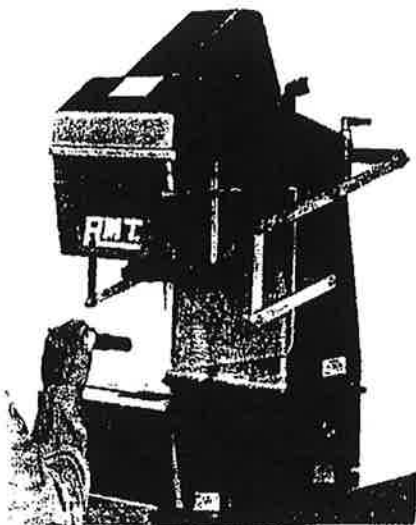


RMT AIR TOGGLE PRESS
MODELS 5B & 7B





RMT AIR TOGGLE PRESS

MODELS 5B AND 7B

INSTALLATION

If Foremost Machinery's optional Floor Stand, FS-ABC, was not purchased with the press, be sure to use a floor stand or workbench top that can support the machine's weight of 400 lbs.

Using the four flanges cast into the press body, securely bolt the machine to the floor stand or workbench with 1/2" bolts. The floor stand or workbench should be bolted to the floor or mounted on machinery vibration mounts.

To insure rapid response time and eliminate air pressure fluctuations, connect the air supply to the machine using a minimum of 1/2" I.D. hose. The rated tonnage of the press is achieved when the air pressure is set to 80 PSI. To insure reliable operation and long cylinder life, the air supply should be filtered and lubricated close to the press.

SET UP

An In-Line Shut-Off and Downline Exhaust Sleeve Valve is located at the air inlet to the press and should be moved to the 'Off' position before setting up. This allows the Link Arm-11 to be raised and lowered by hand which strokes the ram. RMT Air Toggle Presses have variable ram strokes from zero up to the maximum allowable for each model. The machines are shipped with the stroke preset to zero. When set at zero stroke, the Ram-7 is down and the Cylinder Adjusting Screw & Head-40 is completely inside the Cylinder Tube-31.

CAUTION - TO AVOID DAMAGING THE ADJUSTABLE STROKE AIR CYLINDER, THE STROKE ADJUSTING HANDWHEEL-48 SHOULD ONLY BE ROTATED AFTER AIR HAS BEEN EXHAUSTED FROM THE MACHINE!

By turning the Handwheel-48 counterclockwise, the Cylinder Adjusting Screw & Head-40 is screwed out of the Cylinder Tube-31. This allows the Piston Head-36 and Piston Rod-32 to retract further into the Cylinder Tube-31. As you turn the Handwheel, manually push the Link Arm-11 down, forcing the Piston Rod down as well. This will lift the Ram-7 up from the bottom. When the desired stroke length has been achieved, the die can be placed on the press bed.

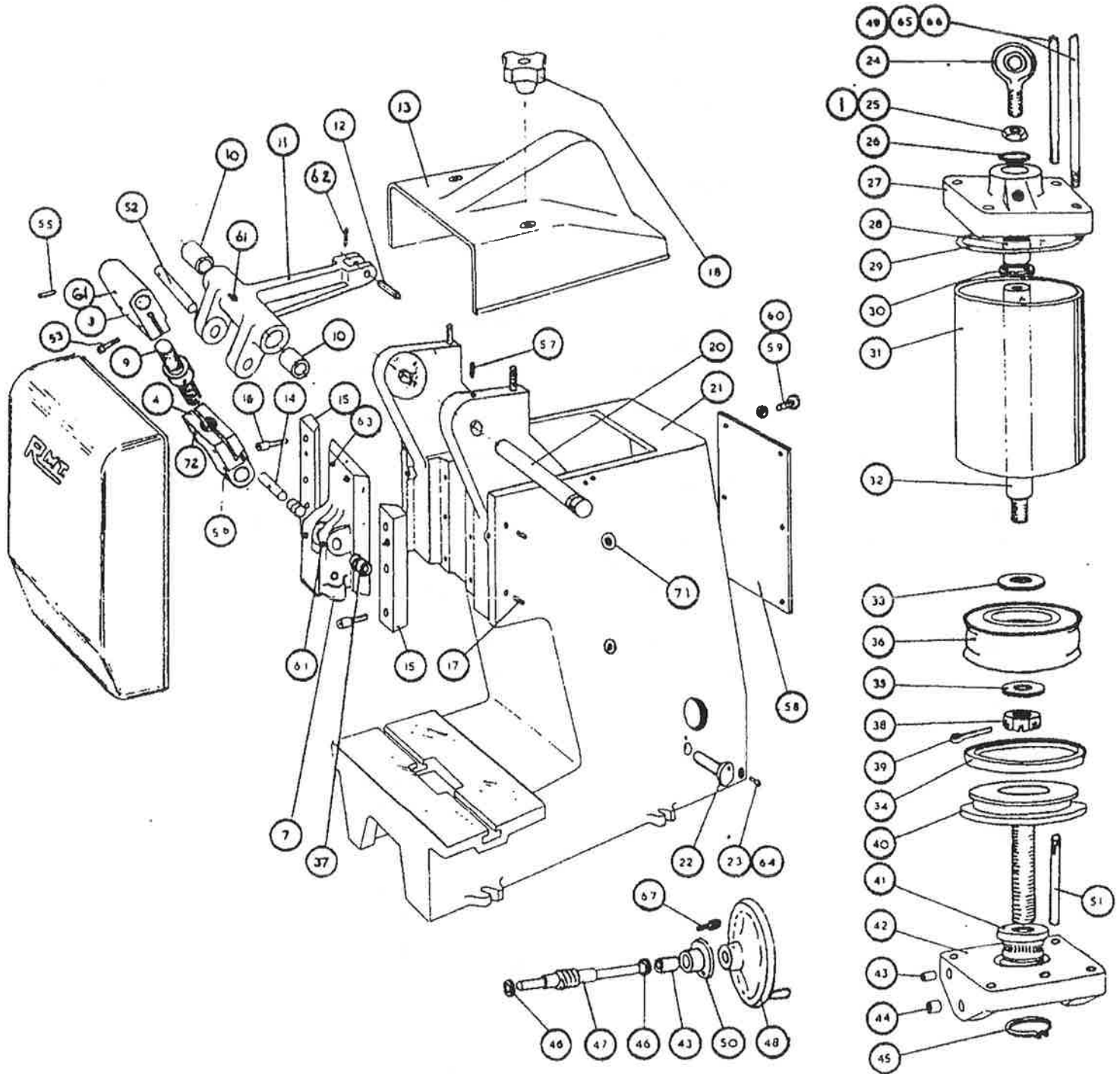
PARTS LIST

<u>ITEM</u>	<u>QTY</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
1	1	R2220/42	Tab Washer
3	1	R2197/B	Ram Link Clamp
4	1	R2198/B	Swivel Block
7	1	R2201F	Flange Style Ram
		R2201C	Clamp Style Ram
9	1	R2200/B	Ram Adjusting Screw
10	2	R2009/29	Bushing
11	1	R2195	5 Ton Link Arm
		R2216	7 Ton Link Arm
12	1	R2002/8	Cylinder Link Pin, .500" dia. X 2.500"
13	1	R5COV	Top Cover
14	1	R2199/1	Ram Pin, 1.000" dia. X 3.250"
15	2	R2002/1	Gib Strip
16	6		3/8-16 x 1-1/4 Lg. S.H.C.S.
17	4		5/16-18 x 1/2 Lg. Set Screw
18	2	R2002/10	Cover Knob
20	1	R2002/2	Pivot Pin, .750" dia. X 8.250"
21	1	R2003	Press Body
22	2	R2002/9	Trunnion Pin

<u>ITEM</u>	<u>QTY</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
23	2	R2090/30	2BA x 1/2 Lg. S.H.C.S.
24	1	R2220/25	Rod End
25	1	R2220/28	Lock Nut
26	1	R2220/16	Wiper Seal
27	1	R2001/1	Cylinder Head
28	1	R2220/17	Bushing
29	1	R2220/18	O Ring
30	1	R2220/19	Piston Rod Seal
31	1	R2001/11	Cylinder Tube
32	1	R2001/4	Piston Rod
33	2	R2220/30	Washer
34	1	R2220/21	Piston Seal
36	1	R2220/15	Piston Head
37	2	R2217/12	Bushing
38	1	R2220/27	Slotted Nut
39	1	R2220/26	5/32 x 1-1/2 Lg. Cotter Pin
40	1	R2001/3/5	Cylinder Adjusting Screw & Head
41	1	R2006/1	Worm Nut
42	1	R2001/2	Cylinder Rear End
43	2	R2001/22	Bushing
44	1	R2220/23	Bushing
45	1	R2220/33	Snap Ring
46	2	R2001/12	Thrust Washer
47	1	R2006/2	Worm Shaft
48	1	R2220/34	Handwheel
49	4	R2001/7	Tie Rod
50	1	R2001/8	Sleeve
51	1	R2001/6	Stay Bar
52	1	R2199/3	Link Pin, .750" dia. X 4.625"
53	2	R2217/14	3/8-16 x 2 Lg. S.H.C.S.
55	1		1/8 dia. x 1-1/2 Lg. Roll Pin
56	2		1/4-20 x 1/4 Lg. Set Screw
57	2		5/16-18 x 1/2 Lg. Set Screw
58	1		Back Plate
59	6	R2090/30	2BA x 1/2 Lg. S.H.C.S.
60	6		2BA Lock Washer
61	8	R2217/17	Straight Grease Fitting
62	1		1/8 dia. x 1 Lg. Roll Pin
63	2	R2217/18	Angled Grease Fitting
64	2		2BA Lock Washer
65	4		3/8-24 Nyloc Nut
66	4		3/8 Washer
67	2		2BA x 3/8 Lg. S.H.C.S.
71	1	R2001/22	Bushing

RMT AIR TOGGLE PRESS

MODELS 5B & 7B



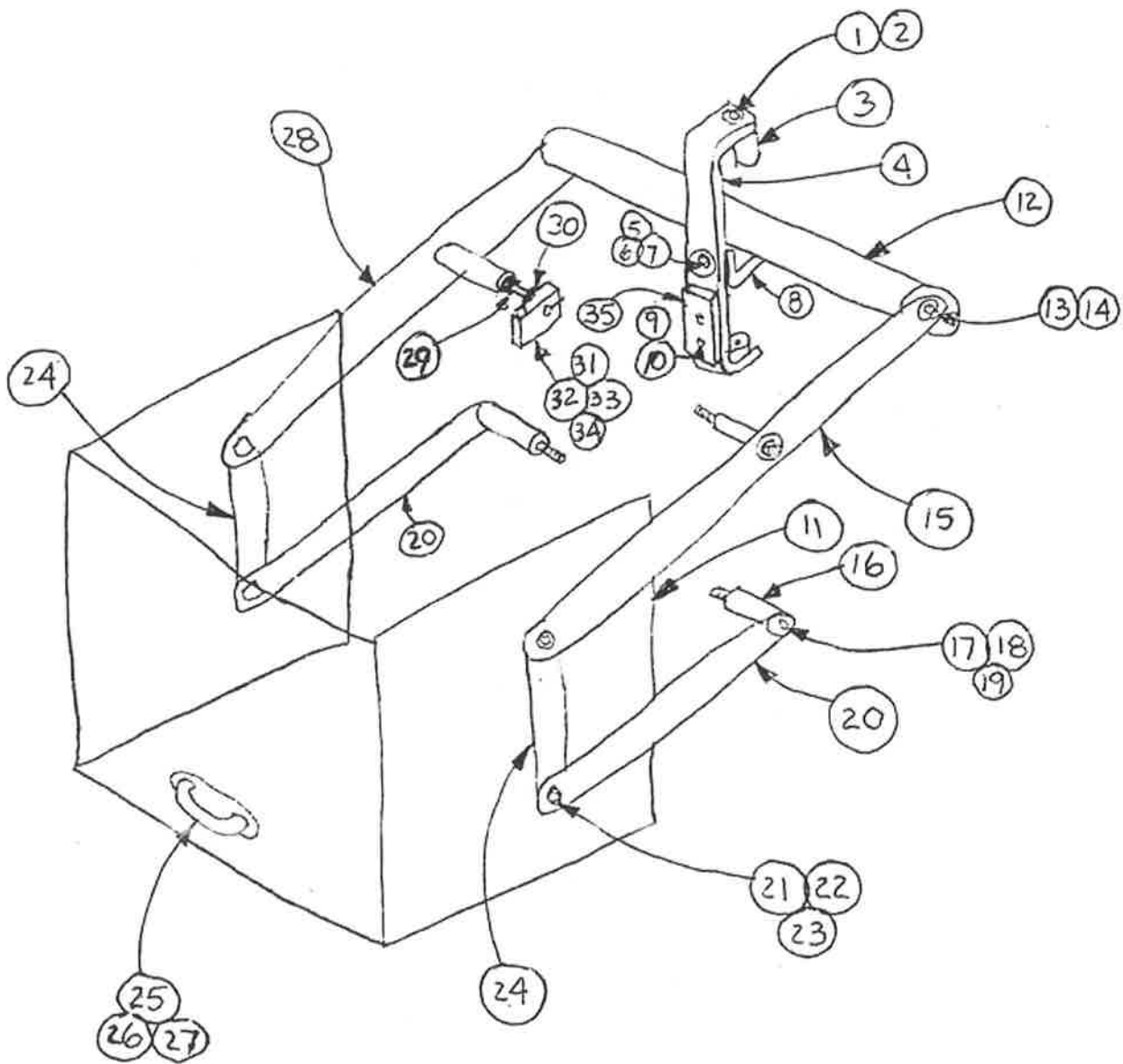
FOREMOST MACHINERY CORPORATION

425 Huehl Road, Northbrook, Illinois 60062

Tel: (847)272-7880

FAX: (847)272-7948

'B' Press Guard



FOREMOST MACHINERY CORPORATION

425 Huehl Road, Northbrook, Illinois 60062
Tel: (708)272-7880 FAX: (708)272-7948

RMT 'B' PRESS SAFETY GUARD PARTS LIST

<u>ITEM</u>	<u>QTY</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
1	2	RH22	MACHINE SCREW, SLOTTED ROUND HEAD, 2 BA X 1 LG.
2	2	RH23	NUT, 2 BA
3	2	RG04ABCD	BUMPER, 1-3/8 OD X 1 T
4	1	RG01B	BRACKET, STRAIGHT BUMPER
5	1	RH15	B.H.C.S., 1/4-26 BSF X 1 LG.
6	1	RH07	WASHER, 1/4 ID, 5/8 OD, .056 T
7	1	RH16	NUT, NYLOC, 1/4-26 BSF
8	1	RG02B	LATCH, GUARD, 1/8 X 1-1/2 X 3 X 1-3/16 WIDE
9	2	RH13	S.H.C.S., 1/4-26 BSF X 3/4 LG.
10	2	RH14	LOCKWASHER, 1/4
11	1	RBGRD	GUARD
12	1	RG03B -	COUNTERWEIGHT, 1-1/2 OD X 13-1/4 LG.
13	2	RH02	S.H.C.S., 5/16-22 BSF X 3/4 LG.
14	2	RH03	LOCKWASHER, 5/16
15	1	RG04B -	BRACKET, LONG, 3/16 X 1 X 17-3/8 LG.
16	3	RG02AB -	SPACER, 1 OD X 2-5/16 LG.
17	3	RG01AB -	STUD, THREADED, 3/8 OD X 3-1/2 LG. CASTING: 3/8-16 X 1/2 LG. BRACKET: 3/8-24 X 1 LG.
18	3	RH04	WASHER, 3/8 ID, 7/8 OD, .072 T
19	3	RH05	NUT, NYLOC, 3/8-24
20	2	RG05B -	BRACKET, SHORT, 3/16 X 1 X 8-1/2 LG.

<u>ITEM</u>	<u>QTY</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
21	4	RH06	B.H.C.S., 1/4-26 BSF X 1/2 LG.
22	4	RH07	WASHER, 1/4 ID, 5/8 OD, .056 T
23	4	RG01ABC	NUT, SPECIAL FLANGED
24	2	RG02ABC ~	BRACKET, GUARD, .119 X 1 X 7-7/16 LG.
25	1	RG01ABCD -	HANDLE, GUARD
26	2	RH08	S.H.C.S., 1/4-20 X 3/4 LG.
27	1	RG02ABCD ~	BRACKET, HANDLE, 1/8 X 1 X 7-7/16 LG.
28	1	RG06B -	BRACKET & SPACER WELDMENT, 3/16 X 1 X 17-3/8 LG.
29	1	R2001/22	BUSHING
30	1	RH09	WASHER, 3/8 ID, 7/8 OD, .049 T
31	1	RG03ABCD	LEVER, RAM ACTUATING
32	1	RH10	H.H.C.S., ROUNDED HEAD, 1/4-26 BSF X 1 LG.
33	1	RH11	NUT, 1/4-26 BSF
34	1	RH17	H.H.C.S., 1/4-26 BSF X 5/8 LG.
35	1	RG07B	SPACER, 1/4 X 1-1/4 X 6-3/4 LG.
36*	2	RH34	S.H.C.S., 1/4-26 BSF X 2-1/2 LG. (A)
	3	RH19	S.H.C.S., 1/4-26 BSF X 1-3/4 LG. (B)
37*	2	RH14	LOCKWASHER, 1/4 (A)
	3	RH14	LOCKWASHER, 1/4 (B)
38*	2	RH16	NUT, NYLOC, 1/4-26 BSF (A)
	3	RH16	NUT, NYLOC, 1/4-26 BSF (B)
39*	2	RH20	H.H.C.S., 2 BA X 1 LG. (C)
40*	2	RH21	LOCKWASHER, 2 BA (C)

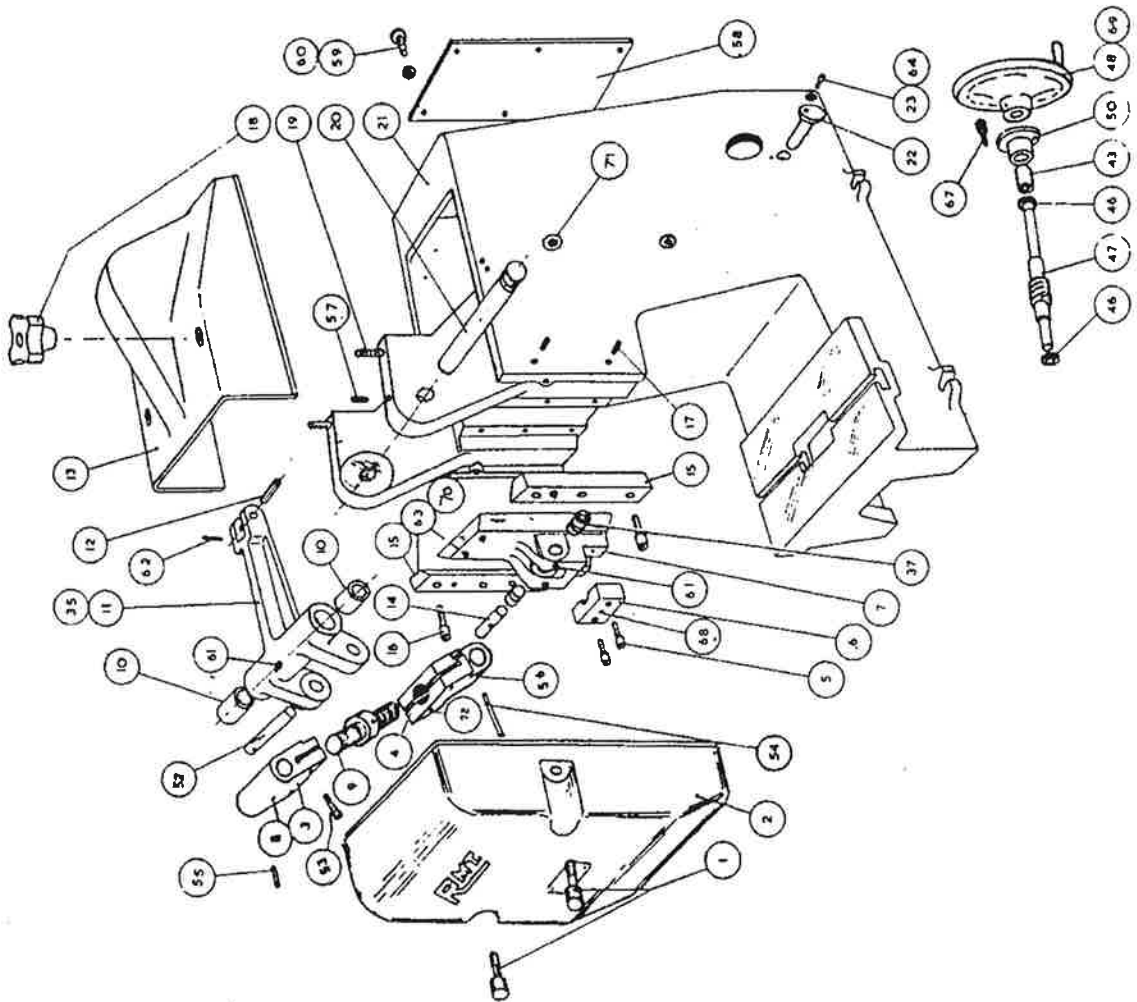
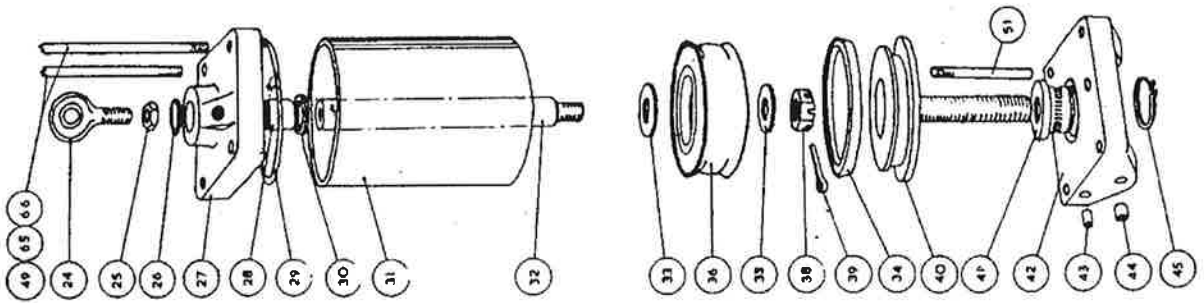
* - VALVE HARDWARE (NOT SHOWN ON DRAWING)

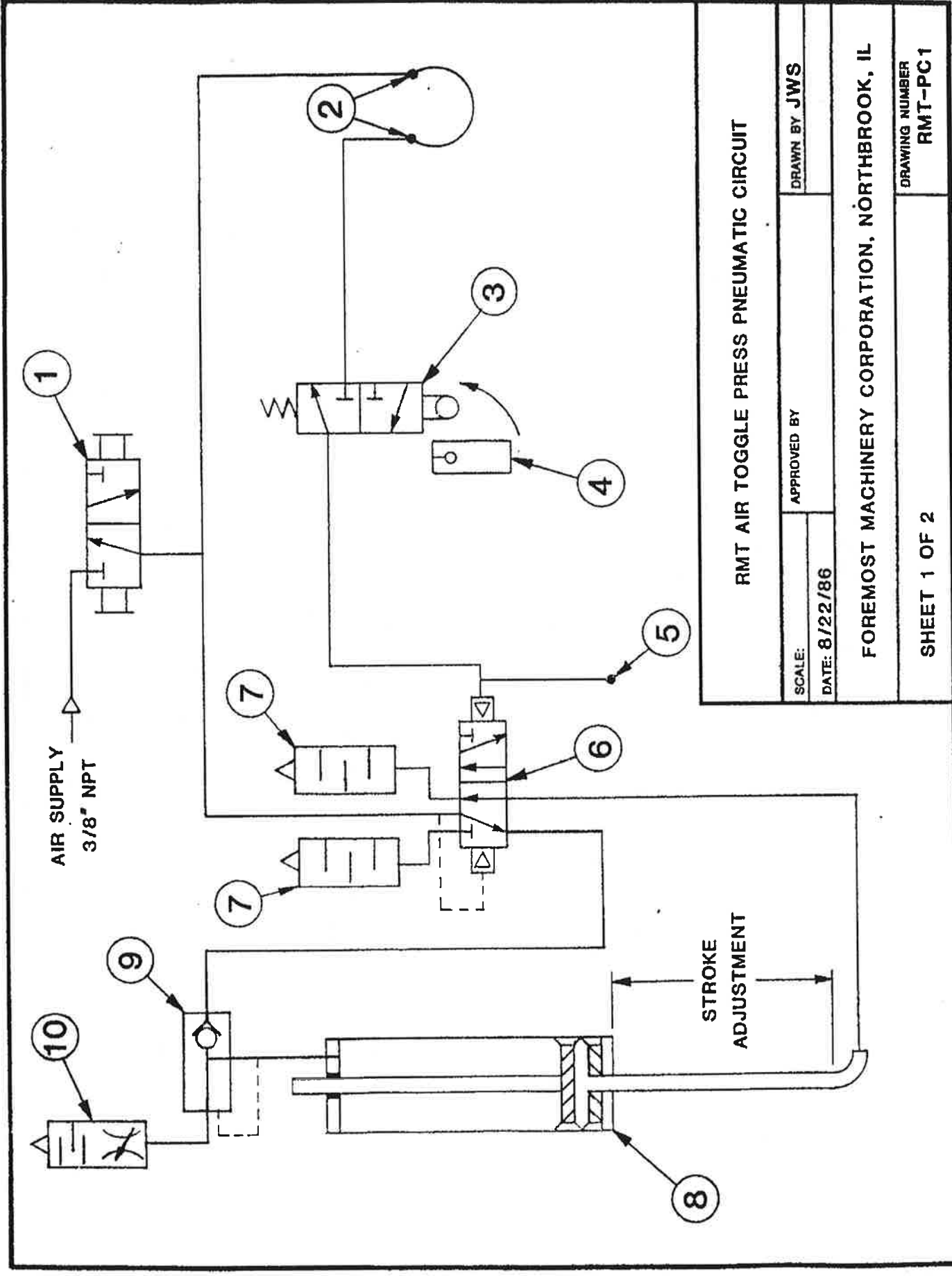
A - FOR COMPAIR VALVE NO. 8L504-102

B - FOR SCHRADER-BELLOWS VALVE NO. 3456AP

C - FOR SCHRADER-BELLOWS VALVE NO. 43003CS

ITEM	PART NO	DESCRIPTION
1	R 2001/4	CAPTIVE SCREW
2	R 2005/2	FRONT COVER
3	R 2197	RAM LINK CLAMP
4	R 2198	SWIVEL BLOCK
5	R 2009/26	CLAMP SCREW
6	R 2002/5	CLAMP
7	R 2001/1	RAM
8	R 2000/1	GREASE NIPPLE (MERTIME)
9	R 2009/29	LINK BEARING
10	R 2195	LINK PIN 15 TON
11	R 2002/8	TOP COVER
12	R 2005/1	RAM LINK PIN (LOWER)
13	R 2198/1	GIB
14	R 2002/1	GIB SCREW
15	R 2009/20	GIB ADJUSTING SCREW
16	R 2009/20	COVER KNOB
17	R 2002/10	COVER STUD
18	R 2002/2	LINK PIVOT PIN
19	R 2003/1	BASE FRAME
20	R 2002/19	TRUNNION PIN
21	R 2001/28	TRUNNION PIN SCREW
22	R 2001/16	PISTON ROD END
23	R 2001/20	LOCKWASHER
24	R 2001/25	WIPER SEAL
25	R 2001/1	CYLINDER HEAD
26	R 2001/27	CYLINDER BEARING
27	R 2001/28	O RING
28	R 2001/26	CYLINDER HEAD SEAL
29	R 2001/11	CYLINDER TUBE
30	R 2001/4	PISTON ROD
31	R 2001/4	PLAIN WASHER 5/8 DIA PLAIN
32	R 2001/4	PISTON SEAL 3/8 DIA
33	R 2216	LINK 17 TON
34	R 2001/2	PISTON HEAD 5/4 DIA
35	R 2001/2	BUSH 1 1/2 DIA
36	R 2001/2	SPLIT PIN 5/32 x 1 1/2
37	R 2001/2	ADJUSTING SCREW & HEAD
38	R 2001/2	WORM NUT
39	R 2001/2	CYLINDER REAR END
40	R 2001/22	WORM BUSH
41	R 2001/23	TRUNNION BUSH
42	R 2001/24	CIRCLIP
43	R 2001/12	THRUST RING
44	R 2008/2	WORM
45	R 2008/2	HANDWHEEL
46	R 2001/7	TIE ROD
47	R 2001/8	BUSHED SLEEVE
48	R 2001/6	STAY BAR
49	R 2009/3	RAM LINK PIN (UPPER)
50	R 2001/2	1/4 UNC x 2 5/8 CAP SCREW
51	R 2001/2	TOMMY BAR 1/8 DIA x 1 1/2
52	R 2001/2	SPINDLE PIN 1/8 DIA x 1 1/2
53	R 2001/2	1/4 UNC x 1/2 GRUB SCREW
54	R 2001/2	SCREW 3/8 UNC x 1/2 LO. DUB
55	R 2001/2	BACK PLATE
56	R 2001/2	SCREW 2 BA x 1/2 LO. CAP NO
57	R 2001/2	SPRING WASHER 2 BA
58	R 2001/2	GREASE NIPPLE 1/8 BSF 5/16
59	R 2001/2	SPINDLE PIN 1/8 DIA x 1 1/2
60	R 2001/2	GREASE NIPPLE 1/8 BSF 5/16
61	R 2001/2	SPRING WASHER 2 BA
62	R 2001/2	NUT 1/4 UNC INTDC
63	R 2001/2	WASHER 3/8 DIA PLAIN
64	R 2001/2	SCREW 2 BA x 1/2 LO. CAP NO
65	R 2001/2	SCREW 1/4 UNC x 1/2 LO. GRUB
66	R 2001/2	SCREW 1/4 UNC x 1/2 LO. GRUB
67	R 2001/2	DOWEL 1/4 DIA x 1 1/2
68	R 2001/2	BUSH 06 DU 08
69	R 2001/2	1/4 UNC x 2 5/8 CAP SCREW





RMT AIR TOGGLE PRESS PNEUMATIC CIRCUIT

DRAWN BY JWS

APPROVED BY

SCALE:

DATE: 8/22/86

FOREMOST MACHINERY CORPORATION, NORTHBROOK, IL

DRAWING NUMBER

RMT-PC1

SHEET 1 OF 2

ITEM	QTY	PART NO.	DESCRIPTION
1	1	04042100000	SHUT OFF SLEEVE VALVE
2	2		1/8" NPT PORTS FOR OPTIONAL CONTROLS (JUMPERED)
3	1	B43003CS	3 PORT, 2 POSITION, 3 WAY VALVE
4	1		RAM TRIP LEVER (GUARD ACTUATED)
5	1		1/8" NPT PORT FOR PRODUCTION COUNTER (PLUGGED)
6	1	B3456AP	5 PORT, 2 POSITION, 4 WAY VALVE
7	2	B476	MUFFLER (QTY 1 ON 'A' MODEL)
8	1		ADJUSTABLE STROKE CYLINDER
9	1	B3340B	QUICK EXHAUST ('B' & 'C' MODELS ONLY)
10	1	63006	FLOW RESTRICTOR/MUFFLER

SINGLE CYCLE OPERATION

1. INSERT MATERIAL INTO DIE.
2. MANUALLY LOWER PLASTIC GUARD. ONCE IT IS DOWN, LEVER (4) OPERATES VALVE (3) SHIFTING VALVE (6) TO ADVANCE AIR CYLINDER (8).
3. RAM WILL ADVANCE TO BOTTOM OF STROKE AND REMAIN THERE UNTIL THE PLASTIC GUARD IS RELEASED.

WARNING

1. SHUT OFF AIR SUPPLY BEFORE MAKING ADJUSTMENTS OR TOOL CHANGES.
2. DO NOT REMOVE GUARD OR MODIFY AIR CIRCUIT WITHOUT SAFETY PRECAUTION.
3. DO NOT REPOSITION TRIP LEVER WITHOUT SAFETY PRECAUTION. LEVER IS PRESET AT FACTORY TO TRIP PRESS ONLY WHEN GUARD IS WITHIN 1/4" OF ENCLOSING DIE SPACE.

RMT AIR TOGGLE PRESS PNEUMATIC CIRCUIT

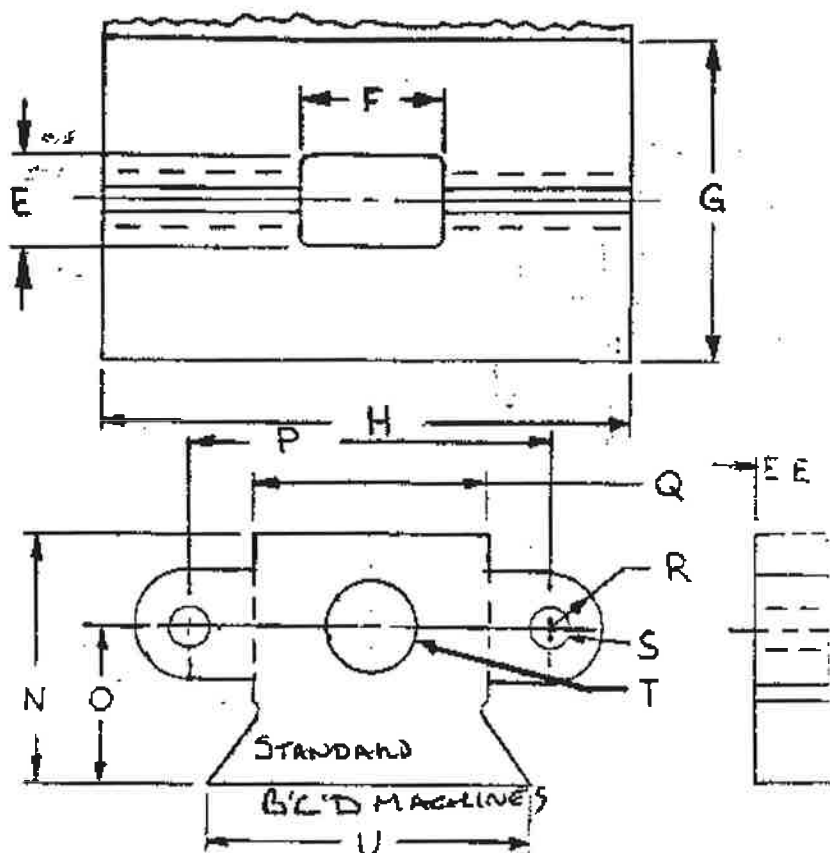
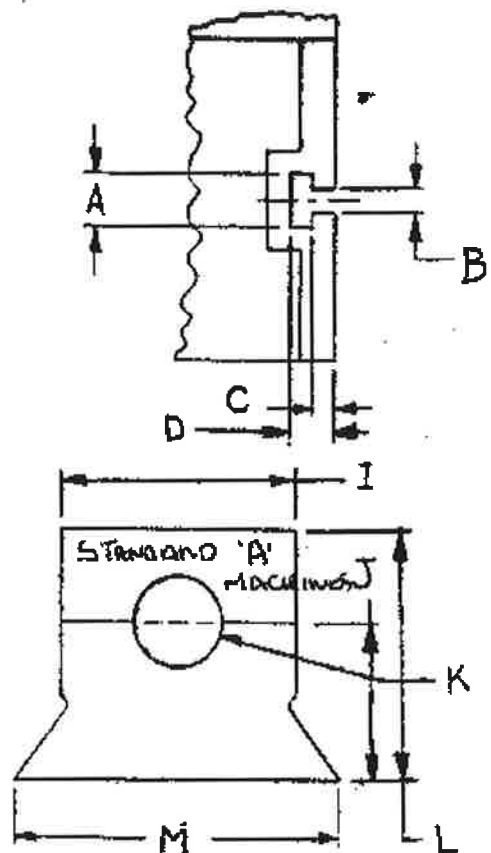
SCALE: APPROVED BY

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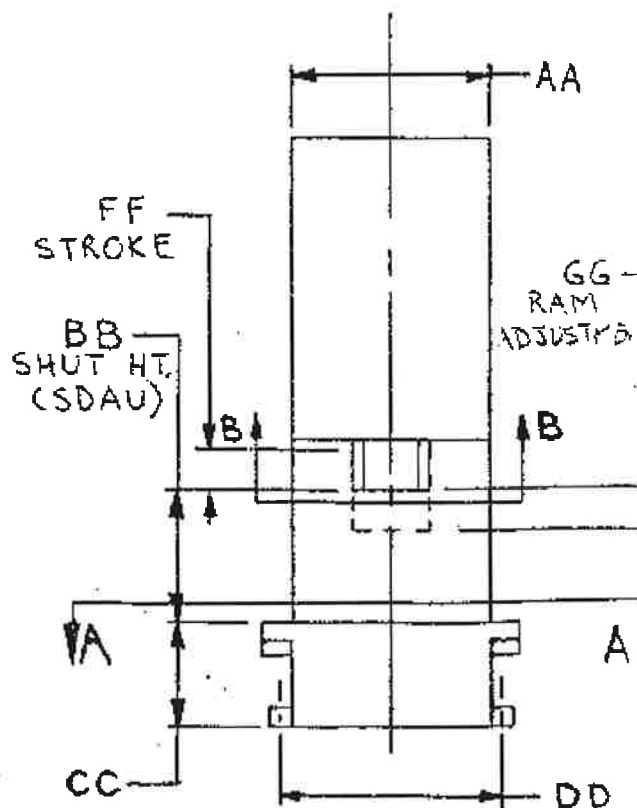
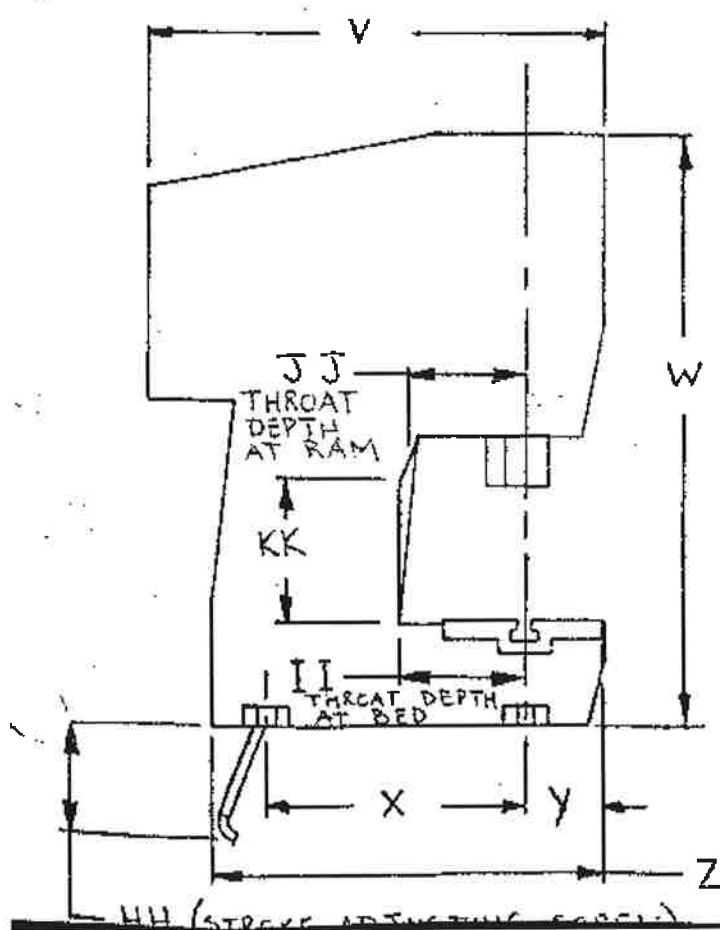
DATE: 8/22/86

FOREMOST MACHINERY CORPORATION, NORTHBROOK, IL

SHEET 2 OF 2
DRAWING NUMBER
RMT-PC1



SECTION E-B (RAM ONLY, CLAMP) SECTION E-B (RAM ONLY, FLANGED)



RMT AIR TOGGLE PRESSES

DIMENSIONS AND SPECIFICATIONS

DESCRIPTION		MACHINE MODEL NUMBER									
"T" SLOT											
		3A	5B	7B	6C	8C	10C	12C	18D	20D	24D
A	width at top	1-3/16"	1-3/8"	1-3/8"	1-1/2"	1-1/2"	1-1/2"	1-1/2"	1-1/2"	1-1/2"	1-1/2"
B	width at bottom	17/32"	11/16"	11/16"	3/4"	3/4"	3/4"	3/4"	3/4"	3/4"	3/4"
C	depth at top	1/2"	1/2"	1/2"	1/2"	1/2"	1/2"	1/2"	5/8"	5/8"	5/8"
D	depth overall	1"	1-1/8"	1-1/8"	1-1/8"	1-1/8"	1-1/8"	1-1/8"	1-1/4"	1-1/4"	1-1/4"
BED - optional wide bed available on "C" and "D" models only											
		3A	5B	7B	6C	8C	10C	12C	18D	20D	24D
E	bed hole, F-B	2"	3"	3"	3"	3"	3"	3"	4"	4"	4"
F	bed hole, L-R	3-1/8"	3-1/4"	3-1/4"	3-1/2"	3-1/2"	3-1/2"	3-1/2"	4-1/2"	4-1/2"	4-1/2"
G	bed depth	7"	8"	8"	9"	9"	9"	9"	12"	12"	12"
H	bed width	11-3/4"	12"	12"	14"	14"	14"	14"	18"	18"	18"
H	bed width - wide bed	N/A	N/A	N/A	20"	20"	20"	20"	24"	24"	24"
CLAMP RAM - standard on "A" machines, optional on "B" and "C" machines, not available on "D" machines											
		3A	5B	7B	6C	8C	10C	12C	18D	20D	24D
I	width at front	2-9/16"	3-1/8"	3-1/8"	3-1/8"	3-1/8"	3-1/8"	3-1/8"	N/A	N/A	N/A
J	back to hole center	1-3/4"	1-3/4"	1-3/4"	1-3/4"	1-3/4"	1-3/4"	1-3/4"	N/A	N/A	N/A
K	hole diameter	1"	1-9/16"	1-9/16"	1-9/16"	1-9/16"	1-9/16"	1-9/16"	N/A	N/A	N/A
K	hole depth	1-1/4"	2"	2"	2"	2"	2"	2"	N/A	N/A	N/A
L	front to back	2-3/4"	3"	3"	3"	3"	3"	3"	N/A	N/A	N/A
M	width at back	3-9/16"	3-7/8"	3-7/8"	3-7/8"	3-7/8"	3-7/8"	3-7/8"	N/A	N/A	N/A
FLANGE RAM - not available on "A" machines, standard on "B", "C" and "D" machine											
		3A	5B	7B	6C	8C	10C	12C	18D	20D	24D
N	front to back	N/A	3-3/8"	3-3/8"	3-3/8"	3-3/8"	3-3/8"	3-3/8"	4-1/4"	4-1/4"	4-1/4"
O	back to hole centers	N/A	1-3/4"	1-3/4"	1-3/4"	1-3/4"	1-3/4"	1-3/4"	2-1/2"	2-1/2"	2-1/2"
P	hole centers	N/A	3-15/16"	3-15/16"	3-15/16"	3-15/16"	3-15/16"	3-15/16"	5-1/2"	5-1/2"	5-1/2"
Q	width at front	N/A	2-3/4"	2-3/4"	2-3/4"	2-3/4"	2-3/4"	2-3/4"	4-1/8"	4-1/8"	4-1/8"
R	flange radius	N/A	5/8"	5/8"	5/8"	5/8"	5/8"	5/8"	3/4"	3/4"	3/4"
S	flange hole diameter	N/A	9/16"	9/16"	9/16"	9/16"	9/16"	9/16"	9/16"	9/16"	9/16"
T	ram hole diameter	N/A	1-9/16"	1-9/16"	1-9/16"	1-9/16"	1-9/16"	1-9/16"	1-9/16"	1-9/16"	1-9/16"
T	ram hole depth	N/A	2"	2"	2"	2"	2"	2"	3"	3"	3"
U	width at back	N/A	3-7/8"	3-7/8"	3-7/8"	3-7/8"	3-7/8"	3-7/8"	5-1/4"	5-1/4"	5-1/4"
BASIC DIMENSIONS											
		3A	5B	7B	6C	8C	10C	12C	18D	20D	24D
V	overall depth at top	20"	18"	18"	21"	21"	21"	21"	32"	32"	32"
W	overall height	25"	30"	30"	35"	35"	35"	35"	44-1/2"	44-1/2"	44-1/2"
X	hole centers, F-B	11-1/2"	12"	12"	14"	14"	14"	14"	23"	23"	23"
Y	front to front holes	3-3/8"	3-7/8"	3-7/8"	4-3/8"	4-3/8"	4-3/8"	4-3/8"	5-7/8"	5-7/8"	5-7/8"
Z	overall depth at base	17-1/4"	19-1/4"	19-1/4"	23"	23"	23"	23"	32"	32"	32"
AA	width at top	9"	10"	10"	12"	12"	12"	12"	12"	12"	12"
BB	shut height - SDAU	6"	7"	7-11/16"	6-3/4"	7-1/2"	8"	8-1/2"	8-1/2"	9"	9-1/2"
CC	base to bed	4-3/4"	5-1/4"	5-1/4"	7"	7"	7"	7"	10-5/8"	10-5/8"	10-5/8"
DD	hole centers, L-R	10-1/2"	10-1/2"	10-1/2"	12-7/8"	12-7/8"	12-7/8"	12-7/8"	12-3/4"	12-3/4"	12-3/4"
EE	flange thickness	N/A	7/8"	7/8"	7/8"	7/8"	7/8"	7/8"	1"	1"	1"
FF	maximum stroke	2"	2"	1-5/16"	3-1/4"	2-1/2"	2"	1-1/2"	2-1/2"	2"	1-1/2"
GG	ram adjustment	1/2"	3/4"	3/4"	1"	1"	1"	1"	5/8"	5/8"	5/8"
HH	max. extend below	0"	0"	0"	6-1/2"	6-1/2"	6-1/2"	6-1/2"	13"	13"	13"
II	throat depth at bed	5-1/2"	5-1/2"	5-1/2"	8-1/2"	8-1/2"	8-1/2"	8-1/2"	8-7/8"	8-7/8"	8-7/8"
JJ	throat depth at ram	5"	5"	5"	7-1/2"	7-1/2"	7-1/2"	7-1/2"	6-1/2"	6-1/2"	6-1/2"
KK	height of back surface	N/A	N/A	N/A	N/A	N/A	N/A	N/A	6-1/2"	6-1/2"	6-1/2"



RMT AIR TOGGLE PRESS WARRANTY CERTIFICATE

As part of the purchase of a new RMT Pneumatic Toggle Press, a parts warranty will be included. The warranty begins at the point of initial shipment and will not automatically be passed along to second owners. The warranty applies to equipment, which has been installed, protected, maintained and used in accordance with the specifications and instructions of the manufacturer, for its intended purposes, without modification, misuse or abuse by the PURCHASER.

Mechanical parts and components are warranted for a period of 12 months from the date of shipment.
Pneumatic parts and components are warranted for a period of 90 days from the date of shipment.

PARTS WARRANTY: In the event of a problem, the purchaser contacts RMT's American Master Distributor whose service technicians will provide over the phone trouble shooting measures to resolve the situation. The purchaser is responsible for executing all required troubleshooting steps to determine the problem. If it is determined that any part has failed due to a defect in material or workmanship within the Warranty Period (defined above), a replacement part will be provided free of charge except for the freight costs which are the purchaser's responsibility. The purchaser is responsible for installing any replacement parts and/or all labor charges associated with installation of replacement parts. The purchaser may be required to send damaged parts prepaid to RMT's American Master Distributor for inspection. Replacement parts are warranted only for the balance of the original Warranty Period.