

If you would like to discuss conveyor safety at your facility or find out more about our range of products and services, designed specifically for your sector - **Please get in touch.**



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# CONVEYOR SAFETY

## A GUIDE TO WORKING SAFELY WITH CONVEYORS

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# A GUIDE TO WORKING SAFELY WITH CONVEYORS

Conveyors are among the most efficient equipment in factories and other industrial sites. They are often referred to as belt conveyors, conveyor belts or belt conveyor systems.

Conveyors, like other heavy equipment, pose several hazards to employees. These hazards are often dependent on the operation and maintenance of workers. That is why employers must provide proper and complete training to conveyor operators. Employees who work near or around conveyors must also be trained to prevent hazards posed by this equipment.

Most accidents around belt conveyors are caused by human error, improper maintenance procedures, lack of effective training or lack of awareness of possible hazards.

The **No.1** cause of injury occurs while performing maintenance, lubrication or checking the belt conveyor

The **No.2** cause of injury occurs when cleaning and shovelling around belt conveyors

## GENERAL REQUIREMENTS

Here are some general requirements for working safely with conveyors:

- Only properly trained workers are allowed to operate, repair, and service conveyor equipment
- **NEVER** exceed the maximum load rating indicated on the conveyor by the manufacturer
- **NEVER** step on/over, climb, sit or ride on conveyors
- Keep tools and other equipment away from the conveyor
- Keep all body parts, including hair, away from parts of the conveyor
- Make sure that the area around the conveyor is free from tools and objects that may cause trips or slips - this is especially true for areas around the loading and unloading points of the conveyor
- Appropriate guards must be provided for conveyors that pass over work areas, aisles, pathways or thoroughfares - these guards must be conspicuously marked with appropriate signs to warn employees of hazards
- If the conveyor passes overhead exposure, employees **MUST** wear hard hats
- The operator must **NEVER** leave the conveyor unattended
- Inspect all conveyors and transmission devices at a regular basis - the inspection intervals must not exceed **60 DAYS**

## STOP/START STANDARDS

Too many accidents have happened in the past just because operators don't follow proper procedures in starting and stopping conveyors. Some conveyors also lack appropriate switches or devices for emergency situations, making the equipment even more dangerous for operators and employees working near them.

Here are some safety standards concerning conveyor stop and start controls/devices:

- Conveyors equipped with electrically released brakes **MUST** be designed in such a way that the brakes cannot be released unless power is applied
- The design of the conveyor **MUST** have the ability to automatically engage the brakes or return the operating control to the "STOP" position in case there is a power failure
- Means for stopping the motor or engine **MUST** be within reach from the operator's station
- Operators **MUST** sound an audible warning signal before starting up a conveyor
- Emergency stop devices **MUST** be within reach of the operator
- Emergency stop switches **MUST** be designed in such a way that the conveyor system cannot be started unless the actuating stop switch is reset to running or "ON" position
- **NEVER** start powered conveyors until the area around the conveyor is free of employees - if employees have to work near the conveyor, they **MUST** be warned when the conveyor is about to start

## LOCKOUT AND TAGOUT PROCEDURES

Operators must be trained to perform the proper procedures in locking or tagging a conveyor. Otherwise, all employees are exposed to hazards such as getting their fingers (and other body parts) cut, having their bones crushed, or getting killed on the spot.

Whenever a conveyor is under repair or maintenance, it should be stopped with their power sources locked out and tagged out. The same is true for a conveyor that needs servicing. Exceptions are given to conveyors that need power for testing or making minor adjustments.

If a conveyor is jammed, it must be locked out and tagged out in the stop position before removing the cause of the jam, unless the conveyor needs to be turned on to remove the jam.

### Disclaimer

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