



ALMIA CEMENT (B) LIMITED – CEMENT PLANT ARIYALUR

MECHANICAL SOP

Issue No. 02	Rev. No: 00	Effective Date: 01.11.2019	SOP/MECH/129
Issued By: M.R		Approved By: HOD, Mechanical.	
SOP FOR AIR BLASTER FIXING AT HOPPERS			

Scope : This SOP is applicable to Safe working for Air blaster fixing at raw coal hoppers

Responsibility : **Section Engineer – Mech.**

Accountability : **Section Incharge – Mech.**

PPE:

1. Goggles
2. Nose filter
3. Hand gloves
4. Full body safety harness.

Tools:

1. Pocking tools
2. Cutting gas set
3. Welding machine
4. Chain pulley block
5. Spanner set

Hazards:

Risks associated

Mitigating Measures

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Falling of coal through top conveyor	Get LOTO for the feeding conveyor L21 BC5
High dust emission while cleaning	Start the work after starting the raw coal hopper venting BF
Coal firing hazard	Ensure no coal inside the hopper & water washing to be done
Chain pulley block failure	Proper test certified pulley blocks to be used

Training needs:

One time Onsite job training.

Procedure:

- 1) First empty out the hopper through weigh feeders and the remaining coatings to be cleaned manually by pocking the coal coating
- 2) Ensure no coal inside the coal hopper and do water washing wherever the dust accumulation possibility is there like between the liner plates and man entry hole corners and roof plate
- 3) Remove the hopper base plate and liner plate where the air blaster nozzle will locate by gas cutting process
- 4) Fix the air blaster nozzle
- 5) Lift and fix the air blaster by chain pulley block
- 6) Provide the gasket between the nozzle flange and air blaster flange properly to avoid air leakage
- 7) Firmly tighten the flange bolts to avoid air leakage and vibration

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Records/Annexure:

1. LOTO is applicable for this operation.
2. JSA is enclosed below.

JOB SAFETY ANALYSIS: (JSA)

Job Safety Analysis	Job: Air blaster fixing at raw coal hoppers	Date: 01– 09 - 2014	Analysis by: Section Engineer	Reviewed by: Section Head
Title of employee doing job: Site in charge	Supervisor: Section Engineer	Department: Mech.	Section: Coal Mill	Approved by: HOD Mechanical.
Req'd/recommended PPE: Safety helmet, Safety shoe, Safety goggles, Nose filter & Hand Gloves.				
Sequence of Basic Job Steps	Potential Hazards	Recommended Safe Job Procedure	What Could Go Wrong	Corrective Action
Empty out the hopper through weigh feeders and the remaining coatings to be cleaned manually by pocking the coal coating	Dust emission	Start the vent Bag filter L21 BF1	More dust particle can fly	Wear eye goggle and nose filter mask
Ensure no coal inside the coal hopper and do water washing wherever the dust accumulation possibility is there like between the liner plates and man entry hole corners and roof plate	Water and coal mixing product	Drain provision to be made	Nearby equipment damage	Cover the nearby equipment's and collect the water mixing product properly
Remove the hopper base plate and liner plate where the air blaster nozzle will locate by gas cutting process	Cutting flux product	Wear safety goggles	Nozzle may slip	To be properly tied with rope
Fix the air blaster nozzle	Falling hazard	Use certified chain pulley block	Standing the works below the lifting material	Bari guard to be done



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Emergency / Emergency Shut OFF:

S L N O	ACTIVITY	ISOLATION TYPE	TAG /NAME OF THE EQUIPMENT							
			ELECTRICAL ENERGY					OTHER ENERGY		
1	Air blaster fixing	NAME AND TAG FOR THE EQUIPMENT	Equipment energy isolation					Air valve isolation		