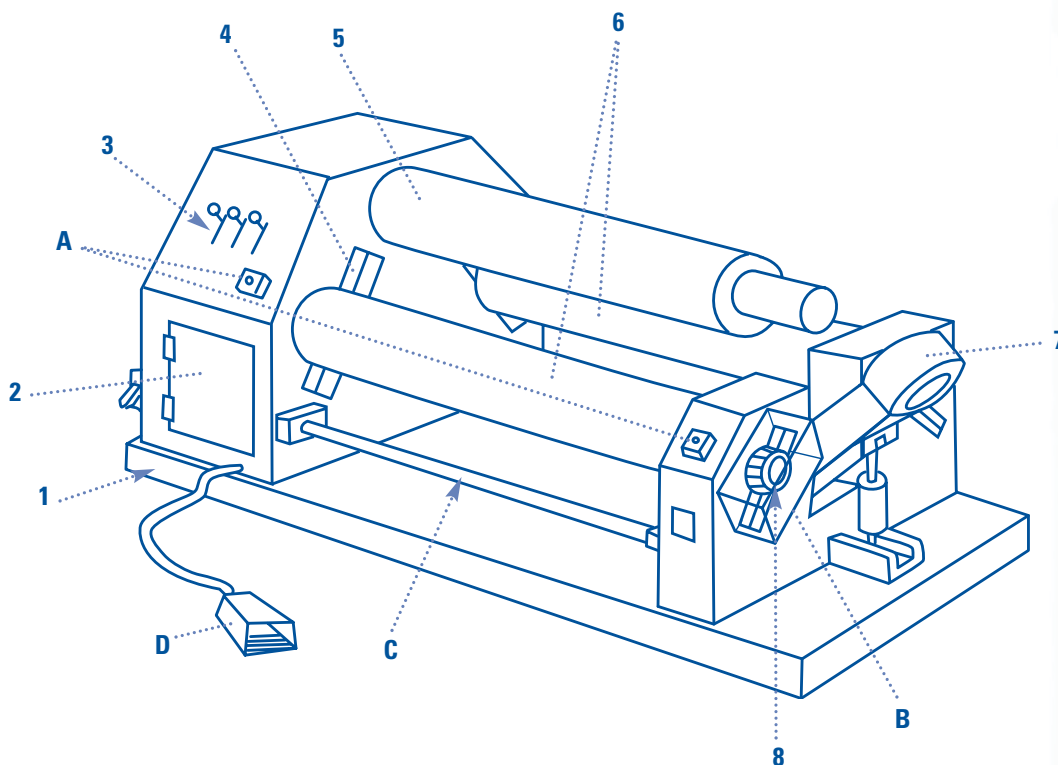


Equipment identification:

Date :

# Roll Bender (Forming Machine)



## Slip Roll Forming Machine Parts

- 1 Chassis
- 2 Drive System Access Panel
- 3 Controls
- 4 Adjustment Mechanism
- 5 Fixed Upper Roller
- 6 Adjustable Lower Rollers
- 7 Swing Bearing
- 8 Track Runner Bearing

## Safety Devices

- A Emergency Stop Button
- B Guard
- C Emergency Stop Bar
- D Three-Position Control Pedal



Association paritaire pour la santé  
et la sécurité du travail  
Secteur fabrication de produits  
en métal et de produits électriques  
[www.aspme.org](http://www.aspme.org)



Institut de recherche Robert-Sauvé  
en santé et en sécurité du travail  
[www.irstst.qc.ca](http://www.irstst.qc.ca)



It's About Making A Difference.  
Industrial Accident Prevention Association  
1-800-406-IAPA (4272)  
[www.iapa.ca](http://www.iapa.ca)

# SELF-ASSESSMENT FORM

For Occupational Health And Safety

## LEGEND

### Preventative Measures

- ▶ Procedural Measures
- Orders/instructions

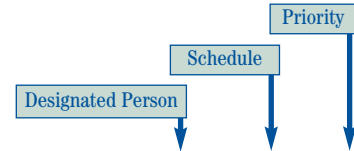
### Priority Codes for applying risk measures:

- A. Immediate stoppage and resolution
- B. Resolution as soon as possible
- C. Resolution according to normal company procedures

The suggested preventative measures are based in part from the Workplace Health And Safety Regulations (RSST, S-2.1, r.19.01), from An Act Respecting Occupational Health and Safety (Québec LSST, S-2.1), INRS Safety Data Sheet 31; Metal Rolling and Forming Machines, 1986, as well as CSA Standards, ANSI B11.12-1996.

# Mechanical Hazards

Most likely injuries: **Crushing, cuts, fractures, contusions.**



Preventative measures	Applicable <input checked="" type="checkbox"/>	Not applicable <input type="checkbox"/>	Notes	Desig.	Sched.	Prior.
<b>Risk Factor: Being Pulled-In By The Sheet Metal, By The Rollers Or By The Track Runner Bearings</b>						
▶ Install feed tables with roller or ball bearings to allow placement of hands away from the pinch danger zone.	<input type="checkbox"/>	<input type="checkbox"/>				
▶ Install hold-down push-button controls.	<input type="checkbox"/>	<input type="checkbox"/>				
▶ Install a three-position control pedal. The roll bender stops when the foot is removed or when greater pressure is applied to the pedal.	<input type="checkbox"/>	<input type="checkbox"/>				
▶ Install a fixed guard around the track runner bearing.	<input type="checkbox"/>	<input type="checkbox"/>				
● Position the workpiece while the rolls are at a standstill.	<input type="checkbox"/>	<input type="checkbox"/>				
● Ensure the workpiece is properly aligned before starting up the bender.	<input type="checkbox"/>	<input type="checkbox"/>				
● Use a guide.	<input type="checkbox"/>	<input type="checkbox"/>				
● Use a tool to hold the workpiece.	<input type="checkbox"/>	<input type="checkbox"/>				
● Remove hands from the workpiece as soon as it is engaged in the machine.	<input type="checkbox"/>	<input type="checkbox"/>				
● Make adjustments when the machine is at a standstill.	<input type="checkbox"/>	<input type="checkbox"/>				
● Wear snug-fitting clothes and gloves.	<input type="checkbox"/>	<input type="checkbox"/>				
● Do not wear any jewelry.	<input type="checkbox"/>	<input type="checkbox"/>				
● Tie up long hair and secure under a cap.	<input type="checkbox"/>	<input type="checkbox"/>				
● Keep the work area free and clear.	<input type="checkbox"/>	<input type="checkbox"/>				
▶ Install a clearly marked emergency stop button located on each side of the forming machine (left and right), and at each mobile control.	<input type="checkbox"/>	<input type="checkbox"/>				
▶ Install an emergency stop device on the whole length of the machine at the front and in the back, such as a kick panel, a cable or a knee-high or foot-level bar.	<input type="checkbox"/>	<input type="checkbox"/>				
▶ Reduce braking speed by using a holding brake, a clutch system or, the application of a direct current.	<input type="checkbox"/>	<input type="checkbox"/>				

Notes:

# Mechanical Hazards (continued)

Most likely injuries: Crushing, cuts, fractures, contusions.

Preventative measures	Appliquée <input checked="" type="checkbox"/>	Non applicable <input type="checkbox"/>	Notes	Desig.	Sched.	Prior.
<b>Most likely injuries: Crushing, cuts, fractures, contusions.</b>						
▶ Install recessed buttons.	<input type="checkbox"/>					
▶ Install a protector on the top and on the sides of the control panel.	<input type="checkbox"/>					
▶ Install as many controls as there are workers simultaneously using the roll bending machine. All workers must maintain their control devices depressed to start the machine.	<input type="checkbox"/>					
▶ Install a by-pass device to make any unused control devices inoperative.	<input type="checkbox"/>					
<b>Risk Factor: Accidental Start-Up Of The Roll Bending Machine</b>						
▶ Ensure that should the electrical supply to the roll bending machine be interrupted, the roll bending machine could not resume work automatically once the electrical power supply is restored.	<input type="checkbox"/>					
● Apply lock-out procedures during maintenance and repairs: - disconnect all sources of energy - dissipate (purge) all residual energies (e.g.: oil pressure in the hydraulic system) - lock-out all sources of energy - validate to ensure start-up is no longer possible and that all power has been dissipated (purged).	<input type="checkbox"/>					
<b>Risk Factor: Handling Badly Burred Workpieces</b>						
● De-burr the workpiece.	<input type="checkbox"/>					
● Wear cut-resistant gloves.	<input type="checkbox"/>					
<b>Risk Factor: Contact With Drive Mechanisms (Gears, Pulleys, etc.)</b>						
● Ensure drive mechanism access panel guards are always in place.	<input type="checkbox"/>					
<b>Risk Factor: Falling Sheets Of Metal</b>						
● Wear CSA-approved safety footwear with steel-capped toes.	<input type="checkbox"/>					
<b>Risk Factor: Workpiece Movement During Rolling Process</b>						
▶ Support large diameter rolls to avoid settling of the workpiece.	<input type="checkbox"/>					
▶ Mark-off work area (yellow line on the floor, barriers, etc.)	<input type="checkbox"/>					
▶ Install a mobile command post which allows the work area to be visible in front and behind the roll bending machine.	<input type="checkbox"/>					
▶ Install a mirror to see behind the roll bending machine.	<input type="checkbox"/>					

Notes:

---



---



---



---





