



## DALMIA CEMENT (B) LIMITED – DALMIAPURAM



### PRODUCTION DEPARTMENT

Issue No. 02	Rev. No: 01	Effective Date: 22.05.2015	SOP/PROD/24
Issued By: S & P		Approved By: Head – Production	
SOP FOR TRANSPORTATION OF FINE COAL AND RAWMEAL FROM FLS TO KHD			

<b>SCOPE</b>	:	TRANSPORTATION OF FINE COAL AND RAWMEAL FROM FLS TO KHD
<b>RESPONSIBILITY</b>	:	CCR executive.
<b>Accountability</b>	:	Section Head – Pyro.

#### PPE:

1. Safety goggles,
2. Safety helmet,
3. Safety shoe,
4. Mask,
5. Cotton Gloves.
6. Safety harness(Full body)

#### TOOLS:

1. Poking bar,
2. Hammer.
3. showel

#### Hazard:

Risks associated:	Mitigating Measures
Fall from height,	Use of safety harness
Fall of tools;	Carry the tools in tool bags
Hit of Hammer in hand;	Trained to be engaged

#### Procedure:

##### 1. For Transporting Raw meal from FLS to KHD

- Operate the Pneumatic gates above IBAU silo as follows.
  - i) Open the Pneumatic gate towards Raw meal silos.
  - ii) Close the Pneumatic gate towards the Fine coal Bin.
- Operate the Pneumatic gates near FLS Raw meal silo as follows.
  - i) Open the Pneumatic gate in Raw meal Pumping line.
  - ii) Close the Pneumatic gate in Fine Coal Pumping line.
- Check and Ensure the Pneumatic gates are open for Raw meal Pumping.



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(Open the Valve in FLS Raw Meal silo bottom compressor air receiver tank compressor air line towards K-Pump.)

- Open the compressor air valve for K-Pump.
- Check and Ensure that the K-pump system panel healthy and ensure the following things are ok.
  - i) Supply on.
  - ii) System on.
  - iii) Convey air valve open.
  - iv) Equalization valve seal pressure ok.
  - v) Vent seal air pressure ok.
- Get clearance from KHD CCR
- Start the K-Pump.
- Check and ensure that the Raw meal powder is transporting to KHD.
- Stop the Raw meal Transport as and when instructed by FLS CCR crew.

### 2. For Transporting Fine Coal from FLS to KHD.

- i) Start the Screw conveyor 50024 and 50023 in local mode.
- ii) Start the 50014 rotary air lock in local mode.
- iii) Start the Bag filter rotary air lock and Bag filter fan in local mode.
- iv) Check and ensure that all the equipments are running.
- v) Check and ensure that the Bag filter purging is on.
- vi) Open the pneumatic gate towards Fine coal bins.
- vii) Close the Pneumatic gate towards IBAU Raw meal silo.
- viii) Check and ensure that the line is open towards Fine coal bin.
- ix) Give clearance to FLS CCR for transporting Fine coal.
- x) Open the 42ND19 motorized gate.
- xi) Ensure that 42NBL3 Blower is in line.

### 3. For Pumping Fine Coal through 42NSC3

- i) Open 42NSGF pneumatic gate.
- ii) Close 42NSGE pneumatic gate.
- iii) Change the diverter 42NDI3 towards stand by solid flow meter.
- iv) Check and ensure that the pneumatic gates and diverters are for fine coal pumping to KHD.



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- v) Start 42NBL3 Blower.
- vi) Ensure with KHD Coal mill operator the 42NBL3 Blower air is reaching KHD.
- vii) Start the 42NPP3 Screw pump.
- viii) Start 42NSC3 Screw conveyor with 100rpm.
- ix) Ensure that Fine coal is reaching KHD Coal bin.
- x) Slowly increase the 42NSC3 screw conveyor speed to 400rpm.

#### 4. For Pumping Fine Coal through 42NSC4

- i) Open 42NSGH pneumatic gate.
- ii) Close 42NSGG pneumatic gate.
- iii) Change the diverter 42NDI4 towards stand by solid flow meter.
- iv) Check and ensure that the pneumatic gates and diverters for fine coal pumping to KHD.
- v) Start 42NBL3 Blower.
- vi) Ensure with KHD Coal mill operator the 42NBL3 blower air is reaching KHD.
- vii) Start 42NPPC Screw pump.
- viii) Start the 42NSC4 screw conveyor with 100 rpm.
- ix) Ensure that Fine Coal is reaching KHD coal Bin.
- x) Slowly increase the 42NSC4 screw conveyor speed to 400 rpm.

#### 5. For Stopping the Fine Coal Pumping.

- i) Stop the Fine coal Screw 42NSC3 or 42NSC4.
- ii) Run the 42NBL3 Blower and 42NPP3 screw pump for 30 mins. For emptying out the line.
- iii) Stop 42NPP3 screw pump.
- iv) Stop 42NBL3 Blower.
- v) Stop the Bag filter fan and Rotary air lock meant for pumping.
- vi) Stop 50014 Rotary air lock.
- vii) Stop 50023 and 50024 screw conveyors.

<b>Job Safety Analysis</b>	Job: Coal pumping from FLS to KHD	Date: 01 – 09 - 2013	Analysis by: Section Incharge	Reviewed by: Section Head
<b>Title of employee doing job:</b>	Supervisor: Sec. Incharge	Department: Production	Section: Fine coal transport group	Approved by: Department Head



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Req'd/recommended PPE:

Sequence of Basic Job Steps	Potential Hazards	Recommended Safe Job Procedure	What Could Go Wrong	Corrective Action
Cleaning of the jam in Coal pipe	pipe hit to the person	Hold the Pipe properly, if there any possible tie it one end.  Use safety goggles and dust mask	Pipe may hit the person while cleaning the box.  Proper site evacuation to be known to all person	Hazards to be explain to the people who are working in that area by safety PeP talk, tool box talk.  Use proper PPE in respective areas
Cleaning of fine coal dust spillage	Hot material cause burn injury	Use hand gloves and shovel for cleaning hot powder	Hot powder may entrapped into shoes	Use proper safety asphestos PPE's

#### Emergency Shut- off:

1. If body injury is there, First aid will be given and inform to the Safety department or Call Emergency number 233/555/9865125176/9865177444.

#### Records/Annexure:

1. Refer Line clearance certificates.
2. JSA as enclosed below.

HOD PRODUCTION

HOD TECHNICAL