



## Working with the press brake

### 1. Purpose

The purpose of these safety instructions is to ensure that, having read the instructions, the employee is aware of the risks associated with the described work activities and can perform them safely.

### 2. General

- It is prohibited to be on, behind or in the machine while it is operational.
- Machine safety devices which are provided must never be removed or rendered inoperative. Never leave any keys near the corresponding lock.
- The stop points must **NEVER** be adjusted from the front (by reaching between the upper and lower beams).
- The operating panel may not be used as storage or support for the workpiece (to ensure that the emergency stop remains accessible).
- The operating personnel must wear proper, close-fitting clothing, safety shoes and work gloves.
- During maintenance the switch must be in the **OFF position** and locked with a padlock.
- Fences at the sides and rear of the machine must be closed.
- When in doubt, never continue; go discuss the situation with the foreman.

### 3. Measures

The following is the sequence to be followed when adjusting the press brake. Naturally this depends on the product; that is what ultimately determines what you can or cannot do.

#### Working just with foot pedal

- 1) Use light curtain

When used without light curtain:

- 2) Gap opening of max. 6 mm
  - If necessary, adjust the length of the upper blade (the product can be moved sideways if necessary)
  - Prevent risk of crushing between the product and the side of the blade
 Adjust the angle of the blade if necessary

- 3) The opening must be greater

- Folding speed (slow speed) <10 mm/sec
- or
- The distance from both hands to the slit opening (crushing location) is >30 cm
- No hands on the sides of the workpiece

This applies to both operators (if two are present).

If none of these methods are feasible, because of the type of product being bent or the type of press brake, consult with the foreman.

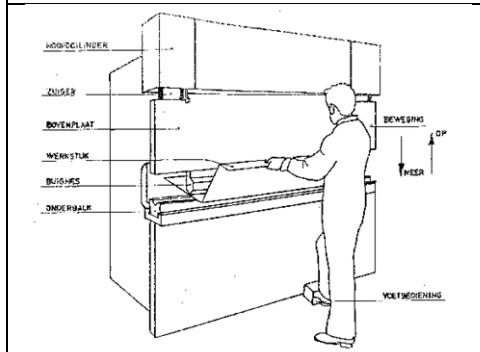
#### Risks

- Crushing between punch blade and die
- Crushing between product and press brake
- Crushing from the side
- Crushing from the back

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### 4. Picture



### 5. Pictograms



### 6. Required PPE



- Make sure all guards are present
- During maintenance the switch must always be in the **OFF position** and locked with a padlock.
- Read the instructions first
- Use light curtain



- Machine safety devices which are provided must never be removed or rendered inoperative. **NEVER** leave any keys near the corresponding lock.
- The stop points must always be adjusted from the rear. This must never be done from the front, because doing so would put you in the crush zone.

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