# Operating Instructions and Parts Manual
# 14ga. x 60in. Electric Plate Roller
## Model EPR-1460-3


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**Part No. M-756030**
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# 1.0 IMPORTANT SAFETY INSTRUCTIONS

**WARNING – To reduce risk of injury:**

1. Read and understand the entire owner's manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace warning labels if they become obscured or removed.
4. This electric plate roller 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 plate roller, do not use it until proper training and knowledge have been obtained.
5. Do not use this plate roller for other than its intended use. If used for other purposes, JET disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear ANSI Z87.1 approved safety glasses or face shield while using this machine. (Everyday eyeglasses only have impact resistant lenses; they are *not* safety glasses.)
7. Wear ear protectors (plugs or muffs) if noise exceeds safe levels.
8. Make certain the machine is properly grounded.
9. Before operating the machine, remove tie, rings, watches, other jewelry, and roll sleeves up past the elbows. Remove all loose clothing and confine long hair.
10. Keep the floor around the machine clean and free of scrap material, oil and grease.
11. Keep machine guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately upon completion of maintenance.
12. 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.
13. Make all machine adjustments or maintenance with machine unplugged from power source.
14. Use the right tool. Do not force a tool or attachment to do a job that it was not designed to do.
15. Make certain the switch is in the **OFF** position before connecting the machine to the power supply.
16. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
17. Give your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.
18. Keep visitors a safe distance from the work area. Keep children away.
19. Make your workshop child proof with padlocks, master switches or by removing starter keys.
20. Do not overreach. Failure to maintain proper working position can cause you to fall into the machine or allow clothing to get caught, pulling you into the machine.
21. Keep the floor around the machine clean and free of scrap material, oil and grease.
22. Use recommended accessories; improper accessories may be hazardous.
23. Do not operate this machine while under the influence of drugs, alcohol or any medication.
24. Keep tools sharp and clean for safe and best performance.
25. Deburr any sharp metal edges of the workpiece before placing it into the machine.
26. Keep hands away from the moving rolls.
27. Provide for adequate space surrounding work area and non-glare, overhead lighting.
28. Don't use in dangerous environment. Don't use power tools in damp or wet locations, or expose them to rain.
29. Do not stand on the machine. Serious injury could occur if the machine tips over.
30. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
31. Use only JET factory authorized replacement parts and accessories; otherwise, the warranty and guarantee are null and void.
32. The plate roller should be anchored to the floor.

33. Use proper extension cord. Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Table 1 *(sect. 8.3)* shows correct size to use depending on cord length and nameplate ampere rating. If in doubt, use the next heavier gage. The smaller the gage number, the heavier the cord.

⚠ **WARNING:** This product can expose you to chemicals including lead which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to http://www.p65warnings.ca.gov.

⚠ **WARNING:** Some dust, fumes and gases created by power sanding, sawing, grinding, drilling, welding and other construction activities contain chemicals known to the State of California to cause cancer and birth defects or other reproductive harm. Some examples of these chemicals are:

- lead from lead based paint
- crystalline silica from bricks, cement and other masonry products
- arsenic and chromium from chemically treated lumber

Your risk of exposure 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 dust masks that are specifically designed to filter out microscopic particles. For more information go to http://www.p65warnings.ca.gov/ and http://www.p65warnings.ca.gov/wood.

**Familiarize yourself with the following safety notices used in this manual:**

**⚠CAUTION** This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.

**⚠WARNING** This means that if precautions are not heeded, it may result in serious, or possibly even fatal, injury.

## SAVE THESE INSTRUCTIONS

# 2.0 About this manual

This manual is provided by JET, covering the safe operation and maintenance procedures for a JET Model EPR-1460 Electric Plate Roller. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. Your machine has been designed and constructed to provide consistent, long-term operation if used in accordance with the instructions as set forth in this document.

If there are questions or comments, please contact your local supplier or JET. JET can also be reached at our web site: www.jettools.com.

Retain this manual for future reference. If the machine transfers ownership, the manual should accompany it.

**⚠WARNING Read and understand the entire contents of this manual before attempting assembly or operation! Failure to comply may cause serious injury!**

**Register your product online -**

http://www.jettools.com/us/en/service-and-support/warranty/registration/

# 3.0 **Table of contents**

**Section** **Page**

# 4.0 **Specifications**

| | |
|---|---|
| Model number | **EPR-1460-3** |
| Stock number | 756030 |

Motor and electricals:

| | |
|---|---|
| Motor type | totally enclosed fan cooled, induction |
| Horsepower | 2HP (1.5kW) |
| Phase | 3 |
| Voltage | 230/460V **(prewired 230V)** |
| Cycle | 60Hz |
| Listed FLA (full load amps) | 5.5 / 3 A |
| Running amps (no load) | 2.7 / 1.8 A |
| Power transfer | chain/gearing |
| Controls | 24V, magnetic contactor |
| Foot switch | satellite foot pedal with E-stop |
| Power cord | 16AWG |
| Power cord length (approx..) | 7 ft. (2.13m) |
| Power plug | not provided |
| Recommended circuit size[1] | 15A |
| Noise emission without load [2] | 60 dB at 60 inches from machine |
| Gear reduction ratio | 1:120 |
| Driven roll speed | 11 RPM |
| Foot pedal wire tube length (approx..) | 6-1/2 ft. (2m) |

Capacities:

| | |
|---|---|
| Maximum thickness – mild steel | 14 gauge |
| Maximum forming length | 60 in. (1524mm) |
| Number of rolls | 3 |
| Diameter of rolls | 3-1/2 in. (89mm) |
| Minimum forming diameter | 5-1/4 in. (133.4mm) |
| Wire grooves | 3/8 in. (9.6mm); 1/2 in. (13mm); 5/8 in. (16mm) |

Main materials:

| | |
|---|---|
| Frame | steel |
| Stand | steel |
| Rolls | high-carbon steel, ground and polished |

Dimensions:

| | |
|---|---|
| Shipping dimensions (LxWxH) | 87.4 x 31.5 x 48 in. (2220 x 800 x 1219mm) |
| Overall dimensions (LxWxH) | 82.3 x 22 x 39.8 in. (2090 x 560 x 1010mm) |

Weights:

| | |
|---|---|
| Net | 1345 lb. (610 kg) |
| Shipping | 1543 lb. (700 kg) |

*[1] subject to local/national electrical codes*

*[2] The specified values are emission levels and are not necessarily to be seen as safe operating levels. As workplace conditions vary, this information is intended to allow the user to make a better estimation of the hazards and risks involved only.*

*L= length; W=width; H=height*

*The specifications in this manual were current at time of publication, but because of our policy of continuous improvement, JET reserves the right to change specifications at any time and without prior notice, without incurring obligations.*

# 5.0 **Features and Terminology**

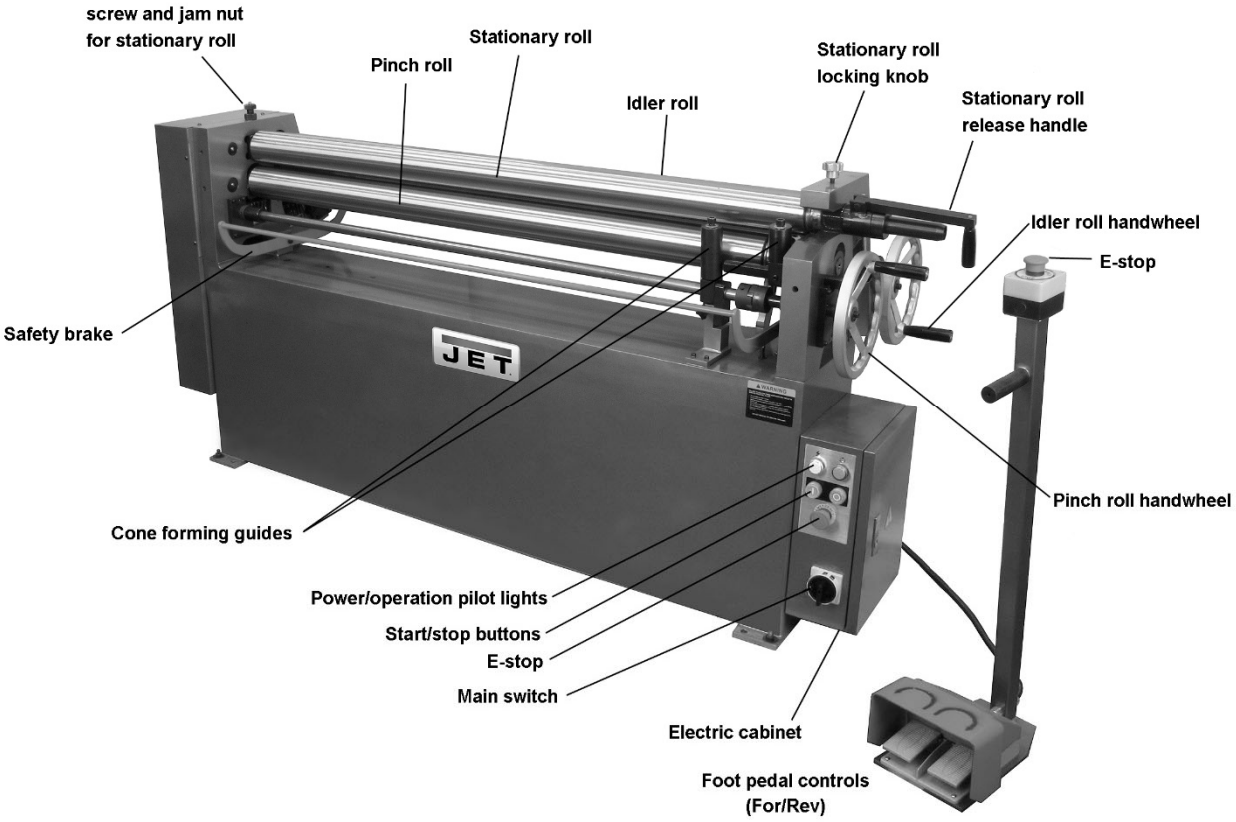



*Figure 5-1: Features*

# 6.0 **Floor mounting holes**

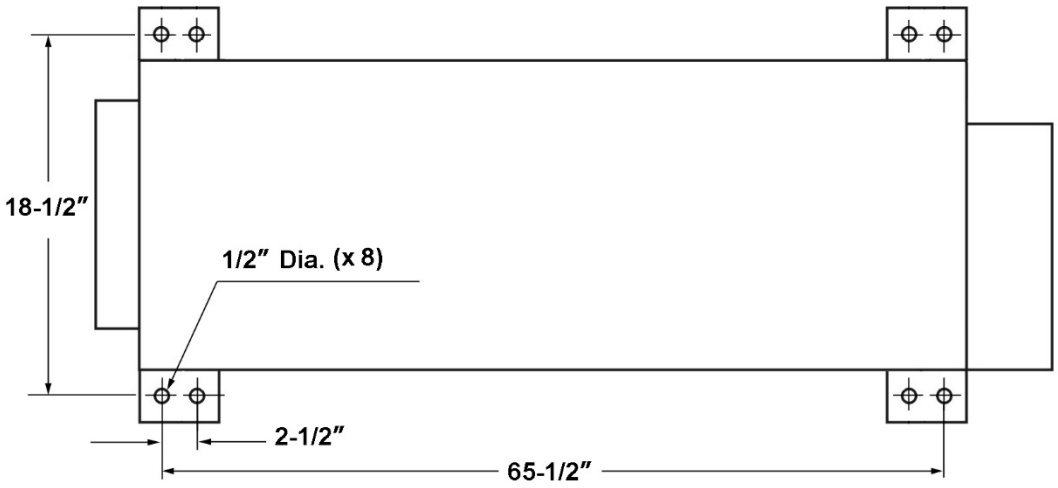



*Figure 6-1: Hole centers*

**⚠WARNING Read and understand the entire contents of this manual before attempting set-up or operation! Failure to comply may cause serious injury.**

# 7.0 Setup and assembly

Open shipping container and check for shipping damage. Report any damage immediately to your distributor and shipping agent. Do not discard any shipping material until the machine is assembled and running properly.

Compare the contents of your container with the following parts list to make sure all parts are intact. Missing parts, if any, should be reported to your distributor. Read the instruction manual thoroughly for assembly, maintenance and safety instructions.

## 7.1 Shipping contents

1 Electric Plate Roller
1 Foot pedal control assembly
1 Operating Instructions and Parts Manual
1 Warranty Card
1 Toolbox (p/n EPR1460-TB), containing:
- 1 Oil can
- 1 Adjustable wrench
- 1 Hex key set
- 1 Grease gun
- 8 Hex cap screws
- 8 Lock washers
- 8 Flat washers
- 8 Hex nuts

## 7.2 Tools required for assembly

Level (not provided)

## 7.3 Positioning and cleanup

Remove all crating from around the plate roller, and use a forklift or hoist with straps to carefully move the machine off the pallet and into position. Lifting equipment must be properly rated for weight of machine.

Position plate roller so there is enough room on all sides for general maintenance and feeding of materials. Anchor machine to a stable floor, preferably concrete, using lag screws or other appropriate fasteners through the four holes in base. Level the machine; use shims if needed.

Exposed metal surfaces have been given a protective coating. Remove this with a soft cloth and a cleaner-degreaser. Do not use gasoline, paint thinner or acetone, as these may damage painted surfaces. Do not use an abrasive pad, as it may scratch polished surfaces.

# 8.0 Electrical connections

**⚠WARNING Electrical connections must be made by a qualified electrician in compliance with all relevant codes. This machine must be properly grounded to help prevent electrical shock and possible fatal injury.**

The EPR-1460 Plate Roller is pre-wired for 230-volt, three-phase operation. It is not provided with a power plug; you may either attach a proper 230V UL-listed plug, or “hardwire” the machine directly to a service panel (make sure a disconnect is available to the operator).

**If used with a plug:**

Grounded, cord-connected tools intended for use on a supply circuit having a nominal rating between 150-250 V inclusive:

This tool is intended for use on a circuit that has an outlet that looks like the one illustrated in Figure 8-1. The tool is intended for use with a grounding plug that looks like the plug illustrated in Figure 8-1. Make sure the tool is connected to an outlet having the same configuration as the plug. No adapter is available or should be used with this tool. If the tool must be reconnected for use on a different type of electric circuit, the reconnection should be made by qualified service personnel; and after reconnection, the tool should comply with all local codes and ordinances.

**If hardwired:**

Permanently connected tools: This tool should be connected to a grounded metal permanent wiring system; or to a system having an equipment-grounding conductor.

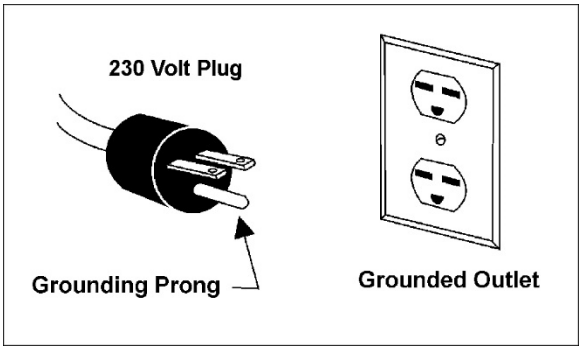



*Figure 8-1: grounding*

## 8.1 Converting to 460V

The plate roller can be converted to 460 volt, as follows:

1. Before connecting to power source, be sure switch is in *off* position. Engage E-stop.
2. Motor junction box: connect the incoming leads to the high voltage terminals, according to the diagram inside the junction box. *Sect. 14.0* includes a similar diagram.

(Note: In case of discrepancy, diagram on machine takes precedence).

3. Transformer: connect line L7 to #13 terminal, and line L8 to #10 terminal. (Do not move the jumper wire.)
4. Overload relay: Change amperage setting to 3.5.
5. If using a plug, replace the 230V plug with a proper 460V, UL-listed plug.

It is recommended that the Plate Roller be connected to a dedicated 15 amp circuit with a circuit breaker or fuse. If connected to a circuit protected by fuses, use time delay fuse marked “D”. **NOTE: Local codes take precedence over recommendations.**

## 8.2 GROUNDING INSTRUCTIONS

This tool must be grounded. In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be inserted into an appropriate outlet that is properly installed and grounded in accordance with all local codes and ordinances.

**⚠WARNING Improper connection of the equipment-grounding conductor can result in a risk of electric shock. Check with a qualified electrician or service person if you are in doubt as to whether the outlet is properly grounded. Do not modify the plug provided with the tool – if it will not fit the outlet, have a proper outlet installed by a qualified electrician.**

The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

Use only 3-wire extension cords that have 3-prong grounding plugs and 3-pole receptacles that accept the tool's plug.

Repair or replace damaged or worn cord immediately.

## 8.3 Extension cords

The use of extension cords is discouraged; try to position equipment within reach of the power source. If an extension cord becomes necessary, be sure it is heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating.

Table 1 shows recommended size to use depending on cord length and nameplate ampere rating. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

| Ampere Rating | | Volts | Total length of cord in feet | | | |
|---|---|---|---|---|---|---|
| More Than | Not More Than | 240 | 50 | 100 | 200 | 300 |
| | | | AWG | | | |
| 0 | 6 | | 18 | 16 | 16 | 14 |
| 6 | 10 | | 18 | 16 | 14 | 12 |
| 10 | 12 | | 16 | 16 | 14 | 12 |
| 12 | 16 | | 14 | 12 | Not Recommended | |

*Extension Cord Recommendations*

*Table 1*

# 9.0 Operation

## 9.1 Controls

**Power light**: Indicates current is flowing to machine.

**Operation light**: Indicates machine is in motion.

**Start/stop button.**

**Emergency stop**: Push E-stop button (one on control panel, one on foot pedal post) for immediate shut-down of machine. To re-start machine, rotate E-stop button clockwise until it disengages. It is recommended that E-stop buttons be used for emergency shutdowns; use stop button on electric box for normal shutdown.

**Main switch:** When turned on, power light will illuminate.

**Foot pedals:** Two pedals for instant forward or reverse motion.

**Safety brake** (see Figure 5-1): Machine will shut off if this is pushed down by operator or contacted by a workpiece.

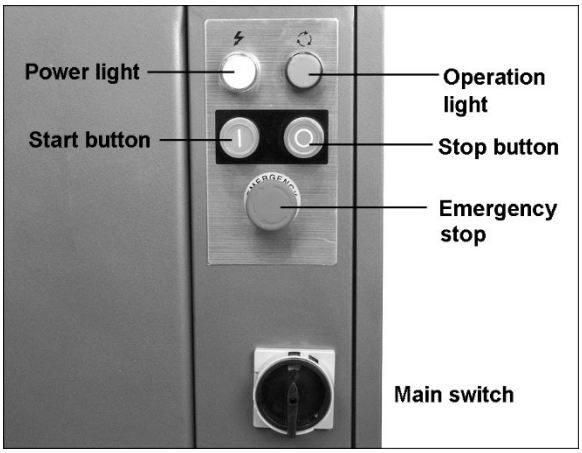



*Figure 9-1: control panel*

## 9.2 **Roll adjustment**

*(Figure 5-1 identifies machine elements.)*

The front handwheel raises or lowers the pinch roll (counterclockwise to raise), so that the correct gap between stationary and pinch rolls may be obtained to feed the stock into the machine.

The rear handwheel raises or lowers the idler roll (clockwise to raise) which determines degree of bend in the stock that is being fed through the machine. A scale near the rear handwheel will aid the operator.

To adjust rolls for material thickness:

1. Insert material between the rolls from front of machine, and raise pinch roll until material fits tightly.
2. Raise idler roll to desired position for bend.

No exact formula can be followed when making these roll adjustments because material "spring back" varies with the kind of material being formed. Only by test forming several pieces can the correct adjustments be obtained. Also, keep in mind that it is much easier to re-pass material to make a smaller radius than it is to attempt to increase a radius that was made too small.

Rolls must be adjusted exactly parallel or the material will spiral during the rolling process. The gearing and transmission shafts on the EPR-1460 ensure parallel movement as the handwheels are rotated.

NOTE: Deliberately setting rolls non-parallel is done to make cone shapes (see *sect. 10.6)*. If rolls have been adjusted for cone forming, check gap between rollers with calipers, and reset them to parallel.

The stationary, or top, roll is secured at its left end with a screw and jam nut (see Figure 1). These have been positioned by the manufacturer, but can be adjusted if needed.

# 10.0 **Forming the workpiece**

**⚠WARNING The rolls present a pinch point and/or crush hazard. Do not place hands in close proximity to rolls while operating.**

## 10.1 **Material size considerations**

To determine approximate length of material needed for a desired size tube, use the following formula:

$$C = \pi D$$

where $C$ is the circumference,
$\pi$ equals 3.1417
and $D$ is the diameter.

For example: To find length of material needed (*C*) to form a tube 4" in diameter, multiply 3.1417 by 4". Result: 12.5667" is the circumference of approximate length of material needed. Cut several pieces of material to this length for a forming test run. Material may have to be lengthened or shortened depending upon results of the test run.

If workpiece is large, make sure it receives proper support as it exits machine.

## 10.2 **Flat rolling**

Softer metals (copper, aluminum, etc.) can be processed through the machine to straighten, flatten, or reduce their thickness. Simply adjust pinch roll for thickness, lower idler roll to same height as pinch roll, and feed workpiece through (Figure 10-1).

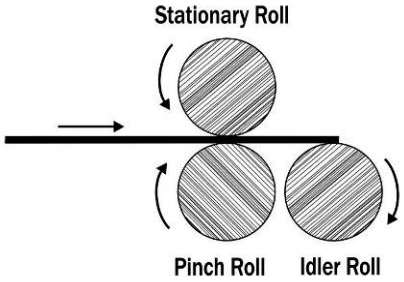



*Figure 10-1*

## 10.3 **Forming a radius**

1. Adjust pinch roll as needed (see *sect. 10.6*).
2. Turn on machine and insert workpiece from the front. Make sure stationary roll is rotating counterclockwise.
3. When material reaches the point where the radius is to begin (Figure 10-2), stop machine and raise idler roll to achieve desired bend.
4. Restart rolls and continue until bend is completed (Figure 10-2). Support workpiece as it exits machine.
5. If a smaller radius is needed, adjust idler roll distance and re-feed workpiece.

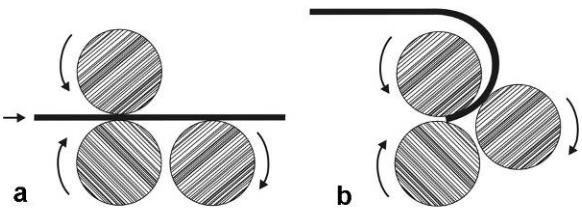



*Figure 10-2*

## 10.4 **Forming a tube**

A tube can often be made with a single pass through the machine, as follows:

1. Adjust pinch roll as needed to accommodate workpiece thickness.
2. Feed workpiece into machine. As it nears the end (Figure 10-3a), stop machine and reverse direction (Figure 10-3b).

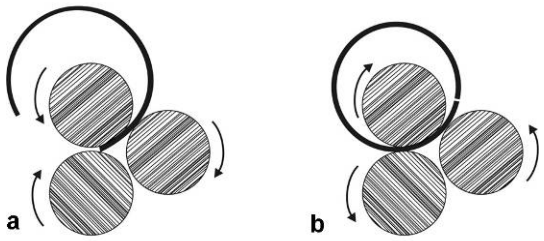



*Figure 10-3*

3. To remove tube from stationary roll:
4. Position cone forming guides out of the way.
5. Loosen knob (A, Figure 10-4), pull handle upward, then toward front. Pull stationary roll out of notch.
6. After tube is removed, reposition stationary roll, making sure handle is rotated back to original position. Tighten knob (A).

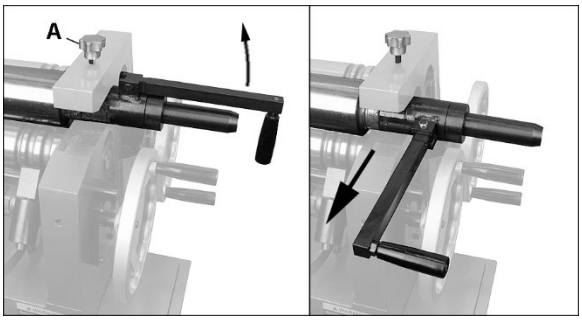



*Figure 10-4*

## 10.5 **Bending wire**

There are three wire grooves at the end of pinch roll and idler roll, to accommodate 3/8, 1/2, and 5/8-inch wire. See Figure 10-5.

Loosen cone forming guide (B, Figure 10-5) and swing it out of the way or remove it.

Use smallest groove into which wire will comfortably fit. Bend the wire using same principles as described for forming a radius. To make a complete loop of wire, use the instructions for forming a tube.

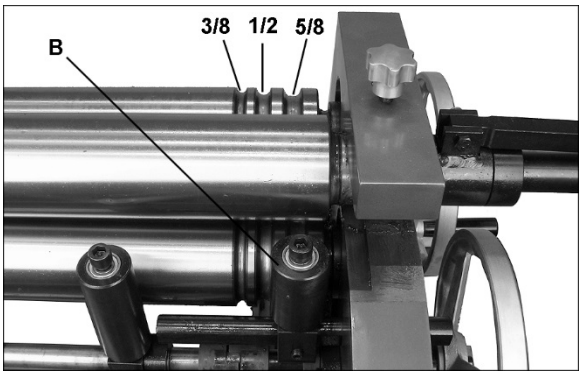



*Figure 10-5*

## 10.6 **Forming a cone**

1. Prepare workpiece to appropriate shape for desired cone.
2. Adjust idler roll and/or pinch roll to allow more free space at left end of rolls. This is done by disengaging clutch coupling, as follows:

   *Idler roll:* Pull pin (C, Figure 10-6) to disengage from groove. Pull out on handwheel until pin engages next groove. Rotating handwheel will now raise or lower right end only of idler roll. (Reverse procedure to re-engage).

   *Pinch roll:* Loosen set screw in left half of bushing (D, Figure 10-7), and slide it away. A flat blade screwdriver may be needed for initial prying apart. (When re-engaging, use a small threaded clamp to push halves together, then tighten set screw.)

3. Slide workpiece against cone forming guide (Figure 10-8) and tightly clamp workpiece at right end. Proceed with forming operation.

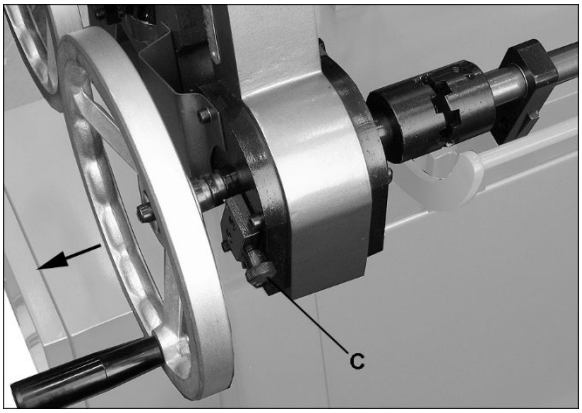



*Figure 10-6: Idler roll disengagement*

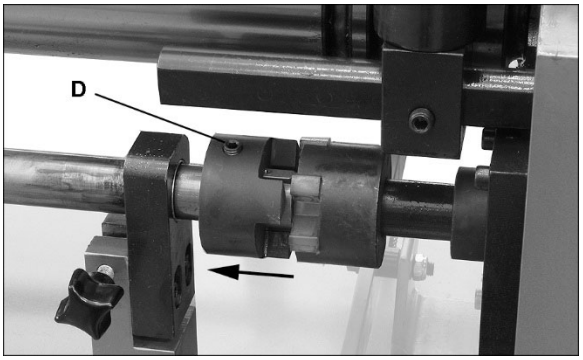



*Figure 10-7: Pinch roll disengagement*

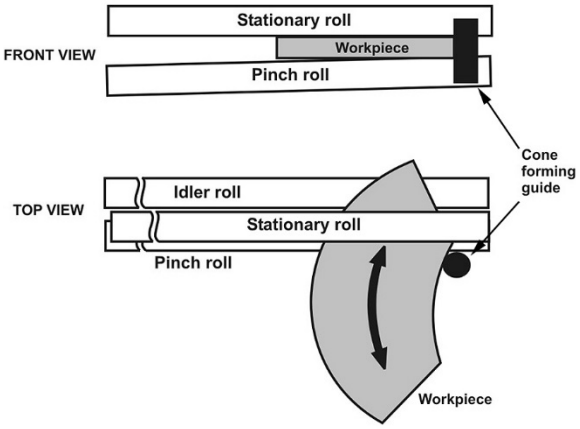



*Figure 10-8: cone forming*

# 11.0 User-maintenance

## 11.1 General maintenance

Keep the rolls clean and rust-free, and periodically apply a light film of oil to their surfaces.

## 11.2 Lubrication

A general-purpose lithium grease is recommended for the following:

Keep gears lubricated. (Remove left side cover to access gears and chain.) Operate machine to disperse the grease.

Apply grease to right end of stationary roll where it slides in and out of notch.

Insert grease into each of 5 fittings, shown in Figure 11-1.

## 11.3 Additional servicing

Any additional servicing should be performed by an authorized JET service center.

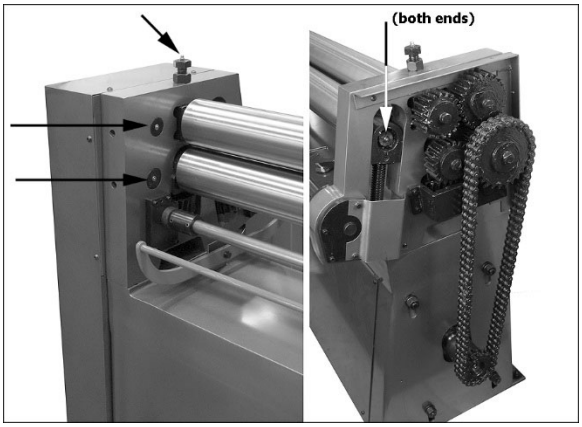



*Figure 11-1: oil fittings*

# 12.0 **Troubleshooting EPR-1460 Plate Roller**

*Table 2*

| Symptom | Possible Cause | Correction * |
|---|---|---|
| Machine doesn't operate; rolls won't move. | No incoming power. | Check power source and connections. |
| | Emergency stop engaged. | Release emergency stop switch by rotating clockwise (check both switch locations). |
| | Jam nut is loose. | Tighten nut to secure stationary roll. |
| | Gears damaged. | Inspect gears; repair/replace as needed. |
| Cones are made when trying to make cylinders. | Rolls not parallel. | Adjust idler (rear) roll as needed until idler roll is parallel to stationary (top) roll. |
| Workpiece is not bending. | Machine capacity exceeded. | Use materials within machine's capacity. |
| | Idler roll not engaging. | Inspect idler roll; make adjustments as needed. |

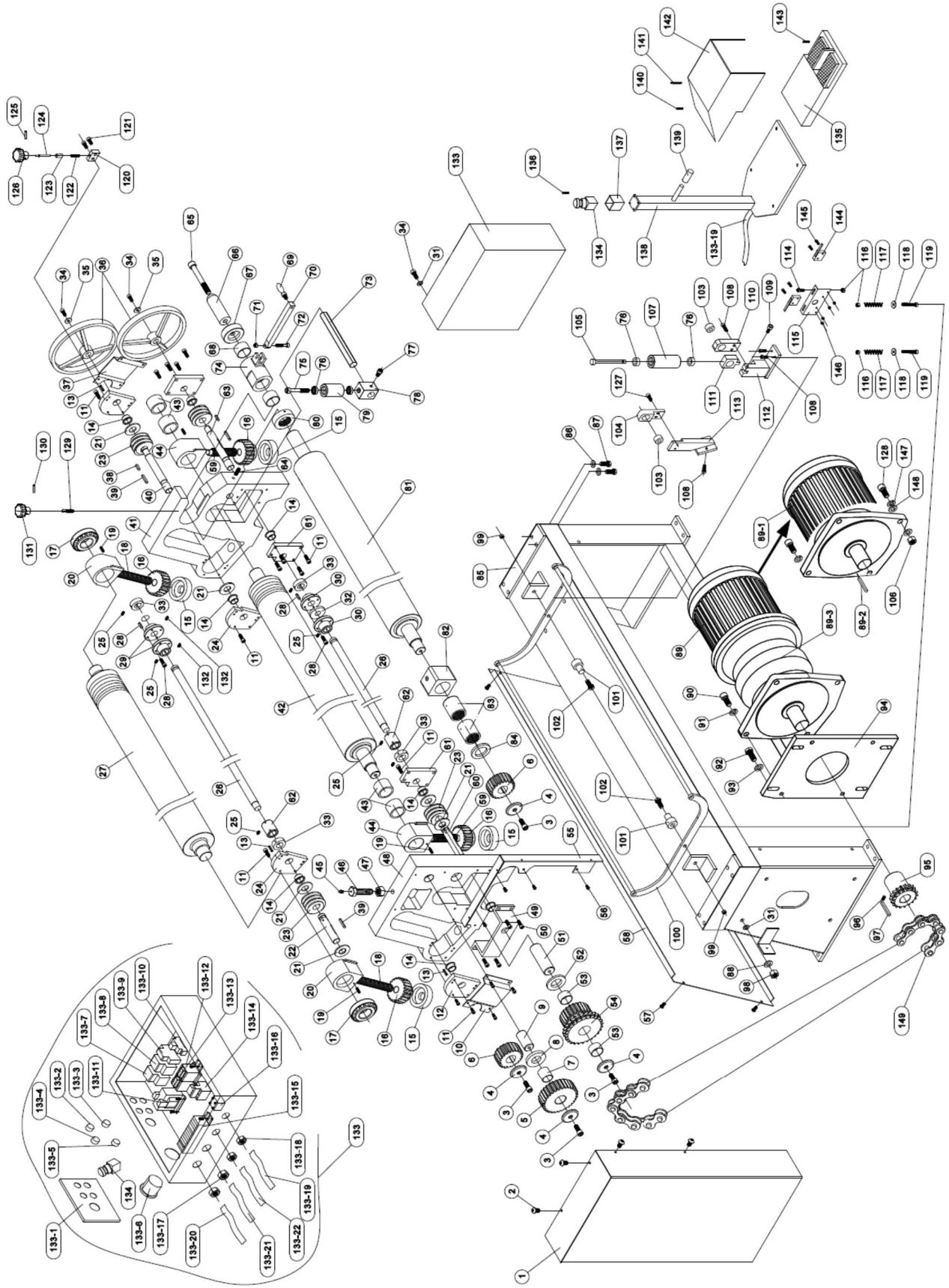
*** WARNING: Some corrections may require a qualified electrician.**

# 13.0 **Replacement Parts**

Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 Monday through Friday, 8:00 a.m. to 5:00 p.m. CST. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

Non-proprietary parts, such as fasteners, can be found at local hardware stores, or may be ordered from JET. Some parts are shown for reference only, and may not be available individually.

### 13.1.1 **EPR-1460 Electric Plate Roller – Exploded View**



## 13.1.2 **EPR-1460 Electric Plate Roller – Parts List**

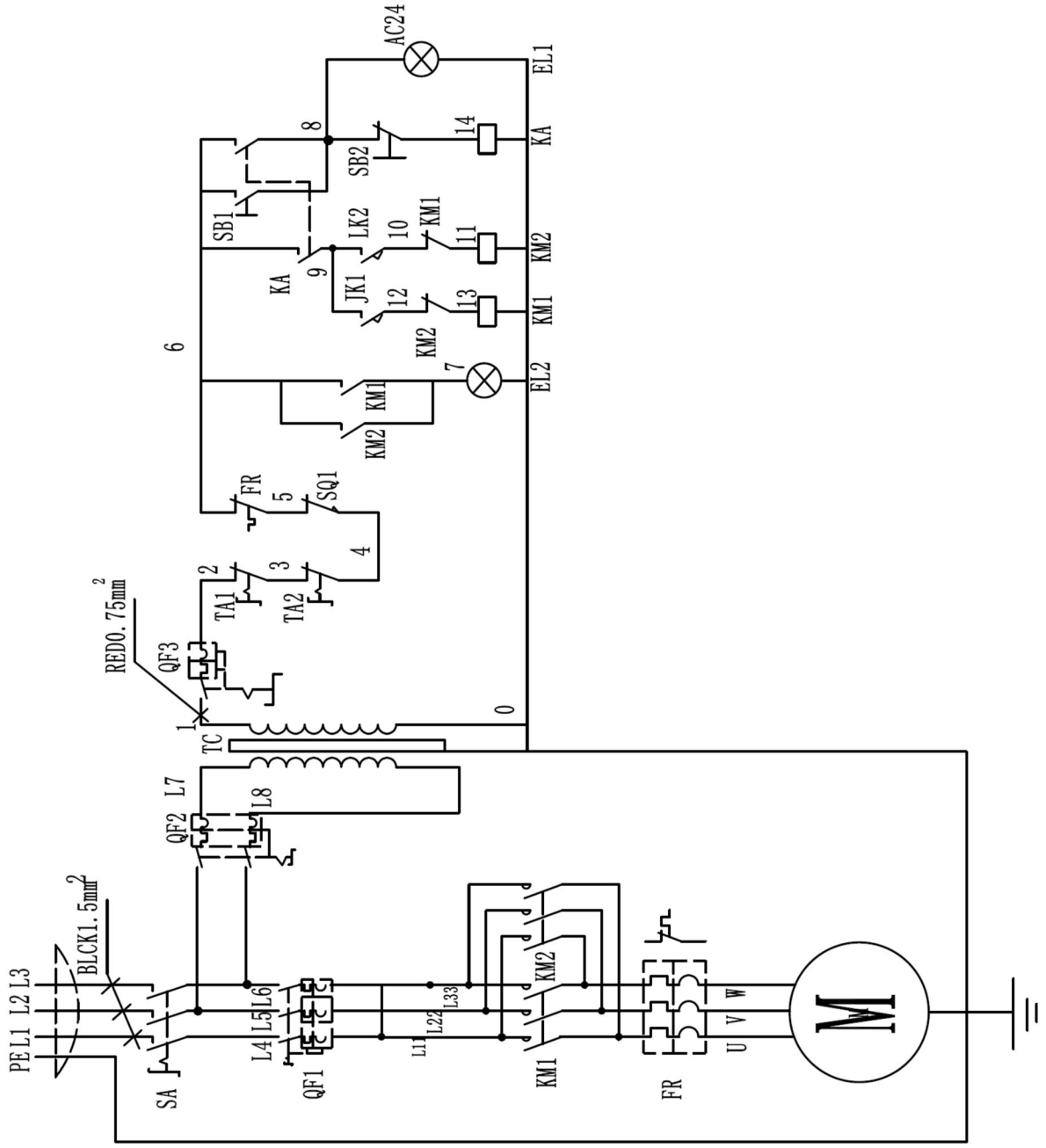
| Index No. | Part No. | Description | Size | Qty |
|---|---|---|---|---|
| 1 | EPR1460-1 | Side Cover | | 1 |
| 2 | TS-2246102 | Socket Head Button Screw | M6x10 | 5 |
| 3 | TS-1492021 | Hex Cap Screw | M12x30 | 3 |
| 4 | EPR1460-4 | Pad | | 3 |
| 5 | EPR1460-5 | Big Gear | 25T | 1 |
| 6 | EPR1460-6 | Small Gear | 20T | 2 |
| 7 | EPR1460-7 | Bushing | ø35xø39x40 mm | 1 |
| 8 | EPR1460-8 | Pad | | 1 |
| 9 | EPR1460-9 | Shaft | | 1 |
| 10 | EPR1460-10 | Cover LH | | 1 |
| 11 | TS-1503041 | Socket Head Cap Screw | M6X16 | 28 |
| 12 | EPR1460-12 | Plate | | 1 |
| 13 | AP2-16 | Spring pin | 6x25mm | 2 |
| 14 | EPR1460-14 | Bushing | | 8 |
| 15 | EPR1460-15 | Supporting Sleeve | | 4 |
| 16 | EPR1460-16 | Worm Gear | | 4 |
| 17 | EPR1460-17 | Spherical Plain Bearing | GE45DS | 2 |
| 18 | EPR1460-18 | Lead Screw | | 2 |
| 19 | F010433 | Socket Set Screw | M8X40 | 4 |
| 20 | EPR1460-20 | Adjusting Block | | 2 |
| 21 | EPR1460-21 | Pad | | 8 |
| 22 | EPR1460-22 | Worm Shaft | | 1 |
| 23 | EPR1460-23 | Worm | | 4 |
| 24 | EPR1460-24 | Plate | | 2 |
| 25 | 130604040 | Spring Pin | 4X40 mm | 4 |
| 26 | EPR1460-26 | Transmission Shaft | | 2 |
| 27 | EPR1460-27 | Rear Roll | | 1 |
| 28 | EPR1460-28 | Key | 6x25 mm | 4 |
| 29 | EPR1460-29 | Trans Shaft Bushing A | | 2 |
| 30 | EPR1460-30 | Trans Shaft Bushing B | | 2 |
| 31 | TS-155010 | Flat Washer | 16mm | 4 |
| 32 | EPR1460-32 | Pad | | 1 |
| 33 | EPR1460-33 | Joint Bushing | | 4 |
| 34 | TS-1504041 | Socket Head Cap Screw | M8x20 | 6 |
| 35 | EPR1460-35 | Washer | | 2 |
| 36 | EPR1460-36 | Handwheel | | 2 |
| 37 | EPR1460-37 | Cover RH | | 1 |
| 38 | 5508737 | Double Round Head Key | 8x8X25 mm | 2 |
| 39 | ESR1650T-41 | Double Round Head Key | 8x8X45 mm | 4 |
| 40 | EPR1460-40 | Worm Shaft | | 1 |
| 41 | EPR1460-41 | Right Support | | 1 |
| 42 | EPR1460-42 | Lower Roll | | 1 |
| 43 | EPR1460-43 | Bushing | ø35xø39x30 mm | 4 |
| 44 | EPR1460-44 | Adjusting block | | 2 |
| 45 | EPR1460-45 | Oil fitting | Φ8 x1 mm | 1 |
| 46 | EPR1460-46 | Bolt | | 1 |
| 47 | TS-2310201 | Hex Nut | M20 | 1 |
| 48 | EPR1460-48 | Left Support | | 1 |
| 49 | EPR1460-49 | Support Plate | | 1 |
| 50 | TS-1504051 | Socket Head Cap Screw | M8X25 | 4 |
| 51 | EPR1460-51 | Shaft | | 1 |
| 52 | EPR1460-52 | Pad | | 1 |
| 53 | EPR1460-53 | Bushing | ø40xø44x25 | 2 |
| 54 | EPR1460-54 | Large Sprocket | P=15.875, Z=26 | 1 |
| 55 | EPR1460-55 | Connecting Rack | | 1 |
| 56 | TS-2246122 | Socket Head Button Screw | M6X12 | 4 |
| 57 | TS-2248162 | Socket Head Button Screw | M8X16 | 4 |
| 58 | EPR1460-58 | Apron | | 1 |
| 59 | EPR1460-59 | Small Lead Screw | | 2 |
| 60 | EPR1460-60 | Worm Shaft | | 1 |

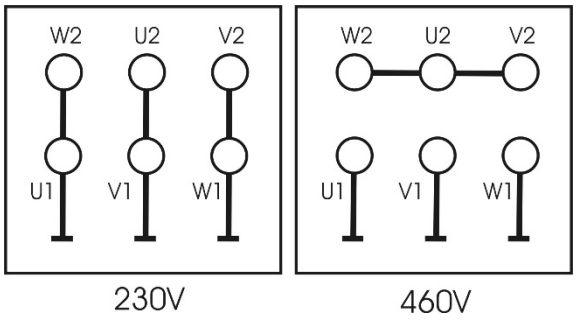
| Index No. | Part No. | Description | Size | Qty |
|---|---|---|---|---|
| 61 | EPR1460-61 | Plate | | 2 |
| 62 | EPR1460-62 | Trans Shaft Bushing | | 2 |
| 63 | EPR1460-63 | Worm Shaft | | 1 |
| 64 | TS-2279301 | Socket Set Screw | M10X30 | 1 |
| 65 | F005505 | Socket Head Cap Screw | M16x130 | 1 |
| 66 | EPR1460-66 | Hand Grip | | 1 |
| 67 | EPR1460-67 | Joint Bushing | | 1 |
| 68 | EPR1460-68 | Bushing | Ø35xØ39x30 mm | 2 |
| 69 | EPR1460-69 | Turning Handle | | 1 |
| 70 | EPR1460-70 | Pull Rod | | 1 |
| 71 | TS-1541031 | Hex Nut, Nylon Lock | M8 | 1 |
| 72 | TS-1504091 | Socket Hd Cap Screw | M8×45 | 1 |
| 73 | EPR1460-73 | Shaft | | 1 |
| 74 | EPR1460-74 | Lock sleeve | | 1 |
| 75 | TS-1506071 | Socket Head Cap Screw | M12X50 | 1 |
| 76 | BB-6001ZZ | Bearing | 6001-2Z | 4 |
| 77 | TS-1505011 | Socket Head Cap Screw | M10X16 | 1 |
| 78 | EPR1460-78 | Sliding Block | | 1 |
| 79 | EPR1460-79 | Guide Roller, Short | | 1 |
| 80 | EPR1460-30 | Bushing | | 1 |
| 81 | EPR1460-81 | Upper Roll | | 1 |
| 82 | EPR1460-82 | Adjusting Block | | 1 |
| 83 | EPR1460-83 | Bushing | ø35xø39x30 mm | 2 |
| 84 | EPR1460-84 | Pad | | 1 |
| 85 | EPR1460-85 | Stand | | 1 |
| 86 | TS-2360121 | Flat Washer | 12mm | 8 |
| 87 | TS-1492021 | Hex Cap Screw | M12x30 | 8 |
| 88 | TS-2361161 | Lock Washer | 16mm | 4 |
| 89 | EPR1460-89 | Reduction Box & Motor Ass. | | 1 |
| | EPR1460-89-1 | Motor, 230/460V-3PH | 1.5kW, 4P | 1 |
| | EPR1460-89-2 | Key | 8x30 mm | 1 |
| | EPR1460-89-3 | Reduction Box | | 1 |
| | EPR1460-89-4 | Motor Fan Cover (not shown) | | 1 |
| | EPR1460-89-5 | Motor Fan (not shown) | | 1 |
| | EPR1460-89-6 | Junction Box (not shown) | | 1 |
| | EPR1460-89-7 | Junction Box Cover (not shown) | | 1 |
| 90 | F005491 | Socket Head Cap Screw | M16x35 | 4 |
| 91 | TS-2361161 | Lock Washer | 16 mm | 4 |
| 92 | F009602 | Hex Cap Screw | M16x40 | 4 |
| 93 | TS-155010 | Flat Washer | 16 mm | 8 |
| 94 | EPR1460-94 | Support plate | | 1 |
| 95 | EPR1460-95 | Small Sprocket | P=12.875, Z=17 | 1 |
| 96 | EPR1460-96 | Lock screw | M8x16 | 2 |
| 97 | EPR1460-97 | Key | 12x45 | 1 |
| 98 | TS-2311161 | Hex Nut | M16 | 4 |
| 99 | TS-1540061 | Hex Nut | M8 | 2 |
| 100 | EPR1460-100 | Safety brake | | 1 |
| 101 | EPR1460-101 | Sleeve | | 2 |
| 102 | TS-1490071 | Hex Cap Screw | M8x40 | 2 |
| 103 | EPR1460-103 | Sleeve | 2520 | 2 |
| 104 | EPR1460-104 | Adjusting plate | | 1 |
| 105 | EPR1460-105 | Screw | M12x125 | 1 |
| 106 | TS-2311101 | Hex Nut | M10 | 4 |
| 107 | EPR1460-107 | Guide Roller, Long | | 1 |
| 108 | TS-1503051 | Socket Head Cap Screw | M6x20 | 6 |
| 109 | EPR1460-109 | Lock Screw | | 1 |
| 110 | EPR1460-110 | Adjusting Plate | | 1 |
| 111 | EPR1460-111 | Limit Block | | 1 |
| 112 | EPR1460-112 | Seat | | 1 |
| 113 | EPR1460-113 | Seat | | 1 |
| 114 | TS-1503041 | Socket Head Cap Screw | M6X16 | 2 |
| 115 | EPR1460-115 | Support Board | | 1 |

| Index No. | Part No. | Description | Size | Qty |
|---|---|---|---|---|
| 116 | TS-2311061 | Hex Nut | M6 | 2 |
| 117 | EPR1460-117 | Spring | | 2 |
| 118 | TS-1550041 | Flat Washer | 6 mm | 2 |
| 119 | TS-2236801 | Socket Head Cap Screw | M6x80 | 2 |
| 120 | EPR1460-120 | Knob Seat | | 1 |
| 121 | TS-1502041 | Socket Head Cap Screw | M5x16 | 2 |
| 122 | EPR1460-122 | Spring | | 1 |
| 123 | EPR1460-123 | Sleeve | | 1 |
| 124 | EPR1460-124 | Pin Shaft | | 1 |
| 125 | 40317-15 | Spring Pin | 3x14 mm | 1 |
| 126 | EPR1460-126 | Lock Handle | | 1 |
| 127 | F005670 | Socket Head Cap Screw | M6x14 | 1 |
| 128 | TS-1505061 | Socket Head Cap Screw | M10x40 | 4 |
| 129 | EPR1460-129 | Lock Bolt | | 1 |
| 130 | F012086 | Spring Pin | 3x25 mm | 1 |
| 131 | EPR1460-131 | Star Grip Knob | | 1 |
| 132 | TS-1524021 | Socket Set Screw | M8X10 | 4 |
| 133 | EPR1460-133 | Electric Cabinet | | 1 |
| 133-1 | EPR1460-133-1 | Electric Panel | | 1 |
| 133-2 | EPR1460-133-2 | White Indicator | KB2-BVB1C 24V | 1 |
| 133-3 | EPR1460-133-3 | Green Indicator | KB2-BVB3C 24V | 1 |
| 133-4 | EPR1460-133-4 | Start Button | ZB2-BE101C | 1 |
| 133-5 | EPR1460-133-5 | Stop Button | ZB2-BE102C | 1 |
| 133-6 | EPR1460-133-6 | Power Switch | JFD11-25 | 1 |
| 133-7 | EPR1460-133-7 | Breaker | 3P20A | 1 |
| 133-8 | EPR1460-133-8 | Breaker | 2P2A | 1 |
| 133-9 | EPR1460-133-9 | Breaker | 1P1A | 1 |
| 133-10 | EPR1460-133-10 | Intermediate Relay | JZX-22F/2E AC24V | 1 |
| 133-11 | EPR1460-133-11 | Transformer | JBR5-60 220V/440/24V | 1 |
| 133-12 | EPR1460-133-12 | A.C. Contactor | CN63A1a | 2 |
| 133-13 | EPR1460-133-13 | Supplementary Contactor | CNA-422M | 2 |
| 133-14 | EPR1460-133-14 | Thermal Relay | RHN-5 3.5-5A | 1 |
| 133-15 | EPR1460-133-15 | Junction Terminal | UK3N20A 16P | 1 |
| 133-16 | EPR1460-133-16 | Grounding Copper Bar | M4X6 | 1 |
| 133-17 | EPR1460-133-17 | Strain Relief | M18x1.5 | 3 |
| 133-18 | EPR1460-133-18 | Hose Adapter | | 1 |
| 133-19 | EPR1460-133-19 | Flexible Conduit | 2m | 1 |
| 133-20 | EPR1460-133-20 | Power Cable | 16AWG | 2.5m |
| 133-21 | EPR1460-133-21 | Motor Cable | 16AWG | 2m |
| 133-22 | EPR1460-133-22 | Cable for Microswitch | 18AWG | 1.4m |
| 134 | EPR1460-134 | Emergency Switch Assembly | | 1 |
| 135 | EPR1460-135 | Pedal Switch Assembly | | 2 |
| 136 | EPR1460-136 | Set Screw | M6x65 | 4 |
| 137 | EPR1460-137 | Switch Box | | 1 |
| 138 | EPR1460-138 | Post | | 1 |
| 139 | EPR1460-139 | Rubber Grip | | 1 |
| 140 | TS-1502071 | Socket Head Cap Screw | M5x30 | 2 |
| 141 | F005671 | Socket Head Cap Screw | M5x95 | 2 |
| 142 | EPR1460-142 | Box Cover | | 1 |
| 143 | TS-1534052 | Machine Screw, Pan Head. | M6X16 | 2 |
| 144 | EPR1460-144 | Microswitch | | 1 |
| 145 | F001160 | Machine Screw, Pan Head | M3x16 | 4 |
| 146 | TS-1540011 | Hex Nut | M3 | 4 |
| 147 | TS-2361101 | Lock Washer | 10 mm | 4 |
| 148 | TS-1550071 | Flat Washer | 10 mm | 8 |
| 149 | EPR1460-149 | Chain | 10A-2x84 | 1 |
| 150 | EPR1460-150 | Scale (not shown) | metric/imperial | 1 |
| | JET-203 | JET Logo (not shown) | 203x84mm | 1 |
| | LM000220 | ID Label, EPR-1460 (not shown) | | 1 |
| | LM000221 | Warning Label (not shown) | | 1 |

| | | | | |
|---|---|---|---|---|
| | EPR1460-TB | Tool Box (not shown – includes following items) | | 1 |
| | | Oil can | | 1 |
| | | Adjustable wrench | | 1 |
| | | Hex Key Set | | 1 |
| | | Grease Gun | | 1 |
| | | Hex Cap Screw | M12x45 | 8 |
| | | Lock Washer | M12 | 8 |
| | | Flat Washer | M12 | 8 |
| | | Hex Nut | M12 | 8 |

# 14.0 **Electrical Connections for EPR-1460 Plate Roller**



# 15.0 **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**
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**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 |

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