

Lockout/Tagout Posted Procedure

ID#: Created: Revised:	Facility:	Location:
Description: 500 TON Hydraulic Press Brake		

5

Lockout Points

Purpose:	This procedure establishes the minimum requirements for the lockout of energy isolating devices whenever maintenance or servicing is done on machines or equipment.
Scope:	This procedure shall be used to ensure that the machine or equipment is stopped, isolated from all potentially hazardous energy sources and locked out before employees perform any servicing or maintenance where the unexpected energization or start-up of the machine or equipment or release of stored energy could cause injury.
Authorization:	This procedure shall only be used by employees that have been trained as "Authorized" employees under CAN. 309 'Control of Hazardous Energy (Lockout & Tagout)' and Occupational Health and Safety Act and Regulation for Establishments (April 2012).
Enforcement:	Failure to properly follow lockout-tagout procedure may result in corrective action. (CAN. 86 - Performance Improvement Plan)

Lockout Application Process

1. Notify affected personnel. 2. Properly shut down machine. 3. Isolate all energy sources. 4. Apply lockout devices, locks, & tags. 5. Verify total de-energization of all sources.

Lockout Tag Color Index

- RED** - Personal lock, used for preventive maintenance
- YELLOW** - Transferable lock, used during break-down
- BLUE** - Used by contractors for repair or inspections
- GREEN** - Used on spare disconnect switch

Lockout/Tagout Posted Procedure

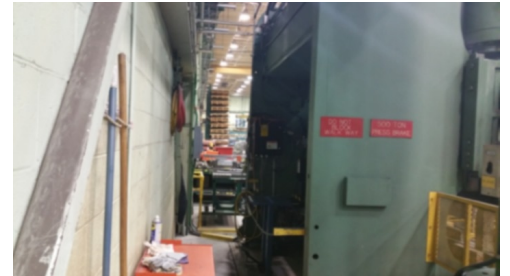
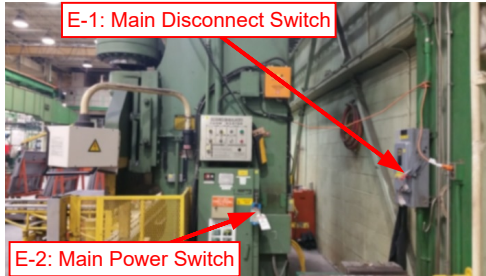
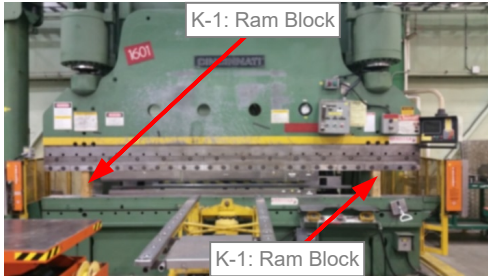
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5 Lockout Points



Front View

Side View

Side/Back View



Lockout Steps

Step #	Action	Info
1 Electrical Primary Feed	The E-1 main disconnect switch is located on the right side of the machine. Switch main disconnect to the off position and lock out. Use a Lock and hasp device.	Main Disconnect Switch 
2 Electrical Secondary Feed	The E-2 main power switch is located on the South side of the machine. Turn main power switch to the off position and lock out. Use a Lock and hasp device.	Main Power Switch 

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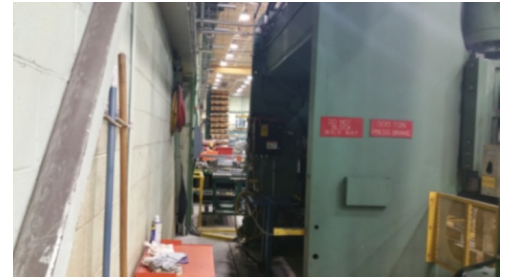
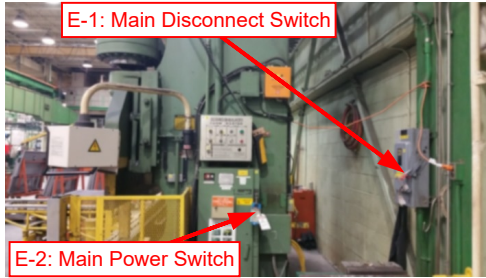
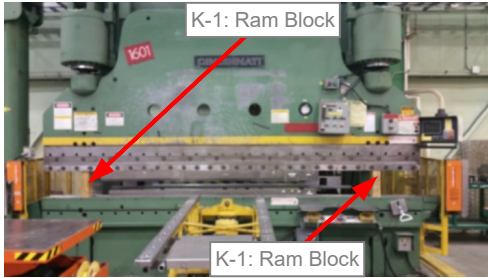
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Lockout Steps

Step #	Action	Info
3 Electrical Secondary Feed	The E-3 safety interlock is located on the Back side of the machine. Unplug and apply lock out Use a Lock device.	Safety Interlock
4 Pneumatic Primary Feed	The P-1 pneumatic ball valve is located on the Back side of the machine. Turn pneumatic ball valve to the off position and lock out. Use a Ball valve lockout device.	Pneumatic Valve

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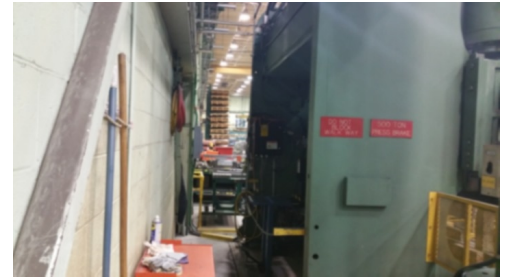
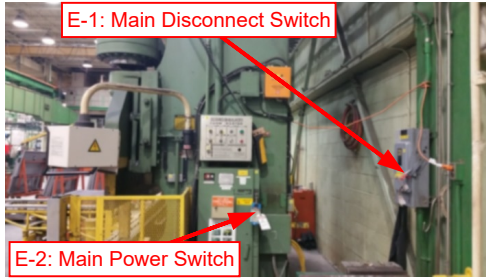
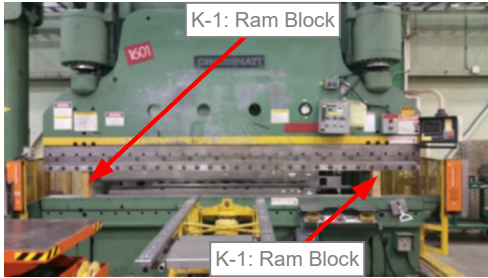
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Lockout Steps

Step #	Action	Info
5 Kinetic	The K-1 ram block is located on the Front side of the machine. Insert the ram block between the ram and the die base and make sure there is no play. Use a Ram block device.	Ram Block

Verification of Energy Isolation

Verify that all energy sources are isolated and at a Zero Energy State by attempting to start machine with normal operating controls.

Lockout Removal Process

1. Ensure all tools and items have been removed. 2. Confirm that all employees are safely located. 3. Verify that controls are in neutral. 4. Remove lockout devices and reenergize machine. 5. Notify affected employees that servicing is completed.