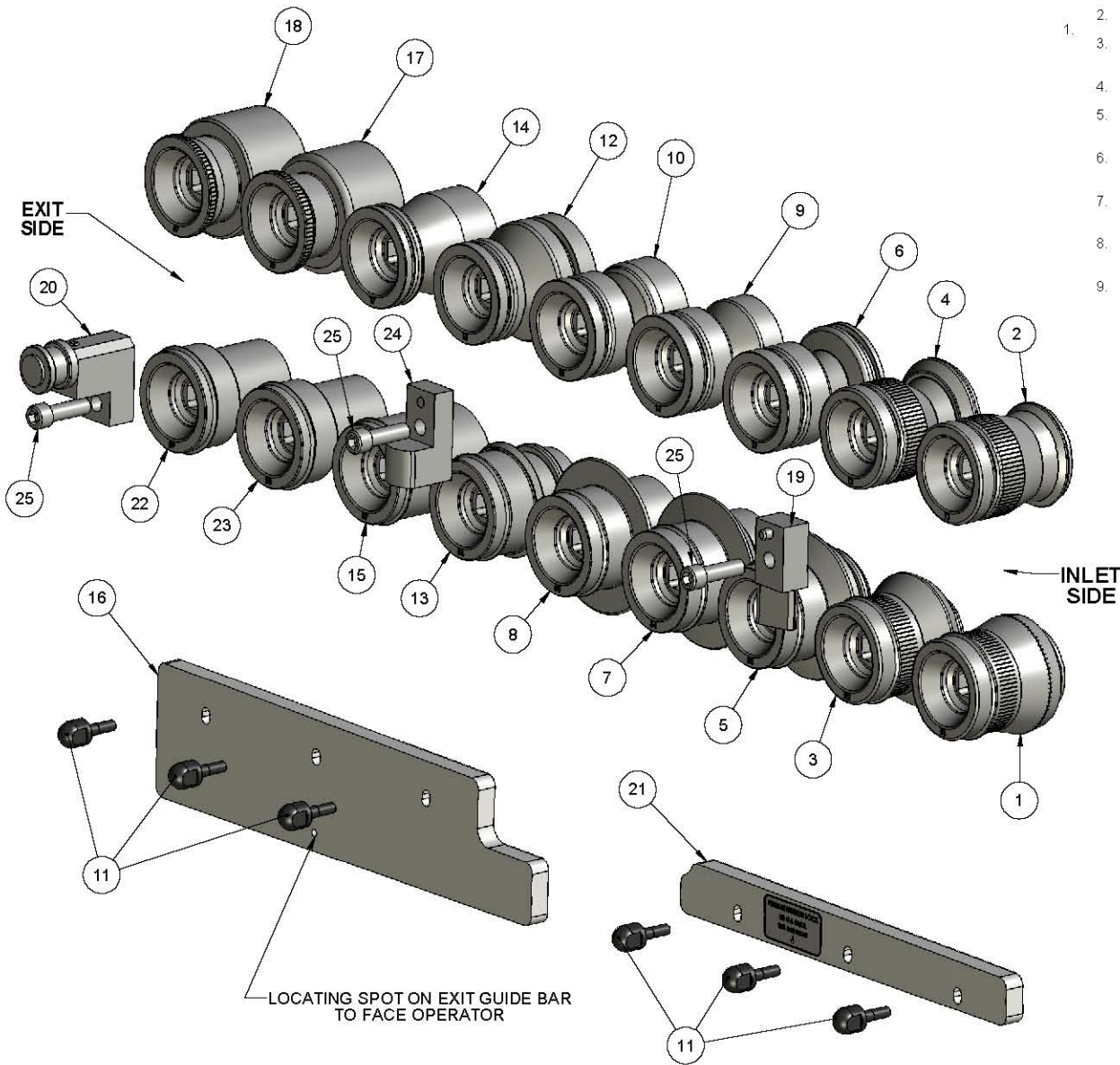


REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	INITIAL RELEASE	02/14/11	DRP

FEMALE BUTTON LOCK ROLL SET 24-28qa



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 21) ON THE INFEED SIDE OF THE MACHINE. GUIDE BARS TO BE BOLTED, (ITEM 1) INTO THREADED HOLES IN TABLETOP OF MACHINE.
6. MOUNT EXIT GUIDE BAR (ITEM 16) ON THE FINISHING SIDE OF THE MACHINE. GUIDE BARS TO BE BOLTED, (ITEM 11) INTO THREADED HOLES IN TABLETOP OF MACHINE.
7. MOUNT FORM BAR, ITEM 19, BETWEEN ROLLERS #2 & #3. DOWEL PIN IN FORM BAR FITS INTO HOLE OF GEARBOX FOR PROPER LOCATION. SECURE WITH BOLT, ITEM 25.
8. MOUNT FORM BAR, ITEM 24, BETWEEN ROLLERS #5 & #6. DOWEL PIN IN FORM BAR FITS INTO HOLE OF GEARBOX FOR PROPER LOCATION. SECURE WITH BOLT, ITEM 25.
9. MOUNT ROLLER ASSEMBLY, ITEM 20, BETWEEN ROLLERS #8 & #9. DOWEL PIN IN ROLLER ASSEMBLY FITS INTO HOLE OF GEARBOX FOR PROPER LOCATION. SECURE WITH BOLT, ITEM 25.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	AX-2201-B	ROLLER, B1, FEMALE BUTTON LOCK, SQ. DR.	1
2	AX-2201-T-1	ROLLER, T1, FEMALE BUTTON LOCK, SQ. DR.	1
3	AX-2202-B	ROLLER, B2, FEMALE BUTTON LOCK, SQ. DR.	1
4	AX-2202-T-1	ROLLER, T2, FEMALE BUTTON LOCK, SQ. DR.	1
5	AX-2203-B	ROLLER, B3, FEMALE BUTTON LOCK, SQ. DR.	1
6	AX-2203-T-1	ROLLER, T3, FEMALE BUTTON LOCK, SQ. DR.	1
7	AX-2204-B	ROLLER, B4, FEMALE BUTTON LOCK, SQ. DR.	1
8	AX-2205-B	ROLLER, B5, FEMALE BUTTON LOCK, SQ. DR.	1
9	AX-2204-T-1	ROLLER, T4, FEMALE BUTTON LOCK, SQ. DR.	1
10	AX-2205-T-1	ROLLER, T5, FEMALE BUTTON LOCK, SQ. DR.	1
11	2054	ADJUSTING BOLT:1/4-20 THREAD	6
12	AX-2206-T-1	ROLLER, T6, FEMALE BUTTON LOCK, SQ. DR.	1
13	AX-2206-B	ROLLER, B6, FEMALE BUTTON LOCK, SQ. DR.	1
14	AX-2207-T-1	ROLLER, T7, FEMALE BUTTON LOCK, SQ. DR.	1
15	AX-2207-B	ROLLER, B7, FEMALE BUTTON LOCK, SQ. DR.	1
16	AX-2213-1	GUIDE BAR, FEMALE BUTTON, EXIT	1
17	AX-2208-T-1	ROLLER, T8, FEMALE BUTTON LOCK, SQ. DR.	1
18	AX-2209-T-1	ROLLER, T9, FEMALE BUTTON LOCK, SQ. DR.	1
19	AX-2214	FORM BAR ASSY, FEMALE BUTTON LOCK	1
20	AX-2216	ROLLER ASSY, FEMALE BUTTON LOCK	1
21	AX-2217-2	GUIDE BAR, FEMALE BUTTON, ENTRANCE	1
22	AX-2209-B	ROLLER, B9, FEMALE BUTTON LOCK, SQ. DR.	1
23	AX-2208-B	ROLLER, B8, FEMALE BUTTON LOCK, SQ. DR.	1
24	AX-2218	FORM BAR ASSY, FEMALE BUTTON LOCK	1
25	HW-1053	SHCS, 3/8-16 X 1 1/4"	3

<p>DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± 1/16 ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ±.01 THREE PLACE DECIMAL ±.005</p>		<table border="1"> <tr><td>DATE</td><td>10/13/08</td></tr> <tr><td>SSS</td><td>4/8/09</td></tr> <tr><td>SSL</td><td></td></tr> <tr><td>SSS</td><td></td></tr> <tr><td>SSS</td><td></td></tr> <tr><td>SSS</td><td></td></tr> <tr><td>SSS</td><td></td></tr> <tr><td>SSS</td><td></td></tr> </table>	DATE	10/13/08	SSS	4/8/09	SSL		SSS		SSS		SSS		SSS		SSS		<p>HORIZON SYSTEMS MACHINING 9121 58TH PLACE KENOSHA, WI 53144 PH: 262-605-1122 FAX: 262-605-1198</p>
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<p>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.</p>		<table border="1"> <tr><td>MATERIAL</td><td>SEE BOM</td></tr> <tr><td>SIZE</td><td>C</td></tr> <tr><td>DWG. NO.</td><td>RAMS AUX-2250</td></tr> <tr><td>REV</td><td>A</td></tr> </table>	MATERIAL	SEE BOM	SIZE	C	DWG. NO.	RAMS AUX-2250	REV	A	<p>SCALE: 1:2 SHEET 1 OF 2</p>								
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