

METALMASTER

BEAD ROLLER OPERATION MANUAL



Model.
SJ-24D
Product Code S641

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OPERATION MANUAL

MACHINE DETAILS

MACHINE	BEAD ROLLER
MODEL NO.	SJ-24D
SERIAL NO.	
DATE OF MANF.	

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Note:

This manual is only for your reference. Owing to the continuous improvement of the Metalmaster machines, 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)

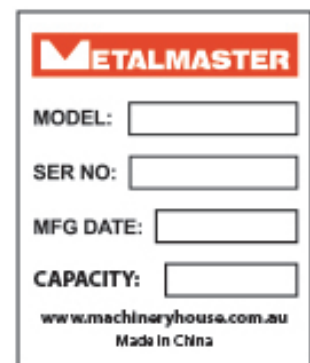


Fig.1



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1.1 SPECIFICATIONS

Product Code		S641
Model		SJ-24D
Capacity (mm/gauge)	Bead and Flange	1.2/18
	Shear	1.0/20
Throat (mm)		460
Bead Mandrels Sizes (mm//in)		6.35//1/4,9//3/8,12.7//1/2
Flange Mandrels Sizes (mm//in)		1.6//1/16,3//1/8,6.35//1/4
Shearing Mandrel Quantity		1 Set

1.2 PACKING CONTENTS



- (A) Bead Roller Frame
- (B) Crank Handle *(Maybe mounted on the machine)*
- (C) Roller Tensioning Lever
- (D) 6 Sets of rolls (Ø22mm Bore)
1/4"- (6.35mm), 3/8" (9mm), 1/2"(12.7) Single bead rolls
1/16" (1.6mm), 1/8" (3mm), 1/4" (6.35mm) Stepped rolls
- (E) One set Cutting Dies *(Maybe mounted on the machine)*
- (F) Stand (Not displayed)



OPERATION MANUAL

2.1 SAFETY REQUIREMENTS

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.



Safety glasses must be worn at all times in work areas. Earmuffs should be worn if the work area is noisy.



Sturdy footwear must be worn at all times in work areas.



Gloves should NOT be worn when using this machine



Long and loose hair must be contained with a net or under a hat

OWNER'S MANUAL. Read and understand this owner's manual before using the machine.

DISCONNECT POWER FIRST. If using power, always disconnect the machine from power supply before making adjustments, or servicing the machine. This prevents any risk of injury from unintended startup or contact with live electrical equipment

TRAINED OPERATORS ONLY. Operators that have not been trained have a higher risk of being seriously injured. Only allow trained or supervised people to use this machine. When the machine is not being used, disconnect the power, to the machine to prevent unauthorized use—especially around children. Make the workshop safe.



OPERATION MANUAL

2.1 SAFETY REQUIREMENTS Cont.

WEARING PROPER APPAREL. Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to avoid accidental slips, which could cause loss of operating control.

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

REMOVE ADJUSTING TOOLS. Tools left on machinery can become dangerous projectiles upon startup. Never leave hex keys, wrenches, or any other tools on machine. Always verify removal before starting!

USE CORRECT TOOL FOR THE JOB. Only use this tool for its intended purpose. Do not force the machine or its attachments to do a job for which they were not designed. Never make unapproved modifications. Modifying the machine or using it differently than intended may result in malfunction or mechanical failure that can lead to personal injury or death!

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make operating control difficult. This could increase the risk of accidental injury

GUARDS & COVERS. Guards and covers reduce accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly.

FORCING MACHINERY. Do not force the machine. It will do the job safer and better at the rate for which it was designed.

NEVER STAND ON MACHINE. Serious injury may occur if the machine is tipped or if the cutting tool is unintentionally contacted

STABLE MACHINE. Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify machine is stable and if using a mobile base it is locked in position.

UNATTENDED OPERATION. To reduce the risk of accidental injury, turn the machine OFF and ensure all moving parts have completely stopped before walking away. Never leave the machine running while unattended.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep the machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

CHECK DAMAGED PARTS. Regularly inspect the machine for any condition that may affect the safe operation. Immediately repair or replace damaged or parts that are incorrectly fitted before operating.

CHILDREN & BYSTANDERS. Keep children and bystanders at a safe distance from the work area. Stop using machine if they become a distraction.



OPERATION MANUAL

2.2 ADDITIONAL SAFETY FOR BEAD ROLLING MACHINE

DO NOT use this machine unless you have read and understand the manual and the requirements for the safe operation of this machine.



Safety glasses must be worn when operating this equipment



Long and loose hair must be contained when operating this equipment.



Safety footwear must be worn when operating this equipment



Close fitting/protective clothing must be worn when operating the machine



Dust mask must be worn when operating in high dust areas.



Hearing protection must be used when operating in a noisy environment

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.
- Working parts should be well lubricated and the dies are 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 and ensure the area is clear before using equipment.

OPERATIONAL SAFETY CHECKS

- Adjust the chosen dies slowly and in small adjustments.
- Take care during the initial feeding of the workpiece into the dies.
- Hold the workpiece sufficiently far back from the edge being fed into the dies, to allow for the infeed speed of the machine.
- Wind handle at a slow even rate. Be aware of rotating dies
- Only one person should operate this machine for a safe result.

ENDING OPERATIONS AND CLEANING UP

- Ensure the machine is left in a safe condition after use.
- Leave the work area in a safe, clean and tidy state.

POTENTIAL HAZARDS AND INJURIES

- Sharp edges and burrs.
- Crush and pinch points.
- Hair/clothing getting caught in moving machine parts.
- Operator's hands may be caught and drawn into the rotating dies.

DON'T

- Do not use faulty equipment. Immediately stop and repair suspect machinery.
- Do not attempt to form material beyond the capacity of the machine.



OPERATION MANUAL

3.1 UNPACKING

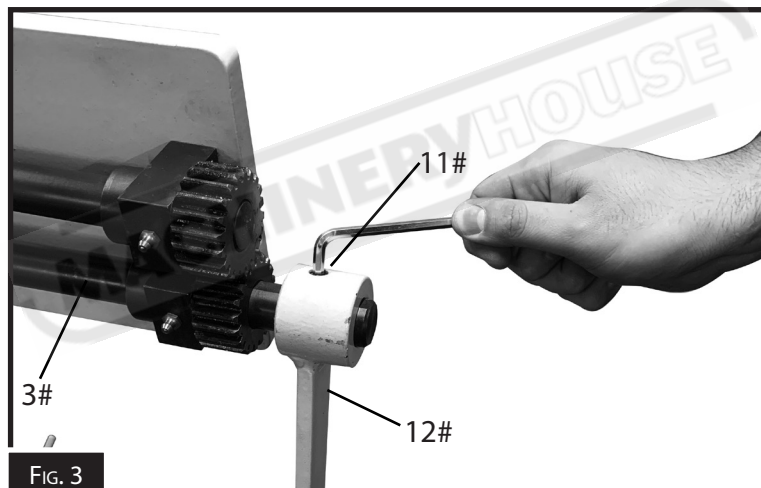
This machine was carefully packaged for safe transport. When unpacking, separate all enclosed items from packaging materials and inspect them for shipping damage. If items are damaged, please contact your distributor.

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 to make sure that all parts shown on page 4 are included. If any parts are missing or broken, please contact the your distributor.

3.2 ASSEMBLY

1. Place the Bead Roller on to the stand.
2. Slide the Handle (12#) onto the Driving Shaft (3#) .
3. Using a Hex Key Wrench , tighten grub screw (11#) securely . Ensure that grub screw (11#) is positioned over the flat surface on the Driving Shaft (3#) .

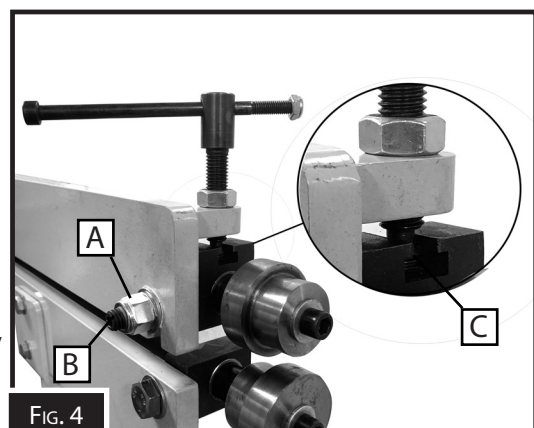


Attaching The Roller Tension Handle

To assemble the handle to the Hafco Bead Roller loosen the nyloc nut, (A in Fig.4) then undo and remove the socket head set screw (B in Fig.4) so that the upper bearing block is free to move down the shaft. Screw the Upper Bearing Block tensioning handle into the casting and slide the upper bearing block back so that the end of the handle fits into the Upper Bearing Block "T" slot. (C in Fig.4)

Screw the set screw (B in Fig.4) into the threaded hole in the Upper Bearing Block and tighten.

While holding the socket head set screw with a hex key, tighten the nyloc nut (A in Fig.4), then back it off half a turn so the Upper Bearing Block can move.



3.3 ALIGNMENT

The Bead Roller usually does not need the operator to adjust the alignment. However, poor alignment will effect the quality of the metal forming and the ability of the machine to cut sheet metal.

If you experience either of these problems perform the following alignment steps.

1. Set up the Bead Roller with cutting dies (10#-1, 10#-2) and cutting plate (9#) as shown in Fig. 5.
2. Inspect the cutting plate (9#) as shown in Fig. 5. When the Bead Roller is aligned correctly, the edges of the cutting plates should almost be touching. If they are not almost touching then the following steps need to be taken.

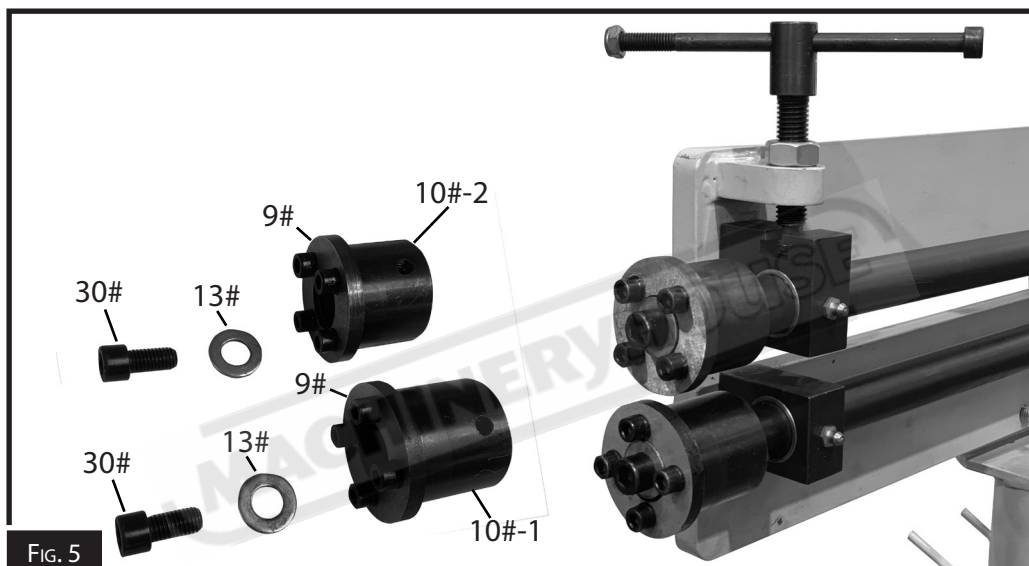


FIG. 5

3. Using the hex key wrench supplied (27#) loosen screws (16#) that secure gear (5#) and collar (6#) to the driving shaft (3#). (Fig. 6)
4. Slide the driving shaft (3#) until the cutting plates (9#) are touching.
5. By hand, move collar (6#) on the driving shaft (3#) so its edge is touching the roll block (2#) and tighten the screws (16#)
6. Move Gear (5#) so its side is touching the Collar(6#) on the Driving Shaft(3#) and tighten its Screws(16#). At all times make sure that the screw is tightened on the flat on the shaft.

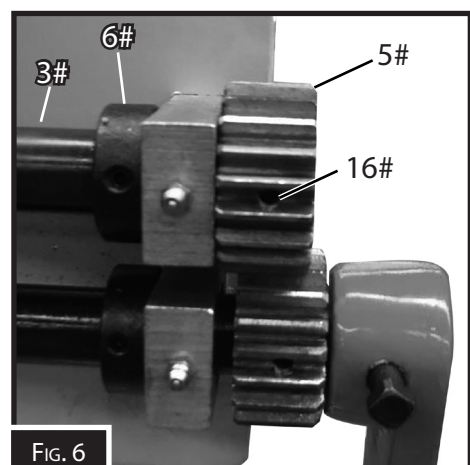


FIG. 6

NOTE: If the edges are touching but the machine does not cut the material correctly, adjust the roller tension. See section "Adjusting The Roller Tension" (Page 11)



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3.4 CHANGING DIES

The Bead Roller comes with a variety of bead and flange dies, as well as the cutting dies & plates. (assembled to the machine before shipping) Use the following instructions when you change dies.

Removing the Cutting Dies and Plates

1. Loosen Handle(39#), See Figure 7.
2. Using a Hex Key Wrench, remove the two socket head cap screws (30#) securing the Cutting Dies (10#-01,10#-02) to the Driving Shaft (3#) and Driven Shaft (4#). Remove the Washers (13#).
3. Using a Hex Key Wrench(27#), loosen the Screws(16#) that lock the Cutting Dies (10#-01,10#-02) onto the shafts. See Figure 7.
4. Remove the Cutting Dies (10#-01,10#-02).

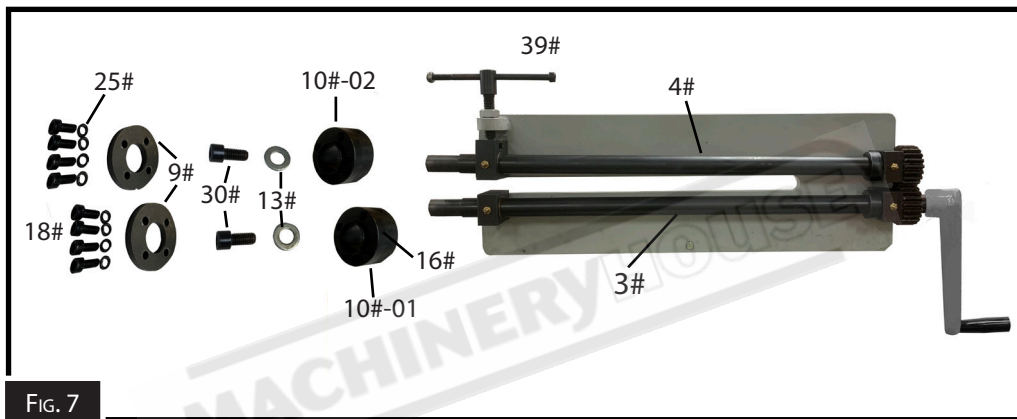


FIG. 7

It may be necessary to sharpen or replace the Cutting Plates (9#) from the Dies (10#-1, 10#-2)

To Remove the Cutting Plates from the Dies

1. Using a hex key wrench, remove the eight Screws(18#) and Spring Washers(25#), securing the Cutting Plates (9#) to the Cutting Dies(10#-01, 10#-02). See Figure 7.
3. Remove the Cutting Plates (9#).

Bead and Stepped Dies





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Installing Bead and Flange Dies

1. Select the correct bead or flange dies for the job you are going to do.
2. Slide both dies onto the Driving Shaft(3#) and Driven Shaft(4#) at the same time (see Figure 8). Ensure that the Screws(16#) are positioned over the flat surface on the Driving Shaft(3#) and Driven Shaft(4#).
3. By hand, install the two Bolts (30#) and Washers(13#).Tighten Bolts (30#) with a Hex Key Wrench.
4. Tighten the two Screws (16#).
5. Check to ensure that the dies are aligned. If not aligned then see "Alignment" on Page 9.

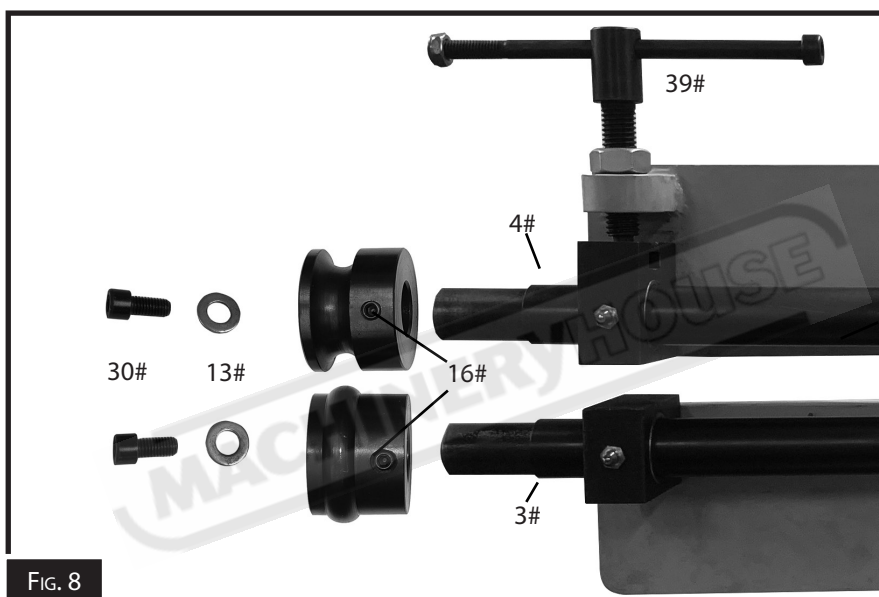


FIG. 8

Adjusting Roller Tension:

1. Adjust the Handle (39#) finger tight.
2. Using the handle, tighten 1 to 3 turns, depending on desired results.

Metalmaster advises to turn the handle slowly as you work. A variety of metals and material gauge will produce a different result with the same dies and will require various degrees of effort.

NOTE: Safety Usage

Wherever possible only one person should operate the Bead Roller. It is dangerous when more than one person uses the machine. If one person is used to crank the handle and another is used to guide the metal along the roller, it can be possible that lack of communication between the two operators may cause accidents to happen. Metal forming is an art and in some cases may require two operators. Good communication between the person cranking and the one guiding the metal particularly on corners, is essential and all care should be taken in these cases.



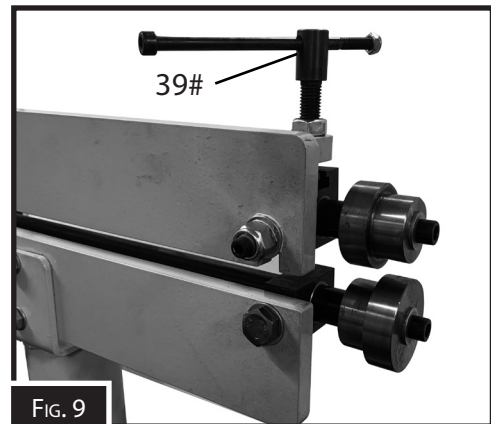
OPERATION MANUAL

4. OPERATION

4.1 GETTING STARTED

- Loosen the Roller Tensioner Lever lock nut (Fig.10)
- Loosen the Roller Tensioner Lever (39#) by turning the lever in a counter-clockwise direction. (Fig 9).

Note: The through hole in the upper frame is slotted. The Upper Roller Shaft and Bearing Block should be free to be raised up sufficiently to separate the Bead Roller Dies enough to slide the workpiece metal between them . If the upper Bearing Block is hard to move see “Adjusting The Top Bearing Block” (Page. 13)



- Center the Upper Die over the previously drawn pattern line then move the Upper Roller Shaft and Bearing Block down in place against the metal work piece.
- Check the alignment with the drawn line, then increase the pressure of the Upper Roller Die by tightening the Roller Tensioner Lever, add additional turns until the bead is formed.
- Tighten the Roller Tensioner Lever Lock nut. (Fig. 10)

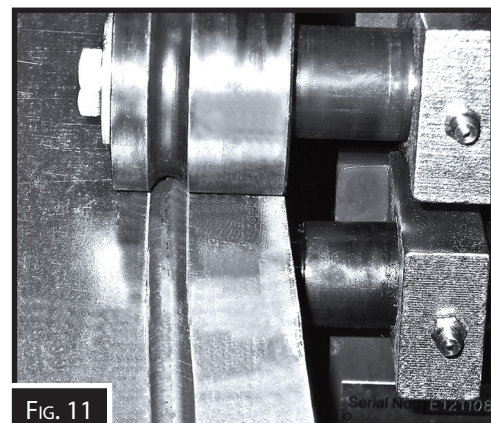
NOTE: Do Not Over tighten as this may tear the metal workpiece, jam the Roller Dies or deform the Frame.



4.2 CREATING STRAIGHT BEADS

NOTE: When forming beads, for greater ease in handling workpiece panels and achieving optimal accuracy, it is strongly advised to turn the handle slowly as you work. A variety of metals and material gauge will produce a different result with the same dies and will require various degrees of effort. Always perform a practice run with a piece of scrap material of the same type and gauge before forming the actual workpiece.

- Crank the handle slowly as you move the metal making sure that the marked guideline is followed.
- Keep the marked guideline aligned with the center of the Upper Die. When you reach the end of the guide line, you may re-roll the bead by turning the crank in the opposite direction.
This produces a more sharply defined bead.
- When done, loosen the Upper Roller Tensioner lock nut and retract the Upper Shaft and Upper Die.
- Pull the workpiece panel from between the dies and check the finished result.



4.3 FORMING CURVES

The success to forming curves with the bead roller is careful coordination between cranking the handle, and moving the metal workpiece slowly through the dies, while turning it through the curve, at the same time.

- It is critical to keep the guideline aligned with the Upper Die as you go (Fig. 12).
- If your design forms an oval, start the bead in the centre of a straight or in the largest radius section
- Do not attempt to start right at a corner or a joint of two lines, as it will be extremely difficult to line up the bead perfectly when completing the form.
- By using combinations of curves and straight lines, there is almost no limit to the designs than can be created with the Hafco Bead Roller.

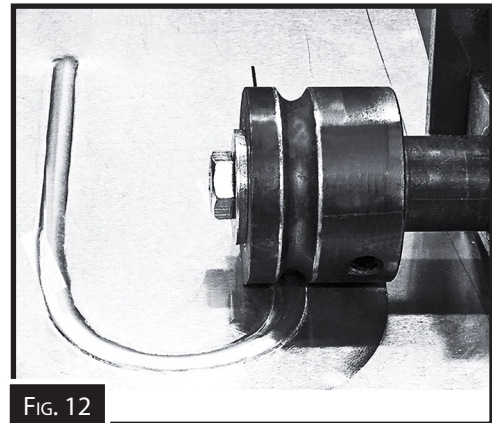


FIG. 12

5. MAINTENANCE

5.1 ADJUSTING THE UPPER BEARING BLOCKS

The accuracy and performance of the Hafco Bead Roller is partly determined by the upper bearing blocks. They need to move but also need to support the upper shaft firmly. Adjustment of the Upper Bearing Blocks is critical to producing a quality result.

To adjust the Front Bearing Block.

1. With an Hex key hold the set screw "A" in Figure 13.
2. Tighten the nyloc nut "B" in Figure 13 until the block is tight then back the nyloc nut off half a turn or until the block moves with the (39#) Tension Adjustment Handle.
3. Re-test to make sure the Front Bearing Block moves but is not loose. If still tight then back off the nyloc nut another half turn.

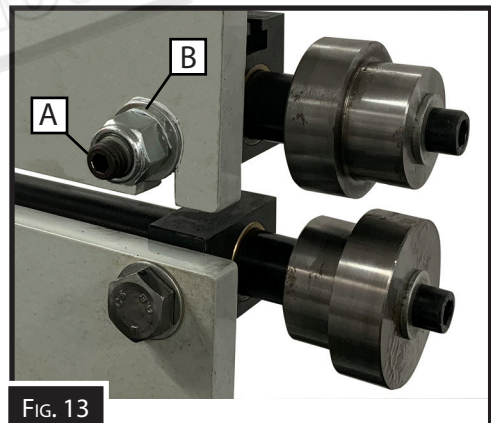


FIG. 13

To adjust the Rear Bearing Block.

1. With an Hex key hold the set screw "C" in Figure 14.
2. Tighten the nyloc nut "D" in Figure 14 until the block is tight then back the nyloc nut off half a turn or until the block moves with the (39#) Tension Adjustment Handle.
3. Re-test to make sure the Rear Bearing Block moves but is not loose. If still tight then back off the nyloc nut another half turn.

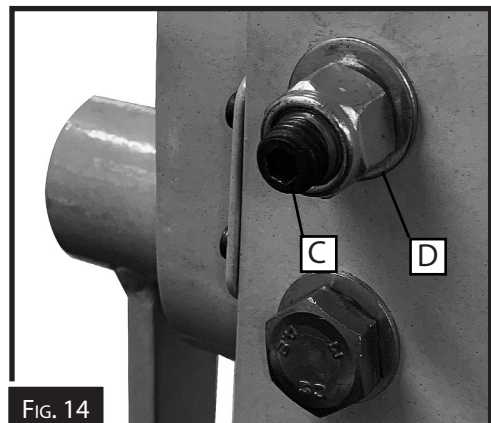


FIG. 14



OPERATION MANUAL

SPARE PARTS SECTION

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

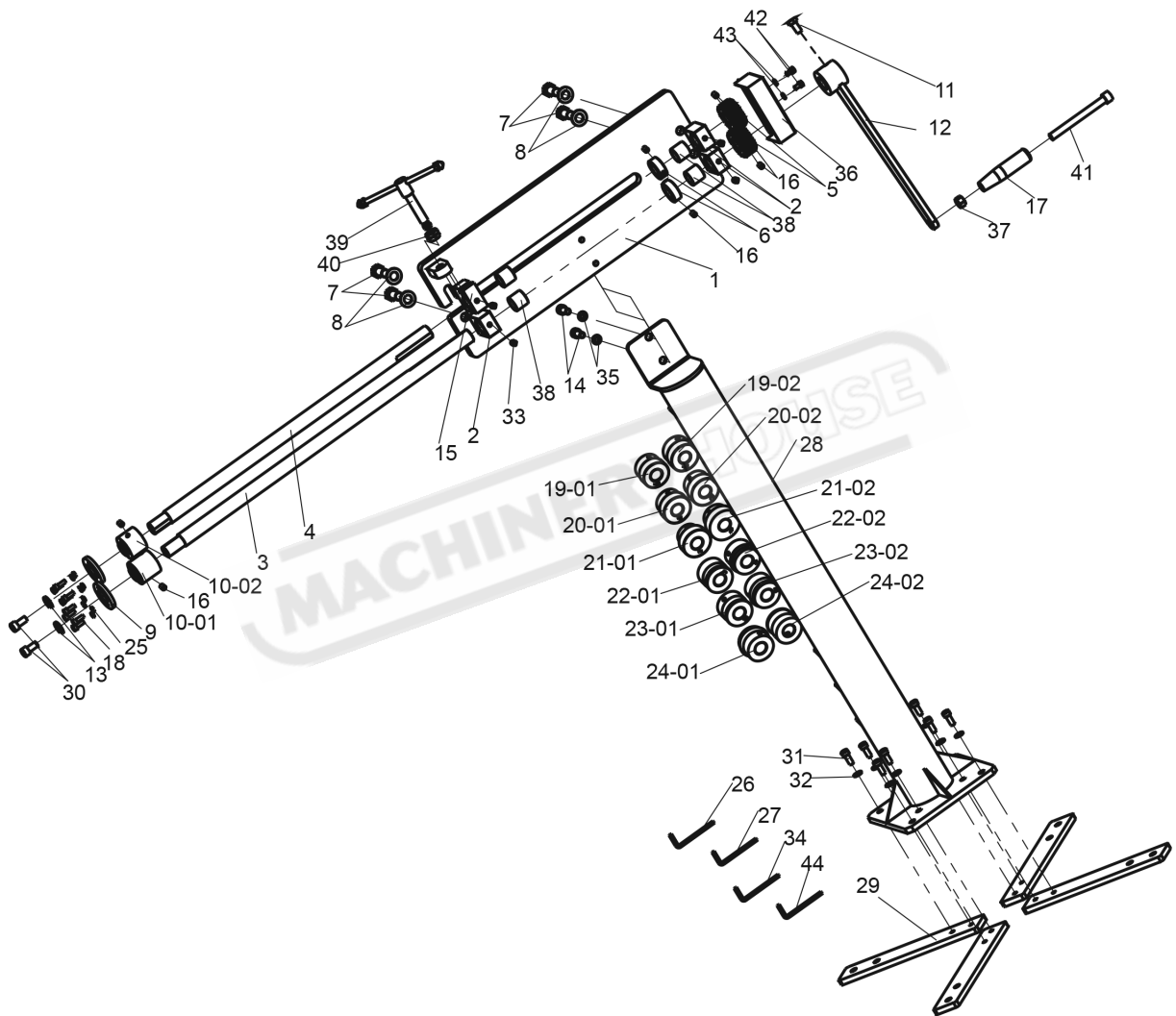
1. Have your machines **model number, serial number & date of manufacture** on hand, these can be found on the specification plate mounted on the machine
2. A scanned copy of your parts list/diagram with required spare part/s identified
3. Go to www.machineryhouse.com.au/contactus and fill out the inquiry form attaching a copy of scanned parts list.





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SPARE PARTS DIAGRAM





OPERATION MANUAL

SPARE PARTS LIST

Part No.	Description	Qty.	Part No.	Description	Qty.
1	Base	1	22-02	6mm Flange Die	1
2	Roll Block	3	23-01	3mm Flange Die	1
3	Driving Shaft	1	23-02	3mm Flange Die	1
4	Driven Shaft	1	24-01	2mm Flange Die	1
5	Gear	2	24-02	2mm Flange Die	1
6	Collar	2	25	Spring Washer 6mm	8
7	Bolt M14x30	4	26	Hex Key Wrench 4mm	1
8	Washer 14mm	4	27	Hex Key Wrench 5mm	1
9	Cutting Plate	2	28	Stand	1
10-01	Long Cutting Die	1	29	Plate	4
10-02	Short Cutting Die	1	30	Screw M10X20	2
11	Bolt M10X20	1	31	Screw M8X20	8
12	Handle	1	32	Washer 8mm	8
13	Washer	2	33	Oil Cup	4
14	Screw M10X20	2	34	Hex Key Wrench 8mm	1
15	Front Roll Block	1	35	Washer 10mm	2
16	Screw M8x10	18	36	Gear Cover	1
17	Handle Cover	1	37	Nut M121	1
18	Screw M6x16	8	38	Bushing 4	4
19-01	12mm Half-Round Die(Convex)	1	39	Adjustment Handle	1
19-02	12mm Half-Round Die(Concave)	1	40	Nut M142	2
20-01	10mm Half-Round Die(Convex)	1	41	Screw M12X110	1
20-02	10mm Half-Round Die(Concave)	1	42	Screw M6x10	2
21-01	6mm Half-Round Die(Convex)	1	43	Washer 6 mm	2
21-02	6mm Half-Round Die(Concave)	1	44	Hex Key Wrench 6 mm	1
22-01	6mm Flange Die	1			

DIE SELECTION

Note: Dies are larger than shown in this illustration

1/4" (6.35)mm Half
Round Die (21#)



3/8" (9mm) Half
Round Die (20#)



1/2" (12.7mm) Half
Round Die (19#)



1/16" (1.6mm) Flange
Die (24#)



1/8" (3mm) Flange
Die (23#)



1/4" (6.35mm) Flange
Die (22#)





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

Swage & Jenny Machine Safety Instructions

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

- 1. Maintenance.** Make sure the Swage & Jenny is turned off and disconnect from the main power supply and make sure all moving parts have come to a complete stop before any inspection, adjustment or maintenance is carried out.
- 2. Swage & Jenny Condition.** A Swage & Jenny must be maintained for a proper working condition. Never operate a Swage & Jenny that has damaged or worn parts. Scheduled routine maintenance should be performed on a scheduled basis.
- 3. Roll Condition.** Never operate a Swage & Jenny with a 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. Roll Direction.** Be aware of the correct rotational axis of the motor when a qualified electrician connects the Machine.
- 5. 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.
- 6. Personal Protection.** Gloves, safety glasses and safety hat are recommended during operation.
- 7. Avoiding Entanglement.** Swage & Jenny guards must be used at all times. Tie up long hair and use the correct hair nets to avoid any entanglement with the Swage & Jenny moving parts.
- 8. Understand the machines controls.** Make sure you understand the use and operation of all controls.
- 9. Trained Operator.** This machine must be operated by authorized and trained personnel.
- 10. 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.
- 11. Work area hazards.** Keep the area around the Swage & Jenny 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.
- 12. Guards.** Do not operate Swage & Jenny without the correct guards in place. Necessary guards protect you from injuries by gearbox, motors and other moving gears & parts. The only other area which needs to be carefully monitored during use is the rotational area of the rolls.
- 13. Material condition.** Material must be clean of oil and dry. Oily material can slip and will not bend.
- 14. 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.
- 15. 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.
- 16. Stopping the Rolls.** Do not stop or slow the rolls with your hand or workpiece. Allow the Swage & Jenny to stop on its own.
- 17. Emergency stop.** Use the emergency stop button in case of any emergency.
- 18. Hearing protection and hazards.** Always wear hearing protection as noise generated from machine and workpiece can cause permanent hearing loss over time.
- 19. 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

Swage & Jenny Machine

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>
A	ENTANGLEMENT CRUSHING	HIGH LOW	Eliminate, avoid loose clothing / Long hair etc. Secure & support work material. Ensure machine is bolted down.
B	CUTTING, STABBING, PUNCTURING.	MEDIUM	Isolate power to machine prior to any checks or maintenance being carried out. Do not adjust or clean until the machine has fully stopped. Wear gloves to prevent cuts from material.
D	SHEARING	MEDIUM	Isolate power to machine when checks or maintenance is being carried out. Make sure all guards are secured shut when machine is on. Hands should be kept clear of moving parts such as rolls etc.
F	STRIKING	MEDIUM	Ensure area is kept clear of material being rolled.
H	ELECTRICAL	MEDIUM	All electrical enclosures should only be opened with a tool that is not to be kept with the machine. Machine should be installed & checked by a Licensed Electrician.
O	OTHER HAZARDS, NOISE.	LOW	Wear hearing protection as required.
Plant Safety Program to be read in conjunction with manufactures instructions			



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Authorised and signed by:
Safety officer: 
Manager: 

Revised Date: 12th March 2012