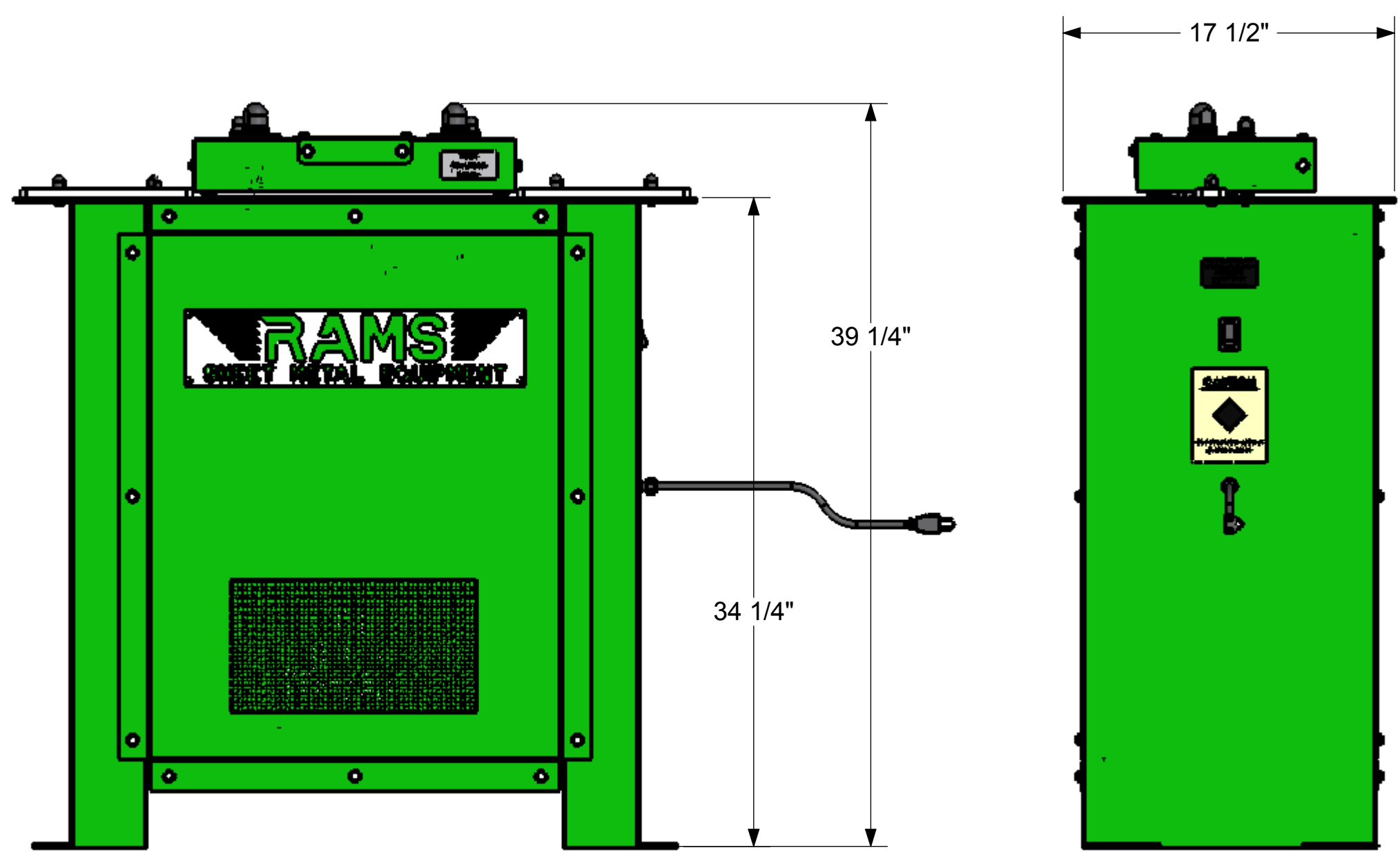
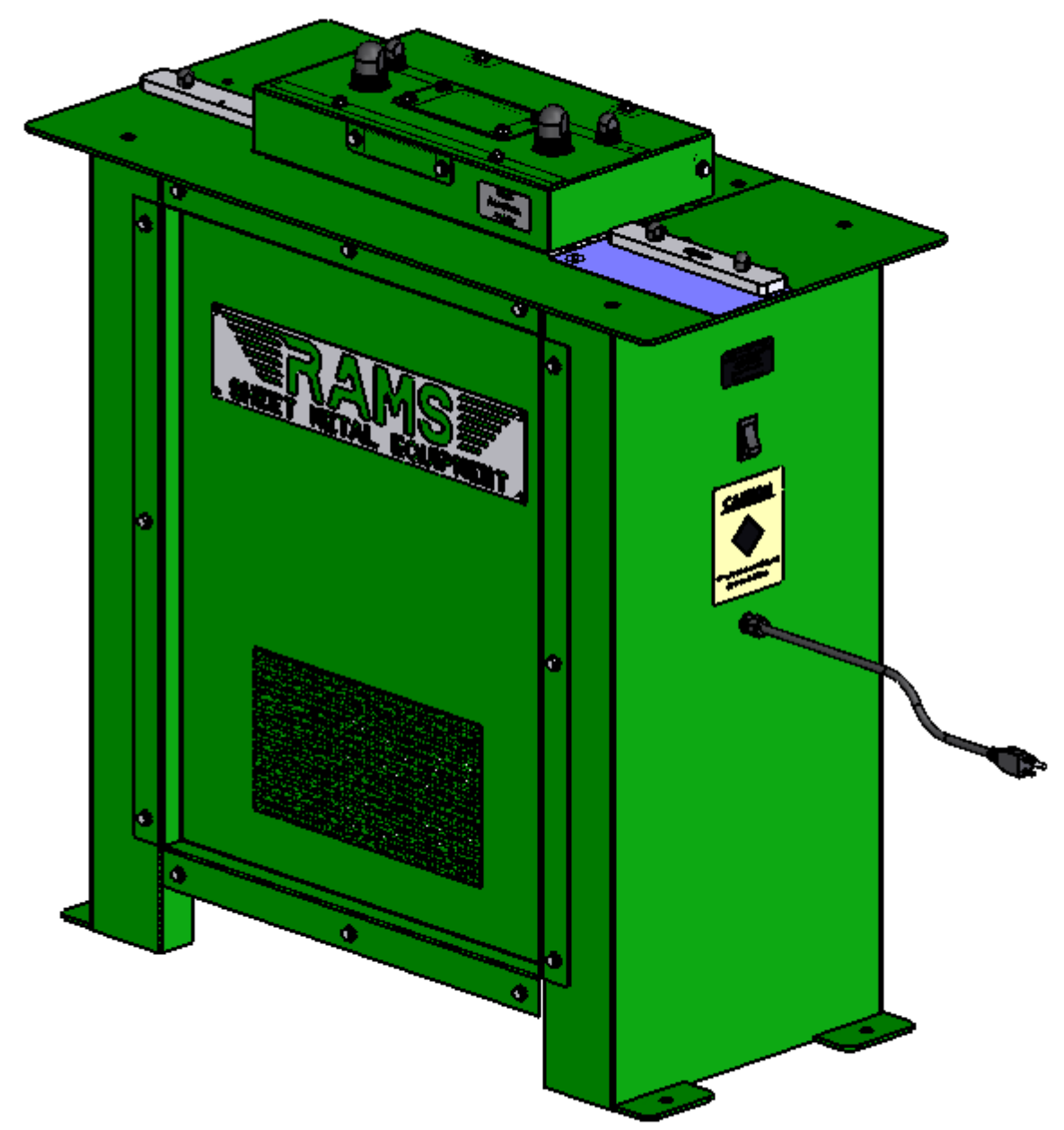
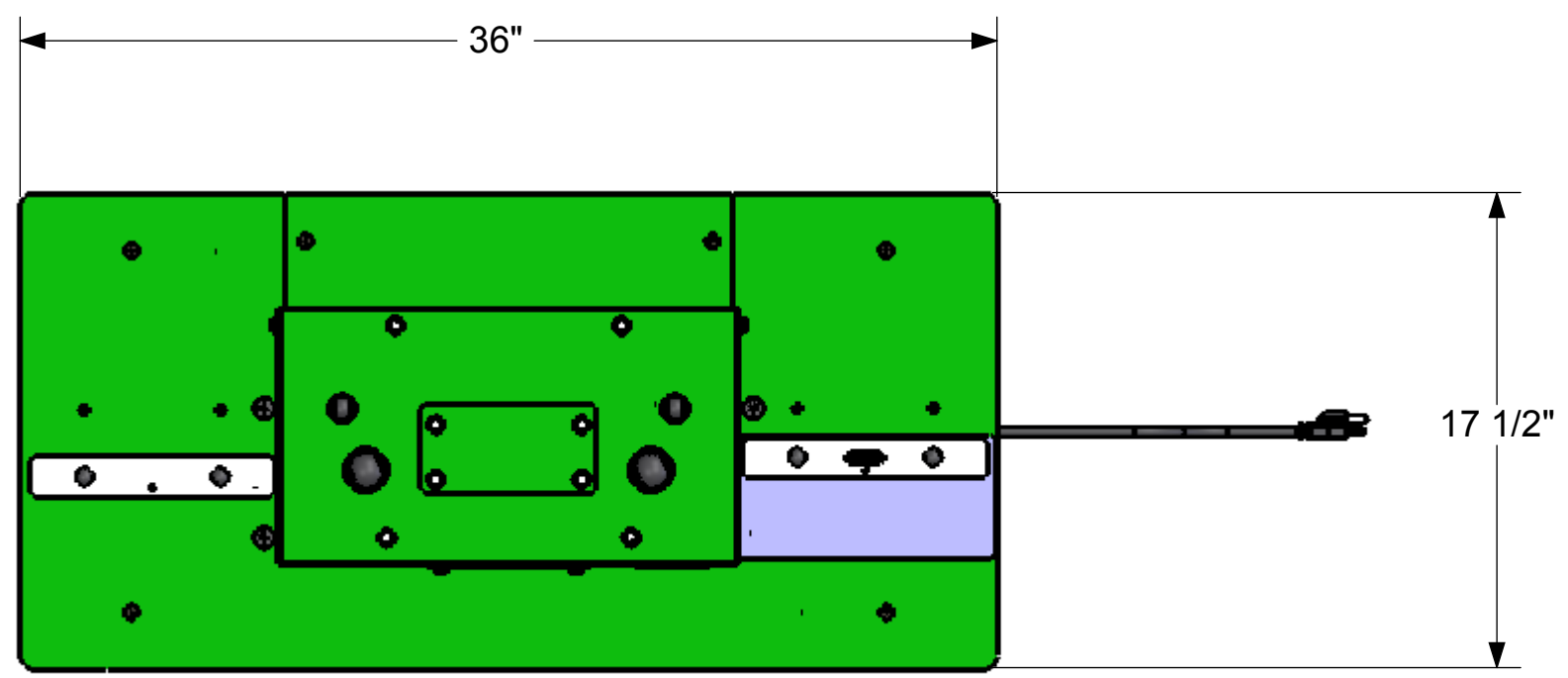


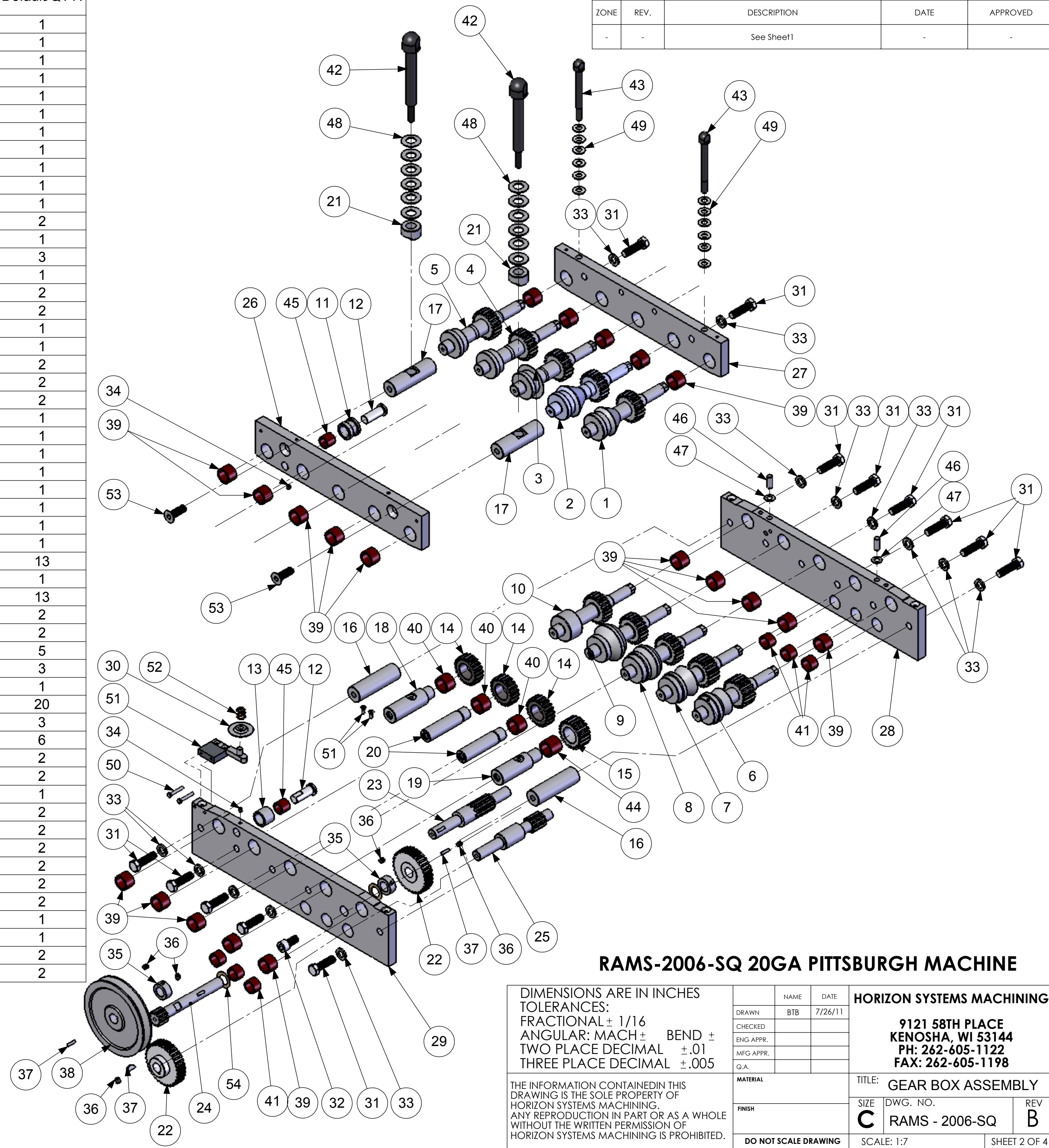
REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	ADDED SHEET 4, ELECTRICAL KIT	7/27/2011	BTB
	B	UPDATED BOM ON SHEET 2 AND 3	2/16/2016	SJB



RAMS-2006-SQ 20 GA PITTSBURGH MACHINE

DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± 1/16 ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ±.01 THREE PLACE DECIMAL ±.005 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.	DRAWN	BTB	7/26/11	HORIZON SYSTEMS MACHINING 9121 58TH PLACE KENOSHA, WI 53144 PH: 262-605-1122 FAX: 262-605-1198
	CHECKED			
	ENG APPR.			
	MFG APPR.			
	Q.A.			
MATERIAL	N/A		TITLE:	RAM-2006-SQ 20 GA PITTSBURGH MACHINE
FINISH	NONE		SIZE	DWG. NO.
DO NOT SCALE DRAWING			C	RAMS - 2006-SQ
				REV B
				SHEET 1 OF 4

ITEM NO.	PART NUMBER	DESCRIPTION	Default/QTY.
1	SQ-2001	T1 ROLLER GEAR	1
2	SQ-2002	T2 ROLLER GEAR	1
3	SQ-2003	T3 ROLLER GEAR	1
4	SQ-2004	T4 ROLLER GEAR	1
5	SQ-2005	T5 ROLLER GEAR	1
6	SQ-2006	B1 ROLLER GEAR	1
7	SQ-2007	B2 ROLLER GEAR	1
8	SQ-2008	B3 ROLLER GEAR	1
9	SQ-2009	B4 ROLLER GEAR	1
10	SQ-2010	B5 ROLLER GEAR	1
11	2011	IDLER ROLLER	1
12	2012	IDLER ROLL PIN	2
13	2013	IDLER ROLLER	1
14	2014	IDLER GEAR	3
15	2015	IDLER GEAR (LARGE)	1
16	2016	PLAIN SPACER	2
17	2017	PLAIN SPACER DRILLED	2
18	2018	STEPPED SPACER #1 (TAPPED)	1
19	2019	STEPPED SPACER #2 (TAPPED)	1
20	2020	STEPPED SPACER #3	2
21	2021	SADDLE WASHER	2
22	2022	DRIVE GEAR	2
23	2023	#1 DRIVE SHAFT	1
24	2024	#2 DRIVE SHAFT	1
25	2025	#3 DRIVE SHAFT	1
26	2026	TOP PLATE (FRONT)	1
27	2027	TOP PLATE (BACK)	1
28	2028	BOTTOM PLATE (BACK)	1
29	2029	BOTTOM PLATE (FRONT)	1
30	2031	OPENING ROLLER	1
31	2032	HHCS, 1/2-13 x 1 1/2"	13
32	2034	1/2-13 X 1" LONG SHCS	1
33	2033	1/2" LOCK WASHER	13
34	2035	SET SCREW, 1/4-20 X 5/16"	2
35	2039	SPACER	2
36	2040	SET SCREW, 5/16-18 X 3/8"	5
37	2041	WOODRUFF KEY 606	3
38	BK60x.75	5" X 3/4 PULLEY 500A	1
39	2044	NEEDLE BEARING # B-1412	20
40	2045	NEEDLE BEARING # BH-1412	3
41	2046	NEEDLE BEARING #JTT-1210	6
42	2049	ADJUSTING BOLT: LARGE	2
43	2052	ADJUSTING BOLT:3/8-16 THREAD	2
44	2068	NEEDLE BEARING # BH-1416	1
45	2069	NEEDLE BEARING # BH-1012	2
46	DPM 0.375x1	DOWEL PIN 3/8 DIA X 1 LONG	2
47	SPACER	SPACER-SIDE PLATE	2
48	N/A	LARGE BELVILLE WASHER	2
49	N/A	SMALL BELVILLE WASHER	2
50	HFBOLT 10-32X1.25	10-32X1-1/4,HHCS	2
51	OPEN ROLL BRACKET	OPEN ROLL BRACKET ASSY	1
52	SP-1001	LEE SPRING, LC 059H 01 M	1
53	91263A605	1/2-13 X 1 1/2 FHCS ALLOY ZINC	2
54	PF-1009	WASHER (RTNG RING)	2



RAMS-2006-SQ 20GA PITTSBURGH MACHINE

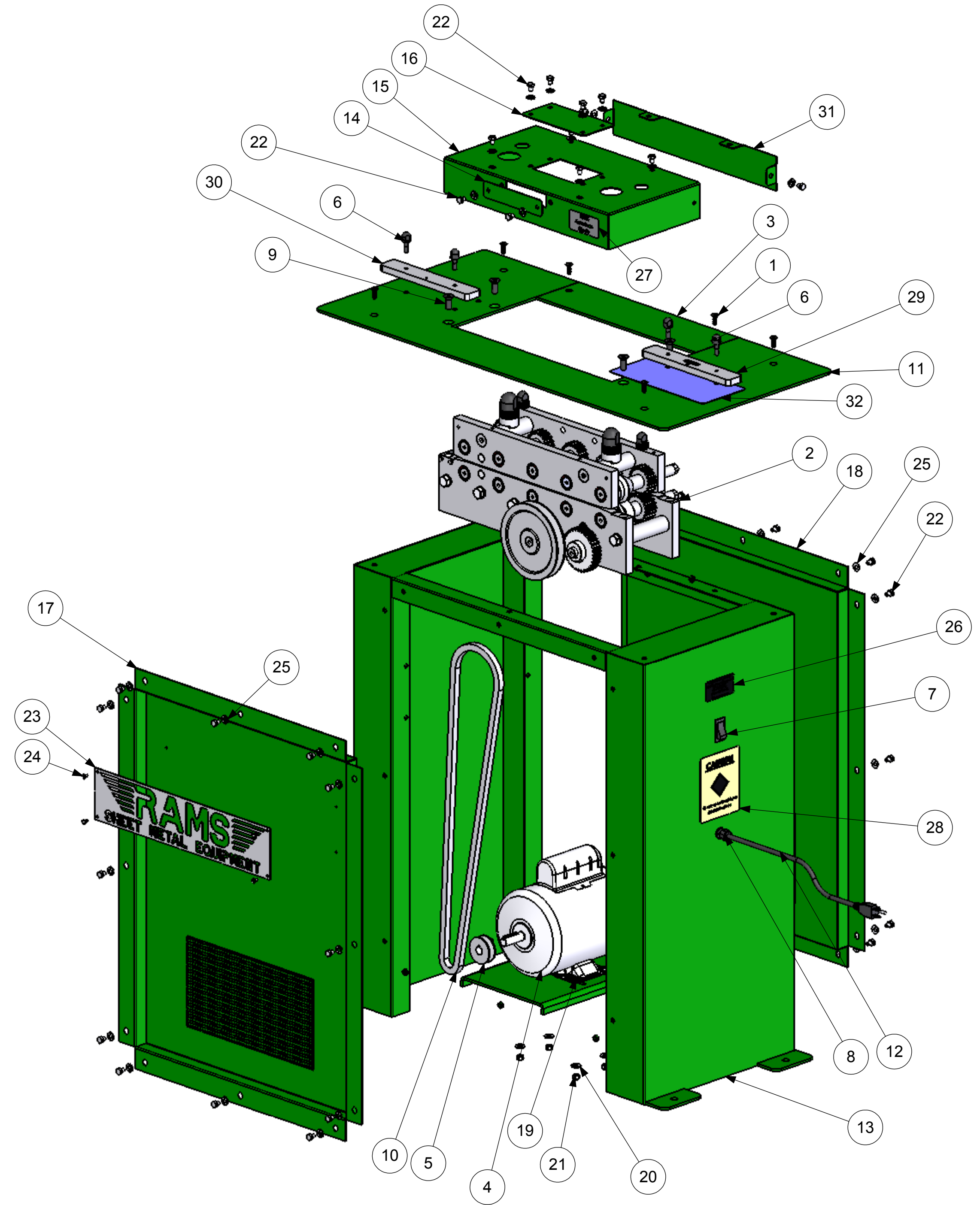
DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± 1/16 ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ±.01 THREE PLACE DECIMAL ±.005		<table border="1"> <tr><td>NAME</td><td>DATE</td></tr> <tr><td>DRAWN BTB</td><td>7/26/11</td></tr> <tr><td>CHECKED</td><td></td></tr> <tr><td>ENG APPR.</td><td></td></tr> <tr><td>MFG APPR.</td><td></td></tr> <tr><td>Q.A.</td><td></td></tr> </table>	NAME	DATE	DRAWN BTB	7/26/11	CHECKED		ENG APPR.		MFG APPR.		Q.A.		HORIZON SYSTEMS MACHINING 9121 58TH PLACE KENOSHA, WI 53144 PH: 262-605-1122 FAX: 262-605-1198
NAME	DATE														
DRAWN BTB	7/26/11														
CHECKED															
ENG APPR.															
MFG APPR.															
Q.A.															
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MATERIAL	TITLE: GEAR BOX ASSEMBLY														
FINISH	SIZE DWG. NO. REV														
DO NOT SCALE DRAWING	C RAMS - 2006-SQ B														

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

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
-	-	See Sheet1	-	-
		UPDATED BOM	7-31-14	SJB

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

RAMS-2006-SQ 20GA PITTSBURGH MACHINE



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	HW-1045	FHCS, 1/4-20 X 3/4", BLACK OXIDE	6
2	GEAR BOX ASSEMBLY	GEAR BOX ASSEMBLY	1
3	PITT-3	COVER TOP "B"	1
4	1HP - 56E	1 HP, 1725 RPM, 110V MOTOR	1
5	2043	3" PULLEY: CA300	1
6	2054	ADJUSTING BOLT:1/4-20 THREAD	4
7	3XS59	TIPPETTE SWITCH	1
8	69915K51	CORD GRIP	1
9	2061	FHCS, 3/8-16 x 1", BLACK	4
10	2066	V-BELT: 4L570	1
11	PITT-2	TOP COVER	1
12	CORD1	POWER CORD	1
13	STAND B	2006 CABINET, WELDED	1
14	PITT-9D	PLATE-ACCESS, TOP COVER	1
15	PITT-9-0	RAMS 2006 TOP COVER	1
16	PITT-9C	PLATE-TOP COVER	1
17	HY-1201-001	FRONT PANEL ASSEMBLY	1
18	HY-1201-002	BACK PANEL ASSEMBLY	1
19	HW-1014-.750	HHCS 1/4-20X 3/4 ZINC	4
20	90108A413	WASHER 1/4" FLAT 3/4 O.D. ZINC	8
21	HW-1047	NUT, HEX, NYLOCK, 1/4-20, ZINC	4
22	HW-1031	HHCS, 1/4-20 X 3/8", ZINC	36
23	PITT-22	RAMS LOGO SIGN	1
24	HW-1027	HHCS, TYPE F THD CUTTING, 8-32 X 3/8"	4
25	HW-1009	WASHER, 1/4" FLAT, 5/8" O.D., ZINC	36
26	RAMS 2006	SERIAL No. TAG, RAMS 2006	1
27	Made in the USA	LABEL, MADE IN USA	1
28	Caution Label	LABEL, CAUTION	1
29	2053-2	GUIDE BAR, 20 GA PITTSBURGH	1
30	2053-3	GUIDE BAR, 20 GA PITTSBURGH	1
31	PITT-9E	ACCESS PANEL	1
32	2080	WEAR PLATE	1

NOTE: FOR RAMS-2006-SQ PITTSBURGH MACHINE WELD THE SCREEN ON OPPOSITE SIDE OF PANEL.

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

NAME	DATE
DRAWN BTB	7/26/11
CHECKED	
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MFG APPR.	
Q.A.	

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

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MATERIAL	
FINISH	
DO NOT SCALE DRAWING	

TITLE: 20 GA PITTSBURGH MACHINE SQ		
SIZE C	DWG. NO. RAMS - 2006-SQ	REV B
SCALE: 1:6		SHEET 3 OF 4

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

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KIT 2	RAMS-2006-SQ 20 GA PITTSBURGH	QTY
MOTOR	WAG 1HP (H-3) Z001180S1B022309	1
BELT	OPTIBELT NOTCHED p/n AX56	1
PULLEY 1	CONGRESS CA0500x075KW	1
PULLEY 2	CONGRESS CA0300x062KW	1
	COMPONENTS IN 1 HP KIT	1
	SJOOW,SOOW 16/3CORD W/PLUG	1
	McGILL 0852-133 LIGHTED SWITCH	1
	S2113 CORD GRIP	1
	TAB ON WIRE DISCONNECTS	1
	ASSEMBLED PER PRINT	1
	WIRED TO MOTOR TESTED AND KITTED	1

RAMS-2006-SQ 20 GA PITTSBURGH MACHINE

DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± 1/16 ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ±.01 THREE PLACE DECIMAL ±.005	DRAWN	BTB	7/27/11	HORIZON SYSTEMS MACHINING 9121 58TH PLACE KENOSHA, WI 53144 PH: 262-605-1122 FAX: 262-605-1198
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	FINISH	NONE		ELECTRICAL KIT 2
	DO NOT SCALE DRAWING	SCALE: 1:6	SHEET 4 OF 4	SIZE DWG. NO. REV C RAMS - 2006-SQ B