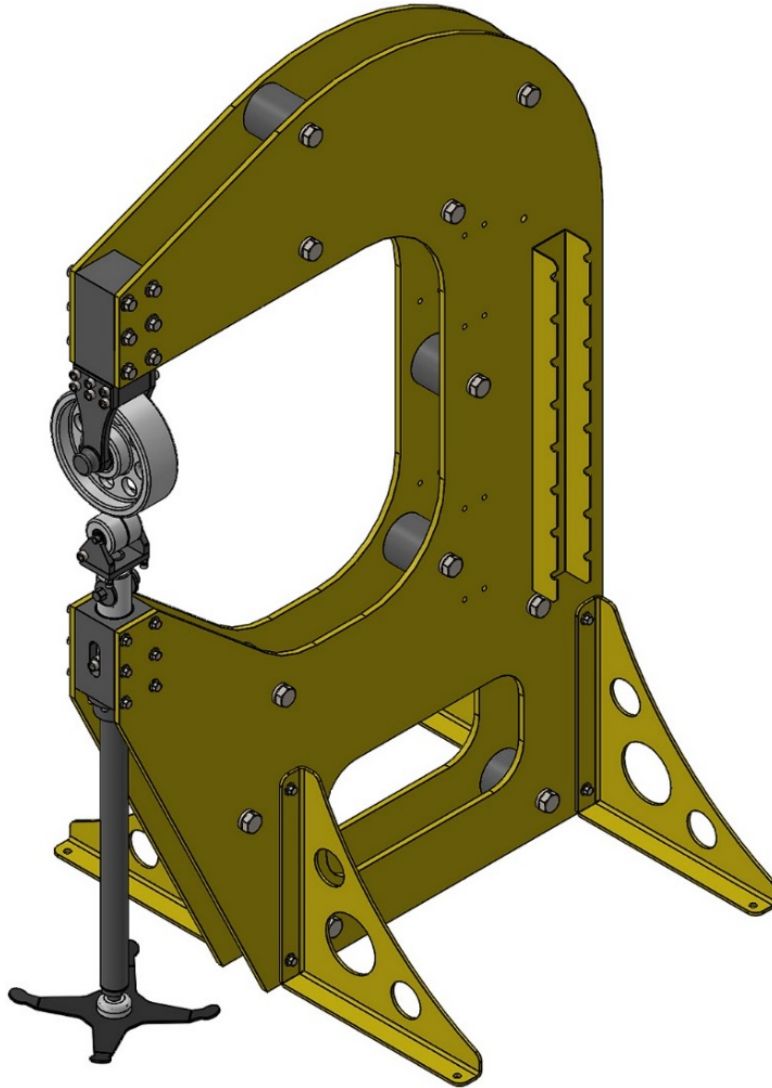




OPERATOR'S MANUAL

Metal Working



ENGLISH WHEEL MODEL: EW-30 (B8870)

www.machineryhouse.com.au



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INTRODUCTION

The quality and reliability of the components assembled on a Baileigh Industrial machine guarantee near perfect functioning, free from problems, even under the most demanding working conditions. However if a situation arises, refer to the manual first. If a solution cannot be found, contact the distributor where you purchased our product. Make sure you have the serial number and production year of the machine (stamped on the nameplate). For replacement parts refer to the assembly numbers on the parts list drawings.

Our technical staff will do their best to help you get your machine back in working order.

In this manual you will find: (when applicable)

- Safety procedures
- Correct installation guidelines
- Description of the functional parts of the machine
- Capacity charts
- Set-up and start-up instructions
- Machine operation
- Scheduled maintenance
- Parts lists

GENERAL NOTES

After receiving your equipment remove the protective container. Do a complete visual inspection, and if damage is noted, **photograph it for insurance claims** and contact your carrier at once, requesting inspection. Also contact your distributor and inform them of the unexpected occurrence. Temporarily suspend installation.

Take necessary precautions while loading / unloading or moving the machine to avoid any injuries.

Your machine is designed and manufactured to work smoothly and efficiently. Following proper maintenance instructions will help ensure this. Try and use original spare parts, whenever possible, and most importantly; **DO NOT** overload the machine or make any unauthorized modifications.



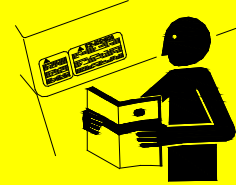
Note: This symbol refers to useful information throughout the manual.



IMPORTANT

PLEASE READ THIS OPERATORS MANUAL CAREFULLY

It contains important safety information, instructions, and necessary operating procedures. The continual observance of these procedures will help increase your production and extend the life of the equipment.



SAFETY INSTRUCTIONS

LEARN TO RECOGNIZE SAFETY INFORMATION

This is the safety alert symbol. When you see this symbol on your machine or in this manual, **BE ALERT TO THE POTENTIAL FOR PERSONAL INJURY!**



Follow recommended precautions and safe operating practices.

UNDERSTAND SIGNAL WORDS

A signal word – **DANGER**, **WARNING**, or **CAUTION** is used with the safety alert symbol. **DANGER** identifies a hazard or unsafe practice that will result in severe **Injury or Death**.



Safety signs with signal word **DANGER** or **WARNING** are typically near specific hazards.



General precautions are listed on **CAUTION** safety signs. **CAUTION** also calls attention to safety messages in this manual.

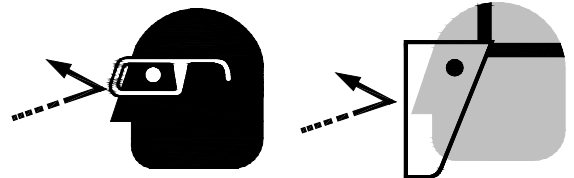


SAVE THESE INSTRUCTIONS.
Refer to them often and use them to instruct others.



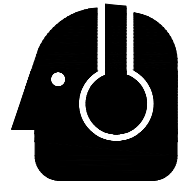
PROTECT EYES

Wear safety glasses or suitable eye protection when working on or around machinery.



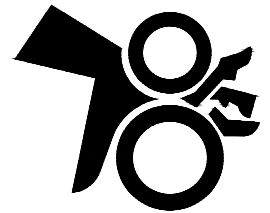
PROTECT AGAINST NOISE

Prolonged exposure to loud noise can cause impairment or loss of hearing. Wear suitable hearing protective devices such as ear muffs or earplugs to protect against objectionable or uncomfortable loud noises.



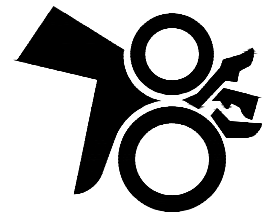
BEWARE OF CRUSH HAZARD

NEVER place your hands, fingers, or any part of your body in the die area of this machine.



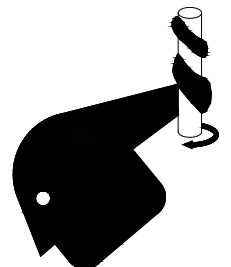
BEWARE OF PINCH POINTS

Keep hands and fingers away from the rolls when the machine is in operation.



ENTANGLEMENT HAZARD – ROTATING SPINDLE

Contain long hair, **DO NOT** wear jewelry or loose fitting clothing.





SAFETY PRECAUTIONS



Metal working can be dangerous if safe and proper operating procedures are not followed. As with all machinery, there are certain hazards involved with the operation of the product. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result.

Safety equipment such as guards, hold-downs, safety glasses, dust masks and hearing protection can reduce your potential for injury. But even the best guard won't make up for poor judgment, carelessness or inattention. **Always use common sense** and exercise **caution** in the workshop. If a procedure feels dangerous, don't try it.

REMEMBER: Your personal safety is your responsibility.



WARNING: FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS PERSONAL INJURY

Dear Valued Customer:

- All Baileigh machines should be used only for their intended use.
- Baileigh does not recommend or endorse making any modifications or alterations to a Baileigh machine. Modifications or alterations to a machine may pose a substantial risk of injury to the operator or others and may do substantial damage to the machine.
- Any modifications or alterations to a Baileigh machine will invalidate the machine's warranty.

PLEASE ENJOY YOUR BAILEIGH MACHINE! ...PLEASE ENJOY IT SAFELY!

1. **FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE MACHINE.** Learn the machine's application and limitations as well as the specific hazards.
2. **Only trained and qualified personnel can operate this machine.**
3. **Make sure guards are in place and in proper working order before operating machinery.**
4. **Remove any adjusting tools.** Before operating the machine, make sure any adjusting tools have been removed.
5. **Keep work area clean.** Cluttered areas invite injuries.
6. **Overloading machine.** By overloading the machine you may cause injury from flying parts. **DO NOT** exceed the specified machine capacities.



7. **Dressing material edges.** Always chamfer and deburr all sharp edges.
8. **Do not force tool.** Your machine will do a better and safer job if used as intended. **DO NOT** use inappropriate attachments in an attempt to exceed the machines rated capacity.
9. **Use the right tool for the job. DO NOT** attempt to force a small tool or attachment to do the work of a large industrial tool. **DO NOT** use a tool for a purpose for which it was not intended.
10. **Dress appropriate. DO NOT** wear loose fitting clothing or jewelry as they can be caught in moving machine parts. Protective clothing and steel toe shoes are recommended when using machinery. Wear a restrictive hair covering to contain long hair.
11. **Use eye and ear protection.** Always wear ISO approved impact safety goggles. Wear a full-face shield if you are producing metal filings.
12. **Do not overreach.** Maintain proper footing and balance at all times. **DO NOT** reach over or across a running machine.
13. **Stay alert.** Watch what you are doing and use common sense. **DO NOT** operate any tool or machine when you are tired.
14. **Check for damaged parts.** Before using any tool or machine, carefully check any part that appears damaged. Check for alignment and binding of moving parts that may affect proper machine operation.
15. **Observe work area conditions. DO NOT** use machines or power tools in damp or wet locations. Do not expose to rain. Keep work area well lighted.
16. **Keep children away.** Children must never be allowed in the work area. **DO NOT** let them handle machines, tools, or extension cords.
17. **Store idle equipment.** When not in use, tools must be stored in a dry location to inhibit rust. Always lock up tools and keep them out of reach of children.
18. **DO NOT operate machine if under the influence of alcohol or drugs.** Read warning labels on prescriptions. If there is any doubt, **DO NOT** operate the machine.
19. Keep visitors a safe distance from the work area.



TECHNICAL SPECIFICATIONS

Mild Steel Capacity	14ga. (1.897mm)
Aluminum Capacity (Soft)	.125" (3.175mm)
Throat Depth	30" (762mm)
Top Wheel Dimensions	10" x 3" (254 x 76.2mm)
Lower Die Edge Radius	Flat, 36", 24", 12", 8", 6", 4", and 2" (Flat, 914, 610, 305, 203, 152, 102, and 51mm)
Power	Manual
Shipping Dimensions	48" x 48" x 84" (1220 x 1220 x 2134mm)
Shipping Weight	900lbs. (409kg)



Note: *The photos and illustrations used in this manual are representative only and may not depict the actual color, labeling or accessories and may be intended to illustrate technique only.*



Note: *The specifications and dimensions presented here are subject to change without prior notice due to improvements of our products.*



UNPACKING AND CHECKING CONTENTS

Your Baileigh machine is shipped complete in one crate. Separate all parts from the packing material and check each item carefully. Make certain all items are accounted for before discarding any packing material.

⚠ WARNING: SUFFOCATION HAZARD! Immediately discard any plastic bags and packing materials to eliminate choking and suffocation hazards to children and animals.
If any parts are missing, do not plug in the power cable, or turn the power switch on until the missing parts are obtained and installed correctly.

Cleaning

⚠ WARNING: DO NOT USE gasoline or other petroleum products to clean the machine. They have low flash points and can explode or cause fire.

⚠ CAUTION: When using cleaning solvents work in a well-ventilated area. Many cleaning solvents are toxic if inhaled.

Your machine may be shipped with a rustproof waxy coating and/or grease on the exposed unpainted metal surfaces. Fully and completely remove this protective coating using a degreaser or solvent cleaner. Moving items will need to be moved along their travel path to allow for cleaning the entire surface. For a more thorough cleaning, some parts will occasionally have to be removed. **DO NOT USE** acetone or brake cleaner as they may damage painted surfaces.

Follow manufacturer's label instructions when using any type of cleaning product. After cleaning, wipe unpainted metal surfaces with a light coating of quality oil or grease for protection.



Important: This waxy coating is **NOT** a lubricant and will cause the machine to stick and lose performance as the coating continues to dry





TRANSPORTING AND LIFTING



IMPORTANT: *Lifting and carrying operations should be carried out by skilled workers, such as a truck operator, crane operator, etc. If a crane is used to lift the machine, attach the lifting chain carefully, making sure the machine is well balanced.*

Follow these guidelines when lifting with truck or trolley:

- The lift truck must be able to lift at least 1.5 – 2 times the machines gross weight.
- Make sure the machine is balanced. While transporting, avoid rough or jerky motion, and maintain a safe clearance zone around the transport area.
- Use a fork lift with sufficient lifting capacity and forks that are long enough to reach the complete width of the machine.
- Remove the securing bolts that attach the machine to the pallet.
- Approaching the machine from the side, lift the machine on the frame taking care that there are no cables or pipes in the area of the forks.
- Move the machine to the required position and lower gently to the floor.
- Level the machine so that all the supporting feet are taking the weight of the machine and no rocking is taking place.

Follow these guidelines when lifting crane or hoist:

- Always lift and carry the machine with the lifting holes provided at the top of the machine.
- Use lift equipment such as straps, chains, capable of lifting 1.5 to 2 times the weight of the machine.
- Take proper precautions for handling and lifting.
- Check if the load is properly balanced by lifting it an inch or two.
- Lift the machine, avoiding sudden accelerations or quick changes of direction.
- Locate the machine where it is to be installed, and lower slowly until it touches the floor.



INSTALLATION

IMPORTANT:

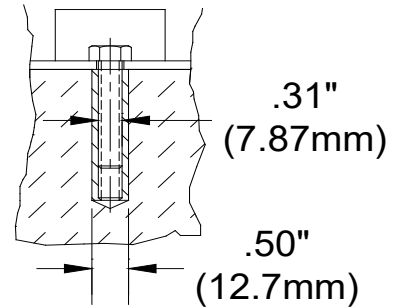
Consider the following when looking for a suitable location to place the machine:

- Overall weight of the machine.
- Weight of material being processed.
- Sizes of material to be processed through the machine.
- Space needed for auxiliary stands, work tables, or other machinery.
- Clearance from walls and other obstacles.
- Maintain an adequate working area around the machine for safety.
- Have the work area well illuminated with proper lighting.
- Keep the floor free of oil and make sure it is not slippery.
- Remove scrap and waste materials regularly, and make sure the work area is free from obstructing objects.
- If long lengths of material are to be fed into the machine, make sure that they will not extend into any aisles.
- **LEVELING:** The machine should be sited on a level, concrete floor. Provisions for securing it should be in position prior to placing the machine. The accuracy of any machine depends on the precise placement of it to the mounting surface.
- **FLOOR:** This tool distributes a large amount of weight over a small area. Make certain that the floor is capable of supporting the weight of the machine, work stock, and the operator. The floor should also be a level surface. If the unit wobbles or rocks once in place, be sure to eliminate by using shims.
- **WORKING CLEARANCES:** Take into consideration the size of the material to be processed. Make sure that you allow enough space for you to operate the machine freely.



Anchoring the Machine

- Once positioned, anchor the machine to the floor, as shown in the diagram. Use bolts and expansion plugs or sunken tie rods that connect through and are sized for the holes in the base of the stand.
- This machine requires a solid floor such as concrete at a minimum of 4" (102mm) thick. 6" (153mm) minimum is preferred.



GETTING TO KNOW YOUR MACHINE

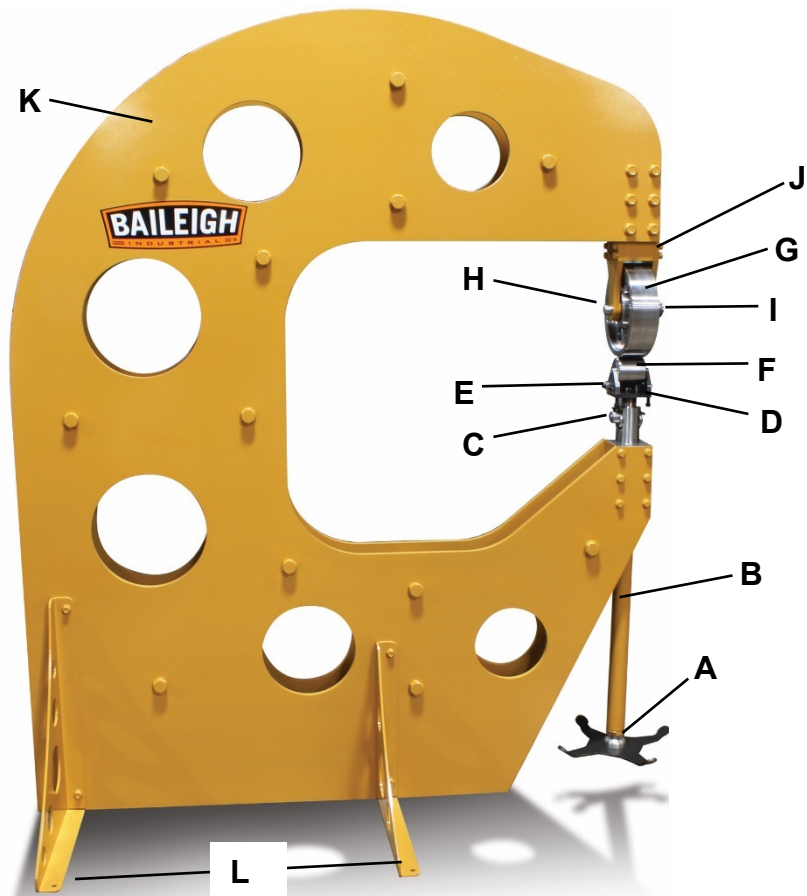
The English wheel stretches metal workpieces thinner and longer as they are rolled between the upper wheel and lower wheel.

Simultaneously, a track is pressed into the metal, creating a convex curve in the workpiece. By varying the amount and pattern of the tracks, a wide variety of contours can be produced.

The English wheel can be used to produce curves in mild steel up to 10ga. (3.416mm) and aluminum up to .125" (3.175mm).



Note: Stock photo.



Item	Description
A	Kick Wheel
B	Lower Wheel Assembly
C	Quick Release Lever
D	Lower Wheel Bracket



E	Lower Wheel Axle
F	Lower Wheel
G	Upper Wheel
H	Upper Axle Latch
I	Upper Wheel Axle
J	Upper Wheel Bracket
K	Frame
L	Mounting Plates
	Wheel Storage Bracket (Opposite side)

MATERIAL SELECTION

⚠ CAUTION: It must be determined by the customer that materials being processed through the machine are NOT potentially hazardous to operator or personnel working nearby.

When selecting materials keep these instructions in mind:

- Material must be clean and dry. (without oil)
- Material should have a smooth surface so it processes easily.
- Dimensional properties of material must be consistent and not exceed the machine capacity values.
- Chemical structure of material must be consistent.
- Buy certificated steel from the same vendor when possible.

OPERATION

⚠ CAUTION: Always wear proper eye protection with side shields, safety footwear, and leather gloves to protect from burrs and sharp edges. Keep hands and fingers clear of the rollers. When handling large heavy sheets make sure they are properly supported.

1. Clean the workpiece and wheels thoroughly, making sure any abrasive particles are removed. Grit or dirt will mar your workpiece and even damage the wheels.
2. Dull sharp edges with a deburring tool and put on a pair of leather gloves to prevent injury to your hands.



3. Turn the upper wheel knob clockwise to raise the upper wheel bracket against the frame bracket.



Note: Make sure the upper wheel bracket and frame bracket edges are parallel so they slide past each other when raising the upper wheel bracket. If not, they may bind.

4. Check the distance between the bottom of the upper wheel and top of the lower wheel. They should be about an inch apart. To adjust the distance, rotate the kick wheel to lower or raise the lower wheel.
5. Engage the quick release lever to raise the lower wheel to the operating position. The button head cap screw on the cam should rest against the bottom of the lower wheel bracket.
6. Insert the workpiece between the wheels.
7. Rotate the kick wheel counterclockwise until there is light pressure on the workpiece.
8. Roll the workpiece up to an edge, rotate it slightly, then pull it back.
9. Turn the kick wheel counterclockwise to increase pressure on the workpiece; turn the kick wheel clockwise to decrease pressure.

To reinsert a workpiece or insert another workpiece of the same thickness, use the quick release lever.

ROLLING TIPS

PRACTICE AND PATIENCE. An English wheel is a simple tool that is easy to start to use however, it is the type of tool that requires experience to master.

When an operator keeps in mind a few safety considerations as noted in the front of the manual they can create and form metal to almost any shape.



CAUTION: Always wear proper eye protection with side shields, safety footwear, and leather gloves to protect from burrs and sharp edges.

Keep hands and fingers clear of the rollers.

When handling large heavy sheets make sure they are properly supported.

They can use the following tips to learn to operate the English wheel more successfully:

- Clean the workpiece and wheels; making sure all grit is removed.
- Start rolling slowly and increase your speed.
- Try rolling the wheels up to, but not past the workpiece edge.



- Mark the workpiece with a non-permanent marker to make it easier to follow tracking patterns or contour the metal.
- Try using the lightest wheel pressure possible to shape the workpiece. Too much pressure will crease or ruin the metal.
- Light pressure is best for smoothing; higher pressure is best for rough shaping.
- Consistent patterns and movements generally return consistent results.

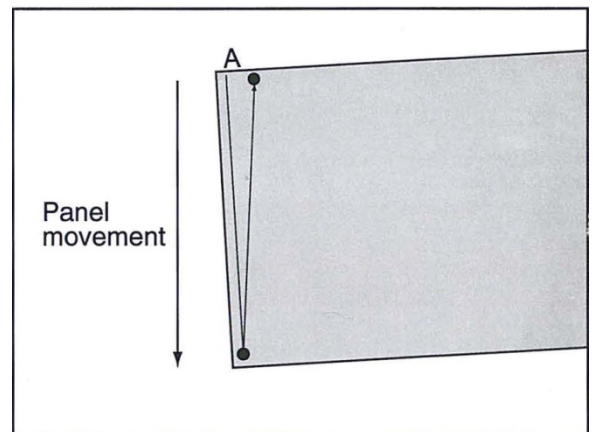
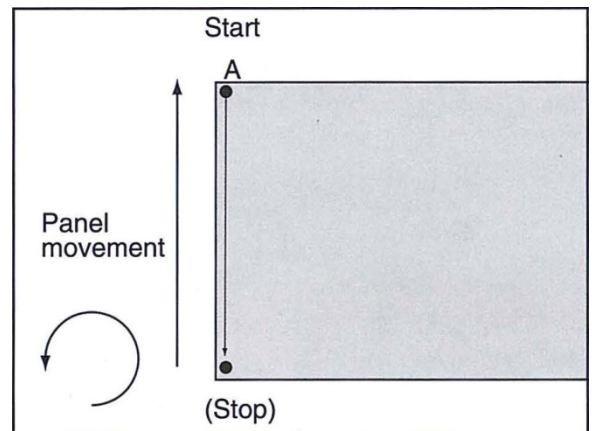
Tracking Patterns

As metal passes between the upper and lower wheels, a "track" or shiny line is pressed into the metal. Various tracking patterns can be used to shape workpieces depending upon their shape or size.

Zigzag Pattern

This pattern uses closely-spaced tracks to move from one end of the material to the other. It can be used for a variety of workpiece shapes.

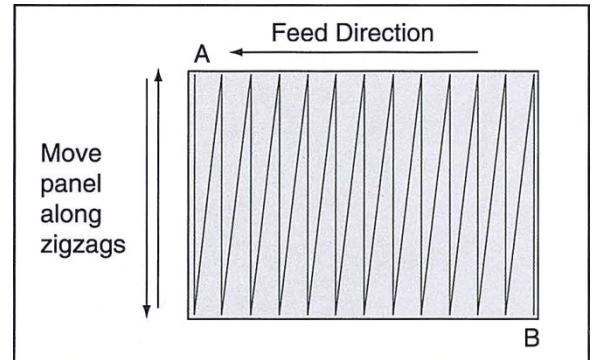
1. Insert the workpiece between the wheels at point A, and start rolling it along the edge. Left edge shown.
2. Push the workpiece forward to the stop point.
3. Turn the workpiece counterclockwise slightly.
4. Pull the workpiece back until it reaches the next point near the far edge.
5. Turn the workpiece clockwise slightly.
6. Continue feeding the workpiece to the other side in the same manner, following the pattern as shown.



Note: Try keeping the tracks close to each other.



7. When the wheels reach point B, feed the workpiece in the opposite direction and return to point A.

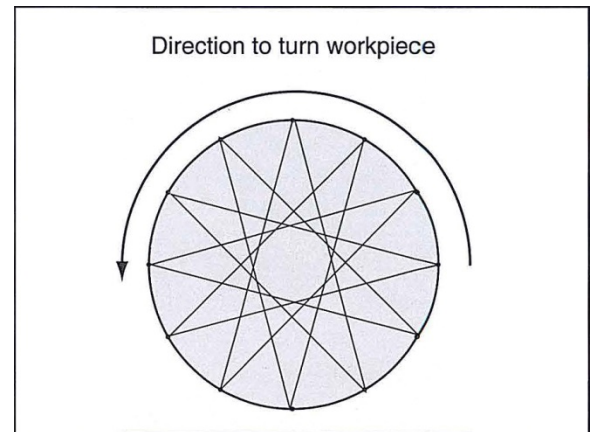


Star Pattern

The star pattern is useful for shaping round workpieces.



Note: Avoid rolling directly over the center of the workpiece, as too many passes could overstretch the metal.





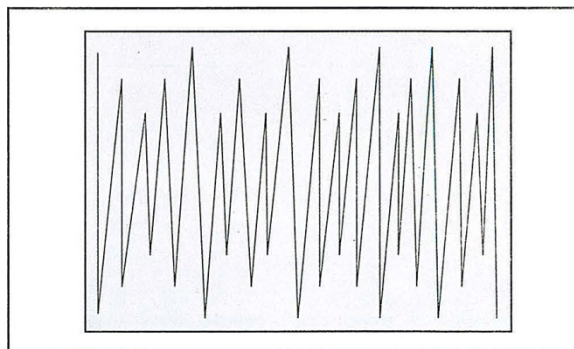
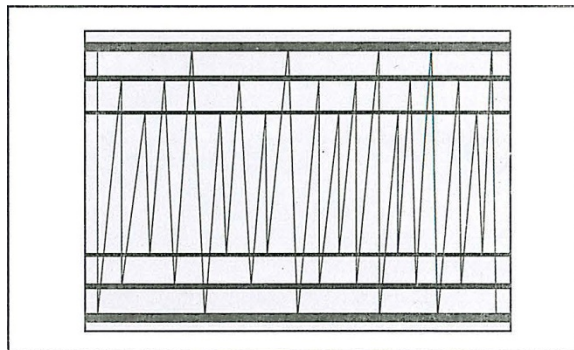
Staggered Stop Pattern

With this pattern, the track alternates randomly between three different sets of lines.



Note: Marking the workpiece with a non-permanent marker so you can see the outside, middle and inside lines more clearly. Clean the wheels and workpiece when you are finished.

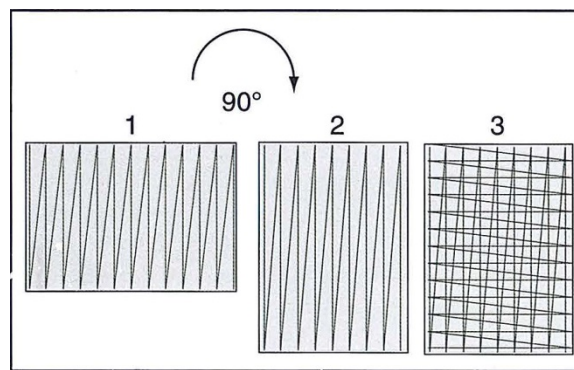
1. From the starting point, roll the workpiece from the outside line on one side to the outside line on the opposite side.
2. Roll the workpiece from the middle line on one side to the middle line on the opposite side.
3. Roll the workpiece from the inside line on one side to the inside line on the opposite side.
4. Repeat Steps 1-3, as you move across the workpiece, randomly alternating between outside, middle, and inside lines.



Crisscrossing Tracks

Crisscrossing tracks can help produce smoother curves in your workpiece using the zigzag or staggered stop pattern.

After running tracks along one length of the workpiece, turn the metal sheet 90° and run tracks along the opposite length so the workpiece is equally covered by both sets of tracks.





Selecting Lower Wheels

Choose a lower wheel that will produce the contour you desire.

Flat lower wheels are good for adding gentle curves to large metal panels; these wheels have wide flat surfaces profiles

Domed lower wheels create tighter curves. The flat areas range from 1/8" to 3/4" (3.175 to 19.05mm). The wider the flat area, the wider the track produced on the workpiece.

Roll a workpiece between a grooved lower wheel and a ridged upper wheel to emboss metal.

The step roller can be used with the flat upper wheel to add a small crease in a metal panel.



MACHINE ADJUSTMENTS

Wheel Replacement

A flat upper and lower wheel are preinstalled on the English wheel. The lower wheel can be replaced with any of the other lower wheel wheels.



Important: Hold an upper wheel securely when installing or removing it or it may fall causing injury or damage! Wear steel toe foot-wear to protect your feet.

Upper Wheel Replacement

1. Raise the lower wheel until the top lightly touches the bottom of the upper wheel. This help to supply some support to the upper wheel.
2. Remove the cotter pin from the inside of the upper wheel axle.
3. Hold the upper wheel firmly to prevent dropping and remove the upper wheel axle.
4. Carefully remove the upper wheel and set it on the upper wheel rack using a bracket mounting shaft.
5. Place a different upper wheel into the upper wheel bracket.



Note: Adjust the lower wheel height as needed to allow the upper wheel to fit into the upper wheel bracket.

6. Align the bracket and wheel bearing holes, insert the axle, and rotate the latch to secure the wheel.

Lower Wheel Replacement

1. Use a wrench to disengage the quick release cam and lower the lower wheel bracket until it stops.
2. Remove the lower wheel and replace it with another one.
3. Engage the quick release lever and raise the lower wheel to the operating position.



LUBRICATION AND MAINTENANCE

⚠ WARNING: Maintenance should be performed on a regular basis by qualified personnel. Always follow proper safety precautions when working on or around any machinery.

- Check daily for any unsafe conditions and fix immediately.
- Check that all nuts and bolts are properly tightened.
- On a weekly basis clean the machine and the area around it.
- Lubricate threaded components and sliding devices.
- Apply rust inhibitive lubricant to all non-painted surfaces.



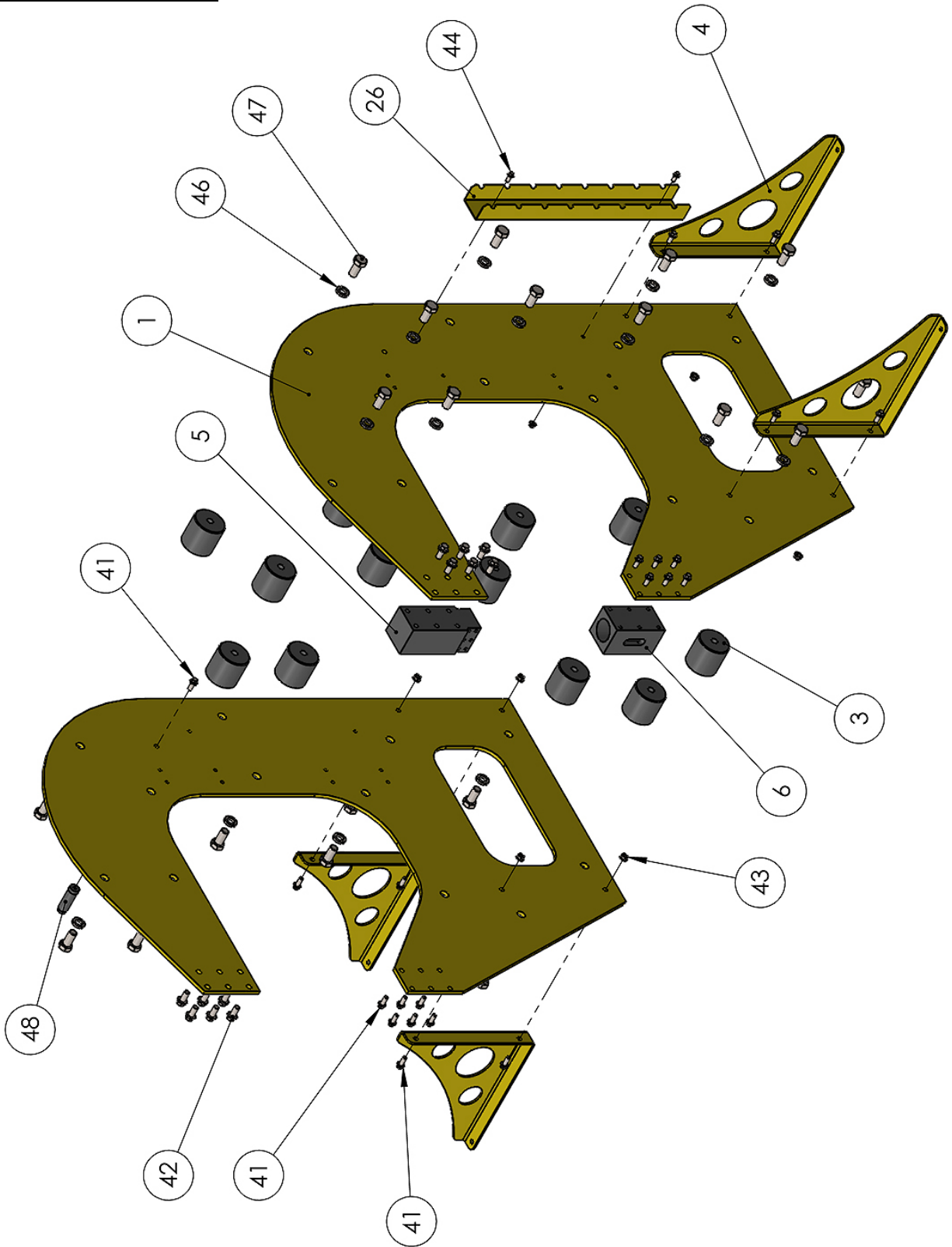
Note: Proper maintenance can increase the life expectancy of your machine.

TROUBLESHOOTING

Symptom	Possible Cause	Possible Solution
Quick release lever will not engage, or has trouble engaging.	<ol style="list-style-type: none"> 1. Lower wheel bracket and cams bind. 2. Setscrews on cams loose and not contacting quick release lever flats. 	<ol style="list-style-type: none"> 1. Lubricate top of cams where they contact the bracket 2. Align setscrews over lever flats and tighten
Upper wheel swivels.	<ol style="list-style-type: none"> 1. Upper wheel is not secured by frame bracket. 	<ol style="list-style-type: none"> 1. Turn upper wheel knob clockwise to raise upper wheel bracket so it is snug against frame bracket.
Wheel does not shape workpiece.	<ol style="list-style-type: none"> 1. Workpiece is too thick. 2. Crown is too low. 3. Incorrect pressure. 	<ol style="list-style-type: none"> 1. Use sheet metal of appropriate thickness. 2. Use a lower wheel with a higher crown. 3. Increase pressure on workpiece.
Upper wheel bracket will not seat against frame.	<ol style="list-style-type: none"> 1. Upper wheel bracket catches on frame bracket; surfaces are not parallel. 	<ol style="list-style-type: none"> 1. Align upper wheel and upper frame bracket surfaces and raise upper wheel bracket up to frame.
Wheels form too high a crown in workpiece.	<ol style="list-style-type: none"> 1. Using lower wheel with too small a flat area. 	<ol style="list-style-type: none"> 1. Use a lower wheel with a larger flat.
Wheels form too low a crown in workpiece.	<ol style="list-style-type: none"> 1. Lower wheel flat is too large. 	<ol style="list-style-type: none"> 1. Use a lower wheel with a smaller flat area.

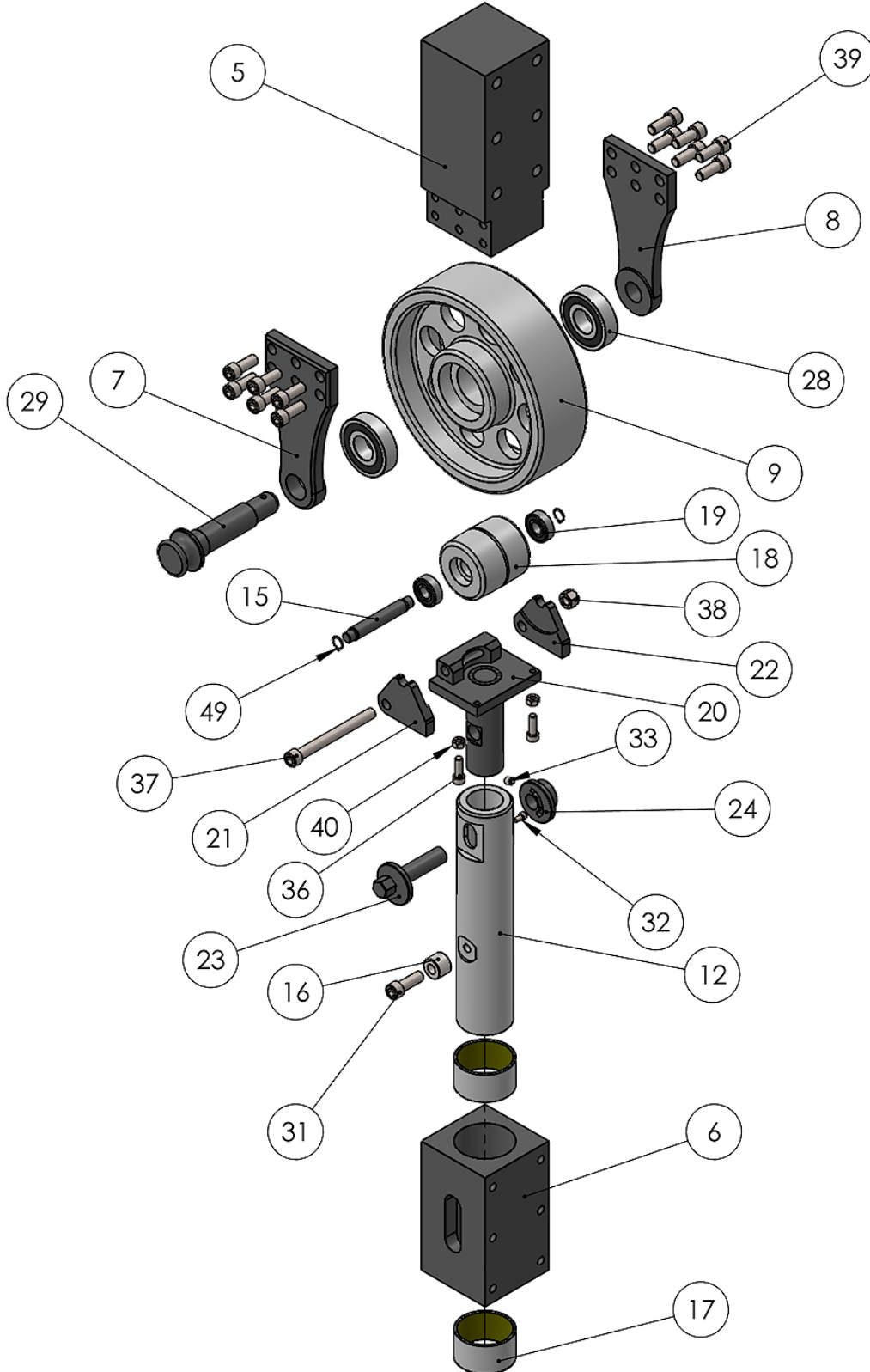


FRAME ASSEMBLY



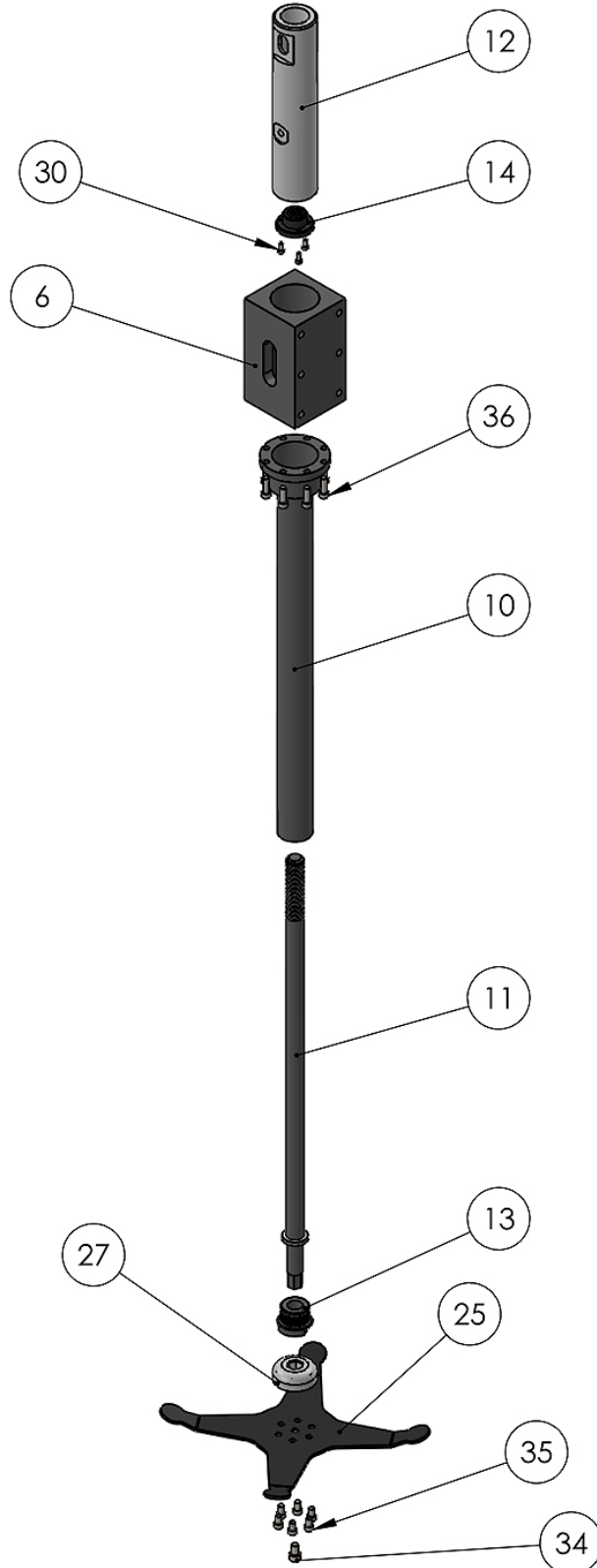


WHEEL ASSEMBLY





ADJUSTER ASSEMBLY





Parts List

Item	Part Number	Description	Qty.
1	EW30-6A001	SIDE PLATE 30"	2
2	EW36-6A006	LEFT FRONT LEG	2
3	EW30-7A001	PLATE SPACER	12
4	EW36-6A003	RIGHT LEG FRONT	2
5	EW36-6A004	MAIN TOP BLOCK	1
6	EW36-6A008	LOWER SLIDE BLOCK	1
7	EW36-6A005	SIDE PLATE	1
8	EW36-6A012	SIDE PLATE REAR	1
9	EW36-7A001	TOP ROLLER	1
10	EW36-5A002	ADJUSTING TUBE	1
11	EW36-5A004	ADJUSTMENT SHAFT	1
12	EW36-7A003	LOWER RAM	1
13	EW36-7A008	THRUST BLOCK	1
14	EW36-7A009	ACME NUT (6 PITCH L.H.)	1
15	EW36-7A014	ROLLER AXLE	1
16	EW36-7A017	GUIDE PIN	1
17	EW36-7A018	SLIDE BLOCK BUSHING	2
18	LR-R240-3	ROLLER 24.0 R 3" DIA	1
19	PP-1331	35MM O.D. X 15MM I.D.	2
20	EW36-5A001	BOTTOM ROLLER ASSY.	1
21	EW36-6A010	END PLATE (OUTSIDE)	1
22	EW36-6A013	END PLATE (REAR)	1
23	EW36-7A004	ECCENTRIC ADJUSTER	1
24	EW36-7A012	ENGAGEMENT CAM	1
25	EW36-6A011-3	FOOT WHEEL	1
26	EW36-6A014	WHEEL RACK	1
27	M300-7A034	HANDWHEEL MTG HUB	1
28	PP-1330	72MM O.D. X 30MM I.D. BEARING	2
29	EW36-7A013	MAIN WHEEL PIN	1
30	M5 X 0.8 X 12	SHCS	3
31	M12 X 1.75 X 35	SHCS	1
32	M5 X 0.8 X 10	SHCS	1
33	M8 X 1.25 X 10	SET SCREW	1



Item	Part Number	Description	Qty.
34	M10 X 1.5 X 14	SHCS	1
35	5/16-18 X 0.5	SHCS	6
36	M8 X 1.25 X 25	SHCS	10
37	M12 X 1.75 X 120	SHCS	1
38	M12 X 1.75	NYLON LOCK NUT	1
39	M12 X 1.75 X 30	SHCS	12
40	M8 X 1.25	HEX NUT	2
41	M12 X 1.75 X 30	HEX FLANGE	21
42	M16 X 2.0 X 35	HEX FLANGE	12
43	M12 X 1.75	FLANGE NUT	8
44	M10 X 1.5 X 25	HEX FLANGE	2
45	M10 X 1.5	FLANGE NUT	2
46	M24 LOCK WASHER	STD.	24
47	M24 X 3.0 X 50	HHCS	24
48	EW36-7A021	TOP WHEEL STUD	1
49	9/16" EXT. RETAINING RING	STD.	2



NOTES



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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

English Wheel 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.
- 2. English Wheel Condition.** English Wheel machine must be maintained for a proper working condition. Never operate a English Wheel machine that has damaged or worn parts. Scheduled routine maintenance should performed on a scheduled basis.
- 3. Roll Condition.** Never operate a English Wheel machine with 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. 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.
- 5. Gloves & Glasses.** Always wear leather gloves and approved safety glasses when using this machine.
- 6. Avoiding Entanglement.** Tie up long hair and use the correct hair nets to avoid any entanglement with the English Wheel machine moving parts.
- 7. Understand the machines controls.** Make sure you understand the use and operation of all controls.
- 8. Work area hazards.** Keep the area around the English Wheel 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.
- 9. Guards.** Do not operate this machine without the correct guards in place. Necessary guards protect you from injuries by rolls and moving gears and parts.
- 10. Material condition.** Material must be clean out of oil and dry. Oily material can slip and will not bend.
- 11. 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.
- 12. Level machine.** Level the machine on a flat concrete surface by using a spirit level.
- 13. Feeding material.** 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 radius always need more passes.
- 14. Call for help.** If at any time you experience difficulties, stop the machine and call you nearest branch service department for help.

PLANT SAFETY PROGRAM

NEW MACHINERY HAZARD IDENTIFICATION, ASSESSMENT & CONTROL

English Wheel

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>
B	CRUSHING	LOW	Secure & support work material. Ensure machine is bolted down.
C	CUTTING, STABBING, PUNCTURING	MEDIUM	Wear gloves to prevent cuts from sharp material.
D	SHEARING	MEDIUM	Keep hands clear from moving parts on rolls.



Plant Safety Program to be read in conjunction with manufactures instructions



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Authorised and signed by:
Safety officer: 
Manager: 

Revised Date: 12th March 2012