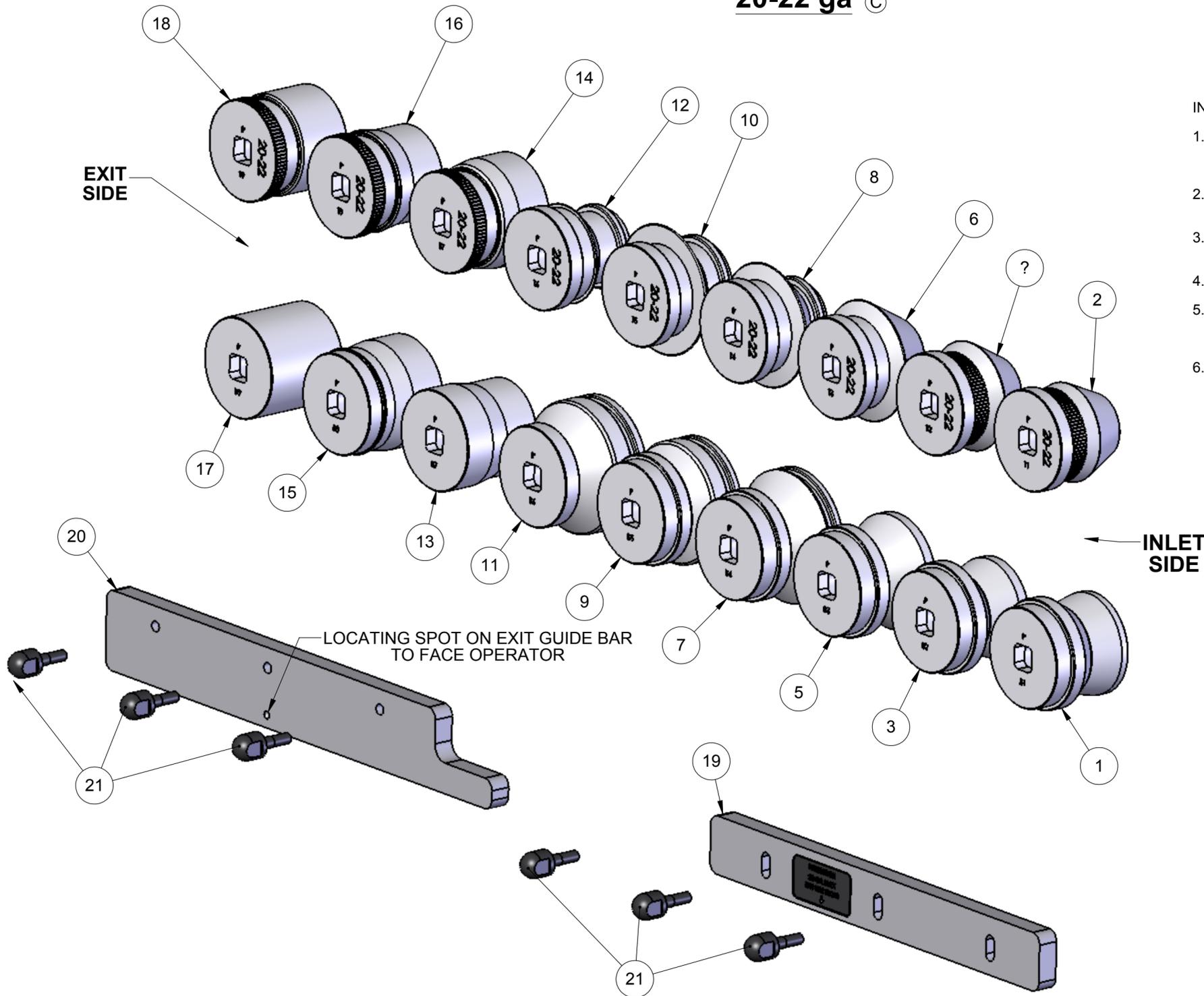


REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	INITIAL RELEASE	12/14/09	SSL
	B	ITEM 19 WAS AX-2518; ITEM 20 WAS AX-2519; ITEM 21 WAS QTY 4	07/21/10	DRP
	C	20-24 ga TO 20-22 ga	7/22/2011	BTB

PITTSBURGH ROLL SET

20-22 ga ©



INSTALLATION INSTRUCTIONS:

1. 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.
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 ENTRANCE GUIDE BAR (ITEM 19) ON THE INFEED SIDE OF THE MACHINE. GUIDE BARS TO BE BOLTED, (ITEM 21) INTO THREADED HOLES IN TABLETOP OF MACHINE.
6. MOUNT EXIT GUIDE BAR (ITEM 20) ON THE FINISHING SIDE OF THE MACHINE. GUIDE BARS TO BE BOLTED, (ITEM 21) INTO THREADED HOLES IN TABLETOP OF MACHINE. LOCATING SPOT MUST FACE OUTWARD TOWARDS OPERATOR.

RAMS 2014 - AUXILIARY MACHINE

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	AX-2501-B	ROLLER, B1, PITTSBURGH, SQ. DRIVE	1
2	AX-2501-T	ROLLER, T1, PITTSBURGH, SQ. DRIVE	1
3	AX-2502-B	ROLLER, B2, PITTSBURGH, SQ. DRIVE	1
4	AX-2502-T	ROLLER, T2, PITTSBURGH, SQ. DRIVE	1
5	AX-2503-B	ROLLER, B3, PITTSBURGH, SQ. DRIVE	1
6	AX-2503-T	ROLLER, T3, PITTSBURGH, SQ. DRIVE	1
7	AX-2504-B	ROLLER, B4, PITTSBURGH, SQ. DRIVE	1
8	AX-2504-T	ROLLER, T4, PITTSBURGH, SQ. DRIVE	1
9	AX-2505-B	ROLLER, B5, PITTSBURGH, SQ. DRIVE	1
10	AX-2505-T	ROLLER, T5, PITTSBURGH, SQ. DRIVE	1
11	AX-2506-B	ROLLER, B6, PITTSBURGH, SQ. DRIVE	1
12	AX-2506-T	ROLLER, T6, PITTSBURGH, SQ. DRIVE	1
13	AX-2507-B	ROLLER, B7, PITTSBURGH, SQ. DRIVE	1
14	AX-2507-T	ROLLER, T7, PITTSBURGH, SQ. DRIVE	1
15	AX-2508-B	ROLLER, B8, PITTSBURGH, SQ. DRIVE	1
16	AX-2508-T	ROLLER, T8, PITTSBURGH, SQ. DRIVE	1
17	AX-2509-B	ROLLER, B9, PITTSBURGH, SQ. DRIVE	1
18	AX-2509-T	ROLLER, T9, PITTSBURGH, SQ. DRIVE	1
19	AX-2518-2	GUIDE BAR, PITTSBURGH, INLET	1
20	AX-2519-1	GUIDE BAR, PITTSBURGH, EXIT	1
21	2054	ADJUSTING BOLT: 1/4-20 THREAD	6

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DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± 1/16 ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ±.01 THREE PLACE DECIMAL ±.005	NAME SSL DATE 12/8/09	HORIZON SYSTEMS MACHINING 9121 58TH PLACE KENOSHA, WI 53144 PH: 262-605-1122 FAX: 262-605-1198
	CHECKED SSL 12/14/09	
	ENG APPR. MFG APPR. Q.A.	
	MATERIAL SEE BOM	
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.	FINISH N/A	TITLE: ROLLERS, PITTSBURGH
DO NOT SCALE DRAWING	SCALE: 1:2	SIZE DWG. NO. REV C RAMS AUX-2500 B
		SHEET 1 OF 1