

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 MUST 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>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>Floor and mats should be cleaned at the start of each day. Ensure rubber mats are in place and that excessive shot has been removed from floor areas</p>
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>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</p>

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				Operator to check camera vision of northern rollers before commencement of machine. Double check that the area is clear.
4	Use compressed air to clean work pieces	Blow away loose “dirt”	<p>Injuries from compressed air</p> <p>Dust & Noise</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 MUST be kept on the body of the machine operator at all times while the gate is open. Once blowing is complete, the operator is to exit the fenced area, close and lock gate to allow the machine to be switched on.</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 respiratory and 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>Hot material causing burns</p>	<p>Before removing work pieces, ensure roller conveyor, turbines, shot and air supply are switched off by opening a fence access gate. The key to the gate MUST be kept on the body of the machine operator at all times while the gate is open. Once all pieces have been removed, the operator is to exit the fenced area, close and lock gate to allow the machine to be switched on.</p> <p>Ensure enough time has elapsed to allow material to cool and wear gloves when machine is not running for an extended period (greater than 1 hour), turn machine off and lock main power switch with a padlock. Machine operator or his supervisor shall be the only personnel to have access to this padlock key.</p>

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- Supervisor:
- Personal Protective Equipment that must be used: gloves, non-fogging eye protection with side shields, hearing protection, protective footwear

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

