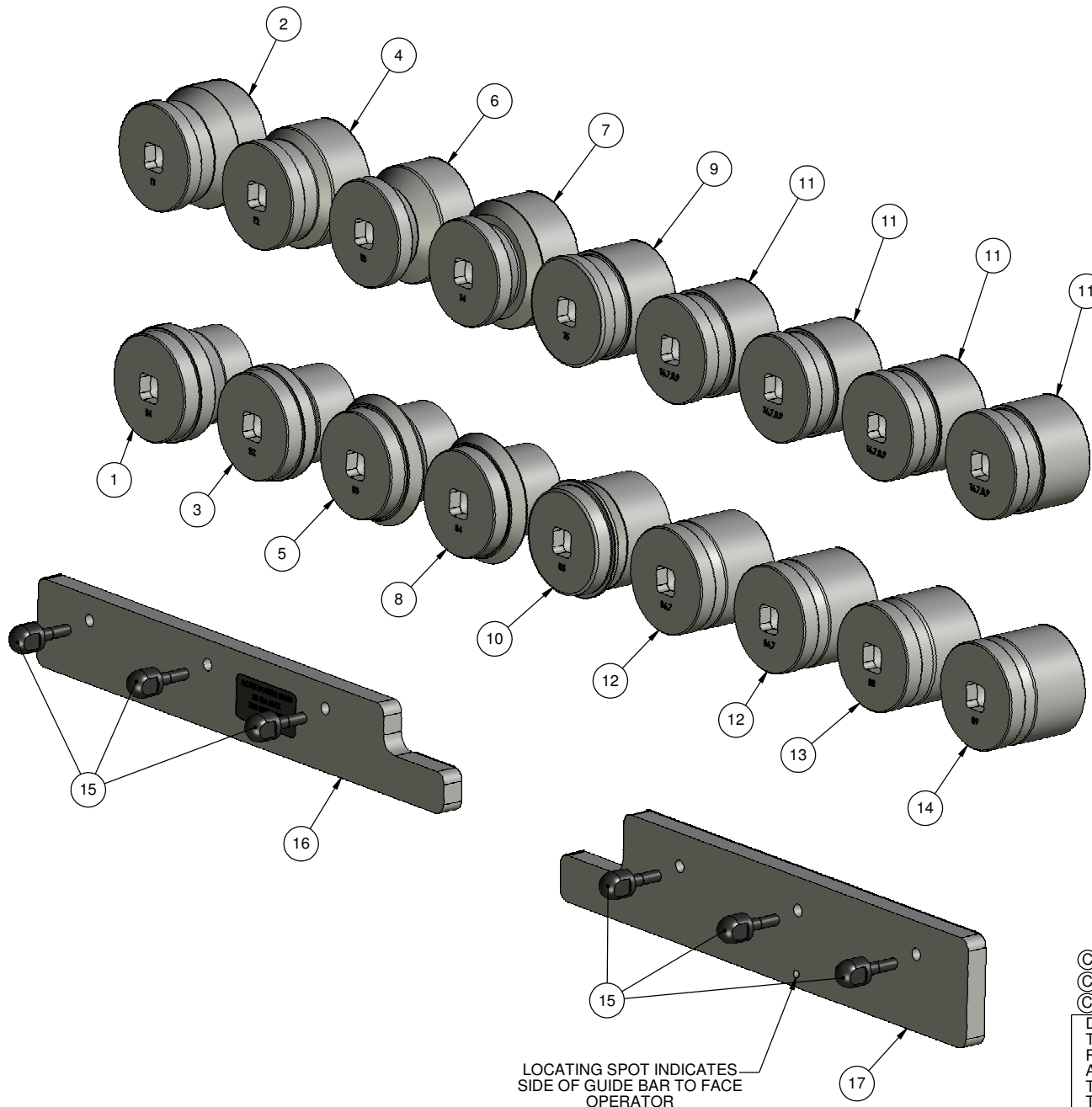
REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	INITIAL RELEASE	9/25/2008	SSL
	B	ADDED LOCATING SPOT TO GUIDE BAR	11/24/2008	SSL
	C	ITEM 15 WAS QTY 4; ITEM 16 WAS AX-1018; ITEM 17 WAS AX-1013	07/21/10	DRP

INSTALLATION INSTRUCTIONS:

- 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.
- REPEAT THE ABOVE PROCEDURE FOR THE REMAINING ROLLERS IN NUMERIC ORDER.
- ALL ROLLERS MARKED "T" SHOULD BE ON THE TOP SHAFTS AND ROLLERS MARKED "B" SHOULD BE ON THE BOTTOM SHAFTS.**
- ALL ROLLER MARKINGS MUST FACE OUTWARD, OR TOWARDS THE OPERATOR.**
- MOUNT ENTRANCE GUIDE BAR (ITEM 16) ON THE STARTING SIDE OF THE MACHINE AT 1.125" FROM THE FRONT EDGE OF THE ROLLERS. LOCATING SPOT ON GUIDE BAR MUST BE FACING OPERATOR.
- THE EXIT GUIDE BAR (ITEM 17) ON THE FINISHING SIDE OF THE MACHINE AT .815" FROM THE FRONT EDGE OF THE ROLLERS. LOCATING SPOT ON GUIDE BAR MUST BE FACING OPERATOR.

RAMS 2014 - AUXILIARY MACHINE

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	AX-1601-B	ROLLER, B1, DOUBLE SEAM, SQ. DRIVE	1
2	AX-1601-T	ROLLER, T1, DOUBLE SEAM, SQ. DR.	1
3	AX-1602-B	ROLLER, B2, DOUBLE SEAM, SQ. DRIVE	1
4	AX-1602-T	ROLLER, T2, DOUBLE SEAM, SQ. DR.	1
5	AX-1603-B	ROLLER, B3, DOUBLE SEAM, SQ. DR.	1
6	AX-1603-T	ROLLER, T3, DOUBLE SEAM, SQ. DR.	1
7	AX-1604-T	ROLLER, T4, DOUBLE SEAM, SQ. DR.	1
8	AX-1604-B	ROLLER, B4, DOUBLE SEAM, SQ. DR.	1
9	AX-1605-T	ROLLER, T5, DBL SEAM SQ. DR.	1
10	AX-1605-B	ROLLER, B5, DOUBLE SEAM, SQ. DR.	1
11	AX-1606_7_8_9-T	ROLLER, T6, 7, 8, & 9, DBL SEAM, SQ. DR.	4
12	AX-1606_7-B	ROLLER, B6,7, DOUBLE SEAM, SQ. DR.	2
13	AX-1608-B	ROLLER, B8, DOUBLE SEAM, SQ. DR.	1
14	AX-1609-B	ROLLER, B9, DOUBLE SEAM, SQ. DR.	1
15	2054	ADJUSTING BOLT:1/4-20 THREAD	6
16	AX-1018-2	GUIDE BAR, DOUBLE SEAM	1
17	AX-1013-1	GUIDE BAR, DOUBLE SEAM, EXIT	1



LOCATING SPOT INDICATES SIDE OF GUIDE BAR TO FACE OPERATOR

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
SSL	9/2/08	
CHECKED		
ENG APPR.		

MATERIAL	TITLE
SEE BOM	ACME DOUBLE SEAM W/SQ. DRIVE
FINISH	SIZE DWG. NO.
N/A	C RAMS AUX-1600 C

DO NOT SCALE DRAWING SCALE: 1:1.75 SHEET 1 OF 1