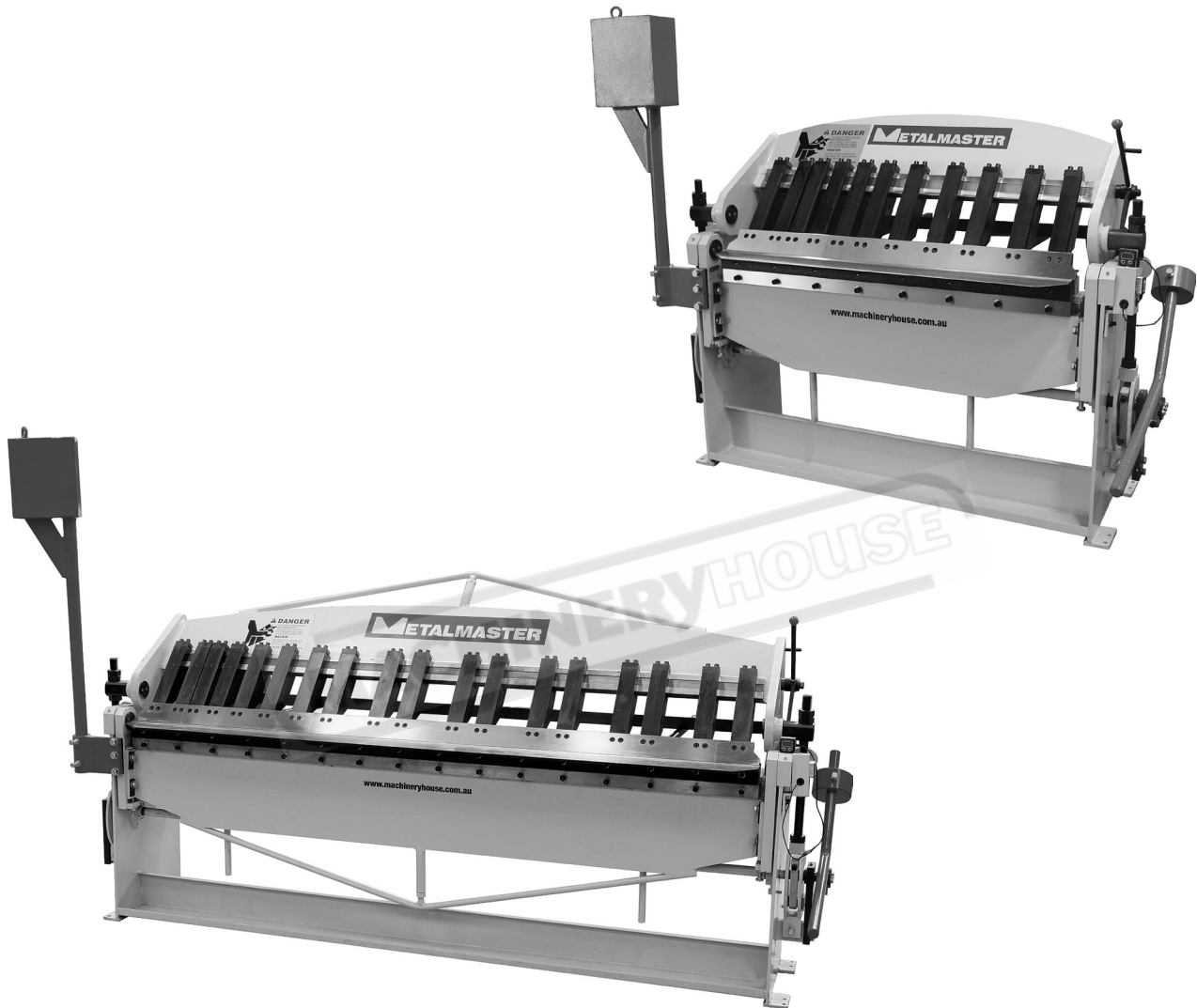


METALMASTER



Edition : 1.0
Date: (06/24)

Instruction Manual

MANUAL PANBRAKES PB-422A & PB-820A

Order Code: (S262 & S264)

MACHINE DETAILS

MACHINE.	MANUAL PANBRAKE
MODEL NO.	PB-422A & PD-820A
SERIAL NO.	
DATE OF MANF.	

Imported by

Australia



www.machineryhouse.com.au

New Zealand



www.machineryhouse.co.nz

NOTE:

This manual is only for your reference. At the time of the compiling of this manual every effort to be exact with the instructions, specifications, drawings, and photographs of the machine was taken. Owing to the continuous improvement of the HAFCO 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.

SAFETY SYMBOLS:

The purpose of safety symbols is to attract your attention to possible hazardous conditions



WARNING Indicates a potentially hazardous situation causing injury or death




CAUTION Indicates an alert against unsafe practices.

Note: Used to alert the user to useful information

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: PB	Nett Weight:
Capacity:	MFG Date:

Serial No:

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Fig.1

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1.1 SPECIFICATIONS

Order Code	S262	S264
Model	PB-422A	PB-820A
(mm) Bending Capacity - Mild Steel	2	2
(mm) Bending Capacity - Stainless Steel	1	1
(mm) Material Length Capacity	1250	2440
(mm) Floor Space (L x W x H)	1820 x 620 x 1300	2960 x 800 x 1470
(deg) Bending Angle	0-120	0-120
(mm) Backgauge Travel	1070	1070
(mm) Maximum Opening	135	135
(mm) Box Depth	230	230
(kg) Nett Weight	980	1530
Digital Angle Gauge	Fitted	Fitted

1.2 ACCESSORIES

1. Quick Action Beam Head Adjustment
2. Rear manual backgauge.
3. Includes digital angle readout with CR2032 battery

Warning: This product contains button or coin batteries which are hazardous if swallowed and are to be kept away from children.

WARNING	
	<p>KEEP OUT OF THE REACH OF CHILDREN Swallowing can lead to chemical burns and death within 2 hours of ingestion. Seek medical attention immediately</p>



CAUTION

It is impossible to cover all possible hazards. All workshop environments are different. These are designed as a guide to be used to compliment training and as a reminder to users prior to equipment use. Always consider safety first, as it applies to the individual working conditions.

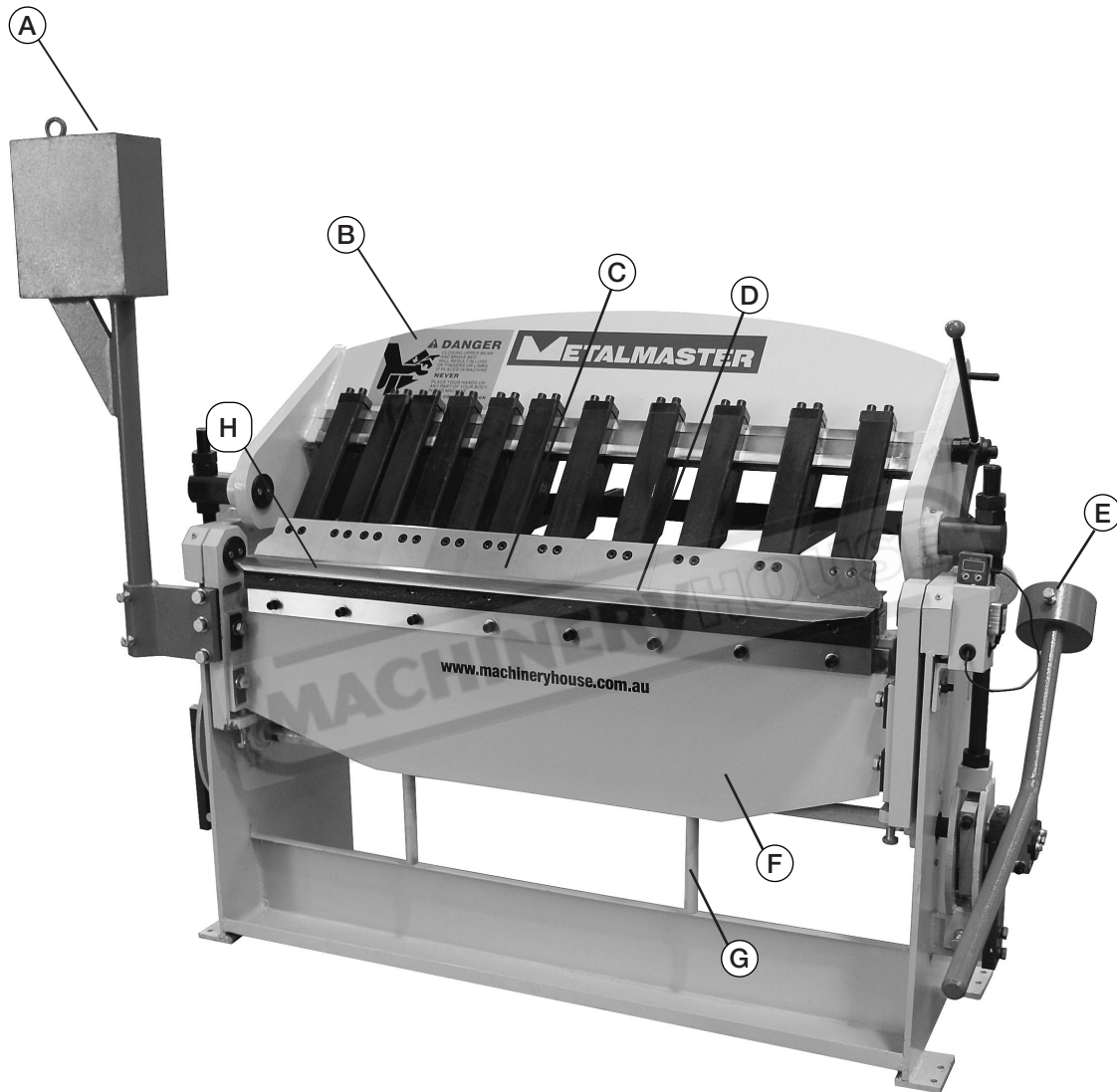


CAUTION

A prepared list of safety guidelines can never be complete. Every workshop environment is different. Always consider Safety first, as it applies to your individual working conditions. Use this machine and other machinery with caution and respect. Failure to do so could result in serious Personal injury, damage to the equipment, or poor work results.

1.3 IDENTIFICATION

Become familiar with the names and locations of the controls and features shown below to better understand the instructions when mentioned later in this manual.



A	Counter Weight	E	Clamping Handles
B	Clamping Leaf	F	Bending Leaf
C	Bending Fingers	G	Operating Handles
D	Clamp Block	H	Bending Wing

2. IMPORTANT INFORMATION

2.1 GENERAL METALWORKING MACHINE SAFETY

DO NOT use this machine unless you have read this manual or have been instructed in the use of this machine in its safe use and operation



WARNING

This manual provides safety instructions on the proper setup, operation, maintenance, and service of this machine. Save this manual, refer to it often, and use it to instruct other operators. Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.

The owner of this machine is solely responsible for its safe use. This responsibility includes, but is not limited to proper installation in a safe environment, personnel training and authorization to use, proper inspection and maintenance, manual availability and comprehension, of the application of the safety devices, integrity, and the use of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



- ✓ Always wear safety glasses or goggles.
- ✓ Wear appropriate safety footwear.
- ✓ Wear respiratory protection where required.
- ✓ Gloves should never be worn while operating the machine, and only worn when handling the workpiece.
- ✓ Wear hearing protection in areas > 85 dBA. If you have trouble hearing someone speak from one metre (three feet) away, the noise level from the machine may be hazardous.
- ✓ DISCONNECT THE MACHINE FROM POWER when making adjustments or servicing.
- ✓ Check and adjust all safety devices before each job.
- ✓ Ensure that guards are in position and in good working condition before operating.
- ✓ Ensure that all stationary equipment is anchored securely to the floor.
- ✓ Ensure all machines have a start/stop button within easy reach of the operator.
- ✓ Each machine should have only one operator at a time. However, everyone should know how to stop the machine in an emergency.

2.1 GENERAL SAFETY REQUIREMENTS Cont.

- ✓ Ensure that keys and adjusting wrenches have been removed from the machine before turning on the power. Appropriate storage for tooling should be provided.
- ✓ Ensure that all cutting tools and blades are clean and sharp. They should be able to cut freely without being forced.
- ✓ Stop the machine before measuring, cleaning or making any adjustments.
- ✓ Wait until the machine has stopped running to clear cuttings with a vacuum, brush or rake.
- ✓ Keep hands away from the cutting head and all moving parts.
- ✓ Avoid awkward operations and hand positions. A sudden slip could cause the hand to move into the cutting tool or blade.
- ✓ Return all portable tooling to their proper storage place after use.
- ✓ Clean all tools after use.
- ✓ Keep work area clean. Floors should be level and have a non-slip surface.
- ✓ Use good lighting so that the work piece, cutting blades, and machine controls can be seen clearly. Position any shade lighting sources so that they do not cause any glare or reflections.
- ✓ Ensure there is enough room around the machine to do the job safely.
- ✓ Obtain first aid immediately for all injuries.
- ✓ Understand that the health and fire hazards can vary from material to material. Make sure all appropriate precautions are taken.
- ✓ Clean machines and the surrounding area when the operation is finished.
- ✓ Use proper lock out procedures when servicing or cleaning the machines or power tools.

DO NOT

- × Do not distract an operator. Horseplay can lead to injuries and should be strictly prohibited.
- × Do not wear loose clothing, gloves, neckties, rings, bracelets or other jewellery that can become 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.

2.1 GENERAL SAFETY REQUIREMENTS Cont.

HAZARDS ASSOCIATED WITH MACHINES include, but are not limited to:

- Being struck by ejected parts of the machinery
- Being struck by material ejected from the machinery
- Contact or entanglement with the machinery
- Contact or entanglement with any material in motion

Health Hazards (other than physical injury caused by moving parts)

- Chemicals hazards that can irritate, burn, or pass through the skin
- Airborne items that can be inhaled, such as oil mist, metal fumes, solvents, and dust
- Heat, noise, and vibration
- Ionizing or non-ionizing radiation (X-ray, lasers, etc.)
- Biological contamination and waste
- Soft tissue injuries (for example, to the hands, arms, shoulders, back, or neck) resulting from repetitive motion, awkward posture, extended lifting, and pressure grip)

Other Hazards

- Slips and falls from and around machinery during maintenance
- Unstable equipment that is not secured against falling over
- Safe access to/from machines (access, egress)
- Fire or explosion
- Pressure injection injuries from the release of fluids and gases under high pressure
- Electrical Hazards, such as electrocution from faulty or ungrounded electrical components
- Environment in which the machine is used (in a machine shop, or in a work site)



WARNING

The machine is the sole responsibility of the owner for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training, proper inspection and maintenance, manual availability and comprehension. The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



WARNING!

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 SAFETY SPECIFIC TO PANBRAKES

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

PERSONAL PROTECTIVE EQUIPMENT



Safety glasses must be worn at all times in work areas



Long and loose hair must be contained.



Gloves must not be worn when using this machine.



Sturdy footwear must be worn at all times in work areas



Close fitting/protective clothing must be worn



Rings and jewellery must not be worn.

PRE-OPERATIONAL SAFETY CHECKS

- ✓ Locate and ensure you are familiar with all machine operations and controls.
- ✓ Ensure all guards are fitted, secure and functional. Do not operate if guards are missing or faulty.
- ✓ Ensure working parts are well lubricated and the jaws and fingers free of rust and dirt.
- ✓ Check workspaces and walkways to ensure no slip/trip hazards are present
- ✓ Be aware of other people in the area. Ensure the area is clear before using equipment.

OPERATIONAL SAFETY CHECKS

- ✓ Remove the panbrake fingers that are in the way. Use only the panbrake fingers required to make the bend.
- ✓ Ensure the panbrake fingers that are not removed for an operation are securely seated and firmly tightened before the machine is used.
- ✓ Ensure your fingers and limbs are clear before operating the panbrake.
- ✓ Lower finger clamps to work. Do not drop.
- ✓ Check workpiece is secure.
- ✓ Keep clear of moving counterweight (where fitted).

ENDING OPERATIONS AND CLEANING UP

- ✓ Lower finger clamps to a safe position.
- ✓ Return all accessories to storage racks.
- ✓ Leave the work area in a safe, clean and tidy state.

DON'T

- ✗ Do not use faulty equipment. Immediately report suspect machinery.
- ✗ Do not use a panbrake for bending metal that is beyond its capacity for thickness, shape or type.
- ✗ Do not attempt to bend rod, wire, strap or spring steel sheets.

POTENTIAL HAZARDS AND INJURIES

- ✓ Sharp edges and burrs.
- ✓ Squash/crush and pinch points.
- ✓ Impact from counterweight.

3 SET-UP

3.1 UNPACKING

This machine was carefully packaged for safe transport. When unpacking, separate all enclosed items from packaging materials and inspect them for shipping damage. If items are damaged, please contact your distributor.

NOTE: Save all the packaging materials until you are completely satisfied with the machine and have resolved any issues with the distributor, or the shipping agent.

When unpacking, check the packing list to make sure that all parts shown are included. If any parts are missing or broken, please contact your distributor.

3.2 CLEAN - UP

The unpainted surfaces of the machine have been coated with a waxy oil to protect them from corrosion during shipment. Remove the protective coating with a solvent cleaner or a citrus based degreaser.

Optimum performance from your machine will be achieved when you clean all moving parts or sliding contact surfaces that are coated with rust preventive products.

It is advised to avoid chlorine based solvents, such as acetone or brake parts cleaner, as they will damage painted surfaces and strip metal should they come in contact. Always follow the manufacturer's instructions when using any type of cleaning product.

3.3 SITE PREPARATION

When selecting the site for the machine, consider the largest size of workpiece that will be processed through the machine and provide enough space around the machine for operating the machine safely. Consideration should be given to the installation of auxiliary equipment. Leave enough space around the machine to open or remove doors/covers as required for the maintenance and service as described in this manual.

It is recommended that the machine is anchored to the floor to prevent tipping or shifting. It also reduces vibration that may occur during operation.

3.4 LIFTING INSTRUCTIONS

⚠ WARNING *This machine is extremely heavy. Serious personal injury may occur if safe moving methods are not followed. To be safe, you will need assistance and power equipment when moving the shipping crate and removing the machine from the crate.*



On the day that the machine arrives, make sure that a forklift or lifting device, with sufficient capacity is available to unload the machine from the vehicle. Ensure access to the chosen site is clear and that doors and ceilings are sufficiently high and wide enough to receive the machine.

3.5 ANCHORING TO THE FLOOR

The machine is best mounted on a concrete slab. Masonry anchors with bolts are the best way to anchor machinery, because the anchors sit flush with the floor surface, making it easy to unbolt and move the machine later if needed. (Fig. 3.1)

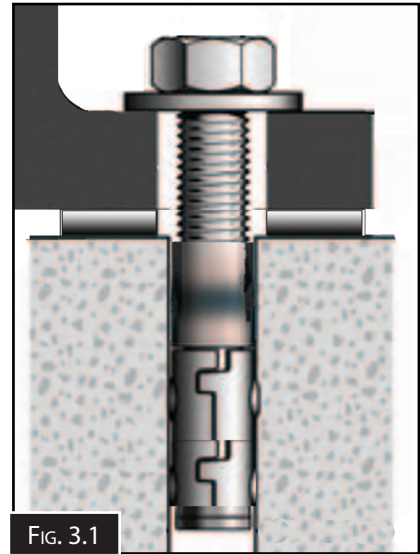


FIG. 3.1

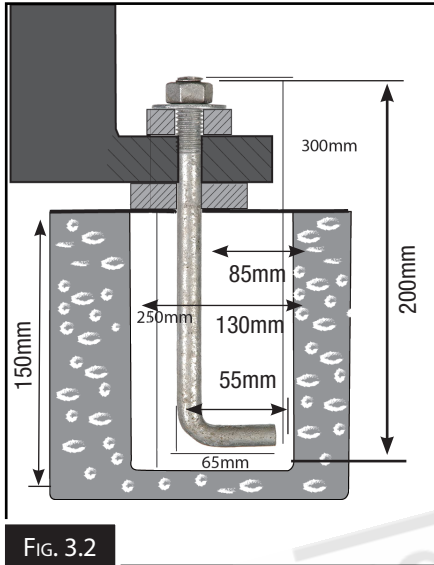


FIG. 3.2

In some cases a suitable foundation may not be available and a new one may need to be prepared. The foundation should be concrete approximately 250mm thick with pockets left clear for the hold down bolts. The hold down bolts can be “L” shape as per the example in Fig. 3.2

3.6 MACHINE LEVELLING

To set your machine up so that it operates to optimum performance, apply the following procedure. After your machine has been anchored to a concrete slab floor, it then needs to be levelled. Loosen the hold down bolts and place a level on the surface of the working table. Metal shims need to be placed under the corner of the base of the machine until level. Once level then tighten the hold down bolts. (Fig. 3.3).

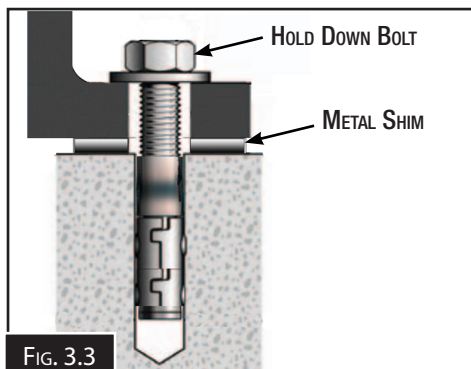


FIG. 3.3



CAUTION

The machine must not rest on supports other than those defined in Fig. 3.3

3.7 ASSEMBLY

The machine must be fully assembled before it can be operated. First clean any parts that are coated in rust preventative to ensure the assembly process can proceed smoothly.

Counter Weight:

1. With the help of a mechanical hoist lift the counter weight up and bolt it to the machine using the three bolts supplied. (Fig. 3.4)

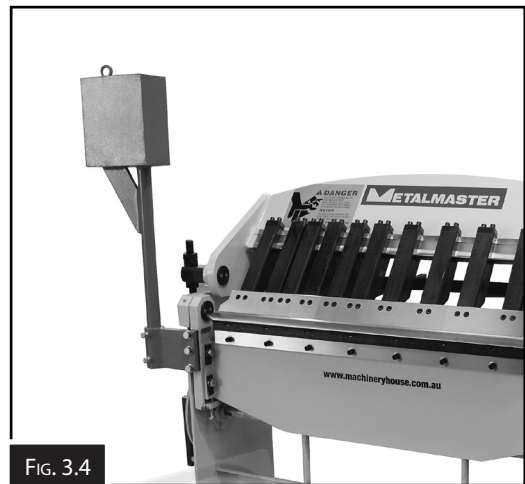


FIG. 3.4

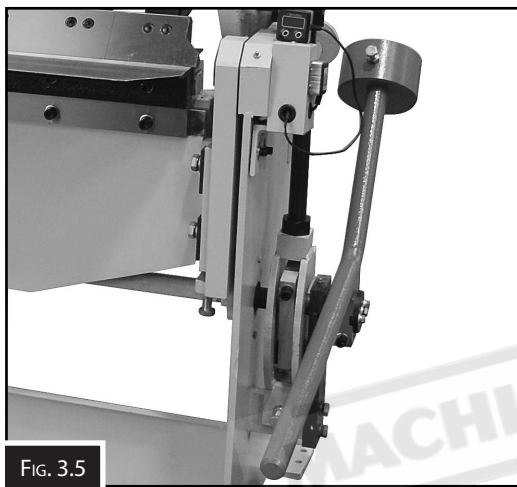


FIG. 3.5

Clamping Handle

1. With the help of a mechanical hoist lift the clamping handles up and fit it to the machine and clamp with the bolts supplied. (Fig. 3.5)

Manual Back Gauge

1. Bolt the two support arms to the back of the machine and then fit the back gauge. (Fig. 3.6)



FIG. 3.6

! WARNING	
PINCH POINTS	<i>This machine has many places that are pinch points and could cause injury to the operator or any person around this type of equipment</i>

	WARNING <i>Serious injury could occur if you connect machine to power before completing the setup process. DO NOT connect to power until all assembly and adjusting processes are complete.</i>
--	---

4. OPERATION

4.1 ADJUSTING THE SETBACK

Set back is the distance from the forward edge of the fingers to the edge of the bending leaf.

The set back on the PB series is set to achieve either sharp or round bends depending on the sheet metal gauge. Normally the setback is adjusted at least 1.5 to 2 times the thickness of the work-piece. (Fig. 4.1)

TO ADJUST THE SET BACK:

1. Raise the clamping leaf about 25mm. Loosen the lock screw.
2. Rotate the setback adjusting handles at the back of the machine on either side. Turning the wheels one way will cause the clamping wing to move forward. Turning it the other way will cause the clamping wing to move backward. (Fig. 4.2)

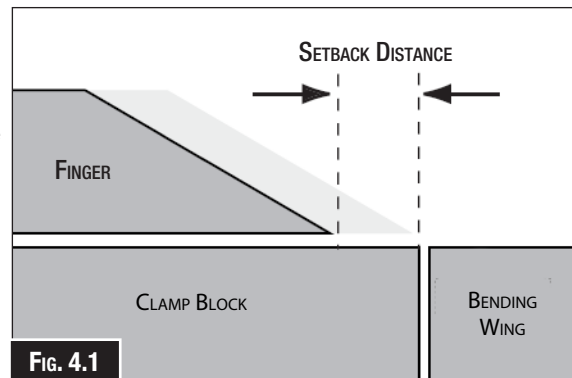


Fig. 4.1

4.2 ADJUSTING CLAMP PRESSURE

The clamping pressure is adjusted for different work-piece thicknesses. When the clamping pressure is adjusted properly, it will have medium resistance at the clamp handles and will lock the work-piece into position easily.

TO SPACE THE FINGERS:

1. Position two pieces of metal the same thickness as the work-piece on each end. When the fingers are slightly touching the workpiece, the clamping handles on the end of the machine should be at 2 o'clock position when viewed from that end. (Fig. 4.3)



Fig. 4.2

4.3 SPACING FINGERS

The fingers can be spaced apart for clearance when making pans or boxes. This requires removing one or more of the fingers, so that you can space the others to match the width of your pan or box.

TO SPACE THE FINGERS:

1. Loosen the cap screws from each of the fingers you decide to remove.
2. Align the remaining fingers and secure them by tightening the cap screws. (Fig. 4.4)

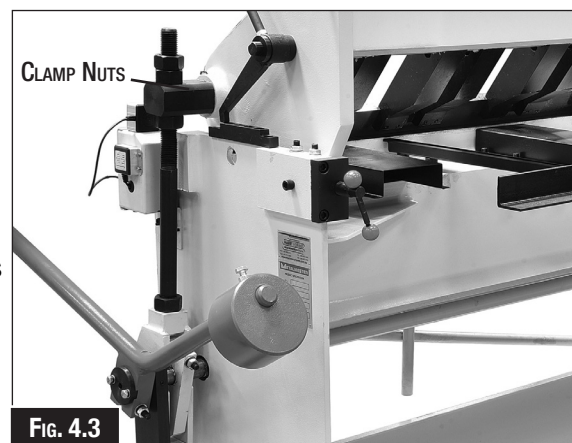


Fig. 4.3

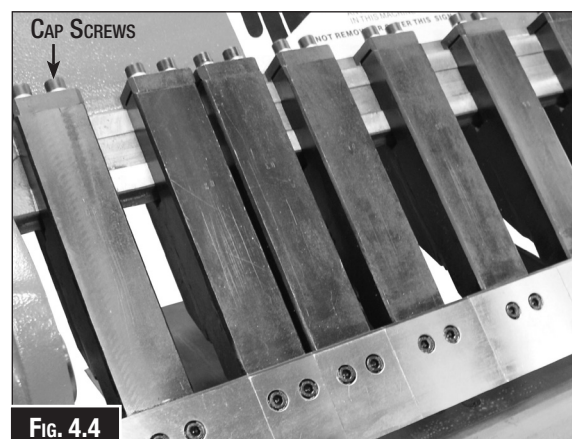


Fig. 4.4

4.4 BASIC OPERATION

The maximum capacity of the machine is 14 gauge (2mm) mild steel or equivalent. Below is an equivalency chart for use when working with materials other than mild steel: (Fig. 4.5)

MATERIAL	SIZE
Mild Steel	2.0mm
Stainless Steel	1.0mm
SAE 1050 Cold Rolled Steel	1.2mm
Aluminium	3.0mm
Soft Brass	2.2mm
Annealed Phosphorus Brass	2.0mm
Soft Copper	2.2mm
Hard Copper	2.0mm
ABS Plastic	4.0mm

FIG. 4.5

1. Install enough fingers to match the width of the metal to be bent (Fig. 4.6)
2. Lift the hold down lever and insert the sheet metal between the fingers and clamp block.
3. Align the sheet metal bend mark with the clamp block edge, and lightly clamp the sheet metal in place. If the lever is hard to lock in position, adjust both hold-down lock turnbuckles to accept the work-piece thickness.
4. Adjust setback so the finger tips are set back from the bending leaf edge a minimum of 1-1/2 times the metal thickness. (Fig.4.7)

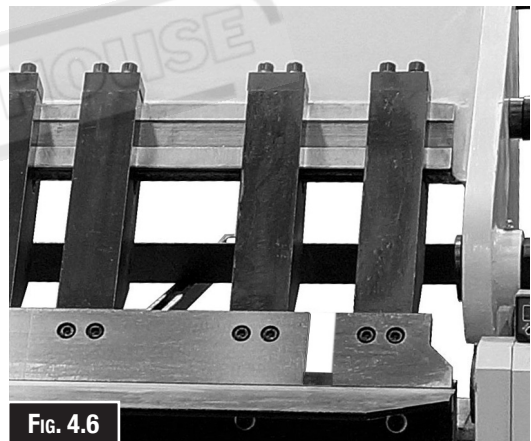


FIG. 4.6

Note: Damage to the tips of the fingers during bending can occur if not correctly set.

5. Lower the hold down lever and clamp the sheet metal in place.

Note: Do not force the hold down lever.

6. Lift up on the bending leaf operating levers until the sheet metal bend angle is at your desired angle.

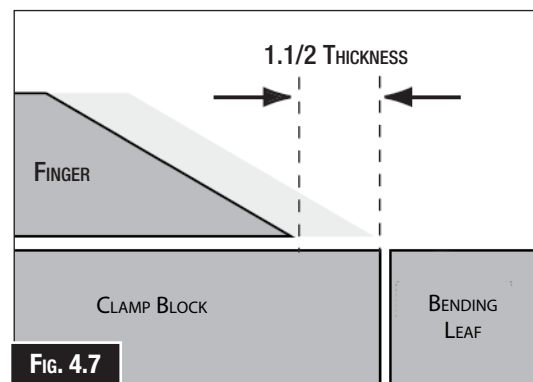


FIG. 4.7

4.5 DIGITAL ANGLE READOUT

Digital Level Box is a handy device for checking existing levels or angles. The magnetic base and automatic inversion allows easy reading and is accurate for angles. (Fig. 4.8)

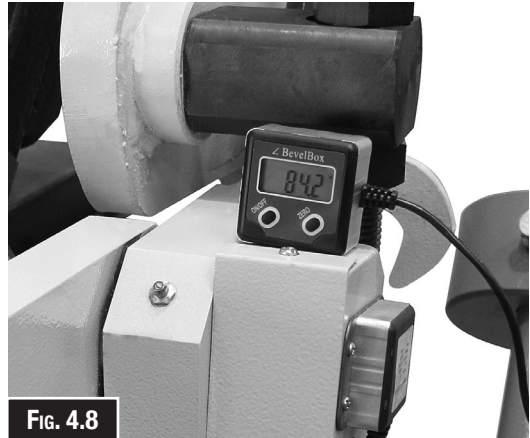
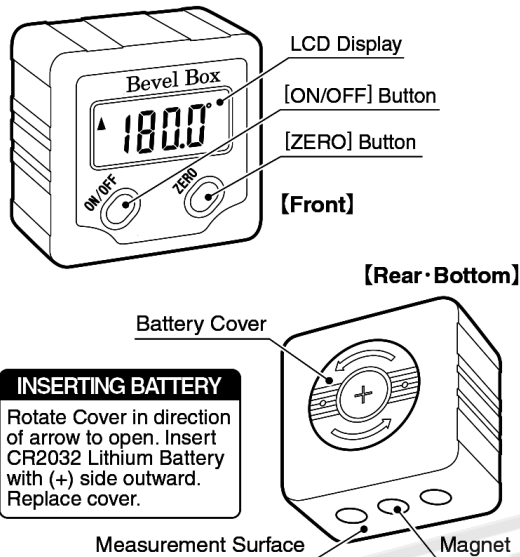


FIG. 4.8

Setting Zero

1. Press [ON/OFF] to turn on power.
2. Press the [ZERO] button (less than 1 sec). The LCD will display "0.0",

Warning: This product contains button or coin batteries which are hazardous if swallowed and are to be kept away from children

4.6 QUICK ACTION THICKNESS ADJUSTMENT

The capacity of your machine is stated on the specifications plate on the frame. This capacity is a mild steel rating. The capacity for other materials will vary. For example Stainless Steel is approximately 0.5x the mild steel rating & aluminium is 1.5x the mild steel rating.

Note ! This must be done on both sides.

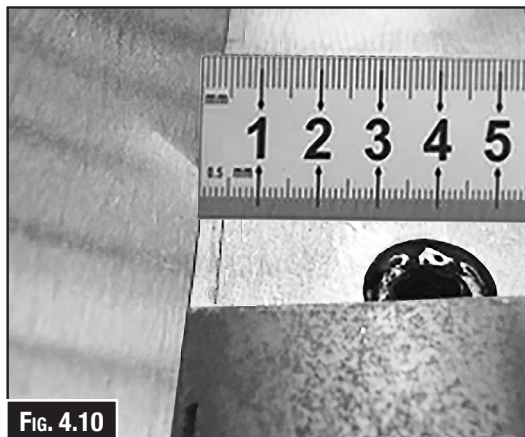


FIG. 4.10



FIG. 4.9

Set the clamp gap to match your material thickness. The clamp gap must be minimum 1.5 x Material Thickness

Example: If 4mm is to be bent, then the clamp "GAP" must be set to minimum of 6mm. Each panbrake may have a different mechanism for adjusting the clamp gap but you must maintain the 1.5 x Material Thickness to prevent overload and possible damage. (Fig. 4.9)

You may have to use a combination of top clamp adjustment and apron adjustment when doing thicker material like 6mm aluminium.

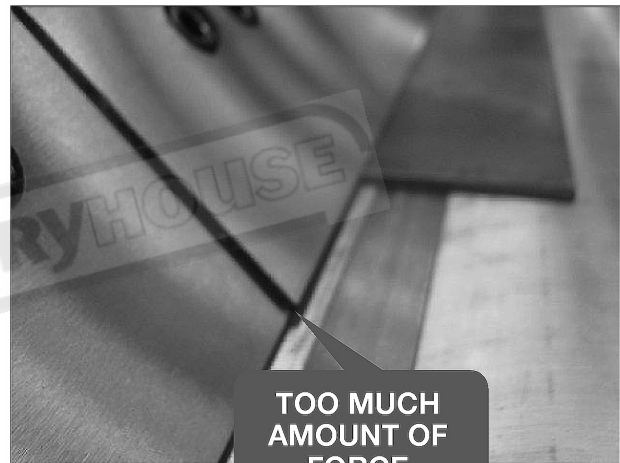
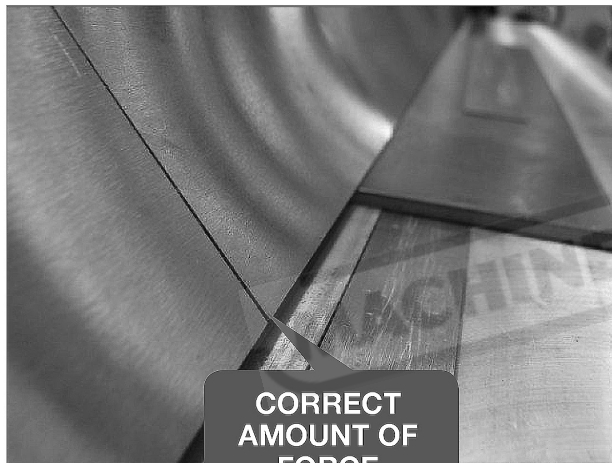
(1.5 x 6mm = 9mm, so you need a total gap of 9mm)

Example: If the top clamp gap is 6mm the apron must be dropped down 3mm to keep a 9mm total gap.

NOTE: Must release locking bolts before adjusting apron up / down. Tighten when at correct height

SETTING CLAMP GAP

IMPORTANT - The clamp pressure is set to bend the maximum capacity over the full length. If shorter pieces, very thin or softer materials are used, there is a possibility that damage can be caused to either the work piece or the fingers. There are 2 clamping techniques the operator can use depending on the material used.



LIGHT CLAMPING - The operator can use the clamp lever with caution and only use enough force required to hold material for bending. It is used when clamping thin aluminium or small pieces of thicker material.

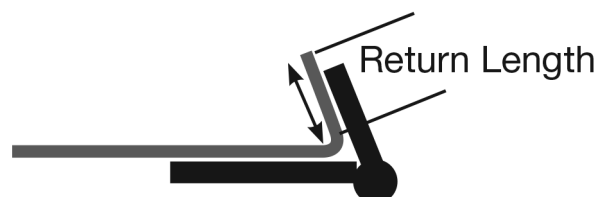
HEAVY CLAMPING - The operator can use the clamp lever until full capacity clamping is achieved. This technique can be used for bending full lengths of thicker material.

DOUBLE CHECK GAP - You must now clamp your job and check the clamp gap to make sure it is correct.

RETURN LENGTH - LIMITATION

Caution - There is a minimum "Return length" of 15 x Thickness of Material when bending thicker material over 1mm. Damage could occur to machine if return is too short.

Example: If bending 4mm then the minimum return length must be 60mm.



5. MAINTENANCE

It is very important that regular maintenance of the equipment is carried out. The operators need to follow the daily maintenance procedures.

For optimum performance from this machine, the maintenance schedule listed below and in this section must be followed.

- Loose mounting bolts or fasteners.
- Check/adjust lubrication.
- Any other unsafe condition.

5.1 LUBRICATION

Lubrication is very important to maintain bending accuracy and avoid machine troubles. Be sure to appropriately lubricate the machine according to the Lubrication points.

MONTHLY:

Using medium weight, non-detergent oil. The bending leaf pivot joints should be oiled through the oil fittings located on the right and left pivot points. (Fig. 5.1)

Oil the clamping handle bearing surfaces through oil fittings on top of links. Coat all exposed machined surfaces to prevent rusting.

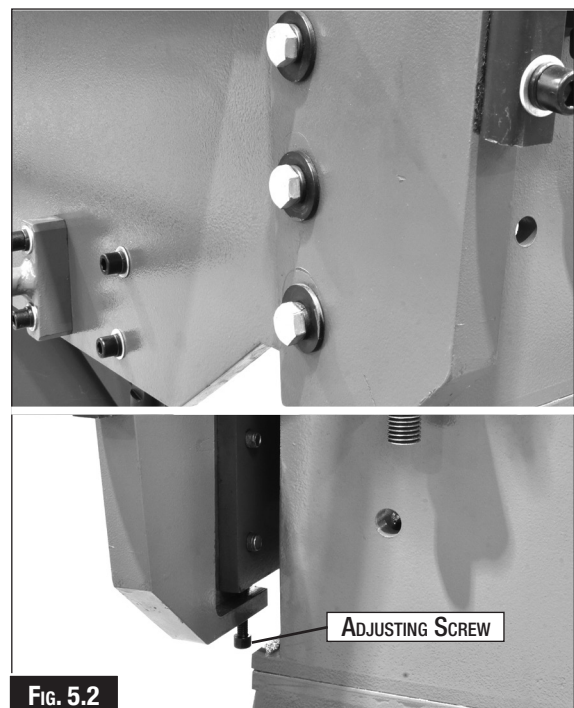


5.2 BENDING LEAF ADJUSTMENT

When the bending leaf is at the bottom dead center position, the edge of the bending leaf must be flush with the beam edge. After long time use, this may need to be adjusted.

TO ADJUST.

Loosen the three hex. head bolts on both sides of the bending leaf. Adjust the sck hd adjusting screws until the bending leaf is flush with the clamp block, then re-tighten the mounting bolts. If the leaf has been adjusted flush on both ends, but is not flush in the center, adjust the nuts located in the center of the beam and bending leaf until center is aligned. (Fig. 5.2)



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

Manual Panbrake 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. Place a block of timber between the Top Tooling and bed to help save hand or fingers from being crushed.
- 2. Panbrake Condition.** Panbrake must be maintained for a proper working condition. Never operate a Panbrake that has damaged or worn parts. Scheduled routine maintenance should be performed on a scheduled basis.
- 3. Tooling Condition.** Never operate a Panbrake with damaged or badly worn tooling. Replace if required.
- 4. Hand Hazard.** Do not insert or extend your hands in between bending tools, under any circumstances, while the machine is in operation mode. Serious injury can occur.
- 5. Gloves & Glasses.** Always wear leather gloves and approved safety glasses when using this machine.
- 6. Work area hazards.** Keep the area around the Panbrake clean from oil, tools, objects & chips. Pay attention to other persons in the area and know what is going on around the area to ensure unintended accidents.
- 7. Guards.** Operate machine only with all protective devices and guarding.
- 8. Material.** Do not over load the machine's capacity by using material which is too thick or hard.
- 9. Warning Labels.** Take note of any warning labels on the machine and do not remove them.
- 10. Support arms.** Do not use support arms for intermediate storage of workpieces.
- 11. Operation.** During the bending process, the workpiece may leap up. Therefore, the material must be handled carefully.
- 12. Secure Panbrake.** Make sure you bolt and the machine down so it is secure when in operation.
- 13. Heating Material.** Heating metal with a torch while the metal is in the panbrake will weaken the fingers.
- 14. Pinching.** Prevent pinching by lowering the panbrake fingers when not in use.
- 15. Call for help.** If at any time you experience difficulties, stop the machine and call your nearest branch service department for help.

PLANT SAFETY PROGRAM

NEW MACHINERY HAZARD IDENTIFICATION, ASSESSMENT & CONTROL

Manual Panbrake

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 on table etc. Lower Panbrake fingers when not in use. Keep fingers clear during clamping. Ensure machine is bolted down.
C	CUTTING, STABBING, PUNCTURING	MEDIUM	Wear gloves to prevent cuts from sharp material offcuts.
F	STRIKING	MEDIUM	Ensure the area around the counter weight is kept clear.
Plant Safety Program to be read in conjunction with manufactures instructions			



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Authorised and signed by:

Safety officer:

Manager:

[Handwritten signatures]

Revised Date: 12th March 2012

NOTES

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ENVIRONMENT PROTECTION

Recycle unwanted materials instead of disposing of them as waste. All tools, accessories and packaging should be sorted, taken to a recycling centre and disposed of in a manner which is compatible with the environment. When the product becomes completely unserviceable and requires disposal, drain any fluids (if applicable) into approved containers and dispose of the product and fluids according to local regulations.

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