

# IMPORTANT SAFETY INSTRUCTIONS

Servo-Torq® Mk.6 Combination  
rotary cutter & haul-off machines

## PLEASE READ !!

Failure to follow these warnings & instructions may result in electrical shocks, cuts, entrapment, crushing, burning &/or serious injury, even death!



PLASTIC

RUBBER

FOOD

AUTOMOTIVE

MEDICAL

CONSUMER

INDUSTRIAL

MASTIC

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## Important Safety Instructions

### Servo-Torq<sup>®</sup> Mk.6 Combination rotary cutter & haul-off machines. Standard & Plus versions.

These instructions are only to be used with the following Model numbers:

ST-LT/40B-UA75 & ST-LT/50B-UA75

ST-MT/40C-UA75, ST-MT/50C-UA75, ST-MT/75C-UA75

ST-HD/40D-UA95, ST-HD/50D-UA95, ST-HD/40D-UA95L

ST-HD/100D-UA95, ST-HD/100D-UA95L, ST-HD/100D-UA95XL

ST-XHD/40E-UA95, ST-XHD/40E-UA95L

ST-XHD/100E-UA95, ST-XHD/100E-UA95L, ST-XHD/100E-UA95XL

ST-XHD/150E-UA150L, ST-XHD/150E-UA150XL

ST-XXHD/40F-UA95, ST-XXHD/40F-UA95L

ST-XXHD/100F-UA95, ST-XXHD/100F-UA95L, ST-XXHD/100F-UA95XL

ST-XXHD/40G-UA95, ST-XXHD/40G-UA95L

ST-XXHD/100G-UA95, ST-XXHD/100G-UA95L, ST-XXHD/100G-UA95XL

ST-XXHD/40H-UA95, ST-XXHD/40H-UA95L

ST-XXHD/100H-UA95, ST-XXHD/100H-UA95L, ST-XXHD/100H-UA95XL

## Warning!

Ensure that all personnel involved in the installation, operation and maintenance of this machine, as well as those persons who will act as supervisory personnel for this listed above, have read and understood fully these instructions and those contained in the accompanying supplier's instruction manuals and instruction sheets, before attempting to install, operate or perform maintenance on this machine.

Should any questions arise regarding the safe and proper installation, operation or maintenance of this machine, contact the manufacturer at the address shown on the previous page before proceeding.

No modifications or alterations are to be made to this product without the prior express written consent of Peter Gillard & Co. Limited.

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## General Machine Safety Warnings:

### WARNING!!



#### Read all safety warnings & all operating instructions.



Failure to follow these warnings & instructions may result in electric shocks, cuts, entrapment, crushing, burning &/or serious injury, even death!



Retain all safety warnings and instructions for future reference.



#### Work safety area:

- **Keep your work area clean, tidy & orderly.** Cluttered or dark areas invite accidents.
  - **Do not operate the machine in an explosive atmosphere, such as in the presence of flammable liquids or gases.**
- 
- **Keep all guards & cover panels in-place & all machine cabinet doors closed, locked, with the key removed.**
  - **Keep bystanders & all other unauthorised or untrained personnel away whilst the machine is in operation.** Distractions can cause you to lose control.
- 
- **Always wear appropriate safety clothing when operating the machine. ALWAYS wear safety gloves when handling the knife blades. They are VERY sharp & will easily cut your hands.**



#### Electrical safety:

- **The machine power plug/mains connection must match the outlet socket. Never modify the plug in any way. Do not use any adapter plugs with the machine.**  
Unmodified plugs and matching outlets will reduce the risk of electric shock.
- **Do not expose machine to rain or wet conditions; it is for indoor use only.**  
Water entering the machine will increase the risk of electric shock.
- **Do not abuse the power cord. Never use the cord for pulling the machine. Keep the cord away from heat, oil, sharp edges and moving parts.**  
Damaged or entangled cords increase the risk of electric shock.

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## Personal safety:



- Ensure you know the function of each and every control; consult the manual for information.
- Do not rush your work.
- ENSURE YOU KNOW HOW TO STOP THE MACHINE BEFORE STARTING IT.
- STOP THE MACHINE IMMEDIATELY ANYTHING UNEXPECTED HAPPENS.
- Do not run the machine unattended.
- Isolate the machine from the electrical supply when leaving it unattended.
- Make sure power has been turned-off when machine is unused for some time.
- Never substitute the wrong size tool if the correct size tool is not available or cannot be located.
- Do not move any guards while the machine is under power.
- Beware of accidentally moving buttons, levers, clutches (where applicable) or turning the power on.
- Allow the caterpillar belts to stop before opening the access door.
- Allow the blade to stop before opening the cutter lid.
- Do not use tools without handles.
- Correctly locate the tool into socket heads & screw slots.
- Beware of any obstructions that prevent complete tightening of screws. Ensure every screw is tightened correctly.
- Never apply undue force on the control fascia or control levers/handles.
- Secure all cutter guide bushes with the lock provided.
- Always use the correct tools & equipment for the job.
- Be aware of where you leave your tools during set up.  
This enables better usage of the machine in unexpected situations.
- Never change gears by moving them with your hands.
- Beware of tools or machine parts falling onto the controls.

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## Personal safety:



- **Beware of performing another operation while in close proximity to any rotating parts on the machine.**



- **If devices are provided for the connection of dust extraction & collection facilities, ensure these are connected and properly used.**

Use of dust collection can reduce dust-related hazards.



- **Remove any adjusting tools before turning the machine on.**

Any tools left attached to any moving part of the machine may result in personal injury.

- **Keep protective guards in place at the point of operation. Know how to set or attach protective guards properly. NEVER use the wrong protective guard. Know how to select the proper guards.**

- **Stay alert, watch what you are doing and use common sense when operating a machine. Do not use the machine when you are tired or under the influence of drugs, alcohol or certain medications.**

A moment of inattention whilst operating the machine may result in serious personal injury.



- **Always wear the correct personal protective equipment before operating the machine.**

**Always wear gloves when changing the blades. The knife blades are VERY sharp & will cause serious cuts!**



**Never remove protection for even a short time when operating the machine.**

**Ensure you know the correct way to wear protective devices.**

Protective equipment, such as non-skid safety shoes, safety glasses, hearing protection & gloves used for appropriate conditions will reduce personal injuries.



- **Do not allow distractions to interfere with the machine operation.**

**Do not operate the machine whilst talking.**

- **Do not over-reach. Do not touch or reach-over or around the machine to retrieve anything. Keep proper footing and balance at all times.**

- **Do not place your hand or body in the path of moving objects.**

- **Use the appropriate equipment necessary for handling work pieces.**

- **Dress safely. Do not wear rings, watches, ties or loose sleeved clothing. Keep your hair (long hair should be tied-up), clothing & gloves away from moving parts.**

Loose clothes, jewellery or long hair can be caught in moving parts.

- **Never lay anything on the working surfaces of the machine where it may foul with rotating or moving parts.**

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## Machine use and care:



- **Do not force the machine. Use the correct machine for your application. Do not operate the machine in excess of the rated capacity.**

The correct machine will do the job better & safer at the rate for which it was designed.



- **Do not use the machine if the isolator switch does not turn off or if any emergency stop or safety switch is inoperable.**

Any machine that cannot be controlled using these switches is dangerous & must be repaired.



- **Disconnect the machine from the power source before making any adjustments, changing belts or knife blades.**

This preventative safety measure reduces the risk of the machine starting accidentally.

- **Always use the tools supplied with the machine for blade changing operation.**  
Always use the correct tool for the job.

- **Do not allow persons unfamiliar or untrained with the machine or with these instructions to use the machine.**

Cutting machines are dangerous in the hands of untrained users.

- **Maintain the machine in good condition. Check for misalignment or binding of moving parts, breakage of parts & any other condition that may affect the machine's operation. If damaged, have the machine repaired before use.**

Many accidents are caused by poorly maintained machines.



- **Keep blades sharp and clean. Always wear gloves when handling the blades! Do not use broken, chipped or defective blades.**

Properly maintained blades with sharp cutting edges are less likely to bind and are easier to control. They are also less likely to give poor cut quality.



- **Use the machine in accordance with these instructions, taking into account the working conditions and the work to be performed.**

Use of the machine for operations different from those intended could result in a hazardous situation.

- **Be aware of irregular shaped extrusions.**

- **Use the floor locks to stabilize the machine & for levelling purposes to cover any slight variations in floor level.**

## Service & maintenance:



- **Have your machine regularly serviced by Gillard or a qualified service engineer using only original replacement parts.**

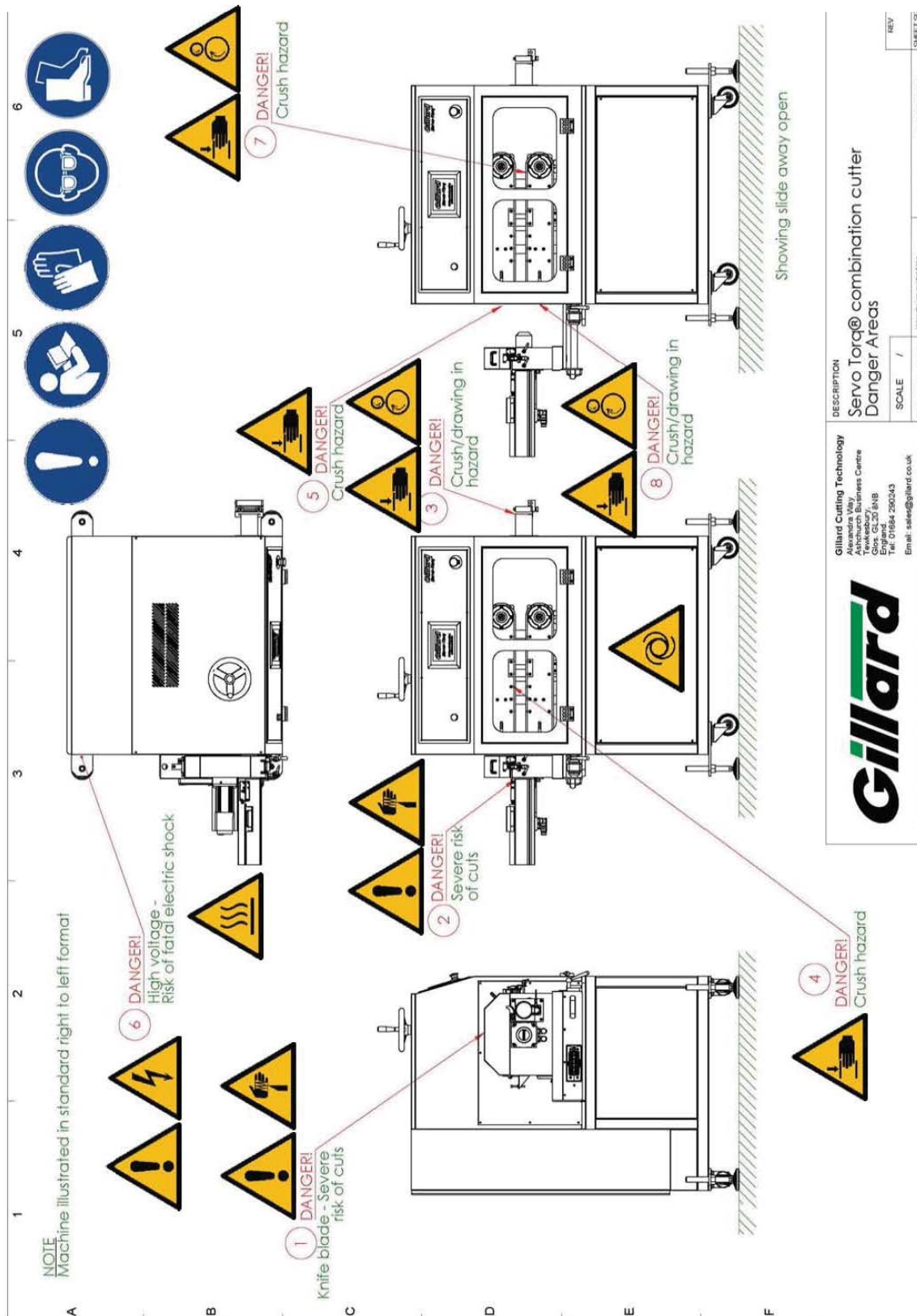
This will ensure that the safety of the machine is maintained over many years.

- **Carry out regular safety checks (daily & monthly) to make sure your machine is safe to use.** Please refer to the operation manual or our website for copies of recommended safety & preventative maintenance checklists.

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	Servo Torq® combination cutter		
	Danger Areas		
SCALE	/	SHEET No. 1 of 1	SHEET NO.
			A 8001 71

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## RESIDUAL DANGER AREAS & HAZARDS:

Please refer to the drawing on page 6.

This shows the location of the residual danger areas & associated hazards.

**Please inform all operators of the hazards before starting the machine!**



1. **CUTTER HEAD** - Due to the inherent nature of the cutting machine, there is an extremely sharp blade contained within the cutter head block. This blade can cause lacerations and even amputations if used incorrectly. Safety precautions have been taken to ensure the blade is kept away from any contact with the operator during the cutting operation. However, there are times, such as blade changing, where the blade is exposed. **Extreme caution should be taken at all times!**



2. **EXIT GUARD** - The exit point provides potential access to the blade. The safety precautions taken should ensure that the operator cannot access the blade as cut product exits the machine. **Extreme caution needs to be taken** when around the exit guard. Reaching inside the exit guard must be avoided at all times to provide maximum safety.



3. **INLET GUARD** - The extrusion enters the machine through the inlet guard. This creates two potential hazards for the operator: 1) a crush point between the extrusion & the machine; & 2) the chance of being drawn in into the machine by the caterpillar belts. The inlet safety guard aims to reduce the risks. However extreme caution still needs to be taken.



4. **CATERPILLAR BELTS** - It is possible to crush your hands or limbs between the caterpillar belts. This risk has been reduced by using a safety sensor on the guard access door. This will not allow the caterpillar belts to move under power when the door is open. **Note:** The belts can still be moved using the height adjustment hand-wheel when the access door is in the open position. This could cause a crush hazard.



5. **SLIDE-AWAY CUTTER HEAD** - When the product is being changed, or any other process which requires the cutter head to be moved-away from the main frame, a hazard is created. The operator's hands or limbs could get crushed between the cutter head and the machine frame. This cannot be guarded against, and as such, caution needs to be taken during operation.



6. **ELECTRICAL CABINET** - The electrical cabinet is an extreme risk area due to the high voltage connection to the machine. There is a risk of a potentially fatal electrocution. This cabinet should always be locked to reduce access to this danger. When it is necessary to work inside the cabinet it should be done under trained supervision with extreme caution.



7. **CATERPILLAR ENTRANCE** - The entrance of the caterpillar belts is most dangerous due to its ability of the belts to drag a hand or limb into the machine. This could result in the crushing of the hand/limb causing serious injury.

This danger is reduced by having a safety switch on the guard access door. This stops the belts moving under power when the door is open. However caution is still needed.



8. **SLIDE-AWAY CUTTER HEAD/INFEED BELT AREA** - With the slide-away cutter head is in the out position a hazard exists between the edge of the machine frame & the moving belt surface. There are two hazards:

- a) drawing-in hazard if the belts are running during extrusion line start-up.
- b) crushing hazard if the belts are manually moved using the overhead hand-wheel.



9. **MOTOR, HEATED BLADE & GUIDE BUSH OPTIONS** - During operation the cutter motor may become very hot. This is normal, but be aware. When the heated knife blade &/or heated inlet bush options are fitted, take care as both may become very hot. Always wear safety gloves when handling knife blades or guide bushes.



10. **AUTOMATIC START-UP** - When cutting long lengths it might appear that the cutter is not working. However as soon as the pre-set cut length has been reached the knife blade will automatically activate without warning. **TAKE CARE !!**

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