

STANDARD OPERATING PROCEDURES

Pipe Bender

DO NOT use this machine unless you have received authorization from the Shop Coordinator



Cut-resistant work gloves must be worn at all times.



Safety goggles or impact-resistant face shield must be worn at all times.



Closed-toe footwear must be worn at all times.



Long and loose hair must be contained.



Close fitting/protective clothing must be worn. Roll up long sleeves.



Rings and jewelry must not be worn.

Potential Hazards and Injuries

- Sharp edges and burrs (cuts)
- Hot metal from heat softening or deformation heating (burns)
- Crush and pinch hazards (bruising, pinching, dismemberment, death)
- Struck-by injuries, blunt force.

Pre-Operational Safety Checks

- Locate and ensure you are familiar with all machine operations and controls.
- Check workspaces and walkways to ensure no slip/trip hazards are present.
- Ensure the workspace is free of clutter, shavings, swarf, and unnecessary tools.
- Check the machine and power cord for signs of wear or faults. If faults are found, tag and remove machine from service until it can be repaired.
- Ensure that the roller molds/die are properly affixed, and the bending die is placed properly.
- Make sure to use equipment only on appropriate materials and per manufacturer's instructions.
- File metal burrs properly and avoid touching metal edges or cuts, even while wearing gloves.
- Select the appropriately sized mold for the pipe being worked. Only use the mold designed for the pipe/wall thickness you are bending.

Safe Practices During Operation

- Ensure the pipe is aligned with molds/dies and fits snugly before operating the machine.
- Stop operating immediately if any abnormalities or unexpected action occurs.
- Bend radius should never be less than 10 times the outer diameter of the pipe.
- Be aware of where pipe stock is moving and ensure it does not endanger personnel, including yourself.
- Stay within reach of the power-off switch while operating.
- Always power down the machine before making adjustments to the elevator screw or molds.
- Decrease radius in small increments by going back and forth over the pipe, making small adjustments each time.

Ending Operations and Cleaning Up

- Power down and unplug the machine before cleaning.
- Clean the machine and molds.

DON'T

- Do not use this machine on glass, plastic, wood or any other materials which could shatter.
- Do not use this machine on any pipes containing fluid or material that could become pressurized.
- Do not use defective machinery. Tag and remove defective unit from service until it is repaired/replaced.
- Do not make adjustments while the machine is running. Always power down before adjusting elevator screw or switching/tightening molds/dies.

SOP must be used in conjunction with an effective training program