



**DALMIA CEMENT (B) LIMITED – CEMENT PLANT**  
**ARIYALUR**  
**MECHANICAL SOP**

Issue No: 02	Rev. No: 00	Effective Date: 01.11.2019	SOP/MECH/128
Issued By: M.R		Approved By: HOD - Mechanical	
SOP FOR SHAPING OPERATION			

**Scope:**

To operate the shaping for machine the given job

**Responsibly:**

Engineer/SH

**PPE:**

Safety helmet  
Safety shoe  
Safety Goggles

**Tools:**

Spanner set  
Surface gauge  
Coolant  
Lighting  
Cutting tools  
Brush  
Spanner set

**Hazard Analysis:**

**Risks associated:**

1. Hot chips
2. Moving parts

**Mitigating Measures**

1. Goggles & gloves
2. Maintain distance from machine



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**Procedure:**

1. Clean and lubricate machine wherever necessary
2. Positing the job in the vice and hold firmly
3. Set up the Ram stroke as per the requirement
4. Keep all bolts tightened before starting the operation
5. Maintain the distance away from the tool
6. Use appropriate speed as per the material of the job
7. Start the lubrication oil pump when the machine is running
8. Adjust tool post carefully while depth feeding
9. Do not touch the job with bare hands
10. Use coolant oil wherever necessary
11. While removing the job switch off the machine and keep the clutch in neutral position.

**Emergency / Emergency Shut OFF:**

If any injury takes place, provide First aid and inform to the Safety department or Call Emergency number 3108/9865152222



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**Records/Annexure:**

JSA as enclosed below.

**JOB SAFETY ANALYSIS: (JSA)**

<b>Job Safety Analysis</b>	Job: Shaping operation	Date: 20.11.2014	Analysis by: Section Engineer	Reviewed by: Section Head
Title of employee doing job: Section Engineer	Supervisor: Section Head	Department: Mechanical	Section: all area	Approved by: HOD Mechanical
Required/recommended PPE: Helmet, Shoe, Nose mask, Cotton Gloves, Ear plug, Safety belt, Goggles				
<b>Sequence of Basic Job Steps</b>	<b>Potential Hazards</b>	<b>Recommended Safe Job Procedure</b>	<b>What Could Go Wrong</b>	<b>Corrective Action</b>
Tools handling	Hands injury	Use Hand Gloves	Hands may injury	Use type of gloves accordingly.
Fall of small objects	Equipment damage.	Use proper Holding ropes other than lifting	Holding tool may failure..	Check physically before use
Fall of object from base/ Hanging	Equipment damage	Check the base capability for handling the same.	Hooks welding may failure	Check before hanging / using.