Specific Exposure Prevention Procedures for Operations of a Power Press Brake

The use of the exposure prevention procedures, safe work practices and alternative safeguarding techniques prescribed in the following plan is solely for the operation of the power press brake. These practices are only applicable when manufacturing constraints, such as during custom jobs or “small quantity runs” of piecework nature, do not allow for the use of standard physical guarding.

When power press brakes are used for production operations, defined as a continuous run of more than 4 hours, standard effective guarding is required as defined by 29 CFR 1910.212 – barrier guards, two hand control devices and electronic safety devices.

Operator Requirements
- At least a second-year apprentice.
- Job training will be conducted by experienced operator, foreman or superintendent.
- Operator may act as a helper.
- All steps of procedure are to be reviewed by oral instruction, demonstration and review of trainee’s techniques.
- Proficiency must be demonstrated prior to becoming an operator.

Helper Requirements
- All steps except for the activation of the press are to be reviewed following all outlined procedures.
- Apprentices may act as helpers.

Required PPE
- Hearing protection may be required in accordance with OSHA standard 29 CFR 1910.95.
- Eye protection may be required in accordance with OSHA standard 29 CFR 1910.133.

Machine Set-up
Prior to operating the power press brake, you must inspect the machine and be sure that the proper die is in place (see minor servicing).

At all times when the press brake is not in operation:
- The foot treadle should be removed or in the up position.
- When foot pedals are used, they must be properly guarded.
- The ram should be placed at the bottom of the stroke.
- The controls should be turned off.
**Safe Distance**

The operator of the power press brake and the helper(s) will not approach any closer than necessary and in no case closer than 4 inches from the point of operation. This distance is measured from the exterior point of contact of the press die closest to an employee.

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**Press Brake**

![Press Brake Diagram]

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**Safeguarding by Distance Measurement**

This can be accomplished by the use of a warning barrier device.

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**Press Brake with Warning Barrier Installed**

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Our safety evaluations, reports and recommendations are made solely to assist your organization in reducing hazards and the potential of hazards and accidents. These recommendations were developed from conditions observed and information provided at the time of our visit. They do not attempt to identify every possible loss potential, hazard or risk, nor do they guarantee that workplace accidents will be prevented. These safety evaluations, reports and recommendations are not a substitute for ongoing, well-researched internal safety and risk management programs. This report does not warrant that the property inspected and its operations are compliant with any law, rule or regulation.

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Operator Safety Guidelines

- Know everything about the press brake you are operating.
  - Types and locations of controls
  - Capacity and operating modes
  - Safeguarding

- Beware of all aspects of the job you are to perform.
  - Proper placement of the materials
  - Proper material feeding
  - Manner in which material moves while being formed

- Be sure to never place hands in the die area.
- Keep the press brake die area free from any necessary materials including tools.
- Cycle the press brake at least twice, without a piece of metal in the die, before each use or after a die change.
- Be sure that both you and the helper are clear of the path of the piece part being formed.
- Keep the work area around the press brake clean and free from debris.
- Be sure that all non-operators are clear of the press brake area before it is operated.