

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
N/A	A	INITIAL RELEASE	7/3/2007	RAF
	F	UPDATE TO CURRENT DESIGN	3/28/08	WH
	C	QTY 1 5L540 V-BELT WAS QTY 2 AX48 BELT: BK34 WAS 2AK25; BK80 WAS 2AK1ST (SHEET 2); ADD LABELS	9/23/2008	SSL
	F	SHEET 2: HW-1026 QTY 6 WAS QTY 4; AX-1735 WAS SL-1309; DELETED 91375A630 & 6-32 HHMS QTY 2	10/17/2008	SSL
	E	ADDED SHEET 4	7/26/2011	BTB
	F	REPLACED GEAR ASSEMBLY WITH SPLIT PLATE GEAR ASSEMBLY	7/29/2011	BTB
	G	ADDED WEAR PLATE	8/10/2011	BTB

NOTE: SEE SHEET 4 FOR ELECTRICAL KIT INFORMATION. (E)

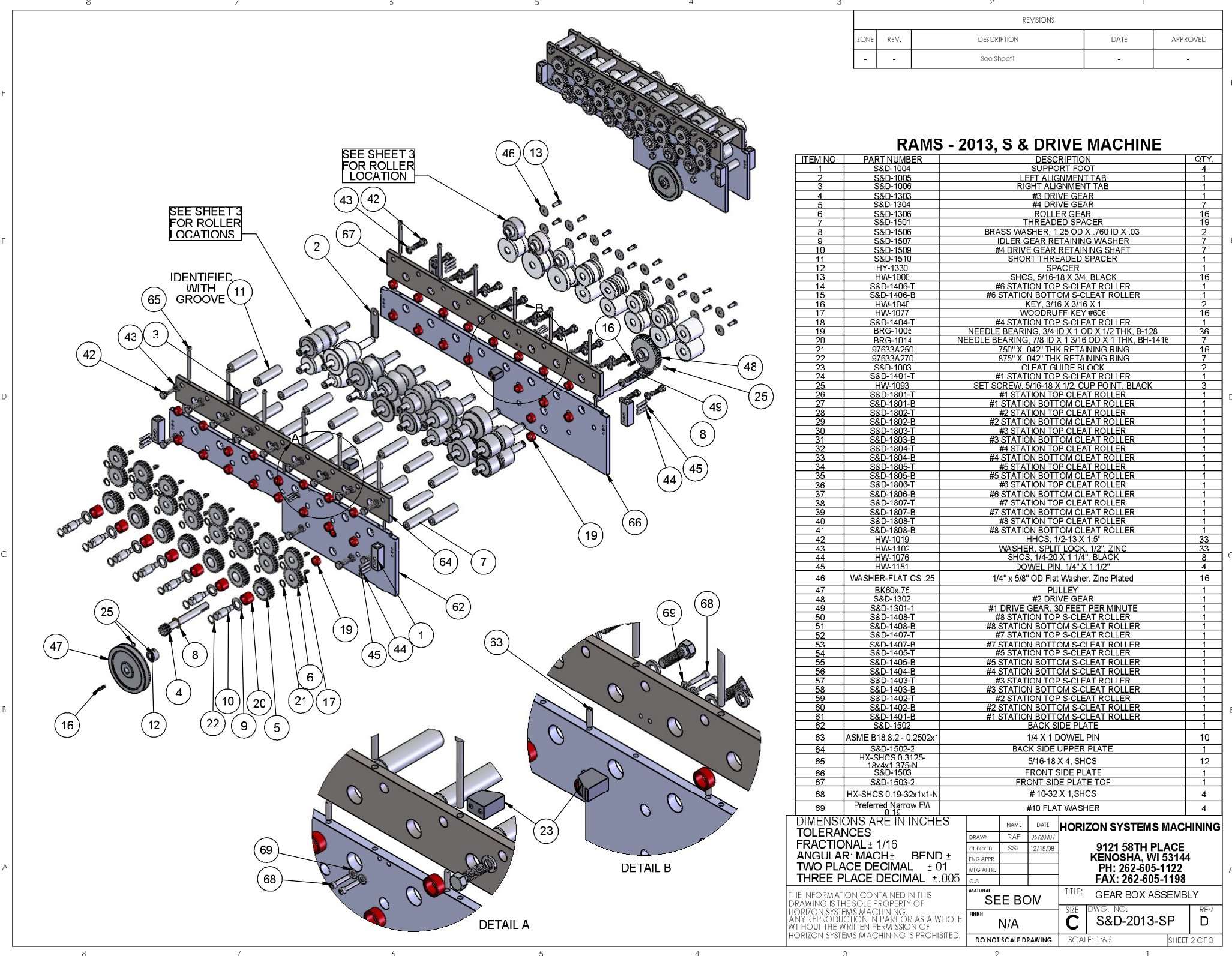
RAMS - 2013, S & DRIVE MACHINE

ITEM NO	PART NUMBER	DESCRIPTION	QTY
1	S&D-170C	S & DRIVE CABINET ASSEMBLY	1
2	Z003180S1DXXXX	3 HP, 1740 RPM, 230V, 182T-215T MOTOR	1
3	HY-1201-002	BACK PANEL ASSEMBLY	1
4	HY-1201-001	FRONT PANEL ASSEMBLY	1
5	PITT-22	RAMS LOGO SIGN	1
6	N/A	POWER CORD ASSEMBLY	1
7	69915K57	CORD GRIP	1
8	N/A	30A, 220 VOLT, AC SWITCH	1
9	N/A	220 VOLT LIGHT ASSY	1
10	BK34x1.125	PULLEY, V-BELT, SINGLE	1
11	S&D-1013	S CLEAT GUIDE BAR	1
12	S&D-1500-SP	GEAR BOX ASSEMBLY	1
13	HW-1045	FHCS, 1/4-20 X 3/4", BLACK OXIDE	4
14	HW-1096	FHCS, 3/8-16 X 1", BLACK	4
15	HW-1031	HHCS, 1/4-20 X 3/8", ZINC	28
16	HW-1008	WASHER, 1/4" FLAT, 5/8" O.D., ZINC	36
17	S&D-1007	CABINET TOP, INFEED	1
18	2054	ADJUSTING BOLT: 1/4-20 THREAD	4
19	SHCS BO, 25-20 X .75	SHCS 1/4-20 x 3/4 BO	2
20	HW-1002	PHMS, 6-32 X 1/2", ZINC	2
21	HW-1026	HHCS, TYPE F THD CUTTING, 8-32 X 3/8", ZINC	6
22	V-BELT	5L540 V-BELT	1
23	HY-1350	WASHER, MOTOR	4
24	HW-1014	HHCS, 1/4-20 X 3/4", ZINC	4
25	HW-1047	NUT, HEX, NYLOCK, 1/4-20, ZINC	4
26	S&D-1016	PLATE, S & DRIVE	1
27	S&D-1011SP	TOP COVER	1
28	S&D-1018	OUTFEED GUIDE ASSEMBLY	1
29	HW-1051	NUT, HEX, 3/8-16, ZINC	4
30	RAMS 2013	SERIAL NUMBER TAGS	1
31	Caution Label	LABEL, CAUTION	1
32	Made in the USA	LABEL, MADE IN USA	1
33	S&D-1013-1	S CLEAT GUIDE BAR (SLOTTED)	1
34	S&D-1014	AUXILIARY GUIDE BAR	1
35	AX-1735	CUSTOM HHCS, 3/8-16 x 1-1/2"	4
36	S&D-1007-1	WEAR PLATE	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	RAF	3/10/07			
CHECKED	SSL	12/15/08			
ENG APPR					
MFG APPR					
O.A.					
SEE BOM				TITLE: S & DRIVE MACHINE	
SEE NOTES				SIZE DWG. NO. REV	
DO NOT SCALE DRAWING				C S&D-2013-SP G	

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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
-	-	See Sheet1	-	-

RAMS - 2013, S & DRIVE MACHINE

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	S&D-1004	SUPPORT FOOT	4
2	S&D-1005	1 FET ALIGNMENT TAB	1
3	S&D-1006	RIGHT ALIGNMENT TAB	1
4	S&D-1303	#3 DRIVE GFAR	1
5	S&D-1304	#4 DRIVE GEAR	7
6	S&D-1306	ROLLER GFAR	16
7	S&D-1501	THREADED SPACER	19
8	S&D-1506	BRASS WASHER, 1.25 OD X .760 ID X .03	2
9	S&D-1507	IDLER GEAR RETAINING WASHER	7
10	S&D-1508	#4 DRIVE GEAR RETAINING SHAFT	7
11	S&D-1510	SHORT THREADED SPACER	1
12	HY-1330	SPACER	1
13	HW-1000	SHCS, 5/16-18 X 3/4, BLACK	16
14	S&D-1406-T	#6 STATION TOP S-CLEAT ROLLER	1
15	S&D-1406-B	#6 STATION BOTTOM S-CLEAT ROLLER	1
16	HW-1040	KEY, 3/16 X 3/16 X 1	2
17	HW-1077	WOODRUFF KEY #806	16
18	S&D-1404-T	#4 STATION TOP S-CLEAT ROLLER	1
19	BRG-1005	NEEDLE BEARING, 3/4 ID X 1 OD X 1/2 THK, B-128	36
20	BRG-1014	NEEDLE BEARING, 7/8 ID X 1 3/16 OD X 1 THK, BH-1416	7
21	97633A250	750" X .042" THK RETAINING RING	16
22	97633A270	875" X .042" THK RETAINING RING	7
23	S&D-1003	CLEAT GUIDE BLOCK	2
24	S&D-1401-T	#1 STATION TOP S-CLEAT ROLLER	1
25	HW-1093	SET SCREW, 5/16-18 X 1/2, CUP POINT, BLACK	3
26	S&D-1801-T	#1 STATION TOP CLEAT ROLLER	1
27	S&D-1801-B	#1 STATION BOTTOM CLEAT ROLLER	1
28	S&D-1802-T	#2 STATION TOP CLEAT ROLLER	1
29	S&D-1802-B	#2 STATION BOTTOM CLEAT ROLLER	1
30	S&D-1803-T	#3 STATION TOP CLEAT ROLLER	1
31	S&D-1803-B	#3 STATION BOTTOM CLEAT ROLLER	1
32	S&D-1804-T	#4 STATION TOP CLEAT ROLLER	1
33	S&D-1804-B	#4 STATION BOTTOM CLEAT ROLLER	1
34	S&D-1805-T	#5 STATION TOP CLEAT ROLLER	1
35	S&D-1805-B	#5 STATION BOTTOM CLEAT ROLLER	1
36	S&D-1806-T	#6 STATION TOP CLEAT ROLLER	1
37	S&D-1806-B	#6 STATION BOTTOM CLEAT ROLLER	1
38	S&D-1807-T	#7 STATION TOP CLEAT ROLLER	1
39	S&D-1807-B	#7 STATION BOTTOM CLEAT ROLLER	1
40	S&D-1808-T	#8 STATION TOP CLEAT ROLLER	1
41	S&D-1808-B	#8 STATION BOTTOM CLEAT ROLLER	1
42	HW-1019	HHCS, 1/2-13 X 1.5	33
43	HW-1102	WASHER, SPLIT LOCK, 1/2", ZINC	33
44	HW-1078	SHCS, 1/4-20 X 1 1/4", BLACK	8
45	HW-1151	DOWEL PIN, 1/4" X 1 1/2"	4
46	WASHER-FLAT CS 25	1/4" x 5/8" OD Flat Washer, Zinc Plated	16
47	BK60x75	PULLEY	1
48	S&D-1302	#2 DRIVE GEAR	1
49	S&D-1301-1	#1 DRIVE GEAR, 30 FEET PER MINUTE	1
50	S&D-1408-T	#8 STATION TOP S-CLEAT ROLLER	1
51	S&D-1408-B	#8 STATION BOTTOM S-CLEAT ROLLER	1
52	S&D-1407-T	#7 STATION TOP S-CLEAT ROLLER	1
53	S&D-1407-B	#7 STATION BOTTOM S-CLEAT ROLLER	1
54	S&D-1405-T	#5 STATION TOP S-CLEAT ROLLER	1
55	S&D-1405-B	#5 STATION BOTTOM S-CLEAT ROLLER	1
56	S&D-1404-T	#4 STATION TOP S-CLEAT ROLLER	1
57	S&D-1404-B	#4 STATION BOTTOM S-CLEAT ROLLER	1
58	S&D-1403-T	#3 STATION TOP S-CLEAT ROLLER	1
59	S&D-1403-B	#3 STATION BOTTOM S-CLEAT ROLLER	1
60	S&D-1402-T	#2 STATION TOP S-CLEAT ROLLER	1
61	S&D-1402-B	#2 STATION BOTTOM S-CLEAT ROLLER	1
62	S&D-1502	BACK SIDE PLATE	1
63	ASME B18.8.2 - 0.2502x1	1/4 X 1 DOWEL PIN	10
64	S&D-1502-2	BACK SIDE UPPER PLATE	1
65	HX-SHCS 0.3175	5/16-18 X 4, SHCS	12
66	S&D-1503	FRONT SIDE PLATE	1
67	S&D-1503-2	FRONT SIDE PLATE TOP	1
68	HX-SHCS 0.19-32x1x1-N	# 10-32 X 1, SHCS	4
69	Preferred Narrow FWA 0.15	#10 FLAT WASHER	4

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TWO PLACE DECIMAL $\pm .01$
THREE PLACE DECIMAL $\pm .005$

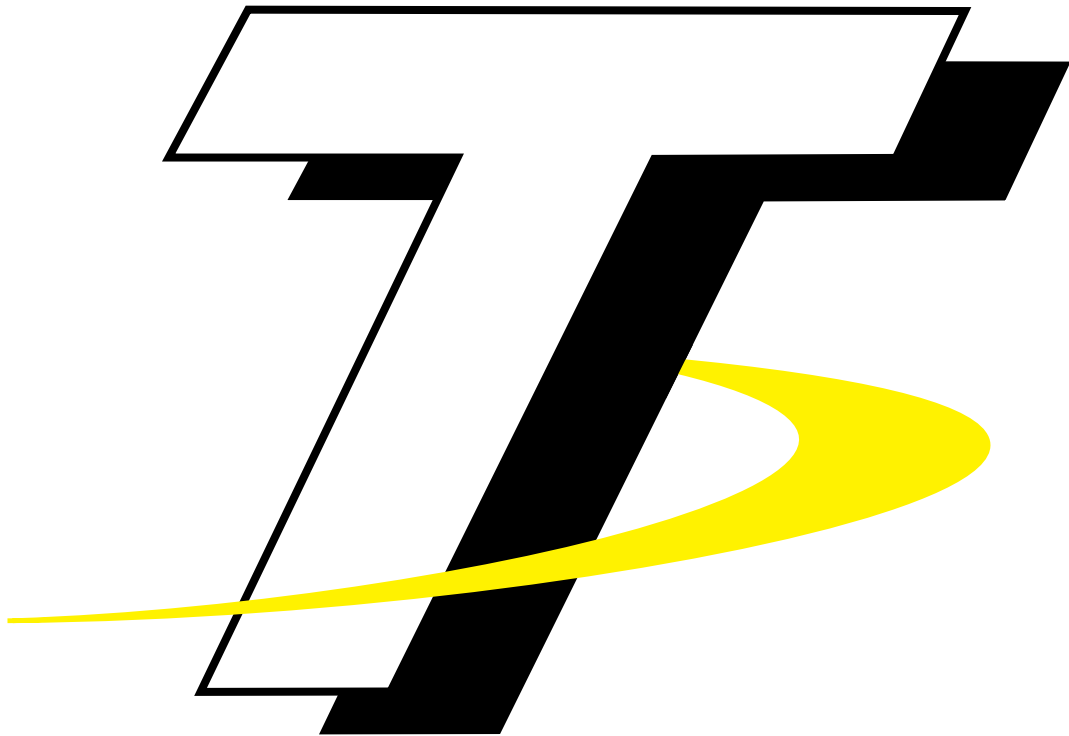
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NAME		DATE	HORIZON SYSTEMS MACHINING	
DRAWN	3AF	3/6/2010	9121 58TH PLACE KENOSHA, WI 53144 PH: 262-605-1122 FAX: 262-605-1198	
CHECKED	SSJ	12/15/08		
ENG APPR.				
MFG APPR.				
MATERIAL			TITLE: GEAR BOX ASSEMBLY	
SEE BOM			SIZE DWG. NO. REV	
FINISH			C S&D-2013-SP D	
DO NOT SCALE DRAWING			SCALE: 1"=1' SHEET 2 OF 3	

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