WESTERN School Division
Morden, Manitoba
"Rooted In Caring; Committed to Learning"

Job Hazard Analysis (Drilling/Iron worker machine)

Analysis by: Riaan Strydom
Reviewed by: **Approved by:**

Department: Welding
Date: June, 2019

Possible Hazards or Task	Describe Harm that could occur	Hazard Rating (Low/ Medium/High)	Control Action	Personal Protective Equipment (PPE)	Frequency of Monitoring
Sharp cutters Moving components hair/clothing entanglement Eye injury Skin irritation Metal splinters and burrs Flying debris	Cuts, lacerations and amputations. Projectile work pieces from improper clamping.	Medium	1. Ensure no slip/trip hazards are present in workspaces and walkways. 2. Locate and ensure you are familiar with the operation of the ON/OFF starter and E-Stop (if fitted). 3. Do not leave equipment on top of the machine. 4. Check that machine guards are in position. 5. Ensure cutter is in good condition and securely mounted. 6. Check coolant delivery system to allow for sufficient flow of coolant. 7. Faulty equipment must not be used. Immediately report suspect machinery.	Safety glasses must be worn at all times in work areas. Rings and jewellery must not be worn. Long and loose hair must be contained. Gloves must not be worn when using this machine.	Annually unless the equipment is modified, task performed change, or procedure changes.

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			1. Keep clear of moving machine parts. 2. Never leave the machine running unattended. 3. Follow correct clamping procedures- keep overhangs as small as possible and check work piece is secure. 4. Set the correct speed to suit the cutter diameter, the depth of cut and the material. 5. Before making adjustments and measurements or before cleaning swarf accumulations switch off and bring the machine to a complete standstill.	CSA footwear must be worn at all times in work areas.	
			1. Switch off the machine. 2. Remove milling cutters and store them safely. 3. Leave the machine and work area in a safe, clean and tidy state.	Close fitting/protective clothing must be worn.	

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			IRONWORKER SAFETY & OPERATING PROCEDURES **A. SAFETY:** 1. Your foot must be completely removed from the pedal box after completing each cut, on machines, which are not equipped light curtains or other safe guards. 2. Use proper shutdown procedures when changing punches, dies, blades, or shims. Shut off the main power and have the key, (switch) in off position when changing punches and dies. 3. Make sure all guards are in place and that all table adjustment bolts are tight. 4. Don't ever try to grab a piece as it is being cut. Remove small pieces from the blade area with a hook, never your fingers. 5. Don't run the shear on 'automatic' unless you are properly trained by your FLS or area designate. 6. Turn the main power off when leaving the machine unattended.		

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			7. **Never** put your hands near a Hazardous area or Pinch Point, if a part is too large to sit on the ironworker table without your assistance. Only hold the part if your hands are completely off the ironworker table and no body part could be susceptible to injury. **B. OPERATION:** 1. After changing punches, dies, blades or shims, lower the punch/ shear by hand (or jog) to check the clearance and alignment. **Note: Most Ironworker Manufacturers recommend Punch and Die alignment is checked before each set-up and periodically throughout longer runs.** **Before** installing a Punch or a Die into the Ironworker, they must be **slipped checked**. Failure to do so could cause tooling damage and/or personal injury. 2. Always adjust material hold-downs to allow material to just slide under before attempting to shear. Don't allow		

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			more than 1/8" clearance between the material and the hold-down clamp. Check to confirm proper blade clearance (use feeler gauges). 3. Never put material in from the backside of the shear. Always cut from the roller table side making sure the material is under the hold-down. 4. Don't attempt to shear off a piece of material shorter than its thickness. 5. Don't cut pieces that have less than ½" under the hold-down. 6. STRIPPER a) Use proper size stripper insert or plate. b) Punch depth must be set to avoid stripper damage. c) Make sure stripper is fully engaged and tightened before operation.		