



# Operating Instructions and Parts Manual

## Shear, Brake and Roll

Models SBR-30N and SBR-40N



**WALTER MEIER (Manufacturing) Inc.**

427 New Sanford Road  
LaVergne, Tennessee 37086  
Ph.: 800-274-6848  
[www.waltermeier.com](http://www.waltermeier.com)

**Part No. M-754031**

Revision G 02/2010

Copyright © 2010 Walter Meier (Manufacturing) Inc.

# 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</b><br>DAY<br>WARRANTY   | <b>1</b><br>YEAR<br>WARRANTY | Body Repair Kits<br>Bottle Jacks<br>Cable Pullers<br>Cold Saws<br>Hoists-Air<br>Hoists-Electric<br>Metal forming<br>Mill/Drills<br>Milling Machines<br>MW Bandsaws<br>MW Drill Presses<br>MW Finishing Equipment<br>MW Lathes<br>MW Precision Vises | <b>2</b><br>YEAR<br>WARRANTY | Palet Trucks<br>Rigging Equip.<br>Service Jacks<br>Stackers<br>Surface Grinders<br>Tapping<br>Trolleys-Air<br>Trolleys-Electric<br>Web Slings<br>Winches-Electric | <b>3</b><br>YEAR<br>WARRANTY | WW Benchtop Tools | <b>5</b><br>YEAR<br>WARRANTY | Beam Clamps<br>Chain Hoist-Manual<br>Lever Hoists<br>Pullers-JCH Models<br>Scissor Lift Tables<br>Screw Jacks<br>Trolleys-Geared<br>Trolleys-Plain<br>Winches-Manual<br>WW Air Filtration<br>WW Bandsaws<br>WW Buffers | WW Drill Presses<br>WW Dust Collectors<br>WW Dust Filters<br>WW Dust Fittings<br>WW Jointers<br>WW Lathes<br>WW Planers<br>WW Sanders<br>WW Shapers<br>WW Tablesaws | <b>LIFE</b><br>LIFETIME<br>WARRANTY | Fastening Tools<br>Mechanics Hand Tools<br>Striking Tools<br>Vises (no -precision)<br>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.

# Table of Contents

- Warranty and Service..... 2
- Table of Contents ..... 3
- Introduction ..... 5
- Specifications ..... 5
- Unpacking..... 5
  - Contents of the Crate..... 5
- Assembly ..... 6
- Setting Up the Press Brake ..... 7
- Setting Up the Shear..... 8
  - Lower Blade Adjustment ..... 8
  - Blade Rotation and Replacement ..... 9
- Setting Up the Slip Roll ..... 9
  - Flat Rolling..... 11
  - Forming a Radius ..... 11
  - Forming a Tube..... 11
  - Bending Wire ..... 12
- Maintenance/Lubrication ..... 12
- Optional Accessories ..... 12
- Replacement Parts ..... 12
  - Breakdown for the SBR-30N Shear, Brake, and Roll..... 13
  - Parts List for the SBR-30N Shear, Brake, and Roll..... 14
  - Breakdown For The SBR-40N Shear, Brake, and Roll..... 16
  - Parts List For The SBR-40N Shear, Brake, and Roll ..... 17



# Warnings

1. Read and understand the entire instruction 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 shear, brake and 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 shear, brake and roll, do not use until proper training and knowledge have been obtained.
5. This shear, brake and roll is intended to be used by one person only. Keep others away from the machine during operations.
6. The shear, brake and roll must be bolted securely to a stand and the stand bolted securely to the floor. If the machine is to be bench-mounted, the bench must be able to support the weight of the machine and must be bolted to the floor.
7. Always wear approved safety glasses/face shields while using this tool. *Note: Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.*
8. Keep the floor around the shear, brake and roll clear of scraps, debris, oil and grease. The flooring around the machine should be a non-skid type.
9. Sheet metal stock has sharp edges. To prevent cuts, deburr edges and use gloves when handling.
10. Keep top guard in place when not using the slip roll.
11. Keep hands and fingers clear of the slip roll pinch points.
12. Keep hands and fingers away from the area in front and rear of the shear blades.
13. Keep hands and fingers away from the press brake dies.
14. Do not exceed the maximum capacity of the machine.
15. Do not use the shear to cut round bars, chain, steel cable or hardened metals.
16. Do not use the machine for any purpose other than for which it is designed.
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. 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, 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 face or dust masks that are specifically designed to filter out microscopic particles.
19. Failure to comply with all of these warnings may cause serious injury.

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



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



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

# Introduction

This manual is provided by Walter Meier (Manufacturing) Inc., covering the safe operation and maintenance procedures for a JET Model SBR-30N and Model SBR-40N Shear, Brake and Roll. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. This machine has been designed and constructed to provide years of trouble free operation if used in accordance with instructions set forth in this manual. If there are any questions or comments, please contact either your local supplier or Walter Meier. Walter Meier can also be reached at our web site: [www.waltermeier.com](http://www.waltermeier.com).

# Specifications

|   |                      |                  |
|---|----------------------|------------------|
| Model Number.....                               | <b>SBR-30N</b> ..... | <b>SBR-40N</b>   |
| Stock Number .....                              | 754031.....          | 754041           |
| Capacity - Mild Steel (ga.).....                | 20.....              | 20               |
| Base Dimensions (LxW)(in.).....                 | 32-1/4 x 14-1/2..... | 45-1/4 X 17-3/4  |
| Overall Dimensions, Assembled (LxWxH)(in.)..... | 41 x 15 x 24.....    | 56 x 19 x 27-1/2 |
| Net Weight, approximate (lbs.).....             | 300.....             | 651              |
| Shipping Weight, approximate (lbs.).....        | 324.....             | 682              |

### Shearing:

|                         |                      |                 |
|-------------------------|----------------------|-----------------|
| Shearing Capacity ..... | 20 ga. x 30 in. .... | 20 ga. x 40 in. |
| Shear Blade .....       | reversible.....      | reversible      |

### Bending:

|                                |                        |                                  |
|--------------------------------|------------------------|----------------------------------|
| Bending Capacity .....         | 20 ga. x 30 in.....    | 20 ga. x 40 in.                  |
| No. of Male Dies.....          | 6.....                 | 8                                |
| No. of Female Dies .....       | 5.....                 | 7                                |
| Width of Upper Dies (in.)..... | 1, 2, 3, 6, 8, 10..... | 1, 1-1/2, 2, 2-1/2, 4, 7, 10, 15 |
| Upper Die Height (in.) .....   | 4-3/8.....             | 3-3/8                            |

### Rolling:

|                                   |                        |                   |
|-----------------------------------|------------------------|-------------------|
| Rolling Capacity .....            | 20 ga. x 30 in.....    | 20 ga. x 40 in.   |
| Wire Grooves (dia./in.).....      | 1/8, 3/16, 1/4.....    | 1/8, 3/16, 1/4    |
| Size of Slip Rolls (in.).....     | 1-1/2 Dia. x 30 L..... | 1-5/8 Dia. x 40 L |
| Minimum Forming Radius (in.)..... | 3/4.....               | 1                 |

The above specifications were current at the time this manual was published, but because of our policy of continuous improvement, Walter Meier reserves the right to change specifications at any time and without prior notice, without incurring obligations.

# Unpacking

Open shipping crate and check for shipping damage. Report any damage immediately to your distributor and shipping agent. Do not discard any shipping material until the Shear, Brake and Roll is assembled and running properly.

Compare the contents of your crate 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.

# Contents of the Crate

- 1 Shear, Brake and Roll Machine
- 1 Operating Lever Assembly
- 2 Guide Rods with hex nuts
- 1 Guide Plate
- 1 Instruction and Parts Manual
- 1 Warranty Card

# Assembly

*Tools required for assembly:*

5mm, 8mm hex keys (“Allen wrenches”)  
19mm open end wrench

1. Finish removing the crate from around the machine.
2. Remove the bolts holding the machine to the skid.
3. 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, as these may damage painted surfaces.
4. Coat all machined surfaces with a very light film of oil to inhibit rust.
5. Carefully move the shear, brake, and roll to a work bench or stand. Machine location must allow free access on all sides.
6. Bolt the machine to a stand or a workbench. If using a stand, the stand must be bolted to the floor. If using a work bench, the bench must be bolted to the floor.

(NOTE: An optional stand is available for this machine; see page 12. Contact your JET distributor to order.)

7. Remove one handle (A, Figure 1) from the operating handle assembly, using an 8mm hex key.
8. The operating handle can be installed on either end of the machine. Loosen lock bolt (C, Figure 1).
9. Slide bar (B, Figure 1) into hub and tighten lock bolt (C, Figure 1) to secure.
10. Re-install handle (A, Figure 1).
11. Install both *guide rods* into either the upper or lower set of threaded holes (Figure 2) and tighten the setting by rotating the *hex nut* against the cast base of the machine using a 19mm wrench.

NOTE: For brake operation, install the guide rods into the upper set of holes (Figure 2); for shear operation, install in the lower set of holes (Figure 3).

12. Install the *guide plate* as shown in Figures 2 or 3. Secure it to the rods by tightening the screws with a 5mm hex key.

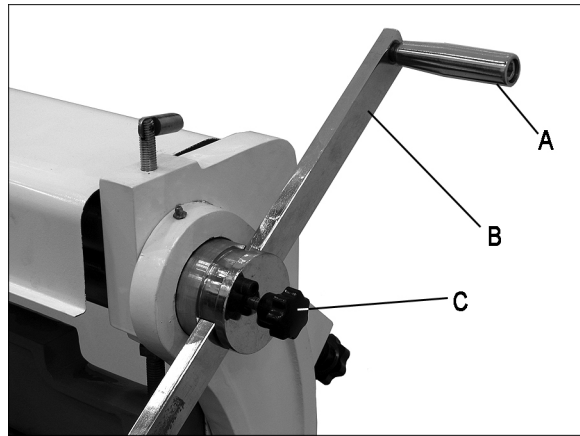


Figure 1

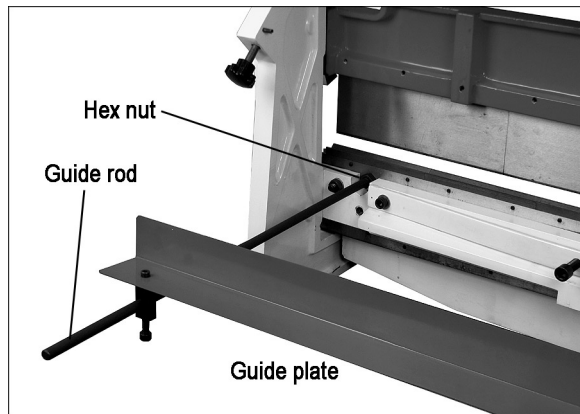


Figure 2  
(Brake position)

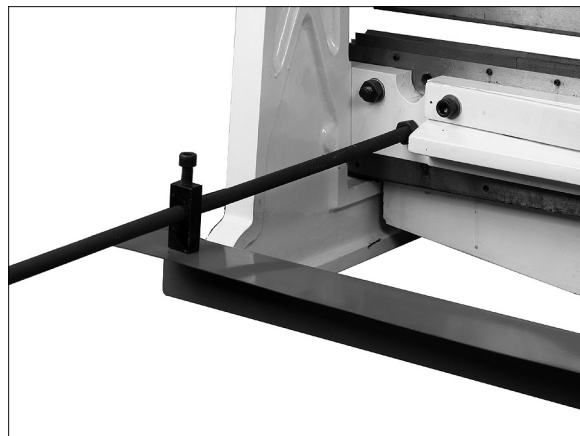


Figure 3  
(Shear position)

# Setting Up the Press Brake

**⚠WARNING** Do not bend any material larger than 30" (40") 20-gauge mild steel. Failure to comply may cause serious injury and/or damage to the machine.

## To set up for bending:

1. Place a strip of wood on the bottom die the full length of the die.
2. Close the brake until the wood contacts the upper dies.
3. Loosen the socket head cap screws (Figure 4) using a 6mm hex key.
4. Select upper die(s) (Figure 4) for the desired job and remove the others by sliding them out the left end.
5. Move the operating handle until the wood pushes up the dies so that they seat uniformly in the upper beam.
6. Securely re-tighten all screws (Figure 4), then release and remove the wood strip.
7. If making repeated bends or using a long workpiece, position the guide rods and plate for brake operation, as shown in Figure 5.
8. Scribe a line on the workpiece for the bend location. (Be sure to accommodate bend allowance based upon thickness of the material. This can be done either through trial and error, or by consulting a machinist's handbook.)
9. Rest the workpiece on the v-block (lower die) so that the scribed line is aligned with the tips of the upper die(s).
10. Hold the workpiece steady and use the operating handle to make the bend.

## To adjust the brake beam to make 90° bends at the bottom of the stroke:

1. Slightly loosen locking screws (D, Figure 6) using an 8mm hex key.
2. Turn brake beam adjusting screws (E, Figure 6) using a 19mm wrench, until test bends reflect a 90° bend at both ends of the brake.
3. Re-tighten locking screws (D, Figure 6).

For special repetitive bends, the brake beam may be adjusted to over-bend the desired angle since the metal will have some degree of "spring back".

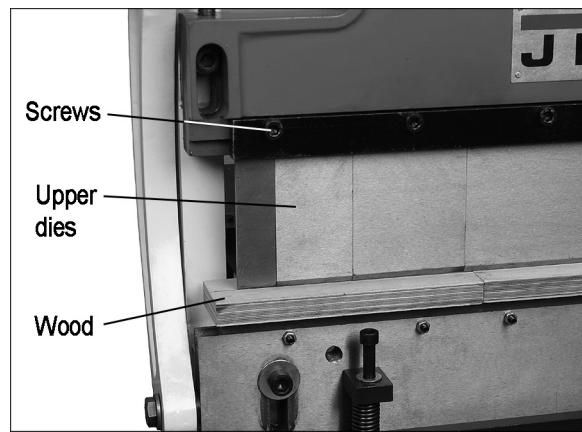


Figure 4

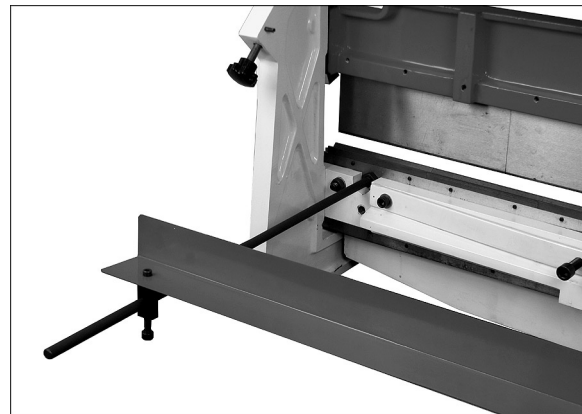


Figure 5

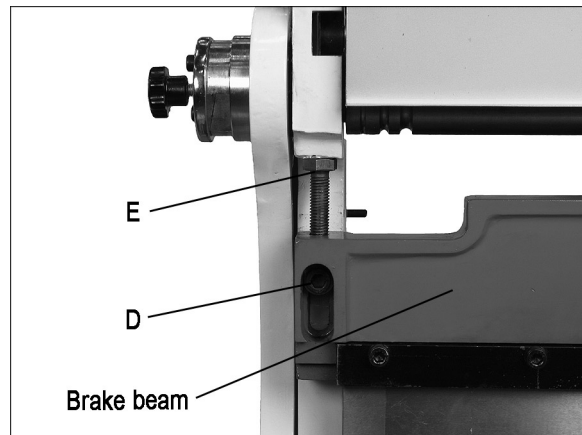


Figure 6

## Setting Up the Shear

**⚠WARNING** Do not shear any material larger than 30" (40") 20 gauge mild steel. Failure to comply may cause serious injury and/or damage to the machine.

1. Install the guide rods and plate in the shear position (Figure 7) and adjust it to the desired length of the cut workpiece.
2. Place the workpiece against the block at the right edge of the table (Figure 8). The end of the workpiece should be against the guide plate.
3. Operate the handle to begin the shearing cut. Shearing action progresses from right to left.

NOTE: To prevent distortion when notching, "snap" the handle to facilitate piercing.

### Lower Blade Adjustment

The upper and lower shear blades have been factory aligned and should not require immediate adjustment. Should re-alignment be needed in the future, proceed as follows:

1. Place a heavy sheet of paper in the cutting position, along the entire length of the bed, and make a cut.
2. If the shear does not cut the paper, loosen the socket head cap screw (F, Figure 8) at each end of the table, with an 8mm hex key.
3. Rotate the adjusting screws (G, Figure 9) to shift the table and change the gap between blades. **Do not allow the blades to overlap.**
4. If the shear cuts the paper on the ends, but not the center, slightly turn the screw (H, Figure 10) *clockwise* until the paper is cut the entire length.
5. If the shear cuts the paper in the center, but not the ends, turn the screw (H, Figure 10) *counterclockwise* until the paper is cut the entire length.

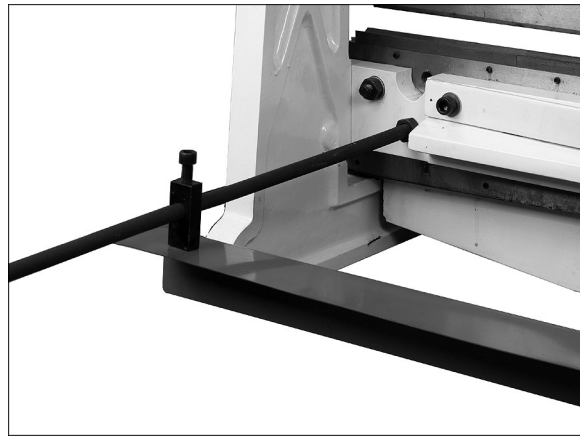


Figure 7

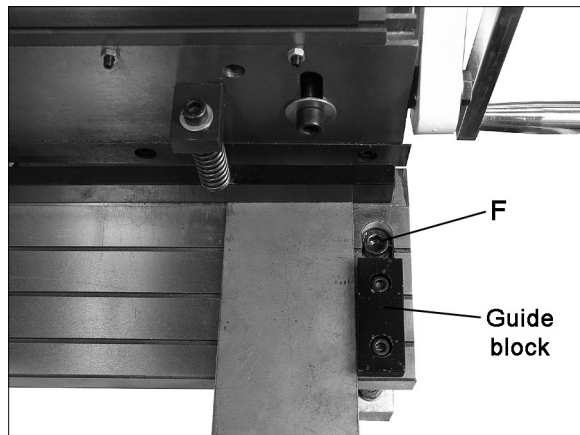


Figure 8

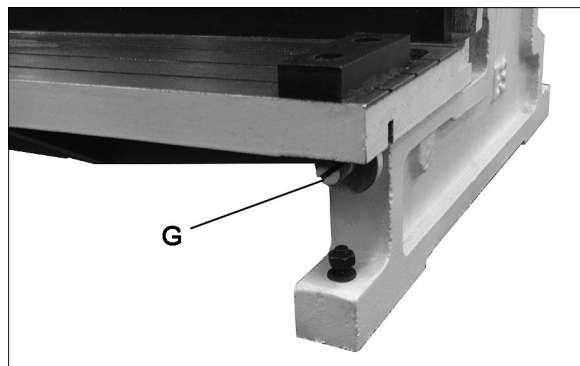


Figure 9

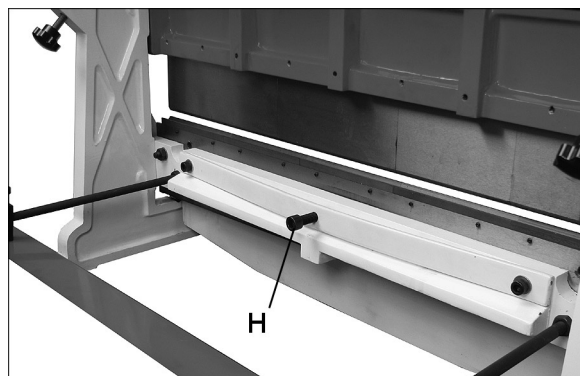


Figure 10



## Blade Rotation and Replacement

**⚠WARNING** Exercise caution when working with or near the blades. Use work gloves when handling them.

The shearing blades are reversible and interchangeable; when the edges dull, rotate them to the new edge, as follows:

1. Remove the *hold-down* by loosening the socket head cap screws (J, Figure 11), using a 6mm hex key.
2. Raise the *upper blade* to highest position.
3. Remove the seven *socket head cap screws* (K, Figure 11) and carefully remove a blade.
4. Rotate or replace the blade and re-install the screws.
5. Re-install the hold-down. When the blade is in highest position, the gap between the hold-down and the table should be within 1/4". Adjust to this position by turning the two socket head cap screws (J, Figure 11) as needed. When the blade starts its downward travel, the hold-down should immediately hold the workpiece in place.

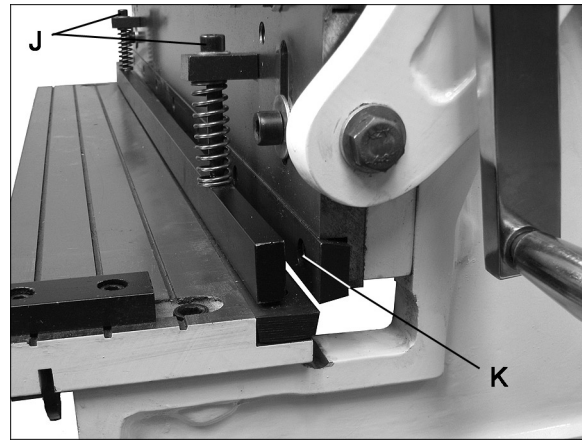


Figure 11

## Setting Up the Slip Roll

**⚠WARNING** Do not roll any material larger than 30" (40"), 20-gauge mild steel. The slip roll guard must cover the slip rolls except when material is being fed into the rolls. Failure to comply may cause serious injury and/or damage to the machine.

### Material Size Considerations

To determine the 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 the 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.

**TIP:** If it doesn't interfere with the proposed final shape or design, a slight bend made with the press brake on the leading edge will simplify the initial rolling process, by allowing the leading edge to slip more easily over the idle roll.

**⚠WARNING** Beware of the pinch point – the intersection of the upper and lower rolls. Failure to comply may cause serious injury to fingers and/or hands.

1. Make sure rolls and workpiece are clean and free of debris to prevent pitting the sheet metal.
2. Back off the idle roll completely by rotating the *idle roll screws* (L, Figure 12) counter-clockwise.
3. Loosen the *bolt* (M, Figure 12) to increase the space between upper and lower press rolls.
4. Insert the material between the upper and lower rolls, and tighten the bolt (M, Figure 12) to lower the upper roll, until the material fits snugly. The upper roll must have sufficient pressure on the work piece to feed properly.
5. Rotate both *idle roll screws* (L, Figure 12) to adjust the idle roll's proximity to the two main rollers. *Raise both ends an equal amount.*
6. Run the workpiece through the machine using the operating lever. If the workpiece is large, make sure it receives proper support as it exits the slip roll machine.
7. Make further passes of the workpiece, raising the idle roll incrementally before each pass, until the desired radius is achieved.

No exact formula can be followed when making 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 to attempt to increase a radius that was made too small.

The idle roll must be adjusted exactly parallel or the material will spiral during the rolling process. Measure each end of the opening with calipers if greater precision is required.

Deliberately setting the rolls non-parallel can be used to make cone shapes.

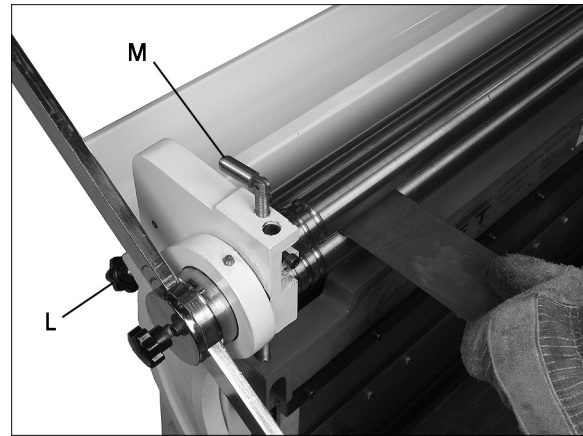


Figure 12

### To remove cylindrical shaped workpieces:

1. Loosen bolt (M, Figure 13)
2. Rotate the screw (N<sub>1</sub>, Figure 30) toward the rear of the machine to release the roll catch (N<sub>2</sub>).
3. Carefully grasp upper roll and swing out the end.

**CAUTION** Grasp the upper roll firmly, to prevent it falling out of the machine.

4. Slip the workpiece off the end of the roll.
5. Re-install the upper roll, and rotate the screw (N<sub>1</sub>) back toward the front to secure.

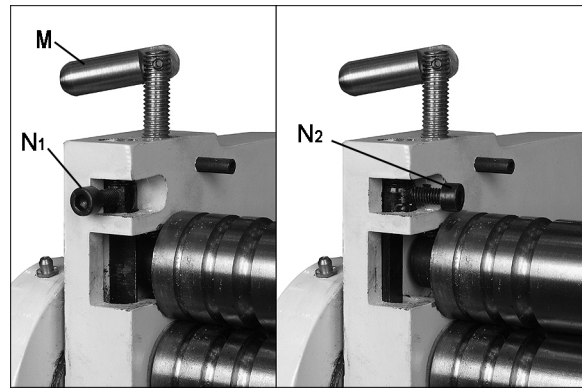


Figure 13

### Flat Rolling

Softer metals (copper, aluminum, etc.) can be processed through the slip roll machine to straighten, flatten, or reduce their thickness. Simply adjust the upper press roll for thickness, lower the idle roll all the way down, and feed the workpiece through (Figure 14).

NOTE: The idle roll will not descend completely out of the path of the workpiece; thus, there may be a slight bend in the workpiece. By flipping the workpiece over and re-feeding it, this bend can be minimized.

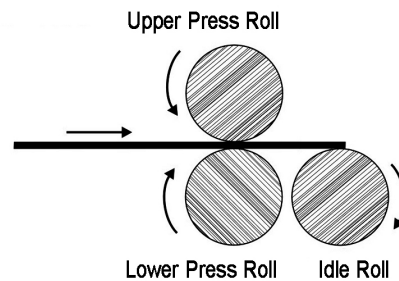


Figure 14

### Forming a Radius

1. Adjust the upper press roll as needed.
2. Insert the workpiece from the front.
3. Operate the lever; when the material reaches the point where the radius is to begin (a, Figure 15), stop the machine and raise the idle roll an equal amount on each end to achieve the desired bend.
4. Re-start the rolls and continue until the bend is completed (b, Figure 15). Support the workpiece as it exits the machine.
5. Make further passes if needed, along with incremental idle roll adjustments.

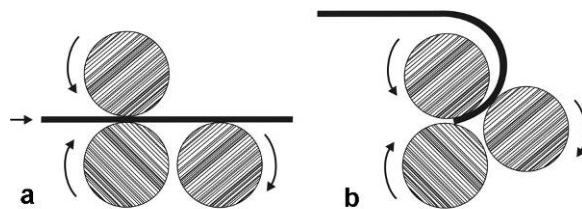


Figure 15

### Forming a Tube

1. Adjust the upper press roll as needed for workpiece thickness.
2. Feed the workpiece into the machine. As it nears the end (a, Figure 16), stop and reverse direction (b, Figure 16).
3. Make further passes if needed, along with incremental idle roll adjustments.

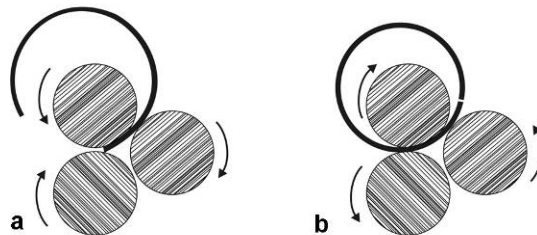


Figure 16

## Bending Wire

There are three wire grooves at the end of the press rollers to accommodate a 1/8", 3/16" and a 1/4" wire.

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

## Maintenance/Lubrication

**⚠WARNING** Use caution when doing maintenance work around the shear blades.

1. Apply #2 lithium tube grease once a month to the grease nipples on both ends of the frame (Figure 17).
2. Keep the slip rolls clean and rust-free, and frequently apply a light coat of oil to them.
3. Lightly brush a multi-purpose grease onto the gears at the end of the rollers (Figure 17). Turn the operating handle to distribute the grease.
4. Keep other exposed areas clean and lightly coated with oil, such as the shear blades, table and upper dies. (Remove the upper dies from the bar for more effective cleaning).

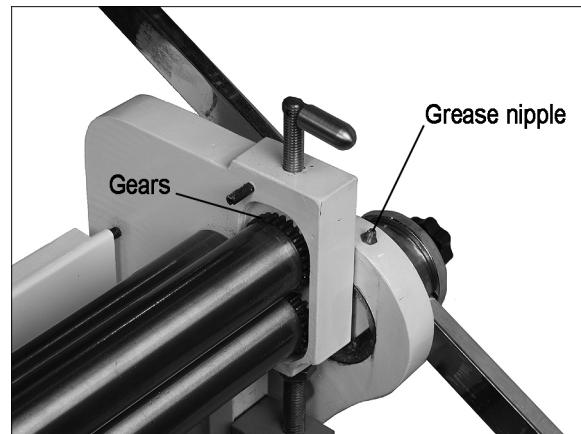


Figure 17

## Optional Accessories

| Part No. | Description                |
|----------|----------------------------|
| 754030   | Optional Stand for SBR-30N |
| 754040   | Optional Stand for SBR-40N |

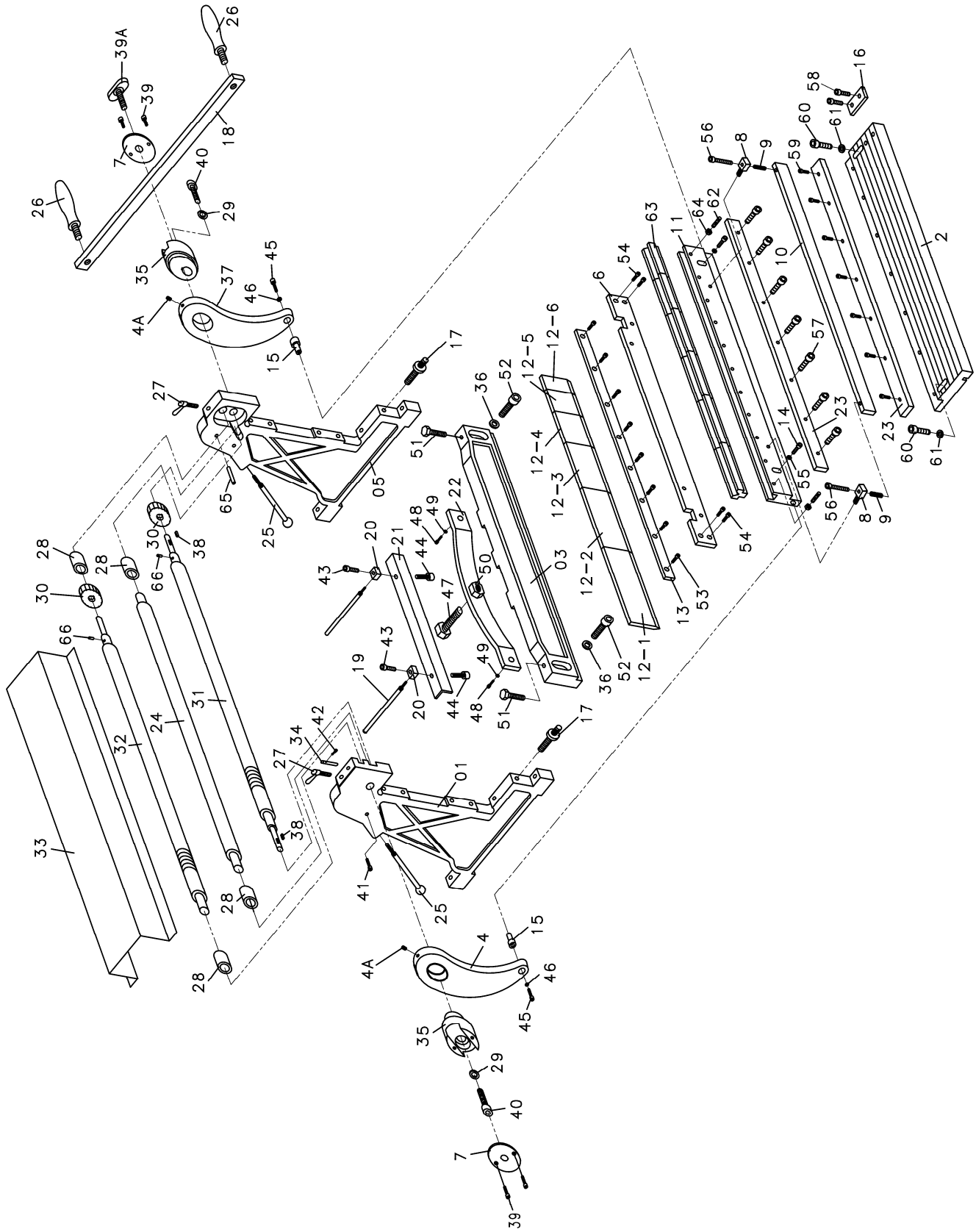


Optional Stand

## 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 (see our website for business hours, [www.waltermeier.com](http://www.waltermeier.com)). Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

# Breakdown for the SBR-30N Shear, Brake, and Roll

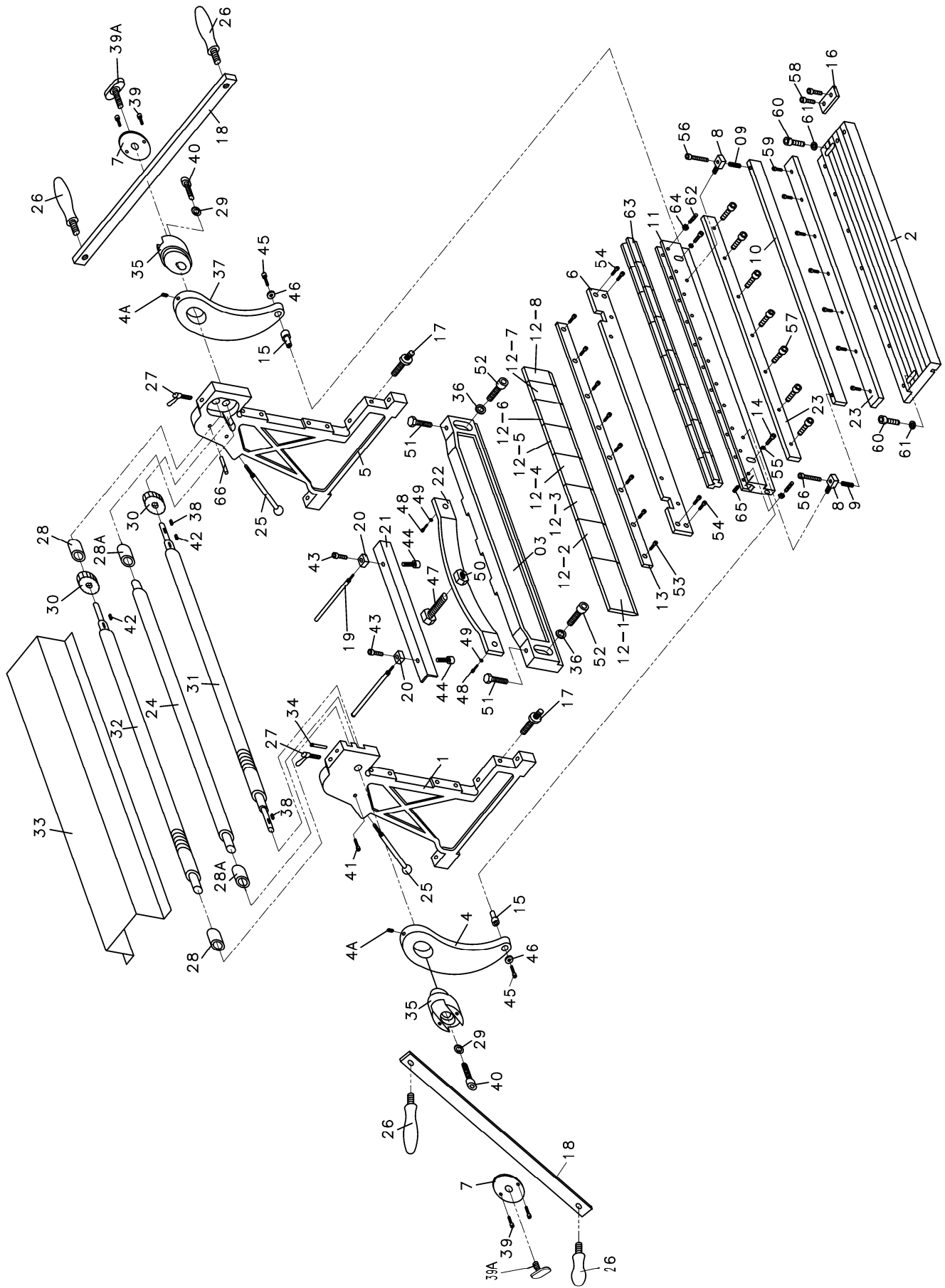


## Parts List for the SBR-30N Shear, Brake, and Roll

| Index No. | Part No.    | Description            | Size        | Qty |
|-----------|-------------|------------------------|-------------|-----|
| 1         | SBR30N-1    | Frame (Left)           |             | 1   |
| 2         | SBR30N-2    | Table                  |             | 1   |
| 3         | SBR30N-3    | Brake Beam             |             | 1   |
| 4         | SBR30N-4N   | Arm (Left)             |             | 1   |
| 4A        | SBR30N-4A   | Zerk Fitting           |             | 2   |
| 5         | SBR30N-5    | Frame (Right)          |             | 1   |
| 6         | SBR30N-6    | Spacer Bar             |             | 1   |
| 7         | SBR30N-7    | Cover                  |             | 2   |
| 8         | SBR30N-8    | Pressure Plate Bracket |             | 2   |
| 9         | SBR30N-9    | Spring                 |             | 2   |
| 10        | SBR30N-10   | Press Plate            |             | 1   |
| 11        | SBR30N-11   | Cutter Plate           |             | 1   |
| 12-1      | SBR30N-12-1 | Brake Forming Die      | 10"         | 1   |
| 12-2      | SBR30N-12-2 | Brake Forming Die      | 8"          | 1   |
| 12-3      | SBR30N-12-3 | Brake Forming Die      | 6"          | 1   |
| 12-4      | SBR30N-12-4 | Brake Forming Die      | 3"          | 1   |
| 12-5      | SBR30N-12-5 | Brake Forming Die      | 2"          | 1   |
| 12-6      | SBR30N-12-6 | Brake Forming Die      | 1"          | 1   |
| 13        | SBR30N-13   | Press Plate            |             | 1   |
| 14        | TS-1491081  | Hex Cap Screw          | M10x50      | 2   |
| 15        | SBR30N-15   | Pivot Bushing          |             | 2   |
| 16        | SBR30N-16   | Block                  |             | 1   |
| 17        | SBR30N-17   | Adjustable Bolt        |             | 2   |
| 18        | SBR30N-18   | Handle Bar             |             | 1   |
| 19        | SBR30N-19   | Guide Rod              |             | 2   |
| 20        | SBR30N-20   | Guide Block            |             | 2   |
| 21        | SBR30N-21   | Guide Plate            |             | 1   |
| 22        | SBR30N-22   | Guide Bar              |             | 1   |
| 23        | SBR30N-23A  | Cutter                 | 25mm x 12mm | 2   |
| 24        | SBR30N-24   | Roll                   |             | 1   |
| 25        | SBR30N-25   | Screw                  |             | 2   |
| 26        | SBR30N-26   | Handle                 |             | 2   |
| 27        | SBR30N-27   | Adjustable Bolt        |             | 2   |
| 28        | SBR30N-28   | Bushing                |             | 4   |
| 29        | SBR30N-29   | Cover                  |             | 2   |
| 30        | SBR30N-30   | Gear                   |             | 2   |
| 31        | SBR30N-31   | Lower Pressing Roll    |             | 1   |
| 32        | SBR30N-32   | Upper Pressing Roll    |             | 1   |
| 33        | SBR30N-33   | Cover                  |             | 1   |
| 34        | SBR30N-34   | Shaft                  |             | 1   |
| 35        | SBR30N-35   | Eccentric Shaft        |             | 2   |
| 36        | TS-1550071  | Flat Washer            | M10         | 2   |
| 37        | SBR30N-37N  | Arm (Right)            |             | 1   |
| 38        | SBR30N-38   | Key                    | C8x25       | 2   |
| 39        | TS-1503031  | Hex Socket Cap Screw   | M6x12       | 4   |
| 39A       | SBR30N-39N  | Lock Bolt              |             | 1   |
| 40        | TS-1503021  | Hex Socket Cap Screw   | M6x10       | 2   |
| 41        | TS-1482081  | Hex Cap Screw          | M6x40       | 2   |
| 42        | TS-1503031  | Hex Socket Cap Screw   | M6x12       | 1   |
| 43        | TS-1503021  | Hex Socket Cap Screw   | M6X10       | 2   |
| 44        | SBR30N-44   | Screw                  |             | 2   |
| 45        | TS-1505061  | Hex Socket Cap Screw   | M10x40      | 2   |
| 46        | TS-1550071  | Flat Washer            | M10         | 2   |
| 47        | TS-1492051  | Hex Cap Screw          | M12x50      | 1   |
| 48        | TS-1491021  | Hex Cap Screw          | M10x20      | 2   |
| 49        | TS-1550071  | Flat Washer            | M10         | 2   |

| Index No. | Part No.   | Description          | Size   | Qty |
|-----------|------------|----------------------|--------|-----|
| 50        | TS-1540081 | Hex Nut              | M12    | 1   |
| 51        | TS-1492041 | Hex Cap Screw        | M12x40 | 2   |
| 52        | TS-1505051 | Hex Socket Cap Screw | M10x35 | 2   |
| 53        | TS-1504051 | Hex Socket Cap Screw | M8x25  | 9   |
| 54        | TS-1505031 | Hex Socket Cap Screw | M10x25 | 4   |
| 55        | TS-1550071 | Flat Washer          | M10    | 2   |
| 56        | TS-1490151 | Hex Cap Screw        | M8x90  | 2   |
| 57        | TS-1503021 | Hex Socket Cap Screw | M6x10  | 7   |
| 58        | TS-1503031 | Hex Socket Cap Screw | M6x12  | 2   |
| 59        | TS-1503031 | Hex Socket Cap Screw | M6x12  | 7   |
| 60        | TS-1505031 | Hex Socket Cap Screw | M10x25 | 2   |
| 61        | TS-1550071 | Flat Washer          | M10    | 2   |
| 62        | TS-1522031 | Socket Set Screw     | M5x10  | 20  |
| 63        | SBR30N-63  | V-Block              |        | 5   |
| 64        | TS-1540031 | Hex Nut              | M5     | 20  |
| 65        | SBR30N-65N | Roll Pin             | A5x26  | 2   |
| 66        | SBR30N-66N | Roll Pin             | A4x8   | 2   |
| 67        | SBR30N-WL  | Warning Label        |        | 1   |

# Breakdown For The SBR-40N Shear, Brake, and Roll





## Parts List For The SBR-40N Shear, Brake, and Roll

| Index No. | Part No.    | Description            | Size   | Qty |
|-----------|-------------|------------------------|--------|-----|
| 1         | SBR40N-1    | Frame (Left)           |        | 1   |
| 2         | SBR40N-2    | Table                  |        | 1   |
| 3         | SBR40N-3    | Cross Beam             |        | 1   |
| 4         | SBR40N-4N   | Arm (Left)             |        | 1   |
| 4A        | SBR40N-4A   | Zerk Fitting           |        | 2   |
| 5         | SBR40N-5    | Frame (Right)          |        | 1   |
| 6         | SBR40N-6    | Spacer Bar             |        | 1   |
| 7         | SBR40N-7    | Cover                  |        | 2   |
| 8         | SBR40N-8    | Pressure Plate Bracket |        | 2   |
| 9         | SBR40N-9    | Spring                 |        | 2   |
| 10        | SBR40N-10   | Press Plate            |        | 1   |
| 11        | SBR40N-11   | Cutter Plate           |        | 1   |
| 12-1      | SBR40N-12-1 | Brake Forming Die      | 15"    | 1   |
| 12-2      | SBR40N-12-2 | Brake Forming Die      | 10"    | 1   |
| 12-3      | SBR40N-12-3 | Brake Forming Die      | 7"     | 1   |
| 12-4      | SBR40N-12-4 | Brake Forming Die      | 4"     | 1   |
| 12-5      | SBR40N-12-5 | Brake Forming Die      | 2-1/2" | 1   |
| 12-6      | SBR40N-12-6 | Brake Forming Die      | 2"     | 1   |
| 12-7      | SBR40N-12-7 | Brake Forming Die      | 1-1/2" | 1   |
| 12-8      | SBR40N-12-8 | Brake Forming Die      | 1"     | 1   |
| 13        | SBR40N-13   | Press Plate            |        | 1   |
| 14        | TS-1492051  | Hex Cap Screw          | M12x45 | 2   |
| 15        | SBR40N-15   | Pivot Bushing          |        | 2   |
| 16        | SBR40N-16   | Stop Block             |        | 1   |
| 17        | SBR40N-17   | Adjustable Bolt        |        | 2   |
| 18        | SBR40N-18   | Handle Bar             |        | 2   |
| 19        | SBR40N-19   | Guide Rod              |        | 2   |
| 20        | SBR40N-20   | Guide Block            |        | 2   |
| 21        | SBR40N-21   | Guide Plate            |        | 1   |
| 22        | SBR40N-22   | Support Plate          |        | 1   |
| 23        | SBR40N-23   | Cutter                 |        | 2   |
| 24        | SBR40N-24   | Roll                   |        | 1   |
| 25        | SBR40N-25N  | Screw w/Knob           |        | 2   |
| 26        | SBR30N-26   | Handle                 |        | 4   |
| 27        | SBR40N-27   | Adjustable Bolt        |        | 2   |
| 28        | SBR40N-28   | Bushing                |        | 2   |
| 28A       | SBR40N-28A  | Bushing                |        | 2   |
| 29        | SBR40N-29   | Cover                  |        | 2   |
| 30        | SBR40N-30N  | Gear                   |        | 2   |
| 31        | SBR40N-31   | Lower Pressing Roll    |        | 1   |
| 32        | SBR40N-32   | Upper Pressing Roll    |        | 1   |
| 33        | SBR40N-33   | Cover                  |        | 1   |
| 34        | SBR40N-34   | Lock Shaft             |        | 1   |
| 35        | SBR40N-35   | Eccentric Shaft        |        | 2   |
| 36        | TS-155010   | Flat Washer            | M16    | 2   |
| 37        | SBR40N-37N  | Arm (Right)            |        | 1   |
| 38        | SBR40N-38N  | Key                    | C8x28  | 2   |
| 39        | TS-1503041  | Hex Socket Cap Screw   | M6x16  | 4   |
| 39A       | SBR40N-39N  | Lock Bolt              |        | 2   |
| 40        | TS-1503041  | Hex Socket Cap Screw   | M6x16  | 2   |
| 41        | SBR40N-41N  | Set Screw              |        | 2   |
| 42        | SBR40N-42N  | Key                    | B4x8   | 1   |
| 43        | TS-1492011  | Hex Cap Screw          | M12x25 | 2   |
| 44        | TS-2211201  | Hex Cap Screw          | M12x16 | 2   |
| 45        | TS-1506111  | Hex Socket Cap Screw   | M12x70 | 2   |
| 46        | TS-2360121  | Flat Washer            | M12    | 2   |

| Index No. | Part No.   | Description          | Size    | Qty |
|-----------|------------|----------------------|---------|-----|
| 47        | TS-149B16  | Hex Cap Screw        | M16x100 | 1   |
| 48        | TS-2212301 | Hex Cap Screw        | M16x30  | 2   |
| 49        | TS-155010  | Flat Washer          | M16     | 2   |
| 50        | TS-154010  | Hex Nut              | M16     | 1   |
| 51        | TS-1492021 | Hex Cap Screw        | M12x30  | 2   |
| 52        | SBR40N-52N | Hex Socket Cap Screw | M16x55  | 2   |
| 53        | TS-1503061 | Hex Socket Cap Screw | M6x25   | 13  |
| 54        | SBR40N-54N | Hex Socket Cap Screw | M16x35  | 4   |
| 55        | TS-2360121 | Flat Washer          | M12     | 2   |
| 56        | TS-1499141 | Hex Cap Screw        | M12x75  | 2   |
| 57        | TS-1503041 | Hex Socket Cap Screw | M6x16   | 6   |
| 58        | TS-1503041 | Hex Socket Cap Screw | M6x16   | 2   |
| 59        | TS-1503041 | Hex Socket Cap Screw | M6x16   | 6   |
| 60        | SBR40N-60N | Hex Socket Cap Screw | M16x35  | 2   |
| 61        | TS-155010  | Flat Washer          | M16     | 2   |
| 62        | TS-1522041 | Hex Socket Screw     | M5x12   | 14  |
| 63        | SBR40N-63N | V-Block              |         | 7   |
| 64        | TS-1540031 | Hex Nut              | M5      | 14  |
| 65        | TS-1502041 | Hex Socket Cap Screw | M5X16   | 14  |
| 66        | SBR30N-65N | Roll Pin             | A5x26   | 2   |
| 67        | SBR30N-WL  | Warning Label        |         | 1   |





**WALTER MEIER (Manufacturing) Inc.**

427 New Sanford Road  
LaVergne, Tennessee 37086  
Phone: 800-274-6848  
[www.waltermeier.com](http://www.waltermeier.com)