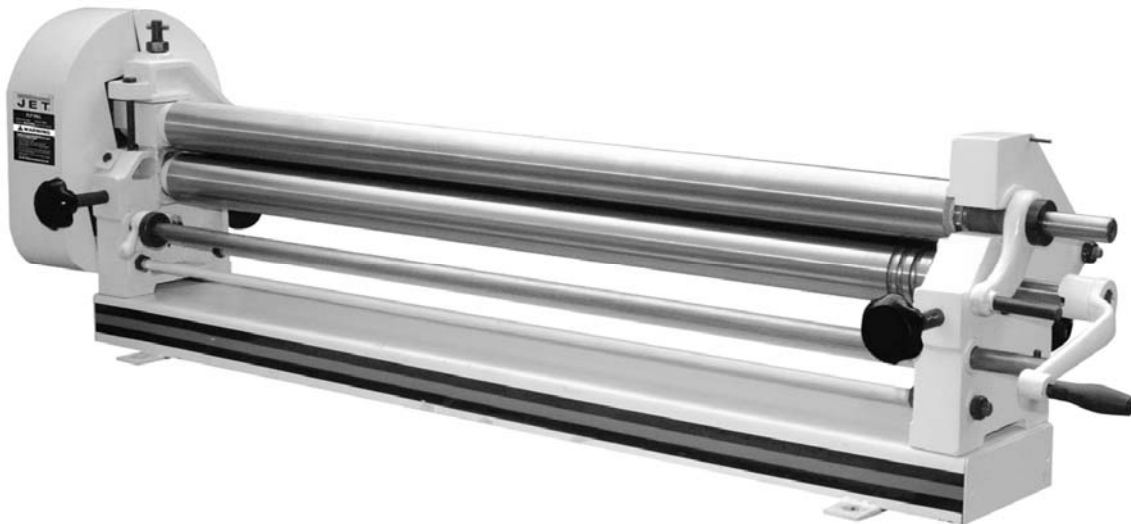




# Operating Instructions and Parts Manual SR-1650M Slip Roll



**WALTER MEIER (Manufacturing) Inc.**

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**Part No. M-756050**

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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](http://waltermeier.com).

### WARRANTY

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

<b>90 DAY WARRANTY</b> Lathe Accessories Machine Accessories Mobile Bases Safety Equipment Specialty Items Vise Accessories	<b>1 YEAR WARRANTY</b> Air Tools-Contractor Air Tools-Industrial Air Tools-Light Industrial Lubrication	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	<b>2 YEAR WARRANTY</b> Pallet Trucks Rigging Equip. Service Jacks Stackers Surface Grinders Tapping Trolleys-Air Trolleys-Electric Web Slings Winches-Electric	<b>3 YEAR WARRANTY</b> WW Benchtop Tools	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	<b>5 YEAR WARRANTY</b> WW Drill Presses WW Dust Collectors WW Dust Filters WW Dust Fittings WW Jointers WW Lathes WW Planers WW Sanders WW Shapers WW Tablesaws	<b>LIFE WARRANTY</b> 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 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 Walter Meier 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.

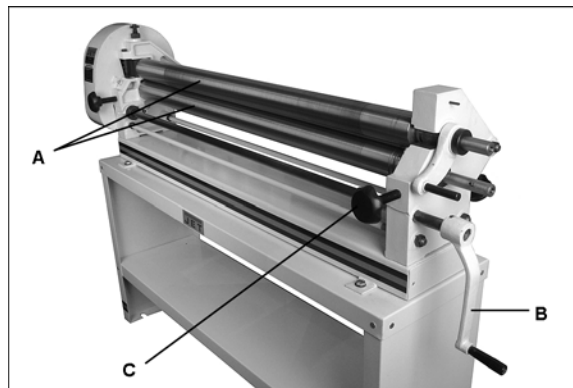


Figure 1

### 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.

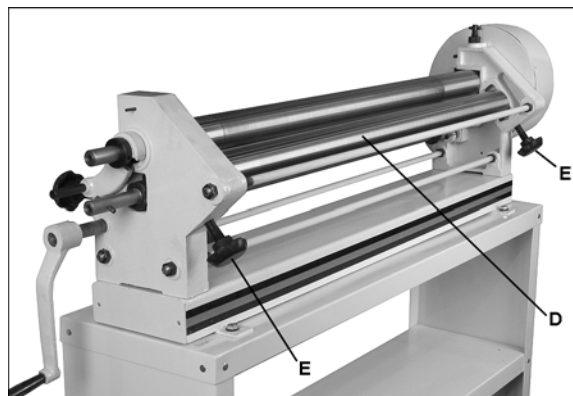


Figure 2

## 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.

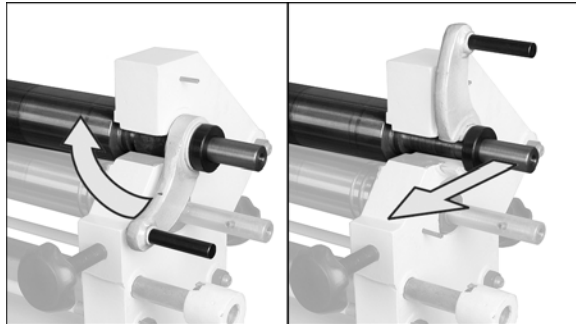


Figure 3

## 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

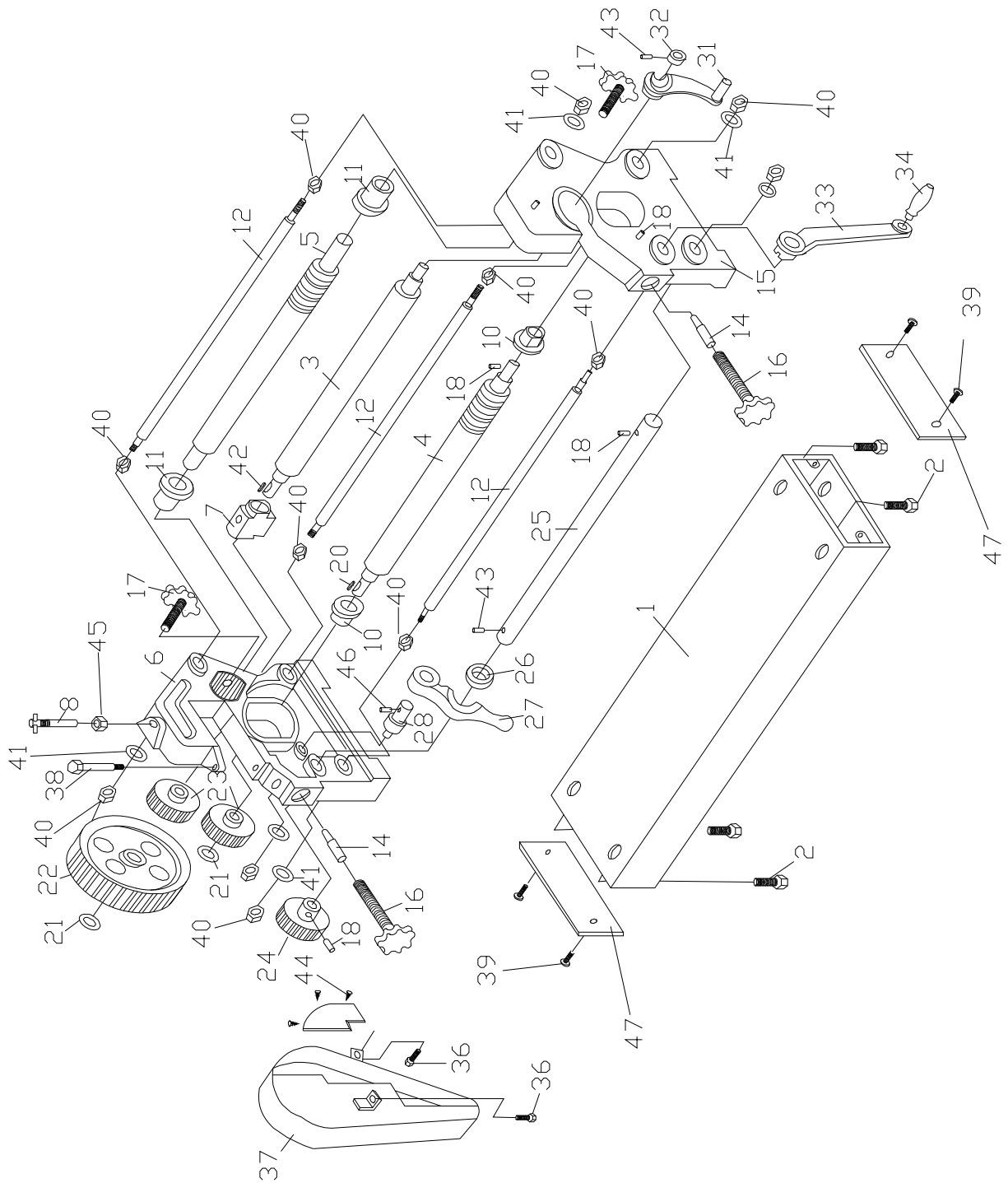
*(Numbers in parentheses refer to parts breakdown.)*

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-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.....	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-47 .....	Plate.....		2
.....	SR1650M-ID .....	ID Label (not shown).....		1
.....	SR1650N-W.....	Warning Label (not shown) .....		1
.....	SR1650N-J .....	JET Label (not shown).....		1



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