

Manual Milling of a Metal Block Face - JSA - C

en-US · 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 fit cutter							
HP-2 Secure stock and path							
HP-3 Hold and correct							
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. Machining plan	1. Wrong datum cut 2. Inadequate holding area 3. Unsuitable tool loading	1. Drawing unclear 2. Final grip not considered 3. Tool chosen by fit	1. Define face and tolerances 2. Review remaining contact 3. Match cutting system	1. Stock and drawing revision 2. Holding allowance 3. Tool and machine instructions				
2. Retention review	1. Cutter release 2. Block ejection 3. Fixture displacement	1. Holder assumed suitable 2. Vise grip unchecked 3. Table fixing omitted	1. Verify tooling interface 2. Verify stock interface 3. Verify table interface	1. Cutter holder spindle 2. Block jaws and supports 3. Vise and table fastening				
3. Motion planning	1. Clamp collision 2. Backlash-driven movement 3. Travel-zone crush	1. Endpoints not reviewed 2. Direction changed casually 3. People share envelope	1. Check full travel path 2. Use permitted feed method 3. Separate table movement zone	1. Tool projection and clamps 2. Feed direction and backlash 3. Endpoints and access				
4. Operating readiness	1. Entanglement 2. Chip impact 3. Unexpected setup-tool throw	1. Gloves remain for cutting 2. Shielding defective 3. Wrench left fitted	1. Check clothing and hand state 2. Verify guard and eye protection 3. Account for setup tools	1. Operator and protection check 2. Guard and stop condition 3. Tool removal confirmation				
5. Abnormal-cut recovery	1. Repeated movement 2. Hidden tooling damage 3. Defective stock released	1. Retightening only 2. Support effects ignored 3. Quality and safety conflated	1. Isolate and investigate 2. Inspect all retention interfaces 3. Separate restart and part judgment	1. Symptoms and settings 2. Correction and path check 3. Part inspection disposition				
6. Shift handover	1. Uncontrolled restart 2. Lost tolerance evidence 3. Open defect reuse	1. Machine state unclear 2. Measurement units missing 3. Hold left verbal	1. Transfer machine configuration 2. Record datum values and units 3. Assign unresolved actions	1. Guard tool and feed state 2. Part inspection result 3. Restrictions and receiving owner				

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

4. Pre-work checklist

☐ Stock and drawing revision	☐ Cutter holder spindle	☐ Tool projection and clamps
☐ Operator and protection check	☐ Symptoms and settings	☐ Guard tool and feed state
☐ Tool and machine instructions	☐ Tool removal confirmation	☐ Restrictions and receiving owner