



# Operating Instructions and Parts Manual SR-1650M Slip Roll



## **JET**

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**Part No. M-756050**  
Revision B 12/2015  
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# Warranty and Service

JET warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

## Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official JET branded website.

- JET products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer's defects.

## Who is Covered

This warranty covers only the initial purchaser of the product from the date of delivery.

## What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance. JET woodworking machinery is designed to be used with Wood. Use of these machines in the processing of metal, plastics, or other materials may void the warranty. The exceptions are acrylics and other natural items that are made specifically for wood turning.

## Warranty Limitations

Woodworking products with a Five Year Warranty that are used for commercial or industrial purposes default to a Two Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

## How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. JET has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the JET website.

## More Information

JET is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the JET website.

## How State Law Applies

This warranty gives you specific legal rights, subject to applicable state law.

## Limitations on This Warranty

JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN 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.

JET sells through distributors only. The specifications listed in JET printed materials and on official JET website are given as general information and are not binding. JET reserves 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 JPW Industries, Inc.

## Product Listing with Warranty Period

90 Days – Parts; Consumable items
1 Year – Motors; Machine Accessories
2 Year – Metalworking Machinery; Electric Hoists, Electric Hoist Accessories; Woodworking Machinery used for industrial or commercial purposes
5 Year – Woodworking Machinery
Limited Lifetime – JET Parallel clamps; VOLT Series Electric Hoists; Manual Hoists; Manual Hoist Accessories; Shop Tools; Warehouse & Dock products; Hand Tools; Air Tools

NOTE: JET is a division of JPW Industries, Inc. References in this document to JET also apply to JPW Industries, Inc., or any of its successors in interest to the JET brand.



# Warnings

**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 16 GAUGE RATED CAPACITY** on this slip roll.
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.

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

## Specifications

Stock Number.....	756050
Model Number.....	SR-1650M
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"
Net Weight .....	.565 lb

*Note: The following photos show the slip roll mounted to the optional stand (stock no. #754051). To order this item, contact your dealer or JET customer service using the phone number on the cover.*

## 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, and enough room to load/unload sheet metal.

### Front Rolls

1. The two front rolls (A, Figure 1) carry the material through as the crank handle (B) is turned in a clockwise direction.
2. The lower roll adjustment knobs (C) are used to move the lower roll up and down for different gauge material.
3. The gap between the two front rolls should be equal at both ends.

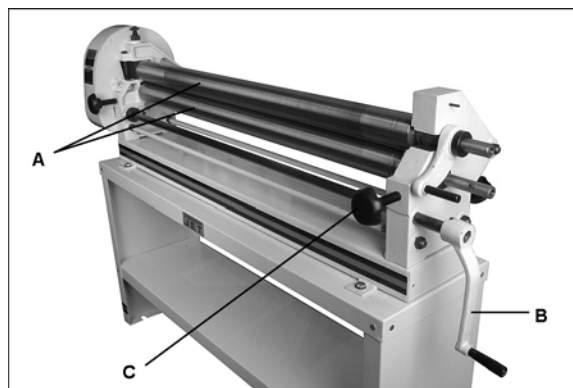


Figure 1

### Rear Roll

1. The rear roll (D, Figure 2) can be adjusted to control the radius by turning adjustment knobs (E).
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.

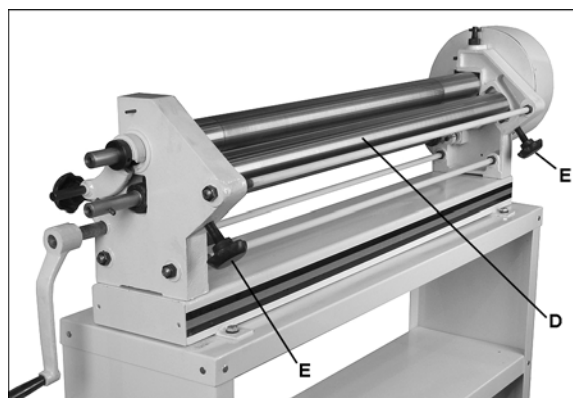


Figure 2

## Releasing the Material

1. Once material has been rolled, release it from roll by lifting clamp handle (Figure 3).
2. Lift upper roll and pivot away from machine, so that material can be removed.

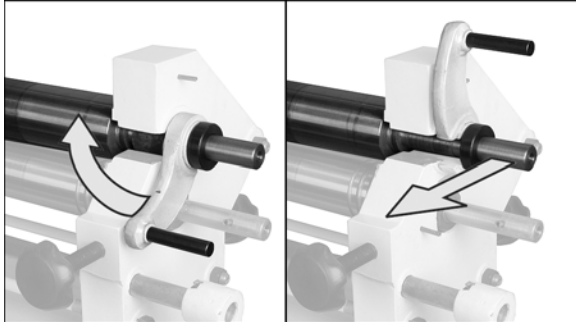


Figure 3

## Ratios

The SR-1650M has two ratios:

- 1:1 – place handle on upper rod,
- 5:1 – place handle on lower rod.

To disengage, lift stop (F) and pull rod (G) to the left.



Figure 4

## 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

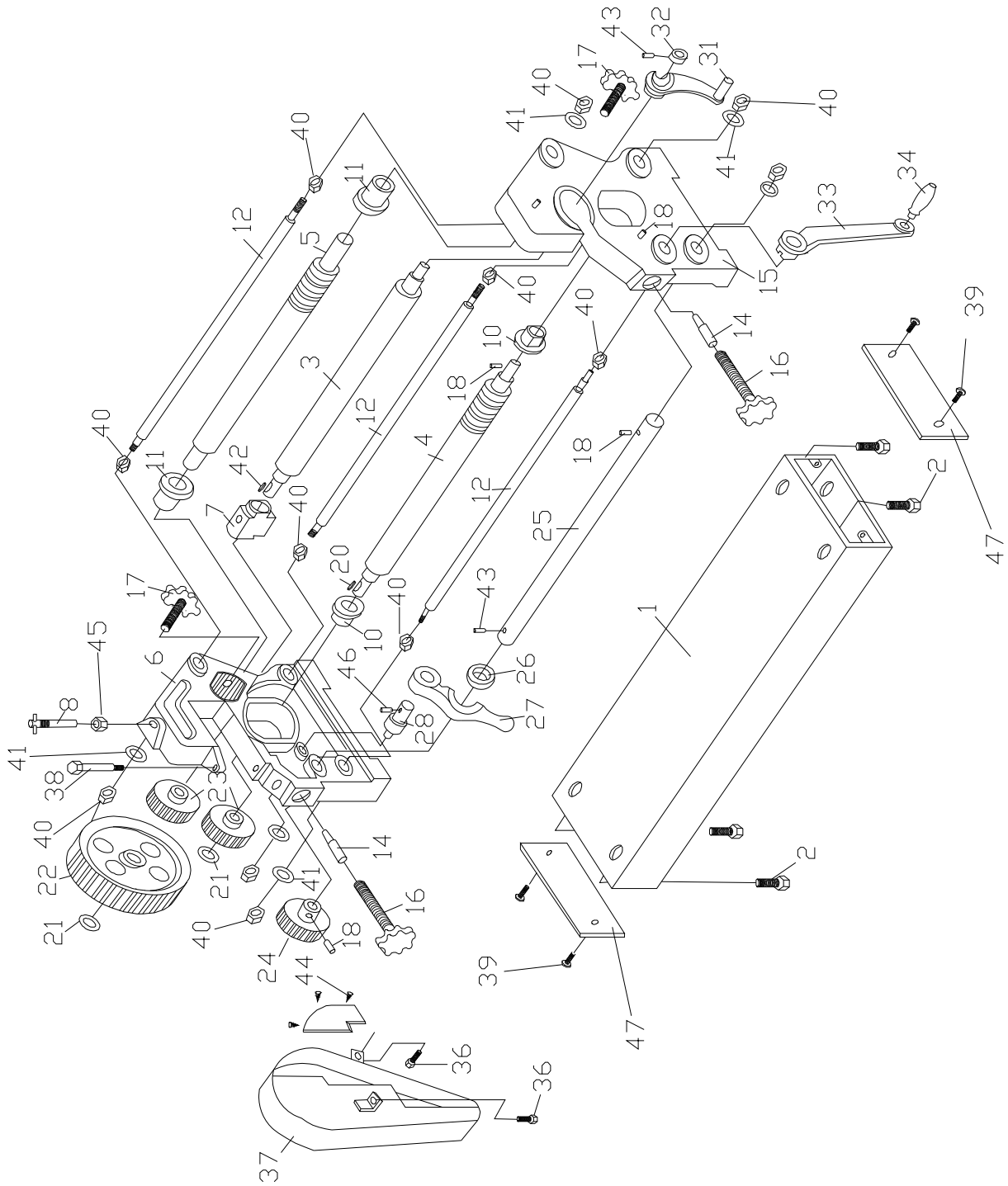
*(Numbers in parentheses refer to parts breakdown.)*

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, remove the gear cover (37) and grease the gears.

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

# Breakdown for the SR-1650M Slip Roll



## Parts List for the SR-1650M Slip Roll

Index No.	Part No.	Description	Size	Quantity
1	SR1650N-1G	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-6G	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-15G	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-27G	Stop		1
28	SR1650N-28	Shaft Assembly		1
31	SR1650N-31G	Clamp Handle		1
32	SR1650N-32	Bushing		1
33	SR1650N-33G	Arm		1
34	SR1650N-34	Handle		1
36	SR1650N-36	Hex Cap Screw	M8x20	2
37	SR1650N-37G	Gear Cover Assembly		1
38	SR1650N-38	Hex Socket Bolt	M12x130	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-47G	Plate		2
	SR1650M-ID	ID Label (not shown)		1
	SR1650N-W	Warning Label (not shown)		1
	JET-113	JET Logo with adhesive	113 x 47mm	1



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