



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



Issue No. 01	Rev. No: 00	Effective Date: 01.03.2016	SOP/MECH/63
Issued By: S.P		Approved By: HOD (MECH)	
SOP FOR CRUSHER WORNOUT LINERS CHANGING INSIDE CHUTE			

Scope/Purpose : This SOP is applicable to Safe working for Crusher worn-out liners changing inside chute

Responsibility : Engineer – Mech

Accountability : Dept.HOD / Site Engineer

PPE:

1. Safety helmet,
2. Safety shoes,
3. Safety Harness
4. Goggles

Tools:

1. Electrically Operated Trolley Crane
2. Wire rope slings
3. Chain pulley block
4. Welding machine and cutting set
5. Wedge pieces
6. Hammer

Hazard Analysis:

Risks associated

Fall from height
Fall of material

Mitigating Measures

Use certified scaffold from competent person
Use trained workmen and tested tools and tackles

Training needs:

1. Usage of tools & PPE
2. Heavy lifting
3. Hot work



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Procedure:

1. Use Proper PPE & tools
2. Take proper Line clearance of crusher, wobbler and 21NBC1 belt conveyor from concerned dept. as per the work condition.
3. Open the crusher casing and provide wooden choke between the door and casing.
4. Scaffolding arrangements with proper platform to be made for gouging and fitting of worn out liner
5. Welder to be engaged for gouging of worn-out liner plates
6. After gouging, with the help of EOT crane lift the worn-out liner out of the feed chute..
7. Proper grinding required over the welding area in order to fix the new liner plate..
8. Lift the new liner plate using EOT crane and position it.
9. Using wedge and hammer make the liner plate set over the feed chute without any gaps on sides.
10. Full Welding to be done after fitment.
11. Remove scaffolding, wooden chokes, close the casing door and give clearance for operation after clearing all work permits.

Emergency / Emergency Shut OFF:

1. If cut or fall injury is there, First aid should be given and Safety department to be informed. Call Emergency number 222/516/523/9865177444/9865195111.

Records/Annexure:

1. Refer crusher worn-out liner changing schedule
2. Hazard identification sheet is enclosed below.



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Hazard Identification:

Hazard Identification	Job: Crusher worn-out liner changing	Date:	Analysis by: Mech dept.	Reviewed by: Safety dept.
Title of employee doing job: Company workmen	Supervisor: Section Engineer	Department: Mech	Section: Plant	Approved by: Unit Head
Req'd/recommended PPE: Safety helmet, Safety shoes, Safety belt, & Goggles				
Sequence of Basic Job Steps	Potential Hazards	Recommended Safe Job Procedure	What Could Go Wrong	Corrective Action
Erection of scaffolding from conveyor to rotor bottom	Slip / fall	Use proper scaffold approved by competent person	Slip / fall	Trained person to be engaged
Tying the wire rope sling to the worn-out liner	Untested tools taken for usage/damaged tools/failure of lifting material & exceed SWL	Tested tools to be mandatory use at site Physical condition of tools to be verified before taken into use by line engineers Proper fixing of lifting tools with considering load carrying capacity.	Fall of material	1. Test certificates of tools to be ensured 2. Validity of test certificate to be verified 3. Trained persons to be engaged