

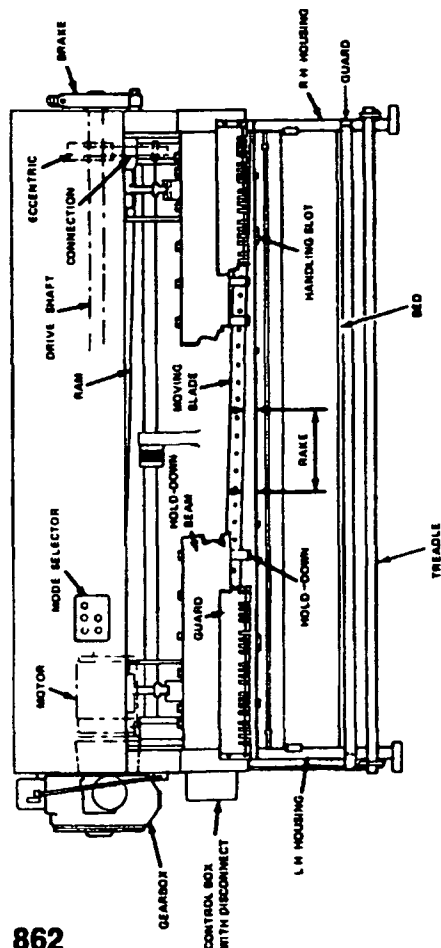
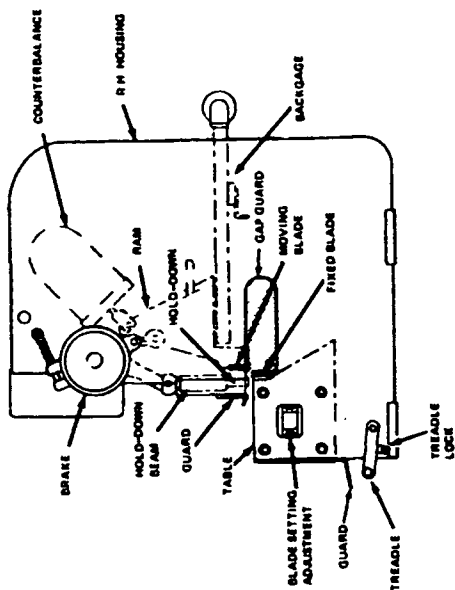


FIG 32-5 — Typical mechanical power shear of the squaring, overdrive type

From ANSI Standard B11.4-1973

TABLE 32-A

PERMISSIBLE GUARD OPENINGS

Distance of opening from pinch point	Maximum width of opening
0 in to 1½ in	¼ in
1½ in to 2½ in	⅜ in
2½ in to 3½ in	½ in
3½ in to 5½ in	⅝ in
5½ in to 6½ in	¾ in
6½ in to 7½ in	⅞ in
7½ in to 8½ in	1¼ in

Also see topic Point-of-Operation Guards in Chapter 29, "Point-of-Operation and Transmission Guards "

Press brakes are generally used for custom work. An operator can work all day, using the same die, and never produce the same item twice. Yet it is quite capable of turning out small production runs of work that would be much too costly to assign to other machines such as a regular power press.

Many of the hazards of press brake operation arise out of this "custom" operation. A press brake will accept and process almost any size work and because of this, there is no such thing as "normal" guarding for press brake operations. In fact, there are times when a guard would seriously interfere with the production process and constitute a hazard in itself.

Good guarding of a press brake starts with a good job analysis of each job to be run, with particular attention to the handling of the work and the closeness of the operator to the point of operation. Any part of the job, or mode of operation, that allows or requires any part of the operator to be in close proximity to the point of operation must be looked at very carefully with respect to the safeguarding applied. Most shops will probably find that two or three safeguarding methods, used either singly or in combination with each other, will enable them to operate efficiently and with safety in all jobs.

Guarding press brakes is not difficult if the foregoing procedures are followed. If a press brake is ever used as a regular power press, however, such operations must be guarded as required for power presses.