



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



Issue No. 01	Rev. No: 00	Effective Date: 01.05.2016	SOP/MECH /68
Issued By: S & P		Approved By: (HOD)Mechanical	
SOP for Mill rotor Blade changing work			

Scope/Purpose : This SOP is applicable for Mill rotor blade changing 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

Fall Injury
Injury due to equipment
Probability of fire

Mitigating Measures

Ensure wearing of ppe's
Ensure proper power isolation
Ensure fire extinguisher

Training needs:

1. Emergency Preparedness
2. Training of how to remove and fixing of Rotor Blades.



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



Issue No. 01	Rev. No: 00	Effective Date: 01.05.2016	SOP/MECH /68
Issued By: S & P		Approved By: (HOD)Mechanical	
SOP for Mill rotor Blade changing work			

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) Tie the rotor blades with Ropes from top.
- e) Remove the bolts of rotor blades and lift up the worn-out blades
- f) Insert the new rotor blades using rope and position in the rotor.
- g) Using hole punch align the holes in rotor and blades
- h) Fix the new blade and tighten the bolts to required torque.
- i) Continue the same steps for all remaining blades.
- j) 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.



DALMIA CEMENT (B) LIMITED – CEMENT PLANT DALMIAPURAM



Issue No. 01	Rev. No: 00	Effective Date: 01.05.2016	SOP/MECH /68
Issued By: S & P		Approved By: (HOD)Mechanical	
SOP for Mill rotor Blade changing work			

JOB SAFETY ANALYSIS: (JSA)

Job Safety Analysis	Job: Rotor blade changing work	Date: 18.11.2015	Analysis by: Gopalakrishnan	Reviewed by:
Title of employee doing job: Fitter, Khalasi, welder	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 blades	Injury due to fall of blades/ slip of blades	Ensure proper handling of tools and ppe's	Damaged Tools/ ropes	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.