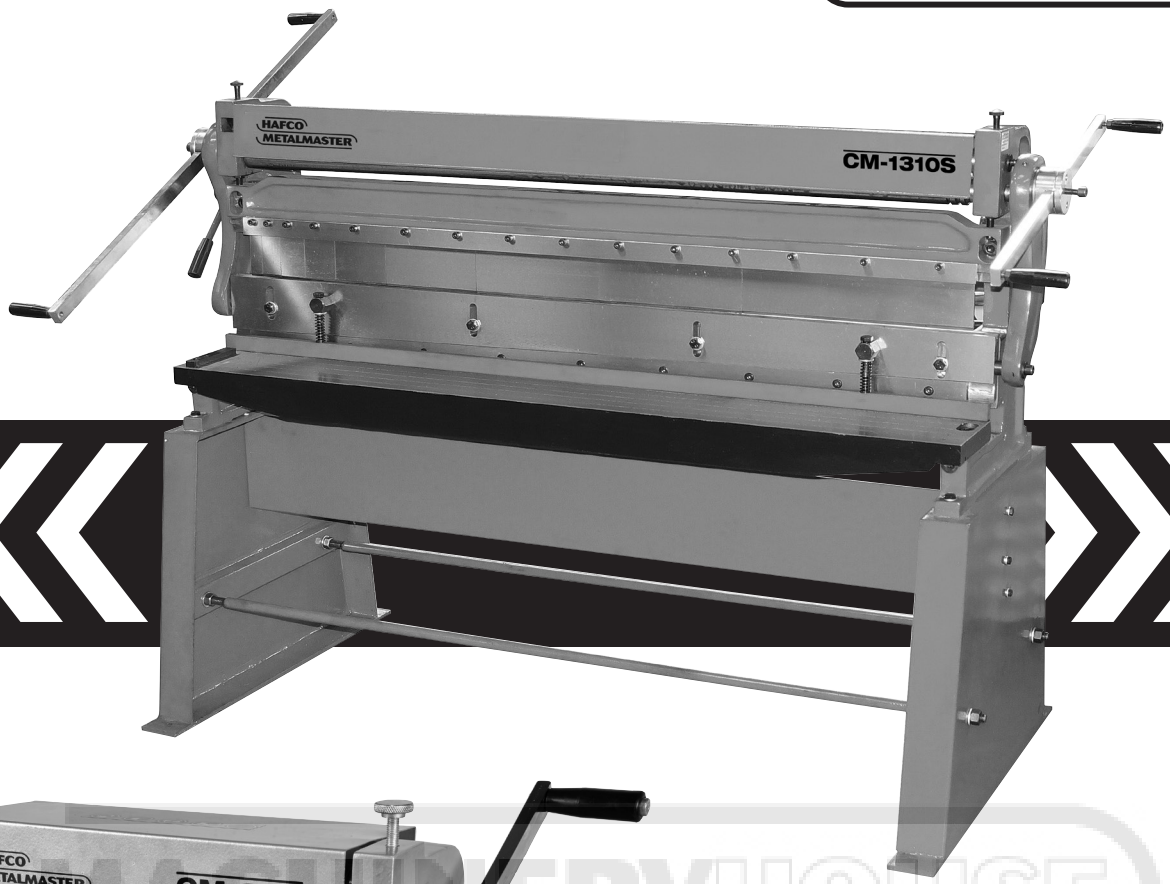
HAFCO METALMASTER



MACHINERYHOUSE

Instruction Manual

CM-300
CM-760
CM-1000
CM-1310S

3 in1 Sheetmetal Machine
Pressbrake, Guillotine & Rolls

06/2024

MACHINE DETAILS

MACHINE	3 In 1 Machine
MODEL NO.	
SERIAL NO.	
DATE OF MANF.	

DISTRIBUTED BY

MACHINERYHOUSE

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NOTE:
This manual is only for your reference. At the time of the compiling of this manual every effort to be exact with the instructions, specifications, drawings, and photographs of the machine was taken. Owing to the continuous improvement of the HAFCO METALMASTER machine, 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.

SAFETY SYMBOLS

The purpose of safety symbols is to attract your attention to possible hazardous conditions

⚠ WARNING ***Indicates a potentially hazardous situation causing injury or death***

⚠ CAUTION ***Indicates an alert against unsafe practices.***

Note: ***Used to alert the user to useful information***

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)

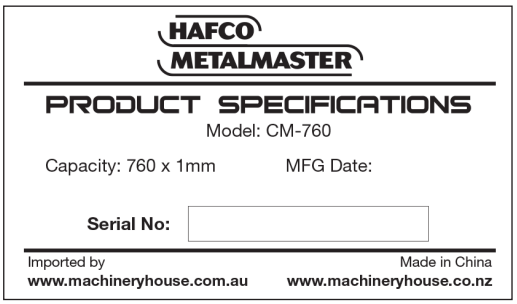

FIG.1

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MACHINERY HOUSE

1.1 SPECIFICATION

Order Code	S648	S650	S652	S654S
MODEL	**CM-300**	**CM-760**	**CM-1000**	**CM-1310S**
(mm) Length Capacity	300	760	1000	1310
(mm) Material Thickness Capacity - Mild Steel	1	1	1	1
(mm) Material Thickness Capacity - Aluminium	2	2	2	2
(mm) Rolls Diameter	42	42	50	50
(mm) Rolls Wire Sizes	3,4,6	4,6,8,	4,6,8	4,6,8
(mm) Rear Stop Gauge Range	12 ~ 400	12 ` 450	12 ~ 450	12 ~ 450
(mm) Max. Height of Pan Box Sides	45	60	45	45
(mm) Minimum Reverse Bend	10	12	12	12
(cm) Footprint	38 x 38	85 x 45	1150 x 52	1460 x 52
(kg) Nett Weight	45	153	215	378

MACHINERYHOUSE

1.2 PACKING LIST

3 in 1 combinayicn of shear, brake and roll
5mm Allen Key
12mm Allen Key
Handles
Instruction Manual

Model SM-1310S Includes stand only.

1.3 IDENTIFICATION

Become familiar with the names and locations of the controls and features shown below to better understand the instructions when mentioned later in this manual.

	Description		Description
A	Top Roller Adjustment Knobs	F	Shear Table
B	Slip Roller Cover	G	Back Gauge
C	Crank Handle	H	Blade Bow
D	Segmented Brake Fingers	I	Rear Roller Adjustment
E	Hold Down Shear Bar	J	Work Bench Mounting Holes

1.1 GENERAL METAL WORKING MACHINE SAFETY

DO NOT use this machine unless you have read this manual or have been instructed in the safe use and operation of this machine.

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.

MACHINERYHOUSE

- ✓ Always wear safety glasses or goggles.
- ✓ Wear appropriate safety footwear.
- ✓ Wear respiratory protection where required.
- ✓ Gloves should never be worn while operating the machine, and only worn when handling the work-piece.
- ✓ Wear hearing protection in areas > 85 dBA. If you have trouble hearing someone speak from one metre (three feet) away, the noise level from the machine may be hazardous.
- ✓ DISCONNECT THE MACHINE FROM POWER when making adjustments or servicing.
- ✓ Check and adjust all safety devices before each job.
- ✓ Ensure that guards are in position and in good working condition before operating.
- ✓ Ensure that all stationary equipment is anchored securely to the floor.
- ✓ Ensure all machines have a start/stop button within easy reach of the operator.
- ✓ Each machine should have only one operator at a time. However, everyone should know how to stop the machine in an emergency.

2.1 GENERAL METALWORKING MACHINE SAFETY Cont.

- ✓ Ensure that keys and adjusting wrenches have been removed from the machine before turning on the power. Appropriate storage for tooling should be provided.
- ✓ Ensure that all cutting tools and blades are clean and sharp. They should be able to cut freely without being forced.
- ✓ Stop the machine before measuring, cleaning or making any adjustments.
- ✓ Wait until the machine has stopped running to clear cuttings with a vacuum, brush or rake.
- ✓ Keep hands away from the cutting head and all moving parts.
- ✓ Avoid awkward operations and hand positions. A sudden slip could cause the hand to move into the cutting tool or blade.
- ✓ Return all portable tooling to their proper storage place after use.
- ✓ Clean all tools after use.
- ✓ Keep work area clean. Floors should be level and have a non-slip surface.
- ✓ Use good lighting so that the work piece, cutting blades, and machine controls can be seen clearly. Position any shade lighting sources so that they do not cause any glare or reflections.
- ✓ Ensure there is enough room around the machine to do the job safely.
- ✓ Obtain first aid immediately for all injuries.
- ✓ Understand that the health and fire hazards can vary from material to material. Make sure all appropriate precautions are taken.
- ✓ Clean machines and the surrounding area when the operation is finished.
- ✓ Use proper lock out procedures when servicing or cleaning the machines or power tools.

DO NOT!

- × Do not distract an operator. This can lead to injuries and should be strictly prohibited.
- × Do not wear loose clothing, gloves, neckties, rings, bracelets or other jewellery that can be come entangled in moving parts. Confine long hair.
- × Do not handle cuttings by hand because they are very sharp. Do not free a stalled cutter without turning the power off first. Do not clean hands with cutting fluids.
- × Do not use rags or wear gloves near moving parts of machines.
- × Do not use compressed air to blow debris from machines or to clean dirt from clothes.
- × Do not force the machine. It will do the job safer and better at the rate for which it was designed.

WARNING.

Before operating any machine, take time to read and understand all safety signs and symbols. If not understood seek explanation from your supervisor.

2.1 GENERAL METALWORKING MACHINE SAFETY Cont.

HAZARDS ASSOCIATED WITH MACHINES include, but are not limited to:

- Being struck by ejected parts of the machinery
- Being struck by material ejected from the machinery
- Contact or entanglement with the machinery
- Contact or entanglement with any material in motion

HEALTH HAZARDS (other than physical injury caused by moving parts)

- Chemicals hazards that can irritate, burn, or pass through the skin
- Airborne items that can be inhaled, such as oil mist, metal fumes, solvents, and dust
- Heat, noise, and vibration
- Ionizing or non-ionizing radiation (X-ray, lasers, etc.)
- Biological contamination and waste
- Soft tissue injuries (for example, to the hands, arms, shoulders, back, or neck) resulting from repetitive motion, awkward posture, extended lifting, and pressure grip.

OTHER HAZARDS

- Slips and falls from and around machinery during maintenance
- Unstable equipment that is not secured against falling over
- Safe access to/from machines (access, egress)
- Fire or explosion
- Pressure injection injuries from the release of fluids and gases under high pressure
- Electrical Hazards, such as electrocution from faulty or ungrounded electrical components
- Environment in which the machine is used (in a machine shop, or in a work site)

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WARNING!

Machines are safeguarded to protect the operator from injury or death with the placement of guards. Machines must not be operated with the guards removed or damaged.

2.2 3 IN 1 SHEET METAL MACHINES

DO NOT use this machine unless you have been instructed in its safe use and operation and have read and understood this manual

Safety glasses must be worn when operating this equipment

Safety footwear must be worn when operating this equipment

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

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

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

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 rolls 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 both ends of the rollers evenly.
- ✓ Take care during the initial feeding of the workpiece into the rolls, guillotine or panbrake.
- ✓ Hold the work-piece sufficiently far back from the edge being fed into the rolls, to allow for the in-feed speed of the machine.
- ✓ Wind handle at a slow even rate. Be aware of pinch points
- ✓ Only one person may operate this machine at any one time.

ENDING OPERATIONS AND CLEANING UP

- ✓ Ensure the handle is left in a safe position after use.
- ✓ Leave the work area in a safe, clean and tidy state.

DON'T

- × Do not use faulty equipment. Immediately report suspect machinery.
- × Do not attempt to roll, cut or bend material beyond the capacity of the machine.
- × Do not attempt to bend rod or wire in bending rolls unless the rolls are grooved for this purpose.

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 counter-rotating rollers.
- ❒ Fingers amputated in the panbrake or guillotine.

3 SET-UP

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

3.2 CLEAN - UP

The unpainted surfaces of the machine have been coated with a waxy oil to protect them from corrosion during shipment. Remove the protective coating with a solvent cleaner or a citrus based degreaser.
Optimum performance from your machine will be achieved when you clean all moving parts or sliding contact surfaces that are coated with rust prevented products.
It is advised to avoid chlorine based solvents, such as acetone or brake parts cleaner, as they will damage painted surfaces and strip metal should they come in contact. Always follow the manufacturer's instructions when using any type of cleaning product.

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3.3 SITE PREPARATION

When selecting the site for the machine, consider the largest size of workpiece that will be processed through the machine and provide enough space around the machine for operating the machine safely. Consideration should be given to the installation of auxiliary equipment. Leave enough space around the machine to open or remove doors/covers as required for the maintenance and service as described in this manual. It is recommended that the machine is anchored to the floor to prevent tipping or shifting.
It also reduces vibration that may occur during operation.

3.4 LIFTING INSTRUCTIONS

⚠ WARNING ***This machine is very heavy. Serious personal injury may occur if safe moving methods are not followed. To be safe, you will need assistance from another person when moving the shipping crate and removing the machine from the crate.***

ENVIRONMENT PROTECTION

Recycle unwanted materials instead of disposing of them as waste. All tools, accessories and packaging should be sorted, taken to a recycling centre and disposed of in a manner which is compatible with the environment. When the product becomes completely unserviceable and requires disposal, drain any fluids (if applicable) into approved containers and dispose of the product and fluids according to local regulations.

3.5 ASSEMBLY

The machine must be fully assembled before it can be operated. First clean any parts that are coated in rust preventative to ensure the assembly process can proceed smoothly.

MOUNTING THE MACHINE
BENCH MODELS (CM-300, CM-760, CM-1000)

For the best results, it is recommended the machine be bolted to the work surface or work bench. (fasteners not included)

1. Trace the holes of the machine onto the bench.
2. Drill the four holes to match the base of the machine.
3. Insert bolts through the holes, and tighten using flat washers, spring washers and nuts. (Fig. 4.1)

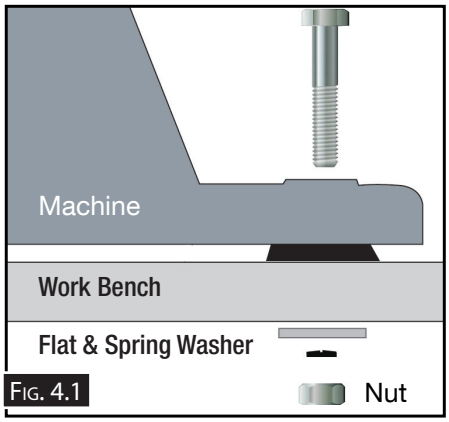


Fig. 4.1

STAND MODEL (CM-1310S)

See parts diagram (page 18).

HANDLE

1. Remove one cap screw from the crank handle hub, then slide the handle through the handle hub. (Fig.3.2)
2. Reinstall the cap screw and tighten the lock knob.

BACK GAUGE

1. Thread the two back gauge rods into the press brake or shear mounting holes. Only hand tighen the rods to make it easy to remove them. (Fig. 3.3)
2. Attach the back gauge to the two rods and secure with the lock knobs.(Fig. 3.4)

Fig. 3.2

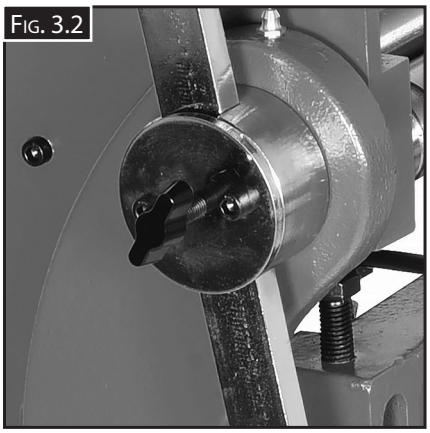


Fig. 3.3

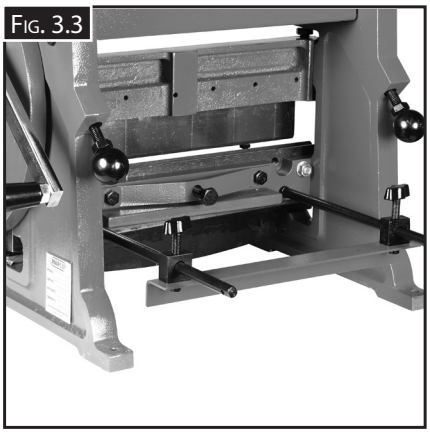
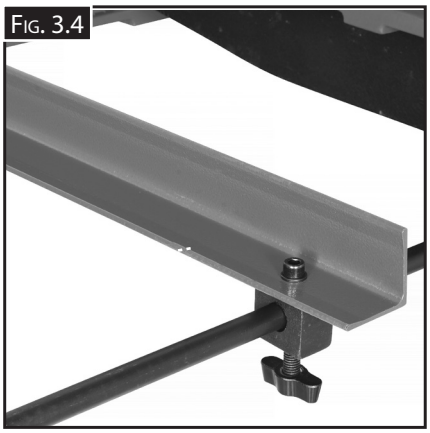


Fig. 3.4



4. OPERATION

4.1 ROLLING OVERVIEW

Three steel rollers are configured to draw the workpiece through a path that will produce the desired cylinders, or curved products.

1. Lower the rear roller until it is flush with the bottom roller. (Fig. 4.1)
2. Set the two thickness adjustment knobs to the size of the material to be worked making sure that the pressure of each end of the roller is the same. (Fig. 4.2)
3. Using the handle, feed the material forward and backwards through the rollers while making small adjustments to the diameter adjustment knobs. Make sure to adjust the knobs equally.
4 Rotate the material 180 degrees then process it through the rolls to ensure an accurate diameter is formed. Repeat the process until the diameter or curve has been reached.

Fig. 4.1

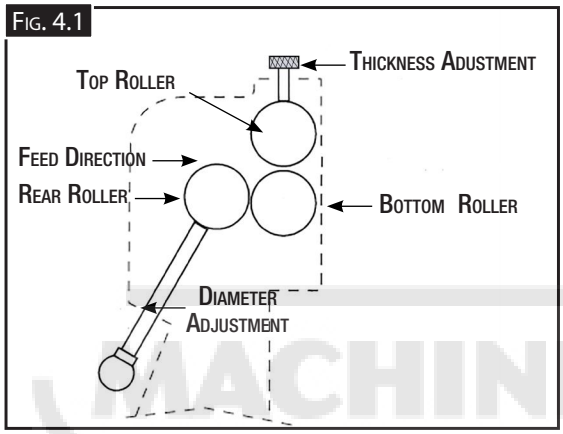
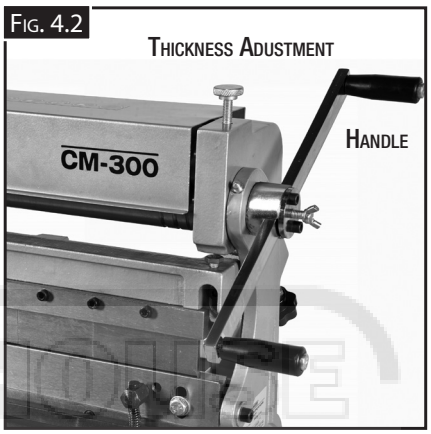


Fig. 4.2



NOTE: Always make the radius too large, than too small. It is easier to tighen the radius than increase the size of the radius.

REMOVING THE MATERIAL

Release the thickness adjustment knobs anti clockwise until the pressure has been taken off the top roller, then rotate the left thickness adjustment knob (Fig. 4.3) until the end of the roller is able to be removed from the main casting and the workpiece can be removed. (Fig. 4.4)

Fig. 4.3

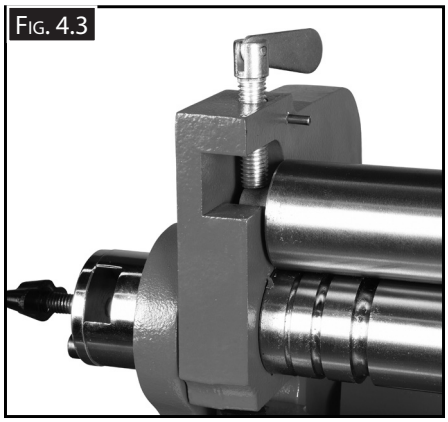
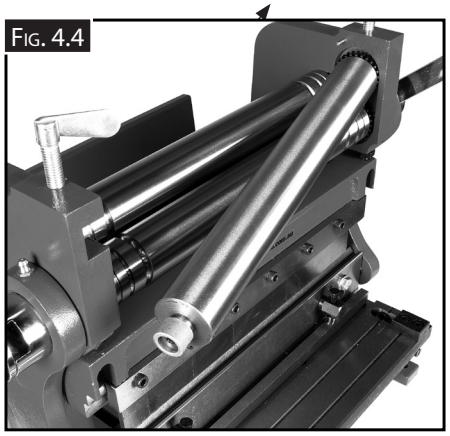


Fig. 4.4



ROLLING WIRE

These machines can roll wires, rods and small diameter tubes. (Fig. 4.5) Check the sizes in specifications on Page 4 to determine the rolling groove sizes for your particular machine.
To ensure even pressure on the work-piece material place it in the smallest possible groove. For example a 3mm rod is best rolled in the 3mm groove.

Fig. 4.5

4.2 PANBRAKE OPERATION

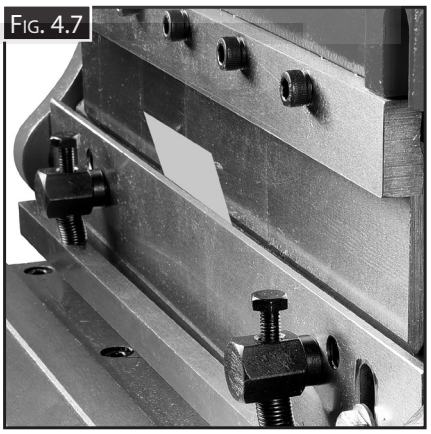
The panbrake section of the machine can produce bends in sheet metal up to 90°.
When sheet metal is bent the overall dimension increases from the original length. A typical allowance for a 90° bend in 1mm sheet metal, is 1.2mm. This means the starting length should be 1.2mm shorter.

Fig. 4.6

To Use the Panbrake:

1. Move the backgauge rods into the panbrake backgauge holes. Reverse the back gauge angle with the clamps on the underside. (Fig. 4.6)
2. Insert the material into the panbrake and use the crank handle to lower the top segmented blade and align the material.
3. Hold the material and use the crank handle to produce the bend. (Fig. 4.7)
4. To do a reverse bend place the work-piece in upside down and repeat the process.

Fig. 4.7



NOTE: Refer to the specifications to determine the minimum reverse bend for each model.

BOX BENDING

The fingers can be moved to produce pan or box sections. To do this some fingers may need to be removed, and others moved to match the width of the box or pan. (Fig. 4.8)
The maximum side height for each machine model can be found under the specifications on Page 4.

Fig. 4.8

To Move or Remove the Fingers:

1. Loosen the Skt Hd cap screws above the fingers that need to be removed or moved.
2. Once the action has been done then lower the top blade fngers into the die and tighten the Skt Hd cap screws.

4.2 GUILLOTINE OPERATION

These machines are fitted with a double sided blade suitable for cutting mild steel or aluminium, with strict limits on the thickness regardless of the width. (See specifications page 4)

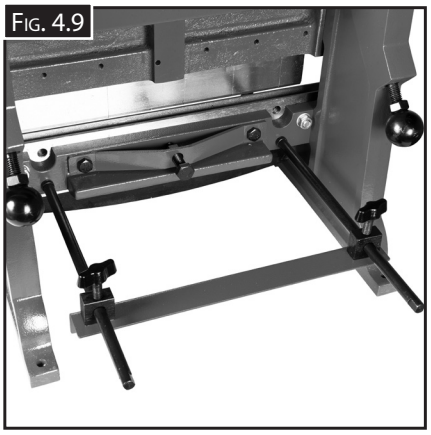


Fig. 4.9

To Use the Guillotine:

1. Move the back-gauge rods into the guillotine back-gauge holes. Reverse the back gauge angle with the clamps on the top side. (Fig. 4.9)

2. Before cutting the work-piece, use a scrap piece as a sample. If there are signs of bending, ripping, tearing, or the blades cannot pass, then refer to Adjusting Guillotine Blade Gap on page 16.

Fig. 4.10

3. Ensure that the gap between the blades is correct for the material that is being cut.

4. Once the sample cut is correct, then place the work-piece against the guide block on the right hand side of the table and align the cut mark with the upper blade. (Fig. 4.10)

5. Use the hold down clamp bar bolts to adjust the clamping pressure to hold the work-piece in place. This will help prevent marking or denting the work-piece. (Fig. 4 11)

Fig. 4.11

6. Hold the material and use the crank handle with an even and continuous movement to produce the cut.

NOTE: Refer to the specifications to determine the maximum thickness cut for each model.

WARNING

The machine is the sole responsibility of the owner for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training, proper inspection and maintenance, manual availability and comprehension. The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.

5 MAINTENANCE

It is very important that regular maintenance of the equipment is carried out. The operators need to follow the daily maintenance procedures.
For optimum performance from this machine, the maintenance schedule listed below and in this section must be followed.

5.1 SCHEDULE

Daily Check

- ❑ Loose mounting bolts or fasteners.
- ❑ Cracked or damaged rollers, fingers and blade.
- ❑ Any other condition that could hamper the safe operation of the machine

Weekly Check

- ❑ Clean machine
- ❑ Lubricate gears (Fig. 5.1)
- ❑ Lubricate roller bushings (Fig. 5.2

FIG. 5.1

FIG. 5.2

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5.2 CHECKING THE BLADE GAP

The blade gap must be the same along the length of the blade. The blade gap was set at the factory but after prolonged use the blade gap my need to be adjusted. (Fig. 5.3)

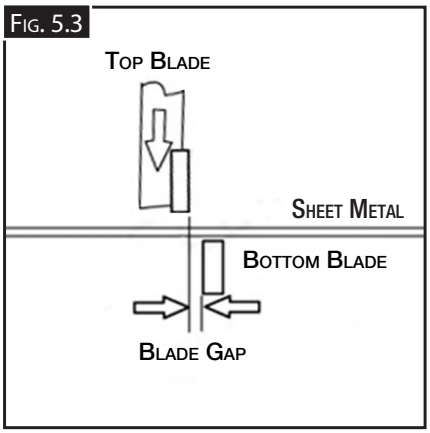
To Check The Blade Gap:

1. Use a piece of paper to do a cut test. The cut should be clean without bending the paper, tearing or ripping the paper. All cuts should be sharp without bending or tearing.

2. If the cut is not sharp all the way along the cut, then see **Adjusting The Blade Gap.**

   If the paper cuts sharply on both ends of the blade but not in the centre then see **Adjusting The Blade Bow.**

FIG. 5.3



5.3 ADJUSTING THE BLADE GAP.

The blade gap was set at the factory but after prolonged use the blade gap may need to be adjusted. (Fig. 5.3)

To Adjust The Blade Gap:

1. Loosen the Skt Hd cap screws at each end of the table guillotine table on the machine.

2. Rotate the table adjustment screws evenly until the blade gap is the same gap all along the blades.

3. Re-tighten the screws at both ends of the table and perform a gap test with a piece of paper.
   (See Checking The Blade Gap on Page 15)

5.4 ADJUSTING THE BLADE BOW.

The blade gap should be parallel all the way along the blade. Sometimes the blade gap may be the same at both ends but not in the centre. The blade bow can be adjusted to bring the blade gap parallel.
(Fig. 5.3)

To Adjust The Blade Bow:

1. If the gap in the centre is larger, then turn the adjusting screw clockwise. Make very small adjustments each time.

2. If the centre gap is smaller than the ends, then the adjusting screw must be turned anti-clockwise. Make very small adjustments each time.

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⚠ WARNING	
PINCH POINTS	***This machine has many places that are pinch points and could cause injury to the operator or any person around this type of equipment***

⚠ WARNING	
SAFETY FIRST	***The safety instructions given in this manual can not be complete. The environment in every shop is different. Always consider your safety first as it applies to your individual working conditions.***

SPARE PARTS SECTION

CM-300
CM-760
CM-1000
CM-1310S

3 in1 Sheetmetal Machine
Pressbrake, Guillotine & Rolls

MACHINERY HOUSE

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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.

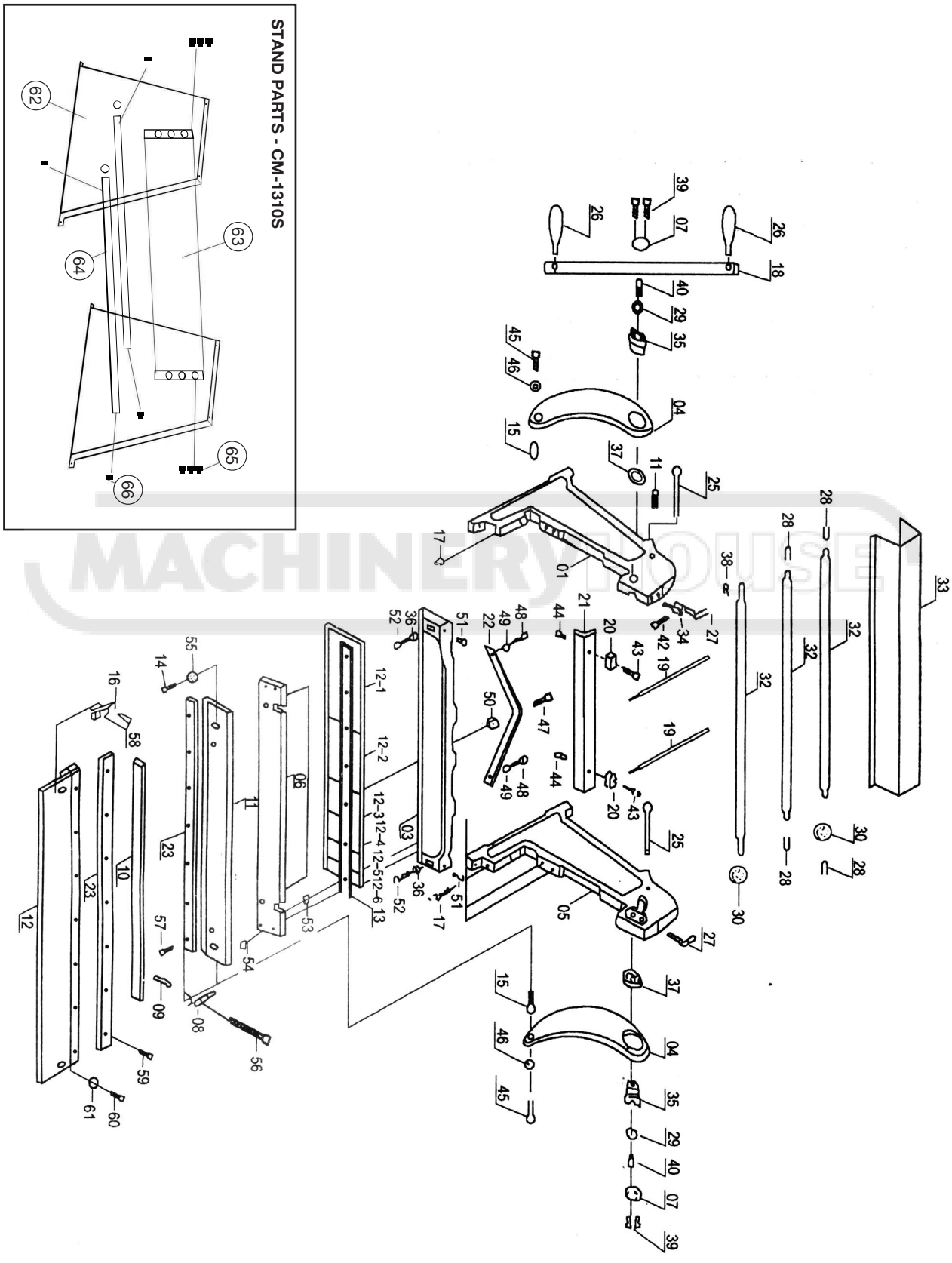
HOW TO ORDER SPARE PARTS

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.

NOTE: SOME PARTS MAY ONLY BE AVAILABLE AS AN ASSEMBLY

3. Go to www.machineryhouse.com.au/contactus and fill out the inquiry form attaching a copy of scanned parts list.

SPARE PARTS DIAGRAM



MACHINERY HOUSE

SPARE PARTS LIST

Item	DESCRIPTION	Item	DESCRIPTION
01.	Left wall	51.	Hexagon head bolts
02.	Workbench	52.	Hexagon screws
03.	Crossbeam	53.	Hexagon screws
04.	Crankarm	54.	Hexagon screws
05.	Right wall	55.	Gasket (Washer)
06.	Beam frame	56.	Hexagon head bolts
07.	Cover	57.	Hexagon screws
08.	Beam frame	58.	Hexagon screws
09.	Spring	59.	Hexagon screws
10.	Pressing plate	60.	Hexagon screws
11.	Moving cutter plate	61.	Gasket (Washer)
12.	Upper braking die	62.	Stand - Legs
13.	Pressing plate	63.	Stand - Cross Plate
14.	Bolt	64.	Stand - Cross Bars
15.	Cranking arm rolling wheel	65.	Stand - Bolts
16.	Positioner	66.	Stand - Nuts
17.	Adjustable bolt		
18.	Handle		
19.	Screw		
20.	Positioning piece		
21.	Positioning plate		
22.	Supporting Plate		
23.	Cutter		
24.	Back pressing roll		
25.	Screw		
26.	Handle jacket		
27.	Adjustable bolt		
28.	Jacket		
29.	Press cover		
30.	Gear		
31.	Lower pressing roll		
32.	Upper pressing roll		
33.	Protecting cover		
34.	Rotation shaft		
35.	Eccentric shaft		
36.	Gasket (Washer)		
37.	Jacket		
38.	Flat key		
39.	Hexagon heard bolts		
40.	Hexagon socket cap head screws		
41.	Hexagon head cap bolts		
42.	Hexagon scoket cap head sctews		
43.	Hexagon head bolts		
44.	Hexagon head bolts		
45.	Hexagon socket cap head screws		
46.	Gasket (Washer)		
47.	Hexagon head bolts		
48.	Hexagon head bolts		
49.	Gasket ,(Washer)		
50.	Hexagon nuts		

MACHINERYHOUSE

NOTE: SOME INDIVIDUAL PARTS MAY ONLY BE AVAILABLE AS AN ASSEMBLY

⚠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 ellergic 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

3 in 1 Sheet Machine Safety Instructions

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

1. **Maintenance.** Make sure all moving parts are locked down before any inspection, adjustment or maintenance is carried out. Place a block of timber between the blades to save blades from shearing hands or fingers.

2. **Machine Condition.** Machine must be maintained for a proper working condition. Never operate this machine with damaged or worn parts. Scheduled routine maintenance should performed on a scheduled basis.

3. **Blade/Rolls Condition.** Never operate a Guillotine with a damaged or badly worn blades. Replace if required.

4. **Hand Hazard.** Keep hands and fingers clear from moving parts. Serious injury can occur if hand or finger tips come between blades and rolls.

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 shear is designed to be operated be a single user. Using the machine with more than one operator is forbidden, except for certain maintenance situations.

7. **Work area hazards.** Keep the area around the Guillotine 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.

8. **Guards.** Do not operate this machine without the correct guards in place. Necessary guards protect you from injuries by the blades and rolls.

9. **Material.** Material must NOT be hardened ceramic or glass-originated, non flat metals (at origin) e.g. rods, bars, tubes & pipes.

10. **Blade gap adjustment.** Do NOT operate the machine without proper blade gap adjustment according to sheet thickness.

11. **Warning Labels.** Take note of any warning labels on the machine and do not remove them.

12. **Backgauge Area.** Do not access the backgauge area, while the machine is working.

13. **Squaring arm.** Do not use side squaring arm and front support arms for intermediate storage of workpieces.

14. **Operation.** During the operation process, the workpiece may slide or move unexpectedly. Therefore, the material must be handled carefully.

15. **Level machine.** Level the machine on a flat concrete surface by using a spirit level.

16. **Hearing protection and hazards.** Always wear hearing protection as noise generated from machine and workpiece can cause permanent hearing loss over time.

17. **Heating Material.** Heating metal with a torch while the metal is in the panbrake will weaken the fingers.

18. **Pinching.** Prevent pinching by lowering the panbrake fingers when not in use.

19. **Call for help.** If at any time you experience difficulties, stop the machine and call you nearest branch service department for help.

MACHINERYHOUSE

PLANT SAFETY PROGRAM

NEW MACHINERY HAZARD IDENTIFICATION, ASSESSMENT & CONTROL

(3 in 1) Panbrake/Folder/Guillotine/Rolls

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 (Recommended for Purchase / Buyer / User)
B	CRUSHING	LOW	Secure & support work material on table etc. Ensure machine is bolted down.
C	CUTTING, STABBING, PUNCTURING	MEDIUM	Wear gloves to prevent cuts from sharp material offcuts. Ensure guards are properly fitted Care must be taken when handling blades.
D	SHEARING	MEDIUM	Keep hands clear of all blades and rolls when using machine.
F	STRIKING	MEDIUM	Ensure material clamps are correctly adjusted.
Plant Safety Program to be read in conjunction with manufactures instructions			

HARE&FORBES MACHINERYHOUSE

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Authorised and signed by:
Safety officer:.....
Manager:.....

Revised Date: 12th March 2012

8.0 NOTES

MACHINERYHOUSE

ENVIRONMENT PROTECTION

Recycle unwanted materials instead of disposing of them as waste. All tools, accessories and packaging should be sorted, taken to a recycling centre and disposed of in a manner which is compatible with the environment. When the product becomes completely unserviceable and requires disposal, drain any fluids (if applicable) into approved containers and dispose of the product and fluids according to local regulations.

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