

Manual-lathe short-bar turning - JSA - C

en-SG · Supervision, records, handover · 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. Machine and stock review	1. Stock ejection 2. Machine used beyond limits 3. Wrong part produced	1. Chuck limits absent 2. Supplier documents missing 3. Drawing outdated	1. Match stock and chuck 2. Obtain actual machine data 3. Verify drawing criteria	1. Stock and drawing identity 2. Machine and chuck instructions 3. Support and cutting basis				
2. Setup release	1. Unexpected rotation 2. Tool release 3. Chuck-key ejection	1. Supply not isolated 2. Toolholder loose 3. Tools left on bed	1. Verify isolation and standstill 2. Check tool and holder 3. Remove all setting tools	1. Isolation verification 2. Tool height and fastening 3. Chuck key and tool count				
3. Workholding acceptance	1. Bar slips 2. Chuck collision 3. Support failure	1. Poor jaw contact 2. Travel unreviewed 3. Projection unsupported	1. Check effective grip 2. Verify full travel clearance 3. Provide specified support	1. Jaw and contact findings 2. Tool and chuck clearances 3. Projection and support record				
4. Rotating-work control	1. Entanglement 2. Flying chips 3. Unstable first cut	1. Gloves near rotation 2. Shield absent 3. Settings improvised	1. Remove gloves and loose items 2. Maintain guarding and shields 3. Observe specified first cut	1. Dress and guarded boundary 2. Speed feed and depth basis 3. Stock and tool response				
5. Measurement and fault review	1. Coasting contact 2. Repeated ejection 3. Defective part released	1. Slow rotation treated safe 2. Speed change masks cause 3. Restart equals part acceptance	1. Stop and prevent restart 2. Inspect isolated fault setup 3. Separate part disposition	1. Standstill and access state 2. Cause and correction evidence 3. Measurements and part hold				
6. Shift transfer	1. Unattended restart 2. Chip injury 3. Known defect reused	1. Power left available 2. Cleanup incomplete 3. Restrictions not passed	1. Secure machine after work 2. Use tools for stopped cleanup 3. Transfer settings and holds	1. Power and guard state 2. Cleanup and part identity 3. Receiver and open actions				

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

4. Pre-work checklist

☐ Stock and drawing identity	☐ Isolation verification	☐ Jaw and contact findings
☐ Dress and guarded boundary	☐ Standstill and access state	☐ Power and guard state
☐ Support and cutting basis	☐ Stock and tool response	☐ Receiver and open actions