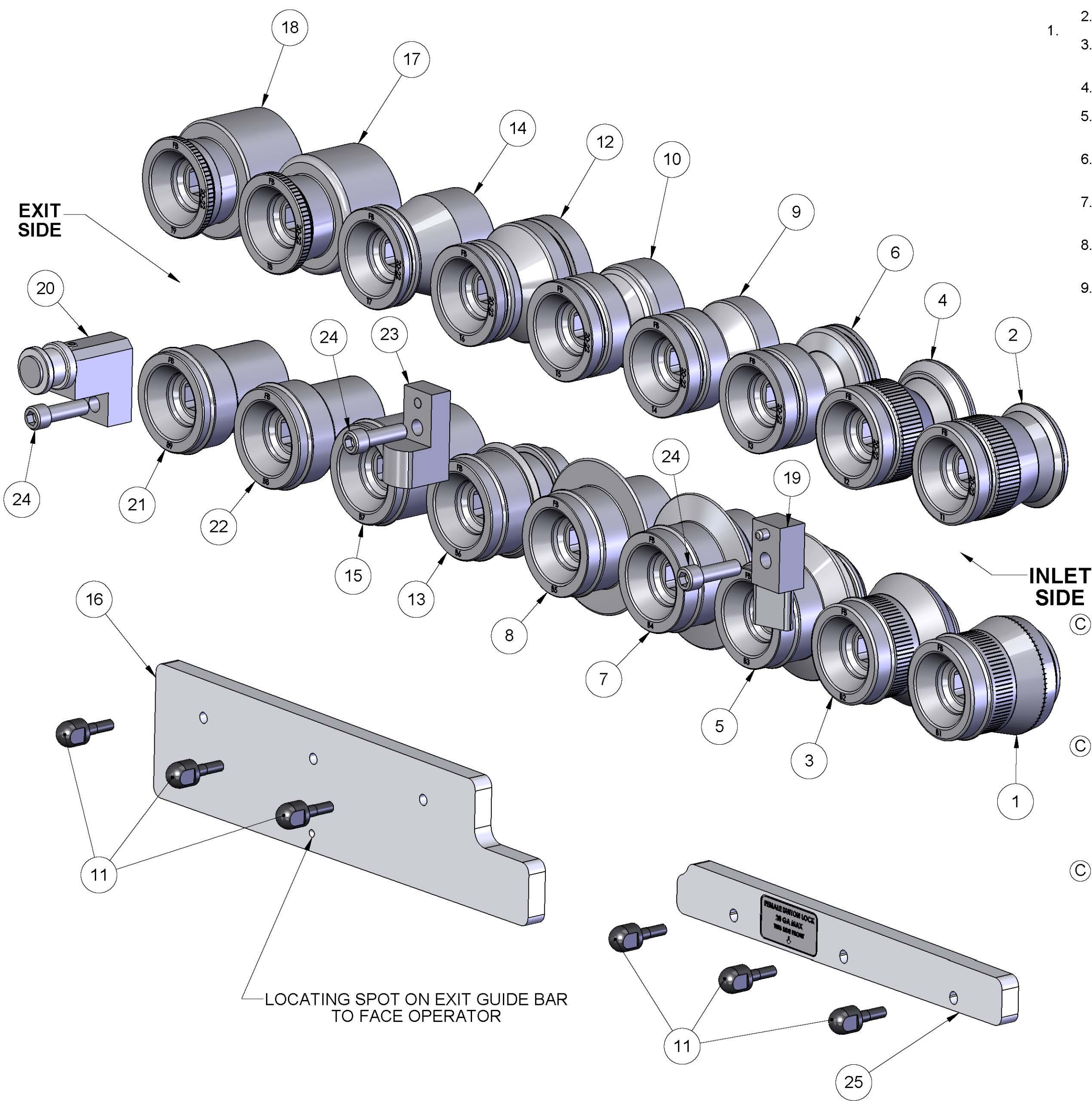


FEMALE BUTTON LOCK ROLL SET
20-22 ga

(D)



REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	INITIAL RELEASE	10/15/08	SSL
	B	REVISED NOTES	4/8/2009	SSL
	C	ITEM 11 WAS QTY 4; ITEM 16 WAS AX-2213; ITEM 21 WAS AX-2217	07/21/10	DRP
	D	20-24 GA TO 20-22 GA	7/21/2011	BTB
	E	Replaced part AX-2217-2-20 with AX-2217-2-20-24	4/20/2012	KL

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 #T2 & #T3. 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 #T5 & #T6. 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 #T8 & #T9. 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	ROLLER, T1, FEMALE BUTTON LOCK, SQ. DR.	1
3	AX-2202-B	ROLLER, B2, FEMALE BUTTON LOCK, SQ. DR.	1
4	AX-2202-T	ROLLER, T2, FEMALE BUTTON LOCK, SQ. DR.	1
5	AX-2203-B	ROLLER, B3, FEMALE BUTTON LOCK, SQ. DR.	1
6	AX-2203-T	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	ROLLER, T4, FEMALE BUTTON LOCK, SQ. DR.	1
10	AX-2205-T	ROLLER, T5, FEMALE BUTTON LOCK, SQ. DR.	1
11	2054	ADJUSTING BOLT: 1/4-20 THREAD	6
12	AX-2206-T	ROLLER, T6, FEMALE BUTTON LOCK, SQ. DR.	1
13	AX-2206-B	ROLLER, B6, FEMALE BUTTON LOCK, SQ. DR.	1
14	AX-2207-T	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	ROLLER, T8, FEMALE BUTTON LOCK, SQ. DR.	1
18	AX-2209-T	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-2209-B	ROLLER, B9, FEMALE BUTTON LOCK, SQ. DR.	1
22	AX-2208-B	ROLLER, B8, FEMALE BUTTON LOCK, SQ. DR.	1
23	AX-2218	FORM BAR ASSY, FEMALE BUTTON LOCK	1
24	HW-1053	SHCS, 3/8-16 X 1 1/4"	3
25	AX-2217-2-20-24	GUIDE BAR, FEMALE BUTTON, ENTRANCE	1

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

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.

	NAME	DATE
DRAWN	SSL	10/13/08
CHECKED	SSL	4/8/09
ENG APPR.		
MFG APPR.		
Q.A.		

SEE BOM	
FINISH	N/A
DO NOT SCALE DRAWING	

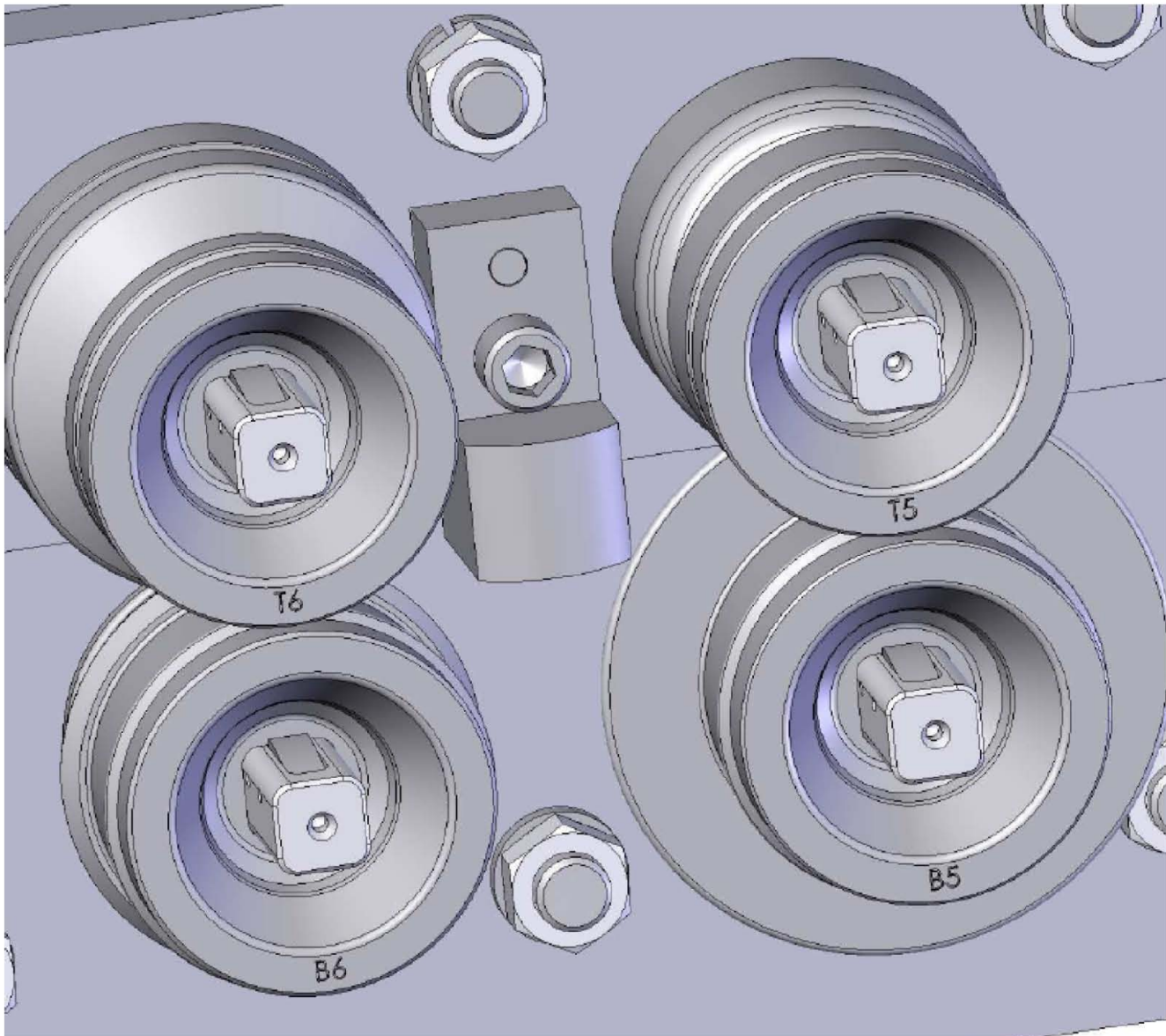
HORIZON SYSTEMS MACHINING

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

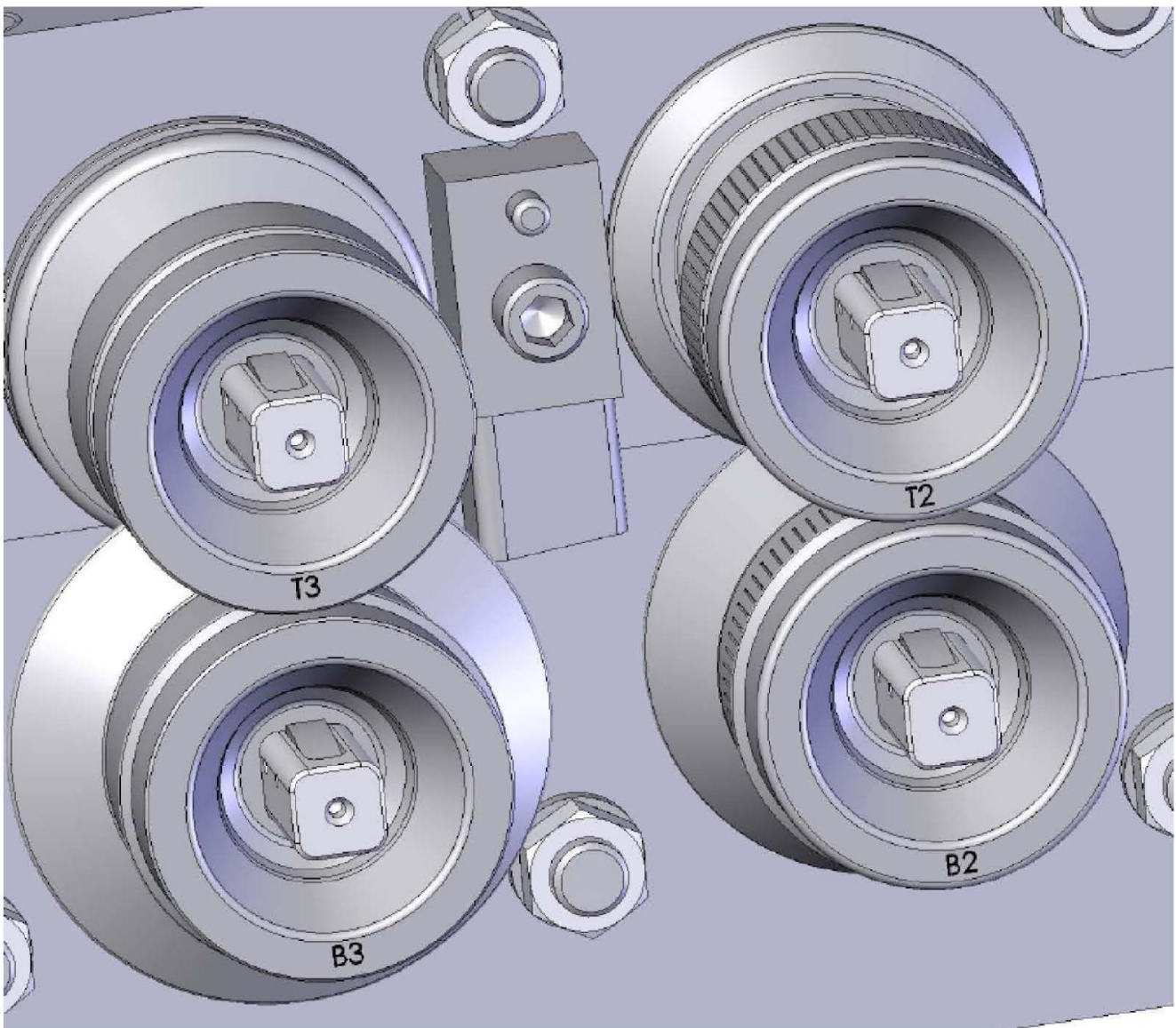
TITLE: ROLLERS, FEMALE BUTTON LOCK		
SIZE	DWG. NO.	REV
C	RAMS AUX-2200	E
SCALE: 1:2		SHEET 1 OF 2

RAMS 2014 - AUXILIARY MACHINE

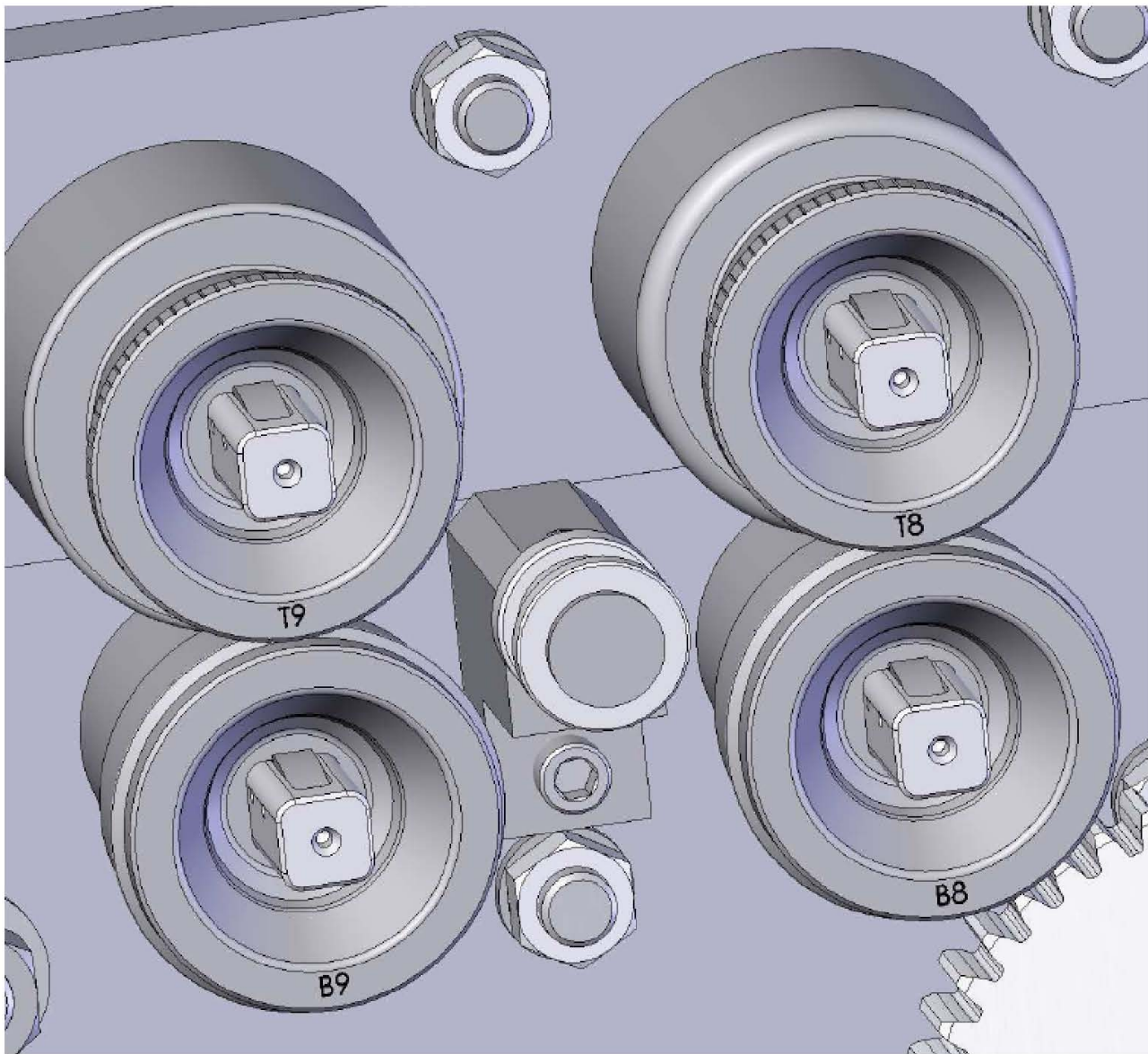
FEMALE BUTTON LOCK ROLL SET



LOCATION OF FORM BAR ASSEMBLY, ITEM 24
LOCATED BETWEEN T5 & T6



LOCATION OF FORM BAR ASSEMBLY, ITEM 19
LOCATED BETWEEN T2 & T3



LOCATION OF FORM BAR ASSEMBLY, ITEM 20
LOCATED BETWEEN T8 & T9

RAMS 2014 - AUXILIARY MACHINE

DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± 1/16 ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ±.01 THREE PLACE DECIMAL ±.005		NAME	DATE	HORIZON SYSTEMS MACHING 9121 58TH PLACE KENOSHA, WI 53144 PH: 262-605-1122 FAX: 262-605-1198		
	DRAWN	SSL	9/2/08			
	CHECKED	SSL	4/8/09			
	ENG APPR.					
	MFG APPR.					
	Q.A.					
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	FINISH			SIZE	DWG. NO.	REV
				C	RAMS AUX-2200	E
	DO NOT SCALE DRAWING			SCALE: 1:1		
				SHEET 2 OF 2		