



OWNER'S MANUAL

SR-2024N & SR-2236N Slip Roll



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M-754020 01/02

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 slip roll.

This slip roll 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 slip roll, 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 GAUGE RATED CAPACITY** on this slip roll, 20 gauge for SR-2024N and 22 gauge for SR-2236N.
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 rolls.
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:

SR-2024N

SR-2236N

Stock Number.....	754020.....	754026
Capacity (mild steel)	20	22
Maximum Forming Length	24"	36"
Number and Diameter of Rolls	3 and 2".....	3 and 2"
Minimum Forming Radius	1"	1"
Wire Grooves.....	3/16" 1/4", 5/16".....	3/16" 1/4", 5/16"
Overall Dimensions (LxWxH)	37" x 17" x 17".....	49" x 17" x 17"

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 upper and lower rolls #23 & #24 carry the material through as the crank handle #33 is turned in a clockwise direction.
2. The lower roll adjustment knobs #12 are used to move the lower roll #24 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 #25 can be adjusted to control the radius by turning adjustment knobs #13.

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 handle #29. Move the handle bracket out of the way.
2. Lift the upper roll #23 by moving lever #3 to the right so that the material can be removed.

Rolling Wires

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

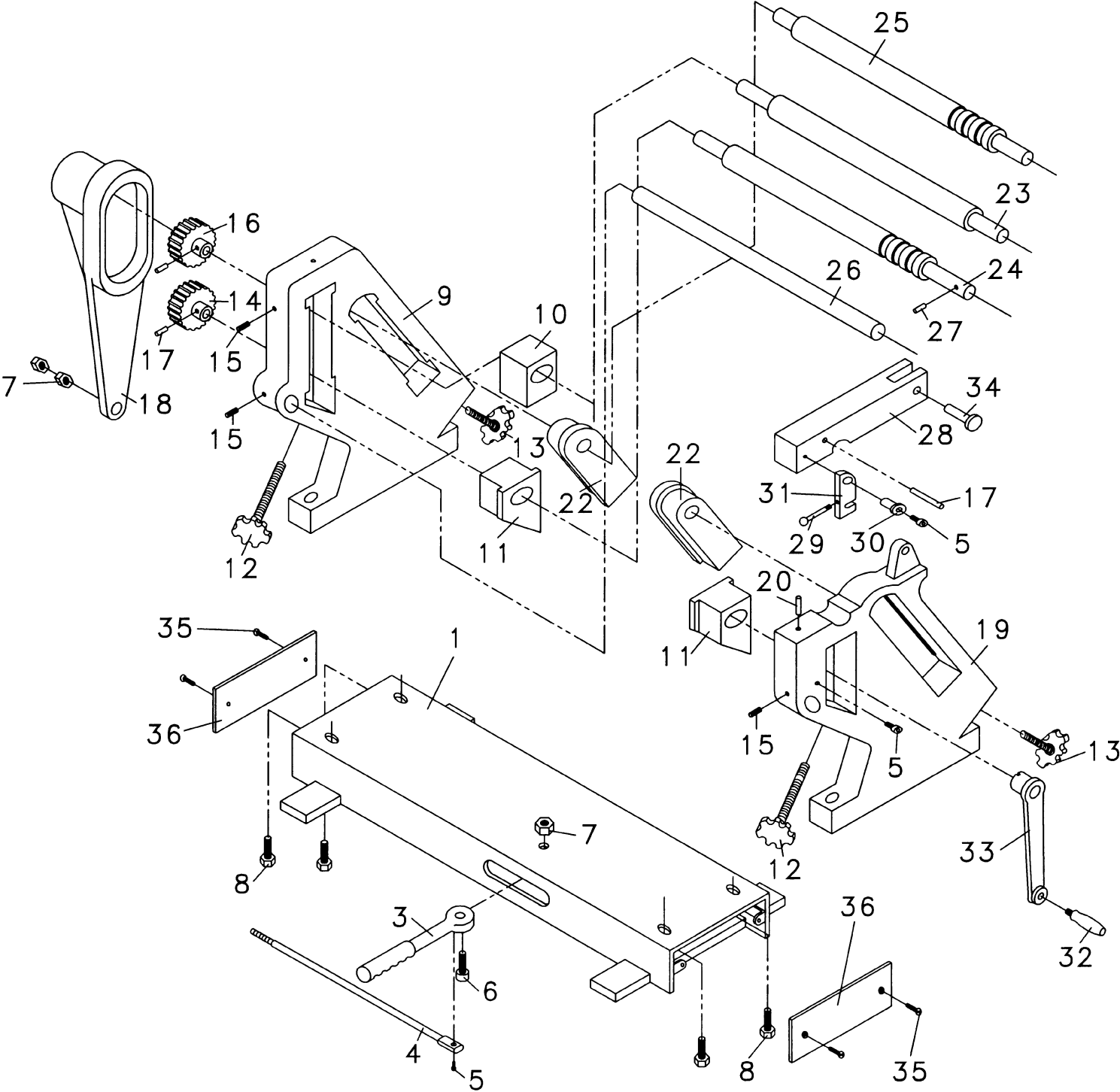
Lubrication

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 #24, and rear roll #25. The upper roll #23 has two oil pinholes on the left side. The right side can be lubed by opening the handle #29, and lightly oiling the end of the upper roll shaft.

Every thirty days of operation grease the gears by removing the outer hex nut #7, and gear cover #18.

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

Breakdown for the SR-2024N & SR-2236N Slip Roll



Parts List for the SR-2024N & SR-2236N Slip Roll

Index No.	Part No.	Description	Size	Quantity
1	SR2024N-1	Base Assembly		1
	SR2236N-1	Base Assembly		1
3	SR2024N-3	Lever		1
4	SR2024N-4	Rod		1
	SR2236N-4	Rod		1
5	SR2024N-5	Socket Head Cap Screw	M8x20	3
6	SR2024N-6	Socket Head Cap Screw	M10x25	1
7	SR2024N-7	Hex Nut	M10	3
8	SR2024N-8	Hex Cap Screw	M12x25	4
9	SR2024N-9	Left Support		1
10	SR2024N-10	Upper Left Bearing Seat		1
11	SR2024N-11	Lower Left Bearing Seat		2
12	SR2024N-12	Knob		2
13	SR2024N-13	Knob		2
14	SR2024N-14	Gear		1
15	SR2024N-15	Set Screw	M8x8	3
16	SR2024N-16	Gear		1
17	SR2024N-17	Spring Pin	5x20	3
18	SR2024N-18	Gear Cover		1
19	SR2024N-19	Right Support		1
20	SR2024N-20	Spring Pin	8x20	1
22	SR2024N-22	Bearing Seat		2
23	SR2024N-23	Upper Roll		1
	SR2236N-23	Upper Roll		1
24	SR2024N-24	Lower Roll		1
	SR2236N-24	Lower Roll		1
25	SR2024N-25	Rear Roll		1
	SR2236N-25	Rear Roll		1
26	SR2024N-26	Link Rod		1
	SR2236N-26	Link Rod		1
27	SR2024N-27	Spring Pin	8x45	1
28	SR2024N-28	Cover		1
29	SR2024N-29	Handle		1
30	SR2024N-30	Cam		1
31	SR2024N-31	Handle Bracket		1
32	SR2024N-32	Handle		1
33	SR2024N-33	Arm		1
34	SR2024N-34	Pin		1
35	SR2024N-35	Flat Head Screw	M4x5	4
36	SR2024N-36	Plate		2
	SR2024N-ID	ID Label (not shown)		1
	SR2236N-ID	ID Label (not shown)		1
	SR2024N-W	Warning Label (not shown)		1
	SR2024N-J	JET Label (not shown)		1