

**SAFE WORK PROCEDURES**  
Wedge Welder Qualifying

<b>Facility:</b> Field	<b>Written By:</b> Kevin Donnelly	<b>Approved By:</b> Kevin Donnelly	<b>Date Created:</b> May 15, 2009	<b>Date of Last Revision:</b> May 15, 2009
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<b>Hazards Present:</b>	<b>Personal Protective Equipment (PPE) or Devices Required:</b>	<b>Additional Training Requirements:</b>
<ul style="list-style-type: none"> <li>• Back Injury-MSI</li> <li>• Electrical Shock</li> <li>• Burns</li> <li>• Pinch Points</li> <li>• Knife cuts</li> </ul>	<ul style="list-style-type: none"> <li>• Wire Brush</li> <li>• Safety Hook Blade</li> <li>• Hard Hat</li> <li>• Safety Footwear</li> </ul>	<ul style="list-style-type: none"> <li>• Titan Wedge Welder Training</li> </ul>

**Safe Work Procedures:**

1. Start up Wedge Welder (See Wedge Welder Start Up/Shut Down Procedure)
2. Set appropriate Wedge temperature and drive wheel speed based on current ambient air temperature and sheet temperatures.
3. Allow hot Wedge to reach the temperature setting.
4. Cut 2-10' strips of the plastic to be welded both approximately 10" wide.
5. Clean both strips.
6. Load one strip under hot wedge from left side of the unit.
7. Load one strip over hot wedge from right side of the unit.
8. Engage the hot wedge.
9. Engage the drive wheels.
10. Allow welder to travel almost the full length of the strip, checking that the 2 strips are fusing together behind the welder as it travels.
11. 2-3 inches before the end of the strip, disengage drive wheels.
12. Disengage wedge.
13. Stand the welder on its nose.
14. Clean the wedge and wheels (with wire brush) if necessary.

**Guidance Documents/Standards/Applicable Legislation/Other:**

**Guidance Documents:**

- Operators Manual
- Manitoba Workplace Safety and Health Regulation, M.R. 217/2006:**
- 2.1 Safe Work Procedures
  - 6.1 Personal Protective Equipment
  - 8 Musculoskeletal Injuries MSI
  - 16.4 Machine and Tool Safety

**This Safe Work Procedure will be reviewed any time the task, equipment, or materials change and at a minimum every three years.**