



## RAMS-2013 S & DRIVE MACHINE

Capacity 24 Ga. Flat Cleats and 22 Ga. Drive Cleats

### OPERATION:

1. Cut proper width of material. Use 3-5/8" wide material for S-Cleats and 2-1/8" wide material for Drive Cleats.  
*Note: make sure entry guides are set precisely to 3-5/8" for S-Cleats and 2-1/8" for Drive Cleats.*
2. Place appropriate width of material between S-Cleat or Drive Cleat entrance guide and feed material into the rolls. (It is recommended the material length is no longer than 5 feet.)  
\*See product video for more information.

### MAINTENANCE:

Due to galvanize build up that will collect on the rollers during operation, the following measures **must** be taken to ensure that the machine runs properly and produces an accurate form:

1. Remove Top Cover.
2. Apply WD-40 or a De-Galvanized spray to forming rolls every four hours of operation.

### FOR REPLACEMENT PARTS:

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