



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	RA-T1-24-28	ROLLER, T1, RIGHT ANGLE	1
2	RA-T2-24-28	ROLLER, T2, RIGHT ANGLE	1
3	RA-T3-24-28	ROLLER, T3, RIGHT ANGLE	1
4	RA-T4-24-28	ROLLER, T4, RIGHT ANGLE	1
5	RA-T5-24-28	ROLLER, T5, RIGHT ANGLE	1
6	RA-B1-24-28	ROLLER, B1, RIGHT ANGLE	1
7	RA-B2-24-28	ROLLER, B2, RIGHT ANGLE	1
8	RA-B3-24-28	ROLLER, B3, RIGHT ANGLE	1
9	RA-B4-24-28	ROLLER, B4, RIGHT ANGLE	1
10	RA-B5-24-28	ROLLER, B5, RIGHT ANGLE	1
11	HW-.250FW	WASHER, FLAT, 1/4	10
12	HW-.250-20x.5	SHCS, 1/4-20 X 1/2, BLACK	10
13	HW-SQ-1011-24-28	FLAT, WASHER, BRASS	10
14	2072-SQ	INLET, GUIDE BAR, AUX-R-SQ	1
15	2054	ADJUSTING BOLT: 1/4-20 THREAD	4
16	2072-1-24-28-SQ	EXIT, GUIDE BAR, AUX-R-SQ	1

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

NAME	DATE
DRAWN BTB	6/17/11
CHECKED	
ENG APPR.	
MFG APPR.	
Q.A.	

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MATERIAL	SEE BOM
FINISH	N/A
DO NOT SCALE DRAWING	

TITLE	RAMS-AUX-R-SQ-24-28	
SIZE	DWG. NO.	REV
C	RAMS-AUX-R-SQ-24-28	
SCALE: 1:4	SHEET 1 OF 1	