ENERGY CONTROL PROCEDURE

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

• AIR

Date Written: 4/5/1999 Date of Revisions: 1/10/11						
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Approvals: FRANK REPROGLE	Date Approved: <u>1/10/11</u>					
EQUIPMENT DESCRIPTION						
GENERAL DESCRITION: 250 TON PRES	S (BMC 3019)					
MANUFACTURER: MINSTER MACHINE						
MODEL: 250 TON	SERIAL NUMBER: <u>E2-250-20034</u>					
LOCATION: FIRST PRESS ROOM RIGHT SID	<u>E</u>					
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>	Location on Equipment					
• START STOP	FRONT PENDANT					
SAFETY BLOCK & INTERLOCK	FRONT RIGHT SIDE OF PRESS					
AIR SUPPLY (PRESS)	BALL VALVE LEFT SIDE IN CEILING					
• COUNTERBALANCE - CUSHION	LEFT REAR CORNER OF PRESS					
• START – STOP FEED	FEED PANEL CABINET					
• (PRESS) – MAIN "D" SWITCH	A CROSS THE AISLE					
• LEVELER/REEL DISCONNECT	RIGHT FRONT OF CONTROL PANEL					

LEFT REAR DUMP VALVE

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

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

	<u>Procedure</u>	Device Used	How to Verify
•	NOTIFY "AFFECTED" AND		
	"OTHER" EMPLOYEES OF		
	IMPENDING EQUIPMENT		
	SHUTDOWN		
•	TURN OF MAIN DISCONNECT	LOCK/TAG	VOLT METER MARKED
	ACROSS THE ASILE FROM		WITH PRESS #
	PRESS		SEE IF MOTOR STARTS
•	TURN OFF AIR - VALVE	BALL VALVE BOX - LOCK/TAG	DRAIN COUNTER
	IN CEILING		BALANCE AND CUSHION
			& CHECK GUAGE
•	UNPLUG THE FEED PANEL	PLUG BOX – LOCK/TAG	FEED PANEL – NO POWER
•	UNPLUG STRAIGHTNER	LOCK / TAG & PLUG COVER	STRAIGHTNER WILL NOT
			START
•	TURN OFF AIR VALVE ON	LOCK /TAG	LOOK AT GAGE
	THE BACK SIDE OF		
	STRAIGHTNER		
•	STOP BLOCK PULL PLUG AND	N/A	
	PUT ON BED		

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.

	<u>PROCEDURE</u>	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	
•	STOP BLOCK	PUT IN HOLDER – PLUG BACK IN
•	CLOSE CUSHION AND COUNTER BALANCE	BACK LEFT HAND CORNER OF PRESS
•	UNLOCK AIR VALVE – ONE IN CEILING AND	IN CEILING – LEFT SIDE OF PRESS AND
	ONE ON THE BACK OF STRAIGHTNER	THE BACK SIDE OF STRAIGHTNER
•	PLUG THE FEED BACK IN	BACK LEFTSIDE OF FEED PANEL
•	UNLOCK & REMOVE PLUG COVER & PLUG IN	FRONT RIGHT SIDE OF STRAIGHTNER
•	UNLOCK MAIN PRESS PANEL	ACROSS THE AISLE FROM THE PRESS