



RAMS-2014 AUXILIARY MACHINE

WARNING :

- DO NOT OPERATE WITH TOP COVER OFF
- DO NOT OPERATE WITH SIDE PANELS OPEN
- DISCONNECT POWER SOURCE WHEN CHANGING ROLL SETS OR CLEARING METAL JAMS!

CAUTION :

Do not use heavier gauge steel than what the roll set states for maximum capacity!

RAMS 2014 AUXILIARY MACHINE IS DESIGNED TO RUN THE FOLLOWING:

<i>RAMS-AUX-1400</i> (6 in 1 Tap-In)	22ga MAX-26ga MIN
<i>RAMS-AUX-1600</i> (Acme Double Seam)	20ga MAX-26ga MIN
<i>RAMS-AUX-1800</i> (Drive Cleat)	20ga MAX-26ga MIN
<i>RAMS-AUX-2000</i> (Pittsburgh Lock *see below)	20ga MAX-28ga MIN
<i>RAMS-AUX-2100</i> (Male Button Lock)	20ga MAX-26ga MIN
<i>RAMS-AUX-2200</i> (Female Button Lock **see below)	20ga MAX-26ga MIN

*PITTSBURGH LOCK:

To install rollers for the Pittsburgh lock, you must first determine what gauge metal you will be using. There are separate sets of rolls provided that will be installed on the top 8th and top 9th roller stations. Use the set that is stamped 24-28 for corresponding gauge and use the set stamped 20-22 gauge accordingly. In addition to installing the correct rolls, you must also set the guide bars accordingly with the setting gauge provided by RAMS. Place the gauge against the face of the rollers for the selected metal capacity. While holding the gauge in place, tighten down guide bars firmly against the gauge. *(This may require two people to ensure gauge doesn't move while tightening down the guide bars.)*

**FEMALE BUTTON LOCK:

You must use the setting gauge provided by RAMS to set guide bars for the Female Button Lock. There are two separate settings on the gauge, one for 24-26 ga. and one for 20-22 ga. Place the gauge against the face of the rollers for the selected metal capacity. While holding the gauge in place, tighten down guide bars firmly against the gauge. *(This may require two people to ensure gauge doesn't move while tightening down the guide bars.)*

The Female Button Lock also requires the installation of three "forming blocks" that are bolted to the side plate (see illustrations). These blocks are for the Female Button Lock only and MUST be removed to produce a different profile.

OPERATION:

ROLL SET INSTALLATION:

1. Disconnect Machine from Power Source.
2. Remove top cover and open hinged side.
3. Select desired roll set.
4. Always wipe the shafts prior to installing a new roll set. Be sure the Roll Bores & Drive Shafts are clean and free of debris.
5. **CRITICAL: MAKE SURE ROLLS ARE IN THE PROPER NUMERIC ORDER!**
 - * The roll stations are always numbered in sequence. Station one starts from the power switch in sequence to opposite end of machine (see illustrations).
6. Slide both T1 & B1 rollers on simultaneously until they click into position and repeat for all roll set stations. (Note the MAX gauge capacity for the selected rolls.)
7. Change and set guide bars to correspond with the selected roll set.
8. Close hinged sides and replace top cover to operating positions
9. Re-establish Power Source.

TO CHANGE OUT ROLL SET:

1. REPEAT STEPS 1-4 above.
2. Depress quick release button on square drive shaft and remove the T1 & B1 rollers at the same time and repeat until all roll set stations are empty.
3. Repeat steps 5-9 above.

CLEARING A JAM:

1. Disconnect Machine from Power Source.
 2. Remove Top Cover by loosening side knobs
 3. Completely disengage the top four stabilizing bolts.
 4. Break free both quick jam release bolts and then loosen bolts **SIMULTANEOUSLY** by hand; the top plate will automatically lift from the bottom plate. (*Assist lift if necessary – use top cover knobs to help lift top plate. Never use anything to pry in between the plates, as this will damage the surface and cause misalignment.*) Once you have created enough space, clear the jam.
 5. Once jam is cleared, reverse process to return machine to original condition. (*Always check that gear teeth are properly aligned and fully meshing, prior to tightening the top plate back down. Simply rotate shaft to align the teeth, this will avoid damage to the machine, and prevent gear teeth from chipping.*)
- * See product video for demonstration(s) and more information.

MAINTENANCE:

It is critical to reduce build up to a minimum by performing the following:

1. Remove Top Cover.
2. Apply WD-40 or a De-Galvanized spray to forming rolls every 4 hours of operation.
3. Ensure roll bores and drive shafts are clean and free of debris.

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