

**Purpose/Application**

Pipe bending is often necessary when installing pipe line. Pipe needs to be bent to conform to the contours of the land or the needs of a current facility or structure. Pipe bending machines can either be human powered, hydraulic assisted or hydraulic motor driven. In the pipe bending operation the tube may be supported internally or externally to preserve the cross section of the pipe.

**PPE**

- Safety glasses
- Steel toed boots
- Hard hat
- Hearing protection

**TRAINING**

- Orientation
- Competency

**TOOLS/EQUIPMENT**

#	Job Steps	Hazards	Control Measures
1	Scope bend and set up joint and bend location	Slips and falls	Watch footing (ice, snow, mud)
2	Move Bending unit into location using Side Boom	Uneven ground Pinch points strains	Be aware of pinch points between the boom and the machine. Ensure solid level ground for set up.
3	Move side boom into position, roll the seam to the correct location and attach sling to pipe	Moving equipment	Ensure back up alarm is working on the side boom Use spotter to move the boom around in the vicinity of the pipe
4	Lift pipe and feed into bending machine.	Cable or hydraulic failures Pipe failing striking boom operator or worker on the ground Rigging failure	Pull bend slowly and use a qualified signal person to bend pipe Check all slings, cables, and hydraulic connections prior to starting bending operations Use side boom to keep pipe level while feeding.



#	Job Steps	Hazards	Control Measures
5	Remove pipe from bending machine	Unbalanced awkward pipe due to bend	Re-adjust slings to prevent an unbalanced load.
6	Set completed bend down on braces and crotched in preparation for welding	Awkward set, swinging or sliding pipe	Stand clear until the pipe is close to the ground and the lateral movement has stopped

**Additional Precautions:**

**REFERENCE/REGULATIONS**

- SWP 10 Noise
- SWP 45 Operating Facilities
- SWP 24 Overhead Power Lines

---

Developed by: 1. Jason Pilon 2. \_\_\_\_\_ Date: Jan 27/10  
3. \_\_\_\_\_ 4. \_\_\_\_\_

Revised by: 1. \_\_\_\_\_ 2. \_\_\_\_\_ Date: \_\_\_\_\_

---