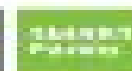


# Safe Operating Procedures



## SOP 20 – Feed Mill / Roller Mill Operation & Servicing

**DO NOT** proceed in this operation unless appropriately instructed in its safe use and operation and permission to operate has been given.

### COMPULSORY PPE



### AS NEEDED PPE



### PRE-OPERATIONAL SAFETY CHECKS

1. Prior to commencing operation of the milling plant operators must familiarise themselves with all aspects of the mill and auger system to the operating instructions contained in the mill manual.
2. Ensure area around Phase Converter is clear of any obstruction and electric motors have good air flow around cooling fins. Switch on each Phase Converter one at a time and check that both have powered up properly.
3. Check all nuts, bolts and attachments to ensure that they have not shaken loose during operation.
4. Ensure that all covers and safety guards are fitted and operation signs attached to plant.
5. Locate all emergency stop buttons and note their location.
6. Locate and identify all electric motor isolating switches.
7. Check all electrical leads. Do not operate if electrical leads are damaged.
8. On the Main Switch Board, inspect and identify all control switches and the power for their operation.
9. IF IN DOUBT ASK.
10. Ensure work site is clear of tools and other equipment or debris to prevent tripping.
11. Ensure that there is sufficient ventilation for fumes and dust to dissipate to enable safe operation.

### OPERATIONAL SAFETY CHECKS

1. Select size for which grain is to be used.
2. Open the slide gate approximately 2 cm by moving the slide handle which is located on the outer ring of the slide base. Note: If the slide gate is open wider than 2 cm then additional vertical load is placed on the auger cones, but no additional feed of grain will occur, so there is no adjusting to do so. Once grain is flowing, slide can be set to appropriate position to maintain required flow.
3. Check that the bank which is to have the rolled grain is close and clear of other plant.
4. Once the selected bank is determined, position the lever below the mill discharge auger in the correct position.
5. Shut off slide gate to allow all grain through mill system and then shut down.
6. TO START ELECTRICAL POWER: Follow switch order for mill start.
7. TO START THE MILL: Check the start button before starting the mill. Use the control points at surge bin and drag auger to regulate output.
8. Mill Adjustment – the mill adjustment cone requires manual setting by loosening the lock nut and adjusting.

This SOP should be used in conjunction with relevant machinery manuals and manufacturer recommendations.

Procedure Reference	Version	Effective Date	Review Date	Page Number	Date Printed
WAG SOP 20	1.0	28/06/2016	28/06/2021	1	28/04/2016

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**Grant Wesley Carter**

A red circular graphic with a gradient, appearing as a partial circle or a thick arc, located to the right of the author's name.

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