

OPERATION MANUAL



SECTION & TUBE ROLLING MACHINE

MODEL. RR-24

Order Code S682

EDITION No : RR-24-1

DATE OF ISSUE : 02/2022

MACHINE DETAILS

MACHINE	<input type="text" value="Section & Tube Rolling Machine"/>
MODEL NO.	<input type="text" value="RR-24"/>
SERIAL NO.	<input type="text"/>
DATE OF MANF.	<input type="text"/>

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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.



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)

HAFCO
PRODUCT SPECIFICATION

MODEL:	<input type="text"/>
CAPACITY:	<input type="text"/>
SER. NO:	<input type="text"/>
MFG DATE:	<input type="text"/>
WEIGHT:	<input type="text"/>
VOLTS:	<input type="text"/>
MOTOR Kw:	<input type="text"/>

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Made in China

FIG.1

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1.1 SPECIFICATION

Order Code	S682
MODEL	RR-24
Powered Driven Rolls (Qty)	2
Bending Rolls (Type)	Manual Top
Square Tube Max. Capacity - MS (size / Ø) (mm)	50 x 50 x 1.6 / 1000
Round Tube Max Capacity - MS (size / Ø) (mm)	Ø76 x 2 / 1520
Square Tube Min. Capacity - MS (size / Ø) (mm)	16 x 16 x 400
Round Tube Min Capacity - MS (size / Ø) (mm)	Ø16 x 1.6 / 320
Motor Power (kW/hp)	1.1 / 1.5
Voltage / Amperage (V / amp)	240 / 10
Dimensions (L x W x H) (mm)	740 x 630 x 1030
Note: Requires Additional Tooling (Yes / No)	No
Shipping Dimensions (L x W x H) (cm)	86 x 111 x 103
Nett Weight (kg)	287

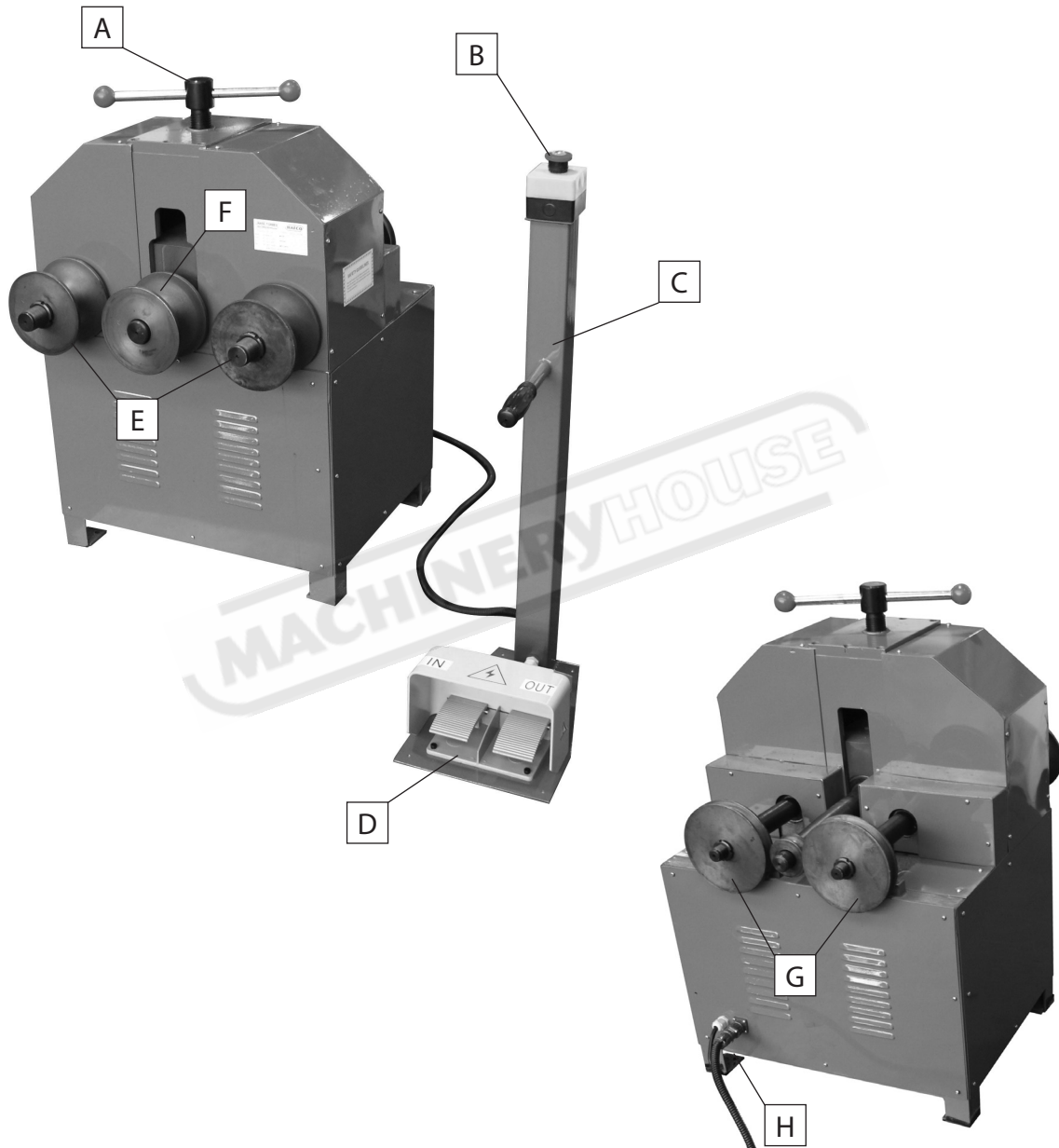
1.2 ACCESSORIES INCLUDED

- 9 Round tube dies - Ø16, Ø19, Ø22, Ø25, Ø32, Ø38, Ø51, Ø63, Ø76mm
- 8 Square tube dies - 16, 19, 22, 25, 30, 38, 40, 50mm
- 1 Roving Foot Pedal
- 1 Manual

Round Tube Dies		Square Tube Dies	
Die Size	Minimum Rolling Dia.	Die Size	Minimum Rolling Dia.
Ø16mm	320mm	Ø16mm	400mm
Ø19mm	380mm	Ø19mm	475mm
Ø22mm	440mm	Ø22mm	550mm
Ø25mm	500mm	Ø25mm	625mm
Ø32mm	640mm	Ø30mm	750mm
Ø38mm	760mm	Ø38mm	950mm
Ø51mm	1020mm	Ø40mm	1000mm
Ø63mm	1260mm	Ø50mm	1250mm
Ø76mm	1520mm		

1.3 IDENTIFICATION

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



A	Centre Roll Adjustment Lever	E	Front View Driven Rolls
B	Emergency Stop Button	F	Centre Movable Roll
C	Roving Foot Pedal	G	Rear View Driven Rolls
D	Direction Pedals	H	Roving Foot Pedal & Power Outlet

2.1 GENERAL METALWORKING 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.



- ✓ 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 workpiece.
- ✓ 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.
- ✓ DISCONNECTION 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. Horseplay can lead to injuries and should be strictly prohibited.
- × Do not wear loose clothing, gloves, necktie's, 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.



BEFORE OPERATING ANY MACHINE, TAKE TIME TO READ AND UNDERSTAND ALL SAFETY SIGNS AND SYMBOLS. IF NOT UNDERSTOOD SEEK EXPLANATION FROM YOUR EXPERIENCED OPERATOR.

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)



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 ADDITIONAL SAFETY FOR SECTION ROLLING MACHINE

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



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 the 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 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 rollers slowly and in small adjustments.
- Take care during the initial feeding of the workpiece into the rollers.
- Hold the workpiece sufficiently far back from the edge being fed into the rolls, to allow for the in-feed speed of the machine.
- Adjust the rollers at a slow even rate. Be aware of rotating rolls
- Only one person may operate this machine at any one time.

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 rolls.

DON'T

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

3. POWER SUPPLY

3.1 ELECTRICAL INSTALLATION

Place the machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure there is access to a means of disconnecting the power source. The electrical circuit must meet the requirements for 240V.

NOTE: The use of an extension cord is not recommended as it may decrease the life of electrical components on your machine.

ELECTRICAL REQUIREMENTS

Nominal Voltage.....	240V
Cycle.....	50 Hz
Phase.....	Single Phase
Power Supply Circuit.....	10 Amps
Full Load Current.....	7.21 Amps

(Full load current rating is also on the specification plate on the motor.)

3.2 FULL-LOAD CURRENT RATING

The full-load current rating is the amperage a machine draws when running at 100% of the output power. Where machines have more than one motor, the full load current is the amperage drawn by the largest motor or a total of all the motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating for these machine at 240V is 7.21 Amps

It should be noted that the full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating and if the machine is overloaded for a long period of time, damage, overheating, or fire may be caused to the motor and circuitry.

This is especially true if connected to an undersized circuit or a long extension lead. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the requirements.



4 SETUP

4.1 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 the your distributor.

4.2 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.

4.3 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.

4.4 LIFTING INSTRUCTIONS



WARNING

This machine is extremely heavy. Serious personal injury may occur if safe moving methods are not followed. To be safe, you will need assistance and power equipment when moving the shipping crate and removing the machine from the crate.



On the day that the machine arrives, make sure that a forklift or lifting device, with sufficient capacity is available to unload the machine from the vehicle. Ensure access to the chosen site is clear and that doors and ceilings are sufficiently high and wide enough to receive the machine.

4.5 TEST RUN

Once assembly is complete, test run the machine to ensure it is properly connected to the power and safety components are functioning correctly. Check that the direction of the motor is correct and make sure that the machine rotates in the correct direction.

If the direction is incorrect, isolate the machine and have the electrician make changes to the wiring.

If you find an unusual problem during the test run, immediately stop the machine, disconnect it from power, and fix the problem BEFORE operating the machine again. The Troubleshooting table in the Maintenance section of this manual may be able to help. If the problem persists the contact your dealers service technician.

To test run the machine:

1. Connect the machine to the power supply.
2. Make sure that the manual has been read and that the safety instructions at the beginning of the manual are understood. Make sure the machine has been setup correctly
3. Make sure all tools and objects used during set up have been cleared away from the machine.
4. Turn the machine ON.
5. Make sure that the rolls are traveling in the correct direction.
6. Listen to and watch for abnormal noises or actions. The machine should run smoothly with little or no vibration or rubbing noises.
7. Any strange or unusual noises should be investigated and corrected before operating the machine again. Always disconnect the machine from power supply when investigating or correcting potential problems. The troubleshooting chart in the maintenance section may be helpful in rectifying a problem

Testing The Emergency Stop Button

Make sure that the emergency button is working correctly

1. Twist the top of the Emergency Stop button to insure that it is in the raised position.
2. Start the machine and then press the emergency stop button. The machine should stop and the power should be cut off. If the machine cannot be started then the emergency stop is working correctly. To reset the Emergency Stop twist the red top until it pops up.
3. The machine should now work again.



5. OPERATION

This machine may perform many types of operations that are beyond the scope of this manual. Many of these operations may be dangerous or deadly if performed incorrectly.

The instructions in this section are written with the understanding that the operator has the necessary knowledge and skills to operate this machine. If at any time you are experiencing difficulties performing any operation, stop using the machine!

If you are an inexperienced operator, we strongly recommend that you read books, trade articles, or seek training from an experienced operator before performing any unfamiliar operations. Above all, your safety should come first!

5.1 BASIC OPERATION TERMS

The RR-24 has two rolls powered and top roll idle. The top roll can be adjusted by the manual screw adjusting system to make the bending in a wide radius range. Therefore, bending operation is simple and smooth however requires experience for efficient working. Following the recommendations will be helpful during operation:

Recommendations

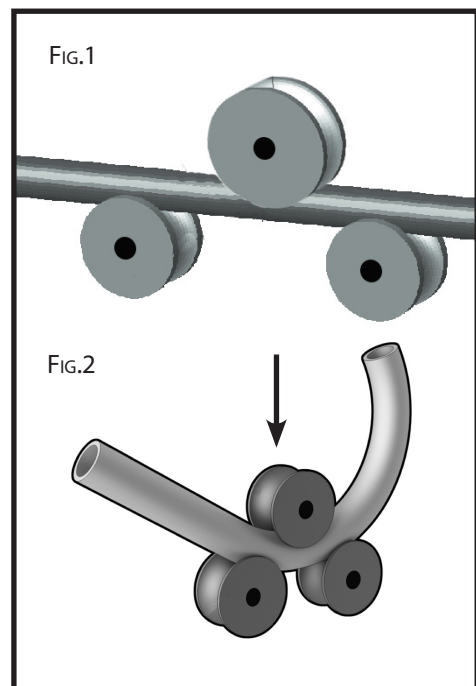
- It is recommended that the user have basic bending information with this kind of machine.
- Making a tight bend in one pass is not possible. So you need several passes before you can achieve a certain radius. Tighter curves and full radii always take a lot of time.
- During the operation never wear loose garments, long loose hair, necklaces, or rings etc. which could be caught and may be dragged into the machine parts,
- Use the emergency button in case of any emergency.

5.2 OPERATING INSTRUCTIONS

Place the material on the rolls as shown in the figure 1. Make sure that material is placed parallel to the ground and touching all three rolls at the same time. This position is called "zero position". (Fig. 1)

Move the upper roll down and position it to apply enough force to bend the material. Do not apply force more than necessary. If you apply too much force, you may deform the material during the bending operation.

Push the foot pedal to rotate the rolls in the direction you want to travel.(Fig. 2). To get desired diameter value make more than one pass by gradually lowering the upper roll after each pass. After a pass if the diameter value is bigger than expected, move the upper roll down to apply more force. If the diameter value is greater than required, then release the upper roll.



5.3 CHANGING THE ROLLS

In order to change the lower rolls:

1. Stop the machine if it is active and disconnect from the power supply
2. Using the "C" spanner supplied, Loosen and remove the nuts at the end of the lower rolls' shafts. (Fig. 4)
3. Slide the rolls off the shafts
4. Replace the rolls with the ones that are to be use
5. Tighten the nuts with the "C"spanner again.



To change the upper roll:

1. Stop the machine if it is active and disconnect from the power supply
2. To remove the top roll of the top shaft, just slide the roll off the shaft. The top roll is not contained and is left to float to ensure that the tube is contained by the rolls.
3. Replace the roll with the one that matches the bottom rolls..

6. MAINTENANCE

It is very important that regular maintenance of the equipment is carried out. The operators need to of follow the daily maintenance procedures.

For optimum performance from this machine, the maintenance schedule listed below and in this section must be followed.

6.1 SCHEDULE

Daily Check

- Loose mounting bolts or fasteners.
- Worn, frayed, cracked, or damaged wires.
- Damaged ON/OFF button
- Check and remove any off cuts or leftover material
- Any other condition that could hamper the safe operation of this machine

IMPORTANT

The rolls of the machine must NEVER be greased or lubricated. Because then the rolls will slip the material and will not bend. Always keep the rolls clean and free from grease or any lubricant. Also make sure that the material is free from grease and dirt.

SPARE PARTS SECTION

SECTION & TUBE ROLLING MACHINE

MODEL. RR-24

Order Code S682

EDITION No : RR-24-1

DATE OF ISSUE : 02/2022

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

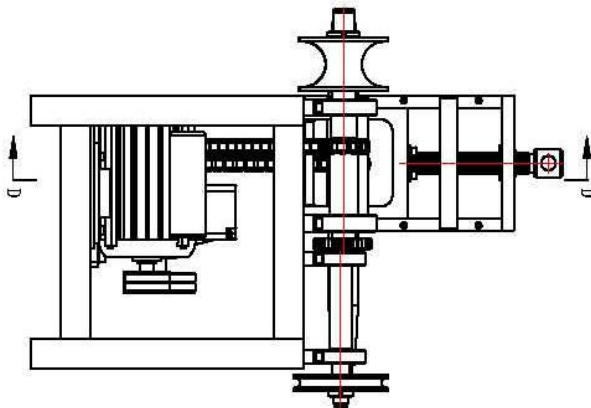
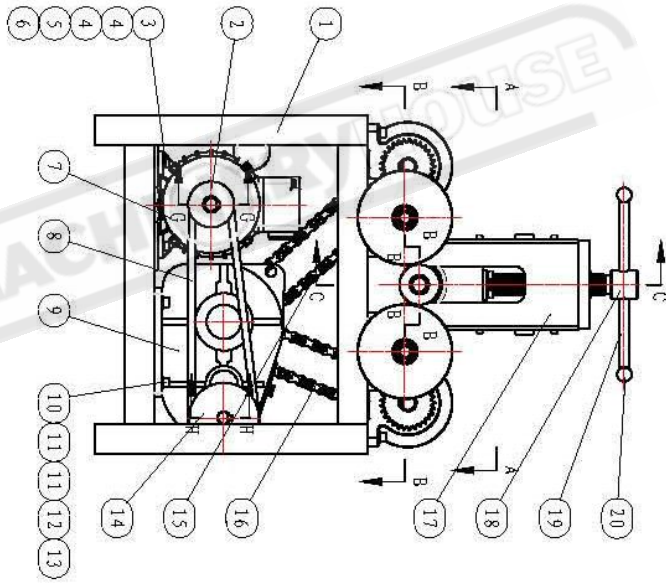
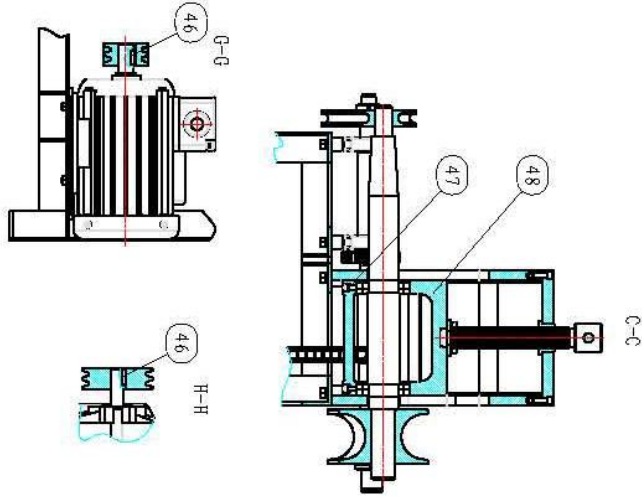
1. Have your machines model number, serial number & date of manufacture on hand, these can be found on the specification plate mounted on the machine
2. A scanned copy of your parts list/diagram with required spare part/s identified.

NOTE: SOME PARTS MAY ONLY BE AVAILABLE AS AN ASSEMBLY

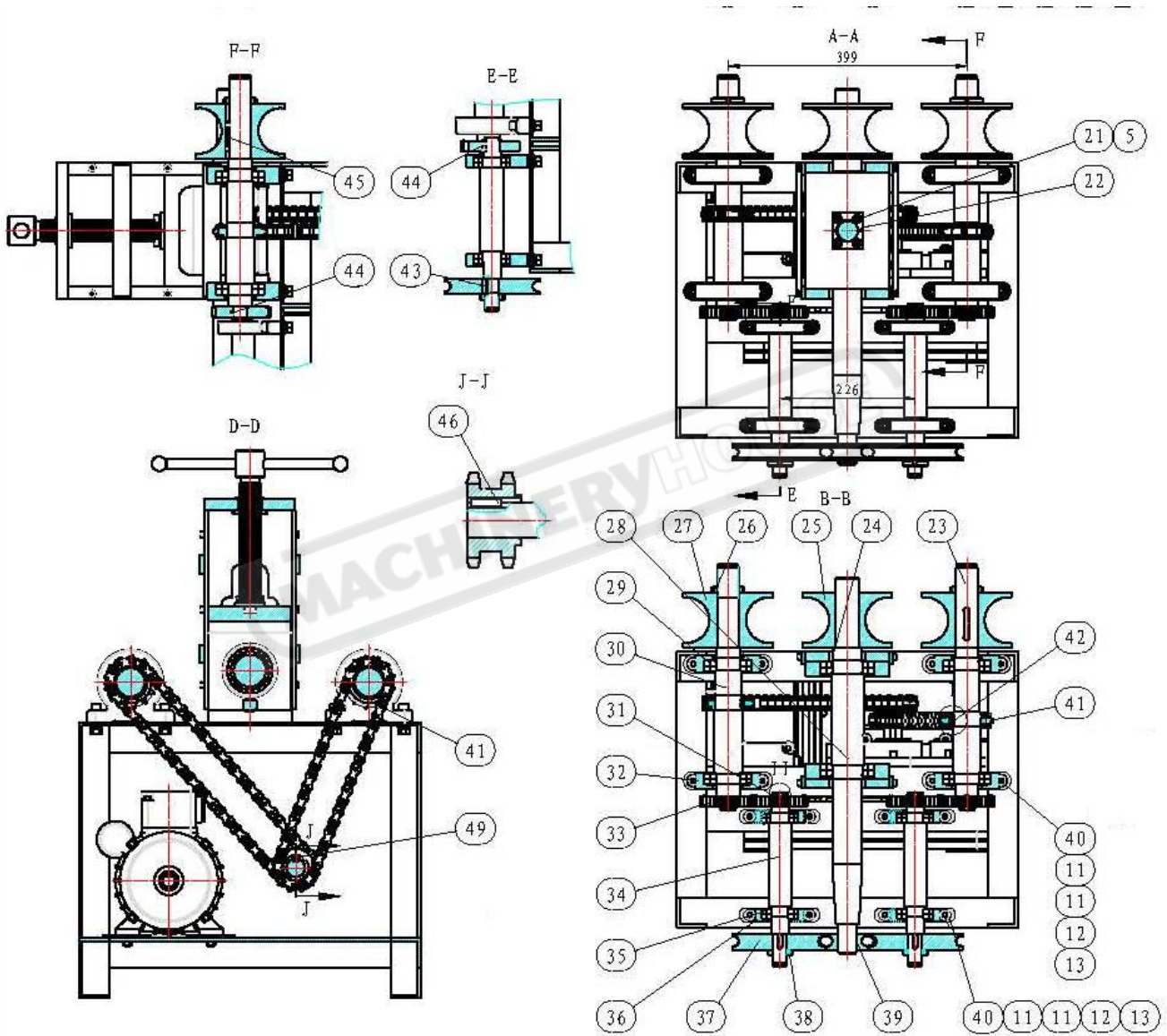
3. Go to www.machineryhouse.com.au/contactus and fill out the inquiry form attaching a copy of scanned parts list.

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

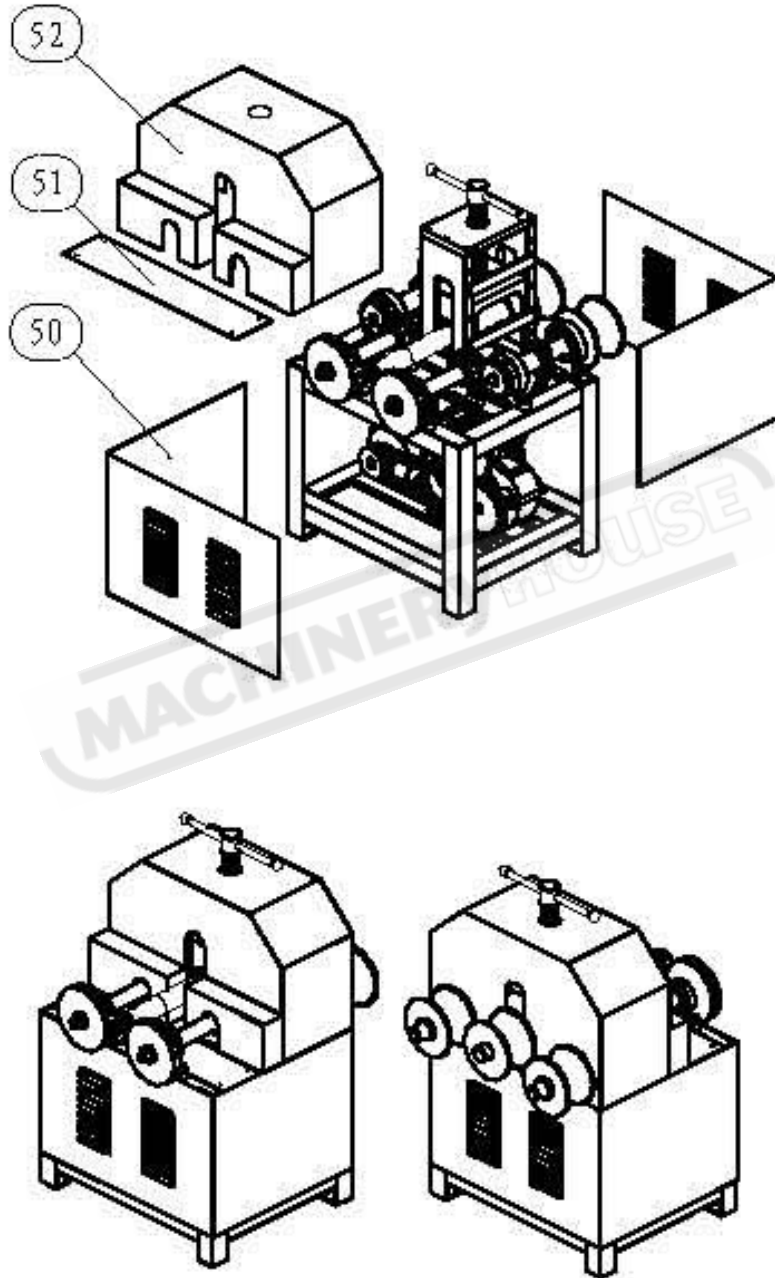
SPARE PARTS DIAGRAMS



SPARE PARTS DIAGRAMS



SPARE PARTS DIAGRAMS



SPARE PARTS LIST

No.	Part No.	Description	Qty
1	HHW-76B-001	Stand	1
2	HHW-76B-002	Small Pulley	1
3	GB/T70.1-2007	Screw M8x30	4
4	GB/T97.1-2002	Flat Washer M8	8
5	GB/T93-1987	Washer M8	8
6	GB/T 41-2000	Nut M8	4
7	YL90L-4	Motor	1
8	A940LI	Belt	2
9	J0Q150	Reducer	1
10	GB/T70.1-2007	Screw M10x30	4
11	GB/T97.1-2002	Flat Washer	40
12	GB/T93-1987	Washer	20
13	GB/T 41-2000	Nut M10	20
14	HHW-76B-003	Big Pulley	1
15		Chain	1
16		Chain	1
17	HHW-76B-004	Base	1
18	HHW-76B-005	Adjust Screw	1
19	HHW-76B-006	Handle	1
20		Handle Knob	2
21	GB/T70.1-2007	Screw	4
22	HHW-76B-007	Block	2
23	HHW-76B-008	Shaft	1
24	GB/T 276-1994	Bearing	2
25	HHW-76B-009	Wheel	1
26	GB/T 812-1988	Nut	2
27	HHW-76B-010	Wheel	2
28	HHW-76B-011	Shaft	1
29	GB/T 279-1994	Bearing	4
30	HHW-76B-012	Shaft	1
31	GB/T894.1-1986	Washer 25	4
32	HHW-76B-013	Bearing Base	4
33	HHW-76B-014	Gear	4
34	HHW-76B-015	Shaft	2
35	GB/T 276-1994	Bearing	4
36	HHW-76B-016	Bearing Base	4
37	HHW-76B-017	Wheel	2
38	GB/T 812-1988	Nut	2
39	HHW-76B-018	Wheel	1
40	GB/T70.1-2007	Screw M10x40	16

SPARE PARTS LIST

No.	Part No.	Description	Qty
41	HHW-76B-019	Chain Wheel	2
42	GB1096-79	Flat Pin 12x18	2
43	GB1096-79	Flat Pin 8x25	2
44	GB1096-79	Flat Pin 8x18	4
45	GB1096-79	Flat Pin 10x50	2
46	GB1096-79	Flat Pin 8x30	3
47	GB/T70.1-2007	Screw M8x15	2
48	HHW-76B-020	Block	1
49	HHW-76B-021	Chain Wheel	1
50	HHW-76B-022	Cover	2
51	HHW-76B-023	Plate	1
52	HHW-76B-024	Cover	1

MACHINERYHOUSE

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 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

Section Rolling Machine Safety Instructions

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

- 1. Maintenance.** Make sure the Section Rolling Machine 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. Section Rolling Machine Condition.** A Section Rolling Machine must be maintained for a proper working condition. Never operate a Section Rolling Machine that has damaged or worn parts. Scheduled routine maintenance should be performed on a scheduled basis.
- 3. Roll Condition.** Never operate a Section Rolling Machine 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.** Section Rolling Machine guards must be used at all times. Tie up long hair and use the correct hair nets to avoid any entanglement with the Section Rolling Machine 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 Section Rolling Machine 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 Section Rolling Machine without the correct guards in place. Necessary guards protect you from injuries by worm-type gearbox and other gears. 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. Several passes are needed 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 Section Rolling Machine 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 your nearest branch service department for help.

PLANT SAFETY PROGRAM

NEW MACHINERY HAZARD IDENTIFICATION, ASSESSMENT & CONTROL

Section Rolling 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	HIGH	Eliminate, avoid loose clothing / Long hair etc.
B	CRUSHING	LOW	Secure & support work material. Ensure machine is bolted down.
C	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:

[Signature]

Revised Date: 12th March 2012