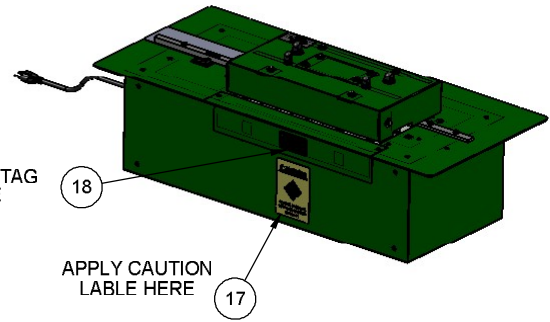
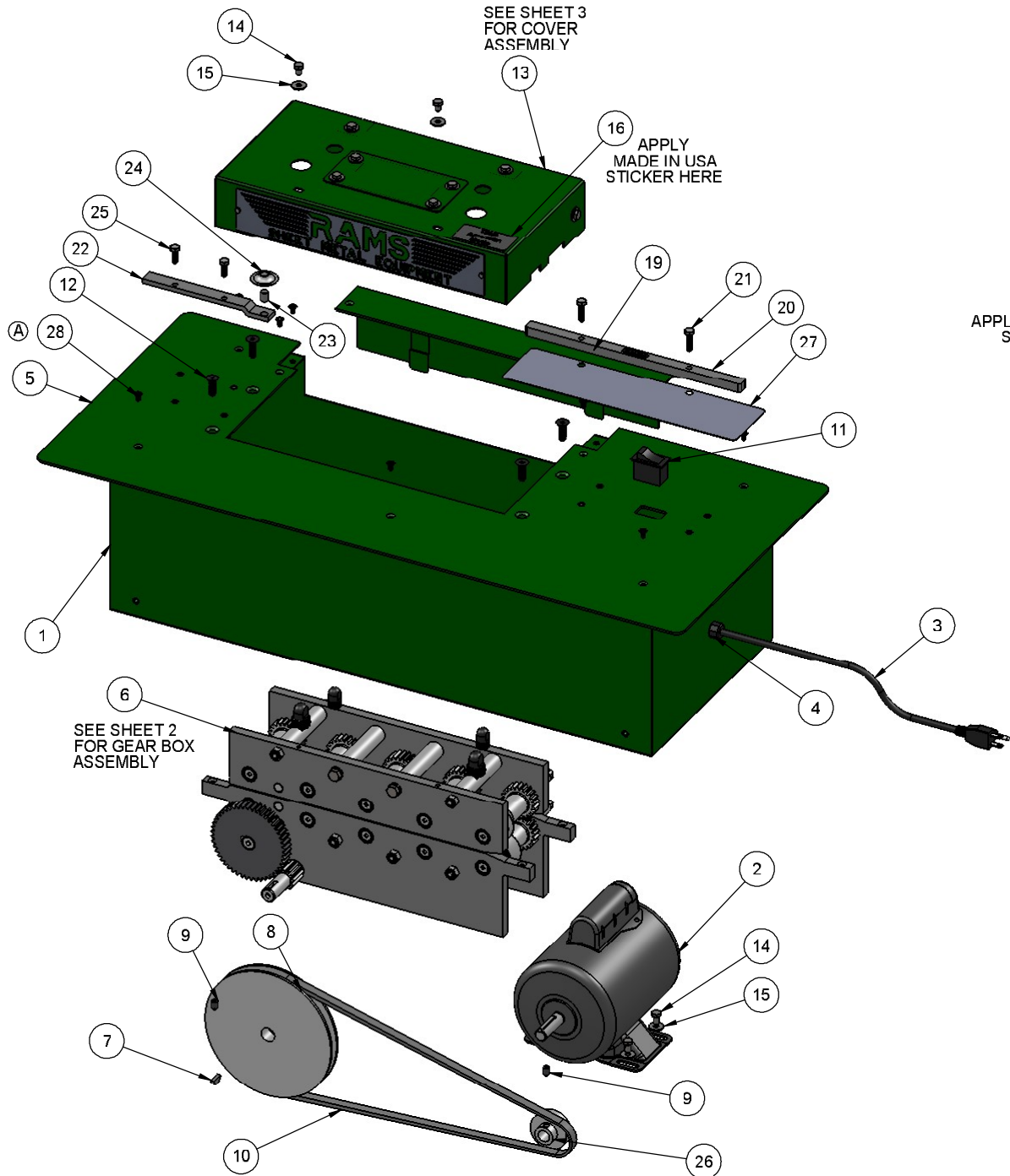


REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	CHANGED 1/4-20 X 3/8 FHCS TO #10-32 X 3/8 FHCS AND QUANTITY.	7/13/2011	BTB
F	ADDED SHEET 4, ELECTRICAL KIT	7/27/2011	RTA



RAMS-24-28-SQ PITTSBURGH MACHINE

ITFM NO	PART NUMBFR	DESCRIPTION	QTY.
1	2420-SQ	BOX FRAME WELDMNT	1
2	N/A	1/2 HP, 110 V MOTOR	1
3	CORD1	POWER CORD	1
4	69915K51	CORD GRIP	1
5	2420-3-SQ	BOX COVER	1
6	RAMS 24-28-SQ-1	GEAR BOX, RAMS 24-28-SQ PITTSBURGH	1
7	2041	WOODRUFF KEY 606	1
8	CA700x.750	7" PULLEY	1
9	N/A	SET SCREW, 5/16-18 X 1/2", BLACK	2
10	AX43	BELT	1
11	3XS59	TIPPETTE SWITCH	1
12	2445	5/16-18 x 1" LONG FHCS	4
13	2421-4-SQ	COVER	1
14	HW-.25-20X.5	1/4-20 x 1/2, HHCS	6
15	HW-FW.250	1/4" FLAT WASHER	6
16	Made in the USA	LABEL, MADE IN USA	1
17	Caution Label	LABEL, CAUTION	1
18	RAMS 24-28-SQ	SERIAL No. TAG, RAMS 2428	1
19	2420-15-SQ	TABLE COVER	1
20	36008 ASSY	GUIDE	1
21	2446	1/4-20 X 1", HHCS, ZINC	2
22	31909-SQ	OPENING ROLLER HOLDER	1
23	2448	3/8" DIA X 1/2" LONG DOWEL PIN	1
24	2424	OPENING ROLL	1
25	2452	1/4-20 X 3/4", HHCS, ZINC	2
26	CA200	2-INCH PULLEY .625 BORE	1
27	2465	WEAR PLATE	1
28	SCHCSREW 0.19-32x0.375x0.375-HX-	10-32 X 3/8, FHCS, BLACK	9

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

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

SEE BOM

FINISH N/A

DO NOT SCALE DRAWING

TITLE: RAMS 24-28-SQ PITTSBURGH MACHINE

SIZE DWG. NO. C

REV B

SCALE: 1:4

SHEET 1 OF 2

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

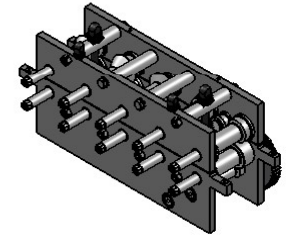
NAME DATE
 BTB 6/21/11

CHECKED
ENG APPR
MFG APPR
D.A.

MATERIAL
FINISH

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.

NOTE: SEE SHEET 4 FOR ELECTRICAL KIT INFORMATION



RAMS 24-28-SQ PITTSBURGH MACHINE

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	2402-1	LOWER FRONT PLATE	1
2	2402-2	LOWER FRONT PLATE	1
3	2438-BOTTOM-2	SPACER	2
4	2438-BOTTOM-1	SPACER	2
5	2438-TOP-2-SQ	SPACER	2
6	2438-TOP-1-SQ	SPACER	2
7	B-108	BEARING	24
8	.25 dowel	1/4 x 1 DOWEL	2
9	B128	BEARING	4
10	2414-SC	T1 FORMING ROLLER	1
11	2413-SC	T2 FORMING ROLLER	1
12	2412-SC	T3 FORMING ROLLER	1
13	2410-SC	T4 FORMING ROLLER	1
14	2411-SC	T5 FORMING ROLLER	1
15	2409-SC	B1 FORMING ROLLER	1
16	2408-SC	B2 FORMING ROLLER	1
17	2407-SC	B3 FORMING ROLLER	1
18	2406-SC	B4 FORMING ROLLER	1
19	2405-SC	B5 FORMING ROLLER	1
20	2439	3/8-24 NYLOC HEX NUT	12
21	243C	IDLER GEAR	4
22	2415-SC	DRIVE SHAFT 1ST	1
23	2416-SC	DRIVE SHAFT 2ND	1
24	2417	4" DRIVE GEAR	1
25	14624	COLLAR	1
26	2403-2-SQ	UPPER FRONT PLATE	1
27	2403-1-SQ	UPPER FRONT PLATE	1
28	B812	BEARING	2
29	2433	LOWER IDLER ROLL	1
30	2432	UPPER IDLER ROLL	1
31	2435	IDLER ROLL PIN	2
32	2054-SC	ADJUSTING BOLT: 5/16-18 THREAD	2
33	2053-SC	ADJUSTING BOLT: 3/8-16 THREAD	2
34	N/A	.375 BELVILLE WASHER	12
35	AX-1505	FLAT WASHER OD Ø 1" ID Ø .751 x .06	2
36	91375A533	SET SCREW 1/4-20 x 1/4	2
37	.260X.5	WASHER SPACER .06	2
38	HW-LW.375	3/8 LOCK WASHER	4
39	N/A	.3125 BELVILLE WASHER	12
40	HW-HB.375-16x1.25	3/8-16 x 1-1/4, HHCS	4
41	2451	3/8-16 X 3/8", CUP POINT SET SCREW	1
42	2450	SET SCREW, 5/16 X 1/2", LOCKING	1

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

	NAME	DATE
DRAWN:	BTE	6/21/11
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
FINISH	N/A
DO NOT SCALE DRAWING	

TITLE	GEAR BOX, RAMS 24-28-SQ PITTSBURGH
SIZE	DWG. NO. C
REV	B
SCALE	1:4
SHEET 2 OF 4	

