

Hazard Analysis and Risk Control Record										
Doc ref:			Task/Process Assessed:		Fit up swages					
Revision:			Location:							
Date:			Assessment Team:							
Operation:			Approved by:							
Activity Steps	HAZARD		INITIAL RISK			CONTROL MEASURES		RESIDUAL RISK		
	Hazard Description and Worst Case Consequences with no Prevention or Mitigation Measures in Place	Loss Category/ Population Affected	Likelihood	Severity	Risk Level	List all Current and Planned Control Measures, taking into Account all Contributing and Escalating Factors		Likelihood	Severity	Risk Level
						Current and Planned Prevention Measures to reduce Likelihood	Current and Planned Mitigation Measures to reduce Severity			
1. Operating Overhead Konecrane	Load drop causing asset damage & injuries to personnel	Assets Personnel	Possible (3)	Major (-3)	Undesirable (-9)	- Pre check lifting gears such as slings, spreader bars, shackles are certified & in good condition and within the lifting load handling capacity prior to use - Operator to be trained in mechanical lifting level 1 before permitted to operate the overhead crane - Operator to check that the overhead crane is in good condition prior to use - Toolbox meeting to communicate the daily plan and work intention to all involved worker - Hazards identified in the HARC briefed to all the operators to create awareness	- First aid kit available & readily accessible on site - Mandatory PPE such as hard helmet, safety shoes, safety glasses & leather gloves	Unlikely (2)	Light (-2)	Acceptable (-4)

Lifting swages to the grinding machine	Load drop causing asset damage & injuries to personnel Hand injures	Assets Personnel	Possible (3)	Major (-3)	Undesirable (-9)	- Pre check lifting gears such as slings, spreader bars, shackles are certified & in good condition and within the lifting load handling capacity prior to use - Weight of load to be established & does not exceed safe working load - Load to be fully fastened & secured & well balanced before the lifting operation - Lifting plan available & readily accessible on site - Watch out surface pinch or nib point on their working equipment , tools and table and to avoid position their hands thereon - Hazards identified in the HARC briefed to all the operators to create awareness	- First aid kit available & readily accessible on site - Mandatory PPE such as hard helmet, safety shoes , safety glasses & leather gloves	Unlikely (2)	Light (-2)	Acceptable (-4)
Moving swages using the overhead crane	Load drop causing asset damage & injuries to personnel Hand injures	Assets Personnel	Possible (3)	Major (-3)	Undesirable (-9)	- Ensure the path of the load is freed of obstruction - No personnel allow entry into the lifting work zone area when moving is in progress. - Pre check lifting gears & accessories prior to using them - Load to be move at appropriate clear safe height. - Pre plan lifting journey - Only trained personnel is permitted to use the mobile crane. - Watch out surface pinch or nib point on their working equipment ,tools and table and to avoid position their hands there - Hazards identified in the HARC briefed to all the operators to create awareness	- First aid kit available & readily accessible on site - Mandatory PPE such as hard helmet, safety shoes , safety glasses & leather gloves	Unlikely (2)	Light (-2)	Acceptable (-4)

Unloading swages to the grinding machine using konecrane	Load drop causing asset damage & injuries to personnel Hand injuries	Assets Personnel	Possible (3)	Major (-3)	Undesirable (-9)	- Lower the load smoothly and slowly - Operator to keep his hands, fingers & fit away from the load during the loading process - Check & ensure the unloading area is free of obstruction during unloading - Watch out surface pinch or nib point on their working equipment ,tools and table and to avoid position their hands there - Hazards identified in the HARC briefed to all the operators to create awareness	- First aid kit available & readily accessible on site - Mandatory PPE such as hard helmet, safety shoes , safety glasses & leather gloves	Unlikely (2)	Light (-2)	Acceptable (-4)
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Swages grinding using air grinder	Injuries to personnel Hand injuries	Personnel	Possible (3)	Major (-3)	Undesirable (-9)	• Pre check grinding machine electrical cord & connection for signs of loose exposed or crushed wiring prior to use • Check & ensure the ventilation system is in working condition • Check & ensure that the pressure hose connection is firmly attached to the grinding unit prior to use • Pre check & ensure that guards are implaced & grinding units such as tail stock, steady rest are locked down before commencing the grinding activity • Check & ensure no oil nor water spill at site prior to commencing grinding activity • No bunks no part container shall be placed at site in a manner obstructing the equipment nor grinding activity • Grinding wheel shall be hold by the inside and tap around the inside of the wheel while listening for ringing sound • Stop all grinding activity if a thud or dull sound is heard • Jewelry , loose clothing and long unkept prohibited for operator operating the grinding machine • All cracked or broken shields or disc shall be replaced immediately • Use approved wheel surfacing tool to grind on the working edge • Never attempt to surface the side of the grinding stone • Readjust tool to 1/8 inch or closer to the grinding surface of the stone after stone is surfaced • Ensure that the gap between the work rest and grinding stone is not more than 1/8 inch • Pre check and ensure the grinding stone is RPM rated • Ring test new stone by suspending on handle of screw driver and tap it lightly with a small wrench • Get supervisor to verify the new stone if light ringing sound is not heard • Stop all grinding activity if a strong vibration is generated • Never attempt to slow down grinder by forcing material into the grinding stone or by hard brushing • Never grind the side of the stone. Always grind at the working edge • Take extra precaution when grinding soft materials such as copper, aluminium and brass • Use vise grips to hold the grinded part & cooled the part with compressed air	• First aid kit available & readily accessible on site • Mandatory PPE such as hard helmet, safety shoes , face shield, leather gloves, ear plugs and fire retardant coverall. • Fire extinguisher readily accessible & available on site	Unlikely (2)	Light (-2)	Acceptable (-4)
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					• Operator trained on the correct procedure to guard & start up the processes • Operator to be trained in workshop safety level 1 before they can operate the grinding machine • Pre check and ensure ventilation system is in working condition • Safety signage displayed to warn operator not to lean against unit to be grinded • Operators to adopt SIPP techniques during the grinding process. • Operator to ensure that his working area is cleared and has no obstruction before he commenced grinding job • Mandatory grinding wheel condition pre check prior to use • Only trained operator can performed the grinding job • Watch out surface pinch or nib point on their working equipment ,tools and table and to avoid position their hands there • Toolbox meeting to communicate the work intention to all involved workers • Hazards identified in the HARC briefed to all the operators to create awareness			
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Welding, torching	Fire Hazards Hand injuries	Personnel Asset				- Only trained personnel can perform the job - Pre work station survey to ensure it is free from combustible material - Pre-check on the welding & cutting equipment and ensure that it is in good condition prior to use - Ensure the ventilation system is in good working condition - Ensure the electrode holder & ground clamp is not in contact with one another - Pre check & ensure the welding rod barrel is free of trash - Pre check & ensure that the grinding machine is set up in the correct position prior to commencing welding - Pre check connection leakage using soapy water - Guide marker on the acetylene & oxygen pressure gauge setting of 5 & 25 PSI respectively - Ensure tank restraint chains are in place on the torch cart and the torch body valves are shut off - Do not attempt to change a tool when machine tool is working - Never attempt to handle the oxy-acetylene equipment with oily hands as such combination is explosive - Safety signage displayed at site to warn operators not to handle shavings with bare hands - Watch out surface pinch or nib point on their working equipment ,tools and table and to avoid position their hands there - Pre check & ensure the ground clamp is firmly attached to the unit to be welded - Safety signage displayed to warn operator not to lean against unit to be welded - Safety signage to warn operator to use only dry leather glove during welding - Perform welding & cutting in the designated hot work permitted area - Fire retardant PVC curtain installed to contain fire spread - Mandatory fire watch at work area for 1 hr after work completion followed by 3 hr fire watch - Adopt SIPP Technique on all welding activities - Toolbox meeting to communicate the work intention to all involved workers - Switch off the welding equipment upon job completion - Mandatory 1 hr & 3 hr fire watch upon job completion	- First aid kit available & readily accessible on site - Mandatory PPE such as hard helmet, safety shoes , face shield, leather gloves, ear plugs and fire retardant coverall. - Fire extinguisher readily accessible & available on site - Worker familiar with the fire emergency exit	Unlikely (2)	Light (-2)	Acceptable (-4)
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Possible
(3)

Major
(-3)

Undesirable
(-9)

						• Ensure the ventilation system is in good working condition prior to welding activity • Check & ensure the electrode holder & clamp is not in contact with one another • Ensure the welding rod barrel is free of trash • Safety signage to warn operator not to lean against the unit to be welded • Safety signage to warn operator to use only dry leather glove for welding activity • Hazards identified in the HARC briefed to all the operators to create awareness				
Operating the torch a)Position torch tip b)Turn on tanks c)Oxygen & acetylene gas pressures	Injuries to personnel - Hand injuries - Burns Damaged to property -fire	Personnel Asset	P o s i b l e (3)	M a j o r (-3)	U n d e s i r a b l e (-9)	• Always face torch tip away from body and tank assembly when lighted • Always turn on the acetylene tank 1st followed by the oxygen tank • Purge oxygen & acetylene gas pressure individually before lighting the torch • Turned on acetylene first then the oxygen knob on torch handle before lighting the torch • Pre check and ensure the oxy-acetylene equipment & its accessories are free of pinch points and hidden traps • Operators trained on the emergency evacuation procedures • Operators trained on how to use fire extinguisher • Always kept the lighted torch away from oxygen & acetylene tank •	• First aid kit available & readily accessible on site • Mandatory PPE such as hard helmet, safety shoes , leather gloves , ear plugs & face shield • Fire extinguisher readily available & accessible on site • Workers familiar with the emergency escape routes	Un i k e l y (2)	Lig h t (-2)	Acce p t a b l e (-4)
Turning off the torch	Injuries to personnel - Hand injuries - Burns Damaged to property -fire	Personnel Asset	P o s i b l e (3)	M a j o r (-3)	U n d e s i r a b l e (-9)	• When turning off the torch face the torch tip away from body and oxygen & acetylene tank • Turn torch body valves off , acetylene 1st followed by turning the tank valves off followed by turning off the acetylene • Coil hose neatly around cart handle • Pre check and ensure the oxy-acetylene equipment & its accessories are free of pinch points and hidden traps • Operators trained on the emergency evacuation procedures • Operators trained on how to use fire extinguisher • Always kept the lighted torch away from oxygen & acetylene tank •	• First aid kit available & readily accessible on site • Mandatory PPE such as hard helmet, safety shoes , leather gloves , ear plugs & face shield • Fire extinguisher readily available & accessible on site • Workers familiar with the emergency escape routes	Un i k e l y (2)	Lig h t (-2)	Acce p t a b l e (-4)

Changing tank on cart a) Tanks b) Regulator c) Check connection after changing	Injuries to personnel - Hand injuries - Burns Damaged to property - fire	Personnel Asset	Possible (3)	Major (-3)	Undesirable (-9)	- Change the tank whenever the working pressure begin to fall - Tank valve caps must be in place on tanks before releasing the restraining chains - Replacement tanks must be chained to torch cart - Blow out cylinder valves using low pressure before attaching the regulator to cylinder valve - Release adjusting screws on the regulator before opening the cylinder valve - Purge oxygen & acetylene gas pressure individually - Do not stand facing the valve when turning on fresh oxygen tank for the 1st time - Check tank regulator connection using only soapy water	- First aid kit available & readily accessible on site - Mandatory PPE such as hard helmet, safety shoes, leather gloves, ear plugs & face shield - Fire extinguisher readily available & accessible on site - Workers familiar with the emergency escape routes	Unlikely (2)	Light (-2)	Acceptable (-4)
Moving cart out of designated area	Injuries to personnel - Hand injuries - Burns Damaged to property - fire	Personnel Asset	Possible (3)	Major (-3)	Undesirable (-9)	- Always remove the regulators and install caps on the bottles before moving the cart out of the shop floor - Ensure the bottle restraint are in place - Operator trained on the correct technique to move cart out - Pre check cart, regulators and bottle caps for signs of pinch points and hidden traps - Operator trained on the use of fire extinguisher	- First aid kit available & readily accessible on site - Mandatory PPE such as hard helmet, safety shoes, leather gloves, ear plugs & face shield - Fire extinguisher readily available & accessible on site - Workers familiar with the emergency escape routes	Unlikely (2)	Light (-2)	Acceptable (-4)
Inspect work station	Injuries to personnel - slipping - tripping - electrical shock	Personnel	Possible (3)	Major (-3)	Undesirable (-9)	- Perform 5s by removing unwanted items & tripping hazards from the work station - Cleaned all visible spills at work station - Pre check all electrical cables & connection prior to using the electrical equipment - Stay focus on task - Hazards identified in the HARC briefed to all the operators to create awareness	- First aid kit available & readily accessible on site - Mandatory PPE such as hard helmet, safety shoes, leather gloves & ear plugs	Unlikely (2)	Light (-2)	Acceptable (-4)

Position mandrel body on the swage fitter	Injuries to personnel -hand & feet injuries	Personnel	Possible (3)	Major (-3)	Undesirable (-9)	- Pre check lifting gears such as slings, spreader bars, shackles are certified & in good condition and within the lifting load handling capacity prior to use - Weight of load to be established & does not exceed safe working load - Load to be fully fastened & secured & well balanced before the lifting operation - Lifting plan available & readily accessible on site - Watch out surface pinch or nib point on their working equipment , tools and table and to avoid position their hands thereon - Hazards identified in the HARC briefed to all the operators to create awareness	- First aid kit available & readily accessible on site - Mandatory PPE such as hard helmet, safety shoes , leather gloves & ear plugs	Unlikely (2)	Light (-2)	Acceptable (-4)
Tack weld lower & upper swage	Injuries to personnel -eyes injuries -burns -mashed fingers & feet	Personnel	Possible (3)	Major (-3)	Undesirable (-9)	- Pre check the welding equipment and its accessories & ensure the electrical cables & connections is in good condition prior to use - Pre check the welding equipment , its accessories & the mandrel for signs of pinch points & hidden traps - Only trained operator can perform the job - Mandatory SIPP Level 2 training for operators - Hazards identified in the HARC briefed to all the operators to create awareness	- First aid kit available & readily accessible on site - Mandatory PPE such as hard helmet, safety shoes , leather gloves & ear plugs & face shield - Workers familiar with the emergency exits - Fire extinguisher is readily available & accessible on site	Unlikely (2)	Light (-2)	Acceptable (-4)

Remove fitted bar from vessel assembly	Injuries to personnel -hands injuries - feet injuries	Personnel	Possible (3)	Major (-3)	Undesirable (-9)	- Pre check the vessel assembly & the fitted bar for signs of pinch point & hidden traps - Operator trained to adopt the correct transfer technique - Mandatory SIPP Level 2 training for all operators - Operator to adopt SIPP Technique during the transferring process - Only trained operator can performed the job - Ensure the intended transport path is free of obstruction & spills - Pre check the crane & its lifting accessories & ensure they are in good condition prior to use - Hazards identified in the HARC briefed to all the operators to create awareness	- First aid kit available & readily accessible on site - Mandatory PPE such as hard helmet, safety shoes , leather gloves & ear plugs	Unlikely (2)	Light (-2)	Acceptable (-4)
Transfer vessel from swage fitting station to the staging rack	Injuries to personnel -hands injuries - feet injuries	Personnel	Possible (3)	Major (-3)	Undesirable (-9)	- Pre check the vessel & fitting station for signs of pinch point & hidden traps - Operator trained to adopt the correct transfer technique - Mandatory SIPP Level 2 training for all operators - Operator to adopt SIPP Technique during the transferring process - Only trained operator can performed the job - Ensure the intended transport path is free of obstruction & spills - Hazards identified in the HARC briefed to all the operators to create awareness	- First aid kit available & readily accessible on site - Mandatory PPE such as hard helmet, safety shoes , leather gloves & ear plugs	Unlikely (2)	Light (-2)	Acceptable (-4)
Inspect robot & its accessories	Injuries to personnel -electrical shock - hand injuries	Personnel	Possible (3)	Major (-3)	Undesirable (-9)	- Pre check the robot & its accessories for signs of pinch points & hidden traps prior to use - Report any loose wiring to supervisor immediately if detected - Mandatory Electrical Level 1 training for all operators - Hazards identified in the HARC briefed to all the operators to create awareness	- First aid kit available & readily accessible on site - Mandatory PPE such as hard helmet, safety shoes , leather gloves & ear plugs	Unlikely (2)	Light (-2)	Acceptable (-4)

Load fixture & clamp part	Injuries to personnel -electrical shock - hand injuries	Personnel Asset	Possible (3)	Major (-3)	Undesirable (-9)	- Pre check the fixture & its accessories as well as clamp for signs of pinch points and hidden traps - Operator to adopt SIPP Level 2 Technique during loading - Ensure the clamping station is free of obstacle & spills. - Pre check all electrical & control cables for signs of expose or crushed wiring - Mandatory SIPP Level 2 training & Electrical Level 1 training - Only trained operator can perform the job - Operator trained on the correct technique to load & clamp the mandrel - Hazards identified in the HARC briefed to all the operators to create awareness	- First aid kit available & readily accessible on site - Mandatory PPE such as hard helmet, safety shoes , leather gloves & ear plugs - Workers familiar with the emergency exits	Unlikely (2)	Light (-2)	Acceptable (-4)
Turn on controls for robot & related equipment	Injuries to personnel - Electrical shock Damaged to asset -fire	Personnel Asset	Possible (3)	Major (-3)	Undesirable (-9)	- Pre check the robot & its related equipment for signs of pinch points & hidden traps - Pre check the connection and wiring for signs of exposed or crushed phenomena - Only trained operator can perform the job - Working voltage of the robot & its related equipment clearly displayed on equipment - Mandatory training on electrical Level 1 & LOTO Level 1 for operators - Hazards identified in the HARC briefed to all the operators to create awareness	- First aid kit available & readily accessible on site - Mandatory PPE such as hard helmet, safety shoes , leather gloves & ear plugs - Workers familiar with the emergency exits - Fire extinguisher readily accessible & available on site	Unlikely (2)	Light (-2)	Acceptable (-4)

Engaging Robot	Injuries to personnel -trip due to existing concrete steps -eyes	Personnel	Possible (3)	Major (-3)	Undesirable (-9)	• Pre check the robot & its related equipment for signs of pinch points & hidden traps • Pre check the connection and wiring for signs of exposed or crushed phenomena • Only trained operator can perform the job • Working voltage of the robot & its related equipment clearly displayed on equipment • Mandatory training on electrical Level 1 & LOTO Level 1 for operators • Safety signage displayed at site to alert operator on existing concrete steps • Hazards identified in the HARC briefed to all the operators to create awareness	• First aid kit available & readily accessible on site • Mandatory PPE such as hard helmet, safety shoes , leather gloves , ear plugs & face shield	Unlikely (2)	Light (-2)	Acceptable (-4)
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Remove cut- out from the mandrel vessel	Injuries to personnel -hand injuries due to sharp edges -feet injuries due to fallen object	Personnel	P o s s i b l e (3)	M a j o r (-3)	U n d e s i r a b l e (-9)	• Ensure the robot is in stationary mode prior to remove the cut-out • Pre check the cut out for signs of pinch points & hidden traps prior to removal • Pre check over head hoist & its accessories & ensure they are in good physical condition prior to use • Operator trained on the correct technique to remove cut-out • Only trained are allowed to perform the job • Only trained operator can operate the over head hoist • Ground guide to provide direction of visibility is poor • Ensure the hoisted cut out weight is within the safe working load of the hoist • Ensure the overhead hoist safe working load is prominently displayed at site • Hoist the heavier cut-out in a slow steady non jerky manner • No one is allowed to be under or near the hoisted cut-out • No authorized personnel allowed entry during the hoisting process • Hazards identified in the HARC briefed to all the operators to create awareness	• First aid kit available & readily accessible on site • Mandatory PPE such as hard helmet, safety shoes , leather gloves & ear plugs	Unl ikel y (2)	Lig ht (-2)	Acce ptabl e (-4)
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Remove vessel assembly from robot fixture and place on fit up fixture	Injuries to personnel -hand injuries due to pinch points -loose clothing trapped in between fixture -slipping -tripping -feet injuries due to fallen object	Personnel	P o s i b l e (3)	M a j o r (-3)	U n d e s i r a b l e (-9)	• Pre check the overhead hoist and its accessories and ensure they are within the validity period & are in good physical condition prior to use. • Pre check vessel assembly & robot fixture for signs of pinch points and hidden traps prior to removal • Operators shall tucked in their working clothing at all times • Operator trained on the correct technique On vessel removal from robot fixture & positioning on fit up fixture • Only trained operator are allowed to perform the job • Operator to adopt SIPP level 2 technique during the entire removing & positioning process • Ensure the work station is free of spills & obstacles • Mandatory SIPP level 2 & Workshop safety level 1 training for all operators • Safe working load of the overhead hoist prominently displayed at site • No one allowed to be under or near the lifted load • No access to unauthorized personnel; during the lifting operations • Hazards identified in the HARC briefed to all the operators to create awareness	• First aid kit available & readily accessible on site • Mandatory PPE such as hard helmet, safety shoes , leather gloves & ear plugs	Unl i k e l y (2)	Lig h t (-2)	Acce p t a b l e (-4)
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Grind all slag and scale from cuts-out	Injuries to personnel -hand injuries due to pinch points -tripping -clothing entrapped grinding machine -feet injuries due to fallen object -eyes injuries due to flying fragments -hearing loss due to noise generated -burns due to contact to freshly grinded area	Personnel	P o s i b l e (3)	M a j o r (-3)	U n d e s i r a b l e (-9)	• Pre check the grinding machine connections and ensure there is no crushed or exposed wiring phenomena • Operator to maintain a safe distance during the grinding process • Operator shall tucked in their working clothing at all times • Operator to stop all work if any unusual sound is reported form the grinding machine • Ensure the cuts-out is secured prior to grinding them • Operator trained on the correct procedure to guard and start up processes • Never attempt to position blowing fan facing directly the operator face • Pre check and ensure guards are implaced & grinding unit such as tail stock, steady rest are locked down prior to grinding activity • Grinding wheel shall be hold from the inside & tap around the inside of the wheel while listening for a ringing sound. • Stop all grinding activity if a thud or dull sound is heard • Nothing is to be positioned near the grinding unit in a manner obstructing the grinding unit control & activity • Jewelry & long unkept hair are prohibited when operating the grinding machine • Never handle shavings with bare hands • Never attempt to change the tooling insert when the machine tool is working • Ensure the grinding machine is setup in the correct position prior to use • Operator trained on the correct technique to grind all slag & scale • Only trained operators are allowed to perform the job • Safety signage on potential burns to alert operators prominently displayed at site • Only trained operators can perform the job • Operator to adopt SIPP technique and ensure that he is always working in his green zone. • Mandatory training on Workshop Safety Level 1 & SIPP level 2 for all operators • Unauthorised personnel prohibited form entry during the grinding process • Hazards identified in the HARC briefed to all the operators to create awareness	• First aid kit available & readily accessible on site • Mandatory PPE such as hard helmet, safety shoes , leather gloves ,ear plugs and face shield	Unl ikel y (2)	Lig ht (-2)	Acce ptabl e (-4)
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Fit the pocket to the vessel	Injuries to personnel -hand injuries due to pinch points -tripping -feet injuries due to fallen objects	Personnel	Possible (3)	Major (-3)	Undesirable (-9)	- Pre check the pocket & the vessel for signs of pinch points & hidden traps prior to fitting - Pre check the overhead hoist & its lifting accessories & ensure it is within its validity date & in good physical condition prior to use - Ensure the transported path is free of obstruction & spills - Only trained operator are allowed to operate the overhead hoist - Operator trained on the correct technique to fit the pocket - Operator to adopt SIPP level 2 technique during the entire hoisting process - Mandatory training on Workshop Safety level 1 & SIPP Level 2 for all operators - No one is allowed to be under or near the lifted load - Unauthorised personnel prohibited from access during the lifting operation - Safe working load of the overhead hoist prominently displayed at sight - Hazards identified in the HARC briefed to all the operators to create awareness	- First aid kit available & readily accessible on site - Mandatory PPE such as hard helmet, safety shoes, leather gloves & ear plugs	Unlikely (2)	Light (-2)	Acceptable (-4)
Remove part from fitup fixture and place them in staging rack	Injuries to personnel -hand injuries due to pinch points -tripping -feet injuries due to fallen objects	Personnel	Possible (3)	Major (-3)	Undesirable (-9)	- Pre check mandrel, fit up fixture & staging rack for signs of pinch points & hidden traps prior to fitting - Pre check the overhead hoist & its lifting accessories & ensure it is within its validity date & in good physical condition prior to use - Ensure the transported path is free of obstruction & spills - Only trained operator are allowed to operate the overhead hoist - Operator trained on the correct technique for parts removal - Operator to adopt SIPP level 2 technique during the entire hoisting process - Mandatory training on Workshop Safety level 1 & SIPP Level 2 for all operators - No one is allowed to be under or near the lifted load - Unauthorised personnel prohibited from access during the lifting operation - Safe working load of the overhead hoist prominently displayed at sight - Hazards identified in the HARC briefed to all the operators to create awareness	- First aid kit available & readily accessible on site - Mandatory PPE such as hard helmet, safety shoes, leather gloves & ear plugs	Unlikely (2)	Light (-2)	Acceptable (-4)