	WORK INSTRUCTION:	Grinding Activity and equipment	Rev.
	HSEQ Procedure:	Project operations	Date: 26.03.16

1. General

Objective

The objective of this procedure is to ensure that grind working takes place responsibly and to eliminate risks.

Applicability

This procedure applies to employees of REC and third parties who carry out work for REC.

Definition/Term	Description
Requesting party Work permit	Person within REC who requests grinding has the work permit
Work equipment	The equipment that is used for the work
User	Person uses the work equipment.

2. Safety hazards

When working with (angle) grinder, the following risks may apply:

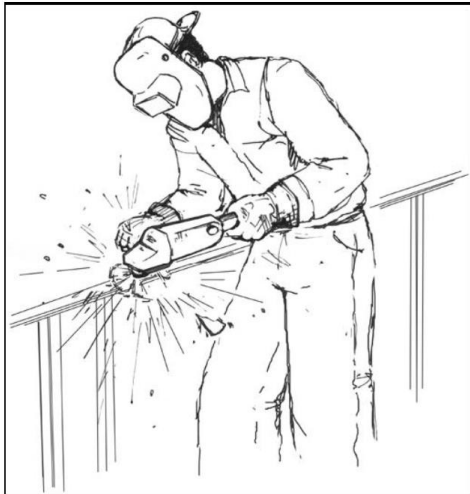
- Risk of breaking abrasive disk at high speed and flying fragments in case disk breaks apart
- Risk of clamping abrasive disk at high speed.
- Risk of grinding sparks in the near environment

3. Working method for (angle) Grinders

- Always wear eye protection when operating a grinder.
- Remove tie and hand jewellery, confine long hair and roll-up sleeves.
- Adjust and tighten wheel guards in place. (and use the correct type of disc, cutting/burring)
- If a spark guard is installed, adjust it to the correct place.
- Check to ensure that blotters and wheel flanges have been used to mount the wheels onto the shaft.
- Adjust and tighten the tool rest to within 1/8" from the wheel.
- Inspect the wheels to ensure they have a special rating greater than or equal to the grinder's speed rating and that they are in good condition. Cracked or chipped wheels must be replaced.
- Do not stand in line with the wheel when starting the grinder.
- Do not use the side of the wheel when grinding; use the face only.
- Use pliers or a vice grip to hold small items.

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- If the wheel vibrates: dress it (on the face only), replace it or replace the shaft bearings if they are worn.
- Allow the object you were grinding to cool before handling it.
- Unplug or lock-out the grinder before doing repairs.
- Never leave a grinder unattended while the wheels are turning.



4. Mandatory PPE:

- Safety footwear.
- Work clothing (possibly worn under a white disposable overall fitted with a hood)
- Work gloves
- Eye protection
- Ear protection
- P3 nose/mouth mask