



DALMIA CEMENT (B) LIMITED – ARIYALUR



MECHANICAL SOP

Issue No. 01	Rev. No: 02	Effective Date: 17.10.2017	SOP/MEC/063
Issued By: M.R		Approved By: HOD Mechanical	
S.F. COOLER U-PROFILE REPLACEMENT			

Scope:

This SOP is applicable for S.F. Cooler U-profile replacement safely.

Responsibility : Section Engineer – Mech.

Accountability : Section head – Mech.

PPE:

1. Helmet,
2. Safety shoe,
3. Goggles
4. Gloves.
5. Nose mask
6. Full body harness

Tools:

1. Spanner set
2. Hammer

Hazards:

Risks associated

1. Body injury
2. Leg injury
3. Hand injury

Mitigating Measures

1. Safe and tested tools and tackles
2. On job training



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Isolation matrix:

Sl: No	Activity	Description	Electrical Energy			Other Energy	
1	SF Cooler U profile replacement	Name and Tag for the Equipment	Cooler all four drives	Cooler all fans (471FN1 to 471FN7)	(471CC1) Hammer crusher & Cooler water spray pump (471WP1)	Inlet air blasters Compressor air Valve to be Closed & locked	Air in the Header to be released
			Primary Air fan 481FN2&3	(461KL1) Kiln main drive	(461AD1) Kiln aux	Hydraulic line pressure to be made zero	
			(431MD1& MD2)Ph bucket elevator	Kiln (481BL1) and pc (451BL1) & Standby blowers	Pre-heater (441FN1) and ESP fan (471FN8)	Cooler water spray pump valve closing after line made zero	

SOP for S.F. Cooler U-profile replacement

1. Energy isolation of the equipment to be taken from the concern department as per above matrix.
2. Ensure use of PPE & dust mask etc
3. Take Confined Area work permit from the safety department and process
4. Open the doors of cooler.
5. Arrange proper lightening inside the cooler.(24 v)
6. Clean the clinker bed of the cooler and put it into the circuit.



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7. Remove the locking wedges & spring pins from cross bar retainer bracket
8. Remove the retainer bracket
9. Remove the Cross bars movable & stationary
10. Remove the U-profile
11. Fix the new U-profile in position
12. Fix the new cross bar on the position
13. Fix the retainer bracket
14. Fix the wedges in position
15. Measure the gap between stationary cross bar & U-profile (2 to 6mm)
16. Measure the gap between U-profile & ADP plate-2mm
17. Drill the locking wedges by hand drilling machine (drill size-8mm)
18. Fix the new spring pins of 8mm
19. Remove all old item & return back into stores.
20. Clear all LC's & Return the work permit.
21. Take trail of the cooler & check the cooler in operation.

Emergency / Emergency Shut OFF:

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

Records/Annexure:

1. Refer Line clearance/permit in mech department.
2. JSA is enclosed below.

JOB SAFETY ANALYSIS :(JSA)



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Job Safety Analysis	Job: Cooler "U" profile replacement	Date: 01/9/2014	Analysis by: Section Engineer	Reviewed by: Section Head
Title of employee doing job: Section Engineer	Supervisor: Section Head	Department: Mech.	Section: PYRO	Approved by: HOD Mechanical
Req'd/ recommended PPE: Safety helmet, Safety shoe, Gloves, Goggles, Gloves, Nose mask & Full body harness				
Sequence of Basic Job Steps	Potential Hazards	Recommended Safe Job Procedure	What Could Go Wrong	Corrective Action
Opening of the cooler doors	hand injury	Use proper tools and tackles so that fasteners will not slip	Fasteners may slip and tools may hit to the hand and leg	Ensure Use/working condition of TOOLS AND TACKLES.
Clean the clinker bed & check the condition	Health injury	Use goggles & nose mask & 24 V lights	Dusty area (Clinkers fines) may leads to suffocation & eye problem	Ensure Use of goggles & nose mask. Use 24 V lights for working
Removing of locking wedges, spring pins & retainer bracket	Leg and hand injury	Use proper tools and tackles for safe removing	Fasteners may slip and tools may hit to the hand and leg.	Ensure Use/working condition of TOOLS AND TACKLES.
Replacement of U-profile	hand injury	Use hand gloves	Worn out profile sharp edges may injure the fingers	Ensure Use of hand gloves
Fixing of retainer bracket, locking wedges, spring pins	Leg and hand injury	Use proper tools and tackles for safe fixing of	Fasteners may slip and tools may hit to the hand and leg.	Ensure Use/working condition of TOOLS AND TACKLES.