

Manual-lathe short-bar turning - JSA - A

en-SG · Basic task controls · 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. Plan stock and cut	1. Stock ejection 2. Wrong material cut 3. Unsupported projection	1. Limits unknown 2. ID missing 3. Support not assessed	1. Match stock and drawing 2. Check material suitability 3. Verify workholding limits	1. Material/dimensions 2. Drawing revision 3. Chuck/support limits				
2. Isolate and set tooling	1. Unexpected rotation 2. Hand cut 3. Tool release	1. Power available 2. Sharp tool mishandled 3. Holder loose	1. Control energy for setup 2. Handle isolated edges safely 3. Secure correct tooling	1. Isolation state 2. Tool/holder condition 3. Fastening/support				
3. Secure stock and clearance	1. Stock slips 2. Chuck collision 3. Support failure	1. Jaw contact poor 2. Travel interferes 3. Projection excessive	1. Verify effective jaw grip 2. Check permitted clearances 3. Apply specified support	1. Jaw/contact condition 2. Travel/clearance 3. Projection/support				
4. Start and cut	1. Entanglement 2. Workpiece ejection 3. Chip eye injury	1. Gloves/loose clothing 2. Grip inadequate 3. Shield missing	1. Remove gloves and loose items 2. Use controlled first cut 3. Retain guards/shields	1. Clothing/hair/gloves 2. Cutting response 3. Guarded zone				
5. Stop and measure	1. Coasting contact 2. Restart during access 3. Sharp-chip injury	1. Switch-off assumed safe 2. Control unsecured 3. Hands clear chips	1. Wait for full standstill 2. Prevent restart for access 3. Use chip-removal tools	1. Actual standstill 2. Access/energy state 3. Chip-removal method				
6. Clean and transfer	1. Residual chips cut 2. Unattended restart 3. Wrong next setup	1. Chips left 2. Power unsecured 3. Settings not shared	1. Clean after safe stop 2. Secure machine 3. Transfer approved settings	1. Cleanup/guard state 2. Power/key state 3. Part/setting record				

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

4. Pre-work checklist

☐ Material/dimensions	☐ Isolation state	☐ Jaw/contact condition
☐ Clothing/hair/gloves	☐ Actual standstill	☐ Cleanup/guard state
☐ Chuck/support limits	☐ Guarded zone	☐ Part/setting record