

LUMBER ORDER PROCESS CENTER
OPERATORS LOCKOUT/TAGOUT PROCEDURES

TILTING HOIST
NEWMEN FEEDER
PINHEIRO PLANNER
TRIMMER
SHAVEINGS MILL
DUST COLLECTION

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LOCKOUT PROCEDURE FOR TILT HOIST OPERATOR

1. Operator hit emergency stop button on console
2. Operator contact supervisor
3. Supervisor, leadman, or operator turn **Main disconnect off** (Pull handle down)
4. Supervisor, leadman, or operator **lock out main disconnect**
5. Operator apply lock to supervisors lock
6. Supervisor apply warning tag
7. Supervisor, leadman or operator **bleed off air** from air line luber (pull lever down)
8. Supervisor, leadman, or operator **lockout air line**
9. Supervisor test the machine to see if its really off.

RESTOREING ENERGY AND REMOVEING LOCKOUT DEVICES

1. Replace all guard and remove tools from area.
2. Open any air valves that were shut.
3. Remove any blocking devices that were inserted.
4. Remove any fuses that were removed.
5. Remove lock and tags.
6. Check area for workers
7. Notify affected employees that lockout devices have been removed.
8. Reactivate energy source and restart the machine.

LOCKOUT PROCEDURE FOR THE NEWMEN FEEDER II

1. Operator shut down the Newmen feeder (push E-stop button)
2. Operator turn off power to hydraulic pump (Pull lever down at disconnect)
3. Contact supervisor or leadman.
4. Supervisor or leadman apply lock to pump disconnect.
5. Operator and maintenance people apply their locks
- 3 Supervisor or leadman, or operator bleed off air (air release next to pump)
5. Supervisor, leadman, or operator lock out air.
6. Turn off power at **main disconnect** (Pull handle down) This kills power for conveyors
7. Supervisor, leadman or operator lock out main disconnect
8. Each person working on feeder must apply their lock
9. Supervisor apply warning tag.
- 10 Supervisor or leadman test machine to see if it is really off.

RESTOREING ENERGY AND REMOVEING LOCKOUT DEVICES

1. Replace all machine guards and remove tools from the area.
2. Open any air valves that were shut.
3. Remove any blocking devices that were inserted.
4. Replace any fuses that were removed
5. Remove lock and tag.
6. Check the area for workers
7. Notify affected employees that lockout devices have been removed.
8. Reactivate energy source and restart the machine.

LOCKOUT PROCEDURE FOR PINHEIRO PLANNER OPERATOR

1. Operator shutdown planner-Push red stop buttons for front and rear of machine.
2. Contact Supervisor or leadman
3. Supervisor or leadman notify everybody affected by lockout procedures.
4. Supervisor or leadman turn off power at main disconnect for all planner heads this is located next to Grinding room. (north east corner)
5. Operator or leadman lockout the planner heads
6. Operator apply lock to supervisors lockout.
7. Operator shutdown the 50 H.P. drive motor for the infeed rolls.(Push red button)
8. Operator turn off power at main disconnect, pulling handle down , located at bottom right of varidrive.
9. Operator apply lockout-
10. Supervisor or leadman test machine to see if it is really off.

RESTOREING ENERGY AND REMOVEING LOCKOUT Devices

1. Replace all machine guards and remove tools from the area.
2. Open any air valves that were shut.
3. Remove any blocking divices that were inserted.
4. Replace any fuses that were removed.
5. Remove lock and tag.
6. Check the area for workers.
7. Notify affected employees that lockout/tagout devices have been removed.
8. Reactivate energy source and restart the machine.

LOCKOUT PROCEDURE FOR TRIMMER OPERATOR

1. Operator turn off everything on console
2. Operator hit emergency stop button
3. Contact Supervisor or leadman
4. Operator or Supervisor go to disconnect for the trimsaws and pull the lever to the off position.
5. Supervisor Lockout the trimsaw disconnect
6. Operator apply lock with supervisor, all people working on this machine must apply their lock to the supervisors lock.
7. Operator bleed off air from trimmer.
8. Operator apply lock to bleed off.
9. Operator turn main disconnect off and lock it out(This would be the new disconnect panel located by Yates planner.
10. Operator test the machine to make sure it is really off.

RESTOREING ENERGY AND REMOVEING LOCKOUT DEVICES

1. Replace all machine buards and remove tools from the area.
2. Open any air valves that were shut
3. Remove any blocking devices that were inserted.
4. Replace any fuses that were removed.
5. Remove lock and tag.
6. Check the area for workers
7. Notify affected employees that lockout/tagout devices have been removed.
8. Reactivate energy source and restart the machine.

LOCKOUT PROCEDURE FOR THE NEWMEN FEEDER II

1. Operator shut down the Newmen feeder (push E-stop button)
2. Operator turn off power to hydraulic pump (Pull lever down at disconnect)
3. Contact supervisor or leadman.
4. Supervisor or leadman apply lock to pump disconnect.
5. Operator and maintenance people apply their locks
- 3 Supervisor or leadman, or operator bleed off air (air release next to pump)
5. Supervisor, leadman, or operator lock out air.
6. Turn off power at **main disconnect** (Pull handle down) This kills power for conveyors
7. Supervisor, leadman or operator lock out main disconnect
8. Each person working on feeder must apply their lock
9. Supervisor apply warning tag.
- 10 Supervisor or leadman test machine to see if it is really off.

RESTOREING ENERGY AND REMOVEING LOCKOUT DEVICES

1. Replace all machine guards and remove tools from the area.
2. Open any air valves that were shut.
3. Remove any blocking devices that were inserted.
4. Replace any fuses that were removed
5. Remove lock and tag.
6. Check the area for workers
7. Notify affected employees that lockout devices have been removed.
8. Reactivate energy source and restart the machine.

LOCK OUT PROCEDURE FOR DUST COLLECTION SYSTEM

1. Operator hit emergency stop button on panel-Push emergency stop button .
2. Contact supervisor
3. **Supervisor or leadman or operator lockout the main disconnect.**
4. Supervisor notify everyone affected by lockout procedure.
5. **Operator apply lock to supervisors lock.**
6. **All employees working on the dust system must apply there lock.**

RESTOREING ENERGY AND REMOVEING LOCKOUT DEVICES

1. Replace guards and remove tool from the area.
2. Remove any blocking devices that were inserted.
3. Replace any fuses that were removed.
4. Remove lock and tag.
5. Check the area for workers.
6. Notify affected employees that lockout devices have been removed.
7. Reactivate energy source and restart the machine.