

Manual-lathe short-bar turning - JSA - B

en-SG · Technical failure review · v1.0 · 2026-10-14 · Sources: article section 9

Site: | Item ID: | Work area:

Approval	Work supervisor	Technical reviewer	Release / handover authority

1. Job details and team signatures

Date / time	Location / area			Assessor		Supervisor	
Team signatures							

2. Conditions and hold points

Stage	Time	Location / area	Environment / readings	Item / condition	Controls	Plant / tools	Approval / signature
HP-0 Start							
HP-1 Isolate and set tooling							
HP-2 Secure stock and clearance							
HP-3 Hold faults and restart							
HP-4 Clean and transfer							

Complete after actual checks. Recheck after changes, defects or shift handover.

3. JSA risk assessment

Job stage	Hazards and effects	Failure factors	Technical and procedural controls	Site verification	P	S	R	A
1. Inspect machine and zone	1. Flying chips 2. Slip injury 3. Delayed stop	1. People exposed 2. Oil on floor 3. Stop inaccessible	1. Protect adjacent people 2. Clear floor and bed 3. Keep stop accessible	1. Exclusion and shields 2. Floor/bed clear 3. Operator competence				
2. Isolate and set tooling	1. Hand cut 2. Tool release 3. Wrong cutting condition	1. Sharp tool mishandled 2. Holder loose 3. Settings improvised	1. Handle isolated edges safely 2. Secure correct tooling 3. Use documented settings	1. Tool/holder condition 2. Fastening/support 3. Speed/feed/depth basis				
3. Secure stock and clearance	1. Chuck collision 2. Support failure 3. Key ejection	1. Travel interferes 2. Projection excessive 3. Key left in chuck	1. Check permitted clearances 2. Apply specified support 3. Remove key immediately	1. Travel/clearance 2. Projection/support 3. Key/tool count				
4. Start and cut	1. Workpiece ejection 2. Chip eye injury 3. Tool failure	1. Grip inadequate 2. Shield missing 3. Cut forced	1. Use controlled first cut 2. Retain guards/shields 3. Stop abnormal behaviour	1. Cutting response 2. Guarded zone 3. Tool/work stability				
5. Stop and measure	1. Restart during access 2. Sharp-chip injury 3. Hot-stock burn	1. Control unsecured 2. Hands clear chips 3. Hot work touched	1. Prevent restart for access 2. Use chip-removal tools 3. Assess handling temperature	1. Access/energy state 2. Chip-removal method 3. Measurements/temperature				
6. Hold faults and restart	1. Hidden chuck damage 2. Symptom masked 3. Defective part released	1. Inspection omitted 2. Cause unrecorded 3. Restart equals quality pass	1. Inspect isolated setup 2. Verify cause and correction 3. Inspect affected parts	1. Jaw/tool/support findings 2. Corrected setup evidence 3. Restart/part disposition				

P/S/R/A: Complete only after actual site assessment using the site risk method.

4. Pre-work checklist

☐ Exclusion and shields	☐ Tool/holder condition	☐ Travel/clearance
☐ Cutting response	☐ Access/energy state	☐ Jaw/tool/support findings
☐ Operator competence	☐ Tool/work stability	☐ Restart/part disposition