

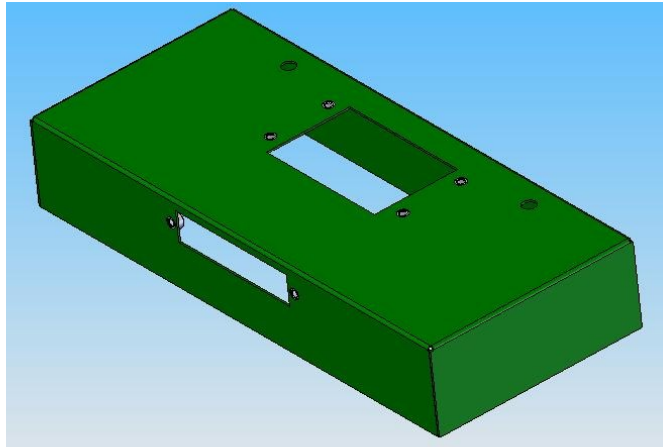


## RAMS-2003 POWER FLANGER ATTACHMENT

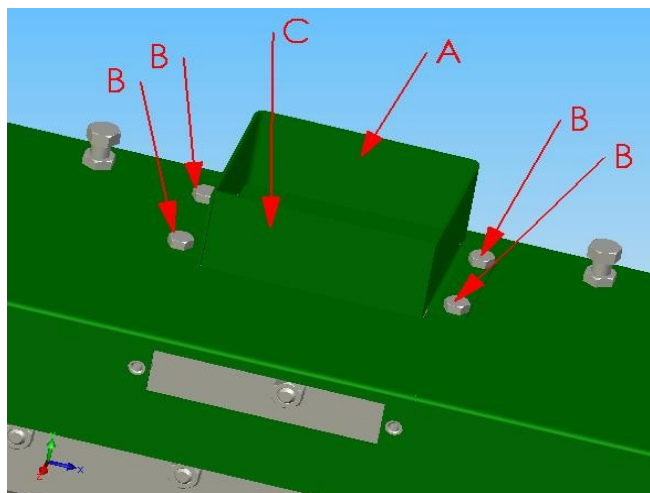
Capacity 24 Ga. Mild Steel Maximum

### TO INSTALL POWER FLANGER ATTACHMENT:

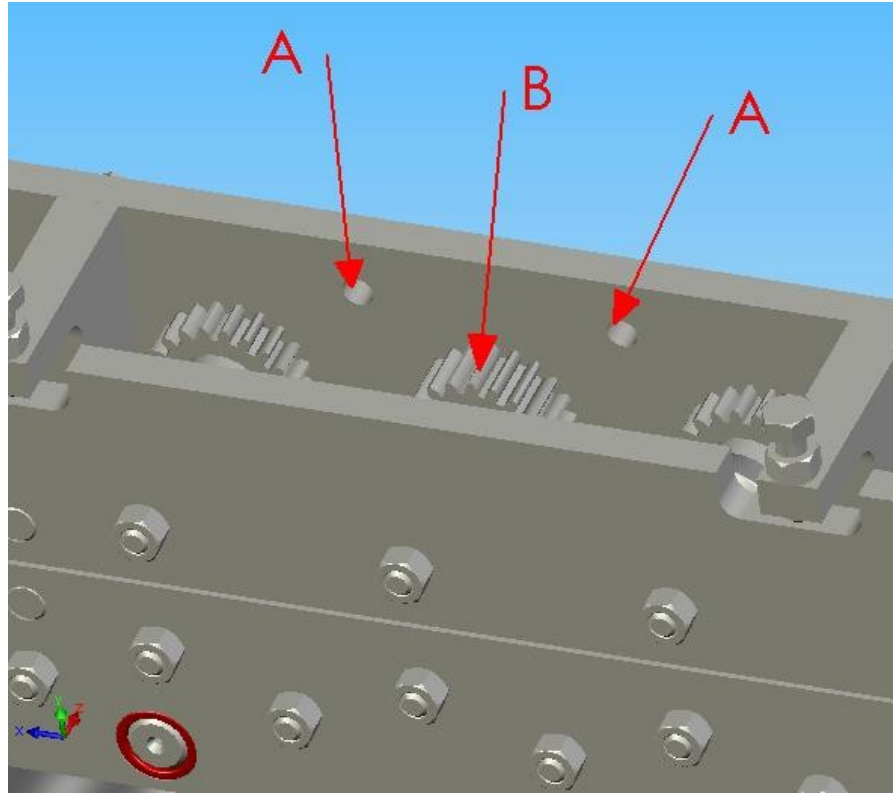
1. Leave cover attached. Remove two access panels from top cover as shown.



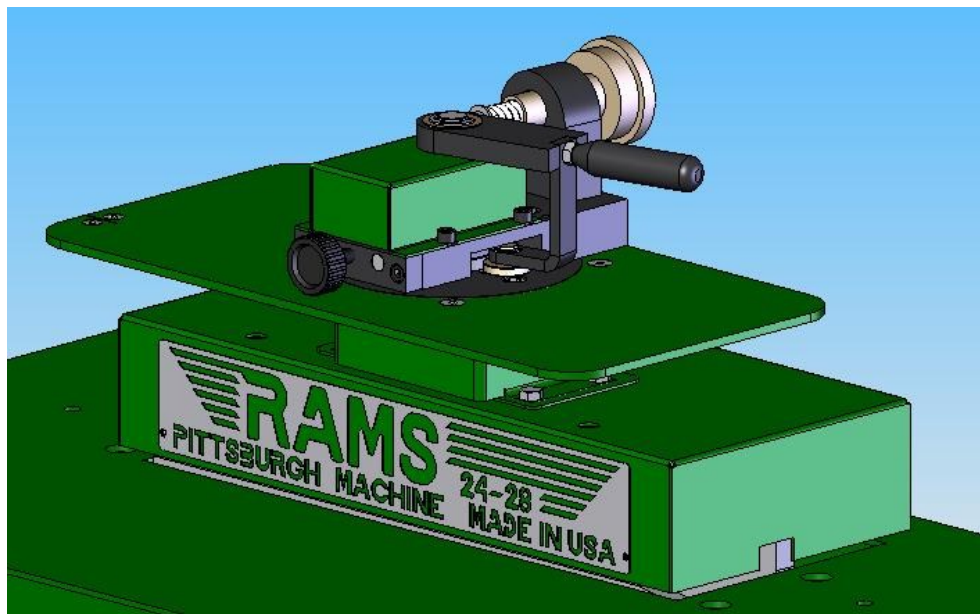
2. Install lower shroud of Power Flanger unit (A) using the four 1/4-20 x 1/2" long hex head screws. The back plate (C) should be inserted into the slots of the lower shroud.



- Set the flanging attachment over the forming head so the combination bevel and spur gear meshes with the Pittsburgh Lock roll No. 3. (B). Place the two 3/8" x 1-1/4" Hex-Head cap screws and lock washers into flanging attachment mounting holes (A) and tighten.



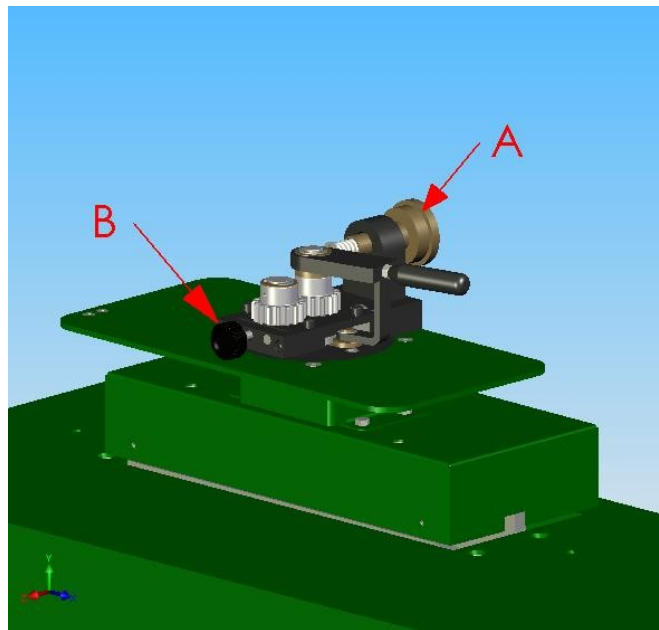
- View of completed installation.



## 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.