

~ FABRICATION ~



METALWORK

OPERATING INSTRUCTIONS



METALWORK

INTRODUCING

the



METAL ROLLER



Cold-Rolling Sheet Metal Bending Machine

Access Level 1 (see Metal Workshop induction Guide on Access Levels)

Large manual-rolling machine used to produce a continuous curve in a sheet of cold metal (up to a maximum of 3mm sheet). It can also be used to cold-roll thin steel bar (up 8mm diameter). Plastic CANNOT be used with this machine

PPE Basic

- Suitable work coat (provided)
- Gloves to handle steel (provided)
- Stout footwear
- No rings, wrist watches, bracelets, or other jewellery that could get caught in the equipment.

What to do before use

- YOU MUST receive an induction into the area and use of machinery/ equipment BEFORE starting work
- INFORM a member of staff BEFORE starting work
- Know and familiarise where the Emergency Exits are
- Know and familiarise the Health and Safety Checklist
- VISUAL check of PPE and equipment related to the area you are working in and report any damage/faults to a member of the technical staff

How To Use This Rolling Machine

- MAKE SURE you have enough clear space AROUND you to work SAFELY
- If necessary have someone to HELP you move or handle equipment
- MAKE SURE that each wheel on the base is BRAKED ON and that the roller machine is STEADY

- **CHECK** the in-feed rollers are **PARALLEL** to each other and are set to the **CORRECT** depth for the sheet going through. **THIS IS IMPORTANT.**
- If the rollers are over-tightened they will **DISTORT** and damage the work and the machine
- If the rollers are too widely spaced, they will **NOT EXERT ENOUGH FORCE** to drive material through
- Adjustment is produced by rotating the screws at each end either **CLOCKWISE** or **ANTICLOCKWISE**, moving the rollers closer or further apart
- **CAREFULLY** offer your sheet to the feed rollers until the in-feed rollers are **TIGHT** against the sheet surface – but **NOT** overly tight
- **CHECK** the back-support roller is parallel to the in-feed rollers; **ADJUST** by using the screws at each end. If you are **NOT SURE** how to do this, **ASK** a member of technical staff to assist you
- **SLOWLY** turn the handle on the right-hand side of the machine **CLOCKWISE** to begin taking a **HOLD** of the sheet and feeding to the back-support roller
- **ADJUST** the back-support roller height **UP** or **DOWN**; via adjustment screws at each end, to generate the curling affect
- **REPEAT** above action to fabricate your desired curve; further **RAISING** of the back-support roller **DECREASES** the radius diameter in the sheet metal material

Date

I verify that I have read and understood the information detailed within this document

Name

Signature