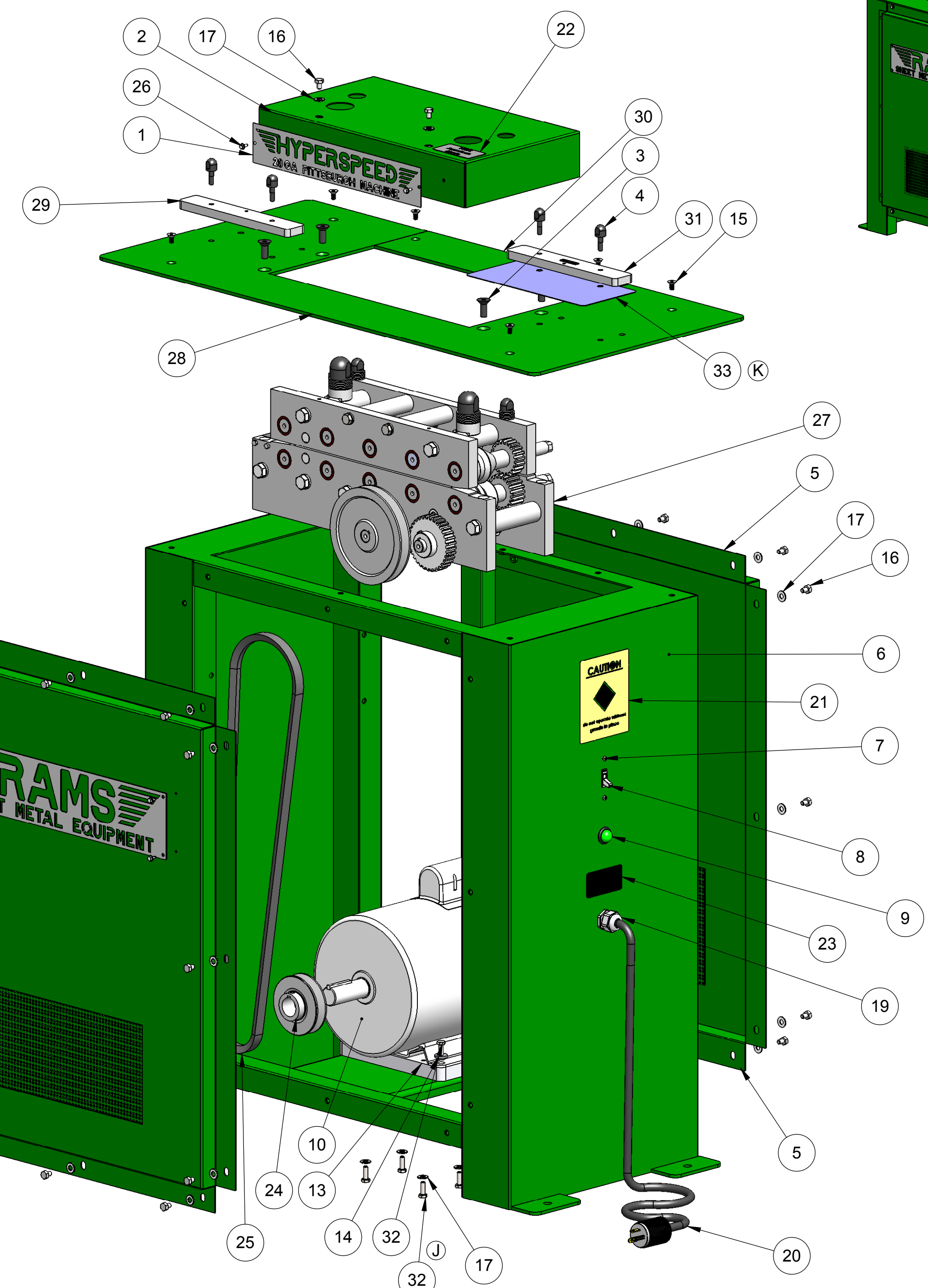
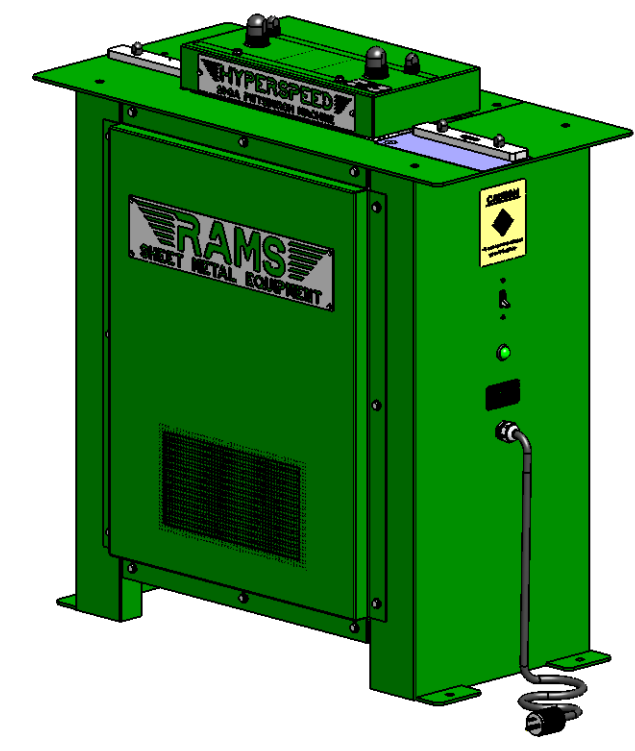


REVISIONS		
REV.	DESCRIPTION	DATE
A	INITIAL RELEASE	2/28/2007
B	CHANGE SWITCH AND CORD GRIP	3/13/2007
C	CORRECT PART NUMBER FROM 6991K57 TO 69915K57 CHANGE DESCRIPTION TO READ 1/2" NPT CORD GRIP	3/21/2007
D	DELETE PART HY-1300 AND REPLACE WITH HY-1305 AND HY-1310	3/26/2007
E	CHANGE BELT FROM AX-55 TO AX-53, ADD MOTOR SPACER AND MOTOR MOUNT HARDWARE	5/4/2007
F	DELETE HW-1008 & HW-1007 & REPLACE WITH HW-1009 REPLACE PITT-21 WITH HW-1043	6/5/2007
G	ADDED LABELS: REPLACED DUAL PULLEYS WITH SINGLE PULLEYS; 5L610 V-BELT QTY 1 WAS 4L560; HY-1058 & HY-1058-1 WERE HY-1055; HW-1026 WAS #6-32x3/8"	12/12/08
H	REPLACED PART #'S HY-1053, HY-1054, HY-1058, HY-105-1 WITH PITT-2, PITT-3, 2053-2, 2053-3. ALSO CHANGED TO SQUARE DRIVE GEARS. ADDED SHEET 2, ELECTRICAL KIT	7/26/2011
J	ADDED 1/4-20x.625 AND 1/4-20x.75 BOLTS. ADDED PLATE TO ELECTRICAL KIT.	8/9/2011
K	ADDED WEAR PLATE	8/10/2011
L	Changed (4) 1/4-20 x 5/8 long bolts to 1/4-20 x 3/4 long. Changed motor & belt info	7/17/2012



**NOTE: SEE SHEET 2 FOR ELECTRICAL KIT INFORMATION**

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

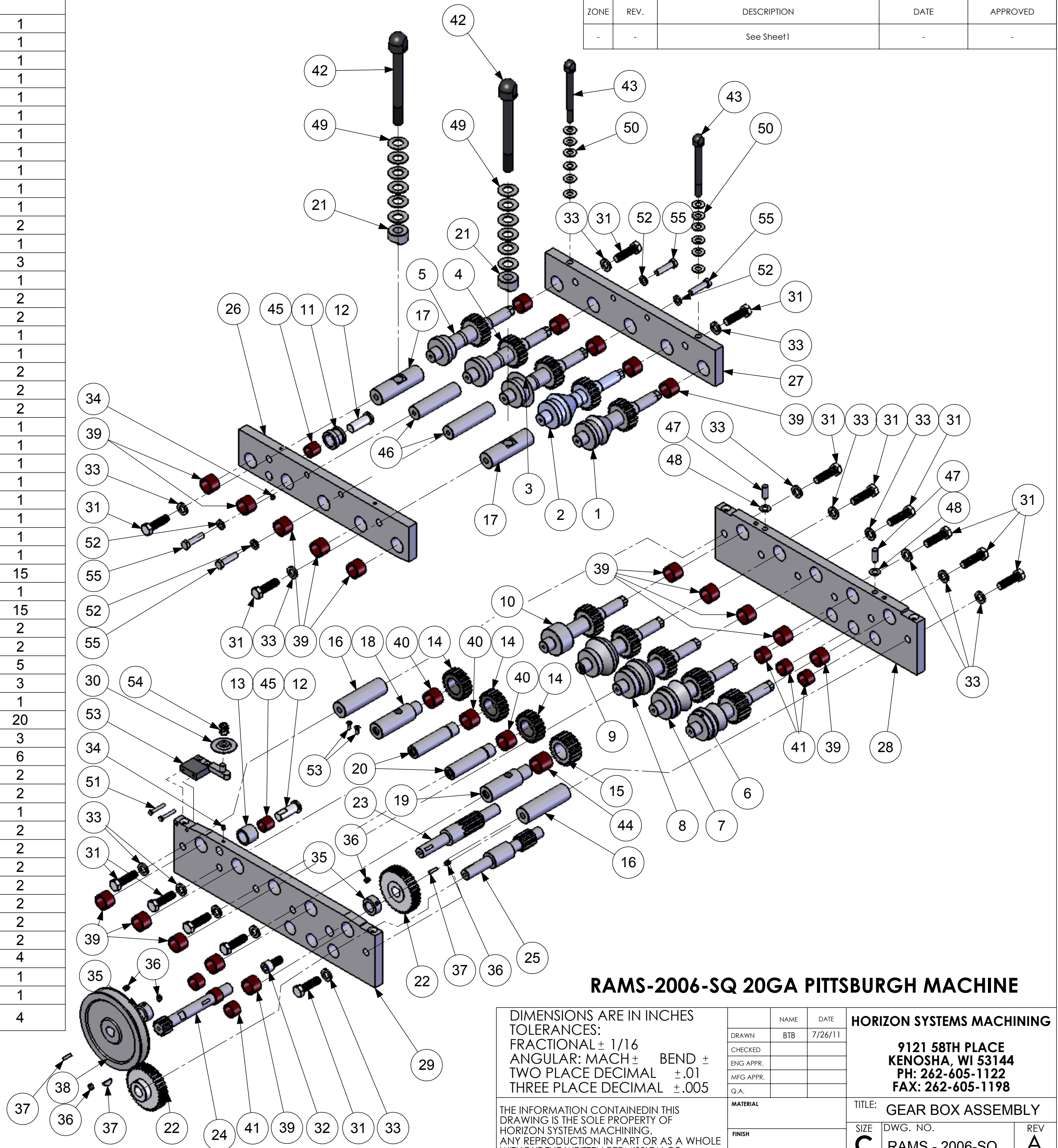
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	HY-1052	PLATE, HYPERSPEED	1
2	HY-1054	HYPERSPEED TOP COVER ASSY	1
3	2061	FHCS, 3/8-16 x 1", BLACK	4
4	2054	ADJUSTING BOLT: 1/4-20 THREAD	4
5	HY-1201-002	BACK PANEL ASSEMBLY	1
6	HY-1201	HYPERSPEED CABINET, ASSEMBLED	1
7	HW-1002	PHMS, 6-32 X 1/2", ZINC	2
8	N/A	30A, 220 VOLT, AC SWITCH	1
9	N/A	220 VOLT LIGHT ASSY	1
10	Z003180S1DXXXX	3 HP, 1740 RPM, 230V, 182T-215T MOTOR	1
11	HY-1201-001	FRONT PANEL ASSEMBLY	1
12	PITT-22	RAMS LOGO SIGN	1
13	HY-1340	PLATE, MOTOR SPACER	1
14	HY-1350	WASHER, MOTOR	4
15	HW-1043	FHCS, 1/4-20 X 1/2", BLACK	6
16	HW-1031	HHCS, 1/4-20 X 3/8", ZINC	26
17	HW-1009	WASHER, 1/4" FLAT, 5/8" O.D., ZINC	30
18	HW-1027	HHCS, TYPE F THD CUTTING, 8-32 X 3/8"	4
19	69915K57	CORD GRIP	1
20	N/A	POWER CORD ASSEMBLY	1
21	Caution Label	LABEL, CAUTION	1
22	Made in the USA	LABEL, MADE IN USA	1
23	RAMS 2012	SERIAL NUMBER TAGS	1
24	AK41x3/4	PULLEY, V-BELT, SINGLE	1
25	AX57	V-BELT	1
26	HW-1026	HHCS, TYPE F THD CUTTING, 8-32 X 3/8", ZINC	2
27	GEAR BOX ASSEMBLY	GEAR BOX ASSEMBLY	1
28	PITT-2	20 GA PITTSBURGH TOP PANELS	1
29	2053-3	GUIDE BAR, 20 GA PITTSBURGH	1
30	PITT-3	COVER TOP "B"	1
31	2053-2 ASSY	DESCRIPTION	1
32	HFBOLT 0.25-20x0.75x0.75-N	1/4-20 X 3/4, HHCS	8
33	2080	WEAR PLATE	1

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

DRAWN		NAME	DATE	<b>HORIZON SYSTEMS MACHINING</b>  <b>9121 58TH PLACE</b> <b>KENOSHA, WI 53144</b> <b>PH: 262-605-1122</b> <b>FAX: 262-605-1198</b>	
CHECKED		RAF	02/28/07		
ENG APPR.		SSL	12/12/08		
MFG APPR.					
G.A.					
MATERIAL		SEE BOM		TITLE:	
FINISH		N/A		20 GA. HYPERSPEED PITTSBURGH MACHINE	
DO NOT SCALE DRAWING		SCALE: 1:5		SIZE	DWG. NO.
				<b>C</b>	<b>HY-2012-SQ</b>
				REV	<b>L</b>
				SHEET 1 OF 2	

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.

ITEM NO.	PART NUMBER	DESCRIPTION	Default/QTY.
1	SQ-2001	T1 ROLLER GEAR	1
2	SQ-2002	T2 ROLLER GEAR	1
3	SQ-2003	T3 ROLLER GEAR	1
4	SQ-2004	T4 ROLLER GEAR	1
5	SQ-2005	T5 ROLLER GEAR	1
6	SQ-2006	B1 ROLLER GEAR	1
7	SQ-2007	B2 ROLLER GEAR	1
8	SQ-2008	B3 ROLLER GEAR	1
9	SQ-2009	B4 ROLLER GEAR	1
10	SQ-2010	B5 ROLLER GEAR	1
11	2011	IDLER ROLLER	1
12	2012	IDLER ROLL PIN	2
13	2013	IDLER ROLLER	1
14	2014	IDLER GEAR	3
15	2015	IDLER GEAR (LARGE)	1
16	2016	PLAIN SPACER	2
17	2017	PLAIN SPACER (DRILLED)	2
18	2018	STEPPED SPACER #1 (TAPPED)	1
19	2019	STEPPED SPACER #2 (TAPPED)	1
20	2020	STEPPED SPACER #3	2
21	2021	SADDLE WASHER	2
22	2022	DRIVE GEAR	2
23	2023	#1 DRIVE SHAFT	1
24	2024	#2 DRIVE SHAFT	1
25	2025	#3 DRIVE SHAFT	1
26	2026	TOP PLATE (FRONT)	1
27	2027	TOP PLATE (BACK)	1
28	2028	BOTTOM PLATE (BACK)	1
29	2029	BOTTOM PLATE (FRONT)	1
30	2031	OPENING ROLLER	1
31	2032	HHCS, 1/2-13 x 1 1/2"	15
32	2034	1/2-13 X 1" LONG SHCS	1
33	2033	1/2" LOCK WASHER	15
34	2035	SET SCREW, 1/4-20 X 5/16"	2
35	2039	SPACER	2
36	2040	SET SCREW, 5/16-18 X 3/8"	5
37	2041	WOODRUFF KEY 606	3
38	BK60x.75	PULLEY	1
39	2044	NEEDLE BEARING # B-1412	20
40	2045	NEEDLE BEARING # BH-1412	3
41	2046	NEEDLE BEARING #JTT-1210	6
42	2049	ADJUSTING BOLT: 5/8-11 THREAD	2
43	2052	ADJUSTING BOLT:3/8-16 THREAD	2
44	2068	NEEDLE BEARING # BH-1416	1
45	2069	NEEDLE BEARING # BH-1012	2
46	2070	TOP SPACER	2
47	DPM 0.375x1	DOWEL PIN 3/8 DIA X 1 LONG	2
48	SPACER	SPACER-SIDE PLATE	2
49	N/A	LARGE BELVILLE WASHER	2
50	N/A	SMALL BELVILLE WASHER	2
51	HFBOLT 10-32X1.25	10-32X1-1/4,HHCS	2
52	Regular LW 0.375	3/8 LOCK WASHER	4
53	OPEN ROLL BRACKET	OPEN ROLL BRACKET ASSY	1
54	SP-1001	LEE SPRING, LC 059H 01 M	1
55	HFBOLT 0.375-16x1.5x1-N	3/8-16X1-1/2, HHCS	4



**RAMS-2006-SQ 20GA PITTSBURGH MACHINE**

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

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NAME	DATE	HORIZON SYSTEMS MACHINING	
DRAWN BTB	7/26/11	<b>9121 58TH PLACE            KENOSHA, WI 53144            PH: 262-605-1122            FAX: 262-605-1198</b>	
CHECKED			
ENG APPR.			
MFG APPR.			
Q.A.			
MATERIAL		TITLE: GEAR BOX ASSEMBLY	
FINISH		SIZE: <b>C</b>	DWG. NO.: RAMS - 2006-SQ
DO NOT SCALE DRAWING		SCALE: 1:7	REV: <b>A</b>
		SHEET 2 OF 4	