



Mechanical SOP

Issue No:02 Rev No:00 Effective Date: 01/11/2019 SOP/MEC/043

ISSUED BY : (MR) APPROVED BY: HOD Mechanical.

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.

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SOP FOR CLEARING ROTARY AIR LOCK**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 certificates.
2. JSA as enclosed below.

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 Mechanical

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

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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