

Open Government status: Fully Open	Paper Number: 61/03/06
	Meeting Date: 16 October 2003
	Type of paper:

RUBIAC WORKING GROUP. SAFE THREADING OF CALENDERS.

REPORT OF MEETING HELD 22 SEPTEMBER 2003 AT HSE LEEDS OFFICE.

Present

G King, HSE
A Hoyland, HSE
A Wood, BRMA
J Robinson, BRMA
M Potter, TUC

Purpose of the meeting

To review the practicability of the advice given at paragraph 49 of RUBIAC publication "Safeguarding of calenders in the rubber industry" in relation to the provision of limited movement devices for use when threading up calenders covered by the publication (i.e. those that were in existence at the date of publication – 1998).

Meeting conclusions

1. It is not practicable for users of calenders covered by the publication to follow the advice given in the last 3 sentences of paragraph 49 of the publication.
2. The advice in the publication should be revised to include guidance that is practicable for users to follow and which, at the same time, will ensure that the risks of injury to people during threading up of calenders are properly controlled.

Proposals

1. The requirement for provision of a limited movement (true inch) control should apply only where it is necessary to remove or disturb the normal production guards (we understand that, in practice, calenders are usually threaded with normal production guards in place and correctly set).
2. The guidance should recommend the following.
 - All the guards specified in the publication should be in position, correctly adjusted to the dimensions specified in the publication, in a sound state of repair and correct operational order whenever a calender is threaded up.

- A minimum of two people should be in attendance at the machine during threading-up so that one person is available to stop the machine in an emergency situation.
 - Threading-up should be carried out at a slow crawl speed of 12 linear feet per minute (3.65 metres per minute) or less.
 - The calender's normal operational speed control should be set to its lowest speed setting either before selecting slow crawl speed or to engage it. It is recommended that the selection of slow crawl speed is by means of a mode selector switch (i.e. either normal operation or slow crawl) that can be locked in the slow crawl position to avoid inadvertent selection of normal operating speeds during threading-up. As a minimum requirement, should slow crawl speed be selected by the normal operating speed control, the slow crawl speed position should be permanently and clearly marked at the position of the control device.
 - In exceptional circumstances where, for technical reasons, a slow crawl speed of 12 linear feet per minute (3.65 metres per minute) or less cannot be achieved a higher speed is permissible for threading-up provided it is the slowest speed at which the machine can be operated and provided it is achieved via a "hold to run" control button.
 - Where unprotected nips that are normally outrunning during production become in-running nips in reverse operation the slow crawl speed should be hold to run control buttons located front and back of the calender, requiring both to be simultaneously depressed, unless suitable guarding is in place to effectively prevent access to the nips.
3. Paragraph 46 of the publication should be amended to make it clear that the 1/8 of a revolution stopping performance applies to the tripping mechanisms associated with the various types of tripping guards described in the publication (manger guard, limited movement guard etc) as well as to emergency stop buttons and trip wires.
 4. Paragraph 50 should be amended to make it clear that the safeguards specified in it apply to any change of speed as well as to start up.

Recommendation

RUBIAC members should consider proposals 1 to 5 above; consult employer and trades union representatives in the industry and reach agreement on an appropriate course of action.