

# Roller Machine Guarding

# Safe Work Procedure

## Plate Roller Operation

### Scope

This document describes the procedure to be followed while performing bending operations. All factory employees must familiarize themselves with this procedure.

### Shop Personnel & Equipment

- ☑ All Plate Roller Operators
- ☑ Steel-toed work boots
- ☑ Safety glasses
- ☑ Leather Gloves
- ☑ Ear Protection

**ALWAYS KNOW THE LOCATION OF THE NEAREST FIRE EXTINGUISHER, EYE WASH STATION, FIRST AID STATION, AND FIRST AID PERSONNEL.**

## **Procedure**

### Rolling – Pre-operation

1. This machine is design for use by a single operator only.
2. Assure that all guards and cover shields are in place before starting machine. CAUTION: Do not remove guards.
3. Keep hands and body clear of moving parts.
4. Assure all tooling is properly held in position before starting any operation.
5. Assure that the area around the machine is well lit, dry and free of any obstructions.
6. All maintenance and repair work should be performed by a person familiar with Repair Manual (Hydraulic Single Pinch Roll Machine)
7. NEVER place any parts of your body within 1 meter of turning rolls.
8. NEVER load material, adjust pinch roll or service this machine with the motor “ON” and controls in “ON” position.
9. At the end of the working day, the operator should turn the power off to the machine.
10. Turn main disconnect selector switch to the OFF position when changing tooling or performing maintenance work.

## **Operation:**

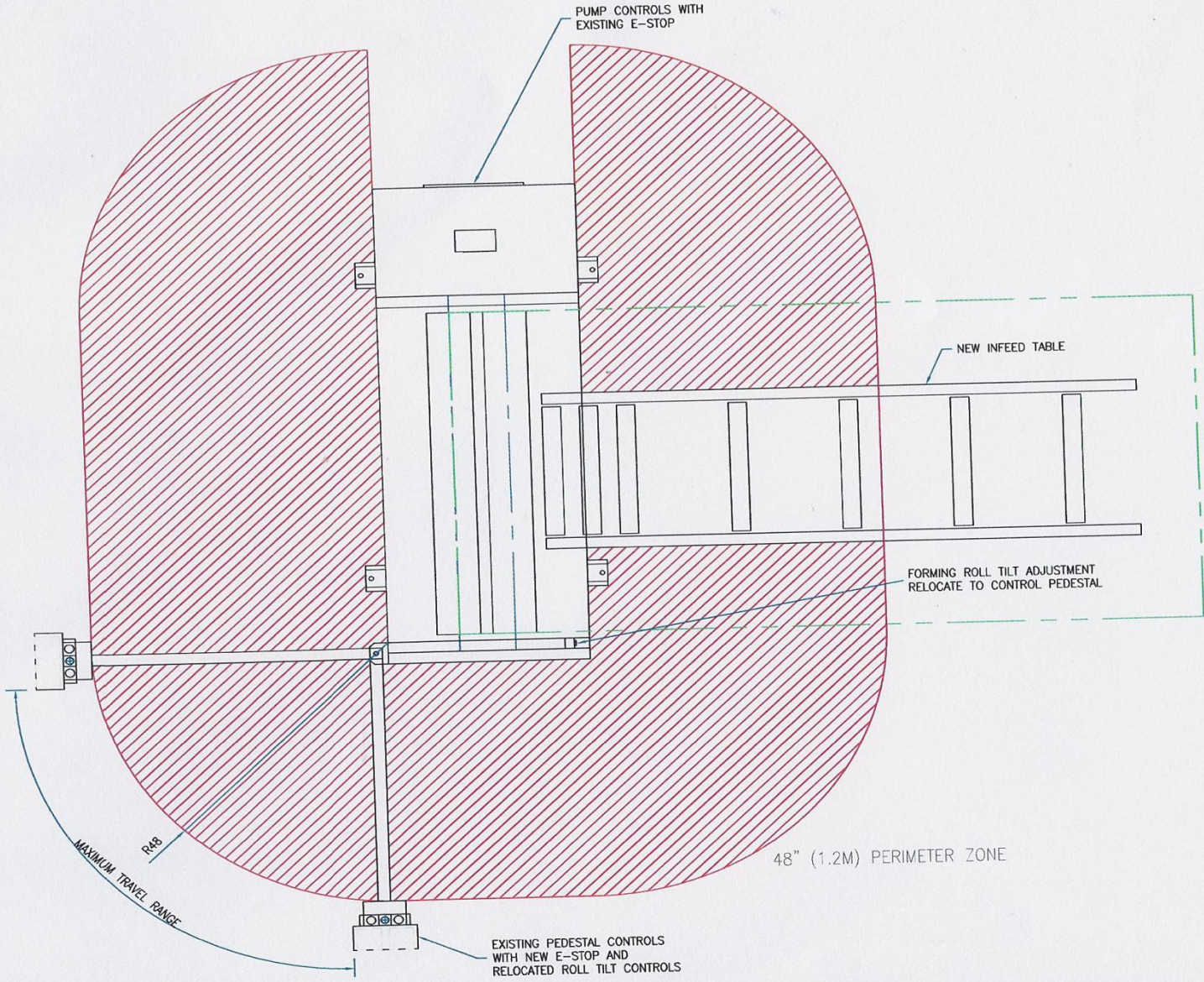
Prior to starting the machine, Load material as follows: (Ensure E-Stop is depressed)

1. Adjust in feed table as required up to machine and secure in place.
2. Lower pinch roll with manual hand wheel.
3. Feed material between drive roll and pinch roll. Ensure material is square with rolls and fed in just past pinch point.
4. Tighten pinch roll with manual hand wheel.
5. Ensure material is adequately supported and adjust in feed table if necessary. OPERATOR CANNOT START MACHINE IF ANY PERSONNEL ARE REQUIRED TO SUPPORT MATERIAL IN ANY WAY.

AT THIS POINT, A MINIMUM SAFE DISTANCE OF 1 METER FROM FINGERTIP TO PINCH POINTS ON ROLLER MUST BE MAINTAINED AT ALL TIMES. LOCATE CONTROL PEDASTAL IN A POSITION WHICH ENSURES THE 1 METER SAFE DISTANCE.

Start machine using the start push button operator on the electrical enclosure. The Emergency stop switch on the main control panel needs to be in the OUT position to start the machine. It may be necessary to push the momentary reset button as well.

1. Adjust the forming roll to the initial forming position desired.
2. Run the drive roll to feed material through forward. Use the optional front side pneumatic guide rollers or overhead crane to support parts over 60 IN in length.
3. Adjust forming roll to second desired position if required.
4. Run the drive roll to feed the material through backwards.
5. Repeat steps 1 through 4 until final rolled shape is attained.
6. DEPRESS THE E-STOP. LEAVE DEPRESSED UNTIL UNLOADING IS COMPLETE.
7. Swing out the drive roll to remove the finished piece.
8. Replace the drive roll into position.
9. Clear the area of all material for the next operation.



PUMP CONTROLS WITH EXISTING E-STOP

NEW INFEED TABLE

FORMING ROLL TILT ADJUSTMENT RELOCATE TO CONTROL PEDESTAL

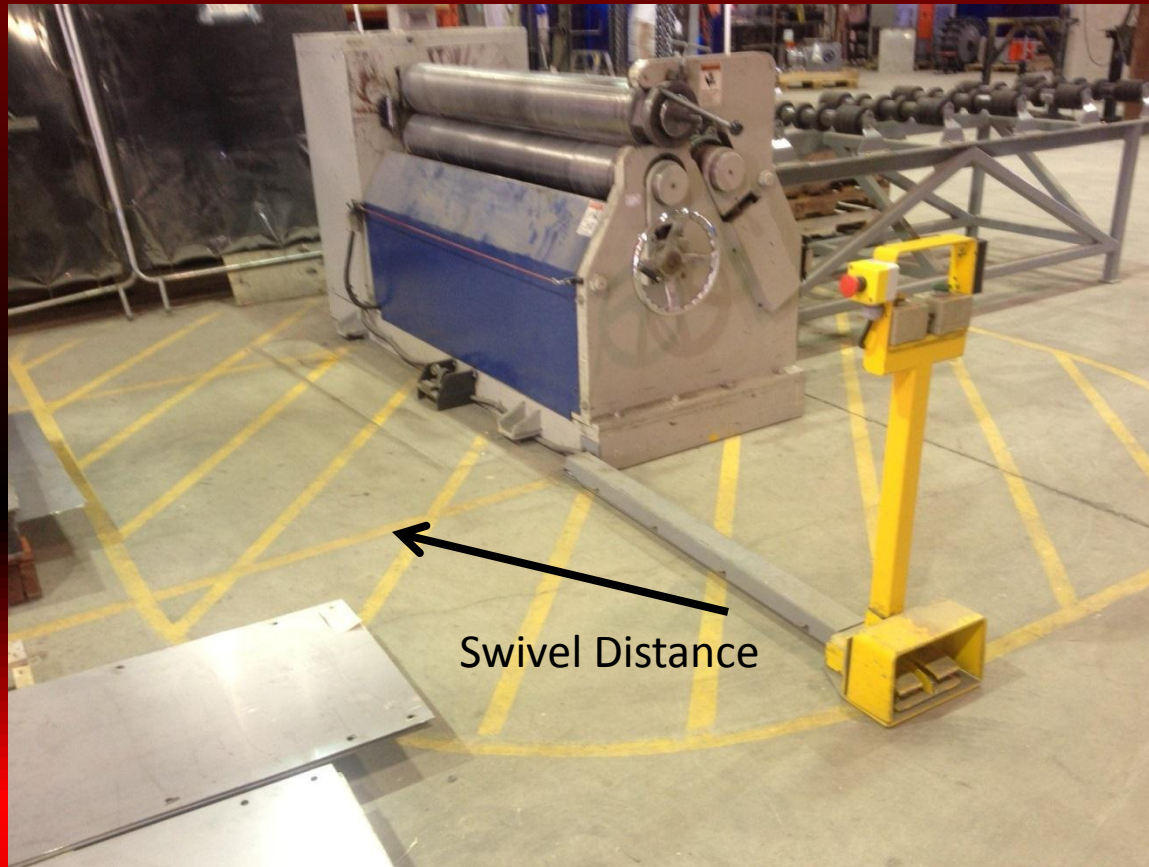
48" (1.2M) PERIMETER ZONE

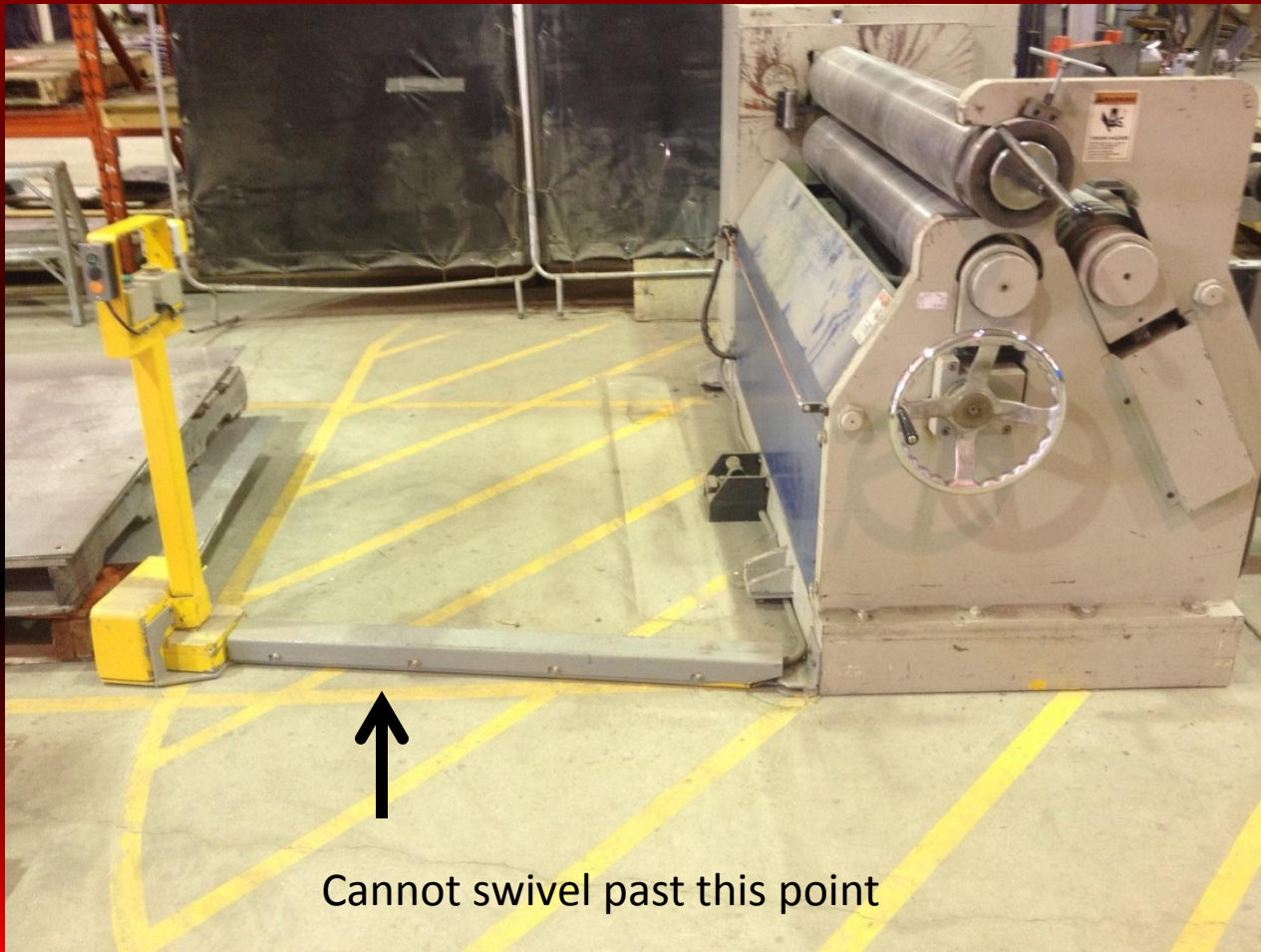
EXISTING PEDESTAL CONTROLS WITH NEW E-STOP AND RELOCATED ROLL TILT CONTROLS

MAXIMUM TRAVEL RANGE

PAB

# Painted Lines, Swivel Control Stand, Two hand control, Pressure Cable





Cannot swivel past this point





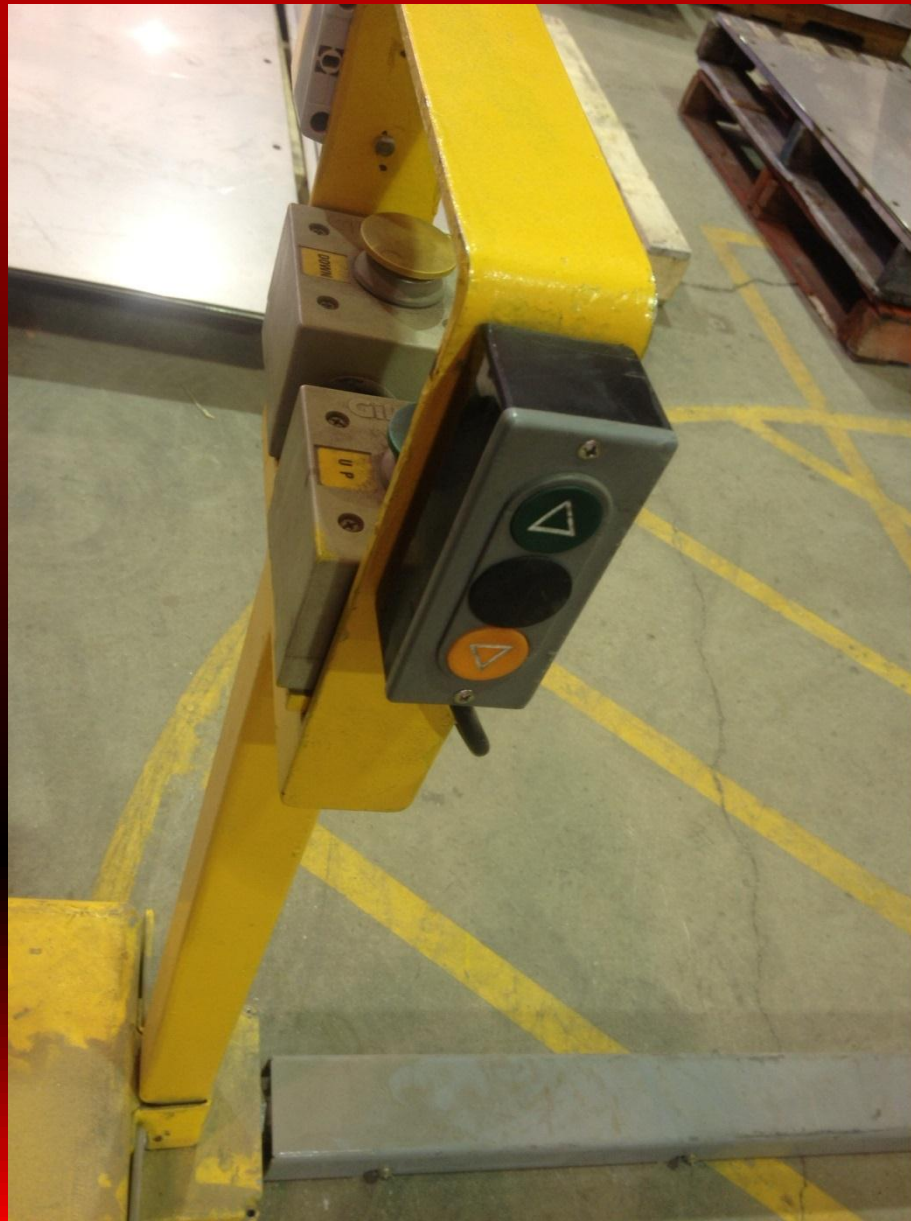


CAUTION HAZARD  
DO NOT TOUCH  
MOVING PARTS  
KEEP HANDS  
AND TOOLS AWAY  
FROM THE  
MACHINE



WALLACE MACHINERY  
204-788-1199











# Disclaimer

Please be advised that this machine guarding used in this example worked for the task/application for a specific company. This is for review only.

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