

METAL CUTTING BAND SAW SOP

ACRONYMS

LOTO - Lockout/Tagout.

PPE - Personal Protective Equipment.

SOP - Safe Operating Procedure.

HAZARDS

What can cause harm?

- Moving saw blade
- ▲ Electricity
- ▲ Hot parts
- Ejected objects
- Manual Handling
- Poor housekeeping

PRECAUTIONS

- All operators are trained and competent to operate Metal Cutting Band Saw safely. Operator training should include:
 - Workplace induction
 - Safe operating procedures
 - Manufacturer's instructions
 - Nature of hazards
 - Fitting of PPE
 - Manual handling
 - Housekeeping
 - First Aid

MAINTENANCE

- Follow LOTO procedures. Record service/repairs information in Maintenance Log
- Maintenance is conducted as per manufacturers' instructions and by qualified persons only
- o When the machine is taken out of service for maintenance:
 - Shut off and isolate the power supply
 - The power supply is clearly labelled/tagged "do not use."



PRE-OPERATIONAL INSPECTION

WORK AREA

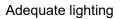






No trip or slip hazards







- Follow the pre-operational checklist in the manufacturer's operational manual:
 - Tested and tagged
 - Interlocked/fixed guards functional
 - Blade guide adjusted to suit workpiece
 - Blade tension correct, sharp and attached secured
 - Nuts, bolts etc. in place, no missing screws
 - Guards undamaged
 - E-stops accessible and functional
 - Controls labelled, legible and functional
 - Moving parts lubricated
 - Coolant levels sufficient
 - Cutting table secured in required work position
 - Cutting table cleared of off-cuts, debris, metal shards
 - Saw clean, clear of dirt, grease, oil or flammable solvents.

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OPERATION

- 1. Operate in accordance with manufacturers' instructions
- 2. Wear prescribed PPE
- 3. Raise the saw head to a vertical position
- 4. Adjust the stop limit do the motor stops just after the workpiece is cut off
- 5. Adjust the stock stop to the required length position
- **6.** Open vice to accept the workpiece to be cut. If the piece is long, support the end with an approved support
- 7. Rotate the vice hand wheel to tighten the workpiece
- 8. Turn the motor switch on, adjust blade speed to correct setting for the material of the workpiece
- **9.** Allow the saw head down slowly to enter the workpiece to minimize blade tooth damage due to excessive entry speed. Ensure:
 - Correct blade for thickness and type of material
 - Select correct speeds for thickness and type of material.
 - Adequate ventilation based on materials being cut
 - Secure work using clamps
 - Ensure correct direction of feed (into blade/cutter against the rotation of the blade)
 - Stand with feet shoulder-width apart, maintain a firm stance
 - Watch workpiece
 - Keep body parts clear of the blade
 - Only cut one workpiece at a time and hold it firmly against the table when passing through the blade
 - Clear away off-cuts, swarf, and debris regularly
 - Turn off the machine; follow LOTO procedures to ensure the machine cannot be accidentally activated. Wear cut-resistant gloves when clearing away debris and disposed of in appropriate containers
 - Stop work if the machine begins to vibrate unexpectedly, or the blade appears to be weakened.

- **Do not leave unattended when running.**
- Entanglement/Lacerations from moving parts/blades. Keep fingers (and other body parts), hair, clothing, jewelry, and tools away from moving parts.
- ✓ CLEAN the band saw. Oil and grease marks should be cleaned off using mild household surface cleaner and a soft rag.
- DO NOT use abrasive cleaners or strong solvents that can damage the machine.



✓ Wear gloves when handling blades during replacement (cut-resistant gloves).

🖊 If blade jams

- ✓ Stop machine.
- Ensure blade comes to a complete stop before clearing blockage.

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