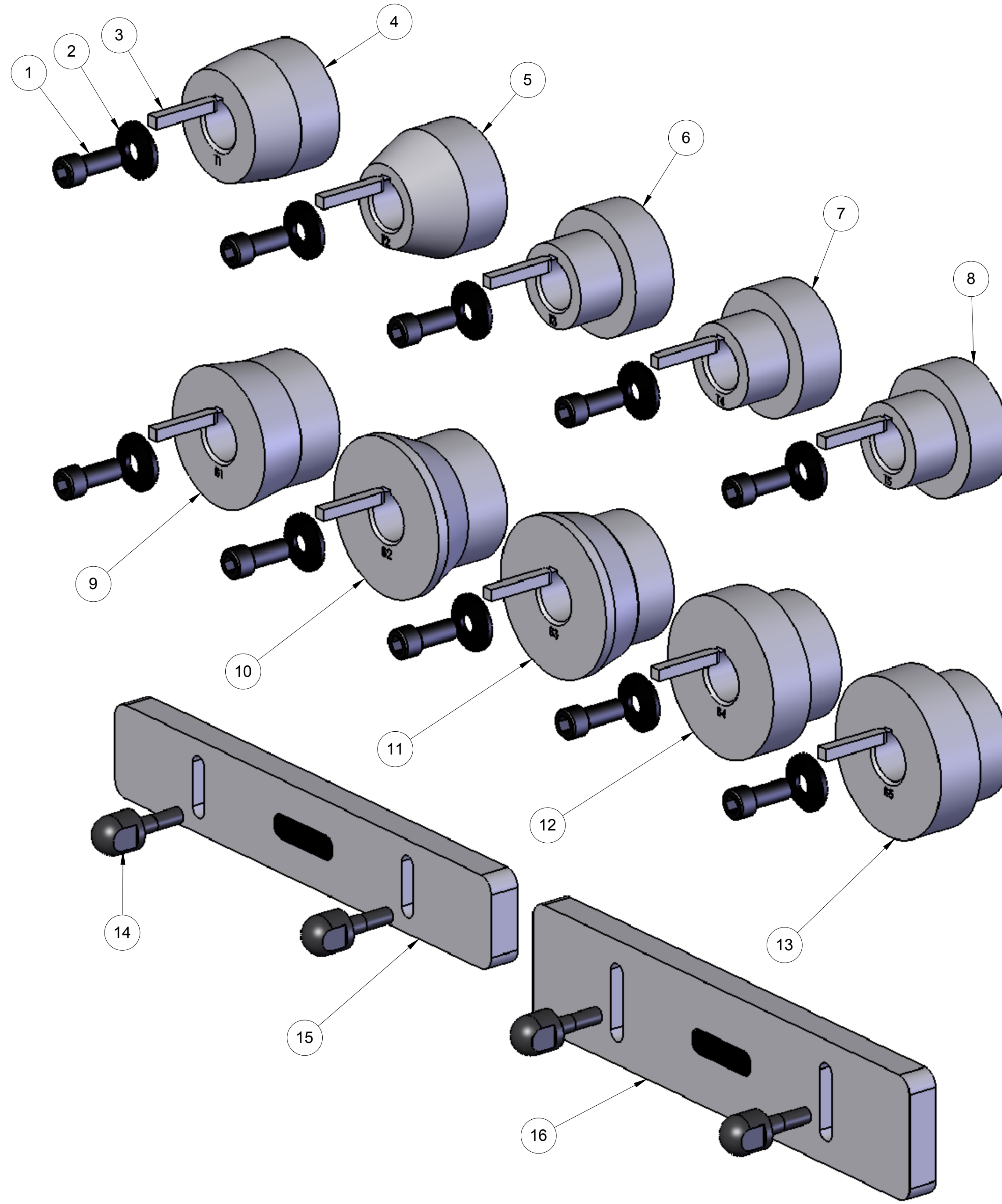


REVISIONS		
REV.	DESCRIPTION	DATE
A	INITIAL RELEASE	1/18/2007



**INSTALLATION INSTRUCTIONS:**

- INSTALL ROLLERS, MARKED "T1" & "B1", ONTO THE SHAFTS AT THE LEFT SIDE, OR FEED 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 15) ON THE STARTING SIDE OF THE MACHINE AT 1-1/16" OFF OF THE EDGE OF THE ROLLERS.
- THE EXIT GUIDE BAR (ITEM 16) ON THE FINISHING SIDE SHOULD BE FLUSH AGAINST THE METAL AS IT EMERGES FROM THE ROLLERS.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	HW-1000	SHCS, 5/16-18 X 3/4, BLACK	10
2	HW-1012	WASHER, TAPERED, 5/16 X 7/8 O.D., BLACK	10
3	HW-1040	KEY, 3/16 X 3/16 X 1 3/16	10
4	RA-T1	ROLLER, T1, RIGHT ANGLE	1
5	RA-T2	ROLLER, T2, RIGHT ANGLE	1
6	RA-T3	ROLLER, T3, RIGHT ANGLE	1
7	RA-T4	ROLLER, T4, RIGHT ANGLE	1
8	RA-T5	ROLLER, T5, RIGHT ANGLE	1
9	RA-B1	ROLLER, B1, RIGHT ANGLE	1
10	RA-B2	ROLLER, B2, RIGHT ANGLE	1
11	RA-B3	ROLLER, B3, RIGHT ANGLE	1
12	RA-B4	ROLLER, B4, RIGHT ANGLE	1
13	RA-B5	ROLLER, B5, RIGHT ANGLE	1
14	2054	ADJUSTING BOLT:1/4-20 THREAD	4
15	2053	GUIDE BAR	1
16	2053-1	AUXILIARY GUIDE BAR	1

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

	NAME	DATE
DRAWN	RAF	01/18/07
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		

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

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	TITLE:	RAMS-AUX-R
FINISH	N/A	SIZE	DWG. NO. <b>C</b>
		REV	<b>A</b>

DO NOT SCALE DRAWING SCALE: 1:1.25 SHEET 1 OF 1