

ENERGY CONTROL PROCEDURE

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

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EQUIPMENT DESCRIPTION

GENERAL DESCRIPTION: 400 TON PRESS FEED, LEVELER & REEL (#3020)

MANUFACTURER: MINSTER MACHINE

MODEL: S2-400 SERIAL NUMBER: S2-400-18700

LOCATION: MAIN PRESS ROOM

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>ON/OFF BUTTON</u>	<u>PENDANT</u>
• <u>AIR SUPPLY PRESS/FEED</u>	<u>2 VALVES IN CEILING OVER LEFT SIDE OF PRESS</u>
• <u>STOP BLOCK</u>	<u>LEFT REAR LEG</u>
• <u>MAIN DISCONNECT</u>	<u>PANEL ON BACK WALL</u>
• <u>PLUG ON FEED & STRAIGHTNER</u>	_____
• <u>STRAIGHTNER AIR</u>	<u>LEFT SIDE REAR - FEED LEFT SIDE PLUG TOP</u> <u>STRAIGHTNER PLUG LEFT SIDE PANEL BOX</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>ON/OFF BUTTON</u>	<u>PENDANT –FRONT</u>	<u>N/A</u>
_____	<u>MACHINE</u>	_____
• <u>STOP BLOCK</u>	<u>LEFT REAR LEG</u>	_____
_____	_____	_____
• <u>AIR SUPPLY</u>	<u>IN CEILING OVER LEFT</u>	<u>BALL VALVE COVER</u>
_____	<u>SIDE OF PRESS</u>	<u>LOCK & TAG</u>
• <u>MAIN DISCONNECT</u>	<u>BEHIND PRESS – RIGHT</u>	<u>LOCK & TAG</u>
_____	<u>SIDE OF WALL PANEL</u>	_____
• <u>PLUG ON FEED</u>	<u>BACK SIDE OF FEED</u>	<u>PLUG BOX AND LOCK & TAG</u>
_____	<u>PANEL</u>	_____
• <u>PLUG ON STRAIGHTNER</u>	<u>FRONT OF STRAIGHTNER</u>	<u>PLUG BOX AND LOCK &TAG</u>
<u>DROP-HOLD DOWN ARM</u>	_____	_____
• <u>AIR SUPPLY STRAIGHTNER</u>	<u>BACK SIDE LEFT OF</u>	<u>LOCKABLE DUMP VALVE</u>
_____	<u>STRAIGHTNER</u>	<u>LOCK & TAG</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>Device Used</u>	<u>How to Verify</u>
• <u>NOTIFY “AFFECTED” AND</u> <u>“OTHER” EMPLOYEES OF</u> <u>IMPENDING EQUIPMENT</u> <u>SHUTDOWN</u>		
• <u>PUT PRESS SLIDE TO 180 DEG</u> <u>ON/OFF BUTTON -</u> <u>PUSH(OFF)</u>	<u>N/A</u>	<u>TRY THE INCH BUTTON</u>
• <u>PULL STOP BLOCK AND PUT</u> <u>ON BED</u>		<u>TRY TO TURN CONTROL</u> <u>ON</u>
• <u>TURN OFF AIR SUPPLY</u> <u></u> <u></u> <u></u> <u></u>	<u>BALL VALVE COVER-LOCK & TAG</u> <u></u> <u></u> <u></u> <u></u>	<u>CHECK AIR BLEEDS &</u> <u>GAGES – DRAIN</u> <u>COUNTERBALANCE</u> <u>CLUTCH AND CUSHION</u> <u>CYLINDER</u>
• <u>MAIN DISCONNECT</u> <u></u>	<u>LOCK & TAG</u> <u></u>	<u>CHECK FOR POWER TO</u> <u>PRESS WITH METER</u>
• <u>UNPLUG STRAIGHTNER</u> <u>& USE PLUG BOX W/LOCK</u> <u>& TAG DROP</u> <u>DROP HOLD DOWN ARM</u>	<u></u> <u></u> <u></u> <u></u>	<u>VISUAL</u> <u></u> <u></u> <u></u>
• <u>TURN OFF AIR ON THE BACK</u> <u>OF STRAIGHTNER REEL – HAVE</u> <u>STEEL BANDED (AIR OFF STEEL</u> <u>WILL UNWIND</u>	<u></u> <u></u> <u></u> <u></u>	<u>GAGES</u> <u></u> <u>VISUAL</u> <u></u>

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>UNLOCK & TURN ON MAIN DISCONNECT</u>	<u>WALL BEHIND PRESS (PANEL ON WALL</u>
_____	<u>WALL NEAR HWY 70</u>
_____	<u>BACK LEFT SIDE OF PRESS AND THE BACK</u>
_____	<u>OF THE FEED</u>
• <u>CLOSED DRAIN VALVES FOR CLUTCH, COUNTERBALANCE AND CUSHION CYLINDER</u>	<u>CEILING OVER LEFT SIDE OF PRESS</u>
<u>UNLOCK & TURN AIR SUPPLY ON</u>	_____
• <u>PUT STOP BLOCK BACK IN HOLDER AND PLUG BACK IN</u>	<u>LEFT REAR LEG OF PRESS</u>
_____	_____
• <u>UNLOCK AIR VALVE ON THE BACK OF STRAIGHTNER</u>	<u>PENDENT</u>
_____	_____