



LOCATING SPOTS INDICATE SIDE OF GUIDE BAR TO FACE OPERATOR

| REVISIONS |                 |         |
|-----------|-----------------|---------|
| REV.      | DESCRIPTION     | DATE    |
| A         | INITIAL RELEASE | 4/27/11 |

**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.

| ITEM NO. | PART NUMBER | DESCRIPTION                              | QTY. |
|----------|-------------|--|------|
| 1        | HW-1001-SQ  | SHCS, 5/16-18 X 1/2, BLACK               | 10   |
| 2        | HW-1012     | WASHER, TAPERED, 5/16 X 7/8 O.D.         | 10   |
| 3        | DC-T1-SQ    | ROLLER, T1 DRIVE CLEAT                   | 1    |
| 4        | DC-T2-SQ    | ROLLER, T2, DRIVE CLEAT                  | 1    |
| 5        | DC-T3-SQ    | ROLLER, T3, DRIVE CLEAT                  | 1    |
| 6        | DC-T4-SQ    | ROLLER, T4, DRIVE CLEAT                  | 1    |
| 7        | DC-T5-SQ    | ROLLER, T5, DRIVE CLEAT                  | 1    |
| 8        | DC-B1-SQ    | ROLLER, B1, DRIVE CLEAT                  | 1    |
| 9        | DC-B2-SQ    | ROLLER, B2, DRIVE CLEAT                  | 1    |
| 10       | DC-B3-SQ    | ROLLER, B3, DRIVE CLEAT                  | 1    |
| 11       | DC-B4-SQ    | ROLLER, B4, DRIVE CLEAT                  | 1    |
| 12       | HW-1020     | SHCS, 1/2-13 X 3", BLACK                 | 1    |
| 13       | HW-1030     | WASHER, TAPERED, 1/2 X 1 1/8 O.D., PLAIN | 1    |
| 14       | DC-SB       | SLIDE BLOCK, DRIVE CLEAT                 | 1    |
| 15       | DC-B5-SQ    | ROLLER, B5, DRIVE CLEAT                  | 1    |
| 16       | 2054        | ADJUSTING BOLT: 1/4-20 THREAD            | 4    |
| 17       | 2071-1      | GUIDE BAR, RAMS AUX. D                   | 1    |
| 18       | 2071        | GUIDE BAR, RAMS AUX D                    | 1    |
| 19       | HW-SQ-1011  | WASHER, FLAT, BRASS                      | 10   |

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| DIMENSIONS ARE IN INCHES<br>TOLERANCES:<br>FRACTIONAL ± 1/16<br>ANGULAR: MACH ± BEND ±<br>TWO PLACE DECIMAL ±.01<br>THREE PLACE DECIMAL ±.005  |  | NAME: CNC<br>DATE: 4/27/11                               | <b>HORIZON SYSTEMS MACHINING</b><br><br>9121 58TH PLACE<br>KENOSHA, WI 53144<br>PH: 262-605-1122<br>FAX: 262-605-1198 |
| 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<br>FINISH: N/A<br>DO NOT SCALE DRAWING |   |