

ENERGY CONTROL PROCEDURE

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

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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.

<u>Description of Control</u>	<u>Location on Equipment</u>
• <u>HYDRAULIC START/STOP/ON BOTTOM</u>	<u>LEVELER CONTROL PANEL</u>
• <u>STOP CONTROL PUSH BUTTON</u>	<u>LEVELER CONTROL PANEL</u>
• <u>MAIN ELECTRICAL DISCONNECT</u>	<u>LEVELER CONTROL PANEL</u>
• <u>480 VOLT PLUG</u>	<u>LEVELER CONTROL PANEL</u>
• <u>MAIN AIR SHUTOFF VALVE</u>	<u>REAR SIDE OF LEVELER</u>
• <u>STRAIGHTNER FAULT/RESET BUTTON</u>	<u>LEVELER CONTROL PANEL</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 <u> X </u>	Pneumatic <u> X </u>	Hydraulic <u> X </u>
Steam <u> </u>	Chemical <u> </u>	Thermal <u> </u>
“Stored” Energy <u> </u>	Other <u> </u>	

<u>SOURCES/DEVICES</u>	<u>LOCATION</u>	<u>TYPE OF LOCK/TAG NEEDED</u>
• <u>HYDRAULIC START/STOP/ON BUTTON</u>	<u>LEVELER CONTROL PANEL</u>	<u>N/A</u>
• <u>STOP CONTROL/PUSH BUTTON</u>	<u>LEVELER CONTROL PANEL</u>	<u>N/A</u>
• <u>MAIN ELECTRICAL DISCONNECT</u>	<u>LEVELER CONTROL PANEL</u>	<u>LOCK & TAG</u>
• <u>480 VOLT PLUG</u>	<u>LEVELER CONTROL PANEL</u>	<u>LOCK & TAG/LOCK OUT COVER</u>
• <u>MAIN AIR SHUT OFF VALVES</u>	<u>REAR SIDE OF LEVELER</u>	<u>LOCK & TAG</u>
• <u>STRAIGHTENER FAULT/BUTTON</u>	<u>LEVELER CONTROL PANEL</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>Procedure</u>	<u>Lock-Out/Tag-Out</u>	<u>How to Verify</u>
<u>Device Used</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>PUSH HYDRAULIC START/ STOP</u> 	<u>N/A</u> <hr/>	<u>HYDRAULIC MOTOR STOPS</u> <hr/>
<ul style="list-style-type: none"> • <u>TURN OFF MAIN ELECTRICAL DISCONNECTS</u> 	<u>LOCK & TAG</u> <hr/>	<u>TRY TO REST & START</u> <hr/>
<ul style="list-style-type: none"> • <u>UNPLUG 480 VOLT PLUG</u> 	<u>LOCK & TAG/LOCK OUT COVER</u> <hr/>	<u>UNPLUGGED</u> <hr/>
<ul style="list-style-type: none"> • <u>PUSH MAIN AIR SHUTOFF VALVE</u> 	<u>LOCK & TAG</u> <hr/>	<u>PRESSURE GUAGE READS ZERO</u> <hr/>

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>	<u>LOCATION</u>
• <u>Inspect work area and remove tools and other non-essential items.</u>	_____
• <u>Inspect equipment and components to make sure it is intact and ready to run.</u>	_____
• <u>Notify “affected” and “other” employees in the area of impending restart and make sure they are safely positioned away from the equipment</u>	_____
• <u>PULL MAIN AIR SHUTOFF VALVE TO OPEN</u>	<u>REAR SIDE OF LEVELER</u>
• <u>TURN ON MAIN ELECTRICAL DISCONNECT</u>	<u>LEVELER CONTROL PANEL</u>
• <u>PUSH STRAIGHTNER FAULT/RESET BUTTON</u>	<u>LEVELER CONTROL PANEL</u>
• <u>PULL HYDRAULIC START/STOP/ON BUTTON</u>	<u>LEVELER CONTROL PANEL</u>