

- 1. Purpose:** The purpose of this procedure is to control the identified hazards in the Manufacturing process and provide guidelines for safety.
- 2. Scope:** The procedure is applicable to all the Powder Coating process.
- 3. Description:**

Sr. No.	Activity	Responsibility
1	<b>Material receiving</b> Bring the material near to loading station of pre-treatment using cotton hand gloves and safety shoes.& from all side equally material is removed for avoiding trolleys falls due to unbalance of weight of trolleys.	Operator
2	Load the material and put in Fixture / trolley.	Operator
3	Lifting the Fixture safety by Transporter with use transporter lift the fixture and deep in to degreasing tank. Operator should use safety apron and shoes safeguard from splashes of chemical from tank.	Operator
4	<b>Degreasing (Ferrous and Non Ferrous)</b> Using rubber hand gloves and safety shoes, prepare the solution and addition in Degreasing tank, and dip the components trolley in Degreasing tank ,use nose mask to protect from fumes of degreasing tank solution.	Operator
5	<b>Water Rinse I &amp; II -</b> Take the components trolley and wash in water rinsing tank avoid splashing of water by slowly dipping the components trolley in tank.	Operator
6	<b>DE - Rusting / Off Line De-Rusting</b> Using rubber hand gloves and safety shoes, prepare the solution and addition in De-rusting tank, and dip the components trolley in De-rusting tank ,use nose mask to protect from fumes of de-rusting tank solution.	Operator
7	<b>Water Rinse III</b> Take the components trolley and wash in water rinsing tank avoid splashing of water by slowly dipping the components trolley in tank.	Operator
8	<b>Activation</b> Using rubber hand gloves and safety shoes, prepare the solution and addition in Activation tank, and dip the components trolley in Activation tank ,use nose mask to protect from fumes of Activation tank solution.	Operator
9	<b>Water Rinse VI &amp; VII</b> Take the components trolley and wash in water rinsing tank avoid splashing of water by slowly dipping the components trolley in tank..	Operator
10	<b>Phosphating, passivation</b> Using rubber hand gloves and safety shoes, prepare the solution and addition in phosphating tank, and dip the components trolley in phosphating tank ,use nose mask to protect from fumes of phosphating tank solution.	Operator
11	<b>Powder Spraying</b> The job is moved to spray booth where the powder is sprayed by spray gun manually using the safety goggle, nose mask, apron and Hand gloves. Ensure Weekly cleaning of all powder booth post filters. Ensure all the material in contact with powder is grounded	Operator
12	<b>Powder Baking Oven</b> Job is moved by conveyer to baking oven for curing at 230 - 240 Oc.Use hand gloves to unload the hot jobs	Operator

**etv practices**

Use of PPE specially nose mask V415 is must inside booth and pt line .and fire extiuisher ABC TYPES 6 KG are placed incase of fire

All the material in vicinity of SPRAYING guns should be properly earth

