



V32/V42 RAM GUIDE FIELD INSTALLATION MANUAL

BACE ENGINEERING, 10/09/2023



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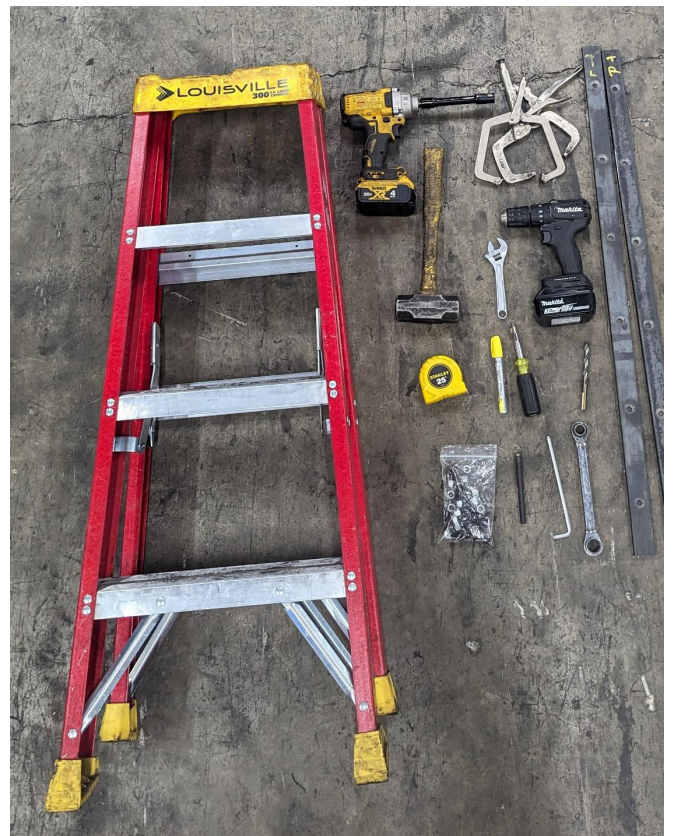
Provided Materials and Required Tools

Provided with Kit

- Ram Guide Kit: two pre-drilled flat bar and hardware kit [includes thirteen nuts/bolts]

Required Tools

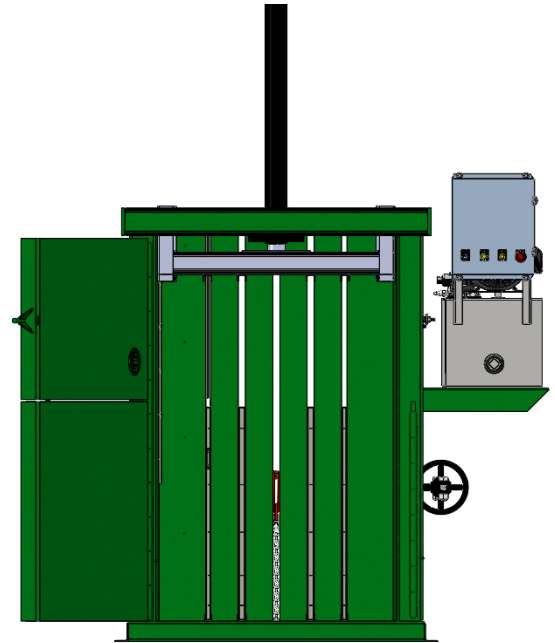
- Step Ladder
- Impact driver with 9/16" socket and extension
- 9/16" box or gear wrench
- Set of standard hex wrenches
- Two clamps
- Drill
- 3/8" drill bit
- 3/8" center punch
- Paint marker (helpful not required)
- Tape measure
- Hammer/mallet
- Phillips head screwdriver
- Adjustable wrench





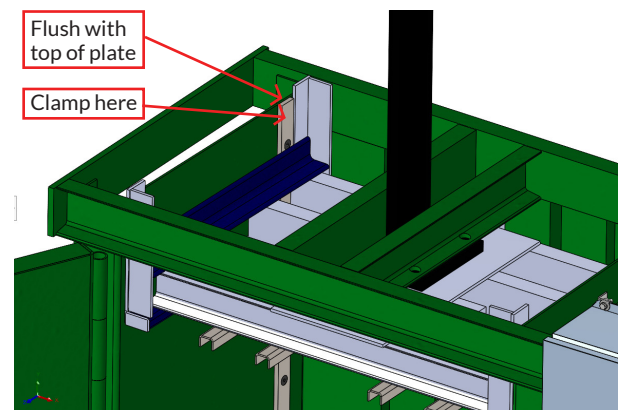
Lift the Ram, Turn The Machine Off

- With the doors closed, lift the ram and pull the emergency stop
- Turn the key to the “off” position
- Lockout/Tagout



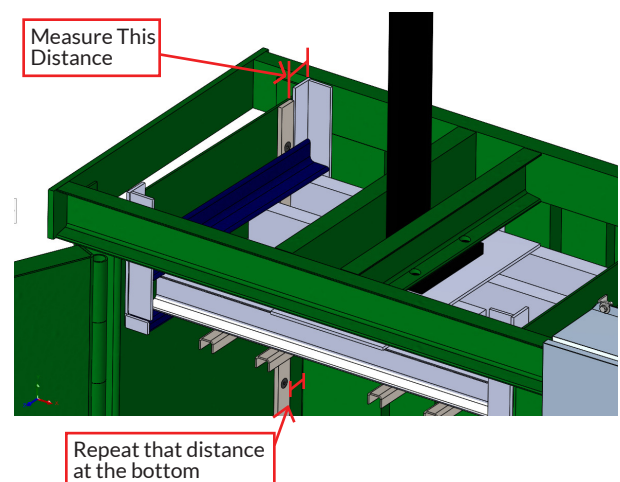
Insert and Clamp Both Guides

- With the presshead retracted, the key in the “off” position and both doors open, slide the flat bar down beside the UHMW
- The flat bar should fit between the UHMW of the presshead and the wipers inside of the bale chamber
- Clamp the flat bar to the Side Plate



Confirm Parallel To The Back Channel

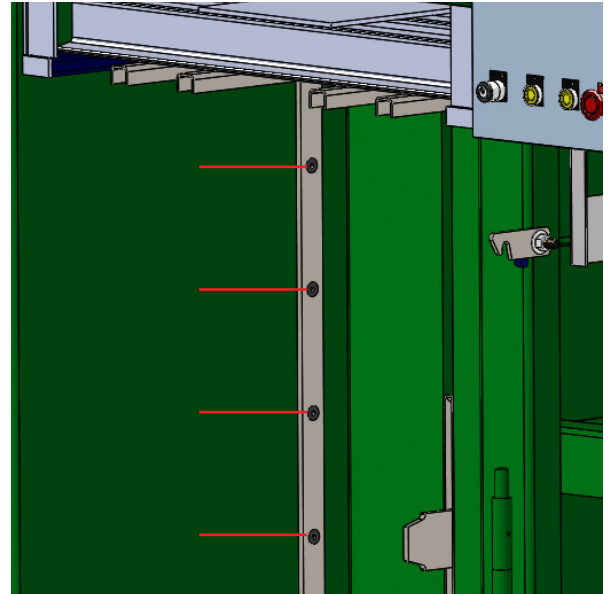
- Measure the distance from the back of the flat bar to the back channel
- Repeat this measurement at the bottom of the flat bar.





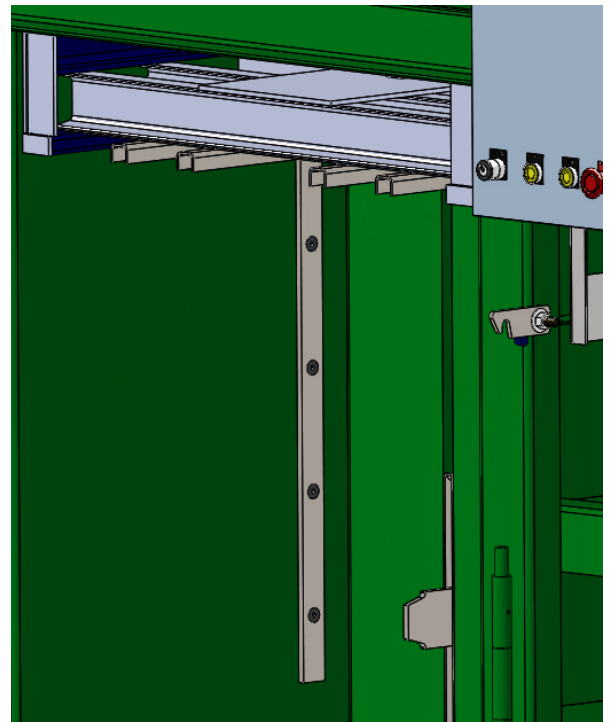
Mark and Center Punch The Bolt Holes

- With the flat bar in the proper location, use the paint marker to mark the Side Plate through the holes of the Flat Bar
 - The paint is not required but aids in finding the center punch hole if the flat bar was to move any during this process
- Once the paint dries, use Flat Bar as a guide to Center Punch the hole for the fasteners
- **DO NOT** move the presshead, or the flat bar



Drill The Bottom Holes and Install Fasteners

- Keep the flat bar in place, drill the bottom hole through the side plate
- Install and tighten the fastener before drilling any more holes
- Drill the remainder of the available holes, tighten the fasteners as you go
- Perform these steps for both sides
- **DO NOT** operate the presshead until complete





Power On, Lower The Presshead To Full Extension

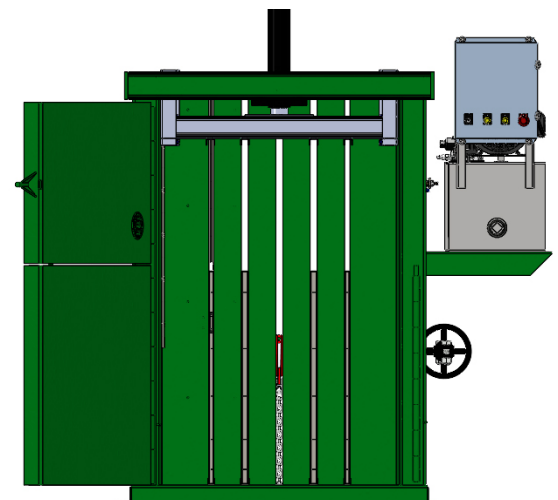
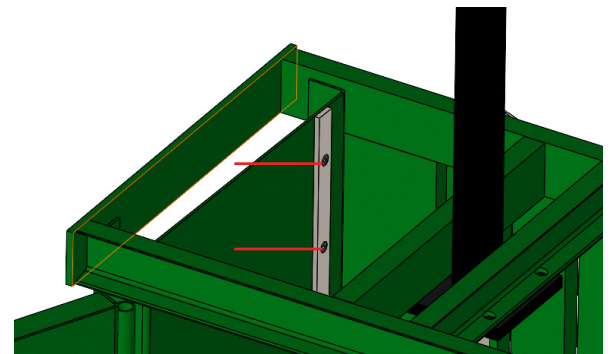
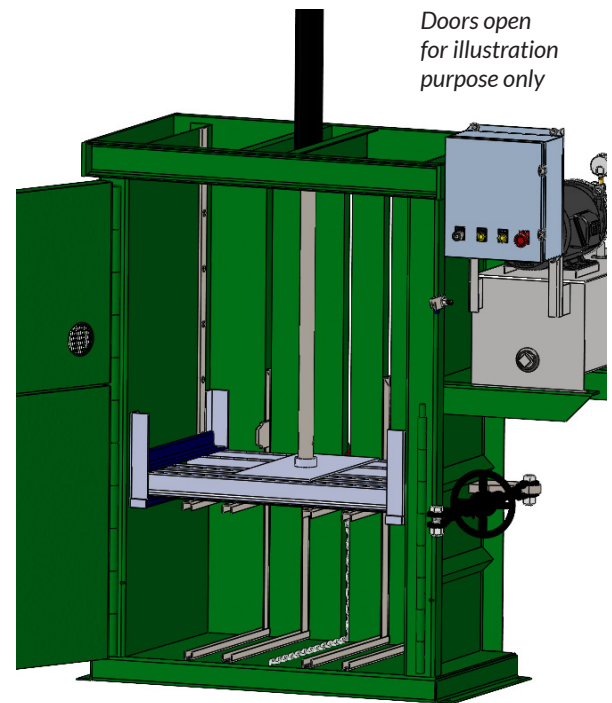
- Turn the power on, cycle the ram down to full extension
- Stop the ram at full extension with the Emergency Stop
- Turn off power to the machine

Perform The Mark And Drill Operation To The Top Two Holes

- Mark, center punch and drill the top two holes
- Add and tighten the fasteners
- **NOTE:** For the right side of the machine, the flag switch **MUST BE REMOVED BEFORE DRILLING**
 - Once the fasteners are installed on the right side, **REINSTALL THE FLAG SWITCH**

Cycle The Ram Several Times

- Cycle the ram several times with the doors closed
- Ensure that the ram does not strike the bottom door
- Ensure that the ram and guides are not binding
- Some squeaking may happen, this will ease as the wear pads wear in, grease where needed






Questions?

For questions please contact:

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