

Government of Maharashtra
Directorate of Industrial Safety and Health

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Subject: Guide lines for Operating Industries using Power Presses

Introduction:

In the current situation of Covid-19 lockdown, the inspection of all the factories may not be possible by this directorate. Hence all such type of factories are hereby directed to follow the following safety measures in addition to the provisions of The Factories Act, 1948 and The Maharashtra Factories Rules, 1963.

The given guide lines are not exhaustive in nature; any additional precaution as may be necessary based on specific requirement should be adopted by the factory management for safe manufacturing operation of the factory based on the nature of manufacturing activity

Guide lines for Operating Industries using Power Presses

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Chapter- I

General Introduction of power presses and its use

“Power press machine” means a machine on which metallic or non-metallic substances are subjected to the operations like blanking, coining, curling, drawing, embossing, forming, piercing, punching, perforating, reaming, trimming, bending, pressing, stamping, raising, mould-making and similar purpose.

The press is a metal forming machine tool designed to shape or cut metal by applying mechanical force or pressure

These are considered fastest and most efficient ways to form a sheet metal into finished products. Presses and press tools facilitate mass production work. The metal is formed to the desired shape.

Power Presses are normally driven by mechanical mechanism or hydraulic system. Power source of these presses may be electric motor or engine.

Sometimes manually operated presses termed as a “hand presses” are used to process thin sheet metal working operations where less pressure or force is required. Most of manually operated presses are hand press, ball press or fly press.

Power Presses are used in large number of industries like automobile industry, aircraft industry, telecommunication electrical appliance; utensils making industry are major examples.

Chapter II

Types of Presses:-

Depending upon the operating mechanism power presses can be classified as

- A) Mechanical power presses
- B) Hydraulic power presses
- C) Pneumatic power presses

The size of the press is designated by its maximum capacity of applying load on a piece of blank, and it is expressed in tones.

Main Parts of presses:-

- 1) **Bolster Plate:-** It is the flat plate fitted on the base for supporting the die block and other accessories of the press.
- 2) **Frame:-** Frame constitute main body of the press located at one edge of its base. It houses support for ram, driving mechanism and control mechanisms. All presses except the straight side type have “C” shaped frame to take up the vertical thrust of the ram.
- 3) **Base:-** The base is the supporting member of the press and provides arrangement for tilting and clamping the frame in an inclined press.
- 4) **Driving mechanism:-** The rotary movement of the motor is converted into the reciprocating movement of the ram by crank and connecting rod, eccentric and connecting rod in mechanical presses.
- 5) **Pitman :-** It is the part which connects the ram and crankshaft or ram eccentric.
- 6) **Ram :-** Ram reciprocates to and fro within its guide ways with prescribed stroke length and power. The stroke length and power transferred can be adjusted as per the requirements. Ram at its bottom end carries punch to process the work piece.
- 7) **Brakes :-**The brakes are used to stop the movement of the driving shaft immediately after it is disconnected from the fly wheel.
- 8) **Clutch:-** The clutch is used for connecting and disconnecting and the driving shaft with the flywheel when it is necessary to start or stop the movement of the ram.
- 9) **Fly Wheel:-** The flywheel is mounted at the edge of the driving shaft and is connected to it through a clutch. The energy is stored up in the fly wheel during idle periods and it is expected to maintain the constant speed of the ram when the punch is pressed into the work.
- 10) **Die set:-** Both die and punch work together as a unit and this is called a die set. Punch and die both are made of high speed steel. Die is the part where strength and wear resistant both properties are required. So normally working surface

11) Die:- A die is that part of the press tool which has opening cavity to receive the punch .The die is usually the lower member of the press tool which is clamped on the bolster plate fitted on the table and remain stationary.

12) Punch:- It is that part of the press tool which enters into the cavity formed in the die section .The punch is usually the upper member of the press tool which is mounted on the lower end of the ram and slides with it.

13) Punch Plate:- Lower end of the ram holds punch holder which is equipped with the punch plate. Punch plate is generally made of stainless steel or HSS. The punch plate holds the punch rigidly and accurately.

14) Safety Devices: For the safety of the operators working on the power presses two hand control devices and presence sensing safety devices are used.

Chapter III

Safety Devices for power presses:-

(a) **Two Hand Control Devices** - The following provisions are required to the power press machine which must be equipped with two hand control devices, namely:-

(i) A two hand operating device needs to be so designed as to require the simultaneous use of both hands to actuate the stroke of the press. It shall be so designed, located and arranged as to prevent tying, wedging or otherwise securing one handle or button and operating the press with other hand only.

(ii) Where two or more workers are engaged in operation of a single press, separate two hand control devices needs to be provided for each worker and individual hand controls needs to be operated concurrently for actuation of stroke;

(iii) The safety distance 'D' between the two hand control station and the point of operation shall be greater than the distance determined by the following formula -
 $D = 1.6 \text{ m/second} \times T \text{ (second)}$, where T is hazard time. Provided that;

(i) on presses with part revolution clutches, T = stopping time of the ram;

(ii) on presses with full revolution clutches, T = Maximum possible time required for the ram to complete one down stroke.

(b) **Presence Sensing Safety Devices** - The following provisions needs to be provided where power press machine is equipped with presence sensing safety devices, namely;-

(i) The Presence Sensing Safety Devices needs to be located and adjusted so that it will respond to any instruction at or before the safe distance and clutch of the press will get deactivated.

(ii) The effective sensing field of the device needs to be located at a distance from the nearest point of operation hazard so that any part of the body of an individual cannot reach to the danger zone before motion of the ram stops.

Types of Guards:-

- a) **"fixed barrier guard"** means a guard attached to the frame, bolster plate or other fixed surface of the press machine to prevent access for any part of the body of a person to the dangerous zone of the power press machine and includes that part of the closed tool, which acts as a guard;
- b) **"inter-locked barrier guard"** means a guard attached to the press frame and interlocked so that the press stroke cannot be actuated normally unless the guard itself or its hinged or movable sections enclose the point of operation.

Chapter IV

Standard Operating Procedure for Work Resumption after any shut down for power presses.

Safety Precautions related to Power Press machines:-

Before starting the power press machines in the factory after any shut down following safety precautions shall be taken :-

A) Visual checks of the entire power press machine should be conducted, before any energy source is switched on :-

- i)** The appearance of each part should be checked;
- ii)** The machine should not have any abnormal conditions such as cracks, damages, dents, foreign items and missing items;
- iii)** The tightness of all parts should be examined;
- iv)** All parts should be fastened properly, including the tensioning of V-belts, chains, etc;
- v)** The tightness of all mounting bolts and nuts;
- vi)** Any leakage of gas, air, oil, water, coolants,
- vii)** Check any physical damage to Presence-sensing devices, two hand control devices, Sensors of safety guards, gates, doors, etc.

Repair/replacement of the faulty parts or accessories before starting the power press machine should be carried out from the trained personal only.

B) In addition to above checks following checks related to Safety Devices fitted to power press machine shall be carried out :-

- i) Check the working and operation of two hand control devices fitted to each machine.
- ii) Where two or more workers are engaged in operation of single press , check the working of separate two hand control devices provided for each worker .
- iii) Working of Presence Sensing Safety Devices fitted to each power press machine shall be checked.

Also following checks regarding the Presence Sensing Safety Devices shall be carried out.

The Presence Sensing Safety Devices shall be located and adjusted so that it will respond to any instruction at or before the safe distance and clutch of the press will get de-activated.

The effective sensing field of the device shall be located at a distance from the nearest point of operation hazard so that any part of the body of an individual cannot reach to the danger zone before motion of the ram stops.

- iv) Fixed barrier guard with slip plate fitted to each power press machine shall be checked thoroughly.
- v) Check the operation of foot pedal provided to each power press machine and ensure that the foot pedal is provided with the substantial guard placed over the pedal to prevent accidental actuation of stroke.

Also check that pad with a nonslip contact area firmly attached to the pedal.

Repair/replace the faulty part or accessories of Safety devices before starting the power press machine.

C) Following safety precautions related to Punch and Die setting before starting the power press machine shall be insured –

- 1) (i) Before setting dies in punch presses or removing them, safety block shall be inserted between the punch and die or between the bolster plate and the face of a ram of the power press machine to prevent the dropping of the ram.
- (ii) The source of power shall be disconnected from the press, while setting dies.
- (iii) On large presses which cannot be turned by hands, power to the motor shall be used in inching mode. When die is set for any operation, safe feeding arrangement and guards provided on the machine, shall be made operative.

(iv) The starting and stopping mechanism shall be provided with a safety stop so as to prevent over running of the press or descent of the ram during tool setting, etc.

- 2) **Work permit** - Work permit shall be issued by a responsible person before carrying out die setting work or maintenance and repair works.

D. General Safety Precautions :-

(i) Check each setup and make sure the operator knows how to run the press safely before beginning work.

(ii) Operator shall be trained before start up. In addition, workers should be trained on safe handling and best practices.

The training shall include suitable and sufficient practical instructions in relation to each type of power press machine and safety devices fitted to that machines .

The operator should also make sure that he has understood the work to be done before he starts actual work.

(iii) Look at the drawings, specifications and other instructions. If operator has some questions, answers his questions before he begins his work. Observe operating procedures are proper and make sure they are followed correctly.

(iv) Do not wear loose clothing, jewelry, or long hair around machines. These increases the risk of being caught in the machinery.

(v) Make sure your hands and other body parts are out of away from any harms, especially when ram is moving down. **Use of hand picking tools/devices needs to be ensured.**

(vi)Keep the floor around the press clean. That can prevent falls and slips, a potential causing serious injury.

(vii) Machine shops use a range of heavy and slippery materials, many of which have sharp edges. That's why gloves are essential.

(viii) Special hand tools needs to be made to work with materials for keeping hands and arms safe.

Note:- Before starting the Power press machines in the factory it shall be insured that all the provisions of schedule VIII-A under Rule 57 of Maharashtra Factories Rule ,1963 regarding power press machines are strictly complied.

Chapter V

Legal Provisions

Schedule VIII-A under Rule 57

of Maharashtra Factories, Rules, 1963

Use of the power press is very much essential in too many industries for metal metallic or non-metallic substances are subjected to the operations like blanking, coining, curling, drawing, embossing, forming, piercing, punching, perforating, reaming, trimming, bending, pressing, stamping, raising, mould-making and similar purposes.

After going through the statistical data of the accidents occurred during last too many years, it was noticed that the number of serious accidents had been occurred on the power presses resulting into amputation of the hands and or it's fingers. So it was decided to induct the special schedule under Rule 57 of Maharashtra Factories Rules, 1963.

So in exercise of the powers conferred by section 112 read with sub-section (2) of section 21 of the Factories Act, 1948 (63 of 1948), in its application to the State of Maharashtra, and of all other powers enabling it in behalf, the Government of Maharashtra had made following rules further to amend the Maharashtra Factories Rules, 1963 vide notification No. FAC-201S/CR-30S/Labour -4 dated 4th August 2017 .

Schedule VIII-A

Power Press Machines

1. Application - The Schedule shall apply to all types of power press machines including the press brakes, except when used for working hot metal.

2. Definitions - (1) For the purposes of this Schedule,-

(a) "approved" means approved by the Chief Inspector (Director of Industrial Safety and Health, Maharashtra State);

(b) "fixed barrier guard" means a guard attached to the frame, bolster plate or other fixed surface of the press machine to prevent access for any part of the body of a person to the dangerous zone of the power press machine and includes that part of the closed tool, which acts as a guard.

(c) "inter-locked barrier guard" means a guard attached to the press frame and interlocked so that the press stroke cannot be actuated normally unless the guard itself or its hinged or movable sections enclose the point of operation.

(d) "point of operation" means a dangerous zone between the punch and die of the power press machine, in which work piece is inserted for carrying out operations mentioned in clause (f);

(e) "positive clutch" means a full revolution type, where ram continues for a complete stroke after each actuation of the press;

(f) "power press machine" means a machine on which metallic or non-metallic substances are subjected to the operations like blanking, coining, curling, drawing, embossing, forming,

piercing, punching, perforating, reaming, trimming, bending, pressing, stamping, raising, mould-making and similar purposes;

(g) "presence sensing safety device" means a device so designed and installed that when hand or any part of the body of a person is in danger zone, the stroke of press cannot be actuated and if hand or any part is inserted while the ram is in motion, it will immediately stop the ram;

(h) "safety block" means a prop that when inserted between the punch and die or between the bolster plate and the face of a ram of the power press machine, prevents the ram from falling from its own deadweight;

(i) "safety device" means a guard and any safety attachments that restrain the person from inadvertently reaching into the point of operation or prevents normal press operation if any part of body of a person are inadvertently within the point of operation or automatically withdraw the part of the body of person if they are inadvertently within the point of operation, before the die close;

(j) "Single stroke device" means an arrangement, which limits the travel of ram to one complete cycle or stroke at each operation of clutch.

(2) The words and expressions used in this Schedule, but not defined, shall have the same meanings respectively assigned to them in the Factories Act, 1948.

3. Protection of tool and die - (1) Each power press machine shall be provided with a fixed barrier guard with a slip plate on the underside enclosing the front and all sides of the tool.

(2) Each die shall be provided with a fixed barrier guard surrounding its front and sides, and extending to the back in the form of a tunnel, through which the pressed article falls to the rear of the press.

(3) The design, construction and mutual position of the guards referred to in sub-clauses (1) and (2) shall be such as to preclude the possibility of any part of the body of a person reaching the danger zone.

(4) The machine shall be fed through a small aperture at the bottom of the die guard, but a wider aperture may be permitted for second or subsequent operations if feeding is done through a chute.

(5) Notwithstanding anything contained in sub-clauses (1) and (2) an inter-locked barrier guard or safety device may be used in place of a fixed barrier guard, but where such guards or safety device are used they shall be constantly maintained in an efficient working condition and kept in position and if, any guard or safety device develops a defect, the power press machine shall not be operated, unless the defect is removed.

(6) Hand Tools - When a worker is required to feed or remove job manually, wherever practicable he shall be provided with hand feeding tools like pushers, pickers, pliers, tweezers, forks, magnets, suction disks or similar hand tools for handling the job so as to keep his hands away from the point of operation. However, they shall not be considered as a substitute for a guard and shall be used in conjunction with the guards as required by these rules.

4. Safety Devices - (a) Two Hand Control Devices - The following provisions shall be complied with, where power press machine is equipped with two hand control devices, namely:-

(i) A two hand operating device shall be so designed as to require the simultaneous use of

both hands to actuate the stroke of the press. It shall be so designed, located and arranged as to prevent tying, wedging or otherwise securing one handle or button and operating the press with other hand only.

ii) Where two or more workers are engaged in operation of a single press, separate two hand control devices shall be provided for each worker and individual hand controls shall be operated concurrently for actuation of stroke;

(iii) The safety distance 'D' between the two hand control station and the point of operation shall be greater than the distance determined by the following formula –

$D = 1.6 \text{ m/second} \times T \text{ (second)}$, where T is hazard time. Provided that;

(i) on presses with part revolution clutches, T = stopping time of the ram;

(ii) on presses with full revolution clutches, T = Maximum possible time required for the ram to complete one down stroke.

(b) Presence Sensing Safety Devices - The following provisions shall be complied with, where power press machine is equipped with presence sensing safety devices, namely;-

(i) The Presence Sensing Safety Devices shall be located and adjusted so that it will respond to any instruction at or before the safe distance and clutch of the press will get deactivated.

(ii) The effective sensing field of the device shall be located at a distance from the nearest point of operation hazard so that any part of the body of an individual cannot reach to the danger zone before motion of the ram stops.

5. Power press machine operating mechanism - (1) Foot pedal - The following provisions shall be complied with, where power press machine is equipped with foot pedal:-

(i) On every foot operated power press machine a substantial guard shall be placed over the treadle to prevent accidental actuation of stroke. A pad with a nonslip contact area shall be firmly attached to the pedal.

(ii) The pedal return spring shall be of compression type.

(2) Hand Operated Levers - Hand operated presses shall be equipped with a spring latch on operating lever to prevent premature or accidental actuation.

(3) Single Stroke Attachment - Power presses having positive clutches shall be provided with single stroke arrangement by which a foot pedal or operating lever is disconnected after each stroke.

6. General Provisions - (1) No worker shall be required to operate or assist in the operation of power press machine, unless he has attained eighteen years of age.

(2) Each press shall be installed on a substantial foundation, floor or other support and shall be securely fastened in place.

(3) Surrounding floors shall be kept in good conditions, free from obstructions, grease, oils and so forth.

(4) All parts, whether fixed or movable, of the every power press machine and its auxiliary devices, equipments and machines shall be of sound engineering construction, strength and free from defects.

(5) All parts of the power press machine shall be so maintained as to be safe operating condition. A log book containing the entries of major repairs carried out on the power press machine shall be maintained.

(6) An emergency stop button shall be provided as a means of disconnecting power required during hazardous situation and it shall be easily accessible.

(7) All gears, moving parts and mechanism on power driven feed rolls and press feeding device shall be securely fenced by a safeguard.

7. (1) Punch and Die setting - (i) Before setting dies in punch presses or removing them, safety block shall be inserted between the punch and die or between the bolster plate and the face of a ram of the power press machine to prevent the dropping of the ram.

(ii) The source of power shall be disconnected from the press, while setting dies.

(iii) On large presses which cannot be turned by hands, power to the motor shall be used in inching mode. When die is set for any operation, safe feeding arrangement and guards provided on the machine, shall be made operative.

(iv) The starting and stopping mechanism shall be provided with a safety stop so as to prevent over running of the press or descent of the ram during tool setting, etc.

(2) Work permit - Work permit shall be issued by a responsible person before carrying out die setting work or maintenance and repair works.

8. Appointment of persons to prepare power press machines for use - (1) Except as provided in sub-clause (4) of clause 9, no person shall set, re-set, adjust or try out the tools on a power press machine or install or adjust any safety guard or safety device thereon, being installation or adjustment preparatory to production or die proving, or carry out an inspection and test of any safety device thereon as required by clause 11, unless he,-

(a) has attained the age of eighteen years;

(b) has been trained in accordance with the sub-clause (2) ; and

(c) has been appointed by the occupier of the factory to carry out the duties in respect of the class or description of power press machine or the class or description of safety device, to which the power press machine or safety device, as the case may be, belongs; and the name of every such person shall be entered in a register in Form 9-A.

(2) The training shall include suitable and sufficient practical instructions in relation to each type of power press machine and safety device in respect of power press machine and safety device in respect of which it is proposed to appoint the person being trained.

9. Examination and testing of power press machines and safety devices - (1) No power press machine or safety device shall be taken into use in any factory for the first time in that factory, or in case of a safety device for the first time on any power press machine, unless it has been thoroughly examined and tested by the competent person, in the case of a safety device, when in position on the power press machine in connection with which it is to be used.

(2) No power press machine shall be used unless it has been thoroughly examined and tested by a competent person within the immediately preceding period of twelve months.

(3) No power press machine shall be used unless every safety device (other than fixed fencing) thereon has, within the immediately preceding period of six months when in position on that power press machine, been thoroughly examined and tested by a competent person.

(4) The competent person carrying out an examination and test under the foregoing provisions shall make a report of the examination and test in Form 9-B and every such report shall be kept readily available for inspection.

(5) Every power press machine in the plant and every safety device provided on it shall be distinctively and plainly marked with identification number and a date of its last examination carried out by competent person.

10. Defects disclosed during thorough examination and tests - (1) Where any defect is disclosed in any power press machine or in any safety device thereon during any examination and test under clause 9 and in the opinion of the competent person carrying out examination and test, either,-

(a) the said defect is a cause of danger to workers and in consequence, the power press machine or the safety device, as the case may be, ought not to be used until the said defect has been remedied; or

(b) the said defect may become a cause of danger to workers and in consequence the power press machine or safety device, as the case may be, ought not to be used after expiration of a specified period unless the said defect has been remedied, then such defect shall, immediately after the completion of the examination and test, be notified in writing, by the competent person to the occupier of the factory and, in the case of defect falling within paragraph (b), such notification shall include the period within which, in the opinion of the competent person, the defect ought to be remedied.

(2) In every case where notification has been given under sub-clause (1), a copy of the report made under sub-clause (4) of clause 9 shall be sent by the competent person to the Inspector within seven days of the completion of the examination and test.

(3) Where such defect is notified to the occupier in accordance with the foregoing provisions of this clause, the power press machine or safety device, as the case may be, having the said defect shall not be used,-

(a) in the case of a defect falling within paragraph (a) of sub-clause (1) unless the said defect has been remedied; and unless it has been thoroughly examined and tested by the competent person, in the case of a safety device, wherein position on the power press machine in connection with which it is to be used;

(b) in the case of defect falling within paragraph (b) of sub-clause (1), after the expiration of the period specified by the competent person unless said defect has been remedied and unless it has been thoroughly examined and tested by the competent person, in the case of a safety device, wherein position on the power press machine in connection with which it is to be used.

(4) As soon as is practicable after any defect of which notification has been given under sub-clause (1) has been remedied, a record shall be made by or on behalf of the occupier stating the measures by which and the date on which the defect was remedied and its copy shall be submitted to the Inspector.

(5) In every case where the defect which has been notified by the competent person sub-clause (1) has been remedied, a copy of the examination under clause 10(3) shall be sent by the competent person to the Inspector in Form no. 9-B within seven days of the completion of the examination and test thereof.

(6) All the examination reports, records, registers obtained and maintained under this rule shall be produced by the occupier to the Inspector on demand.

(7) The examination reports of the power press machines and safety devices thereon shall be preserved for two years from the date of examination.

11. Inspection and test of safety devices - (1) No power press shall be used after the resetting or adjustment of the tool thereon unless a person appointed or authorized for the purpose under clause 8 has inspected and tested every safety device thereon while it is in position on the said power press machine:

Provided that, the inspection and test as aforesaid shall not be required where any adjustment of the tools has not caused or resulted in any alteration to or disturbance of any safety device

on the power press machine and if, after the adjustment of the tools, the safety devices remain, in the opinion of such a person as aforesaid, in efficient working order.

(2) Every power press machine and every safety device thereon while it is in position on the said power press machine shall be inspected and tested by a trained person every day. A log book shall be maintained in respect of all the power press machines and safety devices and the entries shall be made about the observations made by such person.

12. Defects disclosed during an inspection and test - (1) Where it appears to any person as a result of any inspection and test carried out by him under clause 11 that any necessary safety device which is not properly in position on a power press machine or that any safety device which is in position on a power press machine is not in his opinion suitable, he shall notify the Manager of the factory forthwith.

(2) Except as provided in sub-clause (3) where any defect is disclosed in a safety device by any inspection and test under clause 11, the person carrying out the inspection and test shall notify the Manager forthwith.

(3) Where any defect in a safety device is the subject of a notification in writing under clause 10 by virtue of which the use of the safety device may be continued during a specified period without the said defect having been remedied, the requirement in sub-clause (2) shall not apply to the said defect until the said period has expired.

(4) Where such defect is notified to the Manager in accordance with the provisions of sub-clauses (1) and (2), the power press machine with safety device having the said defect shall not be used until the said defect has been remedied; and

(5) As soon as is practicable after any defect of which notification has been given under sub-clause (1) has been remedied, the Manager shall make entry in the log book.

13. Training and instructions to Operators - The workers working on the power press machines shall be informed about the hazards involved in operation of the power press machines and shall be trained and instructed in the safe method of work before starting work on any power press machine.

14. Exemptions - (1) If in respect of any factory, the Chief Inspector is satisfied that owing to the circumstances or infrequency of the processes or for any other reason, all or any of the provisions of this Schedule are not necessary for the protection of the workers employed on any power press machine or any class or description of power press machine in the factory, the Chief Inspector may by a certificate in writing (which he may in his discretion revoke at any time), exempt such factory from all or any of such provisions subject to such conditions, if any, as he may specify therein.

(2) Where such exemption is granted, a legible copy of the certificate, showing the conditions (if any) subject to which it has been granted, shall be kept posted in the factory in a position where it may be conveniently read by the persons employed.

FORM NO. 9-A

(See rule 57 Schedule VIII-A)

Register of persons appointed to carry out setting or adjusting tools or safety devices on power press machine.

1. Name of worker :
2. Serial Number as in the register of adult workers :
3. Date of birth :
4. Qualifications :
5. Period of service on work required to carry out under this Schedule :

6. Remarks :

I certify that the above mentioned person is a properly trained male adult worker as required under clause 8 of Schedule VIII-A appended to the rule 57, who is competent to carry out setting or adjusting or testing tools and safety devices on every power press machine in this factory.

Signature or left hand thumb Impression of worker

Place:

Date:

Signature of Occupier or Manager of
Factory Name of Factory (In block letters)

FORM NO. 9-B

(See Rule 57 Schedule VIII A)

Report of examination of power press machine or safety device

1. Name and Address of factory :-
2. Description of machine:-
3. Make –
Identification No.
Type –
Year of Manufacture –
Capacity in respect of power press machine –
Type of clutch –
Type of Brake –
Type of Feeding –

3-A Description of guard or safety device-1

- Make -
Identification No. -
Year of Manufacture -

3-B Description of guard or safety device-2

- Make –
Identification No. –
Year of Manufacture –

4. Date on which the power press machine or the safety device was first taken into use in the factory -

5. The date of last thorough examination carried out as per requirements of sub-clause (2) of clause 9 above. By whom?
6. Are any defects found after thorough examination of power press machine or guard or safety device?
7. Whether the power press machine, guards or safety devices positioned on the power press machine are fit for use safely? If not, furnish the details of defects and steps to be taken to remedy it in Annexure-I of this Form.

I certify that on _____ the power press machine or guard or safety devices positioned on it as described above are thoroughly examined by me and I have conducted necessary tests. And on the basis of examination and tests conducted by me, I submit the report, which is true and correct.

Name of the Competent Person

Signature

Annexure to Form 9-B

Details of defects and steps to be taken to remedy the defects in the power press machine or guard or safety device

Serial Number	Particulars of any defects affecting the safe working of the power press machine	Steps to be taken to remedy the defects

On the basis of examination and tests conducted by me, I certify that –

(a) The said defect/s is/are a cause of danger to workers and in consequence, the power press or the safety device ought not to be used until the said defect has been remedied; or

(b) The said defect/s may become a cause of danger to workers and in consequence the power press machine or safety device ought not to be used after date _____ unless, the said defects have _____ been _____ remedied.

Place _____ :

Date: _____

Signature of Occupier or

Signature of the Competent Person

Manager of factory :

Name Competent Person

Name _____

of _____

factory: _____

Dr. Mahendra Kalyankar (IAS)
 Director
 Industrial Safety and Health
 Government of Maharashtra
 Mumbai (A. C)