

JET[®]

OWNER'S MANUAL RM-22T Rotary Machine



WALTER MEIER (Manufacturing) Inc.

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Part No. M-756022

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Warranty and Service

Walter Meier (Manufacturing) Inc., warrants every product it sells. If one of our tools needs service or repair, one of our Authorized Service Centers located throughout the United States can give you quick service. In most cases, any of these Walter Meier Authorized Service Centers can authorize warranty repair, assist you in obtaining parts, or perform routine maintenance and major repair on your JET® tools. For the name of an Authorized Service Center in your area call 1-800-274-6848.

MORE INFORMATION

Walter Meier is consistently adding new products to the line. For complete, up-to-date product information, check with your local Walter Meier distributor, or visit waltermeier.com.

WARRANTY

JET products carry a limited warranty which varies in duration based upon the product (MW = Metalworking, WW = Woodworking).

90 DAY WARRANTY	1 YEAR WARRANTY	Body Repair Kits Bottle Jacks Cable Pullers Cold Saws Hoists-Air Hoists-Electric Metal forming Mill/Drills Milling Machines MW Bandsaws MW Drill Presses MW Finishing Equipment MW Lathes MW Precision Vises	2 YEAR WARRANTY	Palet Trucks Rigging Equip. Service Jacks Stackers Surface Grinders Tapping Trolleys-Air Trolleys-Electric Web Slings Winches-Electric	3 YEAR WARRANTY	WW Benchtop Tools	5 YEAR WARRANTY	Beam Clamps Chain Hoist-Manual Lever Hoists Pullers-JCH Models Scissor Lift Tables Screw Jacks Trolleys-Geared Trolleys-Plain Winches-Manual WW Air Filtration WW Bandsaws WW Buffers	WW Drill Presses WW Dust Collectors WW Dust Filters WW Dust Fittings WW Jointers WW Lathes WW Planers WW Sanders WW Shapers WW Tablesaws	LIFE LIFETIME WARRANTY	Fastening Tools Mechanics Hand Tools Striking Tools Vises (no-precision) Clamps
Warranty reverts to 1 Year Warranty if woodworking (WW) products listed above are used for industrial or educational purposes.											

WHAT IS COVERED?

This warranty covers any defects in workmanship or materials subject to the exceptions stated below. Cutting tools, abrasives and other consumables are excluded from warranty coverage.

WHO IS COVERED?

This warranty covers only the initial purchaser of the product.

WHAT IS THE PERIOD OF COVERAGE?

The general JET warranty lasts for the time period specified in the product literature of each product.

WHAT IS NOT COVERED?

Five Year Warranties do not cover woodworking (WW) products used for commercial, industrial or educational purposes. Woodworking products with Five Year Warranties that are used for commercial, industrial or education purposes revert to a One Year Warranty. This warranty does not cover defects due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair or alterations, or lack of maintenance.

HOW TO GET SERVICE

The product or part must be returned for examination, postage prepaid, to a location designated by us. For the name of the location nearest you, please call 1-800-274-6848.

You must provide proof of initial purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, we will repair or replace the product, or refund the purchase price, at our option. We will return the repaired product or replacement at our expense unless it is determined by us that there is no defect, or that the defect resulted from causes not within the scope of our warranty in which case we will, at your direction, dispose of or return the product. In the event you choose to have the product returned, you will be responsible for the shipping and handling costs of the return.

HOW STATE LAW APPLIES

This warranty gives you specific legal rights; you may also have other rights which vary from state to state.

LIMITATIONS ON THIS WARRANTY

WALTER MEIER (MANUFACTURING) INC., LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. 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.

WALTER MEIER 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.

Walter Meier sells through distributors only. The specifications in Walter Meier catalogs are given as general information and are not binding. Members of Walter Meier reserve the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever. JET®-branded products are not sold in Canada by Walter Meier.



Warnings

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 have 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 more safely at the rate for which it was designed.
8. **USE THE RIGHT MACHINE.** Do not 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 is 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.

YOUR RISK FROM THESE 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
20. **DO NOT OPERATE TOOL** while under the influence of drugs, alcohol or any medication.

Specifications:

RM-22T

Stock Number.....	756022
Capacity.....	22 gauge
Distance Between Shaft Centers	2"
Depth of Throat to Frame.....	7"
Overall Dimensions (LxWxH).....	18"x8"x16"
Net Weight	64 lbs.

Uncrating and Clean-Up

1. Remove the RM-22T 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

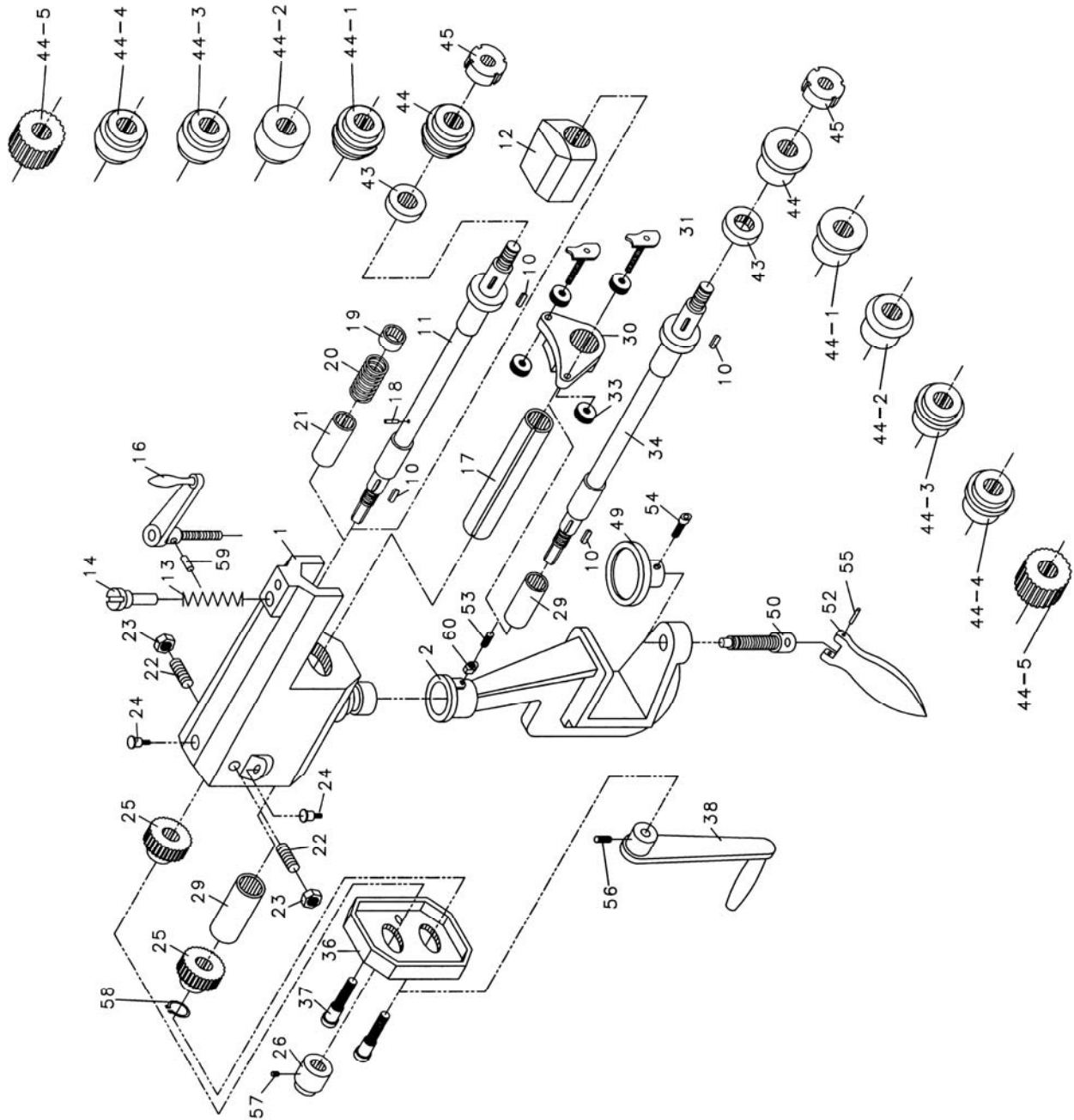
1. There are two grease fittings #24 that need to be greased once a month.
2. The machine must be lubricated every day of service with a few drops of oil. An oil pinhole is located at the end of the lower shaft #34, and upper shaft #11.
3. Every thirty days of operation grease the gears by removing the 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-22T Rotary Machine



Parts List for the RM-22T 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



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