



# OPERATOR'S MANUAL

Metal Working



## RECIPROCATING MACHINE MODEL: PH-28A (B9040)

[www.machineryhouse.com.au](http://www.machineryhouse.com.au)

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## **INTRODUCTION**

*The quality and reliability of the components assembled on a Baileigh Industrial machine guarantee near perfect functioning, free from problems, even under the most demanding working conditions. However, if a situation arises, refer to the manual first. If a solution cannot be found, contact the distributor where you purchased our product. Make sure you have the serial number and production year of the machine (stamped on the nameplate). For replacement parts refer to the assembly numbers on the parts list drawings.*

*Our technical staff will do their best to help you get your machine back in working order.*

### **In this manual you will find: (when applicable)**

- Safety procedures
- Correct installation guidelines
- Description of the functional parts of the machine
- Capacity charts
- Setup and start-up instructions
- Machine operation
- Scheduled maintenance
- Parts lists

## **GENERAL NOTES**

After receiving your equipment remove the protective container. Do a complete visual inspection, and if damage is noted, **photograph it for insurance claims** and contact your carrier at once, requesting inspection. Also contact your distributor and inform them of the unexpected occurrence. Temporarily suspend installation.

Take necessary precautions while loading / unloading or moving the machine to avoid any injuries.

Your machine is designed and manufactured to work smoothly and efficiently. Following proper maintenance instructions will help ensure this. Try and use original spare parts, whenever possible, and most importantly; **DO NOT** overload the machine or make any modifications.



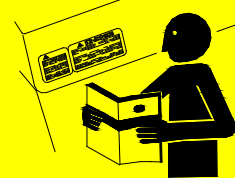
**Note:** *This symbol refers to useful information throughout the manual.*



## IMPORTANT

### PLEASE READ THIS OPERATORS MANUAL CAREFULLY

It contains important safety information, instructions, and necessary operating procedures. The continual observance of these procedures will help increase your production and extend the life of the equipment.



## SAFETY INSTRUCTIONS

### LEARN TO RECOGNIZE SAFETY INFORMATION

This is the safety alert symbol. When you see this symbol on your machine or in this manual, **BE ALERT TO THE POTENTIAL FOR PERSONAL INJURY!**



Follow recommended precautions and safe operating practices.

### UNDERSTAND SIGNAL WORDS

A signal word – **DANGER**, **WARNING**, or **CAUTION** – is used with the safety alert symbol. **NOTICE**, which is not related to personal injury, is used without a symbol.

**DANGER:** Indicates a hazardous situation which, if not avoided, will result in death or serious injury.

**WARNING:** Indicates a hazardous situation which, if not avoided, could result in death or serious injury.

**CAUTION:** Indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

**NOTICE:** Indicates a situation which, if not avoided, could result in property damage.

**DANGER**

**WARNING**

**CAUTION**

**NOTICE**

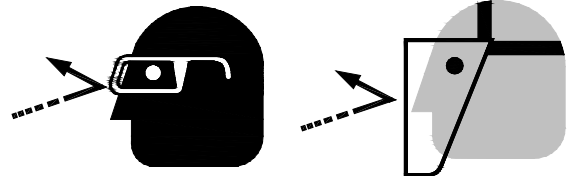


**SAVE THESE INSTRUCTIONS.**  
**Refer to them often and use them to instruct others.**



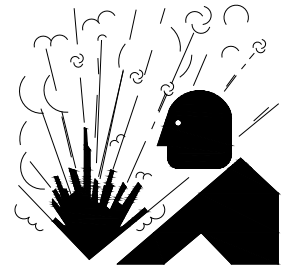
**PROTECT EYES**

Wear safety glasses or suitable eye protection when working on or around machinery.



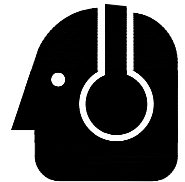
**AIR HOSE FAILURE**

Exercise **CAUTION** around air hoses in case of a hose or fitting failure.



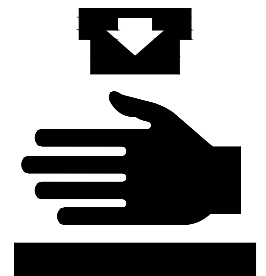
**PROTECT AGAINST NOISE**

Prolonged exposure to loud noise can cause impairment or loss of hearing. Wear suitable hearing protective devices such as ear muffs or earplugs to protect against objectionable or uncomfortable loud noises.



**BEWARE OF CRUSH HAZARD**

**NEVER** place your hands, fingers, or any part of your body in the die area of this machine.



**WARNING:** This machine has a maximum operating pressure of 120 PSI. Exceeding the maximum pressure can lead to high pressure parts failure, which may cause serious personal injury!



## **SAFETY PRECAUTIONS**



Metal working can be dangerous if safe and proper operating procedures are not followed. As with all machinery, there are certain hazards involved with the operation of the product. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result.

Safety equipment such as guards, hold-downs, safety glasses, dust masks and hearing protection can reduce your potential for injury. But even the best guard will not make up for poor judgment, carelessness or inattention. **Always use common sense** and exercise **caution** in the workshop. If a procedure feels dangerous, don't try it.

**REMEMBER: Your personal safety is your responsibility.**



**WARNING: FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS PERSONAL INJURY**

### **Dear Valued Customer:**

- All Baileigh machines should be used only for their intended use.
- Baileigh does not recommend or endorse making any modifications or alterations to a Baileigh machine. Modifications or alterations to a machine may pose a substantial risk of injury to the operator or others and may do substantial damage to the machine.
- Any modifications or alterations to a Baileigh machine will invalidate the machine's warranty.

### **PLEASE ENJOY YOUR BAILEIGH MACHINE! ...PLEASE ENJOY IT SAFELY!**

1. **FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE MACHINE.** Learn the machine's application and limitations as well as the specific hazards.
2. **Only trained and qualified personnel can operate this machine.**
3. **Make sure guards are in place and in proper working order before operating machinery.**
4. **Remove any adjusting tools.** Before operating the machine, make sure any adjusting tools have been removed.
5. **Keep work area clean.** Cluttered areas invite injuries.
6. **Overloading machine.** By overloading the machine, you may cause injury from flying parts. **DO NOT** exceed the specified machine capacities.



7. **Dressing material edges.** Always chamfer and deburr all sharp edges.
8. **Do not force tool.** Your machine will do a better and safer job if used as intended. **DO NOT** use inappropriate attachments in an attempt to exceed the machine's rated capacity.
9. **Use the right tool for the job. DO NOT** attempt to force a small tool or attachment to do the work of a large industrial tool. **DO NOT** use a tool for a purpose for which it was not intended.
10. **Dress appropriately. DO NOT** wear loose fitting clothing or jewelry as they can be caught in moving machine parts. Protective clothing and steel toe shoes are recommended when using machinery. Wear a restrictive hair covering to contain long hair.
11. **Use eye and ear protection.** Always wear ISO approved impact safety goggles. Wear a full-face shield if you are producing metal filings.
12. **Do not overreach.** Maintain proper footing and balance at all times. **DO NOT** reach over or across a running machine.
13. **Stay alert.** Watch what you are doing and use common sense. **DO NOT** operate any tool or machine when you are tired.
14. **Check for damaged parts.** Before using any tool or machine, carefully check any part that appears damaged. Check for alignment and binding of moving parts that may affect proper machine operation.
15. **Observe work area conditions. DO NOT** use machines or power tools in damp or wet locations. Do not expose to rain. Keep work area well lighted. **DO NOT** use electrically powered tools in the presence of flammable gases or liquids.
16. **Keep children away.** Children must never be allowed in the work area. **DO NOT** let them handle machines, tools, or extension cords.
17. Keep visitors a safe distance from the work area.
18. **Store idle equipment.** When not in use, tools must be stored in a dry location to inhibit rust. Always lock up tools and keep them out of reach of children.
19. **DO NOT operate machine if under the influence of alcohol or drugs.** Read warning labels on prescriptions. If there is any doubt, **DO NOT** operate the machine.



## TECHNICAL SPECIFICATIONS

|                                                                 |                                                                                                                                                                        |
|-----------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Control Power                                                   | Pnumatic, 80 – 120psi                                                                                                                                                  |
| Air Consumption                                                 | 15CFM                                                                                                                                                                  |
| Blows per Minute                                                | 0 – 1000                                                                                                                                                               |
| Tooling Height Adjustment                                       | 2" (50.4mm)                                                                                                                                                            |
| Capacity                                                        |                                                                                                                                                                        |
| Mild Steel                                                      | 16ga., 0.059" (1.51mm)                                                                                                                                                 |
| Aluminum                                                        | 14ga., 0.064" (1.62mm)                                                                                                                                                 |
| Throat Depth                                                    | 28" (711mm)                                                                                                                                                            |
| Included Tooling                                                | 2.5" Thumbnail Shrinking Dies,<br>2.5" Master Flat Top Die,<br>1" Linear Stretch Die,<br>Ø2.5" x 36" Radius Die,<br>Ø2.5" x 24" Radius Die,<br>Ø2.5" x 12" Radius Die, |
| Weight                                                          | 1000 lbs (454kg)                                                                                                                                                       |
| Shiiping Dimensions                                             | 36" x 48" x 70" (915 x 1219 x 1778mm)                                                                                                                                  |
| Based on a material tensile strength of *60000 PSI – mild steel |                                                                                                                                                                        |



**Note:** The photos and illustrations used in this manual are representative only and may not depict the actual color, labeling or accessories and may be intended to illustrate technique only.



**Note:** The specifications and dimensions presented here are subject to change without prior notice due to improvements of our products.





## UNPACKING AND CHECKING CONTENTS

Your Baileigh machine is shipped complete. Separate all parts from the packing material and check each item carefully. Make certain all items are accounted for before discarding any packing material.

**⚠ WARNING: SUFFOCATION HAZARD!** Immediately discard any plastic bags and packing materials to eliminate choking and suffocation hazards to children and animals.  
If any parts are missing, **DO NOT** place the machine into service until the missing parts are obtained and installed correctly.

### Cleaning

**⚠ WARNING: DO NOT USE** gasoline or other petroleum products to clean the machine. They have low flash points and can explode or cause fire.

**⚠ CAUTION:** When using cleaning solvents work in a well-ventilated area. Many cleaning solvents are toxic if inhaled.

Your machine may be shipped with a rustproof waxy coating and/or grease on the exposed unpainted metal surfaces. Fully and completely remove this protective coating using a degreaser or solvent cleaner. Moving items will need to be moved along their travel path to allow for cleaning the entire surface. For a more thorough cleaning, some parts will occasionally have to be removed. **DO NOT USE** acetone or brake cleaner as they may damage painted surfaces.

Follow manufacturer's label instructions when using any type of cleaning product. After cleaning, wipe unpainted metal surfaces with a light coating of quality oil or grease for protection.



**Important:** This waxy coating is **NOT** a lubricant and will cause the machine to stick and lose performance as the coating continues to dry.



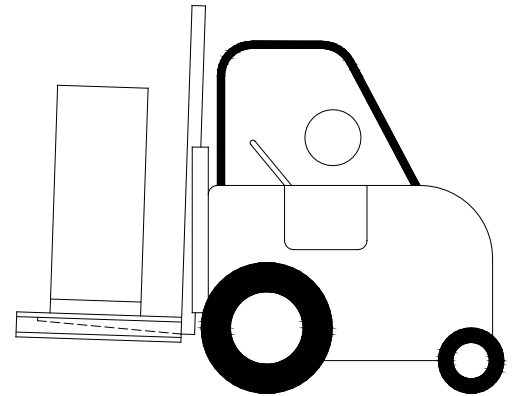


## **TRANSPORTING AND LIFTING**

**NOTICE:** *Lifting and carrying operations should be carried out by skilled workers, such as a truck operator, crane operator, etc. If a crane is used to lift the machine, attach the lifting chain carefully, making sure the machine is well balanced.*

### **Follow these guidelines when lifting with truck or trolley:**

- The lift truck must be able to lift at least 1.5 – 2 times the machines gross weight.
- Make sure the machine is balanced. While transporting, avoid rough or jerky motion, and maintain a safe clearance zone around the transport area.
- Use a fork lift with sufficient lifting capacity and forks that are long enough to reach the complete width of the machine.
- Remove the securing bolts that attach the machine to the pallet.
- Approaching the machine from the side, lift the machine on the frame taking care that there are no cables or pipes in the area of the forks.
- Move the machine to the required position and lower gently to the floor.
- Level the machine so that all the supporting feet are taking the weight of the machine and no rocking is taking place.



### **Follow these guidelines when lifting crane or hoist:**

- Always lift and carry the machine with the lifting holes provided at the top of the machine.
- Use lift equipment such as straps, chains, capable of lifting 1.5 to 2 times the weight of the machine.
- Take proper precautions for handling and lifting.
- Check if the load is properly balanced by lifting it an inch or two.
- Lift the machine, avoiding sudden accelerations or quick changes of direction.
- Locate the machine where it is to be installed, then lower slowly until it touches the floor.



## INSTALLATION

### **IMPORTANT:**

Consider the following when looking for a suitable location to place the machine:

- Overall weight of the machine.
- Weight of material being processed.
- Sizes of material to be processed through the machine.
- Space needed for auxiliary stands, work tables, or other machinery.
- Clearance from walls and other obstacles.
- Maintain an adequate working area around the machine for safety.
- Have the work area well illuminated with proper lighting.
- Keep the floor free of oil and make sure it is not slippery.
- Remove scrap and waste materials regularly, and make sure the work area is free from obstructing objects.
- If long lengths of material are to be fed into the machine, make sure that they will not extend into any aisles.
- **LEVELING:** The machine should be sited on a level, concrete floor. Provisions for securing it should be in position prior to placing the machine. The accuracy of any machine depends on the precise placement of it to the mounting surface.
- **FLOOR:** This machine distributes a large amount of weight over a small area. Make certain that the floor is capable of supporting the weight of the machine, work stock, and the operator. The floor should also be a level surface. If the unit wobbles or rocks once in place, be sure to eliminate by using shims.
- **WORKING CLEARANCES:** Take into consideration the size of the material to be processed. Make sure that you allow enough space for you to operate the machine freely.
- **AIR SUPPLY PLACEMENT:** The air supply should be located close enough to the machine so that the airline is not in an area where it would cause a tripping hazard.



## **MOUNTING AND ASSEMBLY**

1. Determine the most suitable location for your machine based on the planned usage. Larger workpieces will require a larger space around the machine.
2. Consider placing this machine on an industrial grade floor mat to reduce vibration.
3. Check the oil level in the air lubricator. If the oil level is low, refill with an SAE 10-weight non-detergent, non-additive oil.
4. Install a male 1/4" NPT quick connector fitting into the air inlet of the filter/regulator.

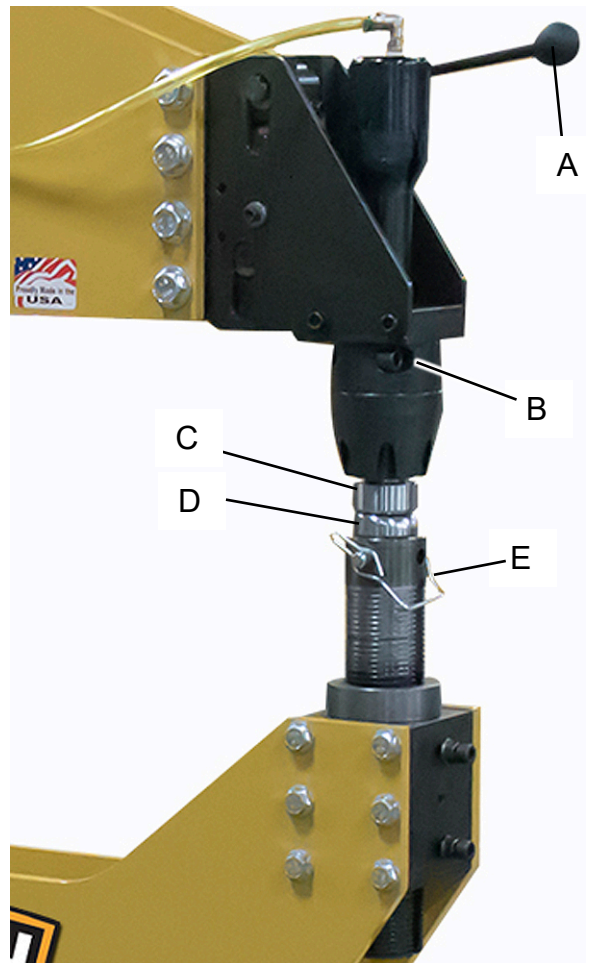


## **SETUP**

Set up involves installing the tooling, setting the gap between the anvil and the hammer head, setting the air pressure, positioning the foot pedal in a comfortable position for the operation of the machine.

### **Tooling Installation**

1. Lift the quick release handle (A) to raise the hammer head.
2. Loosen the two clamping block bolts (B).
3. If needed, lower the anvil ram to allow for clearance to insert the upper tool (C) into the hammer head.
4. Align the index slot on the tool to the hammer head and hold the fully upward and tighten the two clamping bolts (B).
5. Insert the lower die (D) into the anvil ram and align the die with the pin holes and install the lock pin (D).
6. Pull forward on the quick release handle (A) to lower the hammer head to the anvil.
7. Set the tooling clearance.





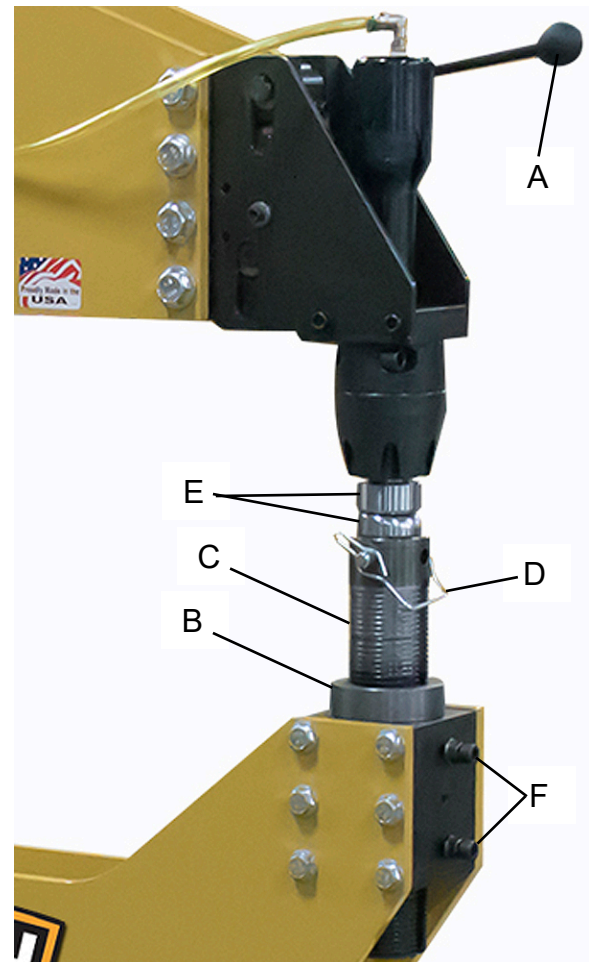
## Tooling Clearance Adjustment

1. Disconnect the machine from the air supply.
2. Install the desired tooling into the hammer head and anvil ram.
3. Pull forward on the quick release handle (A) to lower the hammer head to the anvil.
4. Loosen the anvil lock nut (B) to allow the anvil ram (C) to turn.
5. Remove the lower tool lock pin (D) to allow the lower tool to rotate within the anvil ram.
6. Adjust the anvil ram (A) up or down until the gap between the dies is the same as the material thickness. Example: 16ga. = 0.059" (1.51mm) thick, this should be the gap.



**Note:** For dies that have an interlocking type profile, verify that the lower die is aligned with the upper die when setting the clearance between the dies. Failure to align the dies will damage the tooling.

7. Install the tool lock pin (D). Because the holes for the anvil ram may not align with the tool hole, the anvil ram must be turned to align the holes.
8. Rotate the anvil ram to increase to increase the tool clearance until the first possible set of holes will align with the tool and install the lock pin. If at all possible, do not increase the gap to more than 2 times the material thickness.
9. Tighten the anvil lock nut (B).
10. Once the gap is set, use the release handle to open and close the hammer for easier loading. Always lock the handle when the hammer is in use.



## Air Setting

1. Connect the machine to the air supply.
2. Set the desired air pressure between 80-120PSI using the filter/regulator dial. A lower air pressure will provide a softer hammer blow.
3. Adjust the oil flow using the dial at the top of the lubricator. A setting of 2 drips per minute is sufficient for regular operation.



## OPERATION

**⚠ CAUTION:** Always wear proper hearing and eye protection with side shields, safety footwear, and leather gloves to protect from burrs and sharp edges. Keep hands and fingers clear of the dies. When handling large heavy sheets make sure they are properly supported.

PRACTICE AND PATIENCE. A Reciprocating Hammer is a simple tool that is easy to start to use however, it is the type of tool that requires experience to master. When an operator keeps in mind a few safety considerations as noted in the front of the manual they can create and form metal to almost any shape.

The best recommendation is to practice, take notes, experiment, and seek out advice through technical colleges, individual mentoring with an experienced operator, and through online forums and trade magazines.

1. Use a permanent marker to layout the design, pattern, or area on the material which will be formed. This will be the area that is worked between the dies during the hammering operation.
2. Install the desired tooling.
3. Set the required clearance between the dies for the material thickness to be processed.
4. Connect the machine to the air supply and set the air pressure.
5. Position the material between the dies in a comfortable and controlled position.
6. Pull the quick release handle forward to lower the hammer head to the operating position.

**⚠ WARNING:** DO NOT run this machine with no material. The tools on this machine should never directly come in contact with each other while hammering. If they do, the tooling can shatter causing injury and machine damage.

7. Position yourself and the material so that you can clearly see the area on the material that the hammer will contact. This is important for controlling the amount of forming and area of the forming of the material.
8. Using the foot pedal, slowly press down on the pedal to obtain the desired number of beats per minute (BPM).
9. The max speed is 1000 BPM; you should only use max BPM if the stroke is set to the minimum. Most forming applications will work at a lower speed rate.



10. Keep moving. Once the hammer has started, keep the material moving between the dies and within the area marked on the material. While you may go over an area several times during the forming process, it is very unusual to hammer in one place for any length of time.
11. Keep working the material until it is formed as desired. This may be when it matches your imagination or when it matches a form or template.
12. One of the most common tools used are the supplied Mini Thumbnail Shrink dies. Set the most downward stroke to be equal to the material thickness.
13. Beading tools can be installed in the same fashion; but the tool clearance is more critical. It must be slightly greater than the material thickness.

## **LUBRICATION AND MAINTENANCE**



**WARNING:** Maintenance should be performed on a regular basis by qualified personnel.  
Always follow proper safety precautions when working on or around any machinery.

Before every use:

- Check daily for any unsafe conditions and fix immediately.
- Check that all nuts and bolts are properly tightened.
- Check oil level in the lubricator, refill as needed with an SAE 10-weight non-detergent, non-additive oil.
- On a weekly basis clean the machine and the area around it.
- Lubricate threaded components and sliding devices.
- Apply rust inhibitive lubricant to all non-painted surfaces.



**Note:** *Proper maintenance can increase the life expectancy of your machine.*

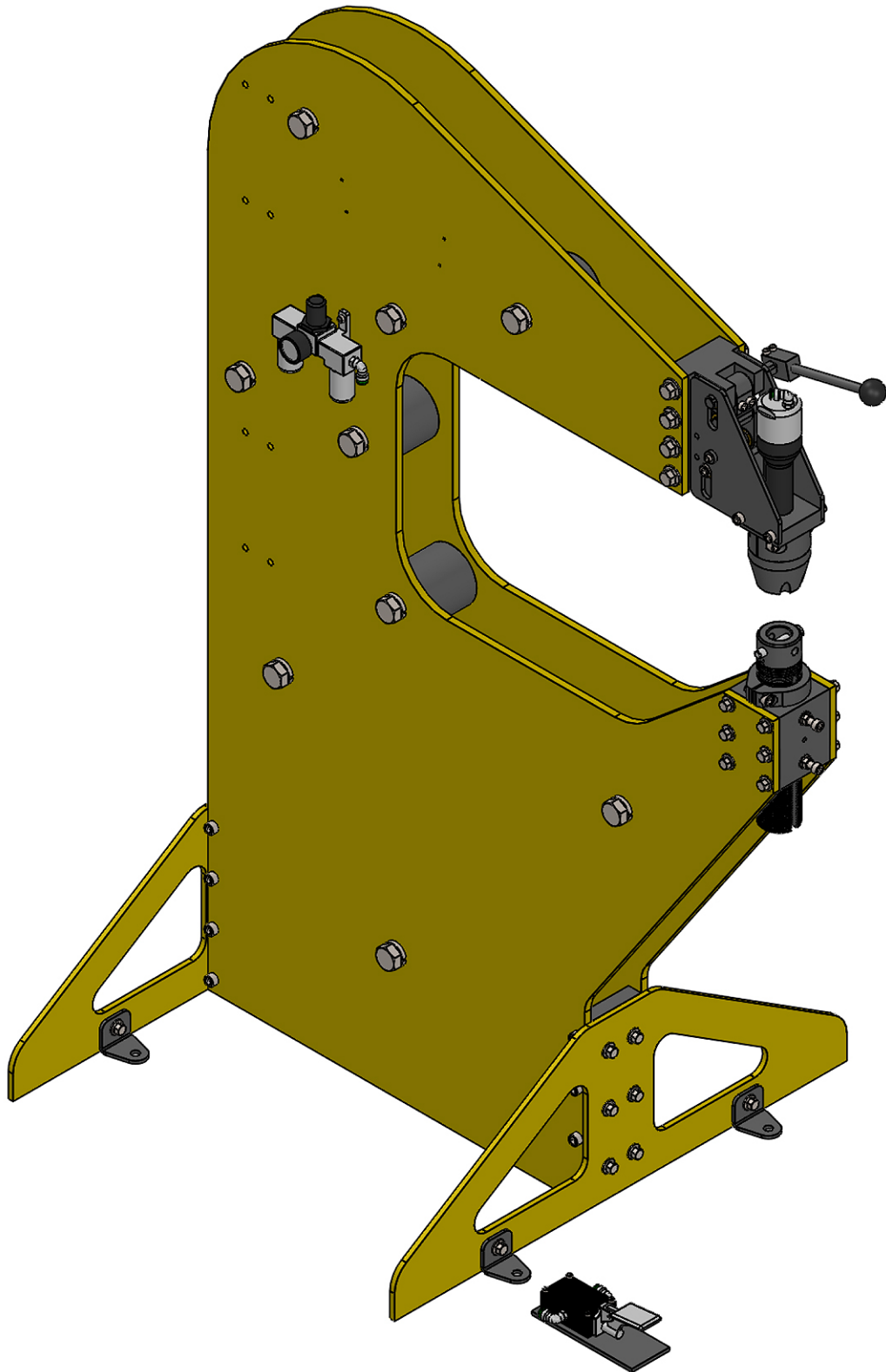
### **Pneumatic Care**

Start with clean and dry. Follow your compressor manufacturer's instructions for proper maintenance, filtering, and moisture control and removal.

Use a 10W pneumatic air tool oil in an oiler set at the lowest setting to provide enough oil to the system to maintain good lubrication. Once started, do not allow the air system to run dry.

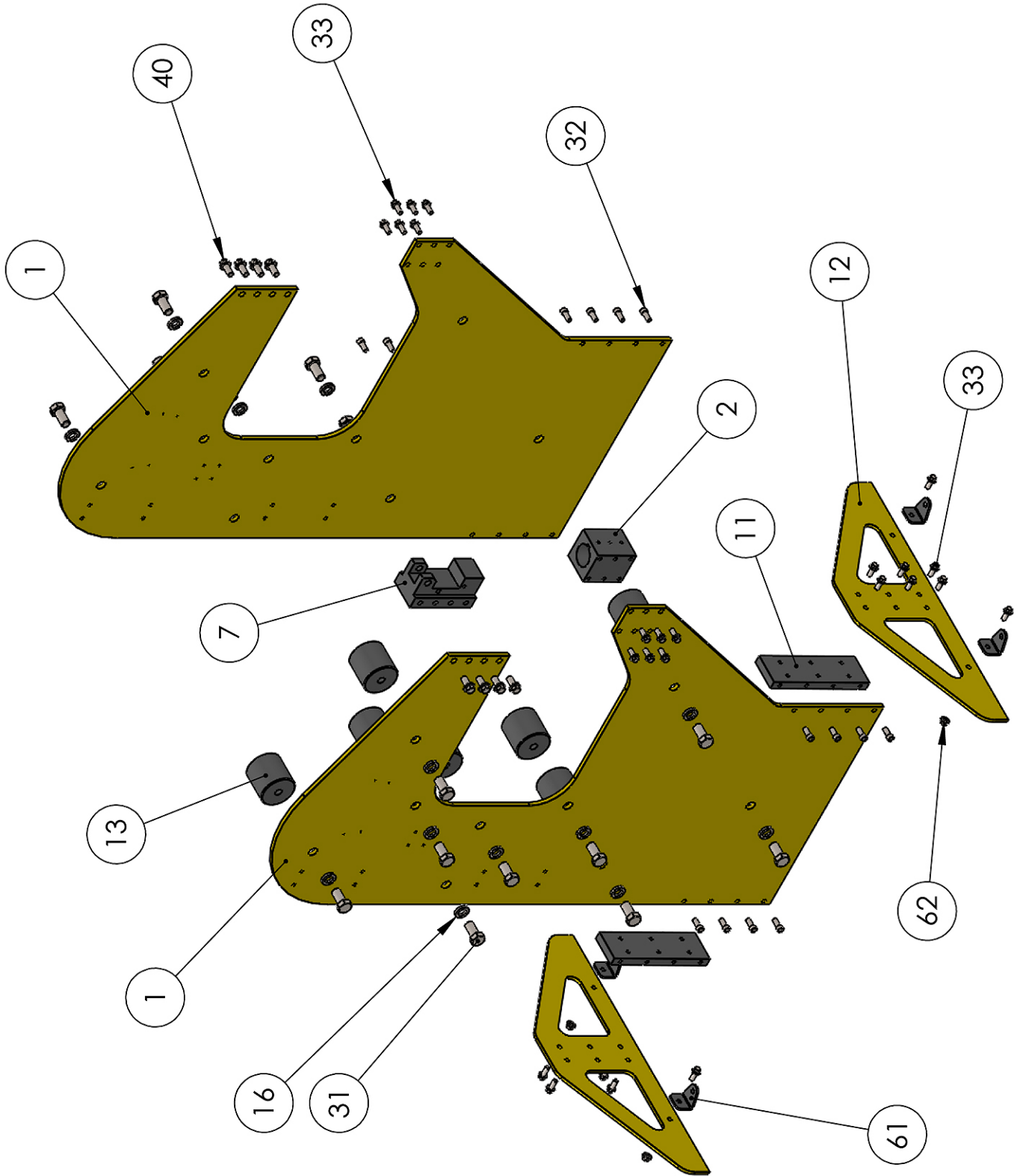


**PARTS DIAGRAM**

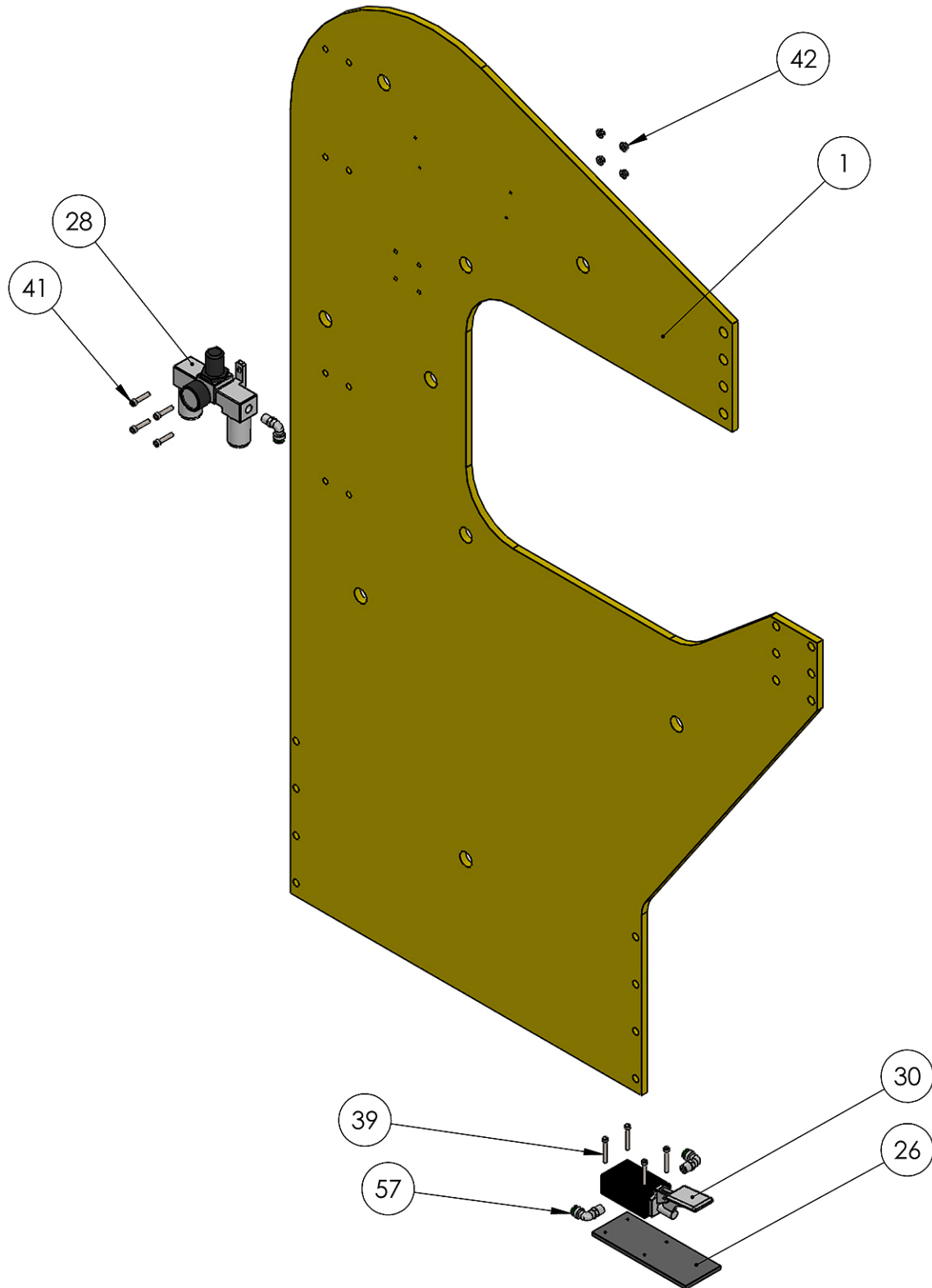




## FRAME

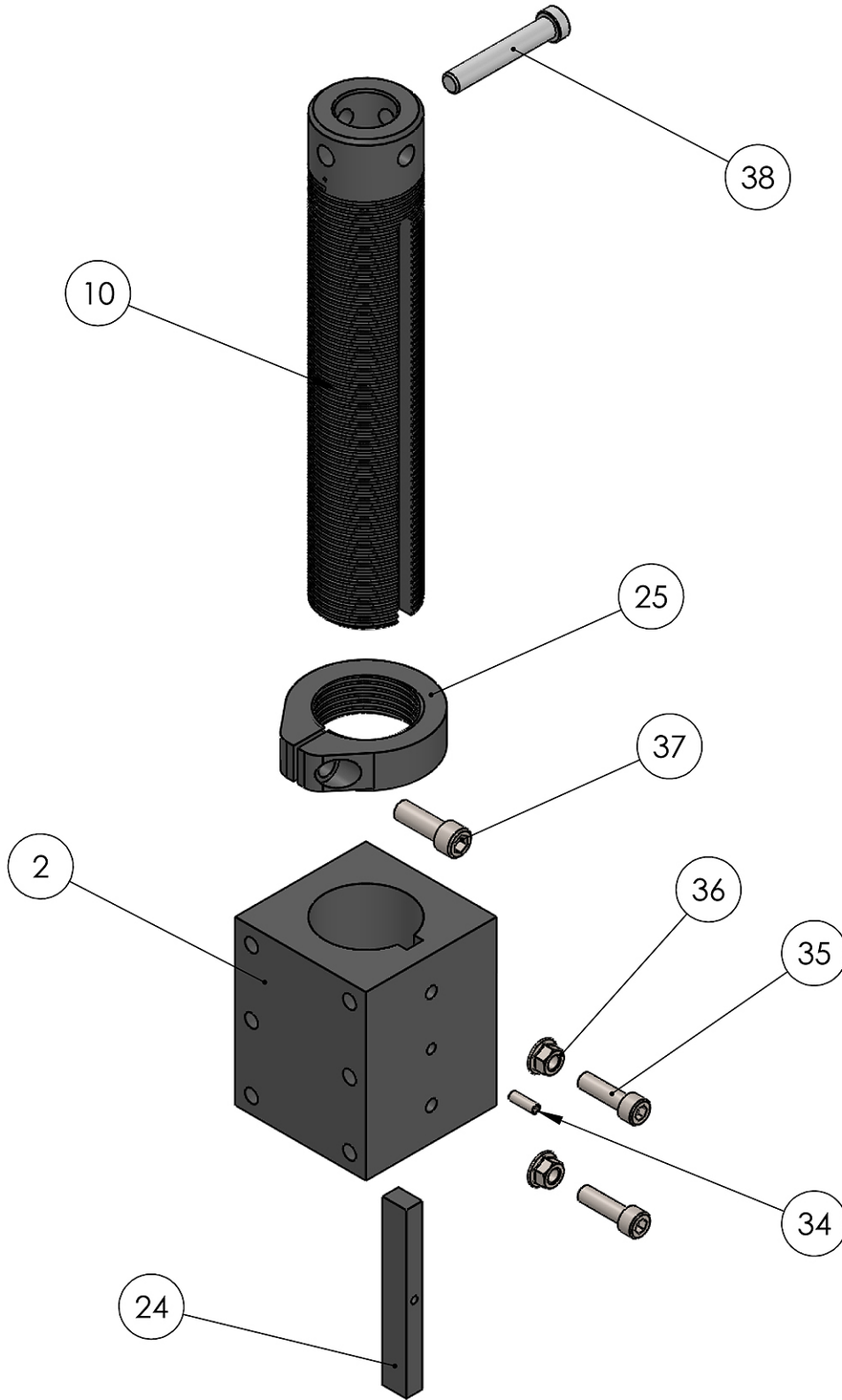


## PNEUMATICS



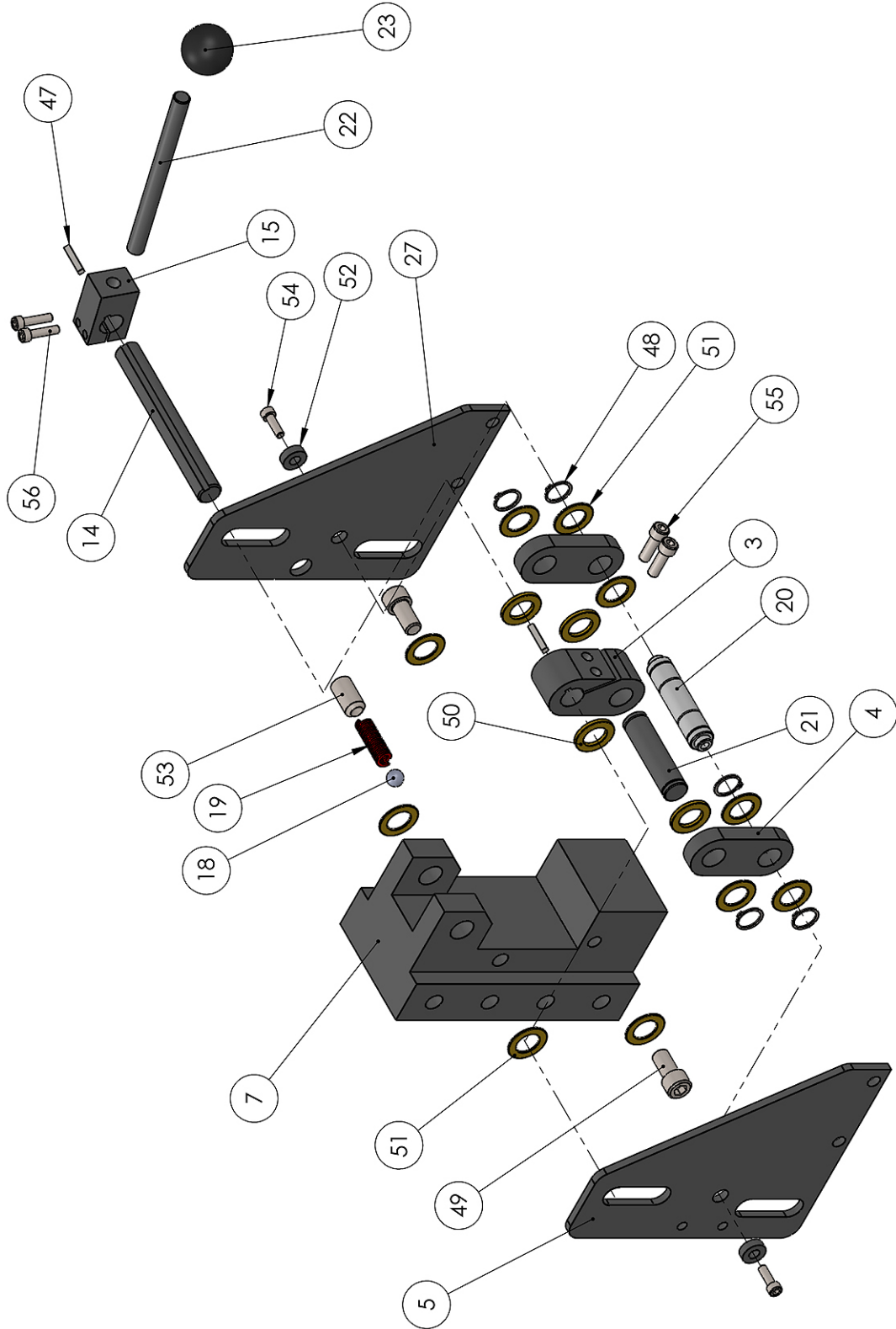


ANVIL RAM



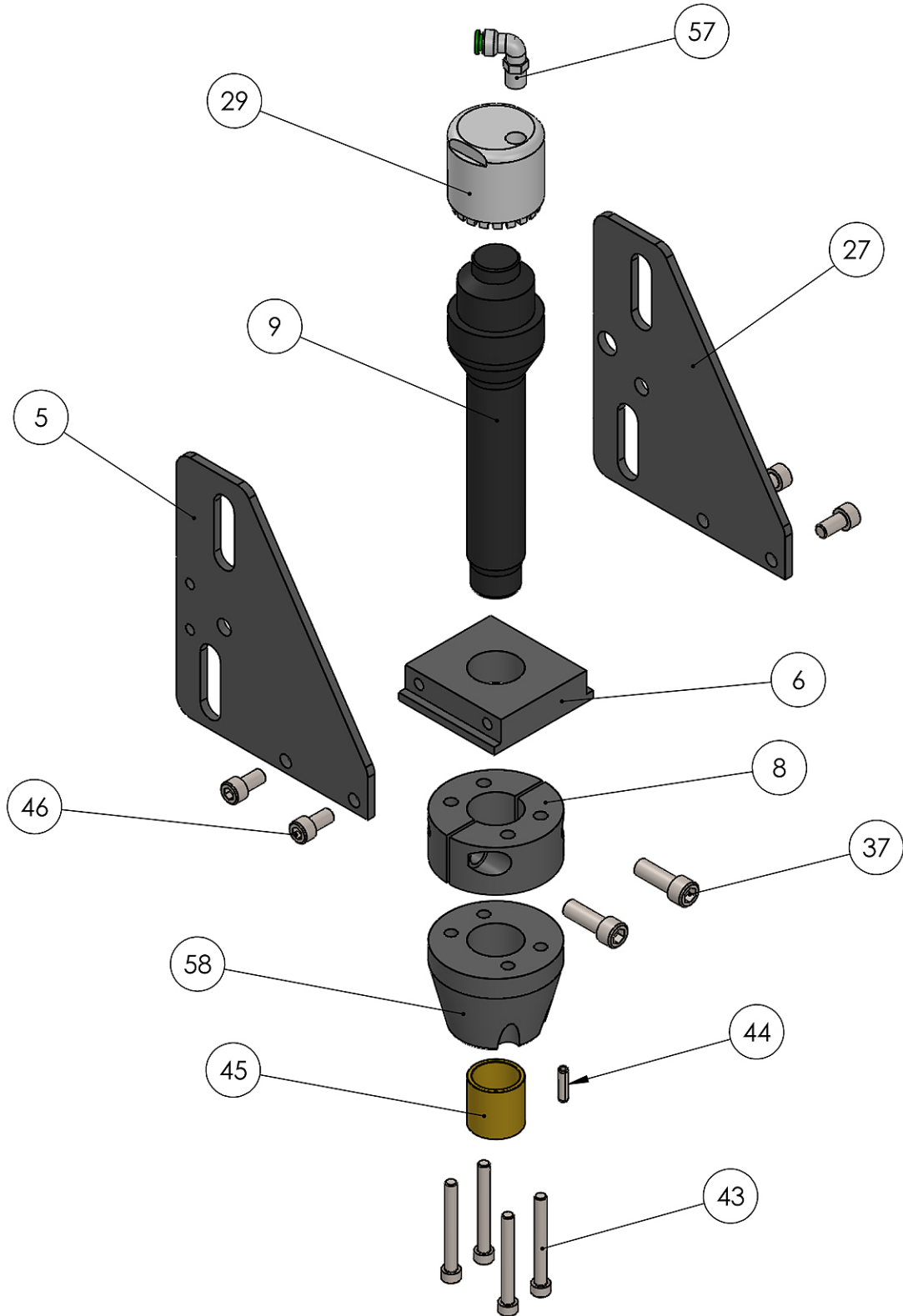


**QUICK RELEASE**





**HAMMER HEAD- PRE 2018**





## Parts List

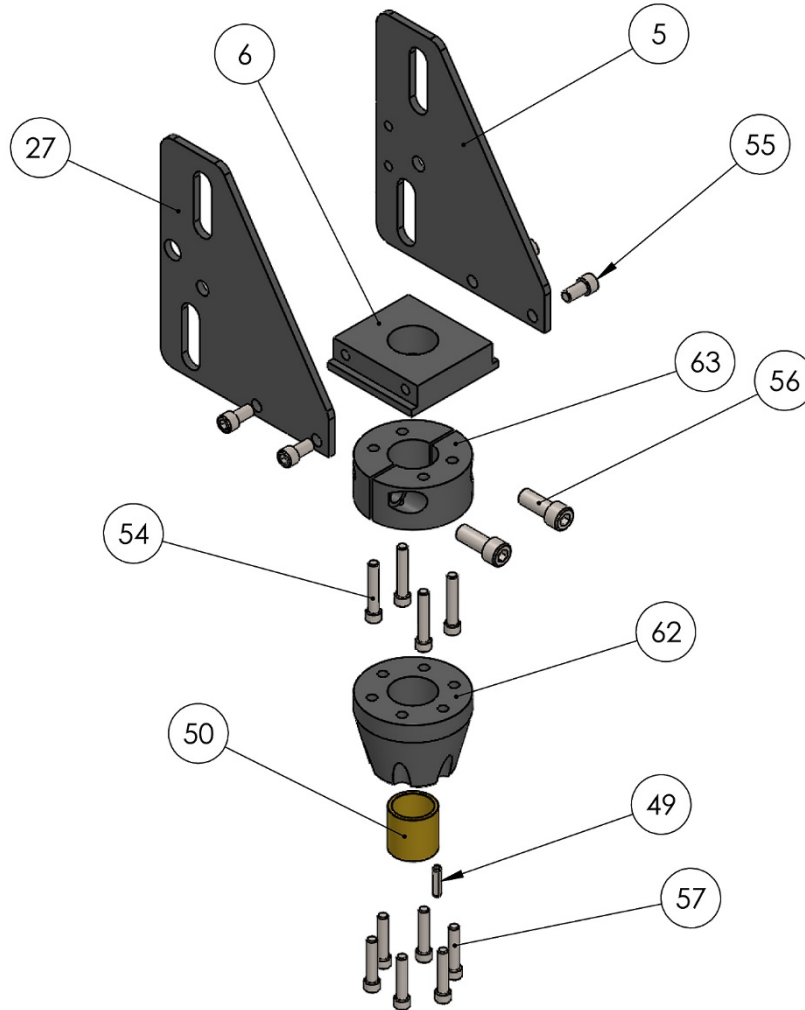
| Item | Part No.        | Description          | Qty. |
|------|-----------------|----------------------|------|
| 1    | AH28-6A026      | Side Plate 30"       | 2    |
| 2    | AH28-6A027      | Lower Tool Block     | 1    |
| 3    | AH28-6A028      | Toggle Master        | 1    |
| 4    | AH-6A006        | Toggle Link          | 2    |
| 5    | AH-6A007        | Side Plate (LH)      | 1    |
| 6    | AH28-6A008      | Tie Block            | 1    |
| 7    | AH28-6A025      | Toggle Block         | 1    |
| 8    | AH28-7A006-V3   | Clamp Block          | 1    |
| 9    | PP-1891         | Hammer Head          | 1    |
| 10   | PH24-7A007      | Lower Ram            | 1    |
| 11   | AH28-6A024      | Leg Mount            | 2    |
| 12   | AH28-6A023      | Leg Brace            | 2    |
| 13   | EW30-7A001      | Plate Spacer         | 9    |
| 14   | AH28-7A017      | Main Pivot Shaft     | 1    |
| 15   | BR16-6A004-V2   | Cam Block            | 1    |
| 16   | M24 Lock Washer | Std.                 | 18   |
| 17   | M24 x 3.0 x 50  | HHCS                 | 2    |
| 18   | PP-1192         | .50 Steel Ball       | 1    |
| 19   | PP-1186         | .5 x 1.5 Spring      | 1    |
| 20   | ME-AH-7A007     | Pivot Shaft          | 1    |
| 21   | AH-7A012        | Middle Pivot Pin     | 1    |
| 22   | M150-7A013      | Quick Release Shaft  | 1    |
| 23   | PP-0133         | Black Ball Knob      | 1    |
| 24   | PH24-6A044      | Lower Tool Shaft Key | 1    |
| 25   | PH24-7A036      | Ram Locknut          | 1    |
| 26   | ME-AH-6A019     | Foot Pedal Base      | 1    |
| 27   | AH-6A018        | Slide Plate (R.H.)   | 1    |
| 28   | PP-1288         | Regulator Manifold   | 1    |
| 29   | AH28-7A018      | Air Hammer Cap       | 1    |
| 30   | PP-1289         | Foot Pedal           | 1    |
| 31   | M24 x 3.0 x 50  | HHCS                 | 16   |
| 32   | M12 x 1.75 x 30 | SHCS                 | 16   |
| 33   | M12 x 1.75 x 30 | Hex Flange           | 28   |



| Item | Part No.                 | Description                       | Qty. |
|------|--------------------------|-----------------------------------|------|
| 34   | M6 x 1.0 x 20            | Set Screw                         | 1    |
| 35   | M10 x 1.5 x 35           | SHCS                              | 2    |
| 36   | M10 x 1.5                | Flange Nut                        | 2    |
| 37   | M12 x 1.75 x 35          | SHCS                              | 3    |
| 38   | PP-1492                  | Tooling Pin                       | 1    |
| 39   | M5 x 0.8 x 40            | SHCS                              | 4    |
| 40   | M16 x 2.0 x 35           | Hex Flange                        | 8    |
| 41   | M6 x 1.0 x 30            | SHCS                              | 4    |
| 42   | M6 x 1.0                 | Flanged Nut                       | 4    |
| 43   | M8 x 1.25 x 70           | SHCS                              | 4    |
| 44   | .25 x 1.0                | Slotted Spring Pin                | 1    |
| 45   | PP-0837                  | 1.25 I.D. x 1.50 O.D. x 1.50 Long | 1    |
| 46   | M10 x 1.5 x 20           | SHCS                              | 4    |
| 47   | STD.                     | .1875 x 1 Keystock                | 2    |
| 48   | 3/4" Ext. Retaining Ring | Std.                              | 6    |
| 49   | 1/2-13 x 1.0             | SHCS                              | 2    |
| 50   | PP-0322                  | 0.75 Id x 1.25 Od x .125 THK      | 4    |
| 51   | PP-0101                  | 0.75 Id x 1.25 Od x .0625 THK     | 10   |
| 52   | AH-7A015                 | Spacer                            | 2    |
| 53   | STD.                     | M16 x 2.0 x 30 Set Screw          | 1    |
| 54   | M6 x 1.0 x 20            | SHCS                              | 2    |
| 55   | M8 x 1.25 x 25           | SHCS                              | 2    |
| 56   | M6 x 1.0 x 25            | SHCS                              | 2    |
| 57   | PP-1333                  | 1/4 NPT – 3/8 Push Lock Elbow     | 4    |
| 58   | AH28-7A016-V2            | Guide Hub                         | 1    |
| 61   | AH28-6A007               | Shipping Bracket                  | 4    |
| 62   | M12 x 1.75               | Flange Nut                        | 4    |



## HAMMER HEAD- 2018 AND AFTER



| Item | Part No.       | Description                       | Qty. |
|------|----------------|-----------------------------------|------|
| 5    | AH-6A007       | Side Plate (L.H.)                 | 1    |
| 6    | AH28-6A008     | Tie Block                         | 1    |
| 27   | AH-6A018       | Slide Plate (R.H.)                | 1    |
| 49   | .25 x 1.0      | Slotted Spring Pin                | 1    |
| 50   | PP-0837        | 1.25 I.D. x 1.50 O.D. x 1.50 Long | 1    |
| 54   | 5/16-18 x 1.75 | SHCS                              | 4    |
| 55   | 3/8-16 x .75   | SHCS                              | 4    |
| 56   | 1/2-13 x 1.25  | SHCS                              | 2    |
| 57   | 5/16-18 x 1.50 | SHCS                              | 6    |
| 62   | AH28-7A016     | Guide Hub                         | 1    |
| 63   | AH28-7A006-V2  | Clamp Block                       | 1    |





NOTES



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# WARNING

## General Machinery Safety Instructions

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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

## Pneumatic Planishing Hammer Safety Instructions

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

- 1. Maintenance.** Make sure the Pneumatic Planishing Hammer is turned off and disconnect from the air before any inspection, adjustment or maintenance is carried out.
- 2. Pneumatic Planishing Hammer Condition.** Pneumatic Planishing Hammer must be maintained for a proper working condition. Never operate a Pneumatic Planishing Hammer that has damaged or worn parts. Scheduled routine maintenance should be performed on a scheduled basis.
- 3. Leaving a Pneumatic Planishing Hammer Unattended.** Always turn the Pneumatic Planishing Hammer off before leaving the Pneumatic Planishing Hammer. Do not leave Pneumatic Planishing Hammer running unattended for any reason.
- 4. Hand Hazard.** Keep hands and fingers clear from moving parts. Serious injury can occur if hand or finger tips get pinched between Air Hammer.
- 5. Gloves & Glasses.** Always wear leather gloves and approved safety glasses when using this machine.
- 6. Avoiding Entanglement.** Tie up long hair and use the correct hair nets to avoid any entanglement with moving parts.
- 7. Understand the machines controls.** Make sure you understand the use and operation of all controls.
- 8. Pneumatic Planishing Hammer kPa capacity.** Never use the Air Hammer over its rated PSI rating.
- 9. Hearing protection and hazards.** Always wear hearing protection as noise generated from Air Hammer and workpiece vibration can cause permanent hearing loss over time.
- 10. Eye protection.** Always wear safety glasses when using and cleaning this machine.
- 11. Work area hazards.** Keep the area around the Pneumatic Planishing Hammer 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. Level machine.** Level the machine on a flat concrete surface by using a spirit level.
- 13. 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**

### **Pneumatic Planishing Hammer**

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<br><small>(Recommended for Purchase / Buyer / User)</small>                                                                       |
|-------------------------------------------------------------------------------|----------------------------------|-------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------|
| B                                                                             | CRUSHING                         | LOW               | Secure & support work material.<br>Ensure machine is bolted down.                                                                                         |
| C                                                                             | CUTTING, STABBING,<br>PUNCTURING | MEDIUM            | Wear gloves to prevent cuts from sharp material.                                                                                                          |
| D                                                                             | SHEARING                         | MEDIUM            | Keep hands clear from moving parts.                                                                                                                       |
| F                                                                             | STRIKING                         | LOW               | Air hammer must be used with extreme precaution and in a controlled environment.                                                                          |
| G                                                                             | HIGH PRESSURE AIR                | MEDIUM            | Disconnect air supply to Air Hammer prior to checks or maintenance.                                                                                       |
| O                                                                             | OTHER HAZARDS, NOISE,<br>DUST.   | HIGH<br>MEDIUM    | Hearing protection must be worn at all times.<br>Safety gloves, shoes, pants must be worn.<br>Make sure work area is clear from objects to save tripping. |
| Plant Safety Program to be read in conjunction with manufactures instructions |                                  |                   |                                                                                                                                                           |





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Authorised and signed by:  
Safety officer:

Manager:

  
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Revised Date: 12th March 2012