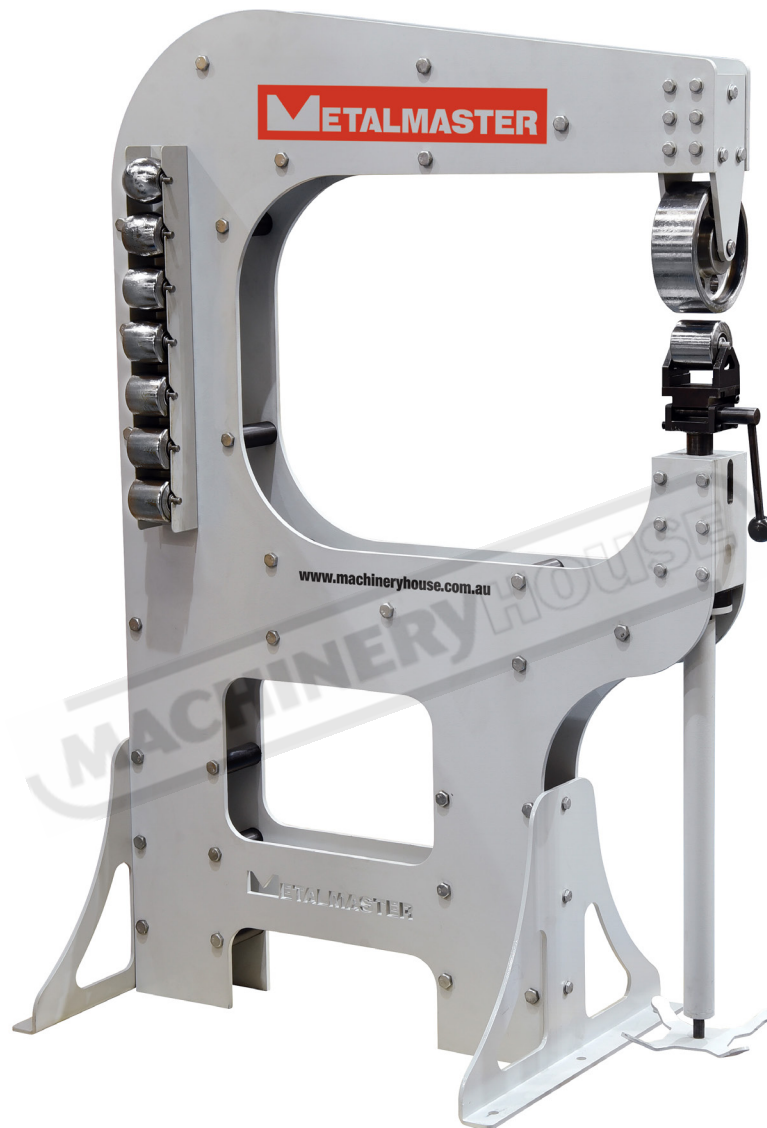


METALMASTER

OPERATION MANUAL



ENGLISH WHEEL

Model. EWHD-80

Order Code S2254

Edition No : EWHD-80-1

Date of Issue : 09/2021

www.machineryhouse.com.au

MACHINE DETAILS

MACHINE	<input type="text" value="ENGLISH WHEEL"/>
MODEL NO.	<input type="text" value="EWHD-80"/>
SERIAL NO.	<input type="text"/>
DATE OF MANF.	<input type="text"/>

Distributed by

www.machineryhouse.com.auwww.machineryhouse.co.nz**NOTE:**

This manual is only for your reference. Owing to the continuous improvement of the Metalmaster machine, changes may be made at any time without obligation or notice. Please ensure the local voltage is the same as listed on the specification plate before operating any electric machine.

**NOTE:**

In order to see the type and model of the machine, please see the specification plate usually found on the back of the machine. See example (Fig.1)

**PRODUCT SPECIFICATIONS**Model: EWHD-80 Nett Weight: 260kg
Capacity: 1.6mm MS MFG Date:Serial No: Imported by www.machineryhouse.com.au Made in China
www.machineryhouse.co.nz

Fig.1

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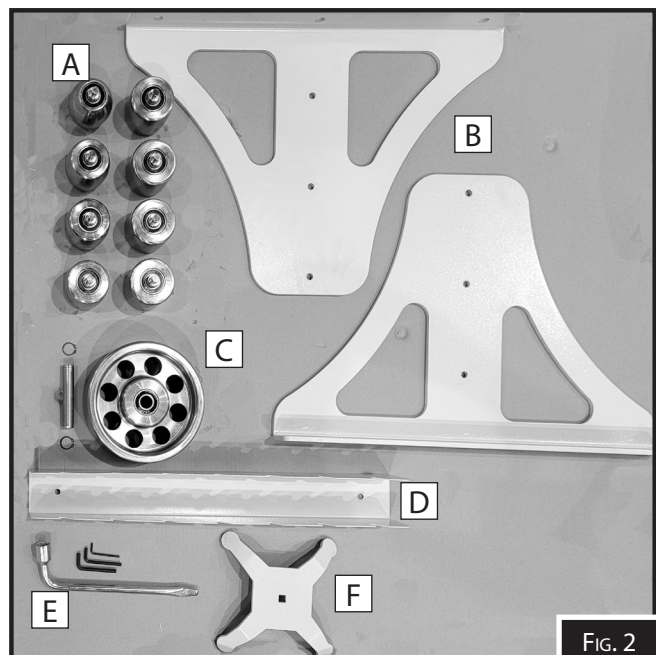
1.1 SPECIFICATION

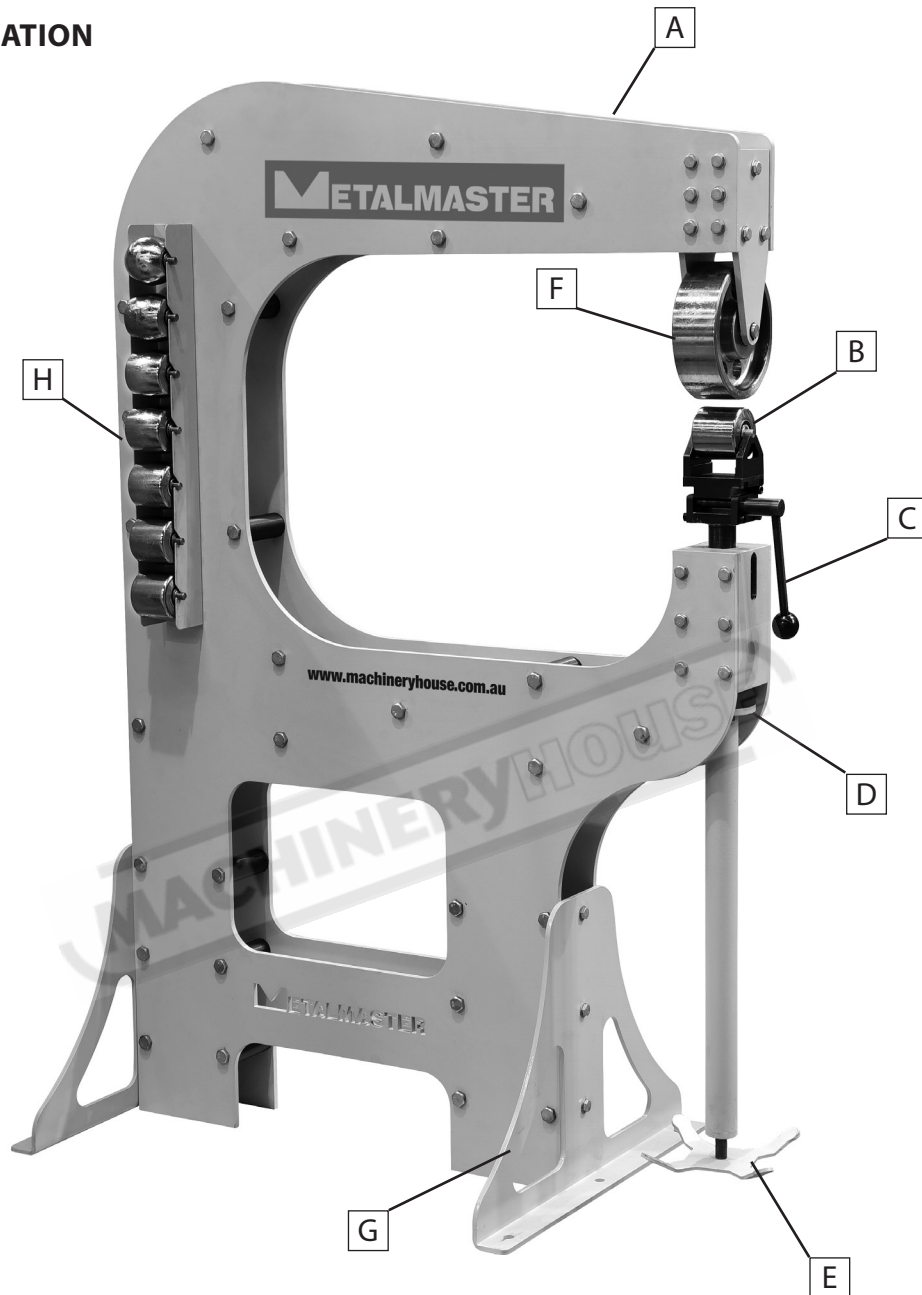
Order Code	S2254
MODEL	EWHD-80
Operation (Type)	Hand Operated
Mild Steel - Capacity (mm/gauge)	1.6 / 16
Aluminium - Capacity (mm/gauge)	2.0
Throat Depth (mm)	800
Working Height (mm)	1250
Top Anvil Size (mm)	Ø197 x 70
Radius Anvils (mm)	50.8, 101.6, 152.4, 203.2, 304.8 609.6, 914,
Dimensions (L x W x H) (mm)	650 x 1330 x 1680
Packing Dimensions (L x W x H) (cm)	175 x 125 x 27
Weight (kg)	260

1.2 PACKING LIST (FIG. 2)

The following is a list of items shipped with your machine. Before beginning setup, lay these items out and make sure they are all there. If any non-proprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

- A. Bottom anvils 50.8, 101.6, 152.4, 203.2, 304.8, 609.6, 914mm.
 - B. Foot Plates
 - C. Top anvil, shaft and circlips.
 - D. Anvil storage rack
 - E. Tools
 - F. Foot adjusting wheel
- Instruction Manual and main frame (Not Shown)



1.3 IDENTIFICATION

A	Main Frame	E	Foot Adjusting Wheel
B	Bottom Anvil	F	Top Anvil
C	Quick Release Lever	G	Foot Plates
D	Lower Anvil Assembly	H	Anvil Storage Rack

2.1 GENERAL METALWORKING MACHINE SAFETY

**WARNING**

When using any tool, basic safety precautions should always be followed to reduce the risk of personal injury and damage. Read the instruction manual before using any tool or machine!

1. **Keep work area clean.** Cluttered areas invite injuries
2. **Observe work area conditions.** Do not use machines or power tools in damp or wet locations. Don't expose to rain. Keep the work area well lit. Do not use electric power tools or machinery in the presence of flammable gases or liquids.
3. **Keep children away.** Children must never be allowed in the work area. Do not let them handle machinery, tools, or extension cords.
4. **Store idle equipment.** When not in use, tools must be stored in a dry location to inhibit rust. Always lock up tools and keep out of reach of children.
5. **Do not force tool.** It will do the job better and more safely at the rate for which it was intended. Do not use inappropriate attachments in an attempt to exceed the tool capacity.
6. **Use the right tool for the job.** Do not attempt to force any machine, tool or attachment to do the work of a larger industrial tool. Do not modify, and do not use any tool for a purpose for which it was not intended.
7. **Dress properly.** Do not wear loose clothing or jewelry as they can be caught in moving parts. Protective, electrically non-conductive clothes and non-skid footwear are recommended when working. Wear restrictive hair covering to contain long hair.
8. **Use eye and ear protection.** Always wear ANSI approved impact safety goggles. Wear a full face shield if you are producing metal filings or wood chips. Wear an ANSI approved dust mask or respirator when working around metal, wood, and chemical dusts and mists.
9. **Do not overreach.** Keep proper footing and balance at all times. Do not reach over or across running machines. Keep hands and fingers clear of moving parts.
10. **Maintain tools with care.** Keep tools clean for better and safer performance. Follow the instructions for lubricating and changing accessories. Handles must be kept clean, dry, and free from oil and grease at all times.
11. **Remove adjusting keys and wrenches.** Check that keys and adjusting wrenches are removed from the tool or machine work surface before plugging it in.
12. **Stay alert.** Be attentive and use common sense. Do not operate any machine or tool when you are tired.
13. **Check for damaged parts.** Before using any machine or tool, parts that appears damaged should be carefully checked to determine that it will operate properly and perform its intended function safely. Check for alignment and binding of moving parts. Any broken parts or mounting fixtures, or any other condition that may affect proper operation. Any part that is damaged should be properly repaired or replaced by a qualified technician. Do not use the machine or tool if any switch does not turn on and off properly.

2.1 GENERAL METALWORKING MACHINE SAFETY

14. **Replacement parts and accessories.** When servicing, use only identical replacement parts. The use of any other parts will void the warranty. Only use accessories intended for use with the machine or tool.
15. **Do not operate** machinery if under the influence of alcohol or drugs. Read warning labels if taking prescription medicine to determine if your judgment or reflexes are impaired while taking drugs. If there is any doubt, do not operate the machinery or tools.
16. **Maintenance.** For your safety, service and maintenance should be performed regularly by a qualified technician.
17. **Workpiece may be sharp.** After bending or cutting workpieces use caution. Be aware of sharp edges or metal debris of metal that may be created. Use heavy duty gloves when handling the workpiece.
18. **Health and fire hazards.** Understand that the health and fire hazards can vary from material to material. Make sure all appropriate precautions are taken.
19. **Clean-up when finished.** Clean machines and the surrounding area when the operation is finished.
20. **Use proper lock out procedures.** When servicing or cleaning machines, make sure that the machine cannot be started by accident.

DO NOT

- × **Do not** distract an operator. Horseplay can lead to injuries and should be strictly prohibited.
- × **Do not** wear loose clothing, gloves, necktie's, rings, bracelets or other jewellery that can be come entangled in moving parts. Confine long hair.
- × **Do not** handle cuttings by hand because they are very sharp. Do not free a stalled cutter without turning the power off first. Do not clean hands with cutting fluids.
- × **Do not** use rags or wear gloves near moving parts of machines.
- × **Do not** use compressed air to blow debris from machines or to clean dirt from clothes.
- × **Do not** force the machine. It will do the job safer and better at the rate for which it was designed.



Before operating any machine, take time to read and understand all safety signs and symbols. If not understood seek explanation from your supervisor. Machines are safeguarded to protect the operator from injury or death with the placement of guards. Machines must not be operated with the guards removed or damaged.

2.2 SPECIFIC SAFETY FOR ENGLISH WHEELS

DO NOT use this machine unless you have been instructed in its safe use and operation and have read and understood this manual.



Safety glasses must be worn at all times in work areas.



Close fitting protective clothing or overalls are encouraged



Appropriate protective footwear with substantial uppers must be worn.



Rings and jewellery must NOT be worn in the workshop



Gloves should be worn when handling the work piece



Ear protection should be used in loud and noisy conditions

PRE-OPERATIONAL SAFETY CHECKS

1. Ensure you are familiar with the operation of the English Wheel
2. Check for any damage or parts missing
3. The area around the machine must be clean and free of trip hazards.
4. Any forming anvil being used must be inspected for safe use i.e. no cracks.
5. Ensure safety glasses or goggles are available and are worn by all persons in the vicinity.
6. Any test piece, project or material (work piece) to be worked must be of an appropriate thickness and safe to use on this equipment.
7. Faulty equipment must not be used. Immediately check suspect machinery.

OPERATIONAL SAFETY CHECKS

1. Place your test piece, project or material (work piece) securely between the top and bottom anvils
2. Do not over reach. Maintain a balanced stance at all times, so that you do not fall or lean against the machine.
3. Use the English Wheel by moving the workpiece in a forward and back action, to slowly work the material.
4. Keep hands and fingers away from the anvils.
5. Wear leather gloves when handling the work piece.
6. Use the right tool. Do not force an anvil set to do a job that it was not designed to do.
7. Give your work undivided attention. Looking around, carrying on a conversation and "horseplay" are careless acts that can result in serious injury
8. DO NOT apply excessive force to the English Wheel.

AFTER OPERATION COMPLETED

1. Clean the machine and place any tools and equipment in the appropriate storage area.
2. Place all scrap or waste in the appropriate bin.

POTENTIAL HAZARDS

- Beware of high forces applied
- Pinch and squash
- Eye injuries – flying or shattering objects
- Laceration injuries

3. SETUP

3.1 UNPACKING

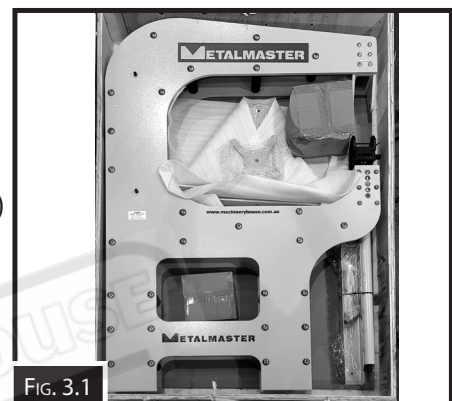
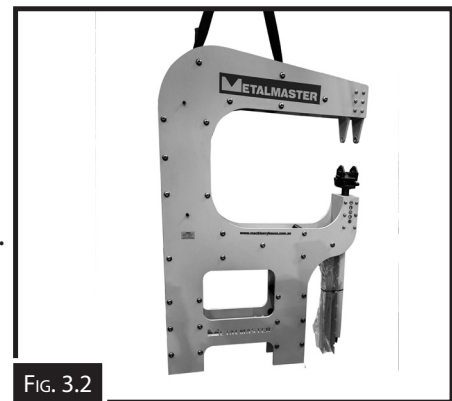
When unpacking, check to make sure that all parts shown in the Parts Diagram are included. If any parts are missing or broken, please contact the distributor

3.2 ASSEMBLY

The METALMASTER English Wheel will require minor assembly prior to operation. It is important that the entire manual is read to become familiar with the unit BEFORE you assemble and use the Machine. Before assembling the English Wheel, be sure that you have all parts described in the Parts List.

To assemble the machine:

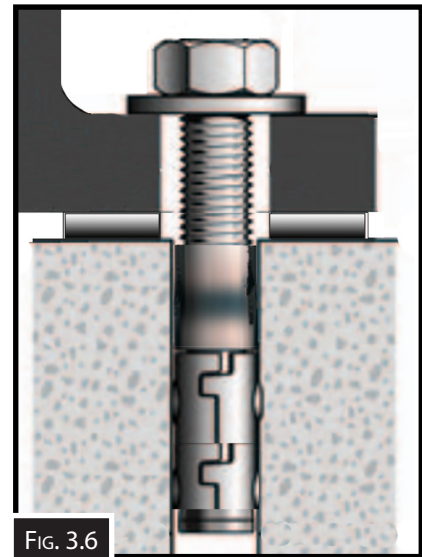
1. Lay the wooden case with the English Wheel and its components on the floor where the unit will be located and mounted. The floor must be able to support the weight of the English Wheel and the workpieces. (Fig. 3.1)
2. With a lifting device carefully lift and hold up the English Wheel vertically while it is assembled. (Fig. 3.2)
3. Attach the foot plates to the bottom of the machine frame at the front and the back of the main frame with the M10 x 20mm Screws and a M10 washer. (Fig. 3.3)
4. Attach the Adjusting Foot Wheel to the lower wheel assembly, making sure that the square hole in the wheel fits onto the square on the shaft and the ends of the wheel face up and not down. Secure with the M6 x 10 screw and M6 washer. (Fig. 3.3)
5. Attach the anvil storage rack to the side of the main frame using the two M8 x 20mm screws and M8 washers. (Fig. 3.4)
6. Locate the top wheel shaft and the two circlips. Place a circlip on one end of the shaft and attach the top anvil then place the second circlip on the shaft. (Fig. 3.5)

**FIG. 3.1****FIG. 3.2****FIG. 3.5****FIG. 3.4****FIG. 3.3**

3.3 ANCHORING TO THE FLOOR

Metalmaster strongly recommends anchoring the English Wheel to the floor to prevent it from tipping or shifting. Because floor materials may vary, anchoring hardware is not included with the machine.

The machine is best mounted on a concrete slab. Masonry anchors with bolts are the best way to anchor the machinery, because the anchors sit flush with the floor surface, making it easy to unbolt and move the machine later, if needed. (Fig. 3.6)

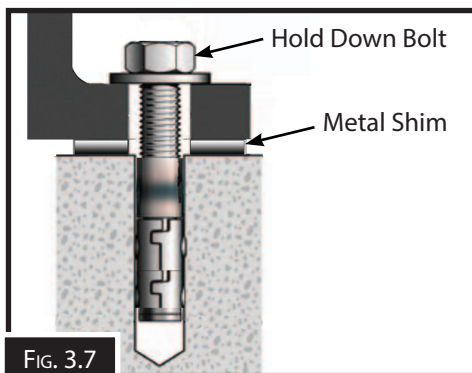


3.4 LEVELING THE ENGLISH WHEEL

Although this is not essential the leveling of your machine will help it operate to its optimum performance,

To level the machine apply the following procedure

After your machine has been anchored to a concrete slab floor, it then needs to be leveled. Loosen the hold down bolts and place a level on the side of the frame. Metal shims need to be placed under corner of the base of the machine until it is level. Once level then tighten the hold down bolts. (Fig. 3.7).



The machine must not rest on supports other than those defined in Fig. 3.7

4. OPERATION

4.1 OPERATIONAL OVERVIEW

The instructions in this section are written with the understanding that the operator has the necessary knowledge and skills to operate this machine.

1. Clean the workpiece and wheels thoroughly, making sure any abrasive particles are removed. Grit or dirt will mark the workpiece and may even damage the wheels.
2. Dull any sharp edges with a deburring tool and have the operator wear a pair of leather gloves to prevent any injury to the hands.
3. Select the bottom anvil from the Anvil Storage Rack, and place on the bottom anvil in the Yoke. When selecting the bottom anvil, consider the type and hardness of the metal being formed as well as the desired curvature of the metal.
4. Check the distance between the bottom of the upper anvil and top of the lower anvil. They should be about 25mm apart. To adjust the distance, rotate the adjusting foot wheel to lower or raise the lower anvil.
5. Engage the quick release lever to raise the lower anvil to the operating position.
6. Using your foot turn the adjusting foot wheel to raise or lower the Bottom Anvil Yoke for an appropriate clearance (or pinching) of the metal between the two anvils. It is better to have a loose pinch than a tight one. A tight pinch will make it harder to push the metal through the anvils and may cause unwanted creasing. A loose pinch makes it easier to push the metal through the anvils, and with more accuracy. It may take more passes to form the metal, however.
7. Begin forming the metal by pushing and pulling it over the anvils. Roll the workpiece up to an edge, rotate it slightly, then pull it back.
8. Turn the adjusting foot wheel counterclockwise to increase pressure on the workpiece; turn the adjusting foot wheel clockwise to decrease pressure.
9. Make small adjustment between the anvils, when turning the adjusting foot wheel.

Note: *To reinsert the workpiece or insert another workpiece of the same thickness, use the quick release lever to open the anvils.*



CAUTION *CRUSHING HAZARD! Hold the upper anvil securely when installing or removing it as it may cause injury if it falls! Steel toe footwear should be worn to protect the feet.*

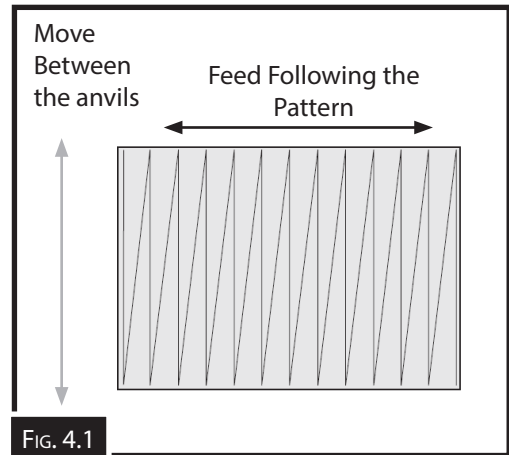
4.2 TRACKING PATTERNS

When metal passes between the upper and lower anvil, a “track” or shiny line is pressed into the metal. Various tracking patterns can be used to shape workpieces depending upon their shape or size. Bellow are a list of patterns and their use.

Zigzag Pattern

This pattern can be used for a series of forms.(Fig. 4.1)

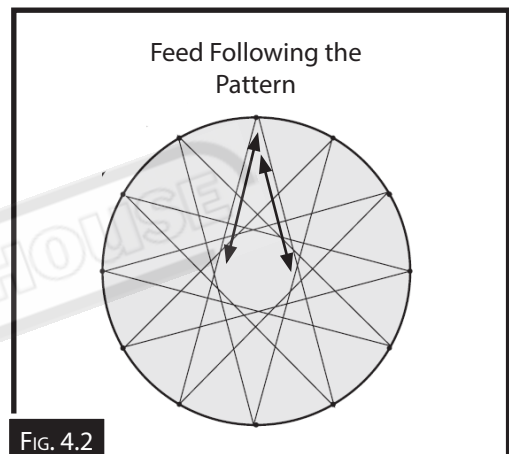
Note: Try keeping the tracks close to each other in a consistent pattern



Star Pattern

The star pattern is useful for shaping round workpieces. (Fig. 4.2)

Note: Avoid rolling directly over center of workpiece, as too many passes could overstretch the metal.



5. MAINTENANCE

5.1 CLEANING AND OILING

When finished with the machine always clean down the machine and oil with a light oil all moving parts and machined surfaces. Inspect the general condition of the tool. Check for loose screws, misalignment or binding of moving parts, cracked or broken parts, and any other condition that may affect its safe operation. If abnormal noise or vibration occurs, have the problem corrected before further use. Do not use damaged equipment.

5.2 MAINTENANCE SCHEDULE

Maintenance Chart						
Maintenance Type	Before Use	After Use	Weekly	Monthly	Every 6 Months	Yearly
Inspect Tools for damage	x					
Wipe off with clean cloth		x	x	x	x	x
Oil moving parts with light oil				x		

5.3 TROUBLESHOOTING

Review the troubleshooting and procedures in this section if a problem develops with your machine. If you need replacement parts then follow the procedure in beginning of the spare parts section or if additional help with a procedure is required, then contact your distributor.

Note: Make sure you have the model of the machine, serial number, and manufacture date before calling.

Symptoms	Possible Cause	Possible Solution
Quick release lever will not engage, or has trouble engaging.	1. Lower anvil bracket and cams bind. 2. Setscrews on cams loose and not contacting quick release lever flats.	1. Lubricate top of cams where they contact the bracket 2. Align setscrews over lever flats and tighten
Anvil does not shape workpiece.	1. Workpiece is too thick. 2. Crown is too low. 3. Incorrect pressure.	1. Use sheet metal of appropriate thickness. 2. Use a lower wheel with a higher crown. 3. Increase pressure on workpiece.
Anvils form too high a crown in workpiece	1. Using lower anvil with too small a flat area.	1. Use a lower anvil with a larger flat.
Anvils form too low a crown in workpiece.	1. Lower anvil flat is too large.	1. Use a lower anvil with a smaller flat area

MACHINERYHOUSE

SPARE PARTS SECTION

English Wheel Model. EWHD-80

Order Code S2254

Edition No : EWHD-80-1

Date of Issue : 09/2021

The following section covers the spare parts diagrams and lists that were current at the time this manual was originally printed. Due to continuous improvements of the machine, changes may be made at any time without notification.

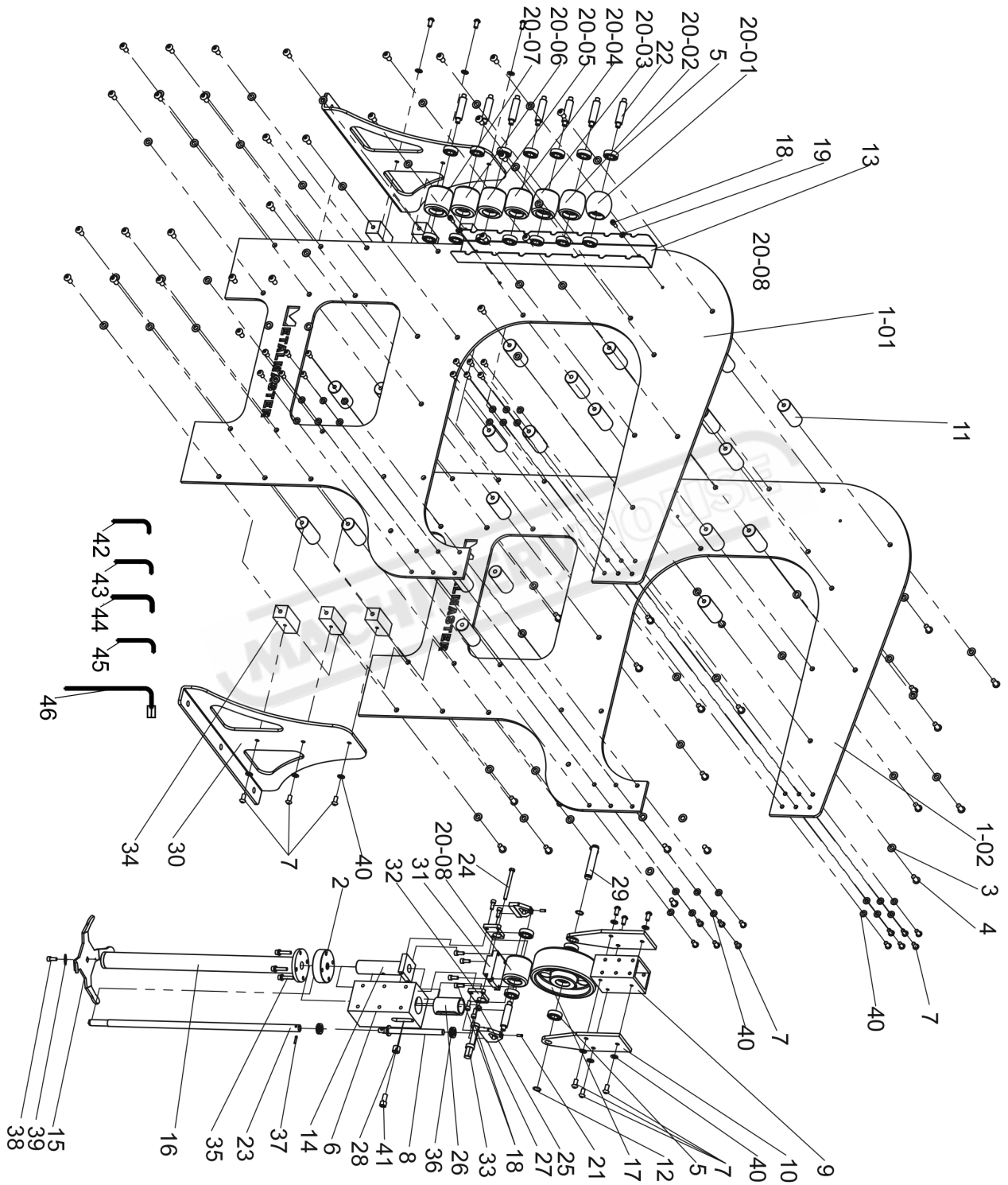
HOW TO ORDER SPARE PARTS

1. Have your machines **model number, serial number & date of manufacture** on hand, these can be found on the specification plate mounted on the machine
2. A scanned copy of your parts list/diagram with required spare part/s identified.

NOTE: SOME PARTS MAY ONLY BE AVAILABLE AS AN ASSEMBLY

3. Go to www.machineryhouse.com.au/contactus and fill out the inquiry form attaching a copy of scanned parts list.

SPARE PARTS DIAGRAM



SPARE PARTS LIST

ITEM	DESCRIPTION	QTY.	ITEM	DESCRIPTION	QTY.
1-01	LEFT SIDE PLATE	1	20-08	FLAT LOWER WHEEL	1
1-02	RIGHT SIDE PLATE	1	21	SCREW M6X20	2
2	ROUND PLATE	1	22	LOWER WHEEL SHAFT	8
3	WASHER 14MM	58	23	ADJUSTMENT SHAFT	1
4	BOLT M14X25	58	24	BOLT	1
5	BEARING 6004-2Z	18	25	LOCKING NUT M6	1
6	LOWER SLIDE BLOCK	1	26	COPPER BUSHING	1
7	SCREW M10X20	36	27	LOWER WHEEL PLATE	2
8	SCREW	1	28	BUSHING	1
9	MAIN TOP BLOCK	1	29	UPPER WHEEL SHAFT	1
10	UPPER WHEEL PLATE	2	30	LEG	2
11	PLATE SPACER	22	31	LOWER WHEEL BLOCK	1
12	C-RING 20MM	2	32	PLATE	2
13	LOWER WHEEL RACK	1	33	ECCENTRIC ADJUSTER	1
14	GUIDE SHAFT	1	34	SQUARE PLATE SPACER	6
15	FOOT WHEEL	1	35	SCREW M8X50	4
16	ADJUSTING TUBE	1	36	BEARING 51103	2
17	UPPER WHEEL	1	37	PIN Ø6X20	1
18	SCREW M8X20	10	38	SCREW M6X10	1
19	WASHER 8MM	6	39	WASHER 6MM	1
20-01	2" LOWER WHEEL	1	40	WASHER 10MM	36
20-02	4" LOWER WHEEL	1	41	SCREW M10X20	1
20-03	6" LOWER WHEEL	1	42	HEX KEY WRENCH 3MM	1
20-04	8" LOWER WHEEL	1	43	HEX KEY WRENCH 5MM	1
20-05	12" LOWER WHEEL	1	44	HEX KEY WRENCH 6MM	1
20-06	24" LOWER WHEEL	1	45	HEX KEY WRENCH 8MM	1
20-07	36" LOWER WHEEL	1	46	L WRENCH 19MM	1

NOTE: SOME INDIVIDUAL PARTS MAY ONLY BE AVAILABLE AS AN ASSEMBLY

WARNING

General Machinery Safety Instructions

Machinery House
requires you to read this entire Manual before using this machine.

- 1. Read the entire Manual before starting machinery.** Machinery may cause serious injury if not correctly used.
- 2. Always use correct hearing protection when operating machinery.** Machinery noise may cause permanent hearing damage.
- 3. Machinery must never be used when tired, or under the influence of drugs or alcohol.** When running machinery you must be alert at all times.
- 4. Wear correct Clothing.** At all times remove all loose clothing, necklaces, rings, jewelry, etc. Long hair must be contained in a hair net. Non-slip protective footwear must be worn.
- 5. Always wear correct respirators around fumes or dust when operating machinery.** Machinery fumes & dust can cause serious respiratory illness. Dust extractors must be used where applicable.
- 6. Always wear correct safety glasses.** When machining you must use the correct eye protection to prevent injuring your eyes.
- 7. Keep work clean and make sure you have good lighting.** Cluttered and dark shadows may cause accidents.
- 8. Personnel must be properly trained or well supervised when operating machinery.** Make sure you have clear and safe understanding of the machine you are operating.
- 9. Keep children and visitors away.** Make sure children and visitors are at a safe distance for you work area.
- 10. Keep your workshop childproof.** Use padlocks, Turn off master power switches and remove start switch keys.
- 11. Never leave machine unattended.** Turn power off and wait till machine has come to a complete stop before leaving the machine unattended.
- 12. Make a safe working environment.** Do not use machine in a damp, wet area, or where flammable or noxious fumes may exist.
- 13. Disconnect main power before service machine.** Make sure power switch is in the off position before re-connecting.
- 14. Use correct amperage extension cords.** Undersized extension cords overheat and lose power. Replace extension cords if they become damaged.
- 15. Keep machine well maintained.** Keep blades sharp and clean for best and safest performance. Follow instructions when lubricating and changing accessories.
- 16. Keep machine well guarded.** Make sure guards on machine are in place and are all working correctly.
- 17. Do not overreach.** Keep proper footing and balance at all times.
- 18. Secure workpiece.** Use clamps or a vice to hold the workpiece where practical. Keeping the workpiece secure will free up your hand to operate the machine and will protect hand from injury.
- 19. Check machine over before operating.** Check machine for damaged parts, loose bolts, Keys and wrenches left on machine and any other conditions that may effect the machines operation. Repair and replace damaged parts.
- 20. Use recommended accessories.** Refer to instruction manual or ask correct service officer when using accessories. The use of improper accessories may cause the risk of injury.
- 21. Do not force machinery.** Work at the speed and capacity at which the machine or accessory was designed.
- 22. Use correct lifting practice.** Always use the correct lifting methods when using machinery. Incorrect lifting methods can cause serious injury.
- 23. Lock mobile bases.** Make sure any mobile bases are locked before using machine.
- 24. Allergic reactions.** Certain metal shavings and cutting fluids may cause an allergic reaction in people and animals, especially when cutting as the fumes can be inhaled. Make sure you know what type of metal and cutting fluid you will be exposed to and how to avoid contamination.
- 25. Call for help.** If at any time you experience difficulties, stop the machine and call you nearest branch service department for help.

WARNING

English Wheel Safety Instructions

Machinery House
requires you to read this entire Manual before using this machine.

- 1. Maintenance.** Make sure all moving parts are locked down before any inspection, adjustment or maintenance is carried out.
- 2. English Wheel Condition.** English Wheel machine must be maintained for a proper working condition. Never operate a English Wheel machine that has damaged or worn parts. Scheduled routine maintenance should performed on a scheduled basis.
- 3. Roll Condition.** Never operate a English Wheel machine with damaged or badly worn Rolls. Replace if required. Rolls should never be greased or lubricated as rolls will slip the material and will not bend.
- 4. Hand Hazard.** Keep hands and fingers clear from moving parts. Serious injury can occur if hand or finger tips get pinched by rolls and can be dragged into machine.
- 5. Gloves & Glasses.** Always wear leather gloves and approved safety glasses when using this machine.
- 6. Avoiding Entanglement.** Tie up long hair and use the correct hair nets to avoid any entanglement with the English Wheel machine moving parts.
- 7. Understand the machines controls.** Make sure you understand the use and operation of all controls.
- 8. Work area hazards.** Keep the area around the English Wheel machine clean from oil, tools, chips. Pay attention to other persons in the area and know what is going on around the area to ensure unintended accidents.
- 9. Guards.** Do not operate this machine without the correct guards in place. Necessary guards protect you from injuries by rolls and moving gears and parts.
- 10. Material condition.** Material must be clean out of oil and dry. Oily material can slip and will not bend.
- 11. Material hardness.** Make sure your hardness is the same throughout the material, we recommend that you use certified material. Never bend hard steel, glass or fragile material on this machine.
- 12. Level machine.** Level the machine on a flat concrete surface by using a spirit level.
- 13. Feeding material.** Making a tight bend in one pass is not possible. So you need several passes before you can achieve a certain radius. Tighter curves and full radius always need more passes.
- 14. Call for help.** If at any time you experience difficulties, stop the machine and call you nearest branch service department for help.

PLANT SAFETY PROGRAM

NEW MACHINERY HAZARD IDENTIFICATION, ASSESSMENT & CONTROL

English Wheel

Developed in Co-operation Between A.W.I.S.A and Australia Chamber of Manufactures
This program is based upon the Safe Work Australia, Code of Practice - Managing Risks of Plant in the Workplace (WHSA 2011 No10)

Item No.	Hazard Identification	Hazard Assessment	Risk Control Strategies <small>(Recommended for Purchase / Buyer / User)</small>
B	CRUSHING	LOW	Secure & support work material. Ensure machine is bolted down.
C	CUTTING, STABBING, PUNCTURING	MEDIUM	Wear gloves to prevent cuts from sharp material.
D	SHEARING	MEDIUM	Keep hands clear from moving parts on rolls.



Plant Safety Program to be read in conjunction with manufactures instructions



www.machineryhouse.com.au



www.machineryhouse.co.nz

Authorised and signed by:
Safety officer: 
Manager: 

Revised Date: 12th March 2012