



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



|                                  |             |                              |              |
|----------------------------------|-------------|------------------------------|--------------|
| Issue No. 01                     | Rev. No: 00 | Effective Date: 01.05.2016   | SOP/MECH /67 |
| Issued By: S & P                 |             | Approved By: (HOD)Mechanical |              |
| SOP for GCT Nozzle Cleaning work |             |                              |              |

**Scope/Purpose** : This SOP is applicable for GCT Nozzle Cleaning 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. Fork

**Hazard Analysis:**

**Risks associated**

Injury due to Slippage  
Injury due to chemical

**Mitigating Measures**

Ensure wearing of ppe's  
Ensure precautions for chemical contact

**Training needs:**

1. Emergency Preparedness
2. Training of how to clean the GCT nozzle



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**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 GCT has come down to ambient temperature.
- d) Remove the Existing nozzle using spanners.
- e) Hold the nozzle using fork and dip in the acid bowl for cleaning.
- f) After cleaning just dip in water and fix the nozzle in lance
- g) Tighten the nozzle nuts with the lance.
- h) Continue the same steps for all remaining blades.
- i) 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.



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**JOB SAFETY ANALYSIS: (JSA)**

| <b>Job Safety Analysis</b>  | Job: GCT Nozzle cleaning work  | Date: 18.11.2015                           | Analysis by: Gopalakrishnan                       | Reviewed by:   |
|---|--------------------------------|--|---|--|
| Title of employee doing job: Fitter, Khalasi  | Supervisor: Section Supervisor | Department: Mechanical                     | Section:  | Approved by:   |
| Req'd/recommended PPE: Safety Shoe, Safety Helmet, Goggles, and Nose Mask & Gloves. |                                |  |   |  |
| <b>Sequence of Basic Job Steps</b>  | <b>Potential Hazards</b>       | <b>Recommended Safe Job Procedure</b>      | <b>What Could Go Wrong</b>                        | <b>Corrective Action</b>                                   |
| Fixing/Removal of Nozzle  | Injury due to slippage         | Ensure proper handling of tools and ppe's  | Damaged Tools/ PPE's may cause slippage from hand | Periodic inspection & Replacement, ensure wearing of ppe's |
| Usage of Chemical/ Acid for cleaning  | Injury due to chemical contact | Ensure proper handling of tools and ppe's, | Acid /chemical contact with hand during cleaning  | Usage of hand gloves and proper fork for cleaning.         |