



SOP-FAB-05 – RMS Bender 11 Operation

RMS Bender 11 Rebar Bending Operation Procedure

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

Document Control

Document Number	SOP-FAB-05
Equipment	RMS Bender 11 Rebar Bending Machine
Standard	ISO 45001:2018 Clause 8.1 – Operational Control
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1. Purpose

This procedure establishes the safe operating requirements for the RMS Bender 11 rebar bending machine used in Viking Reinforcing fabrication yard operations. The objective is to ensure reinforcing steel bending activities are conducted safely, efficiently, and in accordance with ISO 45001 occupational health and safety management system requirements and WorkSafeBC regulations.

2. Scope

This procedure applies to all Viking Reinforcing employees authorized to operate or maintain the RMS Bender 11 located at the Parksville fabrication yard.

3. Equipment Description

The RMS Bender 11 is a hydraulic/mechanical rebar bending machine designed to bend reinforcing steel to specified angles required for structural concrete reinforcement. The machine utilizes a rotating bending table and forming pins to shape reinforcing steel bars.



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4. Responsibilities

Director of Maintenance – Sean Vetra

- Responsible for mechanical integrity, maintenance, and servicing of the equipment.

Chief Safety Officer – Dan Ansell

- Ensures safe operating procedures and hazard controls are implemented.

Yard Foreman – Matt Warawa

- Supervises machine operators and ensures safe work practices are followed.

Operators

- Operate equipment in accordance with this procedure and report hazards or equipment defects.

5. Training and Competency Requirements

Operators must:

- Receive documented training on the RMS Bender 11 machine
- Understand bending controls and machine functions
- Be trained in pinch point hazards and bar kickback risks
- Understand Lockout/Tagout procedures for maintenance

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

6. Required Personal Protective Equipment (PPE)

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 where noise levels require it.

7. Hazards Associated with Operation

Primary hazards include:

- Pinch points between bending table and forming pins
- Rebar kickback during bending
- Sharp edges on reinforcing steel
- Crushing hazards
- Manual handling injuries when positioning steel bars
- Noise exposure.



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8. Pre-Use Inspection

Operators must inspect the machine prior to operation including:

- Hydraulic hoses and fittings
- Bending plate and rollers
- Forming pins
- Machine guards and safety barriers
- Emergency stop functionality
- Control pedals or switches

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

9. Safe Operating Procedure

1. Conduct pre-use inspection and ensure machine is safe to operate.
2. Ensure guards and safety barriers are installed.
3. Verify the correct bending configuration and pin placement.
4. Position reinforcing steel securely against forming pins.
5. Maintain safe hand positioning away from the bending table.
6. Activate bending cycle using the control pedal or control panel.
7. Allow the bending table to complete the full cycle before removing the bar.
8. Carefully remove bent bar and place it in the designated storage area.

10. Prohibited Actions

Operators must not:

- Reach into the bending zone during operation
- Remove or bypass machine guards
- Operate defective equipment
- Allow untrained personnel to operate the machine.

11. Emergency Procedures

In the event of malfunction or injury:

1. Press the emergency stop button immediately.
2. Notify the supervisor.
3. Provide first aid if required.
4. Report the incident using FORM-OHS-02 – Incident Report Form.

12. Maintenance and Servicing

Maintenance must be carried out only by qualified personnel. The machine must be isolated and locked out according to SOP-OHS-17 – Lockout / Tagout Procedure before servicing or replacing components.



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13. Records and Documentation

FORM-OHS-12 – Equipment Pre-Use Inspection

FORM-OHS-11 – Worker Training Record

FORM-OHS-02 – Incident Report Form

LOG-OHS-05 – Equipment Maintenance Log

REGISTER-OHS-02 – Corrective Action Register

14. Continuous Improvement

Inspection findings, maintenance results, and worker feedback will be reviewed to improve safe operating practices and reduce hazards associated with rebar bending operations.