

ELECTRIC MAGNETIC SHEETMETAL BENDING MACHINE

HAFCO METALMASTER MODEL:MB1250



OPERATING MANUAL

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1. INTRODUCTION

Electromagnetic sheet metal bending machines use an electromagnetic, rather than a mechanical, clamping system. The machine consists of a long electromagnet with a steel clamp bar located above it. The sheet metal is clamped between the two by an electromagnet capable of clamping with a force range of between 3-10 tons. Rotating the bending beam then forms the bend. The sheet is bent around the front edge of the clamp-bar.

Using the machine is simple, slide the sheet in under the clamp-bar; press the start-button to initiate clamping; lift the handle to form the bend to the desired angle; and then return the handle to automatically release the clamping force. The folded sheet can now be removed or repositioned ready for another bend.

The special centre less compound hinges, are distributed along the length of the bending beam allowing bending loads close to where they are generated.

The combined effect of the magnetic clamping with the special center less hinges means that the electromagnetic sheet metal bending machine is a very compact, space saving, machine with a very high strength-to-weight ratio.

1.1 ELECTROMAGNETIC SHEET METAL BENDING MACHINE

HAFCO METALMASTER MB1250

The electromagnetic sheet metal bending machine MB1250 is highly versatile sheet metal folding machines used to bend mild steel and aluminum sheet metal.

Thickness of up to 1.6 mm thick can be folded across the full length of machine.

The multi-purpose machine bends sheet metal of lengths up to 1250mm in length.

The magnetic clamping system replaces the bulky clamping structure used in conventional folding machines. The small compact clamp bar does not hinder or obstruct the work piece. Automatic electromagnetic clamping and unclamping, means faster operation.

These machines have a much greater versatility than conventional sheet metal benders. The machines are ideal for use in the sheet metal industry, air-conditioning and building industries.

The operation of the machine ensures that a safe pre-clamping force is applied before full-clamping can be engaged.

1.2 STANDARD ACCESSORIES

Adjustable backstops,

Storage tray,

Full length clamp bar,

Full length narrow clamp bar,

Full length slotted clamp bar for forming shallow boxes more quickly,

Short 580mm clamp bar,

Complete set of segmented clamp-bars 25, 38, 52, 70, 140, 280mm,

2. ASSEMBLY

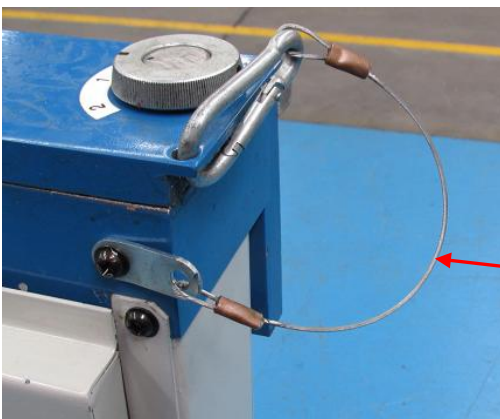
1. Remove all parts from the crate with the exception of the Magnetic body and stand assembly.
2. Remove all 4 sides of crate then bolt on the 2 front feet to stand base as shown (ones with yellow Black warning tape) using M10 x 16mm Button Head cap screws.

3. Fit 2 x Slings as shown and with Correct Suitable Load rated lifting means, Lift Assembly upright and while holding up, carefully assemble the 2 rear legs onto stand.



4. Attach the rear Tray with 3 off M8 x 16mm Socket head Cap Screws, Flat washer and spring washer.

4. Attach the 2 rear length stop bars (one each side of rear Tray) with 4 off M8 x 16mm socket head Cap Screws.



6. Fit clamp bar to top of magnet and ensure Safety Clips are installed in holes provided.

PACEMAKER PROTECTION.

Please note: no person with a pacemaker should be closer than 6 foot or 1.828 metres to an Electromagnetic Field or anything that has an electromagnetic field.

1. Strong electromagnetic fields can cause electromagnetic interference
2. EMI can STOP a pacemaker from sensing your heart's rhythm!



3. OPERATING PROCEDURES

3.1 GENERAL CAUTIONARY IMPORTANT WARNINGS

Electromagnetic sheet metal bending machines are designed for ONE operator only, which includes the inserting of the sheet metal and operating the switches.

See specifications for clamping strength-please note that the force is several tones.

Safety procedures:

1. Place Sheet metal to be bent under clamp and align as needed on bend line.
2. Press and **hold down** Green start button or Foot pedal
(Clamp bar clamps in light clamp mode)
3. While doing this, lift bending beam, clamp bar then Automatically clamps full clamp pressure and foot pedal or button can be released and you can continue to bend to required angle.
4. Lower bending beam to be fully returned to home position,
Full clamp will release automatically
5. While supporting workpiece, press and hold red stop button to demagnetise clamp bar.
6. Remove workpiece or reposition for next bend if required.

Do not insert small items under the clamp bar, a minimum bend of 15 mm is essential except when bending very lightweight soft metal. This will prevent damage to the clamp bar.

To get the best performance do not clamp longer than is necessary due to the magnet having less clamping force when heated.

3.2 HOW TO USE THE BACKSTOPS

Make use of the backstops when handling volume bends that are all the same size. Set the backstops at the size required.

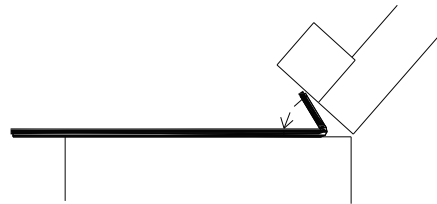
Backstops can be used with a bar (not supplied) laid against them, making a long surface to use as a reference. The extension piece from the bending beam could be used.

Use a strip of sheet metal of the same thickness as the work piece if a backstop is required under the clamp bar.

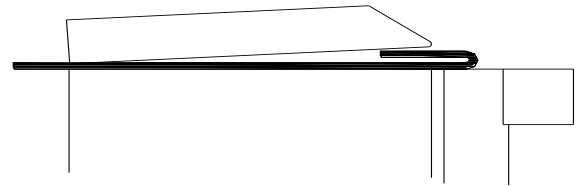
3.3 HOW TO FOLD A LIP

Folding the lip will depend on the sheet metal thickness and the length and width
Lightweight sheet metal up to 0.8 mm.

1. Carry out instruction for standard bending and continue to bend as far as possible.
2. Take away the clamp bar, leave the sheet metal on the machine and move 10 mm backwards, bring over the bending beam and compress the lip.
No clamping is required.
Thick sheet metal is not suitable for this application.



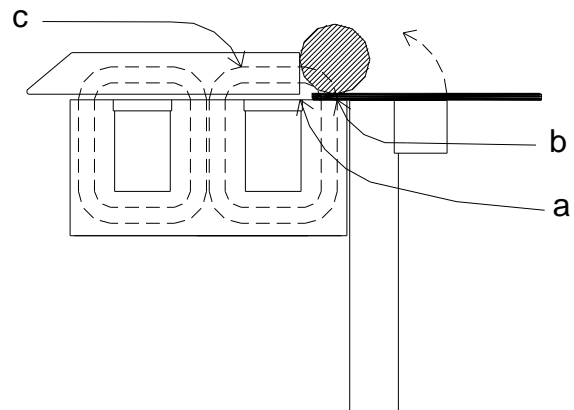
3. Further flattening can be accomplished when using thin lightweight material by following up with magnetic clamping.



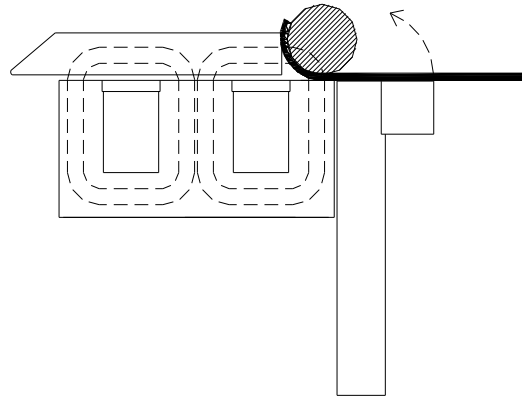
3.4 HOW TO MAKE A ROLLED EDGE

Wrap sheet around a round steel bar or pipe.

1. Position sheet metal clamp bar and round pipe / bar as indicated on drawing.
 - (1) To avoid weak clamping make sure that the clamp bar does not overlap the machines front pole (A).
 - (2) Ensure that the rolling pipe is resting on the front pole of the machine (B).
it must not sit on the aluminum surface of the machine.
 - (3) The clamp bar provides a magnetic pathway (C) for the rolling bar.

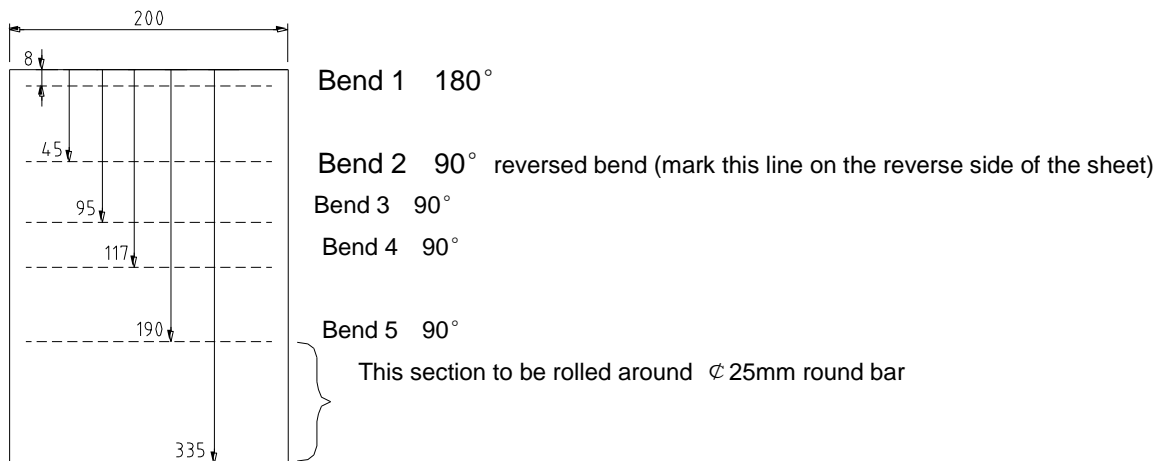


2. Wrap the sheet metal around the rolling bar as far as possible
3. Repeat step 2 until rolled edge is formed to required diameter.



3.5 HOW TO FORM A TEST PIECE

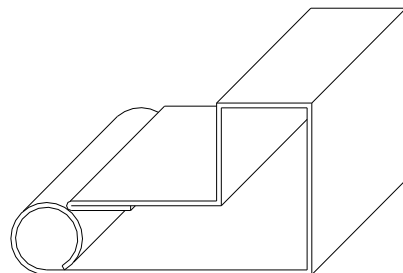
To learn how to work the machine with confidence it is recommended that test pieces are made. Use a piece of 0.8 mm thick x 320 x 200 mm aluminum or mild steel sheet. Mark sheet as per drawing.



From a lip on the edge of the sheet metal (see: How to form a lip)
 Turn sheet metal over and insert under the clamp bar with the folded lip end toward you.
 Tilt clamp bar and line up bend marked 2.
 bend to 90 degrees as shown in drawing



Turn sheet metal over and continue with steps marked 3, 4 and 5 bent to 90 degrees.
 Roll the remaining piece around a 25 mm diameter round bar
 (see How to make a rolled edge) see drawing for completed job.

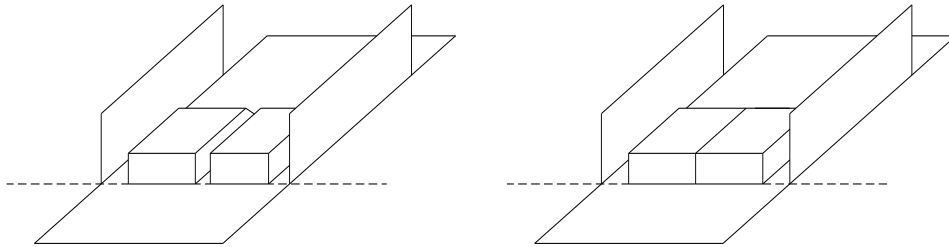


3.6 HOW TO MAKE A BOX USING SHORT CLAMP BARS

For ease of folding, make use of the short clamp bars to the shape folds into each other. Electromagnetic sheet metal bending machines are designed to assist you in the manufacture of a vast variety of box shapes.

3.6.1 BASIC BOXES

Use the long bar clamp to make the first two bends. Choose and insert one or two of the short clamp bars as indicated on drawing.



Select the largest clamp piece for bends up to 70 mm and for longer lengths use several clamp pieces to fit the required length.

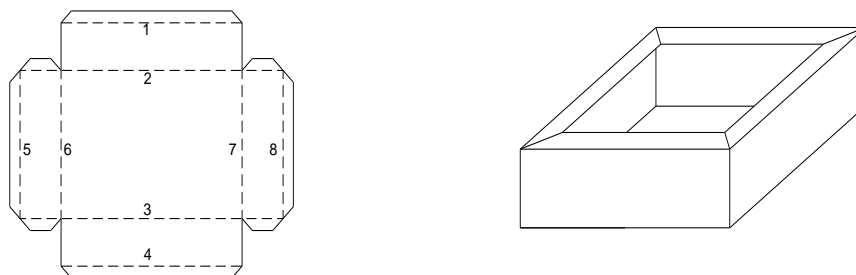
Clamp pieces can be plugged together for repeat bending when making a single unit. A slotted clamp bar must be used for boxes or trays with shallow sides.

3.6.2 LIPPED BOXES

1. Use the set of standard short clamp bars to make rectangular lipped Boxes,, i.e. 98 mm.

2. Choose the short clamp bar with at least a lip-width shorter than that of the box (Two or three may be necessary-depending on length).

Make folds 5, 6, 7 and 8. take care to guide the corner tabs on inside or outside of the box.



3.6.3 BOXES WITH INDIVIDUAL ENDS

Advantages:

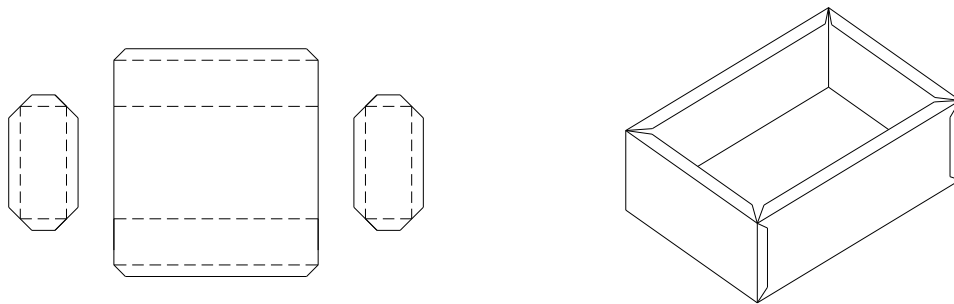
- Material saving
- No corner notching
- Cut without a guillotine
- Fold with the regular full length clamp bar.

Disadvantages:

- Extra folds to be carried out
- Extra corners to join
- The finished product shows more joins

Use the full length clamp bar for all folding.

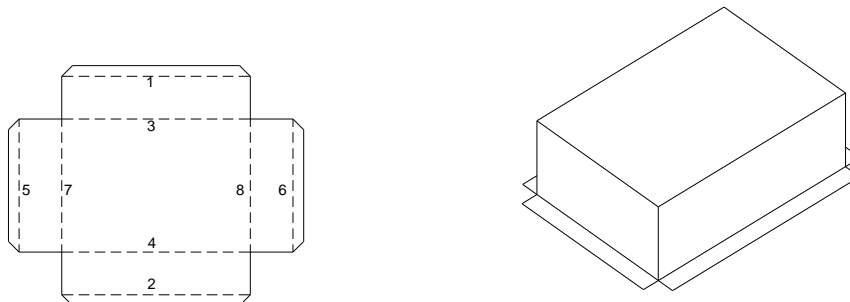
1. Set up sheet metal as per drawing below.
2. Form four folds in the sheet metal as shown on drawing.
3. For folds on side panels, as per drawing, use the narrow flange of the end piece of the clamp bar.
4. join the box.



3.6.4 FLANGED BOXES WITH PLAIN CORNERS

To make plain cornered boxes, the length and width should not exceed the clamp bar width of 98 mm. outside flanges are used when making top hat sections

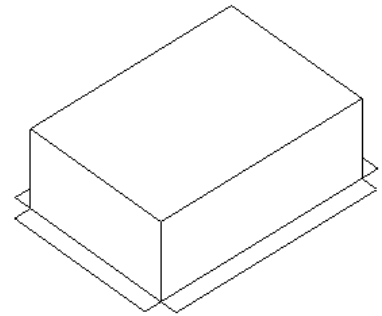
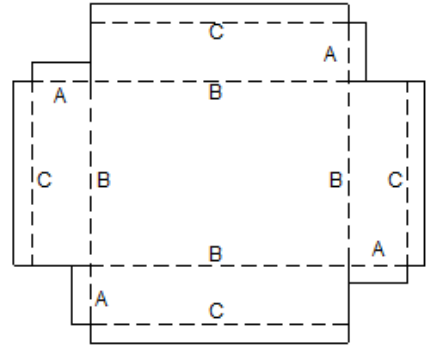
1. Mark up sheet metal as per drawing below.
2. Use the full length clamp bar and fold sections marked 1, 2, 3 & 4.
3. Form fold 5 by inserting the flange under clamp bar follow by folding 6.
4. Using slotted clamp bar form folds 3, 4, 7 and 8.



3.6.5 FLANGED BOX WITH CORNER TABS

Important Note: Folds must be formed in the correct sequence using one piece of sheet metal. It is suggested the deep boxes are manufactured with separate end piece.

1. Mark up sheet metal as be drawing .
2. Form all tab folds to 90 degree, marked A at the one end of the full length clamp bar by inserting the tab under the clamp bar.
3. Use the same end of the clamp bar and fold B to 45 degree. Insert the side of the box instead of the bottom under the clamp bar.
4. Form the flange fold C to 90 degree, at the other end of the clamp bar.
5. Complete folds B to 90 degree. By using suitable short clamp bars.
6. Complete the box by joining the corners.



3.7 HOW TO USE A SLOTTED CLAMP

BAR FORMING TRAYS

The slotted clamp bar is perfect for manufacturing shallow trays and pans.

Advantages:

The bending edges are aligned automatically to the front edge of the magnet body.

The clamp bar automatically lifts to facilitate insertion and removal of the sheet metal whereas with the short each section must be lifted individually.

The slotted clamp bar folds shallow trays, however trays of unlimited depth and complex shapes can be manufactured with a short clamp bar.

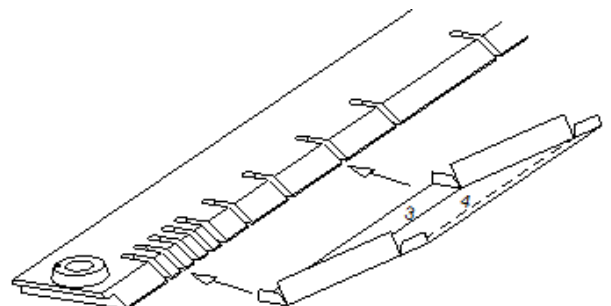
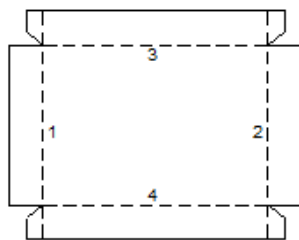
The pitch of the slots has been calculated to enable the folding of various sizes of trays.

Specification sheet indicate shortest and longest tray size that can be accommodated by the slotted clamp bar.

To fold shallow tray

1. First fold two opposite sides and the corner tabs by using the slotted clamp bar-ignore the slots they will have no effect on the finished folds.
2. Select two slots to fold the remaining two sides. Line up the left side of the tray with the left slot and check if there is a slot for the right side. Slide the tray along the left and try the next slot until a suitable slot is found. The edge of the tray should be under the clamp bar and between the two chosen slots.
3. To complete, fold the remaining sides.

Note: Trays that are almost as long as the clamp bar may need to use the end of the clamp bar in lieu of a slot.



3.8 HOW TO CHECK THE ACCURACY OF YOUR MACHINE

Critical aspects of the machine are that working surfaces of the bending beam, the bending edge clamp bar are straight and that both of these surfaces are parallel. This can be checked with a precision straight edge.

3.8.1 How to check using the machine

Swing bending beam up to 90 degree, and hold or lock it in position with a back stop clamp collar at the back of the angle slide on the handle. Check the gap between the working surface of the bending beam and the edge of the clamp bar.

Set the gap at 1 mm on each side by using the clamp bar adjusters.

A feeler gauge or scrap piece of metal can be used.

The gap must be the same along the edge of the clamp bar. Variations can be within +/-0.2 mm, the gap must not exceed 1.2 mm and be less than 0.8 mm. should the adjusters not be the same at each end, they will have to be reset.

See maintenance page 14.

Notes

The straightness of the elevated clamp bar is not important as this is flattened out in magnetic clamping when in use.

The gap between the magnet body and bending beam is about 2 to 3 mm. this does not affect the bending accuracy.

This machine produces folds on thinner gauges and non-ferrous metals such as aluminum, however, check the specification for heavier gauges. To fill in unused portion under the clamp bar, make use of scrap pieces of sheet metal to create uniformity of the bends in thicker gauges.

4. MAINTENANCE

4.1 ADJUSTERS

The adjuster screws at the end of the clamp bar control the thickness of the sheet metal between the bending beam and its edge.

The heads for the screws are divided into 3 by centre pop marks. Use these marks as a reference for repeat setting of the clamp bar. The bending gap will be approx 1 mm, if adjuster screws are both set so that the single pop mark is uppermost.

4.2 HINGE LUBRICATION

Grease all hinges once per month.

4.3 WORKING SURFACES

Bare working surface may become rusty or tarnished. Recondition by filling off and clean up surfaces with emery paper. Use an anti-rust spray.

5. TROUBLE SHOOTING

Prior to ordering a replacement electrical unit from the manufacturer please check the following:

- ◆ If the machine does not operate at all, check the pilot light in the ON/OFF switch.
- ◆ If the machine is hot and power is available, leave the machine to cool and try again.
- ◆ Do not pull the handle prior to starting – the start button or foot switch must be pressed first.
- ◆ If the bending beam is moved prior pressing the start button begin again and make sure the handle is pushed fully back.
- ◆ To check if the Green start button is faulty, try to start the machine with the foot switch.
- ◆ Check the connector and magnet at the electrical module.

This must only be done by a licensed electrician.

5.1 FULL CLAMPING NOT OPERATING

If you are not achieving a full clamp, the angle micro switch may not be fully actuated. How to check that the angle micro switch is being fully actuated.

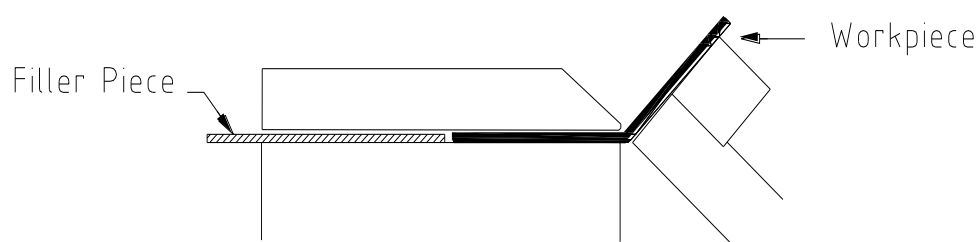
- ◆ The micro switch can be found on the electrical panel
- ◆ To access the electrical panel, the rear cover must be removed.
This must only be done by a licensed electrician.
- ◆ When the bending beam is lifted , you should be able to hear the micro switch click on and off.
- ◆ If the micro switch does not click on and off , then the switch may be fused and would need to be replaced. Call or email your distributor.

5.2 CLAMP BAR NOT BEING RELEASED

This is caused by the failure of the reverse pulse de-magnetizing circuit. Check for sticky contacts on the relay and clean.
This must only be done by a licensed electrician.

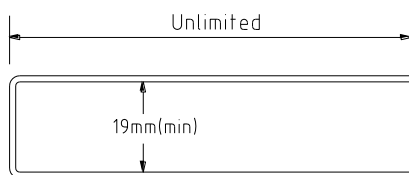
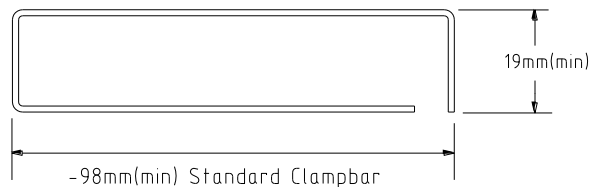
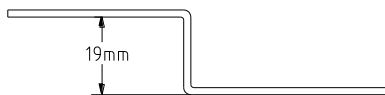
Problem with the bending of heavy gauge sheet metal

- ◆ Ensure that sheet metal thickness is within the specifications of the machine.
- ◆ It may occur if narrow lips are being bent over the full length of the machine, please note that the machine is not equipped to do this.
- ◆ Should the work piece not be level (i.e. have a welded seam or a joint) it may not be possible to bend the work piece. Ensure that all spaces under the clamp bar are filled with flat pieces of scrap metal.

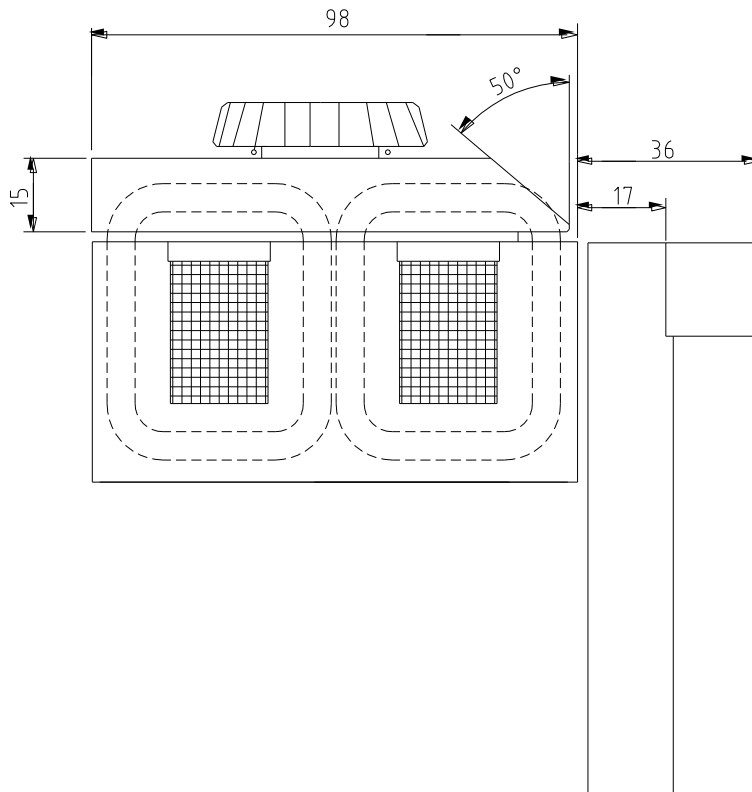
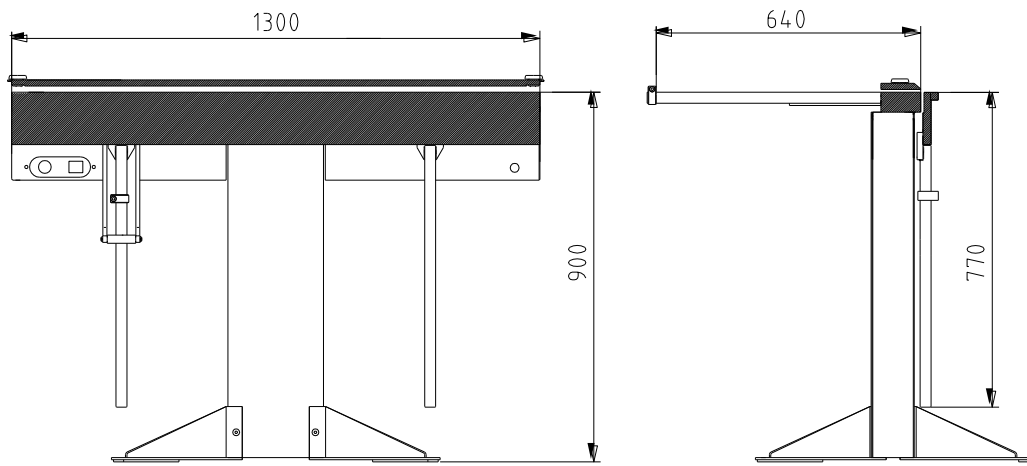


6. SPECIFICATION SHEET

Model	MB1250
Weight of machine (kg)	150
Nominal capacity (length x thickness) (mm)	1250x1.6
Clamping force (tons)	6
Electricity supply	1 phase, 220/240 vac, 10A
Duty cycle (%)	30
Protection (°C)	Thermal cut-out 70°C
Foot switch	Standard
Bending-edge length (mm)	1300
Distance between lifters (mm)	1260
U-channel bends, minimum spacing (mm)	16***
Closed channel, minimum internal (mm)	99x27***
Z-reverse bends, minimum spacing (mm)	36**/18*
Thickness capacities, full length (material thickness can increase depending on the length of bend)	
...Mild steel (mm)	1.6**/1.2*
...Aluminum (medium-hard) (mm)	1.6**/1.2*
...Copper, Zinc, Brass (medium-hard) (mm)	1.6**/1.2*
...Stainless steel (mm)	1.0**/0.9*
***with standard full length clamp bar	**with bending beam extension bar removed



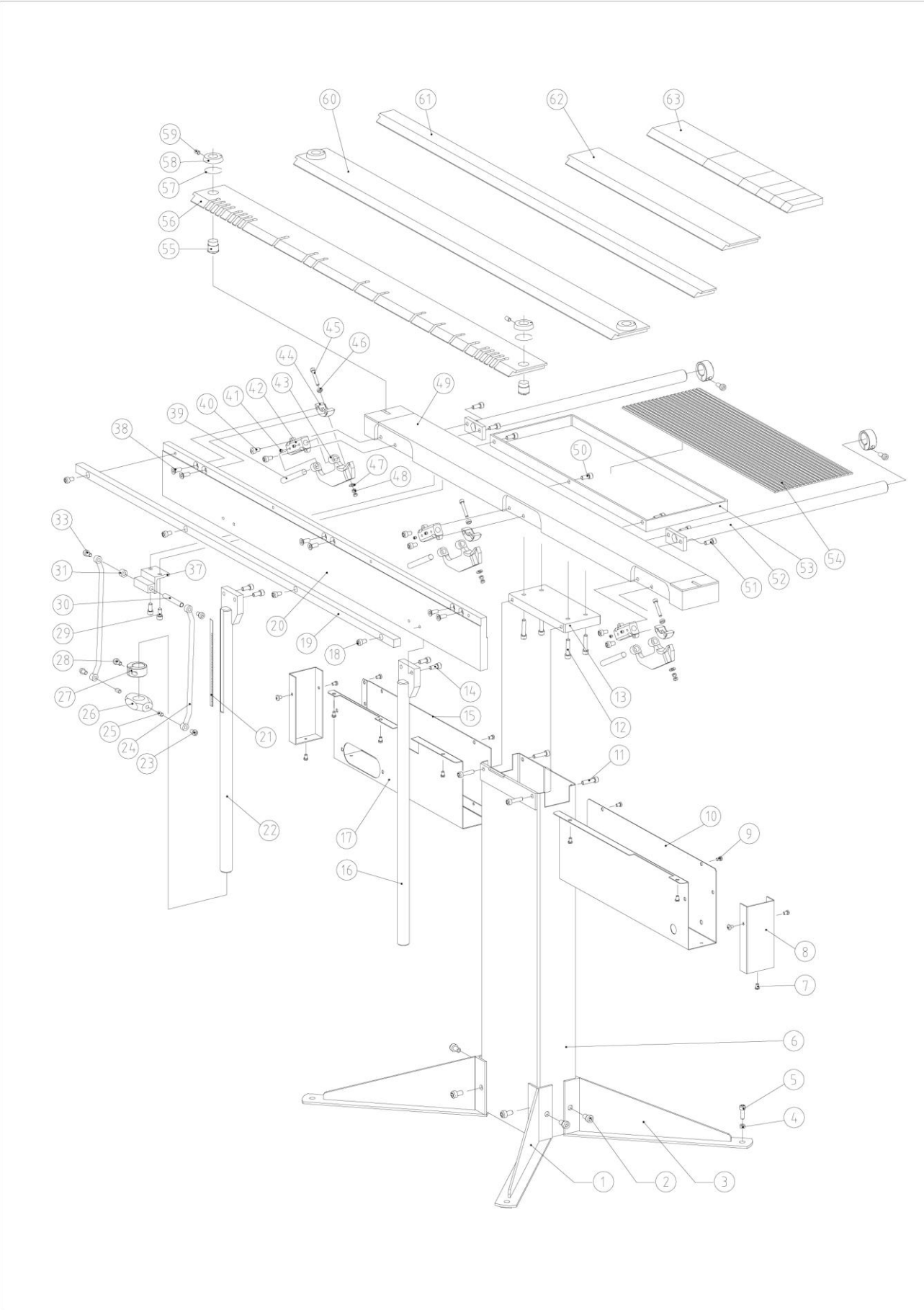
7. DIMENSIONAL SPECIFICATIONS



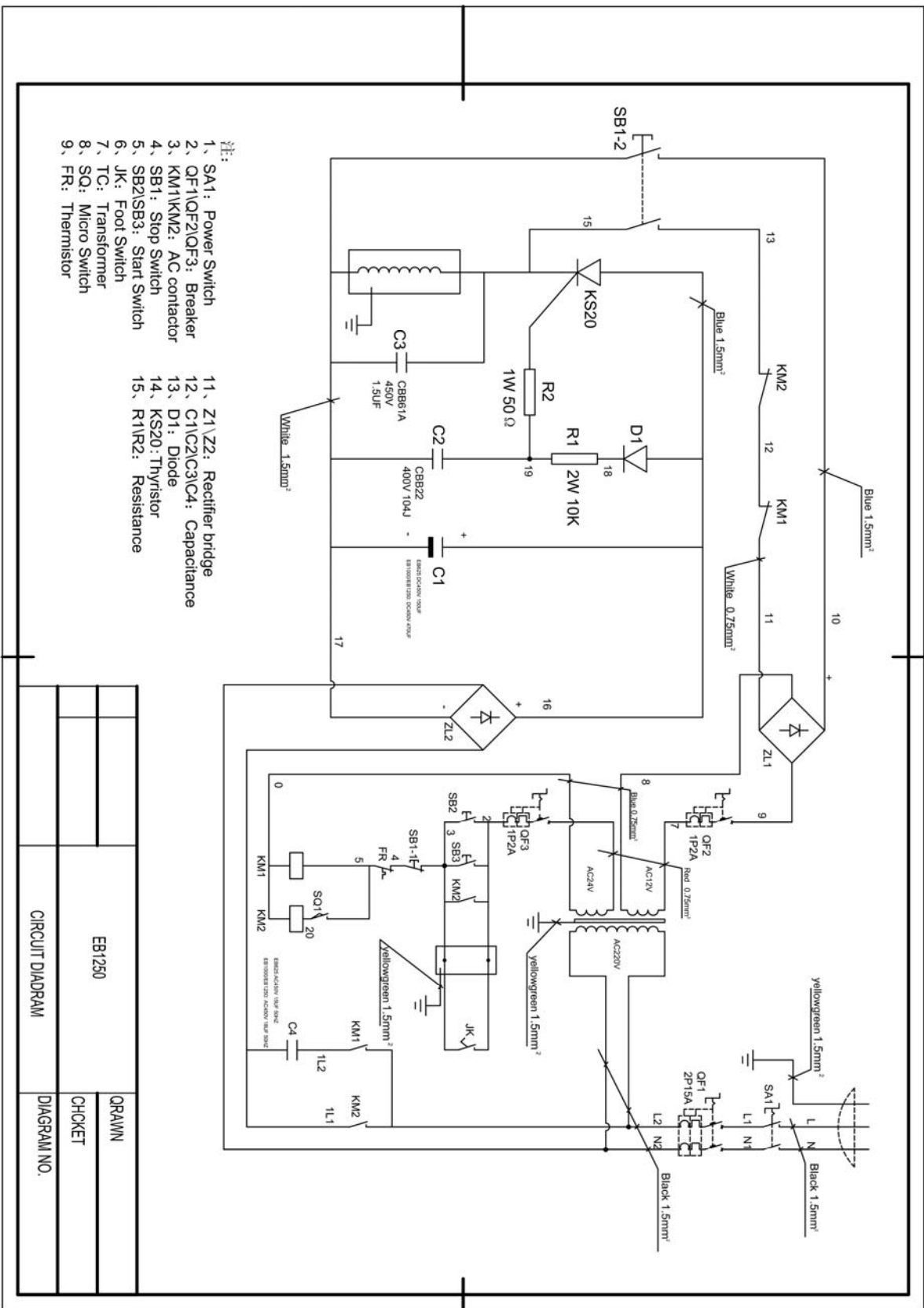
8. 2 PART LIST FOR MB1250

Item	Fin.No	Description	Qty	Item	Fin.No	Description	Qty
1	EB1250-011	Front feet	2	31	GB/T6170	Nut M6	1
2	GB/T70.2	Screw M10×20	8	33	GB/T70.1	Screw M8X20	2
3	EB1250-012	Back feet	2	37	EB1250-027	Angle iron	1
4	GB/T6170	Nut M8	2	38	GB/T70.3	Screw M8X20	6
5	GB/T70.1	Screw M8X25	2	39	GB/T119.2	Straight pin 12X100	3
6	EB1250-013	Stand	1	40	GB/T70.1	Screw M8X20	6
7	GB/T818	Screw M6X12	6	41	GB/T77	Screw M5X4	6
8	EB1250-037	Plate	2	42	EB1250-021	Fixed set	3
9	GB/T818	Screw M6X12	4	43	EB1250-022	Hinge body	3
10	EB1250-016	Right Shield	1	44	EB1250-023	Tee	3
11	GB/T70.1	Screw M8X20	4	45	EB1250-025	Bolt	3
12	GB/T70.1	Screw M8X30	4	46	EB1250-024	Ball seat	3
13	EB1250-015	Connect plate	1	47	GB/T1972	Disc spring 6.2X12.5	1
14	GB/T70.1	Screw M8X16	4	48	GB/T6170	Nut M6	2
15	EB1250-030	Cover	1	49	EB1250-009	Workbench	1
16	EB1250-014	Right clamp handle	1	50	GB/T70.1	Screw M8X16	3
17	EB1250-031	Left Shield	1	51	GB/T70.1	Screw M8X16	4
18	GB/T70.1	Screw M8X20	4	52	EB1250-026	Back stop bar	2
19	EB1250-010	Spoke	1	53	EB1250-007	Tray	1
20	EB1250-006	Bending plate	1	54	EB1250-008	Rubber mat	1
21	EB1250-035	Graduated scale	1	55	EB1250-018	Fix shaft	4
22	EB1250-017	Left clamp handle	1	56	EB1250-001	Clamp bar I	1
23	GB/T70.2	Screw M8X20	2	57	EB1250-020	Spring	4
24	EB1250-032	Connect plate	2	58	EB1250-019	Indicator dial	4
25	GB/T77	Screw M8X6	2	59	GB/T77	Screw M6X8	4
26	EB1250-036	Slider	1	60	EB1250-002	Clamp bar II	1
27	EB1250-034	Stop Block	3	61	EB1250-003	Clamp bar III	1
28	GB/T70.1	Screw M8X20	3	62	EB1250-004	Clamp bar IV	1
29	GB/T70.1	Screw M8X20	2	63	EB1250-005	Clamp bar V	1
30	EB1250-033	Shaft	1				

THE EXPLODED DRAWING FOR MB1250



9. ELECTRICAL WITING FOR MB1250



Note: This manual is only for your reference. Owing to the continuous improvement of the machine, changes may be made at any time without obligation on notice.

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

Magnetic Panbrake Safety Instructions

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

- 1. Maintenance.** Make sure the Panbrake is turned off and disconnect from the main power supply.
- 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. Authorized and trained personnel.** The machine must be operated by authorized and trained personnel. The machine is designed to be operated by a single user. Using the machine with more than one operator is forbidden, except for certain maintenance situations.
- 7. Power outage.** In the event of a power failure during use of the machine, turn off all switches to avoid possible sudden start up once power is restored.
- 8. 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. Do not access the rear of machine, while the machine is working.
- 9. Guards.** Operate machine only with all protective devices and guarding.
- 10. Overloading Panbrake.** Do not exceed the rated capacity of the machine. Refer to the manual for correct capacities.
- 11. Warning Labels.** Take note of any warning labels on the machine and do not remove them.
- 12. Support arms.** Do not use support arms for intermediate storage of workpieces.
- 13. Operation.** During the bending process, the workpiece may leap up. Therefore, the material must be handled carefully.
- 14. Emergency stop.** Use the emergency stop button in case of any emergency.
- 15. Level machine.** Level the machine on a flat concrete surface by using a spirit level.
- 16. Secure Panbrake.** Make sure you bolt and the machine down so it is secure when in operation.
- 17. Floor load for Installation.** The permissible floor load, where the machine is to be installed, must be accounted for.
- 18. Hearing protection and hazards.** Always wear hearing protection as noise generated from machine and workpiece can cause permanent hearing loss over time.
- 19. Heating Material.** Heating metal with a torch while the metal is in the bending brake will weaken the fingers.
- 20. Pinching.** Prevent pinching by lowering the clamp beam when not in use.
- 21. Call for help.** If at any time you experience difficulties, stop the machine and call your nearest branch service department for help.
- 22. Pacemaker Protection.** Please note: no person with a pacemaker should be closer than 6 feet or 1.828 metres to an Electromagnetic machine or anything that has an electrical field.
 1. Strong electromagnetic fields can cause electromagnetic interference.
 2. EMI can stop the pacemaker from sensing your heart's rhythm.



PLANT SAFETY PROGRAM

NEW MACHINERY HAZARD IDENTIFICATION, ASSESSMENT & CONTROL

Magnetic 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	MEDIUM	Secure & support work material. Keep hands clear of folder blades when clamping.
C	CUTTING, STABBING, PUNCTURING	MEDIUM	Wear gloves to prevent cuts from sharp material offcuts. Care must be taken when handling folder blades.
F	STRIKING	MEDIUM	Ensure guards are secured properly. Wear safety glasses. Ensure clamp beam is correctly adjusted. Keep clear of bending material.
H	ELECTRICAL	MEDIUM	Machine should be installed & checked by a Licensed Electrician. All electrical enclosures should only be opened with a tool that is not to be kept with the machine.
O	OTHER HAZARDS, NOISE.	LOW HIGH	Wear hearing protection as required. Pacemaker Protection. Please note: no person with a pacemaker should be closer than 6 foot or 1,828 metres to an Electromagnetic machine or anything that has an electrical field. 1. Strong electromagnetic fields can cause electromagnetic interference. 2. EMI can stop the pacemaker from sensing your heart's rhythm.
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