

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

MALE BUTTON LOCK ROLL SET

24-28 ga



INSTALLATION INSTRUCTIONS:

- INSTALL ROLLERS, MARKED "T1" & "B1", ONTO THE SHAFTS AT THE INFEEED 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 IDLER ASSEMBLY, ITEM 13, ONTO TWO SHAFTS LOCATED AT POSITIONS T5 & T6 AS SHOWN ON SHEET 2. SECURE WITH BOLT PROVIDED.
- MOUNT ENTRANCE GUIDE BAR (ITEM 11) ON THE INFEEED SIDE OF THE MACHINE. GUIDE BARS TO BE BOLTED INTO THREADED HOLES IN TABLETOP OF MACHINE, (0.938" FROM THE FRONT EDGE OF THE ROLLERS).
- MOUNT THE EXIT GUIDE BAR (ITEM 12) ON THE EXIT SIDE OF THE MACHINE. GUIDE BARS TO BE BOLTED INTO THREADED HOLES IN TABLETOP OF MACHINE, (0.510" FROM THE FRONT EDGE OF THE ROLLERS).

RAMS 2014 - AUXILIARY MACHINE

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	AX-2101-B	ROLLER, B1, Male Button Lock, SQ. DRIVE	1
2	AX-2101-T-1	ROLLER, T1, MALE BUTTON LOCK, SQ. DR.	1
3	AX-2102-B	ROLLER, B2, Male Button Lock, SQ. DRIVE	1
4	AX-2102,3,4-T-1	ROLLER, T2,3,4, MALE BUTTON LOCK, SQ. DR.	3
5	AX-2103-B	ROLLER, B3, Male Button Lock, SQ. DRIVE	1
6	AX-2104-B	ROLLER, B4, Male Button Lock, SQ. DRIVE	1
7	AX-2105,6-B	ROLLER, B5 & B6, Male Button Lock, SQ. DRIVE	2
8	2054	ADJUSTING BOLT:1/4-20 THREAD	6
9	AX-2107,8,9-T-1	ROLLER, T7,8,9, MALE BUTTON LOCK, SQ. DR.	3
10	AX-2107,8,9-B	ROLLER, B7,8,9, Male Button Lock, SQ. DRIVE	3
11	AX-2118-2	GUIDE BAR, MALE BUTTON, INLET	1
12	AX-2113-1	GUIDE BAR, MALE BUTTON, EXIT	1
13	AX-2105-T	IDLER ASSY, T5, MALE BUTTON LOCK	1

DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± 1/16 ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ±.01 THREE PLACE DECIMAL ±.005		<table border="1"> <tr> <td>DATE</td> <td>10/13/08</td> </tr> <tr> <td>NAME</td> <td>SSL</td> </tr> <tr> <td>SS</td> <td></td> </tr> <tr> <td>CHKD</td> <td></td> </tr> <tr> <td>ENG APP.</td> <td></td> </tr> <tr> <td>REF APP.</td> <td></td> </tr> <tr> <td>G.A.</td> <td></td> </tr> </table>	DATE	10/13/08	NAME	SSL	SS		CHKD		ENG APP.		REF APP.		G.A.		HORIZON SYSTEMS MACHINING 9121 58TH PLACE KENOSHA, WI 53144 PH: 262-605-1122 FAX: 262-605-1198
DATE	10/13/08																
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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.		MATERIAL: SEE BOM SIZE: N/A DO NOT SCALE DRAWING	TITLE: ROLLERS, MALE BUTTON LOCK DWG. NO.: C RAMS AUX-2150 REV: A SCALE: 1:1.75 SHEET 1 OF 2														