

~ FABRICATION ~



METALWORK

OPERATING INSTRUCTIONS



METALWORK

INTRODUCING

the

FLY PRESS



Electric Guillotine. Metal Workshop

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

Screw press used to stamp out circles in sheet material up to a thickness of 1.5mm.

Will cut mild steel, stainless steel, brass, aluminium, copper and PETG

PPE Basic

- Suitable work coat (provided)
- Eye protection, rated to BS/EN166 (provided)
- Hair tied back, no loose accessories
- Appropriate footwear, no sandals etc

What to do before use

- Visual check of the machine for signs of damage to machine, if student, report any faults to any member of workshop academic/technical staff or if staff, log in the Fault Reporting Log Book by machine – then email technical team to report if machine requires maintenance or servicing
- Check the condition of the flooring – ensure there are no oil or water spillages, offcut obstructions
- Check that there is adequate overhead/natural/machine lighting?
- Ensure Stop collar is in the locked position
- Place material within reach of the press

How to use the Electric Guillotine

- Refer to any Operating Instructions given during training or timetabled workshops
- Ensure only 1 person is operating and in control of the Fly Press. Make sure all others present are at least 1.5M away from the machine

- Undo the punch locking bolt whilst holding the punch so that the punch does not drop, and remove from the fly press
- Remove the die from its cradle
- Place the punch and die together in the tray of bits
- Choose a punch and it's matching die for the hole required
- Undo the two die cradle clamps
- Ensure the die fits into the cradle, if not, replace the holding bits with those that match the die
- Place the punch into the press and do up the locking bolt to finger tight
- Hold the fly handle
- Undo the stop collar
- Pull the handle to lower the punch keeping fingers well clear of the punch and the screw
- Adjust the cradle so that the punch lowers into the die, keeping fingers away from the punch, so that the punch is centralised in the die
- Lock off the press with the stop collar
- Tighten the die cradle clamps
- Undo the stop collar
- Check that the distance allowed by the stop collar is sufficient for the punch to drop below the cutting line of the die
- Raise the Punch
- Place material under the punch, material can be centre punched and the dent lined up with a protrusion on the bottom of the punch for accurate punching
- Check that no one is within 1.5m of the press
- Lower the punch with force to punch a hole in the material
- Raise the punch
- Twist the material off of the punch, move material, and punch again until all holes are done
- Raise the punch and lock off the press
- Collect circles of punched material from the tray below the press

Date

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

Name

Signature