

# ~ FABRICATION ~



## OPERATING INSTRUCTIONS



INTRODUCING

*the*



# SPINDLE MOULDER



### Wadkin Spindle Moulder (wood use only)

Access Level 3 (see Wood Workshop induction Guide on Access Levels)

Moulding, rebating and plough grooving into hard and soft woods and wood-based board  
NO ACRYLIC SHEET

#### PPE Basic

- Suitable Workcoat (provided)
- Eye Protection – generally marked to BS/EN166 (provided)
- Dust Mask (temporary or fixed) rated to FFP1/FFP2 (provided)
- Ear Defenders (if adjoining process, including LEV) or plugs (provided)
- Stout Footwear

#### What to do before use

- Check machine isolator is in the OFF position
- VISUAL check of the machine for signs of damage to machine or electrical supply system
- IF STUDENT, report any faults to any member of workshop academic/technical staff
- IF STAFF, ensure correct spindle block or saw blade type is fitted for the job before use
- ALL cutting blocks MUST be chip limited, i.e. cutting tip exposed by NO MORE than 1.1mm proud of block surface and MUST be marked by the words MAN on them
- A brief running CHECK of the fitted tooling, i.e. under power – watching & listening for reportable faults – is advised before use.
- All fixed (or otherwise) GUARDS are in a good condition?
- AREA AROUND the machine is clean, tidy and free from obstructions?
- ADEQUATE overhead/natural/machine lighting?

- **Safety accessories such as PUSH STICKS, FORMERS, CLAMPS, FENCES/ GUIDES and STOPS are available and not damaged too badly**
- **Push sticks, push blocks, bespoke formers with handholds, MINIMUM safe recommended distance is 300mm from hand point to exterior profile of cutting too**

### **How to Use The Spindle Moulding Machine**

- **Refer to any OPERATING INSTRUCTIONS given during training or timetabled workshops (if student or staff)**
- **ENSURE only 1 person is operating, and IN CONTROL of, the machine. If a second person is 'assisting' with the take-off of long sections, they MUST NOT pull the work through**
- **ENSURE you are wearing the correct PPE; usually Workcoat, Goggles or Faceshield, Dust Mask and (if adjoining processes in operation, Ear Defenders or Plugs), Sturdy boots also recommended in a workshop environment**
- **CORRECTLY SET machine guards – or CORRECT machine fences and guides that are fitted**
- **CORRECTLY SET cutting fences/guides or stops BEFORE starting work**
- **Switch ON LEV/Extraction System**
- **ENABLE power to machine at isolator key-switch and/or ON lever switch**
- **Switch ON the machine using left-side START control button just under the worktable. It takes a few seconds BEFORE the machine is up to speed**
- **ENSURE no ties, bracelets or loose clothing is near an operating machine**
- **If breaking through a newly-fitted FALSE machine fence, do it in a CONTROLLED and CONSIDERED fashion, holding the fence at least 300mm from the cutting block EITHER SIDE of the fence**
- **NEVER take a measuring cut of material WITHOUT the cutter block enclosures, fences, guards and limiters FITTED and CORRECTLY adjusted BEFORE starting work**
- **Place wood on machine table in a STABLE position (i.e. non-rocking) and ENSURE wood is NOT touching the running cutter tool at startup**
- **Take a FIRM GRIP of the wood, ENSURING (gloveless) fingers are NEVER in-line with the cutter tool**
- **SLOWLY ease wood into cutting area, checking that the tool is cutting EFFICIENTLY and STEADILY through material before slowly**
- **As the end of the work comes AT LEAST 300mm from the cutting area, use the PUSH STICKS to push the final section of wood through the cutting block. Take care to AVOID damaging the push stick**

- **STOP** machine using normal silver-coloured **STOP** button
- Use the under-table **ARBOR BRAKE LEVER** to bring the cutting block to a **DEAD STOP** in **UNDER 10** seconds. **DO NOT** allow the cutting block to free-spin to a **STOP**
- **ENSURE** you perform a **VISUAL** verification that the cutting block has come to a **DEAD STOP BEFORE** putting hands and fingers **ON** the worktable
- **DO NOT** use the **EMERGENCY STOP** to stop the machine
- **CLEAR** wood and offcuts from the machine table
- Use a **HOOVER** or portable extract machine to **CLEAR WOOD DUST** from table and floor
- **NEVER** use a sweeping brush or dust pan **OR** blow wood dust off surfaces (allow **LEV** to run for a few additional seconds after machining)
- Isolate machine (or switch to **OFF**)
- **NEVER** exchange operator whilst machine is running
- **ENSURE** complete mechanical stop of machine **BEFORE** handover and that the power is isolated

**Date**

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

**Name**

**Signature**