Cold-End Surface Treatment Operations Tasks - Job Change

2021-02-12

# Purpose and Application

## Purpose

To define a work instruction for listing the tasks to be performed in the cold end surface treatment area during a job change.

## Application

This work instruction applies to all cold end surface treatment systems located at O-I facilities.

# Safety

Observe O-I standard safety requirements and procedures defined by the Global Environmental Health & Safety (EH&S) organization, as well as all applicable local, regional, and national requirements. Safety equipment and instructions specific to the completion of this work instruction are detailed in the Instructions Section.

# Instructions

Copy these steps into SAPPM - Instructions with (\*) indicate the presence of related images in the Appendix

1. Before starting the work instruction activity, perform the following steps:
2. Do not begin these tasks without confirmation that the personnel directly involved have completed the required training associated with the work instruction activity and have reviewed this document.
3. Gather necessary tools and equipment as identified below in the Equipment Section.
4. Wear and use any additional Personal Protective Equipment (PPE) and safety equipment required for this specific work instruction.
5. Obey all applicable safety requirements and procedures.
6. Notify the appropriate personnel of the activity and the estimated time needed to complete the tasks.
7. During a job change, while there are no containers in the lehr, perform the following tasks:
8. Clean or replace the spray guns.
9. Clean the drip pans.
10. Clean the sensors.
11. Confirm that the fluid filter is free of debris.
12. During a job change, while there are no containers in the lehr, perform the following tasks:
13. Align the sensors for the new containers.
14. Align the spray guns for the new containers.
15. Ensure that the timing is correct for the backup spray (if applicable).
16. Set the timing adjustment for the spray trigger (if applicable).
17. Set the cold end coating flow rate.
18. Confirm that the temperatures recorded at the containers are as specified.
19. Upon completion of tasks, perform the following steps:
20. Perform basic housekeeping duties. Clean up the work space, tools, and equipment. Dispose of trash. Put tools and equipment in their assigned areas.
21. Notify the appropriate personnel that the work instruction activity has been completed.
22. Record and report findings and results.
23. Follow the appropriate instructions for notification of findings and results relating to specifications, targets, and/or reaction limits.

# Required Training

Before performing this work instruction, applicable personnel must be trained by an authorized trainer on the required training contents listed in this document.

# References

## Document Classification

Asset Protection and Stability

## Fundamentals

SYS-331

# Approval

Sanctioning Representatives of the Global Team

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| --- | --- |
| Region | Representative |
| Europe | Andre Slagboom, Pierluigi Caravaggi, Leslaw Bojarski, Rodolphe Vallienne |
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| North America | Randy Mason, Phil Elston |
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# Revision History

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| --- | --- |
| 2017-07-20 | Approved by Chris Swingle, Global Manager Asset Reliability and Maintenance  Original Issue |
| 2021-02-12 | Approved by Richard Albanese, Global Manager Asset Reliability  Modified with the following changes:  Format changes in Section 3 to accommodate SAPPM data entry  Modified Appendix to Appendix of Images.  Modified Approval Box  Added Document Classification and Fundamentals boxes |