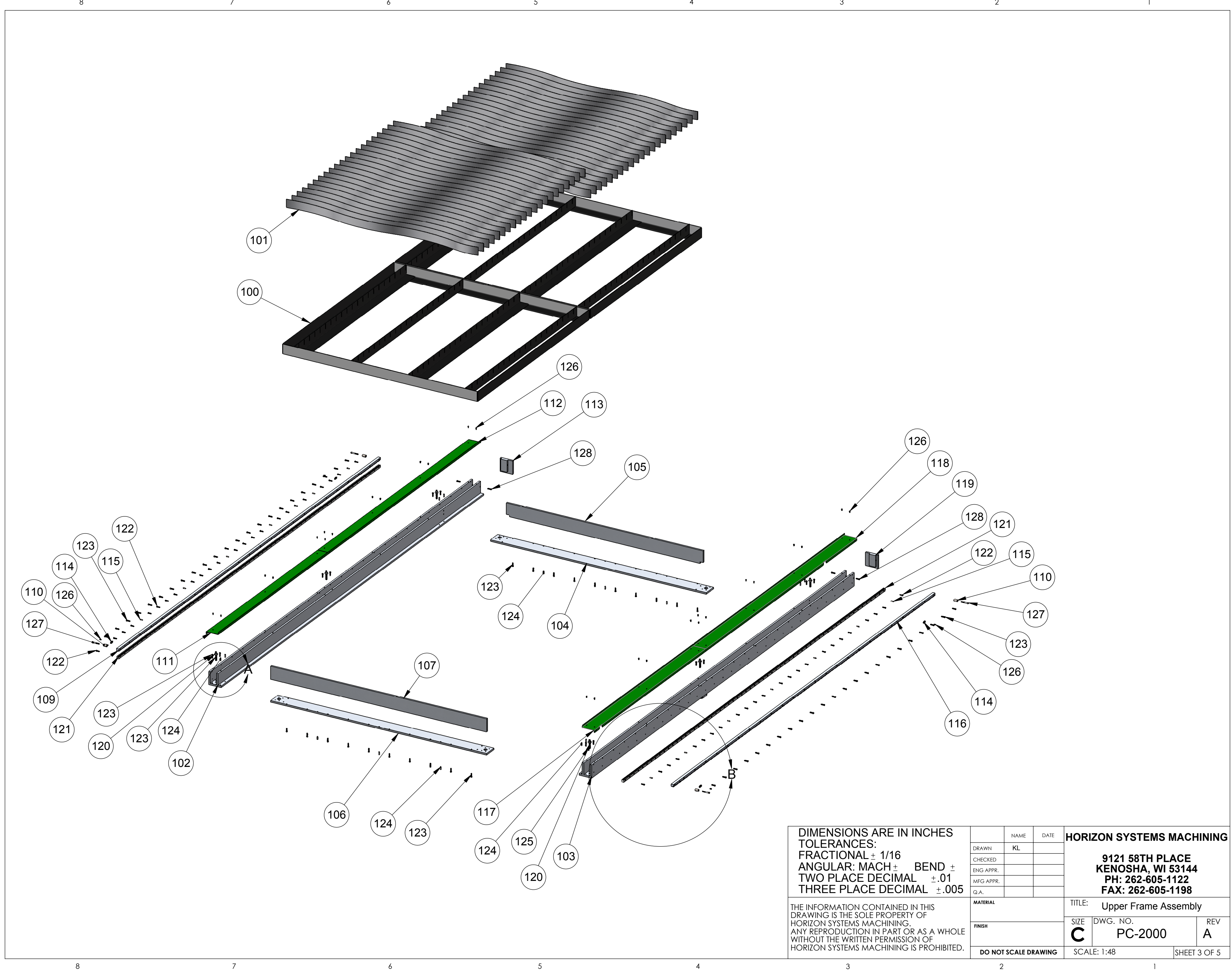


REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A		11/27/2013	KL

DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL $\pm 1/16$ ANGULAR: MACH \pm BEND \pm TWO PLACE DECIMAL $\pm .01$ THREE PLACE DECIMAL $\pm .005$		NAME	DATE	HORIZON SYSTEMS MACHINING 9121 58TH PLACE KENOSHA, WI 53144 PH: 262-605-1122 FAX: 262-605-1198	
		DRAWN	KL		
		CHECKED			
		ENG APPR.			
		MFG APPR.			
		Q.A.			
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		TITLE: Upper Frame Assembly	
		FINISH		SIZE C	DWG. NO. PC-2000
DO NOT SCALE DRAWING		SCALE: 1:24			REV A
				SHEET 1 OF 5	

8				7				6				5				4				3				2				1			
ITEM NO.				PART NUMBER				DESCRIPTION				QTY.				REVISIONS															
100				PC-2001				Slat Frame				2				ZONE		REV.		DESCRIPTION				DATE		APPROVED					
101				PC-2002				Slat				42				-		-		See Sheet1				-		-					
102				PC-2003				LH BASE RAIL				1																			
103				PC-2004				RH BASE RAIL				1																			
104				PC-2005				BACK LOWER				1																			
105				PC-2006				Back Upper				1																			
106				PC-2007				Front Lower				1																			
107				PC-2008				Front Upper				1																			
108				PC-2009				Riser				2																			
109				PC-2010				Left Hand Rack				1																			
110				PC-2011				X Axis Stop				4																			
111				PC-2012				L.H. Front Base Rail Cover				1																			
112				PC-2013				L.H. Back Base Rail Cover				1																			
113				PC-2014				L.H. Base Rail End Block				1																			
114				PC-2015				Prox Sensor Dog				4																			
115				PC-2016				Base Rail Locating Pin				14																			
116				PC-2017				Right Hand Rack				1																			
117				PC-2018				R.H. Front Base Rail Cover				1																			
118				PC-2019				R.H. Back Base Rail Cover				1																			
119				PC-2020				R.H. Base Rail End Block				1																			
120				FW-3				Flat Washer				6																			
121				421N20A +3644.9				Thompson Rail				2																			
122				95263A388				Zinc SHCS M5 x 20mm Long				48																			
123				90128A246				Zinc SHCS 1/4-20 x 7/8" Long				90																			
124				98381A541				Alloy Steel Dowel Pin 1/4" x 7/8" Long				14																			
125				91257A632				Hex Head Cap Screw 3/8 x 2" Long				6																			
126				91306A354				Zinc SBHCS 10-32 x 3/8" Long				32																			
127				90128A253				Zinc SHCS 1/4-20 x 2" Long				4																			
128				91306A383				Zinc SBHCS 1/4-20 x 1" Long				4																			
												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																			
												CHECKED																			
												ENG APPR.																			
												MFG APPR.						Q.A.						MATERIAL				TITLE:			
FINISH				SIZE C		DWG. NO. PC-2000				REV A																					
DO NOT SCALE DRAWING						SCALE: 1:2.5						SHEET 2 OF 5																			

F
E
D
C
B
A



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

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.

	NAME	DATE
DRAWN	KL	
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		

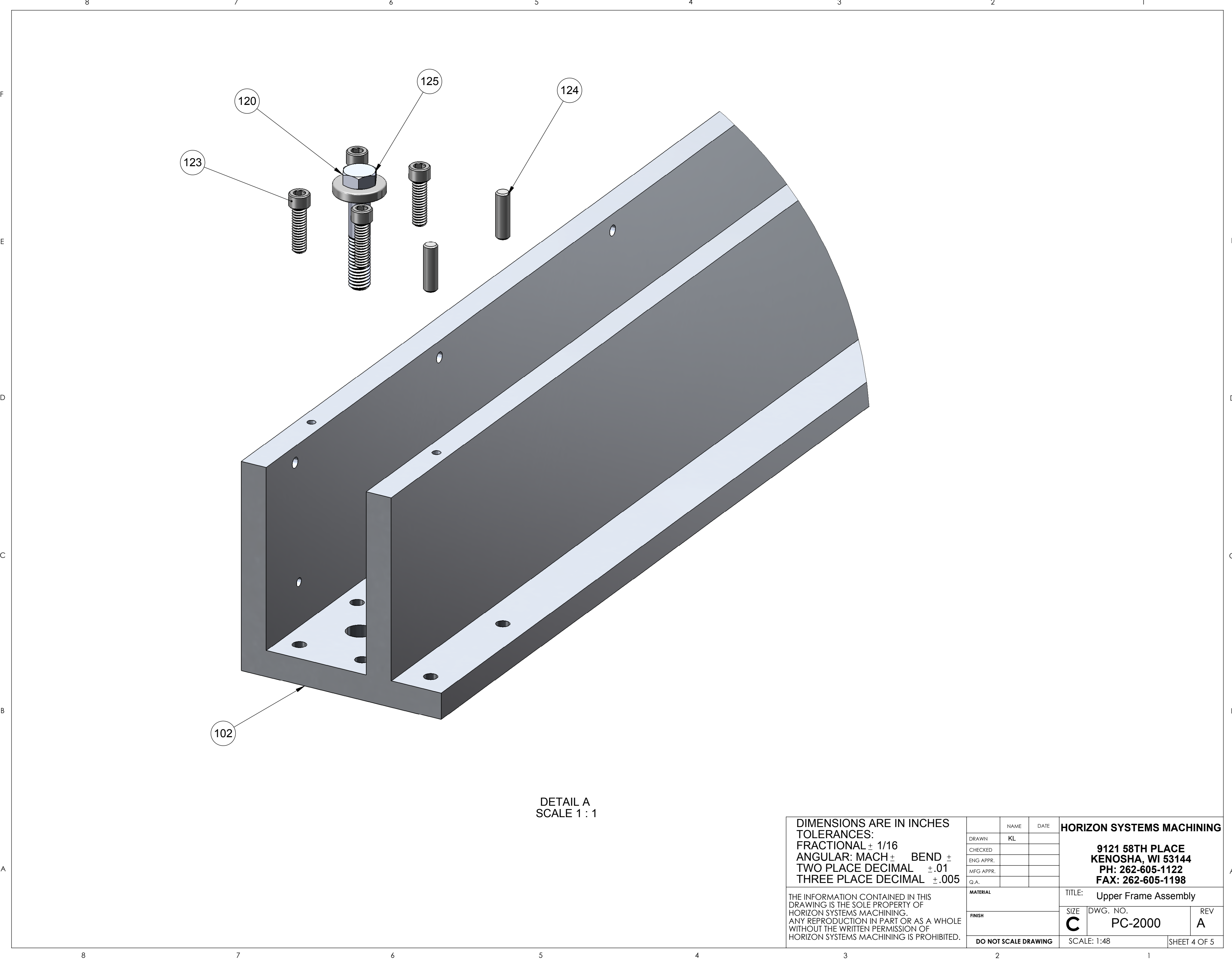
MATERIAL	
FINISH	
DO NOT SCALE DRAWING	

HORIZON SYSTEMS MACHINING

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

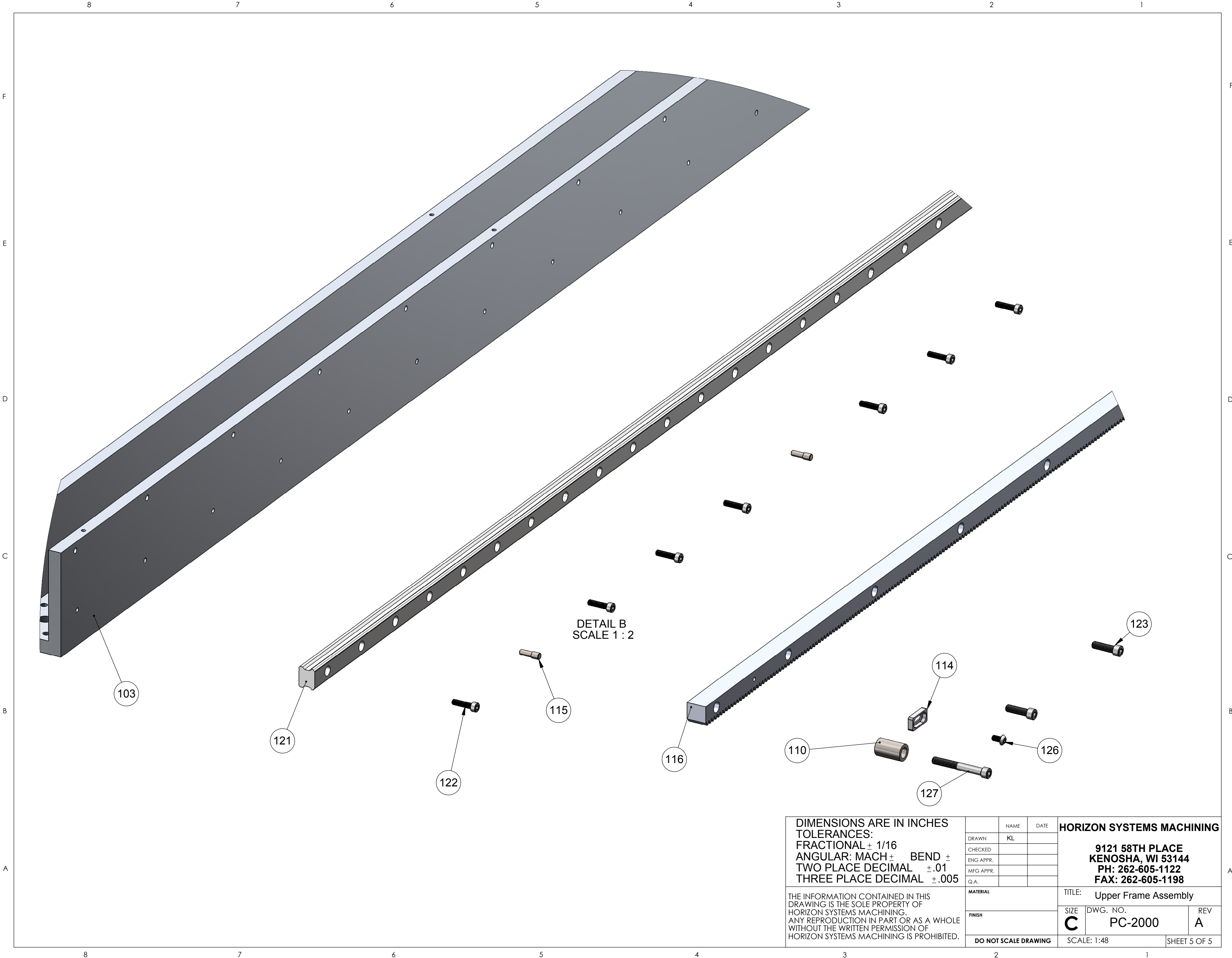
TITLE: Upper Frame Assembly		
SIZE C	DWG. NO. PC-2000	REV A
SCALE: 1:48		SHEET 3 OF 5

8 7 6 5 4 3 2 1



DETAIL A
SCALE 1 : 1

DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL $\pm 1/16$ ANGULAR: MACH \pm BEND \pm TWO PLACE DECIMAL $\pm .01$ THREE PLACE DECIMAL $\pm .005$				HORIZON SYSTEMS MACHINING		
				DRAWN	NAME	DATE
				CHECKED	KL	
				ENG APPR.		
				MFG APPR.		
				Q.A.		
				TITLE: Upper Frame Assembly		
				SIZE	DWG. NO.	REV
				C	PC-2000	A
				SCALE: 1:48		
				SHEET 4 OF 5		



DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL $\pm 1/16$ ANGULAR: MACH \pm BEND \pm TWO PLACE DECIMAL $\pm .01$ THREE PLACE DECIMAL $\pm .005$				HORIZON SYSTEMS MACHINING			
DRAWN		NAME	DATE	9121 58TH PLACE KENOSHA, WI 53144 PH: 262-605-1122 FAX: 262-605-1198			
CHECKED		KL					
ENG APPR.							
MFG APPR.							
Q.A.				TITLE: Upper Frame Assembly			
MATERIAL				SIZE	DWG. NO.	REV	
FINISH				C	PC-2000	A	
DO NOT SCALE DRAWING				SCALE: 1:48		SHEET 5 OF 5	