



Rams 2600 Series Finger Brake/Shear Combos

Safety precautions - Must Read

Shear blades must be lubed with a spray lube or grease such as JB 80. They must be lubed at the start of each use and then several times during the hours of use. Do not raise the brake apron with the brake clamp in the up position. Keep hands clear of all moving parts at all times. Do not attempt to shear or brake beyond capacity. Injury or machine damage may occur if safety precautions are not followed.

Machine operation and instructions

The machine is automatically set up in shear/clamp mode upon startup. To operate in standard mode, use the up and down buttons to run the shear. To operate the apron, push the lower center button *one time*. After the center button has been pushed once, the machine has switched into apron mode with the up and down buttons now operating the apron. To exit from apron mode, simply push that same lower center button one time again and it is back in standard mode. To bend a pan, first bend two parallel sides to 90 degrees. Then, remove and/ or group the required fingers to be about a ½' smaller than the desired pan size. Next, clamp the area to be bent with the bent sides to the outside of the group of fingers. Finally, carefully bend the piece. Please take care to not over bend the piece and crush the corners. To use the optional radius bar, simply slip the bar over the clamp fingers and tighten the thumb screws to hold it in place. Then adjust the clamp head back so the front of the radius tube is 1/8" or more away from the brake base's front edge. To use the optional bend stop, first take a piece of sample material and bend it roughly to the size of the final desired bend. Before lowering the apron, make sure to loosen and move the angle stop until it touches the switch lever making a click noise. Lock the set screw and repeat the steps with another piece of sample material. Fine adjust as needed.

Machine maintenance and adjustments

Lube faces of shear blades with a heavy spray grease daily or more with constant use. Grease the shear blade slides every five days or daily with constant use. Change hydraulic fluid with Dextron type ATF annually. If brake doesn't clamp tight in middle, make sure to adjust the screw under bed at center or adjust clamp head down at center. If brake doesn't clamp tight at ends or all along bed, be sure to adjust wedge tubes on ends of brake.

Rams Sheet Metal Equipment, Inc.
77 McMillen Street Unit 105 Antioch, IL 60002
Phone: 224.788.9900
www.ramsequipment.com

BRAKE SHEAR COMBO UNIT ADJUSTMENTS

RAMS-2200 & RAMS-2600 SERIES



- A** Use adjustment “A” if the ends of the clamp head won’t close tightly and adjust “A” in. If the shear won’t open all the way adjust “A” out.
- B** If the clamp head isn’t clamping tightly in the middle, adjust the closest “B” adjuster tighter. “B” can be adjusted along with “E” to clamp more with the center of the brake.
- C** Adjustment “C” adjusts the outward bow of the apron. If “D” is adjusted “C” will most likely need to be readjusted.
- D** Adjustment “D” adjusts the upward bow of the apron. If the brake is bending with a larger radius in the center or is bending less in the center, tighten this adjustment along with “F”. Please note that an adjustment to “C” may be needed after adjusting “D”.
- E** Tightening adjustment “E” puts a downward and forward bow in the clamp head. Adjusting “E” will help the clamp head to clamp tighter in the center and to bend tighter in the center. “E” can be adjusted with “B” to clamp tighter in the center.
- F** Adjustment “F” puts a forward bow in the clamp head and if the brake is ending with a bigger radius in the center of the part or less in the center of the part more pressure is needed on adjustment “F”.
- H** Adjustment “G” adjusts the clamp head forward and backward. Adjust “G” to change the radius of the bend along the whole bend. Adjust “G” back for a bigger radius or forward for tighter. Also adjust “G” back to use the radius bar.
- G** Adjustment “H” pushes the shear blades tighter together. If the shear will cut lighter material clean but folds metal over with heavier stock, adjust the rods closest to where the material starts to fold over. Be sure to adjust equally from front to back. If it folds the material over towards the ends of the shear blades do not adjust “H”/ Too much pressure can cause blade damage. If the blades are dull, please sharpen blades. When cutting with the HD machine at capacity these may need to be tightened or loosened to back to where they were when the brake was being used.



For Tech Support : (763) 286-7725

