



DALMIA CEMENT (B) LIMITED – DALMIAPURAM



PRODUCTION DEPARTMENT

Issue No. 02	Rev. No: 01	Effective Date: 22.05.2015	SOP/PROD/08
Issued By: S & P		Approved By: Head – Production	
SOP FOR Raw Meal blending & feeding to KHD Kiln			

SCOPE : Raw Meal blending & feeding to KHD Kiln

RESPONSIBILITY : CCR executive.

Accountability : Section Head – Pyro.

PPE:

1. Safety goggles,
2. Safety helmet,
3. Safety shoe,
4. Mask,
5. Cotton Gloves.
6. Safety harness(Full body)

TOOLS:

1. Poking bar,
2. Hammer.
3. showel

Hazard:

Risks associated:

Mitigating Measures

Fall from height,

Use of safety harness

Fall of tools;

Carry the tools in tool bags

Hit of Hammer in hand;

Trained to be engaged

Procedure:

- Check the silo level & raw meal values of silo No. 1 & 2 from previous hour or last sample analysis of kiln feed. Decide from which silo raw meal is to be extracted for kiln feeding.
- Get the clearance from VRM-II M/A as per Work Instruction for extracting raw meal from the required silo in accordance to Work Instruction
- Start Feed Group(411) with SFF1/SFF2 in circuit, depending upon the availability, in recirculation mode at around 100 tph and ensure all the drives are running



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- Start extraction group(321) with silo-I (or) silo-II (or) both depending upon the decision made as per 5.1 above and ensure all the drives in the selected group are running.
- Check and ensure raw meal is extracted from silo, filled in the control bin and recirculated
- When the Kiln becomes ready to take feed, select the “KILN” key in the 411 group and ensure the feed gets diverted to preheater automatically
- Regulate the feed rate accordingly to Kiln / P.H. condition
- Monitor the filling and discharge of control bin for proper working
- Inform the Chemist in shift about extraction silo number
- Atleast once in a shift check the accuracy of solid flow feeder and correct as given below
 - When the enable indicator (green) near the “Cont. Meas. ON” key is ON, press the “Cont. Meas. ON” key and wait till the flashing of key stops.
 - When the measurement is over note down the error in the “loss in weight note book” and corrects the error by pressing “Correct Error” button, if there is any error.
- Ensure that the initial and final raw meal flow counter readings are automatically recorded in the Kiln Log sheet in each shift. In case of any problem in auto recording, inform the concerned engineers and record manually till the problem is rectified
- The silo extraction is changed from one silo to other or to both according to the requirement

Job Safety Analysis	Job: Belt Discharge chute cleaning	Date: 01 – 07 - 2013	Analysis by: Section Incharge	Reviewed by: Section Head
Title of employee doing job:	Supervisor: Sec. Incharge	Department: Raw mill	Section: All Air slides	Approved by: Department Head

Req'd/recommended PPE:

Sequence of Basic Job Steps	Potential Hazards	Recommended Safe Job Procedure	What Could Go Wrong	Corrective Action
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Cleaning of the jam in Air slides	pipe hit to the person	Hold the Pipe properly, if there any possible tie it one end.	Pipe may hit the person while cleaning the box.	Hazards to be explain to the people who are working in that area by safety PP talk, tool box talk.
Inspecting the Air slides	Dust emission	Use safety goggles and dust mask	Proper site evacuation to be known to all person	Use proper PPE in respective areas
Cleaning of raw meal dust spillage	Hot material cause burn injury	Use hand gloves and shovel for cleaning hot powder	Hot powder may entrapped into shoes	Use proper safety asphestos PPE's

Emergency Shut- off:

1. If body injury is there, First aid will be given and inform to the Safety department or Call Emergency number 233/555/9865125176/9865177444.

Records/Annexure:

1. Refer Line clearance certificates.
2. JSA as enclosed below.

HOD PRODUCTION

HOD TECHNICAL