



OWNER'S MANUAL SR-1650N Slip Roll



JET EQUIPMENT & TOOLS, INC.

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M-754050 03/01

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 MERCHANTABILITY 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 slip roll.

Specifications:

SR-1650N

Stock Number.....	754050
Capacity (mild steel)	16
Maximum Forming Length	50"
Number and Diameter of Rolls	3 and 3"
Minimum Forming Radius	2"
Wire Grooves.....	1/4", 5/16", 3/8"
Overall Dimensions (LxWxH)	68" x 22" x 24"

Uncrating and Clean-Up

1. Remove the crate from around the machine.
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. Coat all machined surfaces with a light coat of oil to inhibit rust.
4. Remove the bolts holding the machine to the skid.
5. Carefully move the machine to a well lighted area on a solid, level work bench, and secure to the bench with lag screws or bolts.
6. Machine location must allow access to all sides.

Front Rolls

The (#) in the text refers to the breakdown.

1. The two front rolls carry the material through as the crank handle #33 is turned in a clockwise direction.
2. The lower roll adjustment knobs #16 are used to move the lower roll #4 up and down for different gauge material.
3. The gap between the two front rolls should be equal at both ends.

Rear Roll

1. The rear roll #5 can be adjusted to control the radius by turning adjustment knobs #17.

2. The gap between the rear roll and the two front rolls should be equal at both ends of the roll to assure an equal radius at both ends of the material.

Releasing the Material

1. Once the material has been rolled release the material from the roll by lifting clamp handle #31.
2. Lift the upper roll #3 and pivot away from the machine so that the material can be removed.

Rolling Wires

There are three wire grooves in the upper and rear rolls that will accommodate a 1/4", 5/16" and a 3/8" wire.

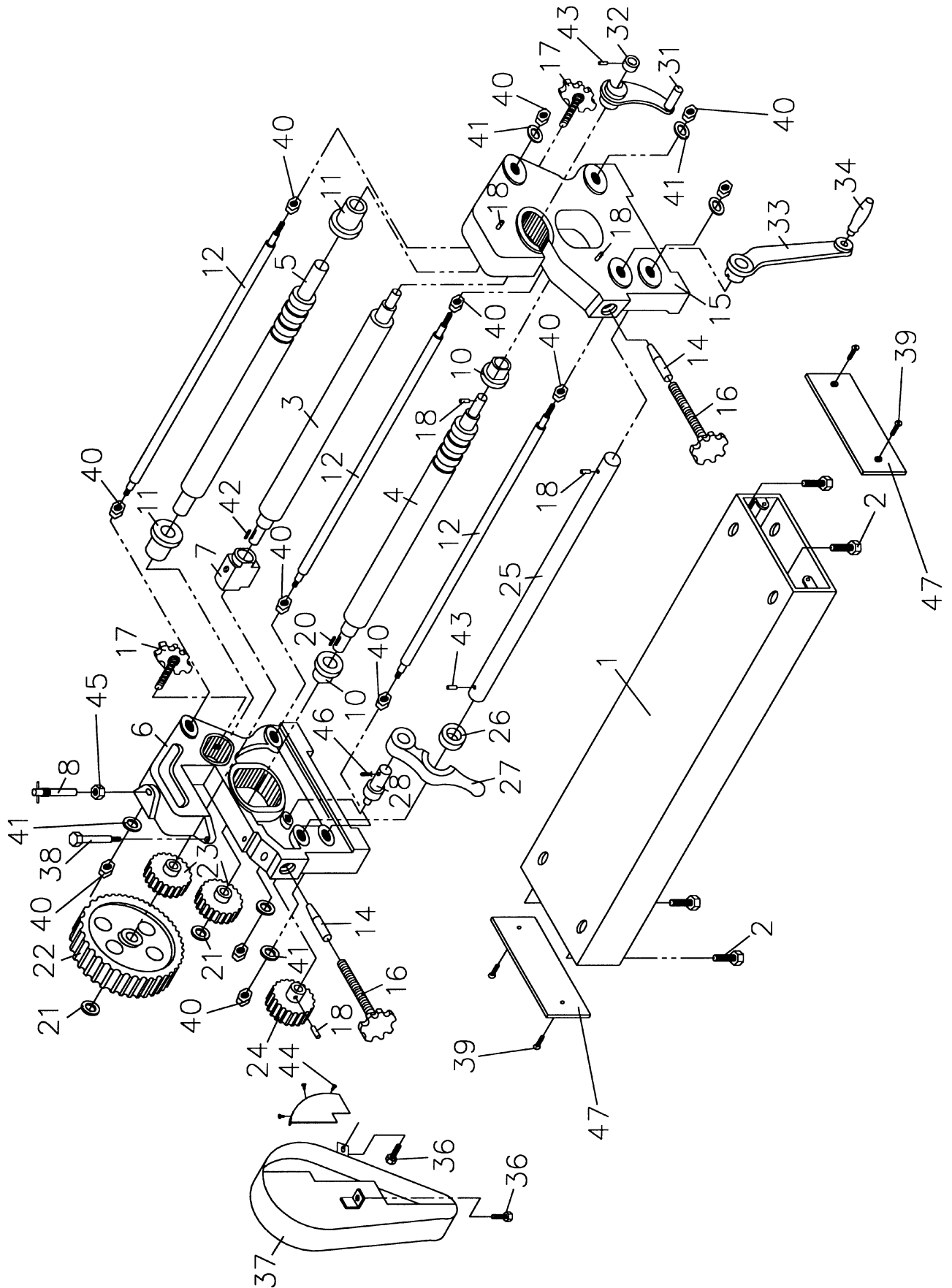
Lubrication

The machine must be lubricated every day of service with a few drops of oil. An oil pinhole is located at both ends of the lower roll #4, rear roll #5, and rod #25. The upper roll #3 has one oil pinhole on the left side. The right side can be lubed by opening the clamp handle #31, and lightly oiling the end of the upper roll shaft.

Every thirty days of operation grease the gears by removing the gear cover #37.

Lightly oil the rolls when not in use to prevent rust.

Breakdown for the SR-1650N Slip Roll



Parts List for the SR-1650N Slip Roll

Index No.	Part No.	Description	Size	Quantity
1	SR1650N-1	Base Assembly		1
2	SR1650N-2	Hex Cap Screw	M16x25	4
3	SR1650N-3	Upper Roll		1
4	SR1650N-4	Lower Roll		1
5	SR1650N-5	Rear Roll		1
6	SR1650N-6	Left Support		1
7	SR1650N-7	Left Upper Roll Seat		1
8	SR1650N-8	Set Rod Assembly		1
10	SR1650N-10	Bushing		2
11	SR1650N-11	Bushing		2
12	SR1650N-12	Set Rod		3
14	SR1650N-14	Pin		2
15	SR1650N-15	Right Support		1
16	SR1650N-16	Knob		2
17	SR1650N-17	Knob		2
18	SR1650N-18	Spring Pin	5x40	5
20	SR1650N-20	Key	8x8x30	2
21	SR1650N-21	C-Ring	28	2
22	SR1650N-22	Gear		1
23	SR1650N-23	Gear		2
24	SR1650N-24	Gear		1
25	SR1650N-25	Rod		1
26	SR1650N-26	Bushing		1
27	SR1650N-27	Stop		1
28	SR1650N-28	Shaft Assembly		1
31	SR1650N-31	Clamp Handle		1
32	SR1650N-32	Bushing		1
33	SR1650N-33	Arm		1
34	SR1650N-34	Handle		1
36	SR1650N-36	Hex Cap Screw	M8x20	2
37	SR1650N-37	Gear Cover Assembly		1
38	SR1650N-38	Hex Socket Bolt	M4x5	1
39	SR1650N-39	Flat Head Screw	M4x5	4
40	SR1650N-40	Hex Nut	M16	12
41	SR1650N-41	Washer	M16	6
42	SR1650N-42	Key	8x8x60	1
43	SR1650N-43	Set Screw	M8x10	1
44	SR1650N-44	Tapping Screw	ST4.3x9	8
45	SR1650N-45	Hex Nut	M20	1
46	SR1650N-46	Cotter Pin	3.2x30	1
47	SR1650N-47	Plate		2
	SR1650N-ID	ID Label (not shown)		1
	SR1650N-W	Warning Label (not shown)		1
	SR1650N-J	JET Label (not shown)		1