



DALMIA CEMENT (B) LIMITED – CEMENT PLANT
ARIYALUR
MECHANICAL DEPARTMENT

Issue No. 02	Rev. No: 00	Effective Date: 01.11.2019	SOP/MECH/163
Issued By: M.R		Approved By: HOD (MECHANICAL)	
SOP FOR TABLE & ROLLER WEAR READING MEASUREMENT			

Scope : This SOP is applicable to Safe working for Mill Roller & Table wear reading

Responsibility : Section Engineer.

Accountability : Section Head – Mills

PPE:

1. Safety helmet,
2. Safety shoe,
3. Mask.
4. Gloves.
 1. Cotton knitted
 2. Leather
5. Ear Plug
6. Safety belt
7. Goggles
8. Welding Shield

Tools:

1. Hammer
2. Box Spanner set
3. Ring Spanner set

Auxiliaries

1. Welding Set
2. Cutting Set

Hazards:

Risks associated

Welding Gas

Mitigating Measures

Wear Goggle

Training needs:

1. Emergency preparedness
2. On job training



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Procedure:

1. Take shutdown for mill and Open the mill door, torque support doors, Scraper chamber doors.
2. Start the mill fan to reduce the temperature by cooling the mill.
3. After getting outlet temperature to 40 deg. Stop the fan
4. Take all required Line clearance.
5. Take Confined permit from Safety and process department.
6. Put 24v Lighting inside the mill
7. Provide a watch person near the confined entry.
8. Allow the maintenance workmen inside the mill
9. By using templates wear reading has to be taken each roller
10. If roller wear reading above 15 mm we can plan for hard facing
11. Clean the table between R1 & R2, R2&R3 space for measure wear reading as per template
12. If TABLE wear reading above 20 mm we can plan for hard facing
13. Remove all machines tools and tackles.
14. Clear the mill table from scrap materials and metal pieces.
15. Close the door.
16. Clear the line clearance taken
17. Surrender the permits.

Emergency / Emergency Shut OFF:

Switch off all drives and welding panels.

Watch person should ensure all persons got exited

Bariguard the entry and assemble as per Emergency procedure

Records/Annexure:

1. JSA as enclosed below.



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2. Isolation Matrix.

Emergency / Emergency Shut OFF:

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

JOB SAFETY ANALYSIS:(JSA)

Job Safety Analysis	Job: Hard facing Work	Date: 06 – 05 - 2019	Analysis by: Section Engineer	Reviewed by: Section Head
Title of employee doing job: Section Engineer	Supervisor: Section Head, Out Sourcing Supply Supervisor	Department: Mechanical	Section: Mills	Approved By: HOD-Mechanical
Req'd/recommended PPE: Helmet, Shoe, Nose mask, Cotton Gloves, Leather gloves, Ear plug, Safety belt, Goggles, Shield				
Sequence of Basic Job Steps	Potential Hazards	Recommended Safe Job Procedure	What Could Go Wrong	Corrective Action
Put on PPE	Exposure to fumes due to welding operation Exposure to noise generation Dust inhalation	Wear Goggles Wear Ear Plug Wear Nose Mask	Damaged goggle Damaged Plug Damaged Mask	Periodic replacement, Watch person should ensure
Lightings	Electric Shock	Use only 24v lamps	Using 230 v lamps	Watcher should ensure the availability of 24v lamps
Cleaning of Table & Mill Table	Caught between	Should allow only trained person to clear After completing cleaning only table cleaning should start	Giddiness may occur to workmen Person can enter without intimation	t should take for workmen Watcher should ensure pressure frame cleaning persons came out of the mill
Closing of mill door	Hand injury	Trained person should involve in job.	Finger may crush between door	Supervisor should take care of working



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S L N o	Activity	Tag / Name of the Equipment									
		Isolation Type									
		Electrical Energy					Other Energy				
1	VERTICAL ROLLER MILL – Table & roller wear reading	Name and Tag for the Equipme nt	561 MD2 Mill Main Motor	561SR1 Classifi er	561FN4 Mill Fan						
		Name and Tag for the Equipme nt	561RA1 Mill feed RAL	561FN1/ Booster fan	371 SD6 Hot gas damper (In closed Conditio n)						
		Name and Tag for the Equipme nt	K21 RA 4 Dry flyash RAL	561 WP1,2,3 Water Pump							