



LOCATING SPOTS INDICATE SIDE OF GUIDE BAR TO FACE OPERATOR

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.**

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	A-T1-24-28	ROLLER, T1, DOUBLE SEAM	1
2	A-T2-24-28	ROLLER, T2, DOUBLE SEAM	1
3	A-T3-24-28	ROLLER, T3, DOUBLE SEAM	1
4	A-T4-24-28	ROLLER, T4, DOUBLE SEAM	1
5	A-T5-24-28	ROLLER, T5, DOUBLE SEAM	1
6	A-B1-24-28	ROLLER, B1, DOUBLE SEAM, SQUARE DRIVE	1
7	A-B2-24-28	ROLLER, B2, DOUBLE SEAM	1
8	A-B3-24-28	ROLLER, B3, DOUBLE SEAM	1
9	A-B4-24-28	ROLLER, B4, DOUBLE SEAM	1
10	A-B5-24-28	ROLLER, B5, DOUBLE SEAM	1
11	HW-1011-24-28-SQ	FLAT, WASHER, BRASS	10
12	HW-.250-20x.5	SHCS, 1/4-20 X 1/2, BLACK	10
13	HW-.250FW	WASHER, FLAT, 1/4	10
14	2053-1-24-28-SQ	EXIT, GUIDE BAR, AUX-A-SQ	1
15	2053-24-28-SQ	INLET, GUIDE BAR, AUX-A-SQ	1
16	2054	ADJUSTING BOLT: 1/4-20 THREAD	4

DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± 1/16 ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ±.01 THREE PLACE DECIMAL ±.005		NAME BTB DATE 6/17/11	HORIZON SYSTEMS MACHINING 9121 58TH PLACE KENOSHA, WI 53144 PH: 262-605-1122 FAX: 262-605-1198	
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FINISH N/A		SIZE C	DWG. NO. RAMS-AUX-A-SQ-24-28	REV
DO NOT SCALE DRAWING		SCALE: 1:1.25	SHEET 1 OF 1	