



Mechanical SOP

Issue No:01

Rev No:02

Effective Date: 17/10/2017

SOP/MEC/25

ISSUED BY : (MR)

APPROVED BY: HOD Mech.

SOP FOR CLEARING ROTARY AIR LOCK**Scope** : This SOP is applicable for Safe working of Mill Feed rotary air lock jam clearing Work**Responsibility** : Section Engineer.**Accountability** : Section Head**PPE:**

1. Safety helmet
2. Safety shoe
3. Dust mask
4. Cotton Knitted hand Gloves
5. Ear Plug
6. Full Body harness
7. Goggles

Tools:

1. Spanner set-1 no
2. 10 Ton Jack -1no

Hazards:**Risks associated**

Hot gas and Fine Dust

Mitigating Measures

Wear Goggles and Dust Mask

Training needs:

1. Emergency preparedness
2. On job training

Isolation Required:

- Rotary air lock

Procedure

1. Ask CCR people to keep RAL in local mode.
2. Rotate RAL in reverse/forward direction wherever it trips with wet/lump material.
3. If it does not rotate, take LOTO permit.
4. Lock the rotor blade with locking bolt (locking bolts are in casing).
5. Open RAL side door and remove accumulated material.
6. Don't send persons inside RAL casing.
7. After removing the jam material, check the RAL blades condition and gap.
8. Clear LOTO permit and rotate in reverse direction in local mode.
9. Check the current at empty load.
10. When RAL is free, close the man whole door and ask the CCR people to take it in sequence.

Emergency / Emergency Shut OFF:



DALMIA CEMENT (B) LIMITED, Ariyalur



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1. 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 certificates.
2. JSA as enclosed below



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SOP FOR CLEARING ROTARY AIR LOCK**Job Safety Analysis:**

Job Safety Analysis	Job: RAL Jam Clearing	Date: 01/09/2014	Analysis by: Section Engineer	Reviewed by: Section Head
Title of employee doing job: Fitter	Supervisor: Section Sr. Engineer (Mech.)	Department: Mechanical	Section: VRM'S	Approved by: HOD mech.

Req'd /recommended PPE:

Sequence of Basic Job Steps	Potential Hazards	Recommended Safe Job Procedure	What Could Go Wrong	Corrective Action
Rotate RAL in reverse/ forward direction wherever it trips with wet/lump material	Minor Injury	Ensure the inspection door & coupling guard is in closed condition	To remove choke work men may open the inspection door & operate the RAL Contact of body parts with rotating equipment.	Engage trained workmen. Continuous supervision of site engineer is required
Open RAL side door and remove accumulated material.	Injury / fracture	Ensure LOTO procedure & rotor is locked at blades to casing to avoid movement	Slippage of tools.	Engage trained workmen. Use PPE
Rotate in reverse /forward direction in local mode.	Minor Injury	Ensure the inspection door is in closed condition	To remove choke work men may open the inspection door & operate the RAL Contact of body parts with rotating equipment.	Engage trained workmen. Continuous supervision of site engineer is required



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Isolation Matrix:

S. N o	Activity				Tag / Name of the Equipment	
					Isolation Type	
					Electrical Energy	Other Energy

1	CLEA RING ROTA RY AIR LOCK	Name and Tag for the Equipment	361MD2 / Mill Main Motor	361SR1 / Classifier	361FN3/ Raw Mill Fan			
		Name and Tag for the Equipment	371FN3 / Booster fan					