

Safet System of Work
OPERATING AND SAFETY INSTRUCTIONS FOR DIE AND CORE CHANGE ON
EXTRUDER ONE

Name: Training Date:.....

	Instruction	Understood ✓ or X
1	Explain that safety equipment must be used at all times and why – safety boots must be used at all times when running machines.	
2	Before operating a machine clarify that safety check has been completed and signed off, if not see a Manager or setter before switching the machine on.	
3	Before starting the change make sure the heat temperatures are running at set value, purge out small amount of ABS before extraction.	
4	Turn off first four heats on the extruder, remove the two front heater bands, 5mm hex key, remove thermocouple and the insert.release the 6 hex bolts on the die ring,10 mm hex key, release 6 bolts on the ring using 14mm hex key.	
5	Release pin using 17mm hex key remove die leaving pin inserted, remove ABS from the pin using brass scraper, remove the pin 17mm hex key. GLOVES AND ARM BANDS MUST BE USED.	
6	To insert next die/pin insert the pin using 17mm hex key , loop the die over the pin , using the ring bolt the die to the head, using the 10mm hex key and bolts. Once bolted attach the two heater bands and thermocouple insert and thermocouple .. wait for head and die to heat up then fully tighten all bold with extension lever.GLOVES AND ARM BANDS MUST BE USED.	
7	Do not use any machine unless trained and authorised by Manager.	

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: