



OWNER'S MANUAL

RM-22N Rotary Machine



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M-754022 10/01

Important Information

**1-YEAR
LIMITED WARRANTY**

**JET offers a one-year limited
warranty on this product**

REPLACEMENT PARTS

Replacement parts for this tool are available directly from JET Equipment & Tools. To place an order, call 1-800-274-6848. Please have the following information ready:

1. Visa, MasterCard, or Discover Card number
2. Expiration date
3. Part number listed within this manual
4. Shipping address other than a Post Office box.

REPLACEMENT PART WARRANTY

JET Equipment & Tools makes every effort to assure that parts meet high quality and durability standards and warrants to the original retail consumer/purchaser of our parts that each such part(s) to be free from defects in materials and workmanship for a period of thirty (30) days from the date of purchase.

PROOF OF PURCHASE

Please retain your dated sales receipt as proof of purchase to validate the warranty period.

LIMITED TOOL AND EQUIPMENT WARRANTY

JET makes every effort to assure that its products meet high quality and durability standards and warrants to the original retail consumer/purchaser of our products that each product be free from defects in materials and workmanship as follows: 1 YEAR LIMITED WARRANTY ON THIS JET PRODUCT. Warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, repairs or alterations outside our facilities or to a lack of maintenance. JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD SPECIFIED ABOVE FROM THE DATE THE PRODUCT WAS PURCHASED AT RETAIL. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OR MECHANABILITY AND FITNESS ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG THE IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU. JET SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY OR FOR INCIDENTAL, CONTINGENT, SPECIAL OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU. To take advantage of this warranty, the product or part must be returned for examination, postage prepaid, to an authorized service station designated by our Auburn office. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, JET will either repair or replace the product or refund the purchase price, if we cannot readily and quickly provide a repair or replacement, if you are willing to accept such refund. JET will return repaired product or replacement at JET's expense, but if it is determined there is no defect, or that the defect resulted from causes not within the scope of JET's warranty, then the user must bear the cost of storing and returning the product. This warranty gives you specific legal rights, and you have other rights, which vary, from state to state.

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WARNING

For your own safety, read the owner's manual before operating the rotary machine.

This rotary machine is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a rotary machine, do not use until proper training and knowledge has been obtained.

1. **KEEP GUARDS IN PLACE** and in working order.
2. **KEEP ALL BODY PARTS AWAY FROM MOVING PARTS.** Avoid placing any part of your body near belts, cutters, gears, etc.
3. **DO NOT EXCEED 22 GAUGE RATED CAPACITY** on this rotary machine.
4. **KEEP THE WORK AREA CLEAN.** Cluttered areas and work benches invite accidents.
5. **KEEP CHILDREN AWAY.** All visitors should be kept a safe distance from the work area.
6. **MAKE THE WORKSHOP KID PROOF** with padlocks, master switches, or by removing starter keys.
7. **DON'T FORCE THE MACHINE.** It will do the job better and safer at the rate for which it was designed.
8. **USE THE RIGHT MACHINE.** Don't force a machine or attachment to do a job for which it was not designed.
9. **WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
10. **ALWAYS USE SAFETY GLASSES.** Also use face or dust masks if the cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
11. **DON'T OVERREACH.** Keep proper footing and balance at all times.
12. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
13. **NEVER STAND ON A MACHINE.** Serious injury could occur if the machine tipped.
14. **CHECK DAMAGED PARTS.** Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function - check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
15. **SHEET METAL STOCK HAS SHARP EDGES.** To prevent cuts, use caution when handling.
16. **KEEP HANDS AND FINGERS** clear of the area in front and rear of the rotary machine.
17. **DO NOT USE THE MACHINE** for any purpose other than for which it was designed
18. **FAILURE TO COMPLY** with all of these warnings may cause serious injury.
19. **SOME DUST CREATED BY** power sanding, sawing, grinding, drilling and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:
 - Lead from lead based paint
 - Crystalline silica from bricks and cement and other masonry products, and
 - Arsenic and chromium from chemically-treated lumber.
20. **YOUR RISK FROM THOSE EXPOSURES** varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specifically designed to filter out microscopic particles
21. **DO NOT OPERATE TOOL** while under the influence of drugs, alcohol or any medication.

Specifications:

RM-22N

Stock Number.....	754022
Capacity	22 gauge
Distance Between Shaft Centers.....	.2"
Depth of Throat to Frame.....	.7"
Overall Dimensions (LxWxH)	18"x8"x16"

Uncrating and Clean-Up

1. Remove the RM-22N from the crate.
2. Carefully clean all rust protected surfaces with a mild solvent or kerosene and a soft rag. Do not use lacquer thinner, paint thinner, or gasoline. These will damage painted surfaces.
3. Lubricate all moving parts of the machine with light grease or heavy oil.
4. Carefully move the machine to a well lighted area and attach to a solid, level work bench.
5. Machine location must allow access to all sides.

Lubrication

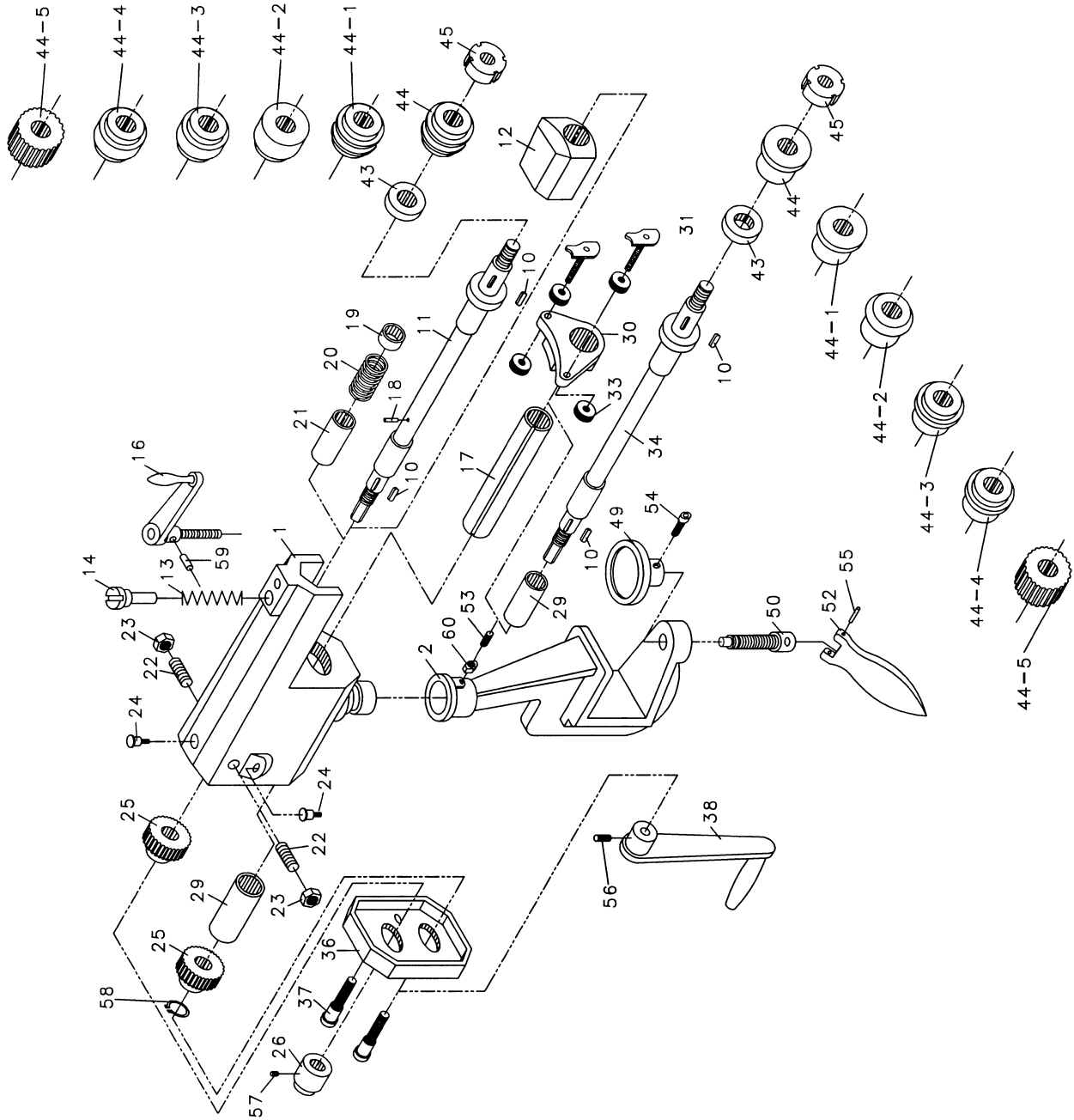
1. There are two grease fittings #24 that need to be greased once a month.
2. The machine must be lubricated every day of service with a few drops of oil. An oil pinhole is located at the end of the lower shaft #34, and upper shaft #11.
3. Every thirty days of operation grease the gears by removing the gear cover #36.

Setup for Rolls

The (#) in the text refers to the breakdown and parts list.

1. Use the spanner wrench to remove the roll nut #45 and install the different roll combinations.
2. According to the material thickness lower the upper shaft #11 by turning the handle assembly #16.
3. Turn the adjusting nut #26 to align the upper and lower rolls. To facilitate the movement push in on the upper roll while turning the adjusting nut. Tighten the set screw #57.
4. According to the size of the work piece adjust the gauge stop #31 by turning knurled nuts #33 to the proper position. You can also adjust the gauge seat #30 by loosening the set screw #32.
5. The work piece can now be inserted between the rolls. Turn handle assembly #16 until the rolls lightly press on the material. Slowly turn handle #38 while handle assembly #16 is rotated to give the desired shape.

Breakdown for the RM-22N Rotary Machine



Parts List for the RM-22N Rotary Machine

Index No.	Part No.	Description	Size	Quantity
1	RM22N-1	Body Assembly		1
2	RM22N-2	Base Assembly		1
10	RM22N-10	Key	6x6x20	4
11	RM22N-11	Upper Shaft		1
12	RM22N-12	Adjust Seat		1
13	RM22N-13	Spring		1
14	RM22N-14	Screw		1
16	RM22N-16	Handle Assembly		1
17	RM22N-17	Collar		1
18	RM22N-18	Spring Pin	5x32	1
19	RM22N-19	Spring Collar		1
20	RM22N-20	Spring		1
21	RM22N-21	Collar		1
22	RM22N-22	Set Screw	M12x40	2
23	RM22N-23	Hex Nut	M12	2
24	RM22N-24	Oil Cup		2
25	RM22N-25	Gear		2
26	RM22N-26	Adjusting Nut		1
29	RM22N-29	Collar		2
30	RM22N-30	Gauge Seat		1
31	RM22N-31	Gauge Stop		2
32	RM22N-32	Set Screw		1
33	RM22N-33	Knurled Nut		4
34	RM22N-34	Lower Shaft		1
36	RM22N-36	Gear Cover		1
37	RM22N-37	Button Head Hex Screw		2
38	RM22N-38	Handle		1
43	RM22N-43	Bushing		2
44	RM22N-44	Beading Roll (set)		2
	RM22N-44-1	Turning Roll (set)		2
	RM22N-44-2	Closing Roll (set)		2
	RM22N-44-3	Jogging Roll (set)		2
	RM22N-44-4	Flanging Roll (set)		2
	RM22N-44-5	Crimping Roll (set)		2
45	RM22N-45	Roll Nut		2
49	RM22N-49	Base		1
50	RM22N-50	Screw		1
52	RM22N-52	Handle		1
53	RM22N-53	Socket Head Cap Screw	M8x40	1
54	RM22N-54	Socket Head Cap Screw	M8x15	1
55	RM22N-55	Pin	8x45	1
56	RM22N-56	Set Screw	M8x16	1
57	RM22N-57	Set Screw	M6x6	1
58	RM22N-58	C-Ring	20	1
59	RM22N-59	Pin	5x20	1
60	RM22N-60	Hex Nut	M8	1
	RM22N-61	Spanner Wrench (not shown)		1
	RM22N-ID	ID Label (not shown)		1
	RM22N-W	Warning Label (not shown)		1
	RM22N-J	JET Label (not shown)		1