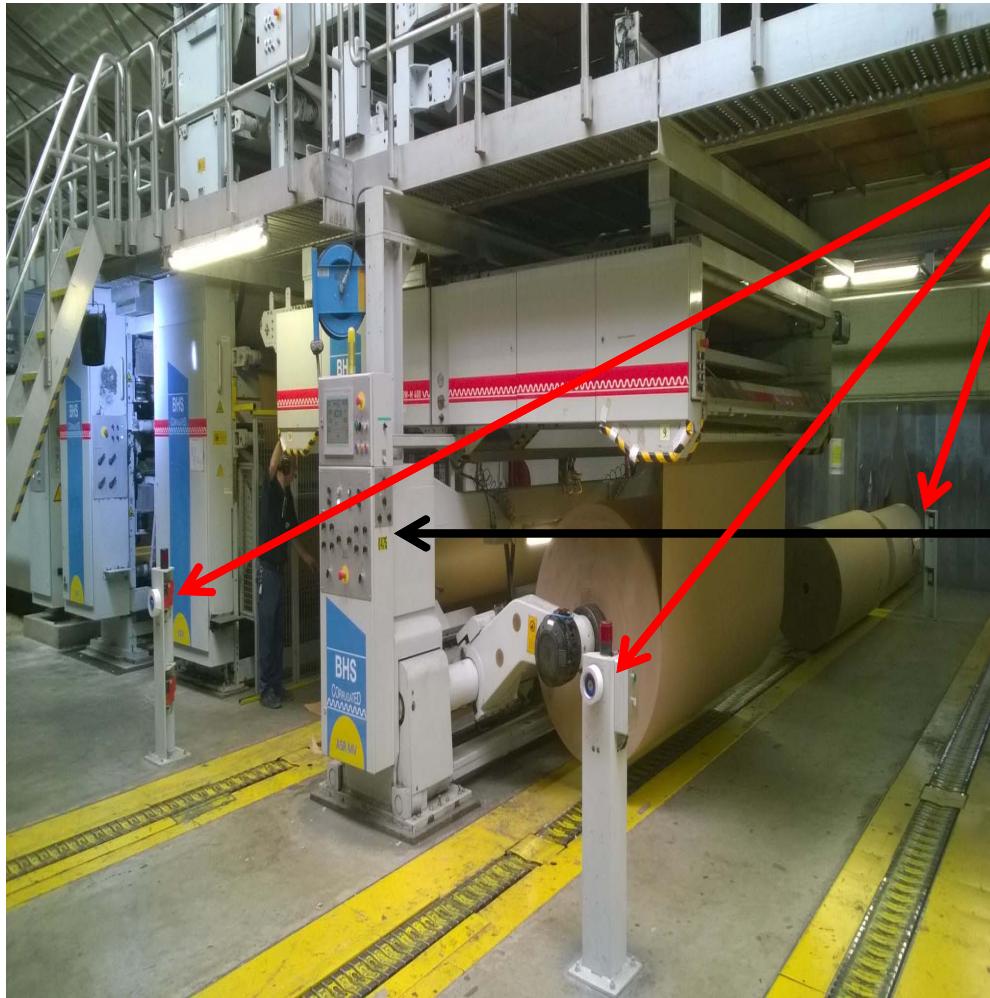




Corrugator Guarding and Safe Working Practices

Inspection Checklist

RS 01 - Reel stand



ESPD light guards around the reel stands.

Transmitter and Receiver operational during reel loading and unloading.

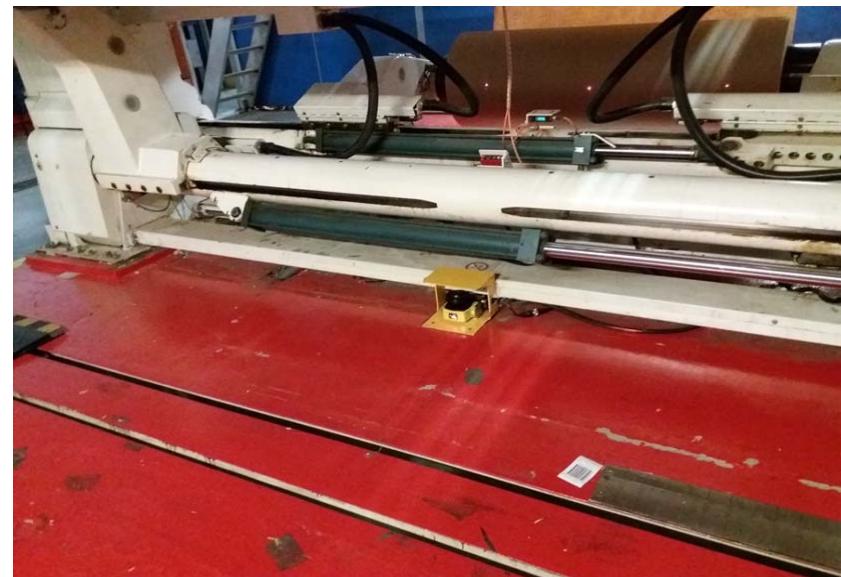
Reel stand control panel positioned away from the reel arm to prevent entrapment and crush injuries.

RS 01 & SP 01 - Reel stand



ESPD scanner positioned around the reel stand and splicer units.

Active during splicer carriage movement.



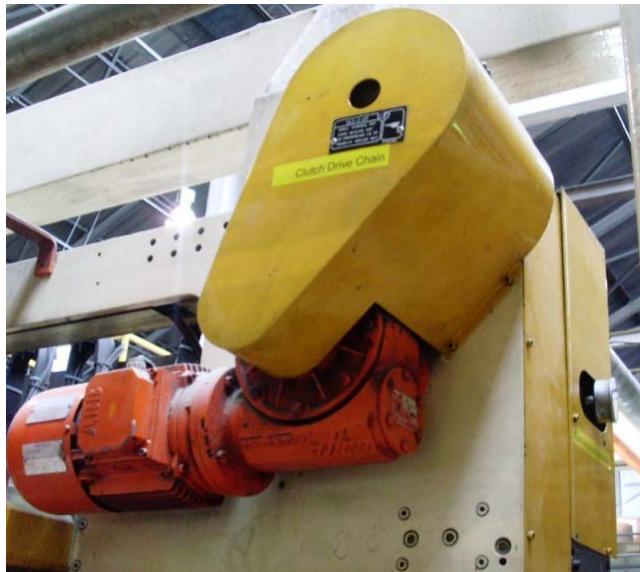
SP 01 - Splicer



Examples of fixed guarding around the splicer head, protecting the splicer and splicer blade.



SP 02 - Splicer

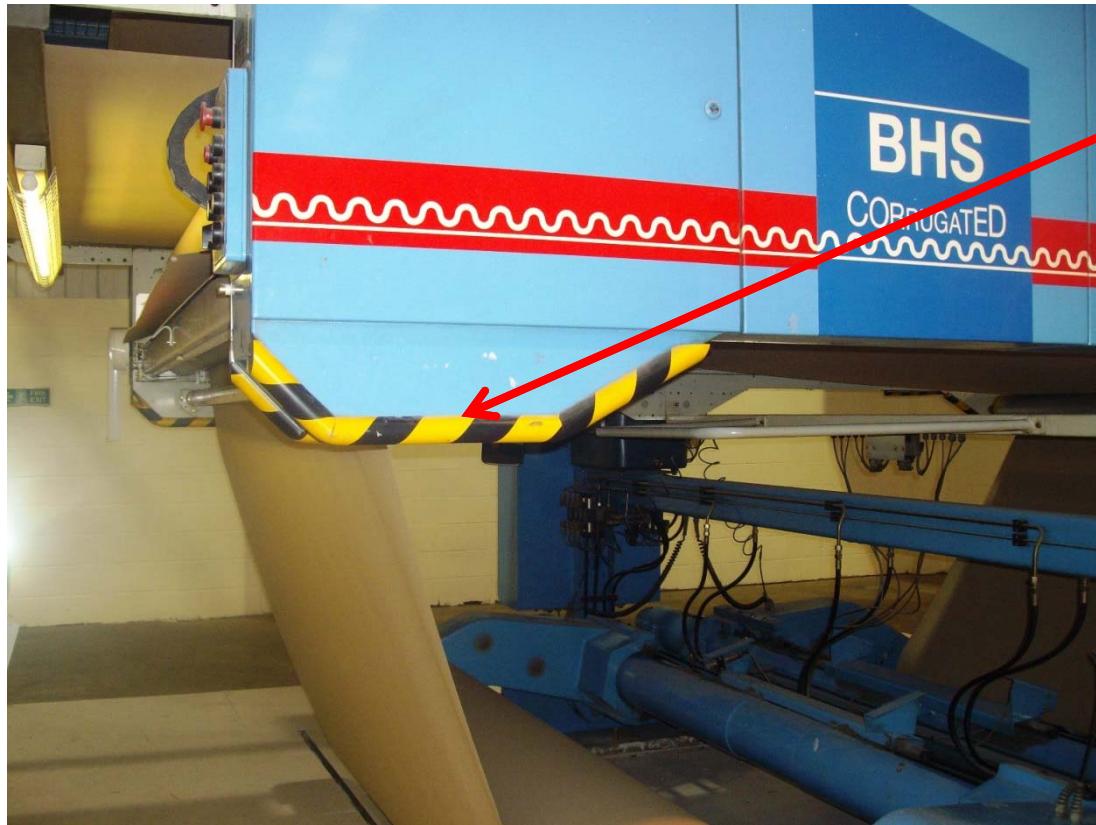


Fixed guarding around the splicer transmission parts.

NB: The design of the guard to facilitate adjustment of controls.



SP 03 Splicer



Highlighted bump protection around the splicer framework reducing head injury contact.

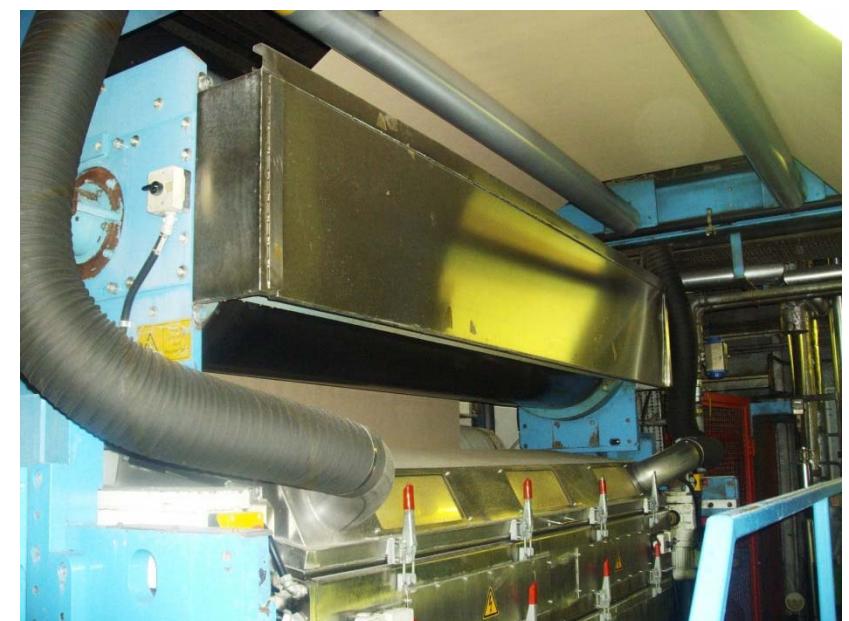


Splicer pneumatic (air) isolation point located on the drive side of the machine.

SF 01 - Single Facer



Fixed guarding and trapped key system installed around the corrugator and press roll.



SF 01 - Single Facer



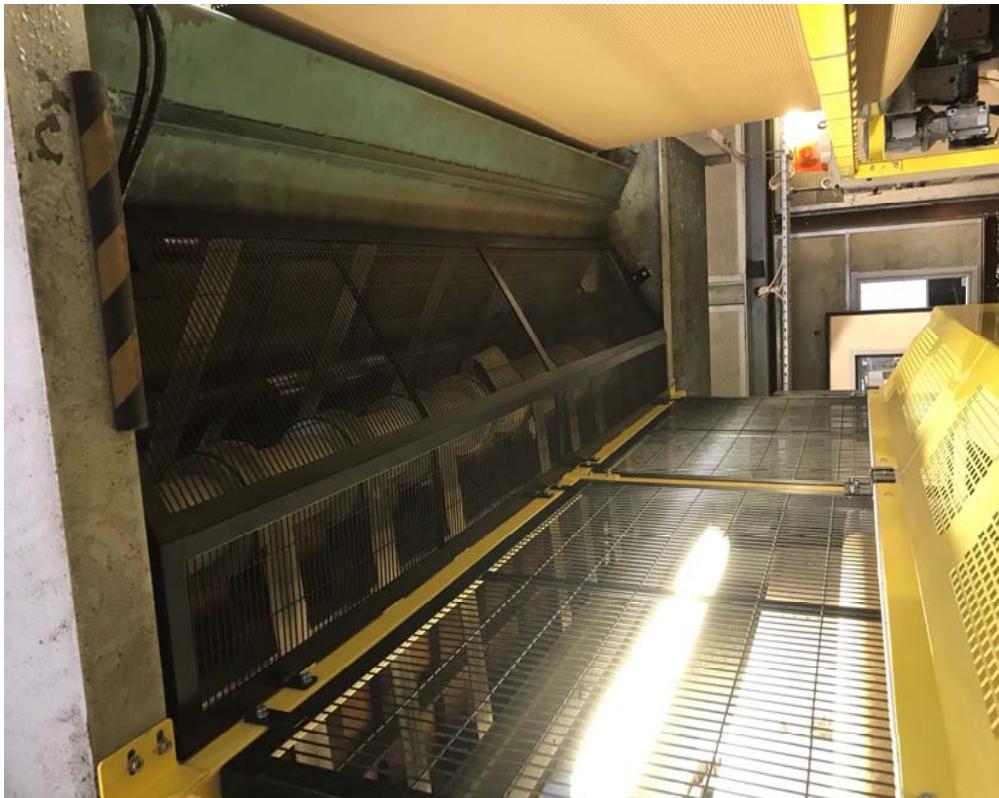
Fixed guarding and interlocked access gate / trapped key system on the operator side of the single facer, preventing access to the corrugator roll and the pre-heater.

SF 01 – Single Facer



Fixed guarding installed within the single facer and platform.

SF 07 - Single Facer



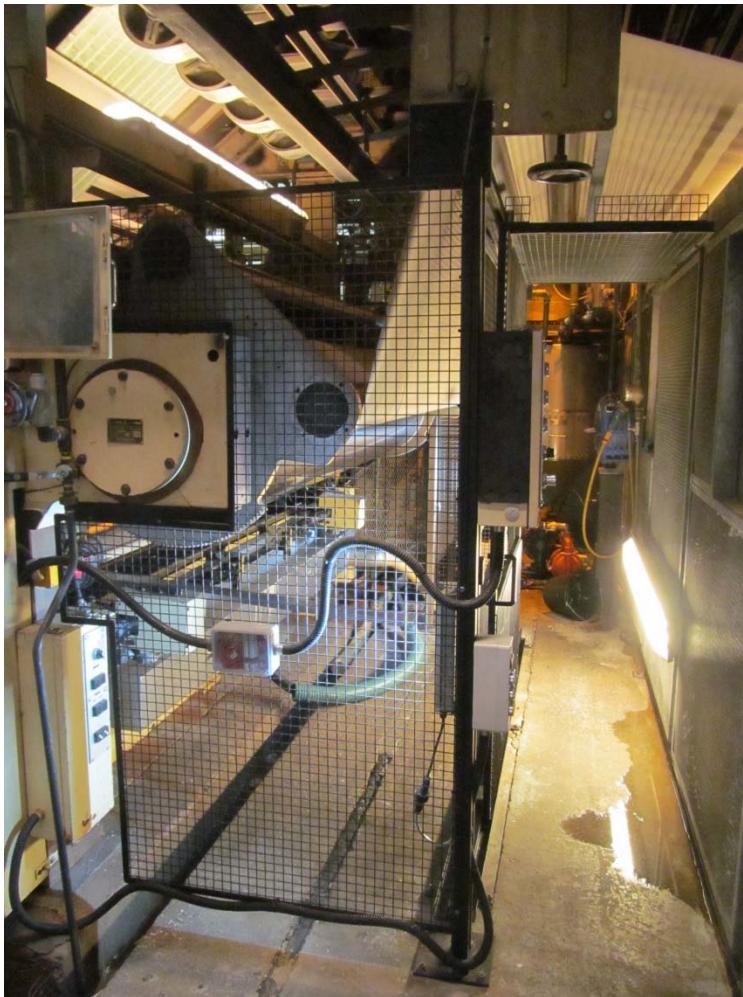
Fixed guarding installed around the sandwich belts where the web is exiting the single facer.

SF 11 - Single Facer



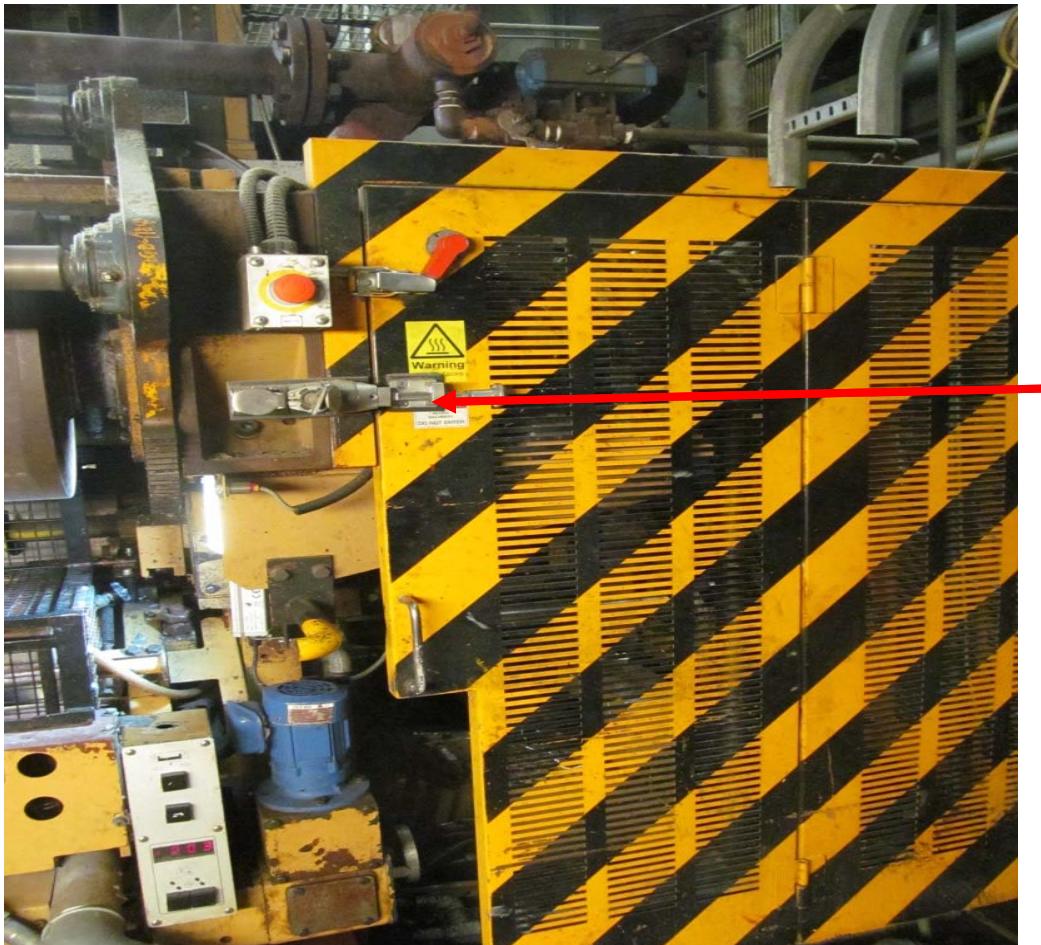
Protecting the corrugator roll cartridge with a heat resistant blanket once removed from the single facer, during the cool down period.

SF 13 - Single Facer



Fixed guarding and interlocked access gate / trapped key system on the drive side of the single facer.

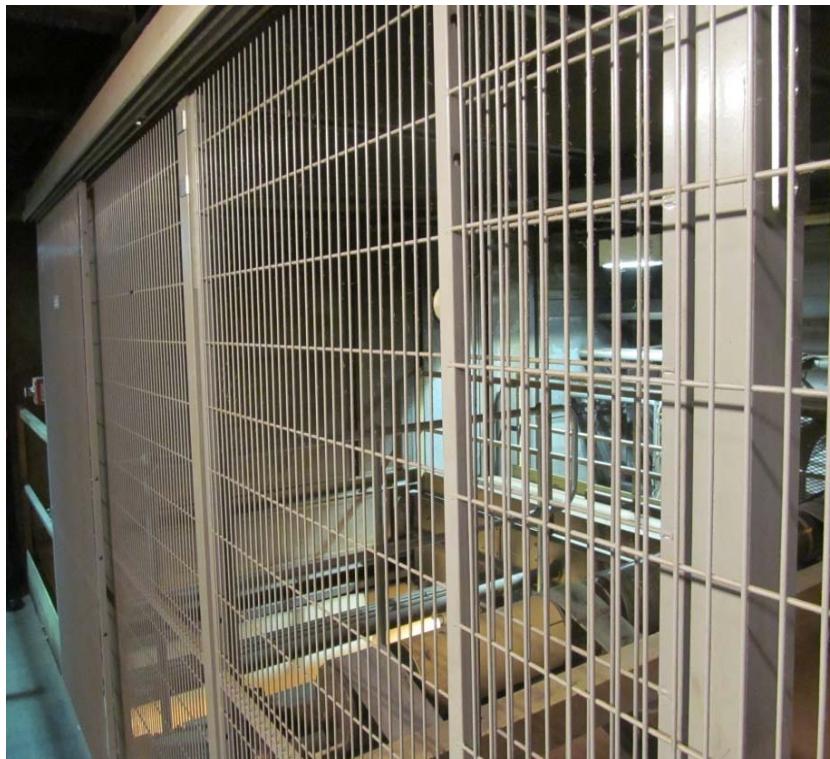




Drive side fixed guarding
access gate with trapped key
safety system.

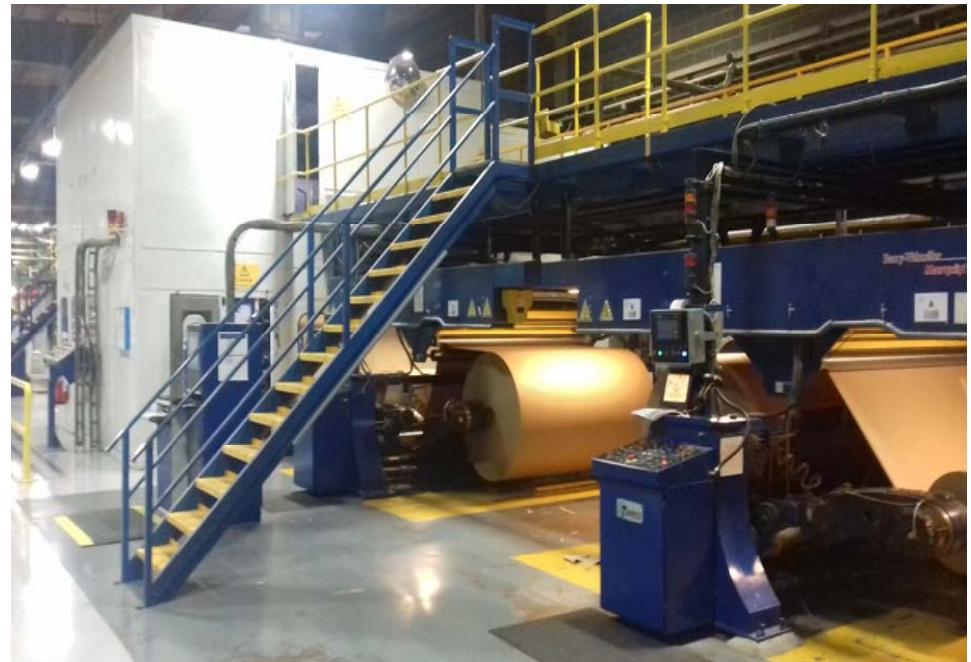


Acoustic sound proof enclosure installed around the single facer to reduce noise exposure.



Fixed guarding and interlocked access gate / trapped key system installed on the bridge section above the single facer to prevent access to moving parts.

BD 01 – Access to the bridge





Guard Rails / toe boards installed on the operator and drive side of the corrugator bridge. On a corrugator with 2 single facers, the web transfer on both need to have guard rails fitted, to protect persons working at height.





Interlocking access gate / trapped key system installed in front of the triple deck preheater protecting access to the pre-heater and the wrap arms.





Interlocked sliding access gate around the web guide and entry to the top pre-heater roll on the bridge.



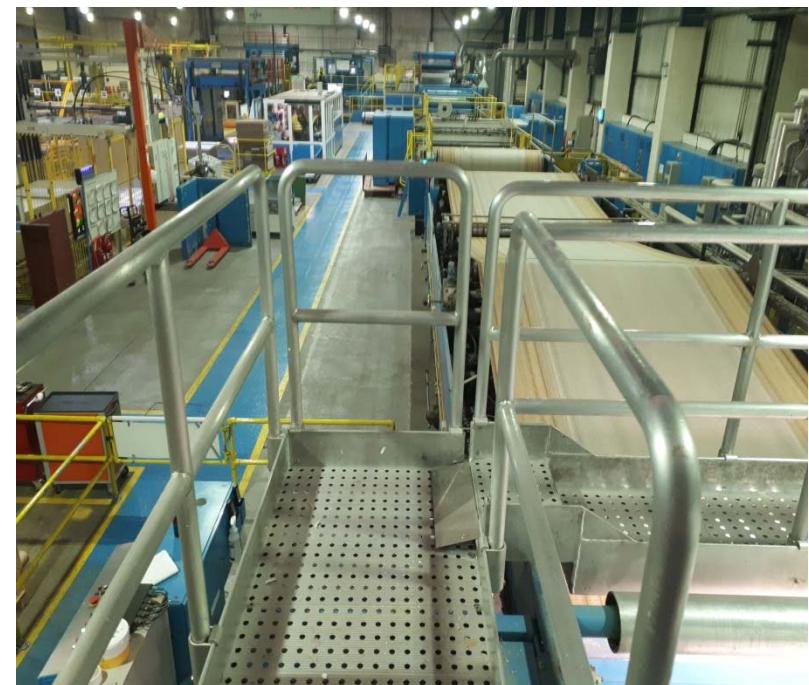


Fixed guarding and interlocking access gate / trapped key system installed on the drive side of the machine.

Steam pipe work lagged.



Guard rails and toe boards on the bridge around the triple deck Pre-heater,





Fixed interlocked access gate / trapped key system installed between the preheater and the double glue unit.

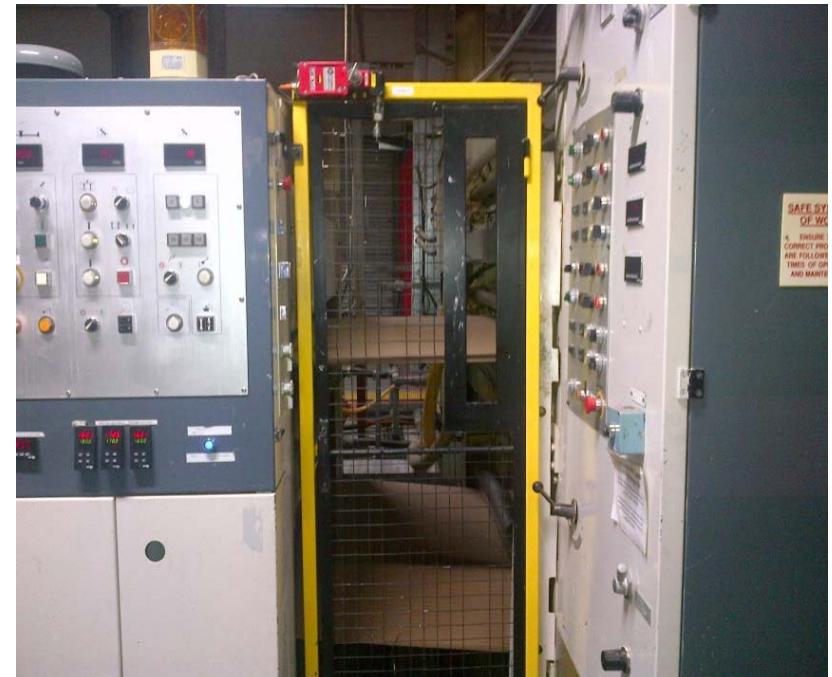




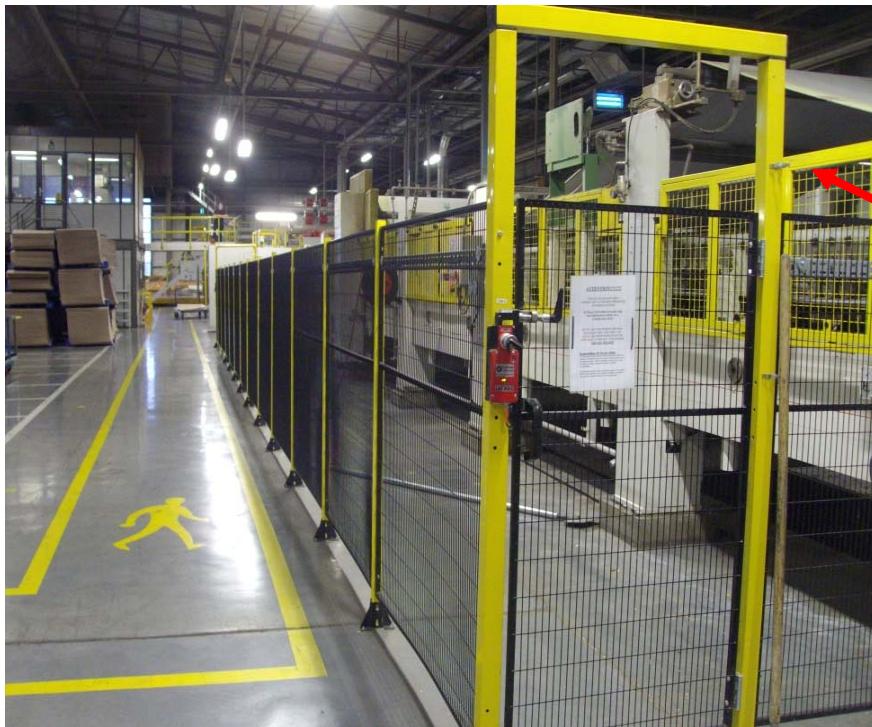
Trapped key access gate installed between the pre-heater and the double glue unit.



Interlocking access gate / trapped key access gate installed between the glue unit and the entry point to the double backer on the operator side.



DB 01 - Double Backer



Operator side perimeter fixed guarding with interlocking access gate / trapped key safety system.

Secondary machine guarding also installed.



DB 01 - Double Backer



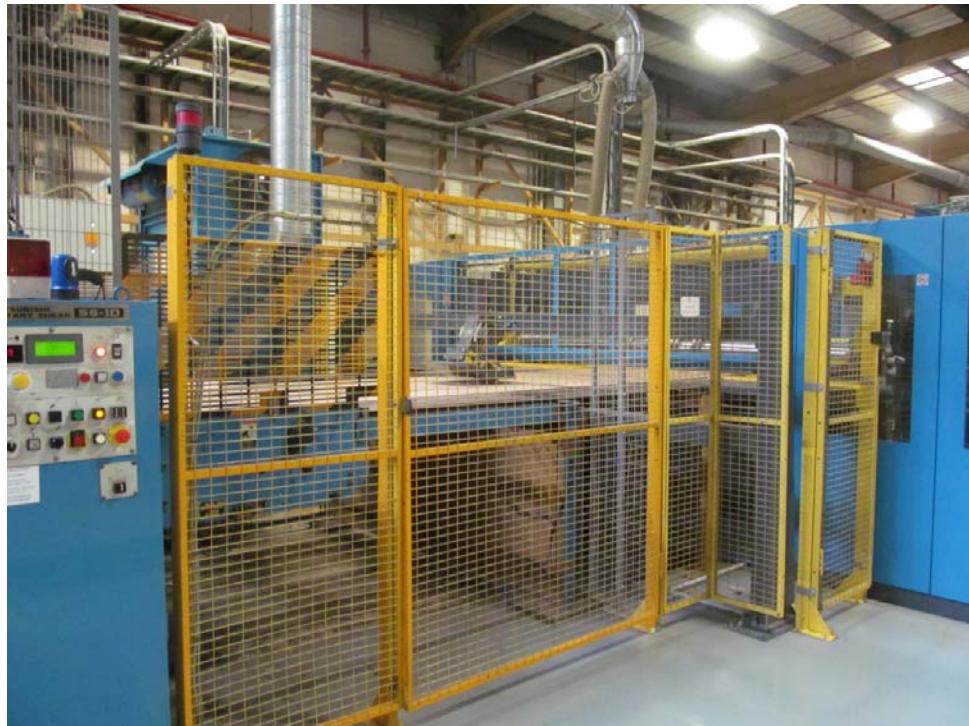
Drive side perimeter fixed guarding
and interlocking access gate / trapped
key safety system.





Fixed guarding and interlocking access gates installed on the operator side of the rotary shear unit to prevent access during waste removal.





Fixed guarding and interlocking / trapped key access safety system installed on the exit from the rotary shear – operator side.

RS 03- Rotary Shear



Interlocking access gate / trapped key system installed on the drive side of the rotary shear unit preventing access to the transmission parts.



Guard rails and toe boards installed around the Rippa tape applicator with mesh guarding preventing access on to the web and to preventing falls from the platform.



SS 01 - Slitter Scorer



Interlocking access door / trapped key safety system installed on the operator side of the slitter scorer.





Fixed guarding and interlocking access gate / trapped key safety system installed on the drive side.



Fixed guarding installed under the slitter scorer unit waste pit.

Controlled access with an interlocking access gate / trapped key system to prevent access to the waste pit whilst the unit is operational.





Guard rails and interlocking access gate / trapped key safety system installed to prevent access to the web leading to the slitter scorer.



CK 01 – Cut-off knife



Fixed Guarding and interlocking guarding / trapped key safety system to prevent entry to the cut-off knife during normal machine operation.



CK 01 – Cut-off knife



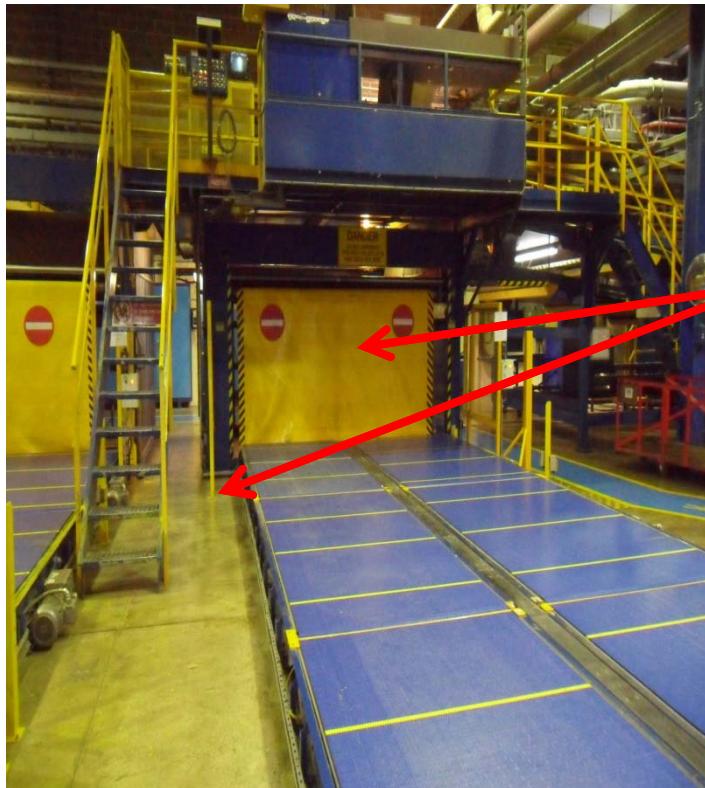
Fixed Guarding and interlocking guarding / trapped key safety system to prevent entry to the cut-off knife during normal machine operation.

CK 01 – Cut-off knife to down stacker



Fixed guarding and interlocking access gate / trapped key safety system on the exit from the cut-off knife.





Curtain and ESPE light guarding installed to prevent access under the lift table when the machine is running.



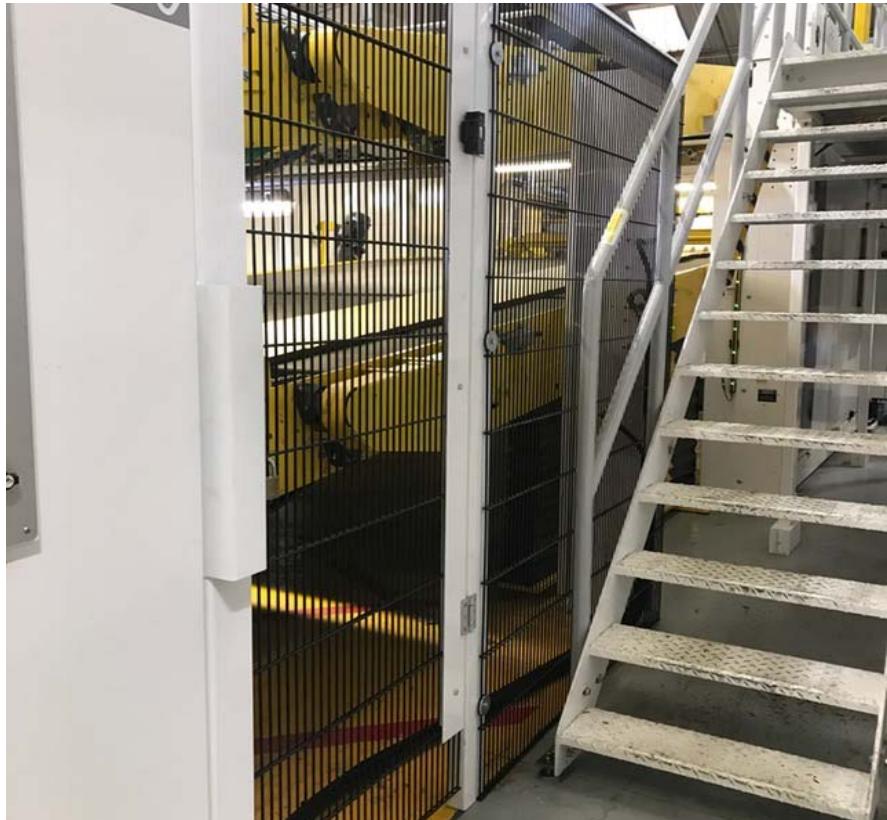
ESPE – light guarding on entry to the moving lift table on the operator side.



Fixed guarding installed on the drive side of the machine.



Access stairs and guard rails preventing a fall from height around the Downstacker.



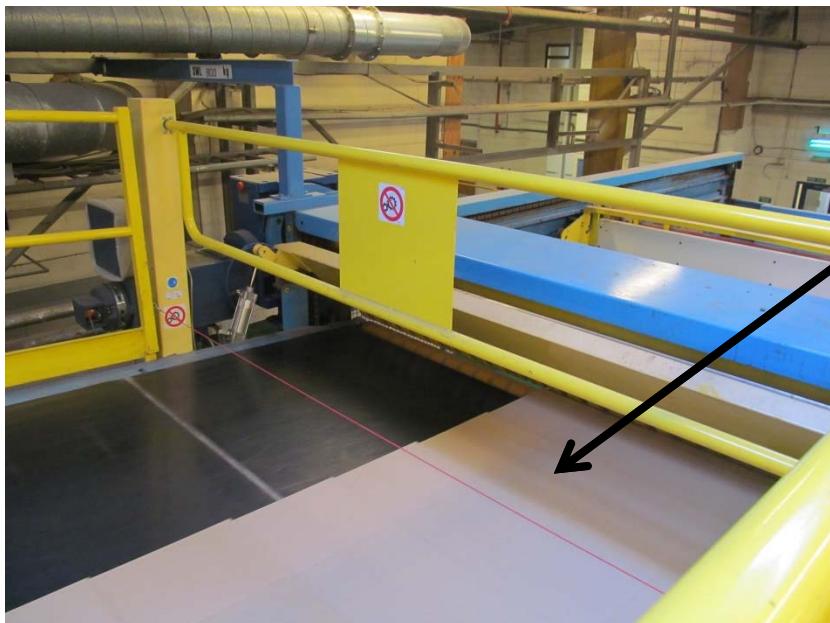
Fixed guarding installed on the operator side of the Downstacker.



Concertina curtain guard and / or ESPE light guarding installed under the Up/Downstacker.



Mechanical locking pins to secure the lift table during maintenance / engineering tasks whereby full body access is required under the lift table.



Stacker take off – gate and emergency stop trip wire installed across the width of the machine.



ESPE light guarding installed linked to the stacker control system to stop the stacker belt during normal machine operation.





When checking and removing board from the top down stacker conveyor, install a discharge inhibitor button to significantly reduce the belt speed to idle. The belt speed can be reset when the board has been removed by pulling out the inhibitor button.