



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	DC-T1-24-28	ROLLER, T1 DRIVE CLEAT	1
2	DC-T2-24-28	ROLLER, T2, DRIVE CLEAT	1
3	DC-T3-24-28	ROLLER, T3, DRIVE CLEAT	1
4	DC-T4-24-28	ROLLER, T4, DRIVE CLEAT	1
5	DC-T5-24-28	ROLLER, T5, DRIVE CLEAT	1
6	DC-B1-24-28	ROLLER, B1, DRIVE CLEAT	1
7	DC-B2-24-28	ROLLER, B2, DRIVE CLEAT	1
8	DC-B3-24-28	ROLLER, B3, DRIVE CLEAT	1
9	DC-B4-24-28	ROLLER, B4, DRIVE CLEAT	1
10	DC-B5-24-28	ROLLER, B5, DRIVE CLEAT	1
11	HW-1011-24-28-SQ	FLAT, WASHER, BRASS	9
12	HW-.250FW	WASHER, FLAT, 1/4	9
13	HW-.250-20x.5	SHCS, 1/4-20 X 1/2, BLACK	9
14	2054	ADJUSTING BOLT:1/4-20 THREAD	4
15	2071-24-28-SQ	INLET, GUIDE BAR,AUX-D-SQ	1
16	2071-1-24-28-SQ	EXIT, GUIDE BAR, AUX-D-SQ	1

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

NAME		DATE		HORIZON SYSTEMS MACHINING 9121 58TH PLACE KENOSHA, WI 53144 PH: 262-605-1122 FAX: 262-605-1198	
DRAWN	BTB	6/20/11			
CHECKED					
ENG APPR.					
MFG APPR.					
MATERIAL		SEE BOM		TITLE: ERROR!:Description	
FINISH		N/A		SIZE	DWG. NO.
DO NOT SCALE DRAWING		SCALE: 1:4		C	RAMS-AUX-D-24-28-SQ
				REV	
				SHEET 1 OF 1	

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