



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



Issue No. 01	Rev. No: 00	Effective Date: 01.03.2016	SOP/MECH/53
Issued By: S.P		Approved By: HOD (MECH)	
SOP FOR BLOWBAR REPLACEMENT			

**Scope/Purpose** : This SOP is applicable to Safe working for Blowbar replacement

**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. Spanners of various sizes
5. 20mm Allen key
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. Hydraulic cylinder usage

**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.



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3. Open the crusher casing and provide wooden choke between the door and casing.
4. Fix chain pulley block on EOT Crane on DE side of crusher
5. Hang one weight in order to push blow bar inside the rotor slot one at EOT crane and one in hook.
6. Loosen the Allen bolts of blow bar locking wedge.
7. Remove used blow bar and insert new one.
8. Fix all the locking wedges and tighten the Allen bolts.
9. Rotate rotor manually and check for touching along the edges of the casing.
10. Remove the wooden choke and close the casing door.
11. Clear the Line clearance and start the crusher.

**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 blow bar changing schedule
2. Hazard identification sheet is enclosed below.



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**Hazard Identification:**

<b>Hazard Identification</b>	Job: Grinding path replacement	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
Tying the wire rope sling to the blow bar	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
Hydraulic jack usage for removing and inserting the pin	Failure of hyd. Jack/hose burstage/slipping of jack from position	Check condition of jack/ensure hose healthiness/tie jack with rigid support before giving load	Oil burstage/jack slip and fall	Hyd. jack inspection due date to be verified. Ensure workmen not very close to the working area during jack load condition