ENERGY CONTROL PROCEDURE

The following Energy Control Procedure should be used for the equipment listed below.

Date Written: 3/28/2000 Date of Revisions: 1/10/2011
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Approvals: FRANK REPROGLE Date Approved: 1/10/2011
EQUIPMENT DESCRIPTION FOUR MACHINES CONNECTED TOGETHER WITH THE SAME POWER SOURCES.
MANUFACTURER: MINSTER MACHINE

BMC 3066	**COIL ELEVATOR**	**SERIAL NUMBER: 13-181170**
BMC 3067	**DUAL COIL REEL**	**SERIAL NUMBER: 13-70503**
BMC 3068	**LEVELER**	**SERIAL NUMBER: 13-50442**
BMC 3069	**THREADER TABLE**	**SERIAL NUMBER: 13-90153**

LOCATION: BMC 3024 PRODUCTION ON 300 TON PRESS

CONTROLS

The following Controls, including "start/stop" buttons, toggle switches, emergency stop button, shut-off valves, etc. have been identified for this equipment.

Description of Control	Location on Equipment
Hydraulic start/stop/on bottom	Leveler control panel
Stop control push button	Leveler control panel
Main electrical disconnet	Leveler control panel
480 volt plug	Leveler control panel
Main air shutoff valve	Rear side of leveler
Straightner fault/reset button	Leveler control panel

ENERGY SOURCES/ISOLATION DEVICES

The following Energy Sources and Energy Isolation Devices supporting this equipment have been identified.
Energy Types: (CHECK ALL THOS APPLICABLE)

Electrical	**x**
Pneumatic	**x**
Hydraulic	**x**
Steam	
Chemical	
Thermal	
"Stored" Energy	
Other	

SOURCES/DEVICES	LOCATION	TYPE OF LOCK/TAG NEEDED
Hydraulic start/stop/ on button	Leveler control panel	N/a
Stop control/push button	Leveler control panel	N/a
Main electrical disconnect	Leveler control panel	Lock & tag
480 volt plug	Leveler control panel	Lock & tag/lock out cover
Main air shut off valves	Rear side of leveler	Lock & tag
Straightener fault/ button	Leveler control panel	N/a

SHUTDOWN PROCEDURES

The steps listed below must be followed to properly shut down and de-energize this equipment.
To verify the effectiveness of each step follow the instructions in the "Verification" column.

Lock-Out/Tag-Out

Procedure	Device Used	How to Verify
Notify "affected" and "other" employees of impending equipment shutdown		
Push hydraulic start/ stop	N/A	Hydraulic motor stops
Turn off main electrical disconnects	Lock & tag	Try to rest & start
Unplug 480 volt plug	Lock & tag/lock out cover	Unplugged
Push main air shutoff valve	Lock & tag	Pressure guage reads zero

RELEASE AND RESTART PROCEDURES

The steps listed below must be followed to properly release this equipment from a locked or tagged out condition and restart it.

PROCEDURE	LOCATION
Inspect work area and remove tools and other non-essential items.	
Inspect equipment and components to make sure it is intact and ready to run.	
Notify “affected” and “other” employees in the area of impending restart and make sure they are safely positioned away from the equipment	
Pull main air shutoff valve to open	Rear side of leveler
Turn on main electrical disconnect	Leveler control panel
Push straightner fault/reset button	Leveler control panel
Pull hydraulic start/stop/on button	Leveler control panel