

ENERGY CONTROL PROCEDURE

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

Date Written: 4/5/1999 Date of Revisions: 1/10/11 - _____ - _____ - _____

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EQUIPMENT DESCRIPTION

GENERAL DESCRIPTION: 250 TON PRESS (BMC 3019)

MANUFACTURER: MINSTER MACHINE

MODEL: 250 TON SERIAL NUMBER: E2-250-20034

LOCATION: FIRST PRESS ROOM RIGHT SIDE

CONTROLS

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

<u>Description of Control</u>	<u>Location on Equipment</u>
• <u>START STOP</u>	<u>FRONT PENDANT</u>
• <u>SAFETY BLOCK & INTERLOCK</u>	<u>FRONT RIGHT SIDE OF PRESS</u>
• <u>AIR SUPPLY (PRESS)</u>	<u>BALL VALVE LEFT SIDE IN CEILING</u>
• <u>COUNTERBALANCE - CUSHION</u>	<u>LEFT REAR CORNER OF PRESS</u>
• <u>START – STOP FEED</u>	<u>FEED PANEL CABINET</u>
• <u>(PRESS) – MAIN “D” SWITCH</u>	<u>A CROSS THE AISLE</u>
• <u>LEVELER/REEL DISCONNECT</u>	<u>RIGHT FRONT OF CONTROL PANEL</u>
• <u>AIR</u>	<u>LEFT REAR DUMP VALVE</u>

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 X Other

<u>SOURCES/DEVICES</u>	<u>LOCATION</u>	<u>TYPE OF LOCK/TAG NEEDED</u>
• <u>MAIN DISCONNECT</u> _____	<u>ACROSS THE AISLE FROM</u> <u>THE FRONT OF PRESS</u> _____	<u>LOCK & TAG</u> _____
• <u>MAIN AIR SUPPLY</u> _____	<u>LEFT SIDE OF PRESS IN</u> <u>CEILING</u> _____	<u>BALL VALVE COVER &</u> <u>LOCK & TAG</u> _____
• <u>COUNTER BALANCE</u> _____	<u>LEFT REAR DRAIN VALVE</u> _____	<u>VALVE COVER & PADLOCK</u> _____
• <u>FEED PLUG</u> _____	<u>BACK OF FEED PANEL</u> _____	<u>PLUG BOX, LOCK & TAG</u> _____
• <u>STRAIGHTNER</u> _____	<u>PLUG ON RIGHT FRONT</u> <u>OF PANEL</u> _____	<u>PLUG COVER & LOCK & TAG</u> _____
• <u>STRAIGHTNER AIR</u> _____	<u>BACK LEFT SIDE</u> _____	<u>LOCK & TAG</u> _____
• <u>STOP BLOCKS</u> _____	<u>FRONT RIGHT SIDE OF</u> <u>PRESS & LEFT REAR</u> _____	<u>N/A</u> _____

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.

<u>Lock-Out/Tag-Out</u>		
<u>Procedure</u>	<u>Device Used</u>	<u>How to Verify</u>
<ul style="list-style-type: none"> • <u>NOTIFY “AFFECTED” AND “OTHER” EMPLOYEES OF IMPENDING EQUIPMENT SHUTDOWN</u> 	<hr/> <hr/> <hr/> <hr/>	<hr/> <hr/> <hr/> <hr/>
<ul style="list-style-type: none"> • <u>TURN OF MAIN DISCONNECT ACROSS THE ASILE FROM PRESS</u> 	<u>LOCK/TAG</u> <hr/> <hr/>	<u>VOLT METER MARKED WITH PRESS #</u> <hr/> <hr/> <u>SEE IF MOTOR STARTS</u> <hr/> <hr/>
<ul style="list-style-type: none"> • <u>TURN OFF AIR - VALVE IN CEILING</u> 	<u>BALL VALVE BOX - LOCK/TAG</u> <hr/> <hr/>	<u>DRAIN COUNTER</u> <hr/> <hr/> <u>BALANCE AND CUSHION & CHECK GUAGE</u> <hr/> <hr/>
<ul style="list-style-type: none"> • <u>UNPLUG THE FEED PANEL</u> 	<u>PLUG BOX – LOCK/TAG</u> <hr/> <hr/>	<u>FEED PANEL – NO POWER</u> <hr/> <hr/>
<ul style="list-style-type: none"> • <u>UNPLUG STRAIGHTNER</u> 	<u>LOCK / TAG & PLUG COVER</u> <hr/> <hr/>	<u>STRAIGHTNER WILL NOT START</u> <hr/> <hr/>
<ul style="list-style-type: none"> • <u>TURN OFF AIR VALVE ON THE BACK SIDE OF STRAIGHTNER</u> 	<u>LOCK /TAG</u> <hr/> <hr/>	<u>LOOK AT GAGE</u> <hr/> <hr/>
<ul style="list-style-type: none"> • <u>STOP BLOCK PULL PLUG AND PUT ON BED</u> 	<u>N/A</u> <hr/> <hr/>	<hr/> <hr/>

