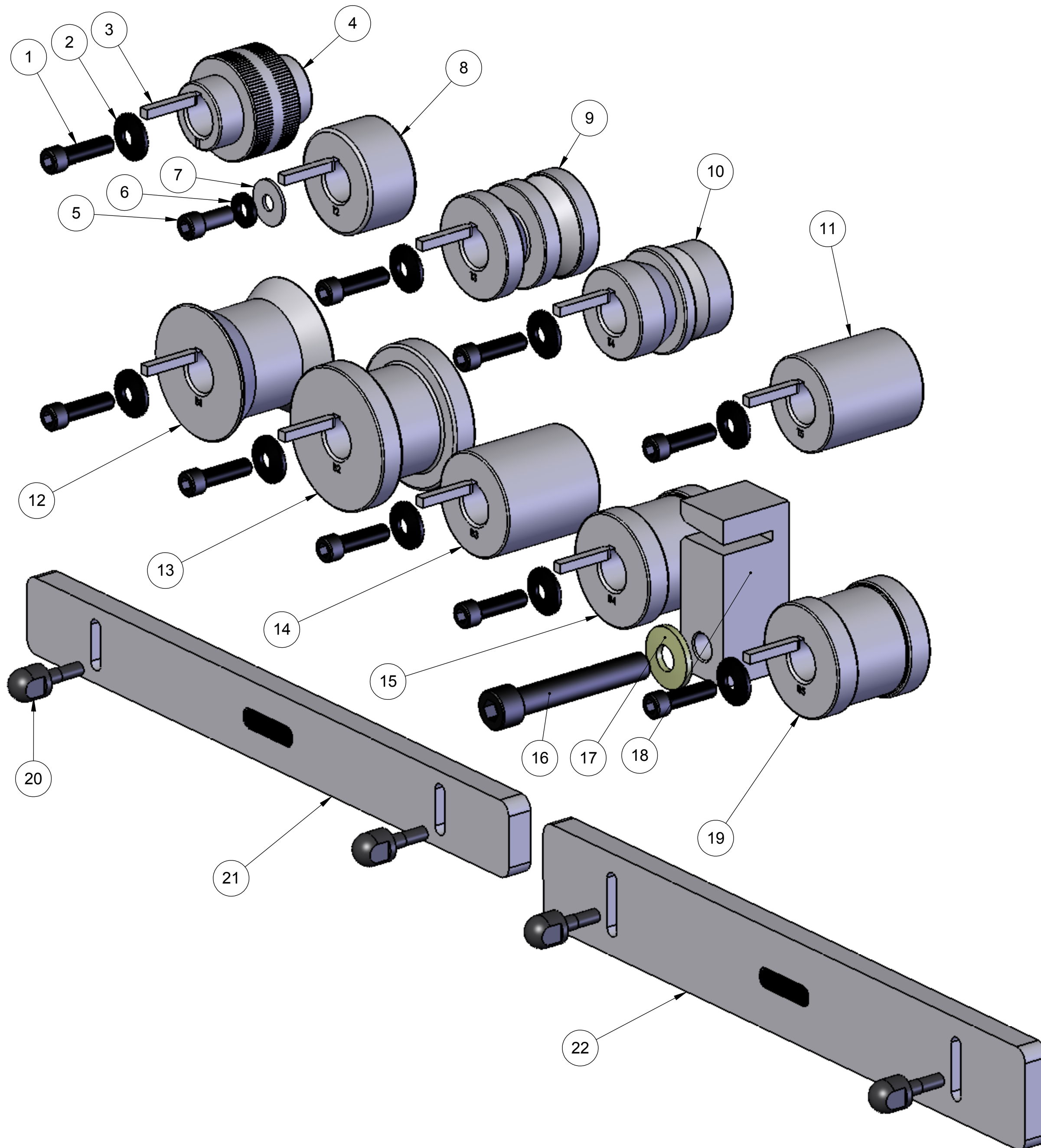


REVISIONS		
REV.	DESCRIPTION	DATE
A	INITIAL RELEASE	03/07/07



**INSTALLATION INSTRUCTIONS:**

1. 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.
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. INSTALL SLIDE BLOCK (ITEM 18) WITH THE INNER EDGE IN LINE WITH OUTER EDGE OF ROLLERS.
6. THE GUIDE BAR ON THE FINISHING SIDE SHOULD BE FLUSH AGAINST THE METAL AS IT EMERGES FROM THE ROLLERS.

**RAMS-2012 20 GA HYPERSPEED PITTSBURGH MACHINE**

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	HW-1001	SHCS, 5/16-18 X 1 1/4, BLACK	9
2	HW-1012	WASHER, TAPERED, 5/16 X 7/8 O.D., BLACK	9
3	HW-1040	KEY, 3/16 X 3/16 X 1 3/16	10
4	DC-T1	ROLLER, T1 DRIVE CLEAT	1
5	HW-1000	SHCS, 5/16-18 X 3/4, BLACK	1
6	HW-1011	WASHER, FLAT, 5/16 X 5/8 O.D., BLACK	1
7	HW-1010	WASHER, FLAT, 5/16	1
8	DC-T2	ROLLER, T2, DRIVE CLEAT	1
9	DC-T3	ROLLER, T3, DRIVE CLEAT	1
10	DC-T4	ROLLER, T4, DRIVE CLEAT	1
11	DC-T5	ROLLER, T5, DRIVE CLEAT	1
12	DC-B1	ROLLER, B1, DRIVE CLEAT	1
13	DC-B2	ROLLER, B2, DRIVE CLEAT	1
14	DC-B3	ROLLER, B3, DRIVE CLEAT	1
15	DC-B4	ROLLER, B4, DRIVE CLEAT	1
16	HW-1020	SHCS, 1/2-13, BLACK	1
17	HW-1030	WASHER, TAPERED, 1/2 X 1 1/8 O.D., PLAIN	1
18	DC-SB	SLIDE BLOCK, DRIVE CLEAT	1
19	DC-B5	ROLLER, B5, DRIVE CLEAT	1
20	2054	ADJUSTING BOLT: 1/4-20 THREAD	4
21	HY-1055	GUIDE BAR, 14"	1
22	2053-2	AUXILIARY GUIDE BAR, 14"	1

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

NAME	DATE	<b>HORIZON SYSTEMS MACHINING</b>  9121 58TH PLACE KENOSHA, WI 53144 PH: 262-605-1122 FAX: 262-605-1198
DRAWN	RAF 01/18/07	
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		

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:	HYPERSPEED-AUX-D	
FINISH	N/A	SIZE	DWG. NO.	REV
		<b>C</b>	HYPERSPEED-AUX-D	<b>A</b>
DO NOT SCALE DRAWING	SCALE: 1:1.5	SHEET 1 OF 1		