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*Past General Chairman

TUESDAY AFTERNOON SESSION

October 8, 1940

The opening session of the Power Press Section was called to order by General Chairman M. R. Zelder, Personnel Manager, Edison General Electric Appliance Company, Inc., Chicago, who presided. In his opening remarks the Chairman took the opportunity to review briefly some activities of the Section during the year, and mentioned the work of many Standing Committees. Officers of the Section to serve during the coming year were elected, as listed elsewhere in this record. The Chairman then introduced the first speaker.

The Safeguarding of Fast Punch Presses

By W. A. VOLLMER

Safety Engineer, Employers Mutuals, Wausau, Wis.

Before the most practical methods of punch press guarding can be applied, it is necessary to realize why and how accidents happen.

I understand that about 85 per cent of all accidents that occur are due to either human or mechanical failures. If this is true, then the supervisor and mechanical appliances can be relied upon only to a very limited degree. If methods of die construction and of guarding can be adapted that will reduce the need for supervision and the use of mechanical movements to a minimum, the operations will be more foolproof and there will be a minimum of potential hazards.

In order to accomplish this, it should be the duty of those responsible for designing dies to try and think of some method of die construction that will enable the operator to feed the die and have some method of automatic ejection to unload the finished piece without making it necessary to place the hands at the point of operation at any time during the cycle of the operation. This can be done a large percentage of the time.

After this has been done, a basket enclosure guard can be used. This guard,

when properly made and adjusted, is stationary and surrounds the die on two sides and the front and built high enough to enclose all of the potential hazards from the bolster plate up to above the clamping bolts on the ram. No moving parts being exposed, there is little chance of the operator being injured.

In most cases where basket guards are used on dies constructed as just mentioned, the operator is not only protected against being injured but the speed of the operation is increased.

There are different types of practical ejectors that can be used, such as air ejectors, pick-up ejectors, clearance ejectors and ejecting by bringing the finished piece to the top of the stroke and stripping it from the punch by aid of the knock-out bar in the ram or by stripping it with a plate stripper or stripping fingers.

One method of feeding is to use a gravity chute feed. An apron with side guides is extended to the front of the die. The die is then placed on an inclined press. The piece to be worked on is placed on the apron and slides under the basket guard that surrounds