

# OPERATOR'S MANUAL

INCLUDING: INSTALLATION, OPERATION & PARTS LIST

**67503**  
**67504**

## 67503 & 67504 DRUM HOLD DOWN KITS for RM552S-XXX-XX & RM552H-XXX-XX RAMS

RELEASED: 7-01-13  
(REV. B)



### READ THIS MANUAL CAREFULLY BEFORE INSTALLING, OPERATING OR SERVICING THIS EQUIPMENT.

It is the responsibility of the employer to place this information in the hands of the operator. Keep for future reference.  
The original language of this manual is English.

## 67503 DRUM HOLD DOWN KIT FOR RM552S-XXX-XX RAM

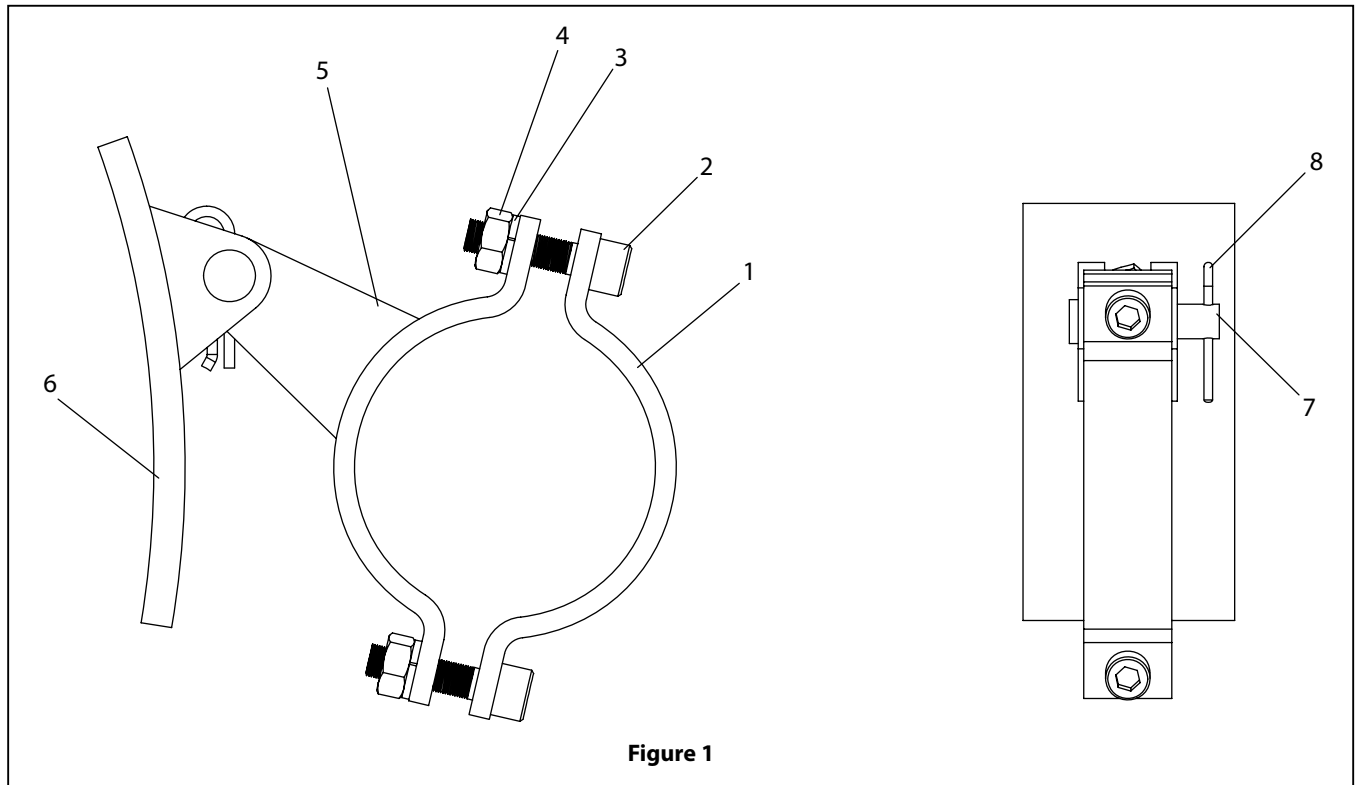


Figure 1

## PART LIST 67503

Item	Description (size)	Qty	Part No.
1	Clamp Bracket	(2)	15309917
2	Screw, Cap (M10 X 40)	(4)	96775
3	Lock Washer	(4)	96753918
4	Nut	(4)	96691
5	Clevis Bracket	(2)	15309909

Item	Description (size)	Qty	Part No.
6	Clamp Shoe	(2)	97190
7	Clamp Pin	(2)	97191
8	Hair Pin Clip	(2)	97192

## 67504 DRUM HOLD DOWN KIT FOR RM552H-XXX-XX RAM

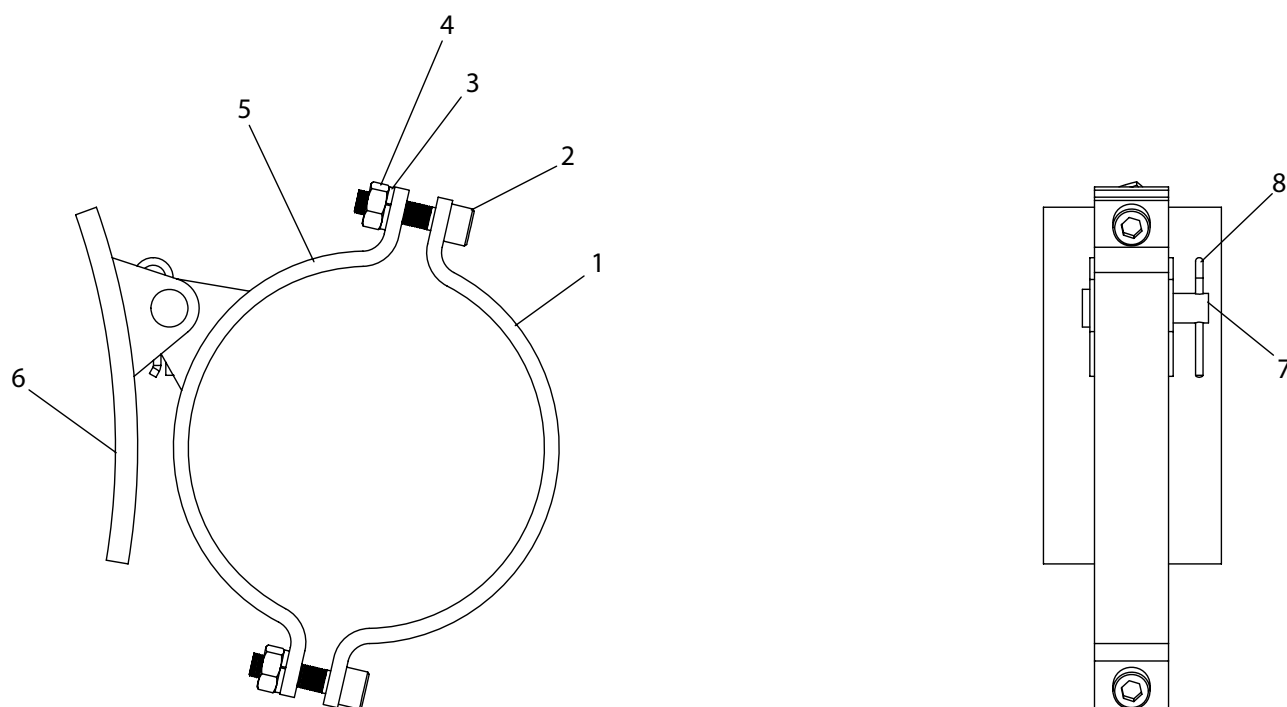


Figure 2

### PART LIST 67504

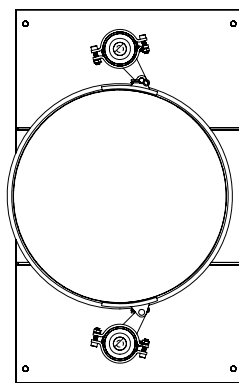
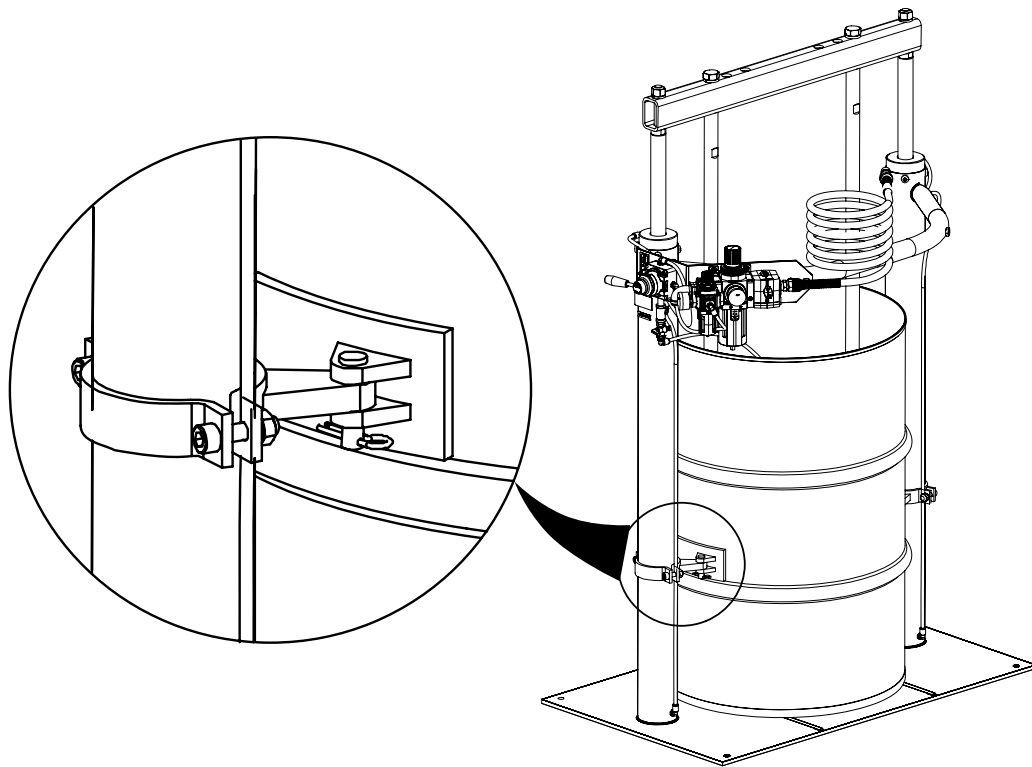
Item	Description (size)	Qty	Part No.
1	Clamp Bracket	(2)	95353
2	Screw, Cap (M10 X 40)	(4)	96775
3	Lock Washer	(4)	96753918
4	Nut	(4)	96691
5	Clevis Bracket	(2)	95354

Item	Description (size)	Qty	Part No.
6	Clamp Shoe	(2)	97190
7	Clamp Pin	(2)	97191
8	Hair Pin Clip	(2)	97192

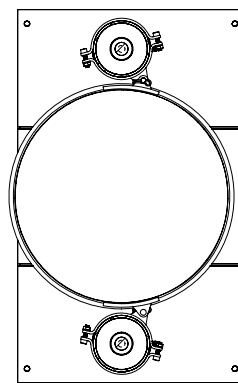
### DRUM HOLD DOWN KIT INSTALLATION ON RAM

1. Install (5) Clevis Bracket on inside side of ram cylinders with clevis arm facing to the back (see figure 3, page 3).
2. Attach (1) Clamp Bracket on opposite side of ram cylinder from the (5) Clevis Bracket using (2) Cap Screws, (4) Nuts and (3) Lock Washer (see figure 3, page 3).
3. Attach (6) Clamp Shoe using (7) Clamp Pin and (8) Hair Pin Clip. The long side of the Clamp Shoe should be toward the front of the ram.
4. The bottom of the Clevis and Clamp Brackets should be about 14 inch above the ram base plate.
5. Repeat steps 1- 4 for other ram cylinder.
6. To adjust the Drum hold clamps:
  - a. Place a drum of material into position.
  - b. Move the Clevis and Clamp brackets up or down, so the Clamp Shoe is just above the bottom rib of the drum.
  - c. Rotate the Clevis and Clamp Brackets around the cylinder so that the Clamp shoe is up against the drum (see figure 3, page 3).
  - d. Tighten the (2) Cap Screws and (4) Nuts.
  - e. Repeat steps b-d for other side.

## DRUM HOLD DOWN KIT WITH RAMS



Section A-A  
showing 67503



Section A-A  
showing 67504

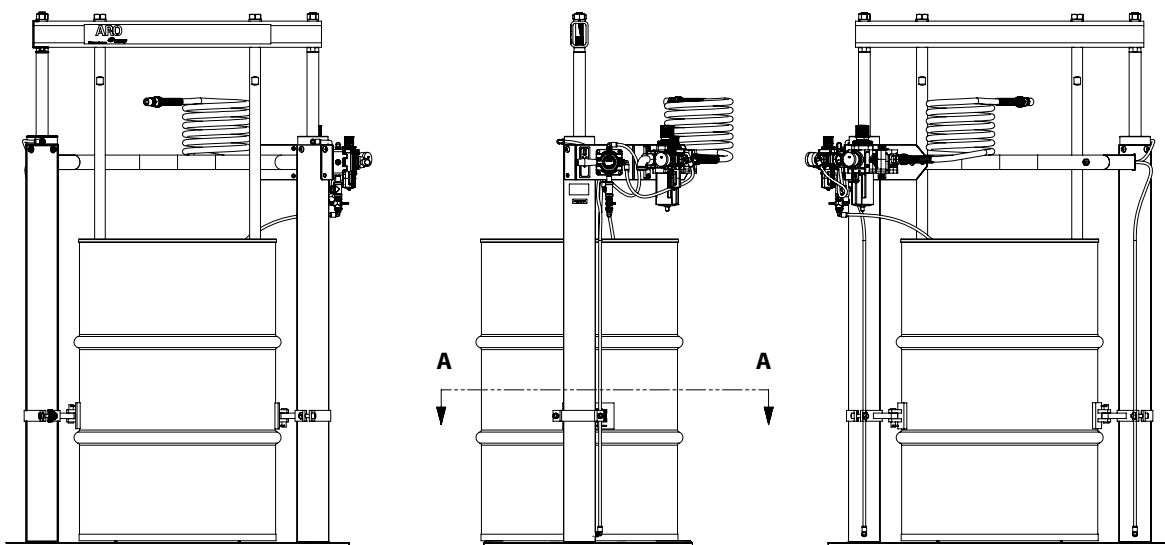


Figure 3

