



**DALMIA CEMENT (B) LIMITED – CEMENT PLANT
DALMIAPURAM**



Issue No. 01	Rev. No: 00	Effective Date: 01.05.2016	SOP/MECH /69
Issued By: S & P		Approved By: (HOD)Mechanical	
SOP for Rocker arm Seal changing , Patch work			

Scope/Purpose : This SOP is applicable for Rocker Arm seal changing and Patch work

Responsibility : Section Supervisor – Mechanical

Accountability : Section Head - Mechanical

PPE:

1. Safety shoe
2. Safety Helmet
3. Nose mask
4. Gloves
5. Goggles

Tools:

1. Tool Box
2. Spanners
3. Screw Drivers
4. Hammer
5. Hole punch
6. Cutting set

Hazard Analysis:

Risks associated

Smoke emission
Injury due to seal rubber removal
Probability of fire

Mitigating Measures

Ensure wearing of ppe's
Ensure proper handling of bag while removal
Ensure fire extinguisher

Training needs:

1. Emergency Preparedness
2. Training of how to Remove and fixing of Seal and rubber patching work



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Procedure:

- a) Get work permit from the concerned Mechanical Section Supervisor.
- b) Ensure Power circuit of associated machineries in Switched OFF condition and remove cable if any
- c) Ensure Temperature of Mill has come down to ambient temperature.
- d) Remove the bolts of the rocker arm seal damaged
- e) Mark measurements and cut the new seal using rubber ply.
- f) Clean the accumulate material if any below rocker arm
- g) Using hole punch make holes on the new rubber seal
- h) Fix the new rubber seal along with MS flats over the welded bolts.
- i) Tighten thee bolts to the required tightness.
- j) If slight damage found over rocker arm seals patch with rubber ply using cold joint solution.
- k) Return the work permit to concerned engineer.

Emergency / Emergency Shut OFF:

1. If any injury is there, inform to the Mechanical Shift Engineer (552 / 9865265203) or Safety Department (523) or call Emergency number 9865160055

Records/Annexure:

1. JSA is enclosed below.



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JOB SAFETY ANALYSIS: (JSA)

Job Safety Analysis	Job: Rocker Arm seal changing	Date: 18.11.2015	Analysis by: Gopalakrishnan	Reviewed by:
Title of employee doing job: Fitter	Supervisor: Section Supervisor	Department: Mechanical	Section:	Approved by:
Req'd/recommended PPE: Safety Shoe, Safety Helmet, Goggles, and Nose Mask & Gloves.				
Sequence of Basic Job Steps	Potential Hazards	Recommended Safe Job Procedure	What Could Go Wrong	Corrective Action
Fixing/Removal seal rubber	Injury due to knife for making of seal	Ensure proper handling of tools and ppe's	Damaged Tools	Periodic inspection & Replacement, ensure wearing of ppe's
Usage of welding machine for bolts welding	Injury due to electric shock. .	Ensure proper handling of tools and ppe's,	Damaged welding cables and loose earth connection	Replace lugs if found damage Ensure machine connection through ELCB.