



**DALMIA CEMENT (B) LIMITED – CEMENT PLANT  
ARIYALUR  
ELECTRICAL MANUAL**

Issue No:02	Rev. No: 00	Effective Date: 01.11.2019	SOP/Elect /053
Issued By:		Approved By: HOD - ELECTRICAL	
SOP For Overhauling of thruster break Motors			

**Scope** : This Procedure to establish and ensure safe method of Overhauling of Thruster break Motors

**Responsibility** : Section Engineer – Electrical

**Accountability** : Section Head-Electrical

**PPE:**

1. Safety helmet,
2. Safety shoe,
3. Cotton gloves,
4. LT Rubber gloves.

**Tools:**

1. Insulated tools,
2. Lifting Equipment's.

**Hazard Analysis:**

**Risks associated**

Injury  
Electric shock

**Mitigating Measures**

Use of proper Handling equipments  
Use of Proper Testing procedure & Insulated tools

**Training needs:**

1. Usage of tools and Nature of Hazards
2. Usage of PPEs

**Procedure:**

1. Take the LOTO permit for the particular Motor as per ELEC/SOP/003 and General Work permit.
2. Clean the Motor with Wire Brush, Hand Blower & Cloth, while cleaning use PPEs like Nose mask, goggles and hand Gloves.



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3. Discharge the Motor terminals after opening the terminal box Cover while opening, handle cover firmly.
4. Disconnect the motor power and earth connections after marking of connection while disconnecting, use proper tools.
5. Remove the motor by removing the cotter pin and shaft on the both top and bottom end of the motor.
6. Shift the Motor to dust free environment for overhauling. While shifting, handle the motor properly and avoid the fall of motor & tools. For shifting the motor use tested lifting equipment and other accessories.
7. Drain the oil from the bottom drain plug.
8. Dismantle the top end cover with bearing housing, while dismantling use proper tools.
9. Remove the stator winding assembly from the thruster, while removing handle the stator firmly to avoid the stator winding damage.
10. Dismantle the bottom cover in order to access the impeller with proper tools and check the condition of the Teflon impeller and Teflon covers on both the ends of the impeller.
11. Clean the rotor, stator winding and thruster assembly with cloth, while cleaning use PPEs like goggles and hand Gloves.
12. Check the condition of the rotor and extended shaft, if it is found damaged remove the rotor and replace it or if possible repair it with proper tools.
13. Check the condition of the DE, NDE bearing and DE oil seal.
14. If required, remove and replace the bearings and oil seal using proper tools.
15. If required, remove and replace the Teflon impeller and covers using proper tools.
16. Check the stator winding resistance and insulation value using certified measuring instruments.
17. Apply the varnish to the stator winding if required.
18. If varnish applied stator winding is to be dried out in the clean environment.



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19. Assemble the impeller and close the bottom cover with proper tools.
20. Assemble the stator winding over the rotor, while assembling; handle the stator firmly to avoid stator winding damage.
21. Ensure no availability of foreign material in the stator and rotor assemblies and fix the top end cover and Bearing housing with proper tools and body.
22. Check the Power Cable Connection Tightness & Condition of Terminal Block with proper tools.
23. Check the Insulation Resistance, Winding Resistance and Inductance of the Motor winding.  
After checking the Insulation resistances again discharge the motor terminals.
24. Fill the thruster with transformer oil.
25. Take no load trial if possible and use rubber Mat & Gloves for trial run.
26. Close the Motor Terminal box cover and box up with Silicon Paste to restrict the dust entry.
27. Shift the Motor to EOT crane machine room. While shifting, handle the motor properly and avoid the fall of motor & tools. For shifting the motor use tested lifting equipment and other accessories.
28. Fix the motor in the spring loaded break assembly with proper locking shaft and cotter pin.
29. Connect the motor power and earth connections as per marking. While connecting, use proper tools.
30. Clear the LOTO permit as per ELEC/SOP/004.

Take Trial if Possible and record all Check point in the concern Check list

**Emergency / Emergency Shut OFF:**

1. If electrical shock injury or body injury is there, give First aid and inform to the Safety department or Call Emergency number 3108/9865152222/9750963761.

**Records/Annexure:**



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1. Refer LOTO permit.
2. JSA as enclosed below.

## JOB SAFETY ANALYSIS: (JSA)

<b>Job Safety Analysis</b>	Job: Overhauling of LT Motors	Date:	Analysis by:	Reviewed by:
Title of employee doing job: Electrician	Supervisor: Section Engineer	Department: Electrical	Section: Plant	Approved by:
Reqd./recommended PPE: Safety helmet, Safety shoe & Rubber Gloves, Cotton hand gloves.				
Sequence of Basic Job Steps	Potential Hazards	Recommended Safe Job Procedure	What Could Go Wrong	Corrective Action
Cleaning of Motors	Eye irritation of dust.	Wear goggles	Damaged goggles/non standard goggles/ Not wearing goggle	Periodic replacement / Proper training / Follow SOP
	Respiration problem of dust	Wear Nose mask	Damaged nose mask/Not wearing Nose mask	Periodic replacement/ Proper training/ Follow SOP
	Body injury	Wear safety helmet, safety shoes , hand gloves	Tools and material may fall on human body	Without PPE don't perform the job/ Proper training / Follow SOP
	Oil spillage	Use oil tray	Slip due to oil spillage	Follow SOP
Open the motor terminal box cover to discharge	Electrical shock	Use Tested Electrical Rubber Hand gloves	Damaged Gloves/ Not checked before use	Periodic replacement/ To check for Damage before use
Cable disconnection and decoupling	Body injury	Wear safety helmet, safety shoes , hand gloves	Tools and material may fall on human body	Without PPE don't perform the job/ Proper training / Follow SOP
Shifting of Motor	Fall of object	Proper shifting method	Slip during shifting	Double holding method
Dismantling of motor	Injury due to striking	Proper dismantling methods	Slip of tools during striking	Usage of proper tools Tool box Pep talk
Applying Varnish	Unconsciousness	Proper Varnishing method	Release of Toxic gases during varnishing	Usage of quality varnish & Proper Varnishing method



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Heating of Winding	Electric Shock	Proper heating method	Open ended terminals	To be take extra precaution during heating
Assembly of motor	Injury due to striking	Proper assembling methods	Slip of tools during striking	Usage of proper tools Tool box Pep talk
Shifting, cable connection	Fall of object	Proper shifting method	Slip during shifting	Double holding method
	Body injury	Wear safety helmet, safety shoes , hand gloves	Tools and material may fall on human body	Without PPE don't perform the job/ Proper training / Follow SOP
Trial Run of Motor	Electric shock	Proper method for Trial run	Open ended terminals / Improper Earthing	Usage of proper trial methods & Ensuring proper earthing
	Body injury due to loose clothing	Wear cover all suit, safety goggles, cotton clothes, safety shoes, safety helmet	Loose cloth may get caught with the rotating shaft makes severe injuries	before approach the motor, make sure of proper clothing and PPE