



PPE Required: Safety Glasses, Face Shield

Prohibited Clothing: gloves, loose clothing, neckties, jewelry

Machine Access Level: Supervised Only

Materials Allowed: Metals

Note: Metals only on this machine!

Operating Procedure

1. Machine Safety Inspection and Work Area Check-Out

- A. **PPE:** Make sure you are wearing the proper PPE and not wearing any equipment listed on the first page that could get caught in the machine.
- B. **Machine Warning Signs:** Make sure you read and follow the machine warning signs that are attached to the machine. If you have any questions, ASK!!
- C. **Work Area:** Make sure the work area is clean and the work area around the machine is free and clear of debris and personnel.

2. Work Supervision

- A. This machine requires supervision by an AFL employee. A Supervisor or TA will assist you in the set-up and operation of the machine. **You may not operate this machine without supervision.**

3. Machine Adjustment

- A. **Note:** The machine adjustment is to be done with the machine **OFF!**
- B. **Check materials:** Do not attempt to cut/ shear, Punch or bend any hard materials or materials that you know have been hardened, stress or heat treated. **This could hurt you and/or the machine.**
- C. **Check blade condition:** Make sure the blade is in good condition. **If the blade appears dull, see the AFL supervisor.**
- D. **Secure the part:** Make sure the work is supported on both ends. **Do NOT let the end you are cutting off fall on the floor or your foot.** Make sure that the piece you are cutting is clamped down well before you begin to make your cut. You will only be able to clamp flat parts. **All others you will have to hold by hand. Do not touch the blade when the machine is in operation.**
- E. **Identify the machine controls:** Identify the on/off switch located on the hydraulic pump on back of the Iron Worker. These controls start and stop the hydraulics of the iron worker. Locate the hydraulic control arm on the front of the Iron Worker, this will control the Iron Worker stroke up and down.

4. Machine Operation

- A. **Turn the machine on:** Check with the TA that it is safe to turn on the machine, and turn the on/off switch to ON to turn on the hydraulics.
- B. **Insert the part:** Into the brake, sheer, or notching tool.
- C. **Raise and lower the Arm:** By using the Up/Down Lever. **Go slow! Always keep hands and fingers away from the sheer.** Use the clamps to hold material whenever possible. Ask the TA for help.
- D. **Turn the machine off:** When finished with the cut, bend, or punch, switch the on/off switch to OFF to shut down the hydraulics.

5. Clean Up

- A. **Disassemble work set up:** disassemble any fixturing used in the process. Return the appearance of the machine to how it looked when you started.
- B. **Clean up the area:** Clean up all messes. The TA will check that the area is clean before you can sign-out of the AFL.