



SOP-FAB-04 – Big Blue HD42A Rebar Bender Operation

Big Blue HD42A Rebar Bender Operation Procedure

Viking Reinforcing Ltd. – Fabrication Yard Operational Procedure
Applicable to Heavy Rebar Bending Operations – Parksville, British Columbia

Document Control

Document Number	SOP-FAB-04
Equipment	Big Blue HD42A Rebar Bender
Standards	ISO 45001:2018 Operational Control
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Revision	1.0
Effective Date	2026-03-06

1. Purpose

This procedure establishes the safe operating requirements for the Big Blue HD42A rebar bending machine used in Viking Reinforcing fabrication yard operations. The objective is to ensure large diameter reinforcing steel bending is performed safely while complying with ISO 45001 occupational health and safety requirements and WorkSafeBC regulations.

2. Scope

This procedure applies to all authorized Viking Reinforcing employees operating or maintaining the Big Blue HD42A rebar bender at the Parksville fabrication yard.

3. Equipment Description

The Big Blue HD42A is a heavy-duty hydraulic rebar bending machine designed to bend large diameter reinforcing steel bars used in structural concrete construction. The machine uses a rotating bending plate and forming pins to produce accurate bends in reinforcing steel.



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4. Responsibilities

Director of Maintenance – Sean Vetra

- Responsible for machine maintenance and mechanical integrity.

Chief Safety Officer – Dan Ansell

- Ensures safe operating procedures are followed.

Yard Foreman – Matt Warawa

- Supervises machine operators and ensures safe work practices.

Operators

- Operate equipment safely and report hazards or defects.

5. Training and Competency Requirements

Operators must:

- Receive documented training on the Big Blue HD42A
- Understand machine controls and bending sequences
- Be trained in hazard recognition and pinch point awareness
- Understand lockout/tagout procedures for maintenance

Training must be documented using FORM-OHS-11 – Worker Training Record.

6. Required Personal Protective Equipment

Operators and nearby workers must wear:

- Hard hat
- Safety glasses with side shields
- Cut resistant gloves
- High visibility vest
- CSA approved safety boots
- Hearing protection when required.

7. Hazards Associated with Operation

Major hazards include:

- Pinch points between bending plate and forming pins
- Rebar kickback during heavy bends
- Manual handling of heavy steel bars
- Crushing hazards
- Sharp steel edges
- Noise exposure.



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8. Pre-Use Inspection

Operators must inspect the machine before use including:

- Hydraulic hoses and fittings
- Bending plate and forming pins
- Machine guards
- Emergency stop function
- Control pedals and switches
- Work area hazards.

Inspection must be documented using FORM-OHS-12 – Equipment Pre-Use Inspection.

9. Safe Operating Procedure

1. Complete pre-use inspection.
2. Ensure guards and safety barriers are installed.
3. Select the correct bending configuration.
4. Position rebar securely against forming pins.
5. Maintain safe hand positioning away from bending plate.
6. Activate bending cycle using the control pedal or panel.
7. Allow machine to complete the bending cycle fully.
8. Remove bent bar carefully and place in designated area.

10. Prohibited Actions

Operators must not:

- Reach into the bending zone while machine is operating
- Bypass machine guards
- Operate defective equipment
- Allow untrained workers to use the machine.

11. Emergency Procedures

In the event of equipment malfunction or injury:

1. Press emergency stop immediately.
2. Notify supervisor.
3. Provide first aid if necessary.
4. Complete FORM-OHS-02 – Incident Report Form.

12. Maintenance and Servicing

Maintenance must be performed by qualified personnel only. Equipment must be isolated using SOP-OHS-17 Lockout/Tagout before servicing or replacing components.



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13. Records and Documentation

FORM-OHS-12 – Equipment Pre-Use Inspection

FORM-OHS-02 – Incident Report

LOG-OHS-05 – Equipment Maintenance Log

REGISTER-OHS-02 – Corrective Action Register

14. Continuous Improvement

Inspection findings, incidents, and worker feedback will be reviewed to improve safe bending practices and machine safety.