

# ILLUSIONS AUSTRALIA

## SAFE WORK PROCEDURE

### SWP 079 – THICKNESSER

#### 1. PURPOSE AND SCOPE

Minimum requirements for safe operation of timber thicknessers at Illusions Australia.

Applies to dimensioning suitable timber using enclosed rotating cutterheads and powered feed rollers.

#### 2. AUTHORISATION AND COMPETENCY

Only trained, competent and authorised workers may operate the thicknesser.

Operators must understand minimum stock dimensions, depth of cut, feed direction, kickback, cutterhead isolation and dust extraction.

#### 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 feed openings/rotating machinery where entanglement may occur.

#### 4. PRE-START CHECKS

Before commencing work, confirm that:

- Guards/covers are secure.
- Cutterhead and feed system are serviceable.
- Dust extraction is connected and operating.
- Table height/depth setting is correct.
- Timber is free from nails, screws and serious defects.
- Stock meets machine minimum size requirements.
- Infeed/outfeed area is clear and long stock can be supported.

#### 5. SAFE OPERATING PROCEDURE

1. Inspect timber and determine suitable feed orientation.
2. Set table/depth with machine stopped as required.
3. Start extraction.
4. Start machine and allow full speed.
5. Feed timber flat and square in the designated direction.
6. Stand to one side of potential kickback line where practicable.

7. Support long stock without lifting it against the feed path.
8. Take shallow passes within machine capacity.
9. Allow feed rollers to move stock; do not force or pull it through.
10. Switch off and isolate before clearing jams or accessing cutterhead.

## 6. PROHIBITED PRACTICES

Workers must not:

- Feed timber below safe minimum dimensions.
- Plane timber containing metal/foreign objects.
- Look or reach into feed openings while running.
- Force or pull stock through the machine.
- Take excessive depth of cut.
- Wear entanglement-prone gloves near feed openings.
- Clear jams or remove guards while energised.

## 7. KICKBACK

Timber can be ejected from the infeed side if it jams, splits or is improperly fed.

- Keep people clear of the infeed line.
- Inspect stock.
- Use correct depth and feed orientation.

## 8. CUTTERHEAD AND ISOLATION

The cutterhead may continue rotating after power is switched off.

- Wait for complete stop.
- Isolate before blade/cutter access, jam clearing or maintenance.

## 9. FAULTS, DAMAGE AND ABNORMAL CONDITIONS

Stop for abnormal noise/vibration, feed failure, kickback, cutter damage, guard fault or extraction failure.

Isolate and tag out.

## 10. SHUTDOWN AND HOUSEKEEPING

- Switch off and wait for complete stop.
- Isolate before close cleaning.
- Vacuum chips/dust.
- Clear infeed/outfeed areas.
- Report defects.

## 11. 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.

## 12. STOP WORK REQUIREMENT

Work must stop where:

- Stock is unsuitable or below safe dimensions.
- Extraction is unavailable.
- Guard/feed system is defective.
- Foreign objects are present.
- Abnormal vibration or cutter damage occurs.

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

## DOCUMENT CONTROL

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