

Ironworker Steel Hole Punch – Shearing

<b>Facility:</b>	<b>Written By:</b>	<b>Approved By:</b>	<b>Date Created:</b>	<b>Date of Last Revision</b>
<b>Hazards Present:</b>		<b>PPE or Devices Required:</b>		<b>Additional Training Required:</b>
Noise		Hearing protection		Operators Manual
Pinch points		Eye protection		
<b>Safe Work Procedure:</b>				
<p><b>Pre-Operation</b></p> <ol style="list-style-type: none"> <li>1. Read operators manual</li> <li>2. Wear safety glasses</li> <li>3. Shear only mild steel. The machine is designed to handle SAE-1020 steel. This is a grade, not a thickness</li> <li>4. Keep the shear section clear</li> <li>5. Remove all tools from under the upper arm when switching from shear to punch mode.</li> </ol> <p><b>Operation</b></p> <ol style="list-style-type: none"> <li>1. Turn on motor switch</li> <li>2. Swing lever to S (Shear). The machine will now have moved to a position with the shear in the raised position. The operating pedals will have changed position with the shear pedal in the raised position and the punch pedal in the lowered position.</li> <li>3. Move the valve knobs when the machine is at rest at either end of the stroke</li> <li>4. Place valve knobs in the proper position</li> </ol> <p><b>Standard Shear Position:</b></p> <p>No. 1 – pushed in          No. 2 – pushed in          No. 3 – pulled out</p> <p><b>Maximum Shear Position</b></p> <p>No. 1 – pulled out          No 2. Pushed in          No. 3 Pulled out</p> <ol style="list-style-type: none"> <li>5. Place the material to be cut between the shear blades</li> <li>6. Snug the moveable blades up to the channel's flange</li> <li>7. Check that the area below foot pedal is clear</li> <li>8. Move hands away from the shear blade. Unless the material is very long there is no need to have your hands on the material to be sheared</li> <li>9. Make the shear stroke by depressing the foot pedal</li> <li>10. Before releasing the foot pedal back the moveable blades off by ½ turn off the crank. Make sure the slug drops from the chute after each stroke</li> <li>11. At the conclusion of the stroke, remove the foot from the pedal and the machine will return and stop in readiness for the next stroke.</li> </ol>				
<p><b><i>If an emergency situation occurs while conducting this task, or there is an equipment malfunction, engage the emergency stop and follow the lock out procedure</i></b></p> <p><b>REPORT ANY HAZARDOUS SITUATIONS TO YOUR SUPERVISOR</b></p>				
<p align="center"><b>Guidance Documents/Standards:</b></p> <p>MB Workplace Safety &amp; Health Act &amp; Regulations:</p>		<p>This Safe Work Procedure will be reviewed any time the task, equipment or materials change and at a minimum of every three years</p> <p>Reviewed By WSH Committee:</p> <p>Date:</p>		