



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.