



# **RAMS-2019 Power Rotary Machine**

**Capacity 14a. Mild Steel Maximum**

**Maximum PSI operating pressure is 90 lbs. (Factory set at 80 lbs.)**

**\*\*Exceeding maximum operating pressure may rupture air-bellows\*\***

## **OPERATION:**

1. Adjust initial forming pressure by putting the speed selector switch to neutral.
2. Depress foot pedal switch, the rollers will compress together.
3. Adjust the pressure by Pulling out and rotating the air pressure adjustment switch to the desired setting.
4. The back gauge is now adjusted to the desired depth.
5. Select the desired speed and direction.
6. Place material to back gauge between rollers.
7. Depress the foot pedal to lower the top roller and to start roller rotation. Hold material to back gauge and use the necessary revolutions to complete the desired profile.

\*See product video for more information.

\*\* Time Delay and low speed adjustments can be made by Removing the lower unit side panel and referring to the “Frequency Drive” Instruction Manual

## **MAINTENANCE:**

1. Once a year: Remove back cover of Upper unit and Lightly grease Drive Gear with “High Temperature” LUBRIMATIC (Brand Name) Wheel Bearing Grease.

## **FOR REPLACEMENT PARTS:**

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

### Flanging Kit Installation and Operation

- To install the Flanging Kit, first determine the gauge of material you are working with and apply the proper spacer to the bottom shaft prior to putting on the bottom roller (See Chart).
- Once the rollers are installed, next you will determine the diameter of your part. Smaller nylon rollers are used for small diameters while the larger rollers are used for larger diameters.
- Next, set the back gauge to the desired flange size (Max 3/8") then put the material in between the rollers and bump against the back gauge. With the speed control in neutral, lower the top shaft on to the material and slide the nylon rollers up to the inside diameter of the tube and lock the rollers in place by tightening the nuts located on the back of the slotted back gauge.
- When determining your flange size, you will need to drop the nylon rollers slightly to accommodate the drop of the tube being flanged (during the flanging operation, the tube will drop down approximately 3/8").
- After the rolls and the back gauge are set up for operation, decrease the air pressure to 10psi. Start your operation in the "F1" or "R1" speed depending on your desired rotation direction.
- Continue running the part, slowly bring up the air pressure until you have established enough air pressure to create the flange.

PART NUMBER	DESCRIPTION	GA. THK
RAMS-PRM-FLA-7	.090 Thk Spacer	16 GA
RAMS-PRM-FLA-8	.100 Thk Spacer	18 GA
RAMS-PRM-FLA-9	.112 Thk Spacer	20 GA
RAMS-PRM-FLA-10	.124 Thk Spacer	22 GA
RAMS-PRM-FLA-11	.135 Thk Spacer	24 GA
**Note: No Spacer is for 14 GA Material		