ENERGY CONTROL PROCEDURE

Plant:	Irvine, CA	**Developed By:**	Sentinel Safety Group
Department/Process:	Servo	**Reviewed By:**	
Equipment Name:	Tsugami Lathe, Coolant System	**Origin Date:**	2/1/2019
Asset Number:	B 1680	**Revision Date:**	

Procedure Purpose and Compliance

Purpose & Scope: This procedure establishes the minimum requirements for the lockout of energy isolating devices whenever maintenance or servicing tasks are performed on machines or equipment as outlined below in '**Tasks**'.

Compliance: All employees are required to comply with the restrictions and limitations imposed upon them during the use of lockout. The authorized employees are required to perform the lockout in accordance with this procedure. Failure to follow this lockout procedure may result in injury to personnel or damage to equipment and may result in disciplinary action, including termination.

Tasks: This procedure applies to the following tasks associated with this equipment:

1 Maintenance and Servicing
2
3
4

2	 **# Locks Needed for Lockout**	***Special Instruction*** **Chip Conveyor & Coolant system are isolated by using LOTO #10 but the Coolant system has its own isolation LOTO # 12. The Mist Buster is isolated using its cord & plug.**

Cautionary Statement

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Lockout Sequence

STEP 1 Notify all affected employees that the equipment must be shut down and locked out.

STEP 2 Authorized employee shall understand the hazards of the energy and shall know the methods to control the energy.

STEP 3 Shut equipment down by the normal stopping procedure.

STEP 4 De-activate the energy isolating device(s) so that the machine or equipment is isolated from the energy source(s) identified below.

Energy Source Magnitude	Isolation Point ID	Energy Isolating Device & Isolation Method	Lockout Device	Stored Energy?	Zero Energy Verification
Electrical 208 VAC	10	Place disconnect in off position and apply lock.	Lock	No	Actuate controls
Electrical 208 VAC	12	Place disconnect in off position and apply lock.	Lock	No	Actuate controls

STEP 5 Lock out the energy isolating device(s) with assigned individual lock(s) or process locks.

STEP 6 Stored or residual energy must be dissipated or restrained as shown below.

Energy Source	Method of Control or Dissipation.	Equipment Needed
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STEP 7 Verify the isolation of the equipment by operating control(s) or by testing to make certain the equipment will not operate by following the Zero Energy Verification outlined in section 4. Please note that electrical work or access to electrical conductor requires zero energy verification with a properly rated meter.

STEP 8 The machine or equipment is now locked out.

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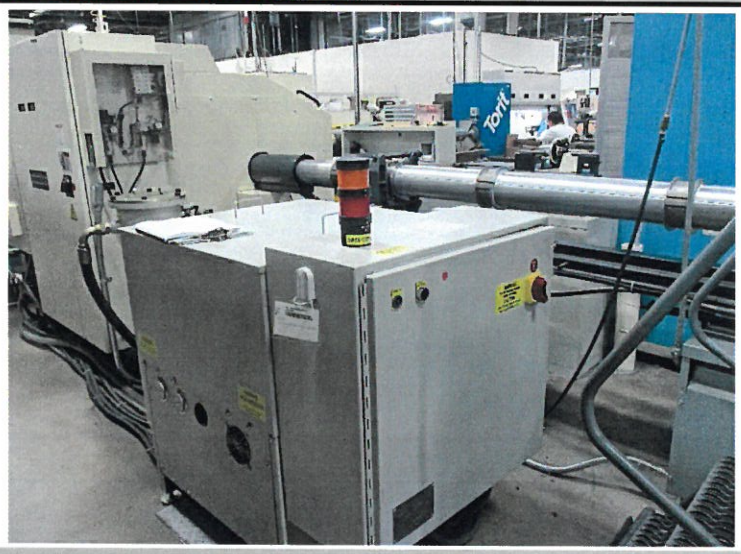
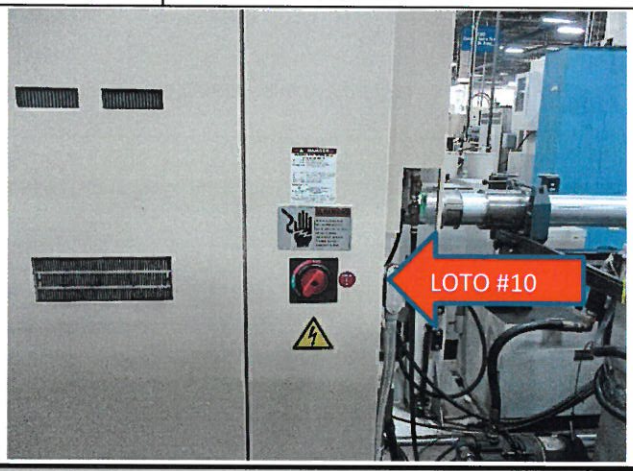
Equipment Photo: B 1680, Tsugami Lathe Cooling system



Isolation Point and Controls Identification

Description:	LOTO #10, 208 VAC disconnect	Description:	LOTO #12, 208 VAC disconnect
Location:	Back side of Lathe	Location:	Located front side



Return to Service

Step 1	Verify equipment and area is clear of tools, workers, equipment, materials, and debris.
Step 2	Verify controls are in neutral.
Step 3	Reposition any safety devices, guards, interlocks.
Step 4	Warn workers to stay clear of area.
Step 5	Remove all locks and tags from energy control points.
Step 6	Verify affected areas are clear of personnel.
Step 7	Re-energize the machine or equipment.