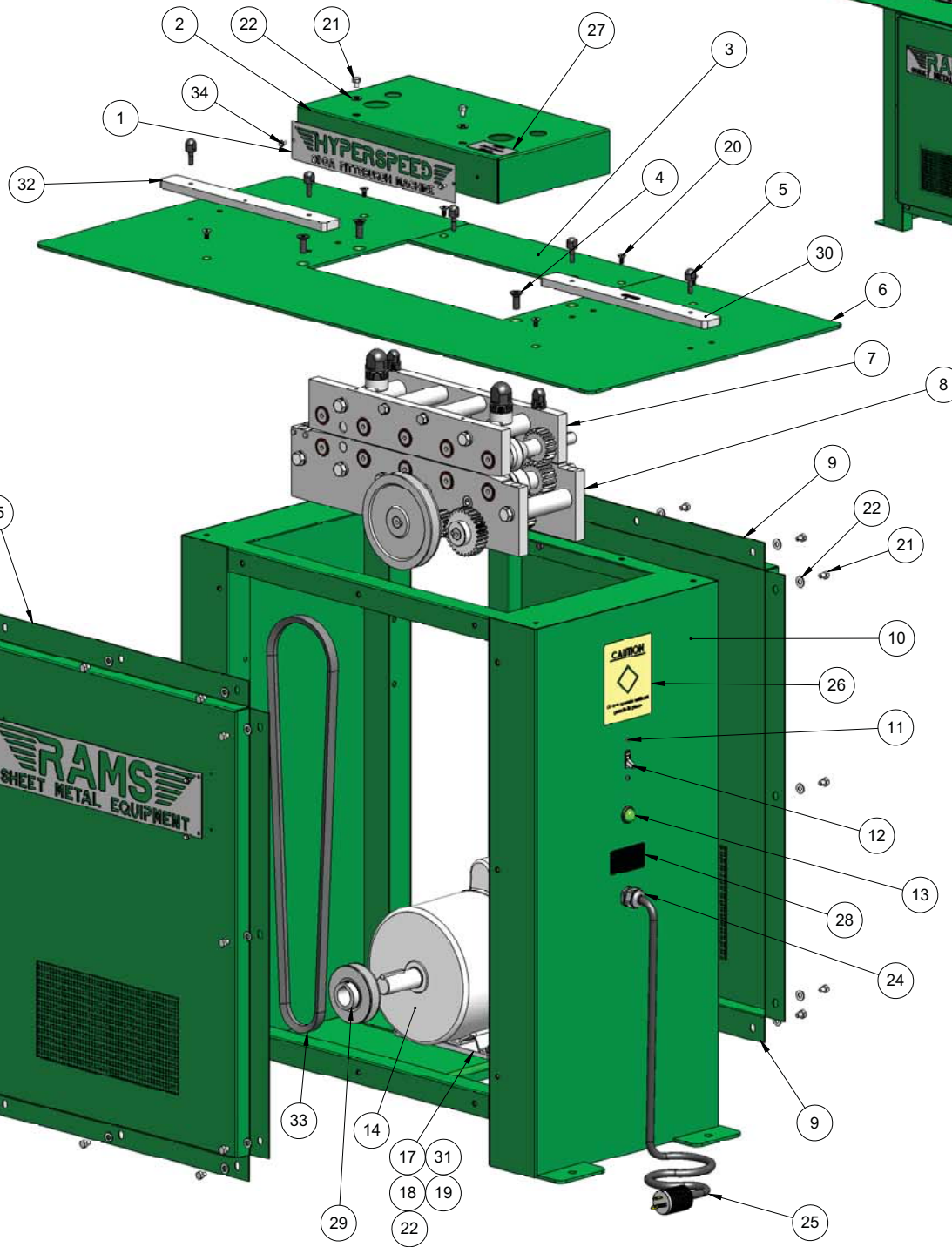


REVISIONS		
REV.	DESCRIPTION	DATE
G	ADDED LABELS	12/12/08



RAMS-2012 20 GA HYPERSPEED PITTSBURGH MACHINE

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	HY-1052	PLATE, HYPERSPEED	1
2	HY-1054	HYPERSPEED TOP COVER ASSY	1
3	HY-1053	COVER, AUXILIARY ACCESS	1
4	2061	FHCS, 3/8-16 x 1", BLACK	4
5	2054	ADJUSTING BOLT:1/4-20 THREAD	5
6	HY-1051	HYPERSPEED TOP PLATE ASSY	1
7	HY-1310	TOP GEAR BOX ASSY	1
8	HY-1305	BOTTOM GEAR BOX ASSY	1
9	HY-1201-002	BACK PANEL ASSEMBLY	1
10	HY-1201	HYPERSPEED CABINET, ASSEMBLED	1
11	HW-1002	PHMS, 6-32 X 1/2", ZINC	2
12	N/A	30A, 220 VOLT, AC SWITCH	1
13	N/A	220 VOLT LIGHT ASSY	1
14	N/A	3 HP, 1740 RPM, 230V, 182T-215T MOTOR	1
15	HY-1201-001	FRONT PANEL ASSEMBLY	1
16	PITT-22	RAMS LOGO SIGN	1
17	HY-1340	PLATE, MOTOR SPACER	1
18	HY-1350	WASHER, MOTOR	4
19	HW-1047	NUT, HEX, NYLOCK, 1/4-20, ZINC	4
20	HW-1043	FHCS, 1/4-20 X 3/8", BLACK	6
21	HW-1031	HHCS, 1/4-20 X 3/8", ZINC	26
22	HW-1009	WASHER, 1/4" FLAT, 5/8" O.D., ZINC	30
23	HW-1027	HHCS, TYPE F THD CUTTING, 8-32 X 3/8"	4
24	69915K57	CORD GRIP	1
25	N/A	POWER CORD ASSEMBLY	1
26	Caution Label	LABEL, CAUTION	1
27	Made in the USA	LABEL, MADE IN USA	1
28	RAMS 2012	SERIAL NUMBER TAGS	1
29	BK34x1.125	PULLEY, V-BELT, SINGLE	1
30	HY-1058	GUIDE BAR, HYPERSPEED	1
31	HW-1023	HHCS, 1/4-20 X 1.25"	4
32	HY-1058-1	GUIDE BAR, HYPERSPEED	1
33		V-BELT	1
34	HW-1026	HHCS, TYPE F THD CUTTING, 8-32 X 3/8", ZINC	2

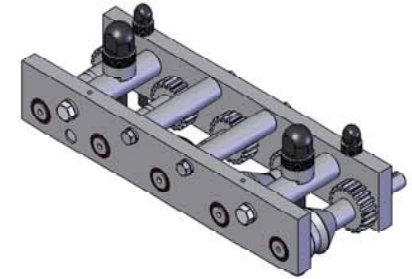
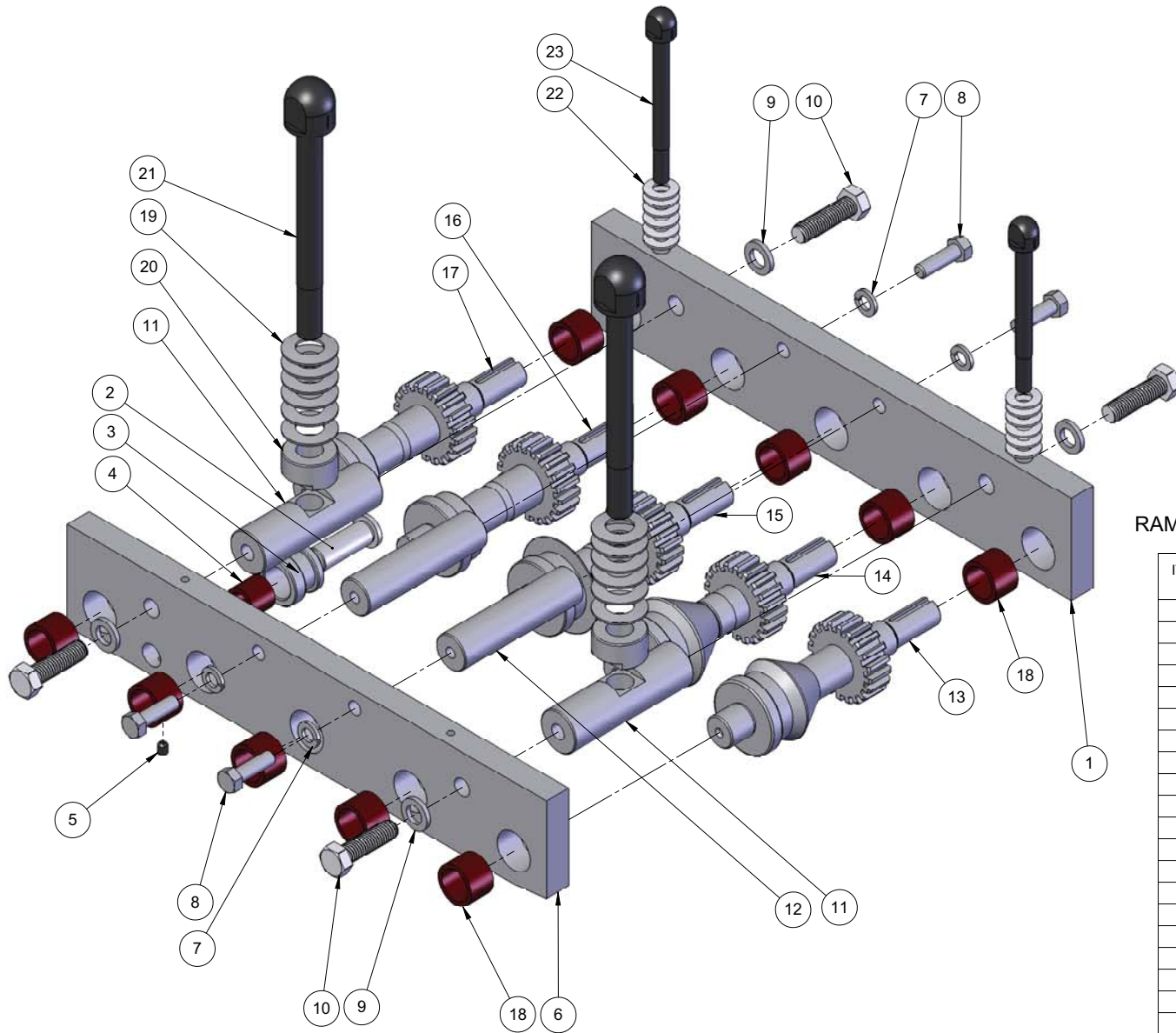
DIMENSIONS ARE IN INCHES
 TOLERANCES:
 FRACTIONAL ± 1/16
 ANGULAR: MACH ± BEND ±
 TWO PLACE DECIMAL ±.01
 THREE PLACE DECIMAL ±.005

	NAME	DATE
DRAWN	RAF	02/28/07
CHECKED	SSL	12/12/08
ENG APPR.		
MFG APPR.		
G.A.		

HORIZON SYSTEMS MACHINING
 9121 58TH PLACE
 KENOSHA, WI 53144
 PH: 262-605-1122
 FAX: 262-605-1198

MATERIAL SEE BOM		TITLE: 20 GA. HYPERSPEED PITTSBURGH MACHINE	
FINISH N/A	SIZE C	DWG. NO. HY-2012	REV G
DO NOT SCALE DRAWING		SCALE: 1:5	SHEET 1 OF 1

REVISIONS		
REV.	DESCRIPTION	DATE
B	REVISED	3/26/2007



RAMS-2012 20 GA HYPERSPEED PITTSBURGH MACHINE

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	2027	TOP PLATE (BACK)	1
2	2012	IDLER ROLL PIN	1
3	2011	IDLER ROLLER	1
4	2069	NEEDLE BEARING # BH-1012	1
5	2035	SET SCREW, 1/4-20 X 5/16"	1
6	2026	TOP PLATE (FRONT)	1
7	N/A	WASHER, LOCK, 3/8"	4
8	N/A	HHCS, 3/8-16 X 1.25	4
9	2033	1/2" LOCK WASHER	4
10	2032	HHCS, 1/2-13 x 1 1/2"	4
11	2017	PLAIN SPACER (DRILLED)	2
12	2070	TOP SPACER	2
13	2001	T1 ROLLER GEAR	1
14	2002	T2 ROLLER GEAR	1
15	2003	T3 ROLLER GEAR	1
16	2004	T4 ROLLER GEAR	1
17	2005	T5 ROLLER GEAR	1
18	2044	NEEDLE BEARING # B-1412	10
19	2050	LARGE BELLVILLE WASHER	12
20	2021	SADDLE WASHER	2
21	2049	ADJUSTING BOLT: 5/8-11 THREAD	2
22	2051	SMALL BELLVILLE WASHER	12
23	2052	ADJUSTING BOLT:3/8-16 THREAD	2

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

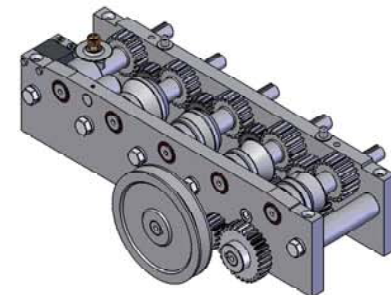
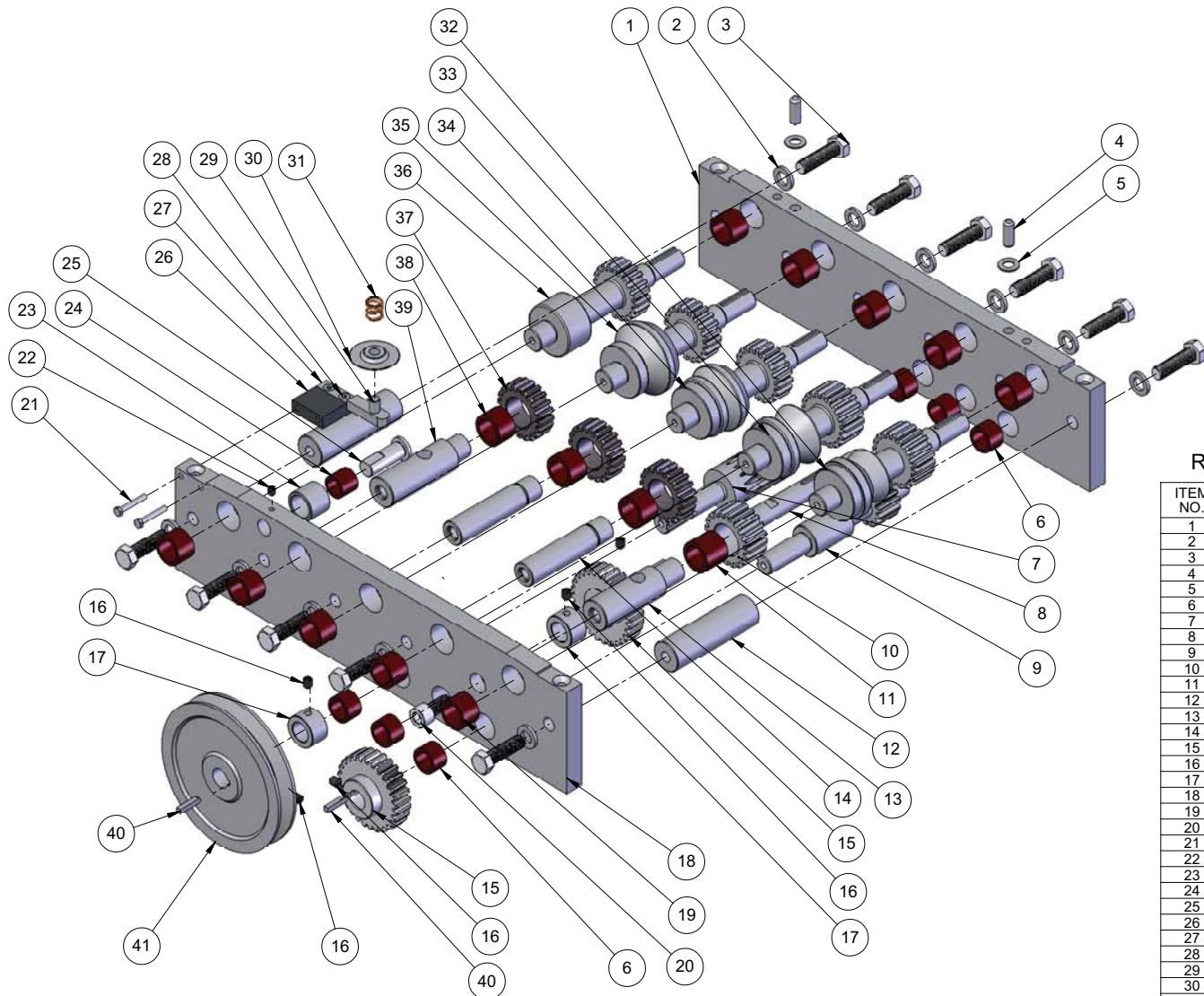
	NAME	DATE
DRAWN	RAF	02/28/07
CHECKED	SSL	12/12/08
ENG APPR.		
MFG APPR.		
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MATERIAL SEE BOM		TITLE: TOP GEAR BOX ASSY		
FINISH N/A	SIZE C	DWG. NO. HY-1310	REV B	
DO NOT SCALE DRAWING		SCALE: 1:2	SHEET 1 OF 1	

REVISIONS		
REV.	DESCRIPTION	DATE
D	REVISED	5/2/2007



RAMS-2012 20 GA HYPERSPEED PITTSBURGH MACHINE

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	HY-1305-005	BOTTOM PLATE (BACK)	1
2	2033	1/2" LOCK WASHER	11
3	2032	HHCS, 1/2-13 x 1 1/2"	11
4	DPM 0.375x1	DOWEL PIN 3/8 DIA X 1 LONG	2
5		SPACER-SIDE PLATE	2
6	2046	NEEDLE BEARING #JTT-1210	6
7	HY-1305-001	#1 DRIVE SHAFT	1
8	HY-1305-002	#2 DRIVE SHAFT	1
9	HY-1305-003	#3 DRIVE SHAFT	1
10	2015	IDLER GEAR (LARGE)	1
11	2068	NEEDLE BEARING # BH-1416	1
12	2016	PLAIN SPACER	2
13	2019	STEPPED SPACER #2 (TAPPED)	1
14	2020	STEPPED SPACER #3	2
15	HY-1305-004	DRIVE GEAR	2
16	2040	SET SCREW, 5/16-18 X 3/8"	5
17	HY-1330	SPACER	2
18	HY-1305-006	BOTTOM PLATE (FRONT)	1
19	2044	NEEDLE BEARING # B-1412	10
20	2034	1/2-13 X 1" LONG SHCS	1
21	N/A	HHMS, 10-32 X 1.25	2
22	2035	SET SCREW, 1/4-20 X 5/16"	1
23	2013	IDLER ROLLER	1
24	2069	NEEDLE BEARING # BH-1012	1
25	2012	IDLER ROLL PIN	1
26	2060	OPEN ROLL SPACER	1
27	2059	OPEN ROLL BAR	1
28	N/A	FHCS, 10-32 X 1/2	2
29	2037	3/8" DIA X 7/8" LONG DOWEL PIN	1
30	2031	OPENING ROLLER	1
31	SP-1001	LEE SPRING, LC 059H 01 M	1
32	2006	B1 ROLLER GEAR	1
33	2007	B2 ROLLER GEAR	1
34	2008	B3 ROLLER GEAR	1
35	2009	B4 ROLLER GEAR	1
36	2010	B5 ROLLER GEAR	1
37	2014	IDLER GEAR	3
38	2045	NEEDLE BEARING # BH-1412	3
39	2018	STEPPED SPACER #1 (TAPPED)	1
40	HW-1040	KEY, 3/16 X 3/16 X 1	3
41	BK60x.75	PULLEY	1

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 TWO PLACE DECIMAL ±.01
 THREE PLACE DECIMAL ±.005

DRAWN	NAME	DATE
CHECKED	RAF	02/23/07
ENG APPR.	SSL	12/12/08
MFG APPR.		
G.A.		

MATERIAL
SEE BOM

FINISH
SEE NOTES

DO NOT SCALE DRAWING

TITLE: BOTTOM GEAR BOX ASSY

SIZE	DWG. NO.	REV
C	HY-1305	D

SCALE: 1:3 SHEET 1 OF 1

F
E
D
C
B
A