

Safe Operating Procedure #13 – Auto Shot Blasting Machine

	Activities	Procedures	Hazards/Risks	Controls
1	Transferring work piece to shot blasting machine	Use crane to move the trolley holding the work pieces to the blast machine	Manual handling injuries. Refer to SOP #2 covering Gantry Crane	<p>Before loading a trolley ensure roller conveyors, turbines, shot and air supply are switched off by opening a fence access gate. The key to the gate <u>MUST</u> be kept on the body of the machine operator at all times while the gate is open. Once loaded, the operator is to exit the fenced area, close and lock the gate to allow the machine to be switched on.</p> <p>If necessary to manually handle the work, assess the weight and where it has to go and only handle it alone if safe to do so. Use someone to assist you and use mechanical equipment where necessary.</p> <p>Before turning on the machine, ensure that the operator and other individuals working in the area are aware of the locations of the emergency stop buttons and the emergency stop wire.</p> <p>In the event of a fault, do not proceed until Supervisor instructs you to however Supervisor must document fault in Works Diary. Repair is to be arranged and alternate safe-to-use equipment is to be provided.</p>
2	Activate machine to receive work pieces	Rollers move work pieces through blast machine	<p>Noise</p> <p>Shot can fly out of chamber striking personnel</p> <p>Slip hazards from shot on floor areas</p>	<p>Wear hearing protection</p> <p>Wear eye protection, and ensure rubber curtains are in place</p> <p>Ensure rubber mats are in place and that excessive shot has been removed from floor areas. Floor and mats should be cleaned at the start of each day and throughout the day as required to reduce the slipperiness of the ground.</p> <p>Under no circumstances is the machine to be turned on while someone is standing inside the fenced off area.</p>

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3	Work pieces exit from machine	Rollers move work pieces out of machine chamber	<p>Shot can fly out of chamber striking personnel</p> <p>Steel can strike personnel in conveyor area</p> <p>Conveyors and other moving parts of the machine potentially causing crushing injuries or other forms of harm.</p>	<p>Wear eye protection and keep clear of machine and work pieces exiting.</p> <p>Workers to keep out of conveyor area at all times while machine is running. Workers are not to jump over the fence located around the machine or attempt to reach over it while the machine is in operation.</p> <p>Operator to check camera vision of northern rollers before commencement of machine. Double check that the area is clear.</p> <p>In the event of an emergency where the machine needs to be stopped immediately, press one of the emergency stop buttons located around the machine or the control panel or trigger the emergency shutdown by pulling the emergency stop wire around the fence.</p>
4	Use compressed air to clean work pieces	Blow away loose abrasive material from steel	<p>Injury from falling.</p> <p>Crushing injury from getting stuck in the conveyors</p> <p>Injuries from compressed air</p> <p>Abrasive material coming out of the machine & Noise</p>	<p>Stand on the bridge and use the extended air hose to blow air onto the steel and remove the abrasive material. Do not lean over the side of the bridge.</p> <p>Never use compressed air to clean work clothes or body parts and do not point air gun in direction of others or where others may come into that area.</p> <p>Wear eye protection and hearing protection</p>
5	Remove work pieces from conveyors	Use crane to move trolley holding work pieces away from the machine	<p>Manual handling injuries. Refer to SOP #2 Gantry Crane.</p> <p>Steel can strike personnel in conveyor area</p>	<p>Before blowing loose dirt, ensure roller conveyor, turbines, shot and air supply are switched off by opening a fence access gate. The key to the gate <u>MUST</u> be kept on the body of the machine operator at all times while the gate is open. Once loaded, the operator is to exit the fenced area, close and lock the gate to allow the machine to be switched on.</p>

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6	Maintenance of Machine	Lock out machine prior to performing maintenance.	<p>Crushing injuries, dust and noise, abrasive material causing eye injury.</p> <p>Slipping hazards and falling hazards, noise.</p> <p>Injury from jumping from a height</p>	<p>Before performing maintenance on the machine, ensure it is turned off and at least one of the individuals performing maintenance has a key for one of the gates to ensure the machine cannot be turned on by someone else. Under no circumstances is the machine to be turned back on without all nearby individuals being aware and clear of the machine.</p> <p>If required to go under the machine for maintenance, ensure that the machine is turned off and cannot be turned back on by following the procedure written above. Ensure the surface you are on is not slippery as you open the grating. Ensure the ladder is secure and keep at least three points of contact on the ladder at all times.</p> <p>Do not jump to the ground below.</p>
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- Personal Protective Equipment that must be used: gloves, non-fogging eye protection with side shields, hearing protection, protective footwear

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This SOP has been developed in consultation with me and I agree to follow it and carry out tasks in a safe manner, reporting any problems to my immediate Supervisor.

Bundy Card no.	Name	Signature	Date