

# ILLUSIONS AUSTRALIA

## SAFE WORK PROCEDURE

### SWP 074 – SPINDLE MOULDER

#### 1. PURPOSE AND SCOPE

Minimum requirements for safe operation of spindle moulders at Illusions Australia.

Applies to profiling, rebating and shaping suitable timber using approved cutters, fences, guards, jigs and power-feed arrangements.

#### 2. AUTHORISATION AND COMPETENCY

Only trained, competent and authorised workers may operate the spindle moulder.

Operators must understand cutter direction, tooling speed limits, guarding, workpiece control, kickback, ring/fence work and isolation.

#### 3. REQUIRED PPE

The following PPE must be worn as appropriate:

- Eye protection.
- Hearing protection.
- Safety footwear.
- Respiratory protection where extraction does not adequately control dust.
- Close-fitting clothing and restrained hair. Gloves must not be worn near rotating tooling where entanglement may occur.

#### 4. PRE-START CHECKS

Before commencing work, confirm that:

- Cutter block/tooling is correct, sharp, secure and rated for spindle speed.
- Guards, fences, pressure devices and extraction are correctly fitted.
- Spindle direction/speed are correctly selected.
- Workpiece is suitable and free of nails/screws and major defects.
- Push sticks, jigs or power feed are available where required.
- Table and surrounding area are clear.
- Emergency stop is accessible.

#### 5. SAFE OPERATING PROCEDURE

1. Isolate before fitting/adjusting cutters, fences or guards.
2. Confirm tooling security, speed and rotation direction.
3. Set guards and fences to expose the minimum cutter necessary.
4. Start extraction.
5. Use power feed, jigs, pressure devices or push tools where practicable.

6. Start machine and allow full speed.
7. Feed work in the correct direction against cutter rotation using steady control.
8. Maintain hand separation from the cutter at all times.
9. Use trial pieces and shallow passes for setup where appropriate.
10. Switch off and wait for complete stop before measuring, adjustment or clearing waste.

## 6. PROHIBITED PRACTICES

Workers must not:

- Operate with inadequate guarding.
- Use tooling above its rated speed.
- Freehand-machine small or unstable workpieces without suitable jig/guarding.
- Feed in an uncontrolled direction with cutter rotation.
- Reach over or near rotating cutters.
- Wear gloves near rotating tooling.
- Adjust or clear jams while energised.
- Machine timber containing foreign objects.

## 7. CUTTER CONTACT AND KICKBACK

Spindle moulders expose workers to high-speed rotating tooling and severe kickback potential.

- Use guards, fences and pressure devices.
- Keep hands separated using jigs/push devices.
- Control feed direction and stock condition.

## 8. TOOLING AND SPEED

Incorrectly mounted or oversped tooling can fail catastrophically.

- Use only compatible rated tooling.
- Follow machine/tooling speed limits.
- Isolate before tooling changes.

## 9. POWER FEED

A suitable power feeder can substantially improve hand separation and feed consistency.

- Use where practicable for repetitive/straight work.
- Set pressure and feed to maintain stable stock control.

## 10. FAULTS, DAMAGE AND ABNORMAL CONDITIONS

Stop for abnormal vibration/noise, tooling movement/damage, guard failure, kickback, extraction failure or electrical fault.

Isolate and tag out.

## 11. SHUTDOWN AND HOUSEKEEPING

- Switch off and wait for spindle to stop fully.
- Isolate before close cleaning or tooling access.
- Vacuum dust/chips.
- Return jigs/push devices.
- Report defects.

## 12. EMERGENCY AND INCIDENT RESPONSE

1. Stop the equipment or activity immediately.
2. Isolate the hazard or energy source where safe to do so.
3. Provide or obtain first aid as required.
4. Notify the Foreman, Leading Hand or other authorised Illusions Australia representative.
5. Call emergency services where required.
6. Do not recommence until the incident, defect or unsafe condition has been addressed.

## 13. STOP WORK REQUIREMENT

Work must stop where:

- Guarding or correct tooling is unavailable.
- Workpiece cannot be safely controlled.
- Tooling speed/security is uncertain.
- Extraction is inadequate.
- Abnormal vibration or cutter damage occurs.

**No production requirement or deadline takes priority over safe work.**

## DOCUMENT CONTROL

|                      |                           |
|----------------------|---------------------------|
| <b>Document</b>      | SWP 074 – Spindle Moulder |
| <b>Document Type</b> | Safe Work Procedure       |
| <b>Prepared By</b>   | Aidan McDonnell           |
| <b>Approved By</b>   | Managing Director         |
| <b>Status</b>        | Controlled Document       |