

Equip Num: MA05 Location: Front Molding Room Description: Cincinnati Molding Machine 05 and Automation

6



Isolation Points to Lock, Tag, & Verify

DANGER

Confined Space. Obtain proper permits and follow confined space procedure prior to entering. Take precautions and wear proper PPE when servicing. Shut down adjacent equipment prior to servicing machine. This machine shares disconnects and removes sources from the other equipment.

Operator Side View



Operator Side View



OPENING A GUARD DOES NOT CONSTITUTE A LOCKOUT

WHEN IN DOUBT, LOCK IT OUT, AND VERIFY TWICE

Any machine modifications must be shown in procedure. Contact the Safety Department to update procedure.
Safety is your Responsibility!
Stop, Look, Think, Speak Up!

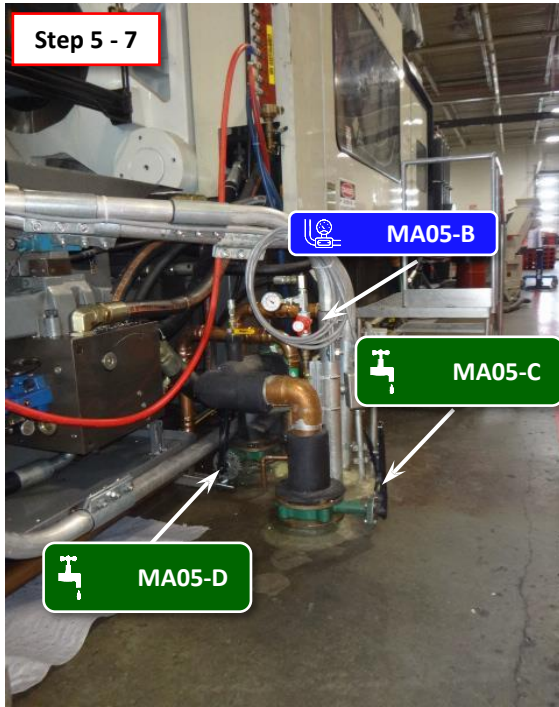
ONLY AUTHORIZED EMPLOYEES MAY PERFORM THIS LOCK, TAG, TRY PROCEDURE
ALWAYS PERFORM A MACHINE STOP BEFORE LOCKING OUT DISCONNECTS
NOTIFY AFFECTED EMPLOYEES BEFORE STARTING LOCK, TAG, TRY PROCEDURE

ID/Step Num	Source	Device	Location	Method	Check
1 MA05-G	Pre-Isolation Step		A.) Check that phase indicator lights are working properly. B.) If possible, follow safe shutdown procedures. (Reference machine specific SOP) C.) Then press E-stop. E.) Turn off associated heat controller.		
2 MA05-A	Electrical 480V	Padlock	Isolation point on Operator side of unit.	Move electrical disconnect to off. Apply hasp, lock and tag.	Restore E-stop, attempt restart at MA05-G, and verify by phase indicator.
3	Hydraulic Energy 3300 PSI		Ensure the drop down bar is engaged and verify that the screen on MA05-G is blank		

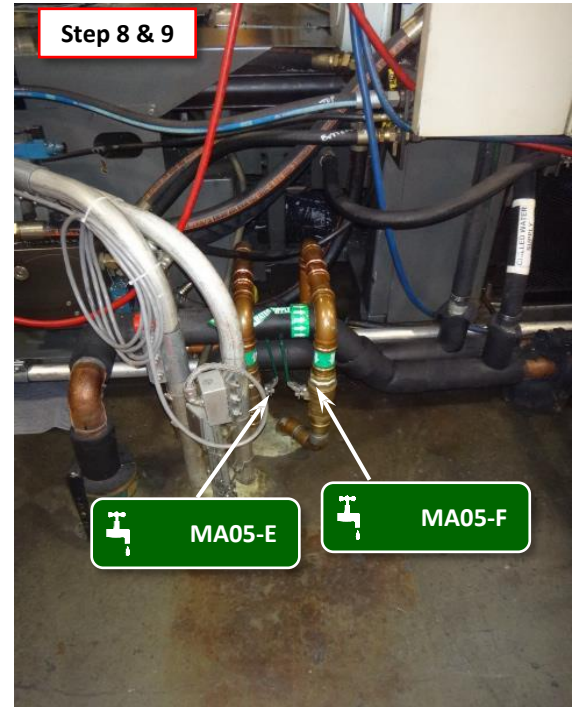
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Non-Operator Side View



Non-Operator Side View



ID # / Step #	Source	Device	Location	Method	Check
4 MA05-C	Chilled Water Inlet – 60 PSI	Cable Device	Isolation point on Back side of unit.	Turn valve to closed position. Apply hasp, lock and tag.	Close inlet and use compressed air to blow out water line.
5 MA05-B	Compressed Air Inlet - 100 PSI	Padlock	Isolation point on Back side of unit.	Turn valve to closed position. Apply hasp, lock and tag.	Verify pressure has bled off at local gauge and drain valve.
6 MA05-D	Chilled Water Inlet - 60 PSI	Cable Device	Isolation point on Back side of unit.	Turn valve to closed position. Apply hasp, lock and tag.	Verify pressure has bled off at drain valve.
7 MA05-E	Tower Water Inlet - 60 PSI	Ball Valve Device	Isolation point on Back side of unit.	Turn valve to closed position. Apply hasp, lock and tag.	
8 MA05-F	Tower Water Outlet - 60 PSI	Ball Valve Device	Isolation point on Back side of unit.	Turn valve to closed position. Apply hasp, lock and tag.	
9	Thermal Energy 600 F		Be sure to wait until heat has dissipated from machine until cool to touch before servicing. Wear proper PPE before beginning work.		
10	Post-Isolation Step		To verify machine is de-energized, press the motor start button on MA05-G.		