



DALMIA CEMENT (B) LIMITED – ARIYALUR



MECHANICAL SOP

Issue No. 01	Rev. No: 02	Effective Date: 17.10.2017	SOP/MEC/082
Issued By: M.R		Approved By: HOD Mechanical	
SOP FOR STACKER BEARING REPLACEMENT			

Scope: Stacker Bearing Replacement

Responsibility: Shift Fitter

Accountability: Mechanical-Section Engineer / Shift Engineer

PPE:

1. Safety helmet.
2. Safety shoe.
3. Nose Mask.
4. Hand Gloves
5. Safety Goggles

TOOLS:

1. Box spanner Set
2. Ring spanner set
3. Tool Bag
4. 100 Ton Hyd jack with Pump
5. Torch light / Hand Lamp.
6. Chain block 5 Ton with Sling & D shackle.
7. Cutting Set.

Hazard Analysis:

Risks associated

Body injury
Cut injury

Mitigating Measures

Safe and health tools and tackles
Safe and health tools and tackles

SOP for the Stacker Bearing Replacement

1. Take the line clearance. Use LOTO system
2. The line clearance paper should be with the person who is working in the site.
3. Use ppe's while working



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4. Clean thoroughly gallery area.
5. Removed stacker chute.
6. Fix 4 nos. hyd. Jack below gallery.
7. Remove all holding down bolts of bearing.
8. Lift the upper part of stacker (gallery)
9. Provide packing in between the lower and upper parts.
10. Fix tested chain block for pull out of bearing.
11. In new bearing fill initial grease.(As per recommended by supplier)
12. Installed the bearing
13. Put down all holding bolts
14. Give the tightening torque.
15. Put the jack the removed the packing.
16. Release the jack and fix the gallery.
17. Installed the stacker chute.
18. Clear the shutdown.
19. Take the trial .(ensure grease pump started)



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Job Safety Analysis	Job: Stacker Bearing Replacement	Date: 01 – 09 - 2014	Analysis by: Section Engineer	Reviewed by: Section Head
Title of employee doing job: Shift fitter	Supervisor: Shift Engineer / Section Engineer	Department: Operation / Mechanical	Section: Circular stacker	Approved by: HOD Mechanical.

Req'd/recommended PPE: Safety helmet, Safety shoe, Safety goggles & Cotton hand Gloves.

Sequence of Basic Job Steps	Potential Hazards	Recommended Safe Job Procedure	What Could Go Wrong	Corrective Action
Placing the jack under bearing for support	Hand Injury	Wear the hand gloves and to place the jack from side only	Hand may stuck between equipment and jack	Deploy trained person
At the time of loosening bolts	Hand Injury	Use appropriate ring spanners only do not use D-spanner	Falling by slipping	Visual inspection of tools before use
While bearing removing/fixing	Body Injury	Hold the bearing firmly to avoid slippage	Falling by slipping	Deploy trained person