



RAMS 2011-C & 2011-T

Capacity 16 Ga. Mild Steel Maximum
(See page 6 for 2011-T mounting instructions)

OPERATION:

Place edge of material against slotted entry guide bar and feed into cutting wheels while making sure material stays against the guide for entire length of material.

Note the following capacities chart for cutting various metals:

- | | | |
|--------------------|-------|------------|
| • Mild Steel | 16 ga | .0598" |
| • Galvanized Steel | 16 ga | .0635" |
| • Stainless Steel | 18 ga | .0480" |
| • Aluminum | | .0800" |
| • Copper | | .0800" |
| • Brass | | .0800" |
| • Truss Plates | 16 ga | .0635" |
| • Plastics | 16 ga | .109" MAX* |

*Bainbridge, Polystyrene, Polycarbonate, Polyethylene, Cellulose Acetate, PVC & Hi-Impact Styrene.

ADJUSTMENT:

Always disconnect power source prior to performing any maintenance or adjustments.

Machine is factory set and requires no adjustments. In the event that machine fails to make clean or complete cuts, refer to the following instructions to adjust top cutting wheel:

- 1) Remove Cover (eight standard bolts).
- 2) Loosen front cutting wheel nut.
- 3) Break rear nut loose.
- 4) Bump the blade forward (or outward) until top wheel touches bottom wheel.
- 5) Rotate middle nut accordingly until it touches the cutting wheel (blade).
- 6) Tighten the front nut while holding the middle nut in place with a wrench.
- 7) Then, tighten the back nut while holding the middle nut in place with a wrench.
- 8) The back nut locks the cutting wheel (blade) in place.

Refer to the following instructions in the event that the blades need to be changed or removed (refer to figures 1 - 4 on pages 4 & 5):

1) Cutter Removal

- a) Unplug or disconnect unit from power source.
- b) Remove the Top Cover by removing the eight bolts and pulling the cover forward. Gently lay cover off to the side. **Use caution to not cut the wires that come from the power switch.**
- c) Remove the Front Cover by removing the four bolts and pulling the cover down. It is not necessary to remove the Small Access cover.
- d) **Bottom Cutter is to be removed first.** To remove bottom cutter, loosen the one 1 3/4" Retaining Nut by holding the 3/4" wrench flat with a 3/4" wrench (See Figure 4). This is extremely important because by not holding this wrench flat it will cause damage to the worm gears. This may be a two-man operation.
- e) To remove Top Cutter, repeat step 1-d.
- f) In the event that the cutters do not slide off, it may be necessary to gently tap them using a soft mallet. **Cutters are hardened and will shatter if hit with a metal hammer.** Lightly tap evenly around the back of the cutter, paying attention to not hit the cutters edge.

2) Cutter Installation

- a) Install Top Cutter making sure that the hole in the cutter is aligned with the pin in the Collar. The Inner and Outer Adjusting Nuts should be backed off towards the black bearing housing. This will allow you to adjust the Cutter forward once the Bottom Cutter is installed. Install 1-3/4" Retaining Nut by hand. It is important to back off the Adjusting Nuts completely so when you install the Bottom Cutter it does not damage the Top Cutter.
- b) When installing Lower Cutter, make sure the hole in the cutter is aligned with the pin in the shaft. Install the nut by hand. It is extremely important to use the 3/4" wrench flat while you torque the 1-3/4" Retaining Nut to 80 ft/lbs. Failure to do so will cause damage to the worm gear. This may be a two-man operation. Visually check to see that there is some clearance between the Top and Bottom Cutters. Lower Cutter is now completely installed.
- c) With Lower Cutter secured back out 1 3/4" Retaining Nut and slowly rotate Outer Adjusting Nut until Upper Cutter is within .001 to .003" of Lower Cutter. It is extremely important to use the 3/4" wrench flat while you torque the 1-3/4" Retaining Nut down to 80 ft/lbs. Failure to do so will cause

damage to the worm gear. This may be a two man operation. Rotate Inner Adjusting Nut until it is in contact with the Outer Adjusting Nut and secure. The Upper Cutter is now completely installed.

- d) Install the Front Cover by sliding up until flush to top of table and install the four bolts.
- e) Install the Top Cover by reversing the removal process. **Use caution to not cut the wires that come from the power switch.**

MAINTENANCE:

- **Weekly**

1. Disconnect power from unit.
2. Using a small brush or compressed air (35 psi max) to remove metal debris.
3. With unit unplugged, gently wipe off Slide Rail to remove dust and debris, then lightly spray WD-40 or equivalent on Slide Rail and gently work back and forth.
4. Spray a soft rag lightly with WD-40 or equivalent and wipe down backgauge and table top.

- **Monthly**

1. Disconnect power from unit.
2. With top cover removed place Lubrimatic High Temperature Disc/Drum Brake Wheel Bearing Grease on gears in gearbox.
3. Inspect wires for cuts or insulation damage.
4. Reinstall cover.
5. Remove cabinet front cover (cabinet models only) and pulley cover.
6. Inspect belt for abnormal wear and tear.

FOR REPLACEMENT PARTS:

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

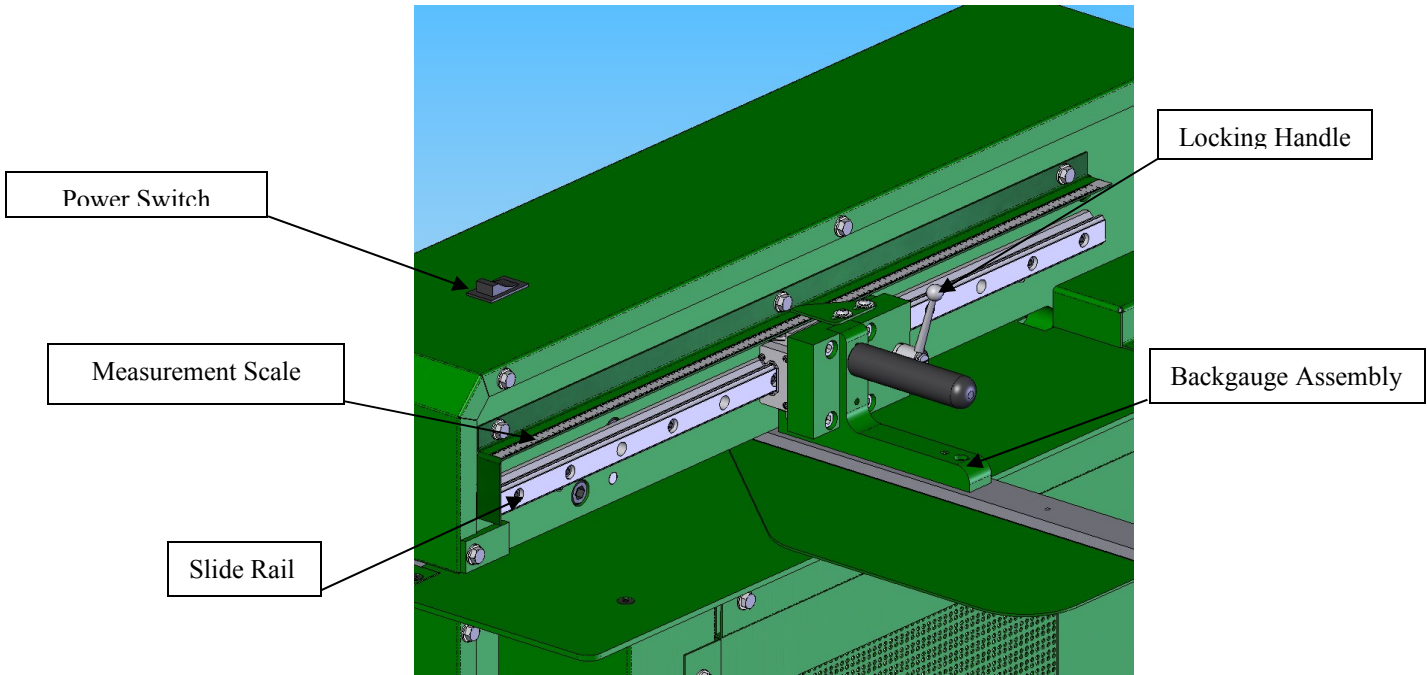


Figure 1

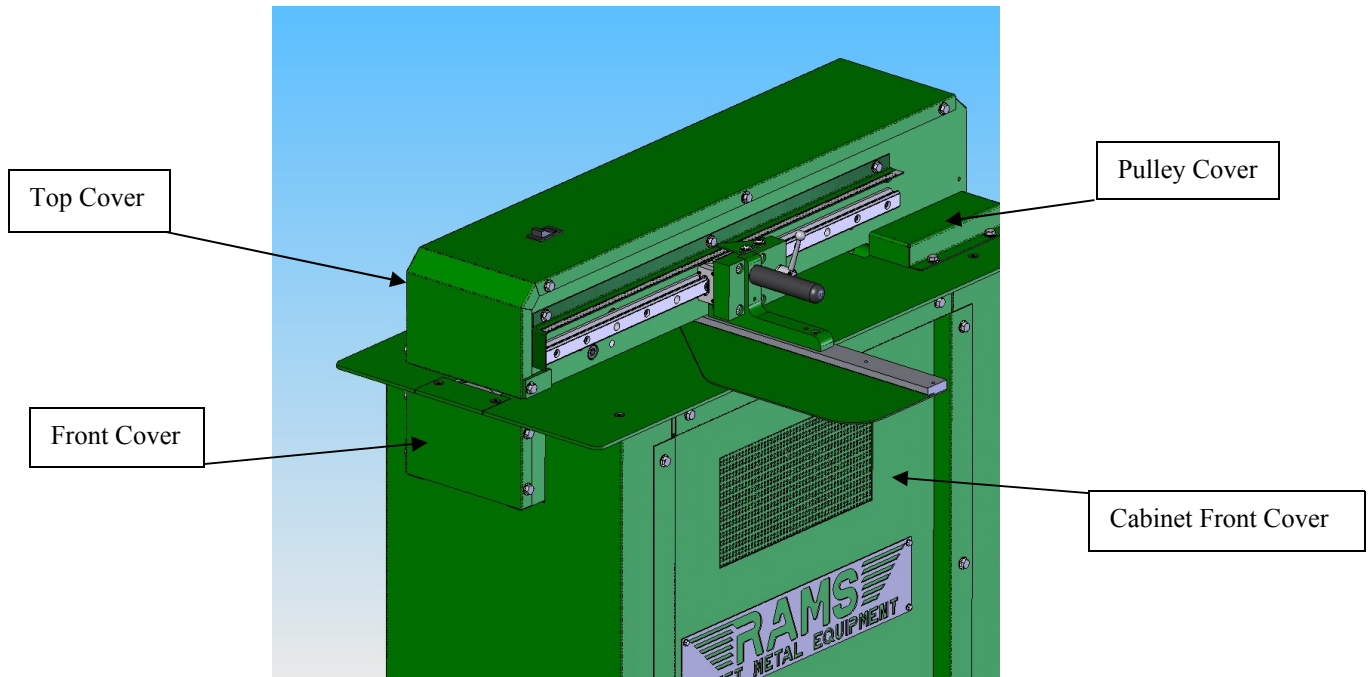


Figure 2

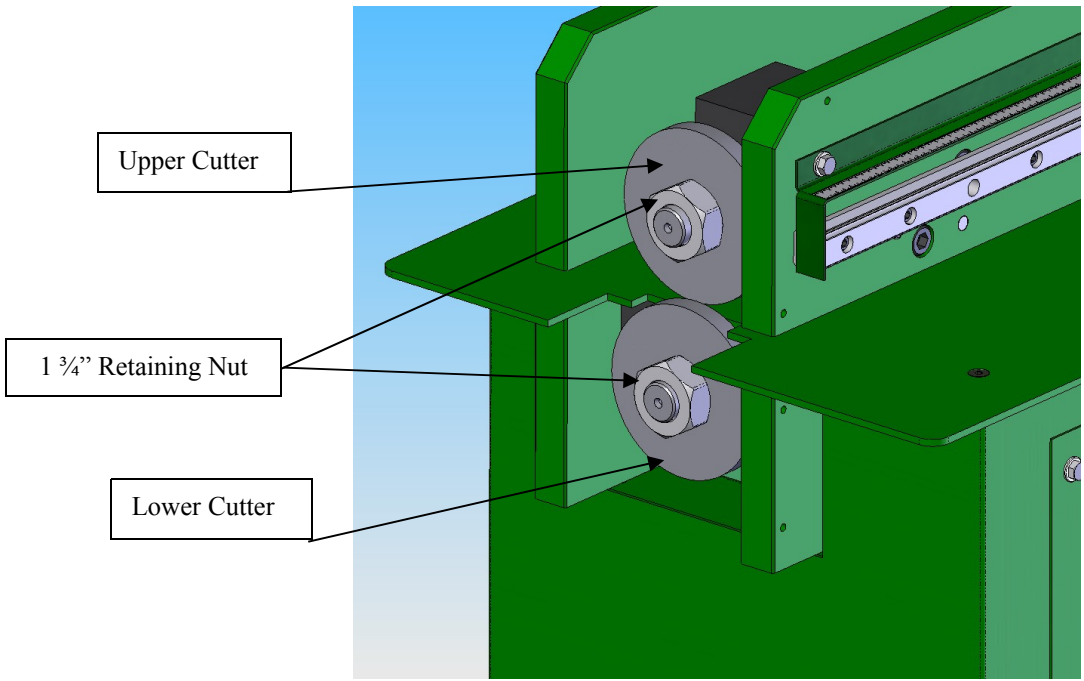


Figure 3

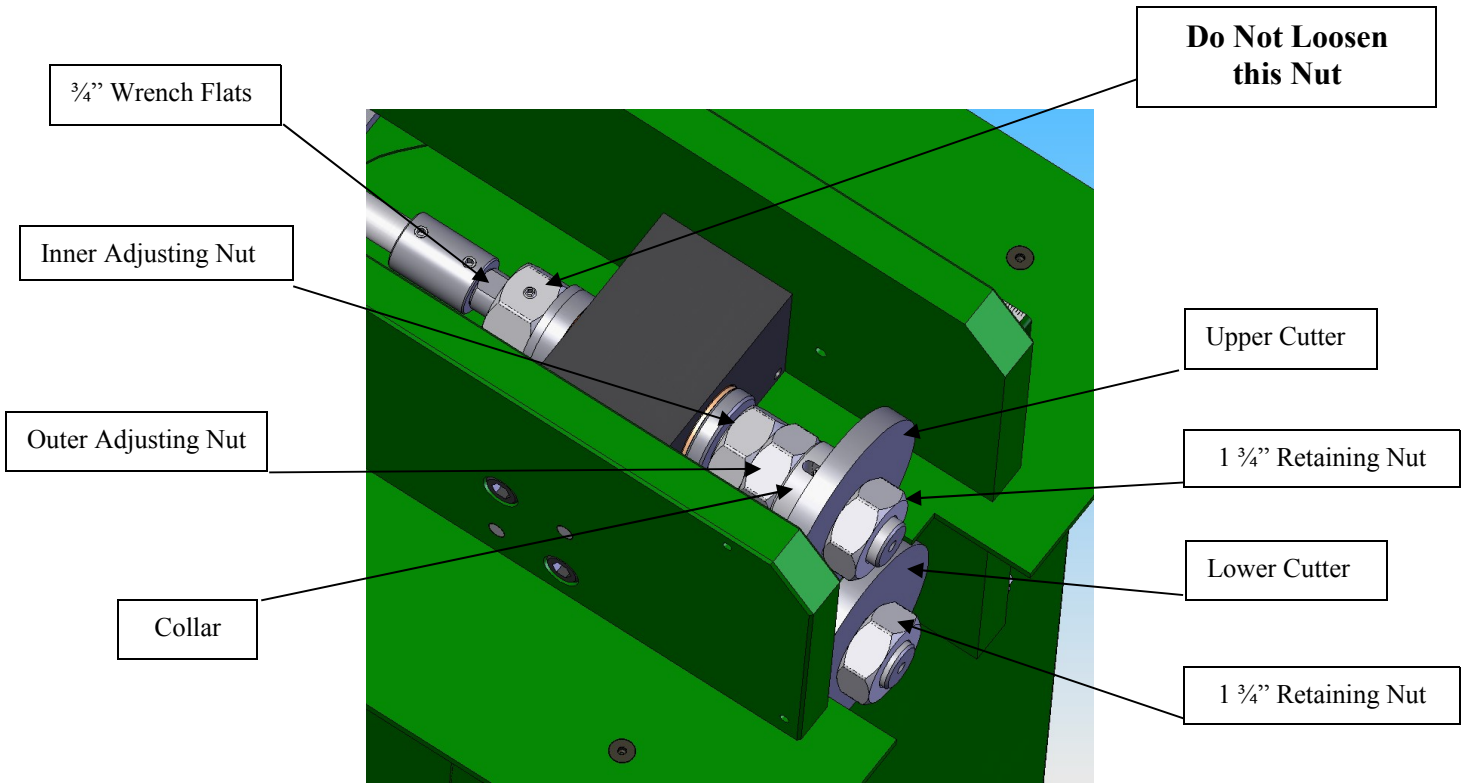
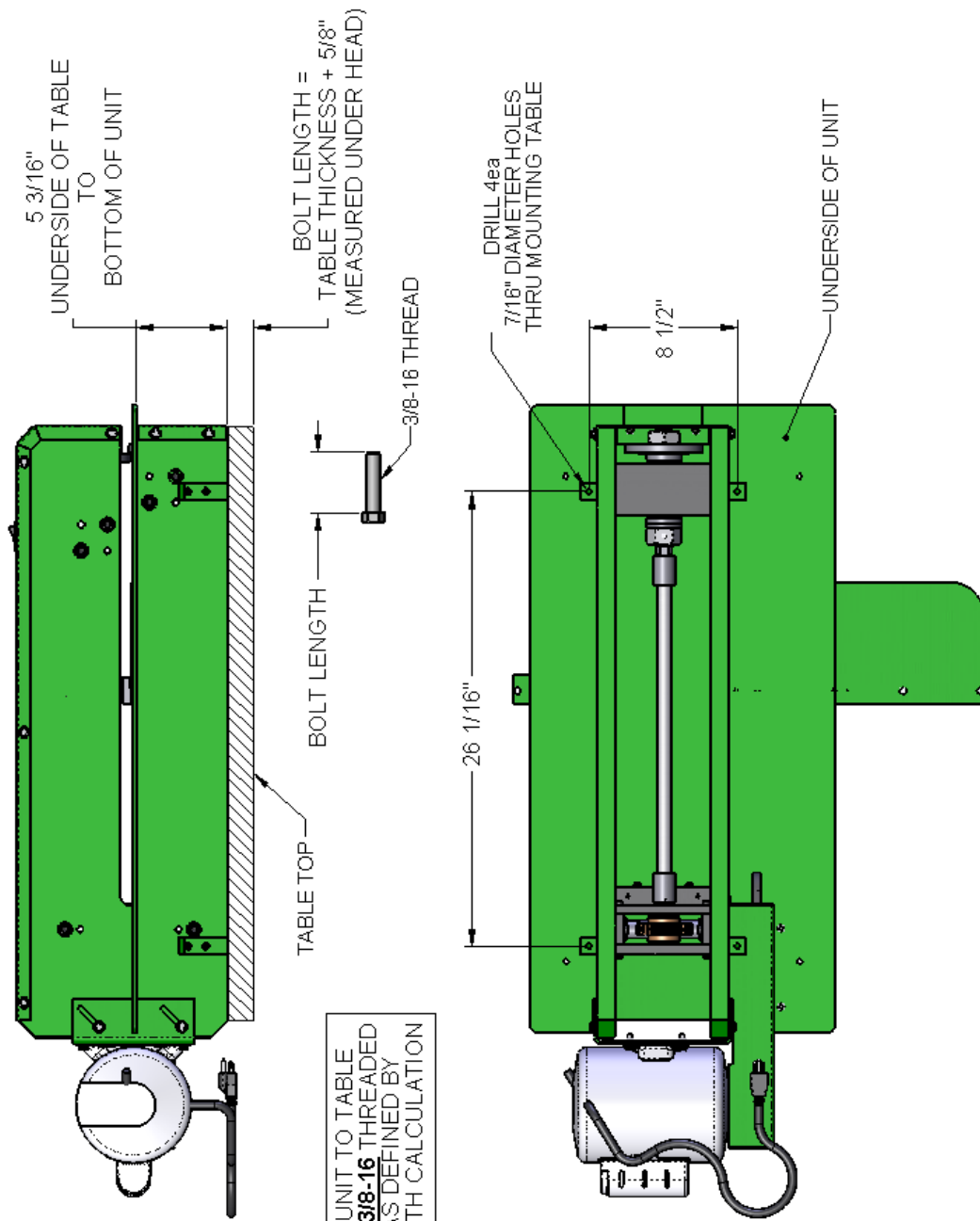


Figure 4

MOUNTING TO TABLE



SECURE UNIT TO TABLE
USING 4ea 3/8-16 THREADED
BOLTS AS DEFINED BY
BOLT LENGTH CALCULATION