



MECHANICAL

Issue No. 01	Rev. No: 02	Effective Date: 02.06.2020	SOP/MEC/203
Issued By: M.R		Approved By: HOD-Mechanical	
SOP FOR CLASSIFIER ANNULAR GAP REDUCTION			

SOP FOR CLASSIFIER ANNULAR GAP REDUCTION

Scope	: This SOP is applicable to Safe working of Classifier annular gap reduction
Responsibility	: Section Engineer mech
Accountability	: Section Incharge mech

PPE:

1. Safety harness(Full body)
2. Safety helmet,
3. Safety shoe,
4. Nose Mask,
5. Hand gloves
6. Safety goggles

TOOLS:

1. spanner set
2. chain blocks
3. Crowbar
4. Slings
5. D-shackles
6. Hydraulic jack

Hazard Analysis:

Risks associated:

Fall from height,
Hand or Leg slipping in to the rotary vanes
Fall of chain Block
Fall of tools,
Contact with hot body

Mitigating Measures

Use of safety harness
Locking the movement of rotor
Use certified chain block as required
Carry the tools in tool box/bag
Use of hand gloves/apron



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Procedure:

1. Line clearance to be taken for classifier as per DCBL LOTO standard
2. The line clearance paper should be with the authorized person who is working in the site.
In case of man entering inside the mill take the confined area work permit from the relevant department and allow the persons to work
3. Use PPE's while working.
4. Open the main man entry door.
5. Remove the coating/material in the classifier body
6. Fix the safe access in surrounding of classifier body
7. Shift the plate from outside of mill to inside of classifier body in safe manner
8. Fix the plate in classifier body as per drawing
9. Direct earth to be connected
10. By using the certified welder & welding machine the job can be start
11. After the welding, the plate joint area to be check for any gap
12. Remove the access inside of classifier in safe manner
13. Clear the scrap material inside of mill
14. Close the Main man door
15. Clear the LOTO and take the trail run
16. If it found Ok then inform to the CCR for operation

Emergency Shut- off:

In such cases, the rotary air lock must be placed on floor and chain block should be freed from load. All tools and tackles should not be in the workstation, to be placed in the tool box/ floor in a systematic manner in order to avoid fall of the same.

Emergency / Emergency Shut OFF:

1. If any injury takes place, provide First aid and inform to the Safety department or Call Emergency number 3108/9865152222

Records/Annexure: Job safety analysis.

JOB SAFETY ANALYSIS :(JSA)



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Job Safety Analysis	Job: RAL Disc welding	Date:21.04.2020	Analysis by: Section Engineer	Reviewed by: Section Head
Title of employee doing job: Section Incharge	Supervisor: Section Engineer (Mech.)	Department: Mechanical	Section: VRM'S	Approved by: HOD Mechanical
Req'd /recommended PPE:				
Sequence of Basic Job Steps	Potential Hazards	Recommended Safe Job Procedure	What Could Go Wrong	Corrective Action
Position of the chain blocks for fixing the plate	Leg and hand injury	Use correct lifting Tackles Teflon/wire rope slings	Chain block may slip and fall while removing and inserting the belt	1. Check the condition of the ropes and slings 2. Check the correct size of slings to operate/actual capacity and ensure certificate of clearance.
Lock plate by welding the angle	Leg injury	Use proper lifting tools to lift the material	Material may slip during tag welding	Ensure the person Lifting the material as per lifting procedure
Fixing the safe access	Leg and hand injury	Use proper standard tool for removing the bolt .	Material may slip	Ensure the person using proper PPE



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Isolation Matrix:

1	Mill classifier annular gap reduction	Name and Tag for the Equipment	561MD2 / Mill Main Motor	561SR1 / Classifier	561FN1 / Mill Fan	561AD2/ Axilary drive Chain not to be connected	Rollers Position Landed & Pressure Zero at Pannel	561DV1 / Diveting Gate Air Valve.
		Name and Tag for the Equipment	561RA1 / Mill feed RAL	561FN4 / Booster fan	561SD2 / Hot Air Shut-off Damper(In closed condition only)			
		Name and Tag for the Equipment	K21 RA4 / DFA Feed RAL	371SD66 / Damper(In closed condition only)				