

Management	Operator	Maintainer	Cleaner	Visitor	Safety Around Conveyors: Whose Responsibility
					Safety Requirement
X					Establish safe conveyor start-up procedures.
X					Instruct workers on how and when to use E-stop devices such as 'cable pull' wires.
X					Allow only properly trained workers who are aware of the hazards to operate, inspect, repair, or clean the conveyor.
X					Prohibit covering, modifying, bypassing, disabling, or misusing conveyor controls and safeguards.
X					Require all safety guards, covers, and controls to be in place when the conveyor is in operation.
X					Train all personnel in safe work procedures.
X					Restrict conveyor access to only those whose jobs require access.
X					Establish policies and procedures (JSAs) for conducting specific tasks on or around belt conveyors.
X					Assure that safe access is provided to all working areas.
X					Train workers and visitors in the proper use and care of their PPE.
X					Provide hazard-identification training to persons who observe, operate, and work in the vicinity of equipment.
X					Prohibit standing, walking, or riding on the moving conveyor.
X					Investigate all conveyor and personnel accidents or near misses to find root causes.
X					Address changes to equipment, materials, or work processes for new risks.
X					Provide safe access to any area where cleaning or maintenance will take place.
X					Test monthly and document that all safety controls and E-stops are properly working.
X					Label all controls.
X	X	X	X	X	Mitigate identified hazards immediately.
X	X				Do not overload conveying equipment.
X		X	X		Ensure the proper tools are provided, maintained, and used to complete all tasks.
	X	X	X		Ensure manufacturer's manuals are reviewed prior to beginning work.
X	X	X	X	X	Report unsafe conditions.
	X	X	X	X	Be aware that ladders, stairs, catwalks, walkways, and surfaces may be slippery.
	X	X	X		Ensure that all persons are clear before operating the conveyor.
	X	X	X	X	Bind hair and loose clothing before going near conveyors.
	X	X	X		Clean conveyor components only when safe.
	X	X	X	X	Cross conveyor only at designated crossing points.
	X	X	X		Remove 'danger' or 'repair' tags only after the hazard is eliminated or repair completed.
	X	X	X		Keep conveyor walkways, passages, and immediate areas clear.
	X	X	X	X	Maintain communications with all persons working along the conveyor(s).
	X	X	X		Clear all personnel, tools, and materials from the conveyor before starting the belt.
X	X	X	X		Prohibit relying on an emergency stop to (routinely) stop or restart the conveyor.
	X	X	X		Shut down conveyor [LOTO/BOTO] to free, adjust, or repair idlers.
	X	X	X		Shut down and lockout machines before cleaning, oiling, adjusting, or repairing.
	X	X	X	X	Use Lockout / Tagout / Blockout / Testout Procedure.
	X	X	X		Keep people and tools away from moving parts.
	X	X	X		Control falling materials and flying debris.
	X	X	X		Return tools to proper places before the conveyor is restarted.