

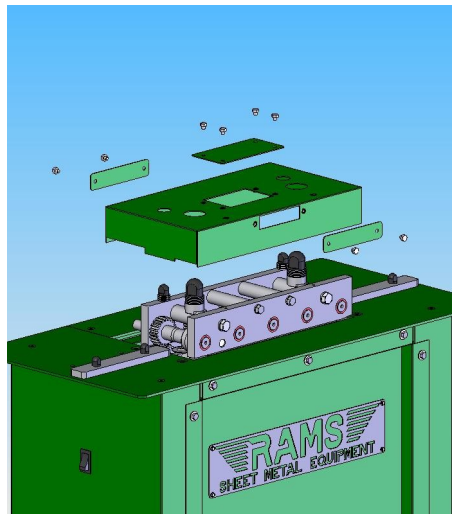


RAMS-2008 Power Flanger Attachment

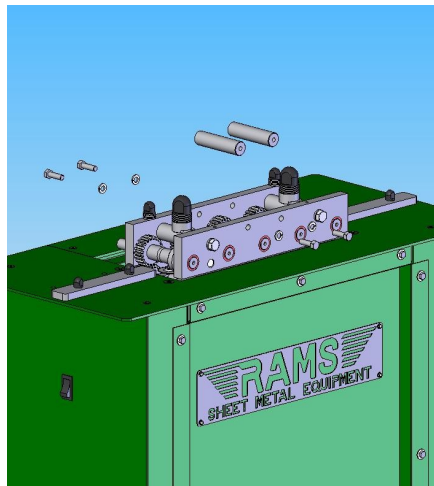
Capacity 20 Ga. Mild Steel Maximum

TO INSTALL POWER FLANGER ATTACHMENT:

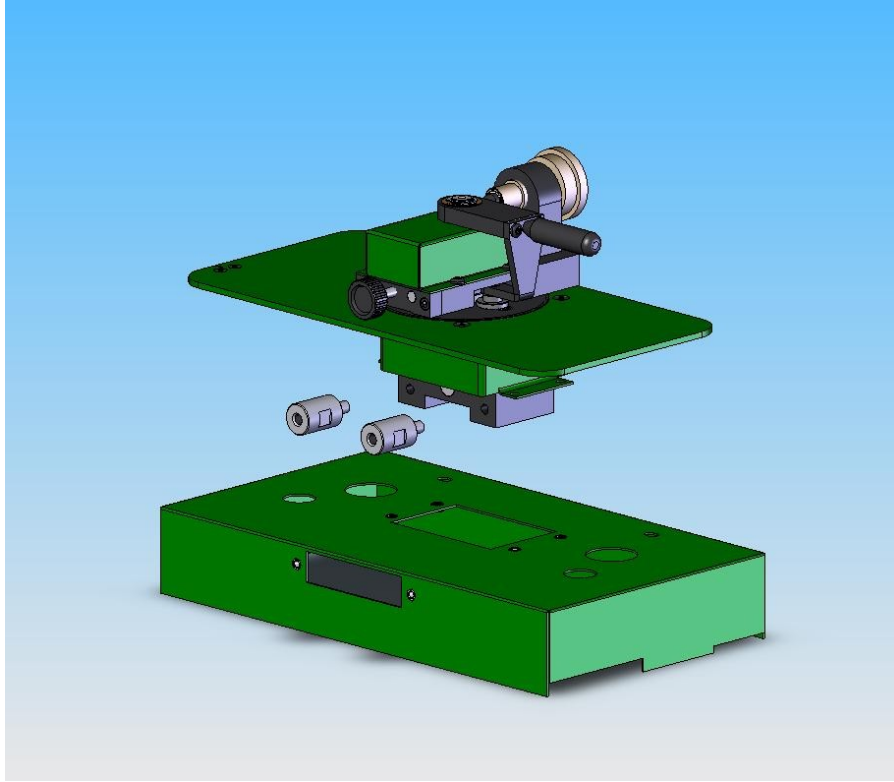
1. Remove attached cover.
2. Remove three access panels from top cover as shown.



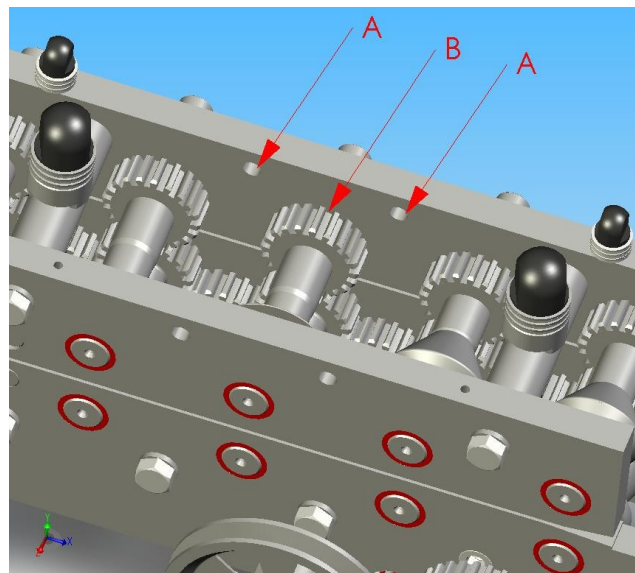
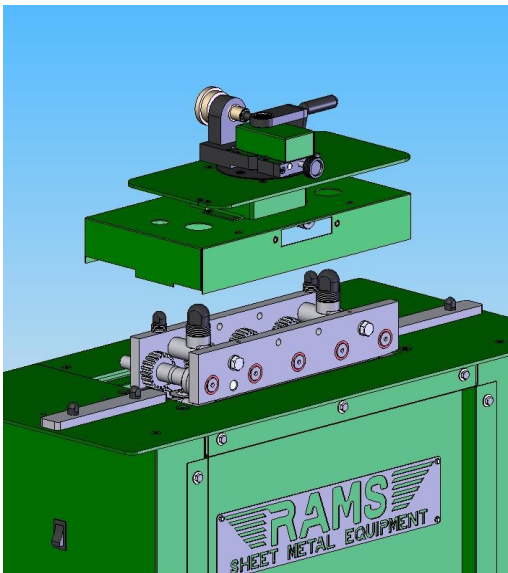
3. Remove the supplied 3/8-16 x 1-1/4" hex bolts and 3/8" lock washers. Make sure to keep these components, as they will be needed when fastening the power flanger.



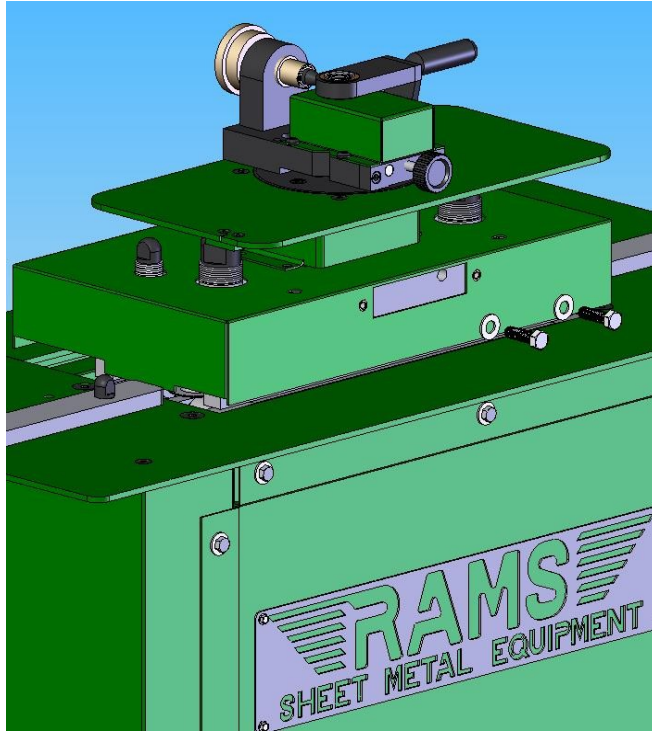
- Secure the standoffs to the RAMS 2008 Power Flanger, and slide unit into cover.



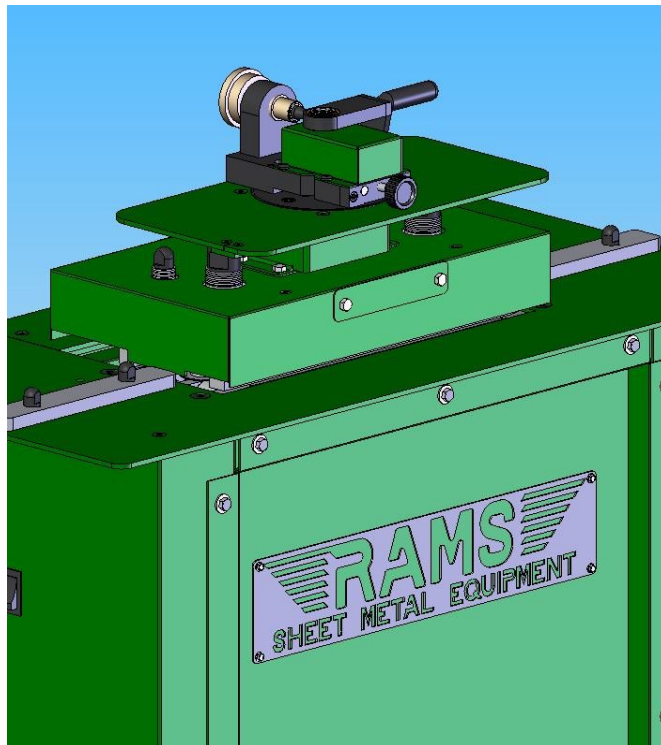
- Set the flanger attachment over the forming head so that the combination bevel and spur gear meshes with the Pittsburgh Lock roll (B). Use mounting holes (A).



- Secure the RAMS 2008 Power Flanger using the 3/8-16 x 1-1/4" hex head cap screws and lock washers described in item #2. Use mounting holes (A). (see picture on previous page)



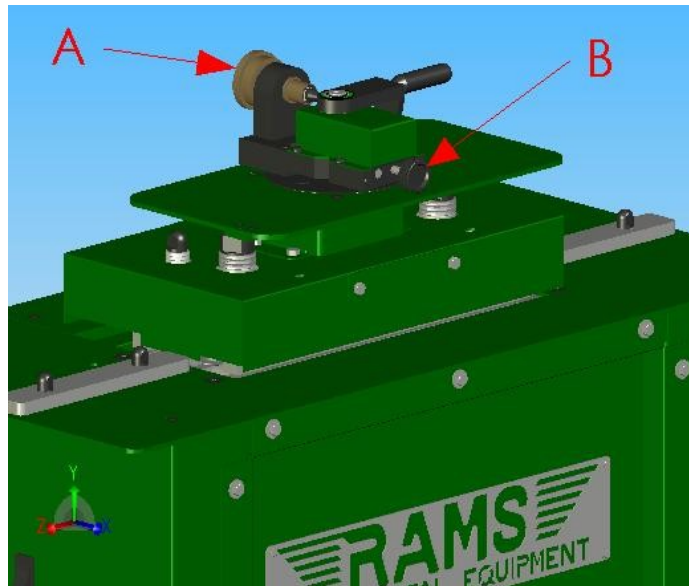
- Place the side access panels back on the top cover. Below is a view of completed installation.



TO OPERATE POWER FLANGER ATTACHMENT:

ADJUST UNIT FOR MATERIAL TO BE USED. To adjust the spring tension on the auto-guide arm (A), tighten or loosen to desired tension for material thickness. To adjust the clearance between flanger rolls, tighten the adjusting screw (B) on the front of the block of the machine all the way, then loosen the screw in approximately 1/8" increments to desired material thickness. Do not set front gauge adjusting screw too tight. It should be set just tight enough to draw the metal through the rolls. Too tight a setting will stretch and wrinkle the material. *See product video for more information.

TURN UP A "STARTER FLANGE" on the material edge by inserting it into slot located at edge of the table top. Bend material down towards table to form a "starter flange". Place material flat on table top edge and feed the starter flange into the rolls. As the material passes through the rolls, the auto-guide arm will make contact with the material and guide it through the rolls. If the material pulls out of the rolls, it is an indication that either the front adjusting screw is too loose or the back adjusting screw is not tight enough.



MAINTENANCE:

1. Keep rollers clean and free of galvanized deposits.
2. Occasionally spray rollers with WD-40.

FOR REPLACEMENT PARTS:

Please verify part number on our website and then call RAMS Sheet Metal Equipment at 262-925-8920.