



DALMIA CEMENT (B) LIMITED – CEMENT PLANT
DPM
MECHANICAL DEPARTMENT



Issue No. 02	Rev. No: 01	Effective Date: 22.05.2015	SOP/MECH/27
Issued By: S & P		Approved By: Head - Mech	
SOP-JSA FOR WEIGHFEEDER BELT REPLACEMENT			

Scope : This SOP is applicable to Safe working for Weigh Feeder Belt Replacement.

Responsibility : **Section Engineer – Mech.**

Accountability : **Section Incharge – Mech.**

PPE:

1. Helmet,
2. Safety shoe,
3. Safety belt,
4. Safety goggles.
5. Asbestos Gloves.

Tools:

1. chain block-1no
2. Web (Nylon) slings-2Nos.
3. Box Spanner set
4. Ring Spanner set

Hazards:

Risks associated

Body injury

Mitigating Measures

safe and tested tools and tackles

Training needs:

1. Fire fighting
2. Emergency preparedness
3. Assembly procedure

Procedure:

1. Planning and informing to CCR for making hopper empty.
2. Use PPE's while working.
3. Closing the hopper pin gates.
4. Ensure to take line clearance for weigh feeder & Hopper Feeding Conveyor.
5. Loose the take up adjustment bolts completely.
6. Remove the skit rubber and top hood.
7. Arrange chain block for hold the weigh feeder.
8. Remove the weigh feeder bottom base supports at one side.
9. Arrange lifting tackle of weigh feeder.
10. Remove old belt manually.
11. Clean the roller with air (Blower).
12. Check all rollers are rotating freely.
13. Insert the new belt sleeve and fix the base supports.
14. Fix the top hood and skit rubber Boards & rubbers.
15. Tension the belt suitably and remove chain blocks.



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16. Clear the line clearance for weigh feeder drive.
17. Adjust the belt to run at center of the Head & tail drums.
18. When belt obtain center position weight calibration to be done.
19. Once the calibration is completed to open the hopper gates Pins, give clearance

20. Emergency Shut- off:

21. If body injury is there, First aid will be given and inform to the Safety department or Call
Emergency number - 222/9865125176/9865177444.

Records/Annexure:

1. Refer Line clearance/permit in Mechanical department.
2. JSA is enclosed below.

JOB SAFETY ANALYSIS: (JSA)

Job Safety Analysis	Job: Weigh Feeder Belt Replacement	Date: 26 – 09 - 2012	Analysis by: SECTION ENGINEER	Reviewed by: SECTION HEAD
Title of employee doing job: Site in charge (Shree)	Supervisor: Section Engineer	Department: Mech.	Section: Cement Mill	Approved by: HOD
Req'd/recommended PPE: Safety helmet, Safety shoe, Safety goggles & Asbestos Gloves.				
Sequence of Basic Job Steps	Potential Hazards	Recommended Safe Job Procedure	What Could Go Wrong	Corrective Action
Shifting of Endless Belt To working	Leg and hand injury	Use Hydra to shift the endless belt to the working spot	Endless pipe may rotate/unbalance and may fell down	1.Use guide rope to control the unbalance of endless belt
Removal of Safety guard, Skirt rubber, Side skirt And Support for weigh feeder	Hand injury Leg injury	Use proper lifting tools to lift the material	Material may slip during removing	Ensure the person Lifting the material as per lifting procedure
Cutting and Removal of old belt from weigh Feeder	Hand injury	Use proper cutting tool and Hand gloves to cut the belt	Cutting tool may be cut the hand during cutting of old belt	Ensure the person wearing safety hand gloves
Position of the chain blocks for lifting the weigh feeder for removing old belt and inserting new belt	Leg and hand injury	Use correct lifting Tackles Teflon/wire rope slings	Chain block may slip and fall while removing and inserting the belt	1. Check the condition of the ropes and slings 2. Check the correct size of slings to operate/actual capacity and ensure certificate of clearance.



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HEAD MECHANICAL

HEAD TECHNICAL