

Operating and Service Instructions for RAMS 2006

CAUTION:

Do not use a heavier gauge material than the machine was designed for.
RAMS 2006-Maximum 20 Gauge Mild Steel

OPERATION:

Place edge of material **SQUARELY** against entrance guide and slide forward (Right to Left) in a slow, steady motion. Keep material against guide fence at all times during the forming process, to ensure a consistently uniform Pittsburgh lock.

RAMS Sheet Metal Equipment, Inc. assumes no responsibility of liability for damage or injuries due to the misuse or misapplication of the machine. Always use proper precautionary safety measures when operating this, or any powered machinery. Read the following instructions carefully to familiarize yourself with the operational characteristics of this machine, before continuing.

ADJUSTMENT

It's **IMPORTANT** to note that **BOTH** bolts **MUST** be adjusted **EQUALLY**. Failure to do so could result in an improperly formed Pittsburgh lock.

1. This machine is factory set up to run 20 GA Mild Steel.
(Slight adjustments may be necessary.)
2. Tighten small adjusting bolts all the way down.
3. Tighten large adjusting bolts all the way down.
4. Back off small adjusting bolts 1/4 turn each.
5. Then back off large adjusting bolts 1/2 turn each.

6. This procedure should be adequate for all gauges of material. If slippage occurs, however, continue to tighten bolts equally in small increments until condition is rectified.

NOTE: Be careful not to over adjust studs, as curling and/or marring of material may result. Should this occur, simply loosen BOTH adjusting bolts a little

LUBRICATION OF RAMS 2006 (Weekly)

1. With unit unplugged, remove cover and lightly spray WD-40 on form rollers to help prevent surface rust.
2. Place Lubrimatic High Temperature Disc/Drum Brake Wheel Bearing Grease on gears.
3. Reinstall cover.

USE ONLY IDENTICAL REPLACEMENT PARTS! Refer to parts list in this manual when ordering. Include Model no. and Serial no. For replacement parts contact your dealer or RAMS Sheet Metal Equipment, Inc. 9031 58 th Place Kenosha, WI 53144 Ph: (262) 605-1122

SPECIFICATIONS-RAMS 2006

Capacity:

26 to 20 Gauge Material