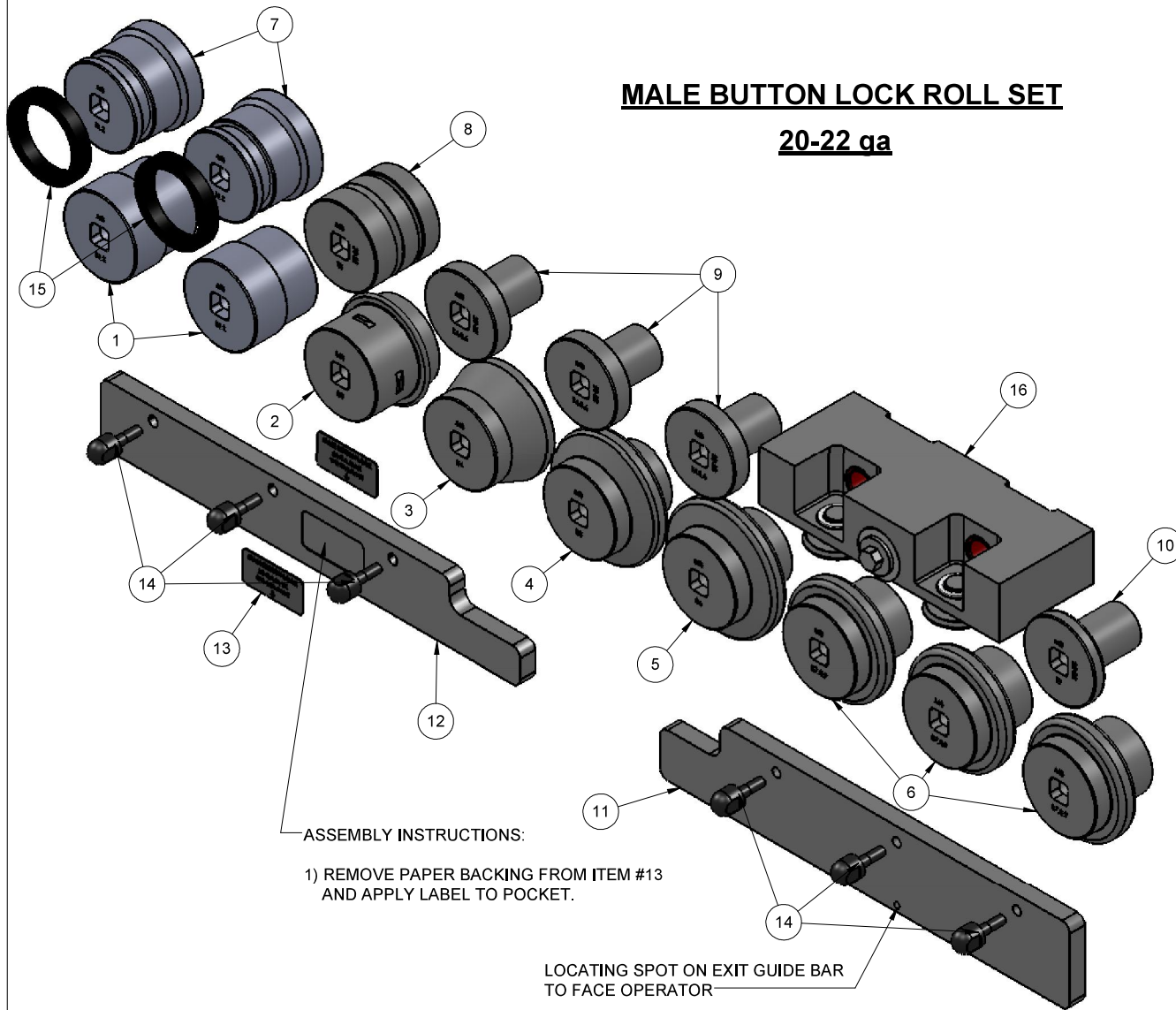


MALE BUTTON LOCK ROLL SET

20-22 qa



ASSEMBLY INSTRUCTIONS:

- 1) REMOVE PAPER BACKING FROM ITEM #13 AND APPLY LABEL TO POCKET.

LOCATING SPOT ON EXIT GUIDE BAR TO FACE OPERATOR

INSTALLATION INSTRUCTIONS:

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.

1. REPEAT THE ABOVE PROCEDURE FOR THE REMAINING ROLLERS IN NUMERIC ORDER.
2. ALL ROLLERS MARKED "T" SHOULD BE ON THE TOP SHAFTS AND ROLLERS MARKED "B" SHOULD BE ON THE BOTTOM SHAFTS.
3. ALL ROLLER MARKINGS **MUST** FACE OUTWARD, OR TOWARDS THE OPERATOR.
4. MOUNT IDLER ASSEMBLY, ITEM 13, ONTO TWO SHAFTS LOCATED AT POSITIONS T5 & T6 AS SHOWN ON SHEET 2. SECURE WITH BOLT PROVIDED.
5. MOUNT ENTRANCE GUIDE BAR (ITEM 11) ON THE INFEED 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).
6. 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).

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	AX-221,2-B	T9 HEM ROLL	2
2	AX-223-B	ROLLER, B1, Male Button Lock, SQ. DRIVE	1
3	AX-224-B	ROLLER, B2, Male Button Lock, SQ. DRIVE	1
4	AX-225-B	ROLLER, B3, Male Button Lock, SQ. DRIVE	1
5	AX-226-B	ROLLER, B4, Male Button Lock, SQ. DRIVE	1
6	AX-2107,8,9-B	ROLLER, B7,8,9, Male Button Lock, SQ. DRIVE	3
7	AX-221,2-T	B9 HEM ROLL	2
8	AX-223-T	ROLLER, T1, MALE BUTTON LOCK, SQ. DR.	1
9	AX-224,5,6-T	ROLLER, T2,3,4, MALE BUTTON LOCK, SQ. DR.	3
10	AX-229-T	ROLLER, T7,8,9, MALE BUTTON LOCK, SQ. DR.	1
11	AX-2113-1	GUIDE BAR, MALE BUTTON, EXIT	1
12	AX-2118-2	GUIDE BAR, MALE BUTTON, INLET	1
13	AX-2118-1	LABEL, GUIDE BAR, MALE BUTTON	2
14	2054	ADJUSTING BOLT:1/4-20 THREAD	6
15	AX-2699	ROLLER SLEEVE	2
16	AX-2105-T-20-22	IDLER ASSY, T5, MALE BUTTON LOCK	1
	AX-2105-T-01	FRAME, IDLER, LEFT	1
	AX-2105-T-06	ROLLER, IDLER, MALE BUTTON, EXIT	2
	B-107	BEARING, NEEDLE, CUP, .625 SHAFT	2
	B-1212	NEEDLE ROLLER BEARING	4
	AX-2105-T-05	CUSTOM BOLT, 3/8-16 UNC	1
	9712K462	Belleville Spring	2
	92505A538	1/4-20 x .63 DOG POINT SET SCREW	1
	90482A222		2
	92678A352		2
	92678A399		2
	97431A350	EXTERNAL RETAINING RING E-STYLE	2
	98029A035		1

RAMS 2014 - AUXILIARY MACHINE & RAMS 2018 BUTTON MACHINE

DIMENSIONS ARE IN INCHES FRACTIONAL: 1/16 ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ±.01 THREE PLACE DECIMAL ±.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.		HORIZON SYSTEMS MACHINING 9121 88TH PLACE KENOSHA, WI 53144 PH: 262-605-1122 FAX: 262-605-1198	SIZE DWG. NO. C RAMS AUX-2100	REV C
ENG APPR: JK	DATE: 1/13/17	SCALE: 1:1.75	SHEET 1 OF 2			