

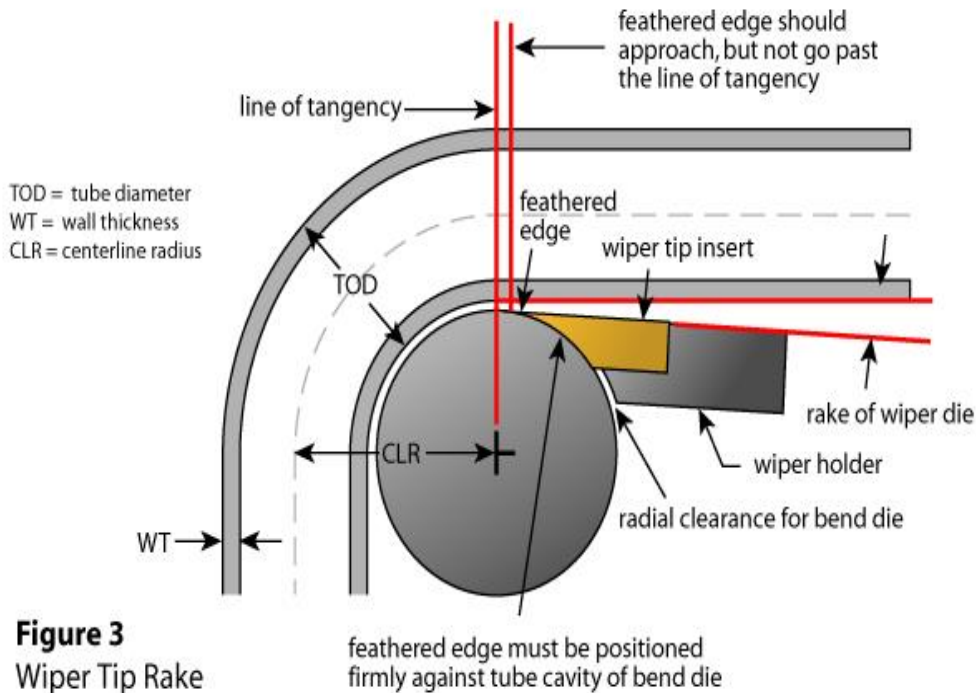
Safe System of Work
OPERATING AND SAFETY INSTRUCTIONS FOR SETTING WIPER DIE

Name: Training Date:.....

Just as the setting of the mandrel is important for successful bending, so is the setting of the wiper die, these are the basic steps for correct setting of the wiper die:

	Instruction	Understands ✓ or X
1	Explain that safety equipment must be used at all times and why – gloves must be used at all times when running machines.	
2	Fix the tube into the jaws of the clamp die and the pressure die. Making sure that the tube is really gripped in the clamp and die.	
3	Gently position the wiper die so that the tip touches the clamp and the tube. Do not use unnecessary force.	
4	Position the base of the wiper die about 1 degree from the tube.	
5	Move the wiper die to the holder. Check the position of the wiper die and check that the bend former is moving freely, especially during large angle bends.	
6	Release the tube, measure the distance between the end and the axis of the clamp die, this needs to be about 3mm.	
7	Adjust the rake of the wiper die about 1 degree as per figure 3 diagram. On a larger diameter tube this may need to be increased.	
8	Make sure the nuts holding the wiper die are tightened before starting.	

See next page for diagram



I have received the above training and fully understand every point that was explained to me. I confirm that I will wear the required PPE equipment when using the above machinery and take all steps to ensure my own safety. I will ask for further training if I need to and will immediately inform the Supervisor or Manager if there are any issues with the machinery.

Name:

Signed: Date:.....

I confirm that I have trained the aforementioned person and that they fully understand how to use the above machinery, have received the required PPE equipment and know to inform me immediately of any issues with the machinery or if they require further training. I authorise this person to use the machinery detailed above.

Name:(Authorised Trainer)

Signed Date: