



## **RAMS-2006 PITTSBURGH MACHINE**

**Capacity 20 Ga. Mild Steel Maximum**

### **OPERATION:**

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

\*See product video for more information.

### **ADJUSTMENT:**

If adjustment is needed it's **IMPORTANT** to note that both adjusting bolts must be adjusted equally as specified below to form a proper Pittsburgh lock. Use the following factory settings:

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 full turn each.
5. Then back off large adjusting bolts 3/4 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.

**If your machine is equipped with auxiliary rolls, use guide bar factory settings below:**

Acme Rolls: Entrance guide bar setting 6-9/16" Exit guide bar 6-3/16" from the surface edge.

Drive Cleat Rolls: Entrance guide bar setting 7-9/16" Exit guide bar 7-1/16" from the surface edge.

Right Angle Rolls: Entrance guide bar setting 6-1/2" Exit guide bar 6-3/16" from the surface edge.

**MAINTENANCE:**

1. With unit unplugged, remove cover. On a weekly basis, lightly spray WD-40 on form rollers to help prevent surface rust.
2. Place high temperature grease on gears every 6 months.

**FOR REPLACEMENT PARTS:**

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