

# ENERGY CONTROL PROCEDURE

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

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## EQUIPMENT DESCRIPTION

GENERAL DESCRIPTION: 300 TON PRESS (BMC #3024) FEED/STRAIGHTNER/REEL/COIL LIFTER

MANUFACTURER: MINSTER MACHINE

MODEL: E2-300      SERIAL NUMBER: E2-300-26467

LOCATION: MAIN PRESS ROOM NEAR BACK FAR CORNER NEW HWY 70

## **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
Press start/stop button	Pendant
Safety plug (blocks-2)	Left rear leg/right front
Air supply	Ceiling over left end and right front
Main disconnect	Panel on back wall behind press
Feed/start – stop	Front control cabinet/same as press (same panel)
Leveler/reel (electric)	Front left plug
Air supply	Rear left lockable dump valve

**ENERGY SOURCES/ISOLATION DEVICES**

The following Energy Sources and Energy Isolation Devices supporting this equipment have been identified.

Energy Types: (CHECK ALL THOSE APPLICABLE)

Electrical	X
Pneumatic	X
Hydraulic	X
Steam	
Chemical	
Thermal	
“Stored” Energy	X
Other	

Sources / Devices	Location	Type of Lock/Tag Needed
Press start/stop	Pendant	N/A
Safety block	Left rear leg	Plug cover & lock tag
Air supply	In ceiling over left side of press right front corner	Gates valve cover, lock and tag
Main disconnect	Wall behind press	Standard lock & tag
Feed	Start-stop on cabinet main wall behind press	Standard lock & tag
Straightner reel/ elevator	Start/stop control on top of panel	
Main power	Right front	Plug cover lock and tag
Air	Left rear	Pump valve lock and tag

## 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 Stop Button, put press bottom of stroke	N/A	Try Run Buttons, check angle is 180
Shut off air supply valve right front corner	Gate valve, Lock Tag, drain counter balance tank	Air bleeds & pressure gauges
Pull safety 2 plug	Plug box and lock and tag	Try control start button
Main disconnect - feed push off/stop	Padlock and tag	Check for power to press with meter
Straightener power air	Plug cover, lock tag	Meter, check gauge

## 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>
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	
Unlock and close the air valve	Right side of press above the feed
Close drain valve and unlock air valve	Left back side of press
Close air drain valve for counter balance, clutch and press overloads and unlock the main air valve	Left front corner of press and turn on
Unlock and turn on HMS transfer disconnect	
Unlock and turn on 120/480 disconnect	
Unlock and turn on main straightner disconnect	