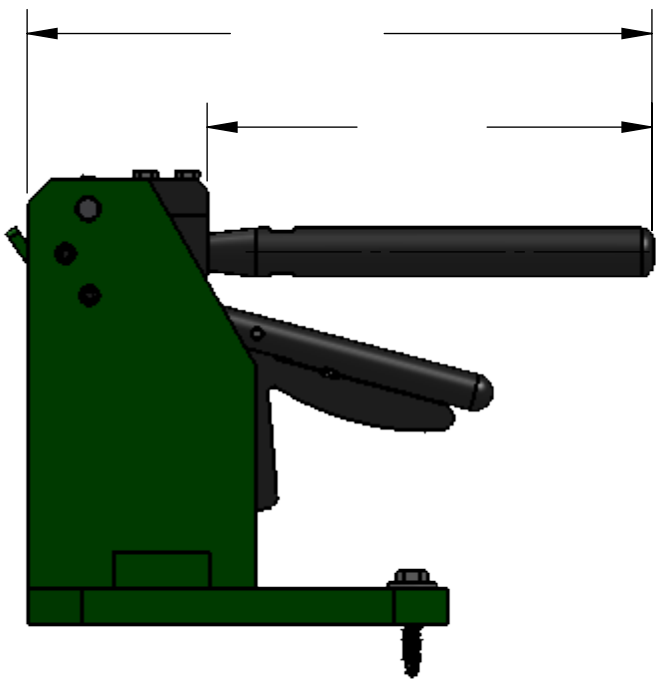
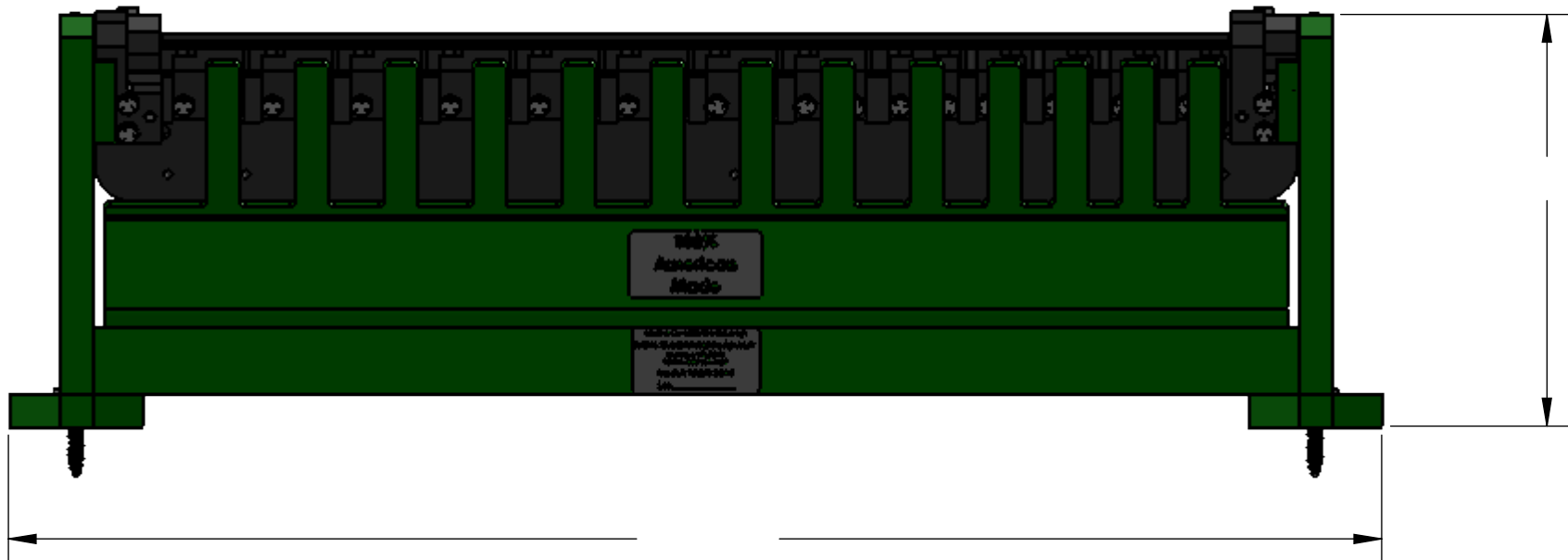
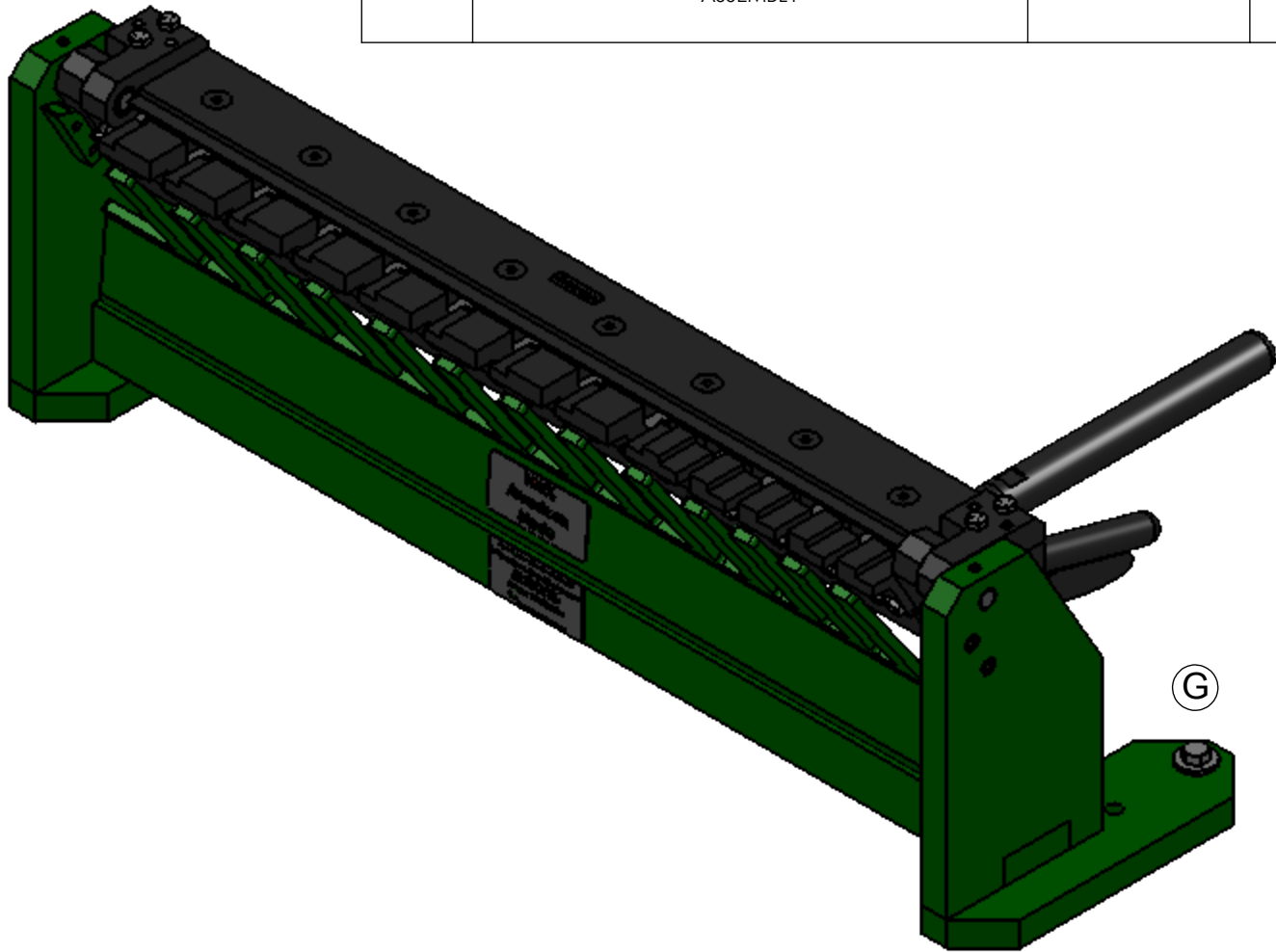
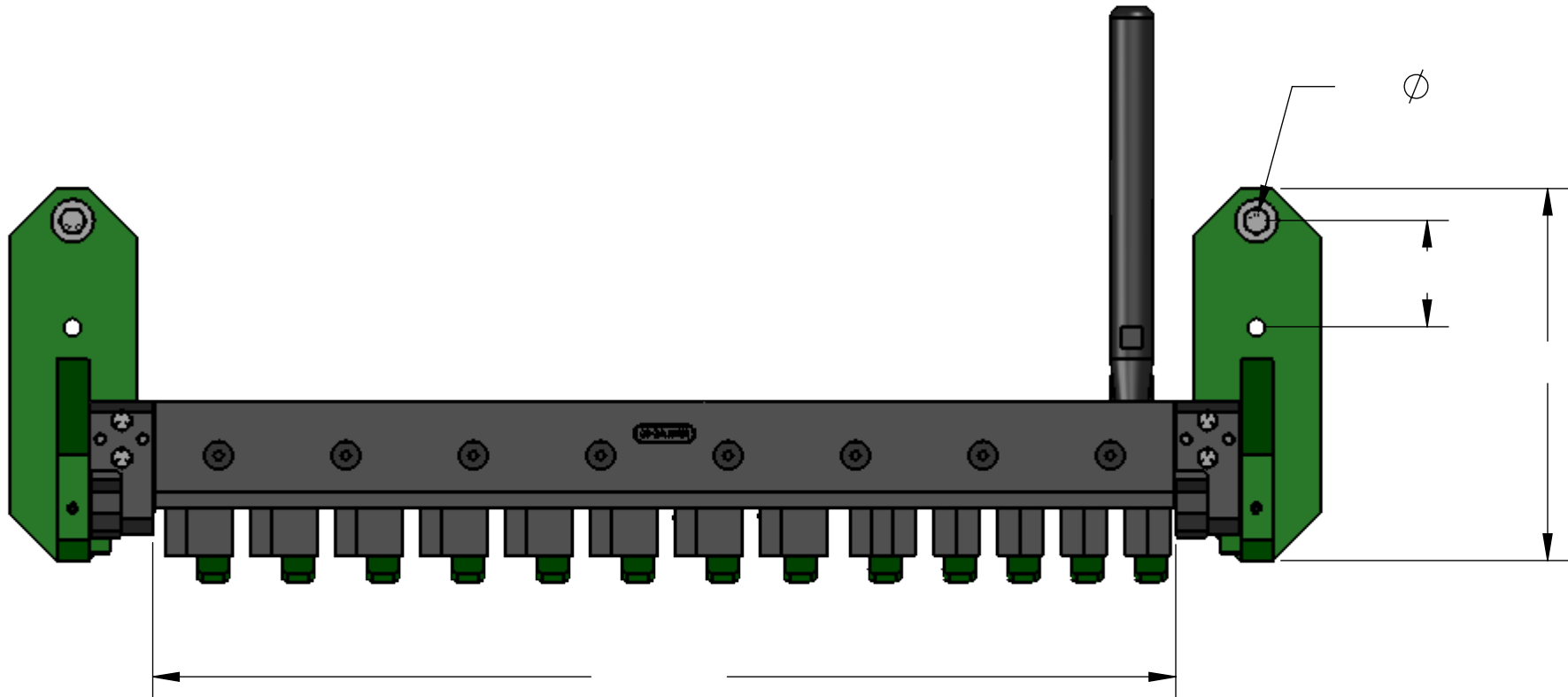


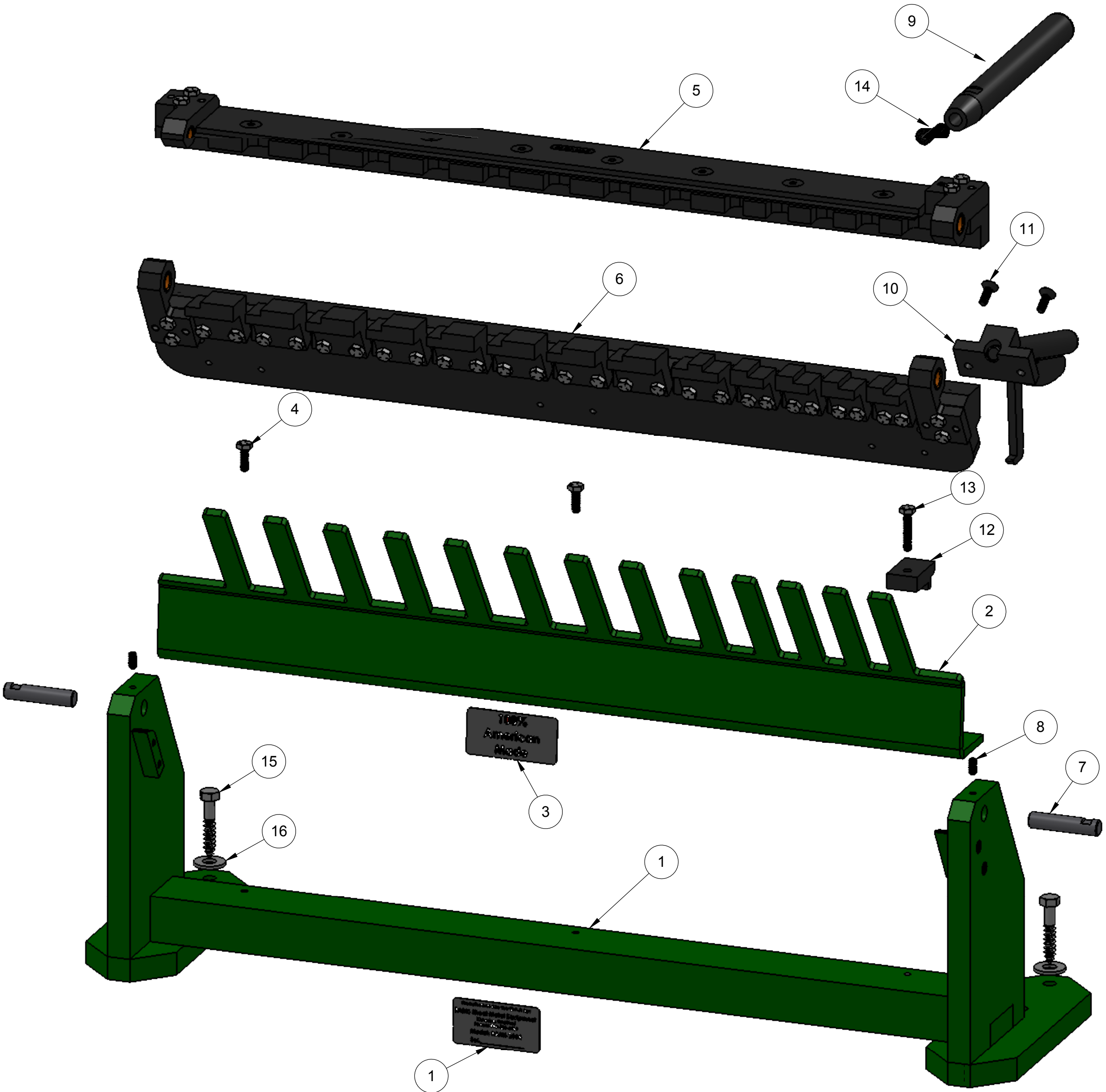
- (A)
- (B)
- (C)
- (D)
- (E)
- (F)

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	ADD FILLETS TO EXTRUDED HINGE COMPONENTS	4/3/2007	RAF
B	ADD 20GA. MAX LABEL AND ADD FRACTIONAL DIMENSIONS TO SHEET 1 VIEWS	5/31/2007	RAF
C	REMOVE 3 HOLES FROM MAIN BAR AND COMB AND DELETE 3 EACH OF CB-1033 HEX BOLTS	8/21/2007	RAF
D	ADDED LABELS TO BILL OF MATERIAL	12/11/2008	SSL
E	REMOVED (4) B88 & (2) B87 BUSHINGS. ADDED (4)B-812 BUSHINGS	6/5/2012	KL
F	UPDATED MAIN ASSEMBLY / ADDED SUB-ASSEMBLIES TO MAIN PRINT	9/4/2018	JK
G	ADDED SET SCREW ,WOOD SCREWS AND WASHERS TO ASSEMBLY	8/7/2019	JK



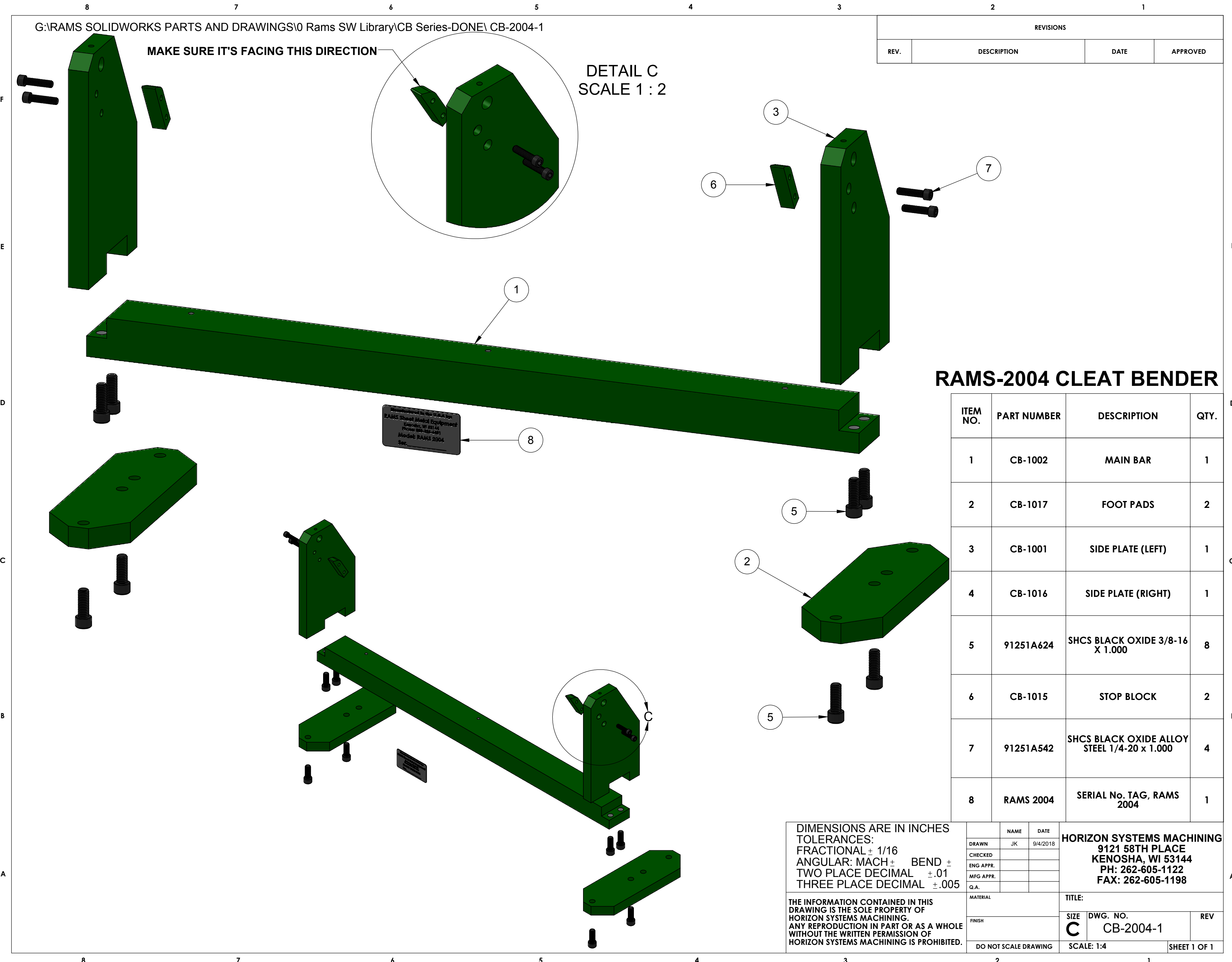
RAMS 2004 24" CLEAT BENDER

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	JK	9/4/2018			
	CHECKED					
	ENG APPR.					
	MFG APPR.					
	Q.A.					
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	FINISH			SIZE	DWG. NO.	REV
				C	RAMS-2004	G
	DO NOT SCALE DRAWING			SCALE: 1:4		SHEET 1 OF 2



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	CB-2004-1		1
	CB-1002	MAIN BAR	1
	CB-1017	FOOT PADS	2
	CB-1001	SIDE PLATE (LEFT)	1
	CB-1016	SIDE PLATE (RIGHT)	1
	91251A624	SHCS BLACK OXIDE 3/8-16 X 1.000	8
	CB-1015	STOP BLOCK	2
	91251A542	SHCS BLACK OXIDE ALLOY STEEL 1/4-20 x 1.000	4
	RAMS 2004	SERIAL No. TAG, RAMS 2004	1
2	CB-1029	COMB	1
3	Made in the USA	LABEL, MADE IN USA	1
4	92865A540	HHCS ZN 1/4-20 X 3/4	2
5	CB-2004-3		1
	CB-1004-DURA BAR	TOP LEAF PLATE	1
	CB-1026	BLADE	1
	91253A581	FHCS BLACK OXIDE 5/16-18 X 3/4	8
	CB-1008	TOP LEAF HINGE	2
	20 GA MAX	LABEL, 20 GA MAX	1
	92865A544	HHCS ZN 1/4-20 X 1.1/4	4
	98381A544	ALLOY STEEL DOWEL PIN 1/4 x 1-1/4	4
	B-812	BEARING: 1/2 ID X 11/16 OD X 3/4 WIDE	2
6	CB-2004-2		1
	CB-1034	LOWER LEAF EXTRUSION	1
	CB-1011	STEP BLOCK #3	8
	CB-1012	STOP BLOCK #2	1
	CB-1013	STEP BLOCK #1	4
	CB-1010	LOWER LEAF HINGE	2
	B-812	BEARING: 1/2 ID X 11/16 OD X 3/4 WIDE	2
	92865A542	HHCS ZN 1/4-20 X 1.00	26
	92865A540	HHCS ZN 1/4-20 X 3/4	4
	98381A540	ALLOY STEEL DOWEL PIN 1/4 X 3/4	4
7	CB-1014	SHAFT	2
8	91375A537	BLACK OXIDE CUP POINT SET SCREW 1/4-20 X 1/2	2
9	CB-1020	HANDLE	1
10	CB-2004-4		1
	CB-1022	LOWER HANDLE BLOCK	1
	CB-1021	LOWER HANDLE	1
	91375A535	BLACK OXIDE CUP POINT SET SCREW 1/4-20 X 3/8	1
	98381A540	ALLOY STEEL DOWEL PIN 1/4 X 3/4	1
	CB-1019	HANDLE LOCK	1
	LC-059E-05-M	LC-059E-05-M SPRING	1
11	91253A540	FHCS BLACK OXIDE 1/4-20 X 3/4	2
12	CB-1018	HANDLE BLOCK	1
13	92865A544	HHCS ZN 1/4-20 X 1.1/4	1
14	91375A718	BLACK OXIDE CUP POINT SET SCREW 1/2-13 X 1-3/4	1
15	91478A632	HEX HEAD SCREW ZN .375 X 2.00 FOR WOOD	2
16	90108A417	ZINC-PLATED STEEL USS FLAT WASHER 1.00 OD FOR .375 SCREW	2

NAME	DATE	HORIZON SYSTEMS MACHINING 9121 58TH PLACE KENOSHA, WI 53144 PH: 262-605-1122 FAX: 262-605-1198	
JK	9/4/2018		
MATERIAL		TITLE: RAMS-2004 CLEAT BENDER	
FINISH		SIZE C	DWG. NO. RAMS-2004
DO NOT SCALE DRAWING		SCALE: 1:8	REV G
		SHEET 2 OF 2	



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MAKE SURE IT'S FACING THIS DIRECTION

DETAIL C
SCALE 1 : 2

RAMS-2004 CLEAT BENDER

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	CB-1002	MAIN BAR	1
2	CB-1017	FOOT PADS	2
3	CB-1001	SIDE PLATE (LEFT)	1
4	CB-1016	SIDE PLATE (RIGHT)	1
5	91251A624	SHCS BLACK OXIDE 3/8-16 X 1.000	8
6	CB-1015	STOP BLOCK	2
7	91251A542	SHCS BLACK OXIDE ALLOY STEEL 1/4-20 x 1.000	4
8	RAMS 2004	SERIAL No. TAG, RAMS 2004	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	JK	9/4/2018			
	CHECKED					
	ENG APPR.					
	MFG APPR.					
	Q.A.					
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	FINISH			SIZE	DWG. NO.	REV
				C	CB-2004-1	
	DO NOT SCALE DRAWING			SCALE: 1:4		SHEET 1 OF 1

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	CB-1034	LOWER LEAF EXTRUSION	1
2	CB-1011	STEP BLOCK #3	8
3	CB-1012	STOP BLOCK #2	1
4	CB-1013	STEP BLOCK #1	4
5	CB-1010	LOWER LEAF HINGE	2
6	B-812	BEARING: 1/2 ID X 11/16 OD X 3/4 WIDE	2
7	92865A542	HHCS ZN 1/4-20 X 1.00	26
8	92865A540	HHCS ZN 1/4-20 X 3/4	4
9	98381A540	ALLOY STEEL DOWEL PIN 1/4 X 3/4	4

RAMS-2004 CLEAT BENDER

DIMENSIONS ARE IN INCHES

TOLERANCES:

FRACTIONAL ± 1/16

ANGULAR: MACH ± BEND ±

TWO PLACE DECIMAL ±.01

THREE PLACE DECIMAL ±.005

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	NAME	DATE
DRAWN	JK	9/4/2018
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		

TITLE:	
SIZE	DWG. NO.
C	CB-2004-2

SCALE: 1:4		REV

HORIZON SYSTEMS MACHINING

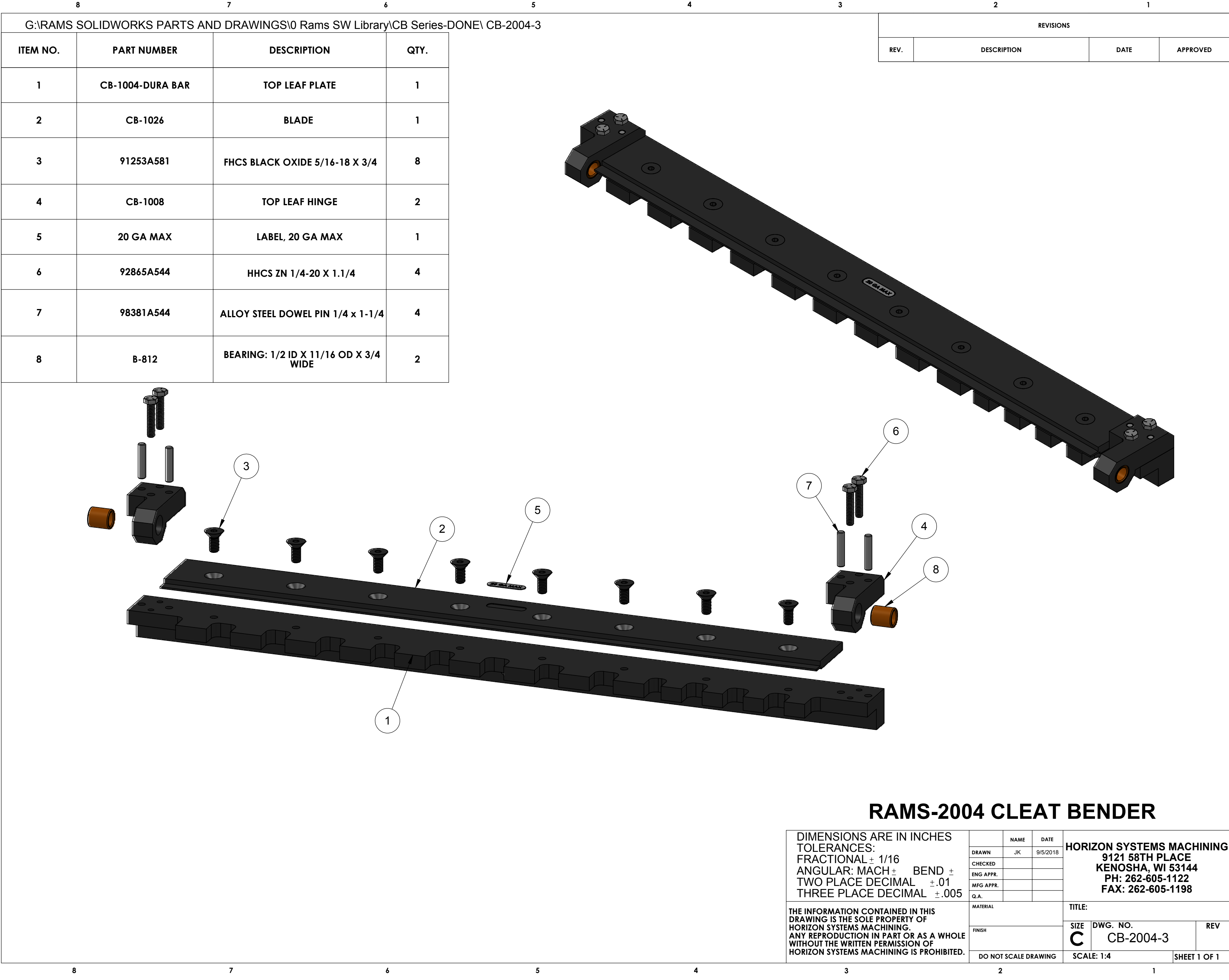
9121 58TH PLACE

KENOSHA, WI 53144

PH: 262-605-1122

FAX: 262-605-1198

SHEET 1 OF 1



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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	CB-1022	LOWER HANDLE BLOCK	1
2	CB-1021	LOWER HANDLE	1
3	91375A535	BLACK OXIDE CUP POINT SET SCREW 1/4-20 X 3/8	1
4	98381A540	ALLOY STEEL DOWEL PIN 1/4 X 3/4	1
5	CB-1019	HANDLE LOCK	1
6	LC-059E-05-M	LC-059E-05-M SPRING	1

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

RAMS-2004 CLEAT BENDER

DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± 1/16 ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ±.01 THREE PLACE DECIMAL ±.005			<table><tr><td></td><td>NAME</td><td>DATE</td></tr><tr><td>DRAWN</td><td>JK</td><td>9/5/2018</td></tr><tr><td>CHECKED</td><td></td><td></td></tr><tr><td>ENG APPR.</td><td></td><td></td></tr><tr><td>MFG APPR.</td><td></td><td></td></tr><tr><td>Q.A.</td><td></td><td></td></tr></table>		NAME	DATE	DRAWN	JK	9/5/2018	CHECKED			ENG APPR.			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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TITLE:																						
SIZE C	DWG. NO. CB-2004-4																					
REV																						
DO NOT SCALE DRAWING			SCALE: 1:2																			
			SHEET 1 OF 1																			