



WELCOME!

Presented By:
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Paper Making Specialist

IT CAN HAPPEN TO ANY OF US.



HOW FAST ARE YOU?

6 seconds

The amount of time the SUV driver had from the initial skid until impact

1/2 second

At 1000 fpm on a paper machine you could have already travelled **8 feet into the machine**

ELEVATING THE CONVERSATION

This is the first time that this discussion has been held with anyone other than operators and technicians on the operating floor.

It was a group of operators from one of the WestRock mills that suggested that a group such as this one needs to hear the same message.



WHY DO I WORK SAFELY?



HOW LONG DOES IT TAKE?

- To completely crush and dismember your left arm.
- To fracture 8 ribs on your left side.
- To fracture 4 ribs on your right side.
- To fracture your left hip.
- To fracture your neck.
- To fracture your skull.

HOW LONG DOES IT TAKE?

■ **.5** second

The human brain and body can react and make a move in less than .5 second

How long does it take to recover??

■ **.375** second

It takes LESS than .375 of a second to pull a 6' body through a 48" pope reel roll nipped to a 30" reel.

THE BOTTOM LINE

A person wearing a white lab coat is holding a bright yellow hard hat. The person's hands are visible, and the hard hat is held in front of them. The background is plain white.

Only you as a **cohesive group**, armed with a **specific skill set** and experience base, can determine, establish, communicate and foster safe working conditions and habits specific to your working environment. You operate in a **unique environment** with **unique hazards** that very few people outside our industry understand.

We must rely on each other to be successful.

UNIQUE HAZARDS

OSHA's 2015 TOP TEN Most Frequently Cited Violations

- | | |
|--------------------------------------|---|
| 1. 1926.501 – Fall Protection (C) | 6. 1910.178 – Powered Industrial Trucks |
| 2. 1910.1200 – Hazard Communication | 7. 1926.1053 – Ladders (C) |
| 3. 1926.451 – Scaffolding (C) | 8. 1910.305 – Electrical, Wiring Methods |
| 4. 1910.134 – Respiratory Protection | 9. 1910.212 – Machine Guarding |
| 5. 1910.147 – Lockout/Tagout | 10. 1910.303 – Electrical, General Requirements |

(C) = Construction standard

Nips?

Carrier ropes?

Chemical handling exposure?

Burns?

Cuts due to “blades”?

Fabric Installation hazards?

A man with dark hair and a light beard is lying in bed, propped up on his left arm. He is looking directly at the camera with a thoughtful expression. The room is dimly lit, with a soft light source creating a gentle glow on his face and the white pillow. The background is dark and out of focus.

**WHAT KEEPS
YOU UP AT
NIGHT?**

**WHERE DOES SAFETY
FALL ON THE LIST?**

WHEN DO THE RULES MATTER?

- Does everyone here drive to work every day?
- Is there anyone here that makes it to work without violating any traffic laws?
- Do you usually violate the same law in the same place each day?

WHEN DO THE RULES MATTER?

Often times safety rules are similar in nature to traffic regulations. They are routinely violated with no consequence...

Until someone gets injured.

Then all hell breaks loose and we write 5 new regulations and spend enormous amounts of money to now guard and monitor the area.



WHEN DO WE WRITE THE RULES?

Almost all safety regulations and procedures have been written in someone's blood or shrouded in someone's pain.

Why does someone have to get hurt requiring someone else to formulate a procedure to prevent someone else from getting hurt?



RON MORGAN

"All in favor of replacing our safety officer ..."

PERSONAL PROTECTIVE EQUIPMENT



PERSONAL PROTECTIVE EQUIPMENT

- Provides the least reliable control measure.
- Provides the lowest level of health and safety protection.
- Must follow mill minimum PPE requirements.
- Ensure that PPE is: suitable, sized to fit, maintained in good condition and is actually used.

OVERRATED?

Although absolutely essential, there is no manmade device that can override an individual's disregard for his or her own safety and well being



WHAT IS THE SINGLE MOST IMPORTANT PPE?

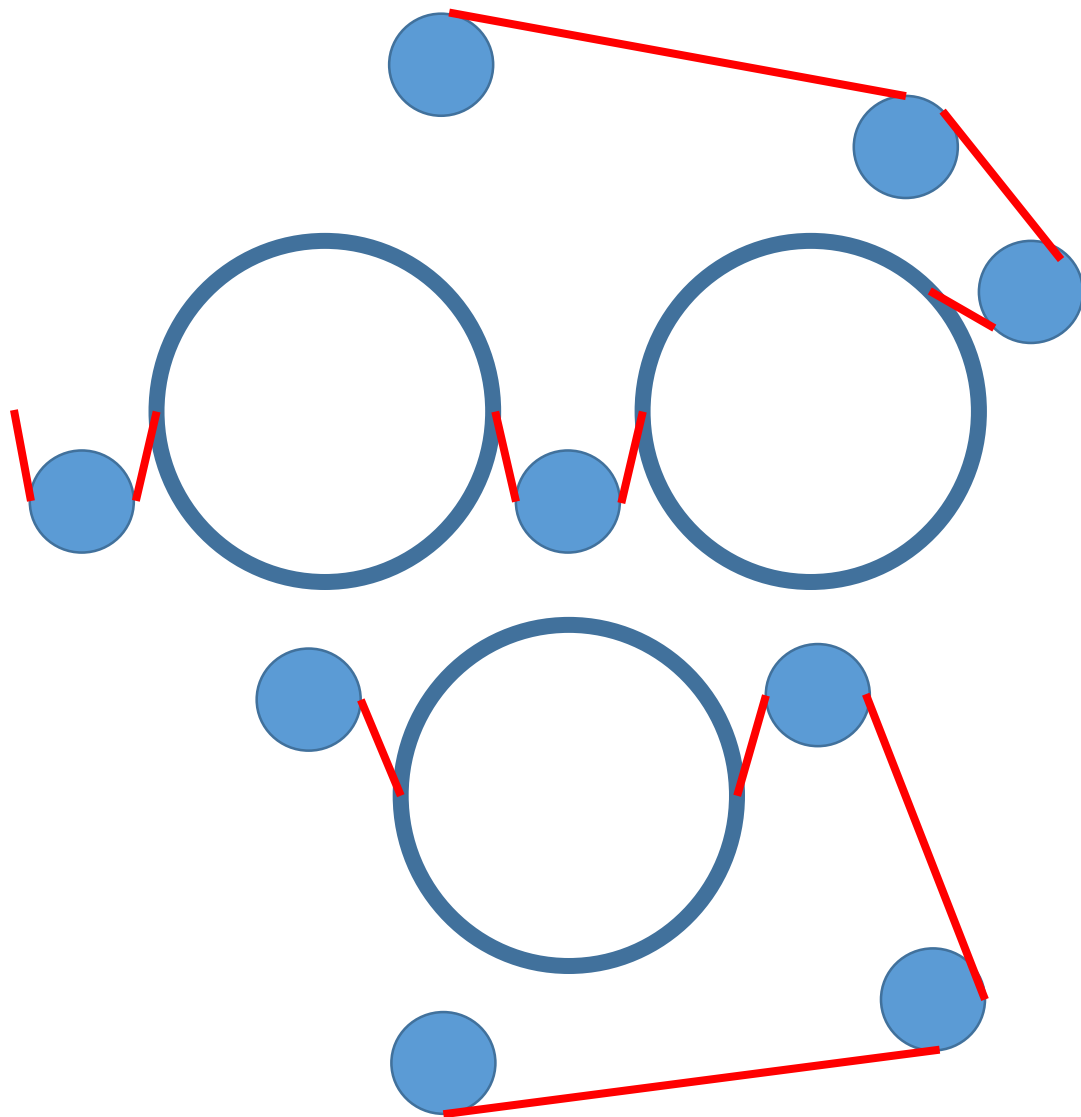
It is that 6' space
between your ears.



***DO YOU REALLY WANT TO
UNDERSTAND THE RISKS?***

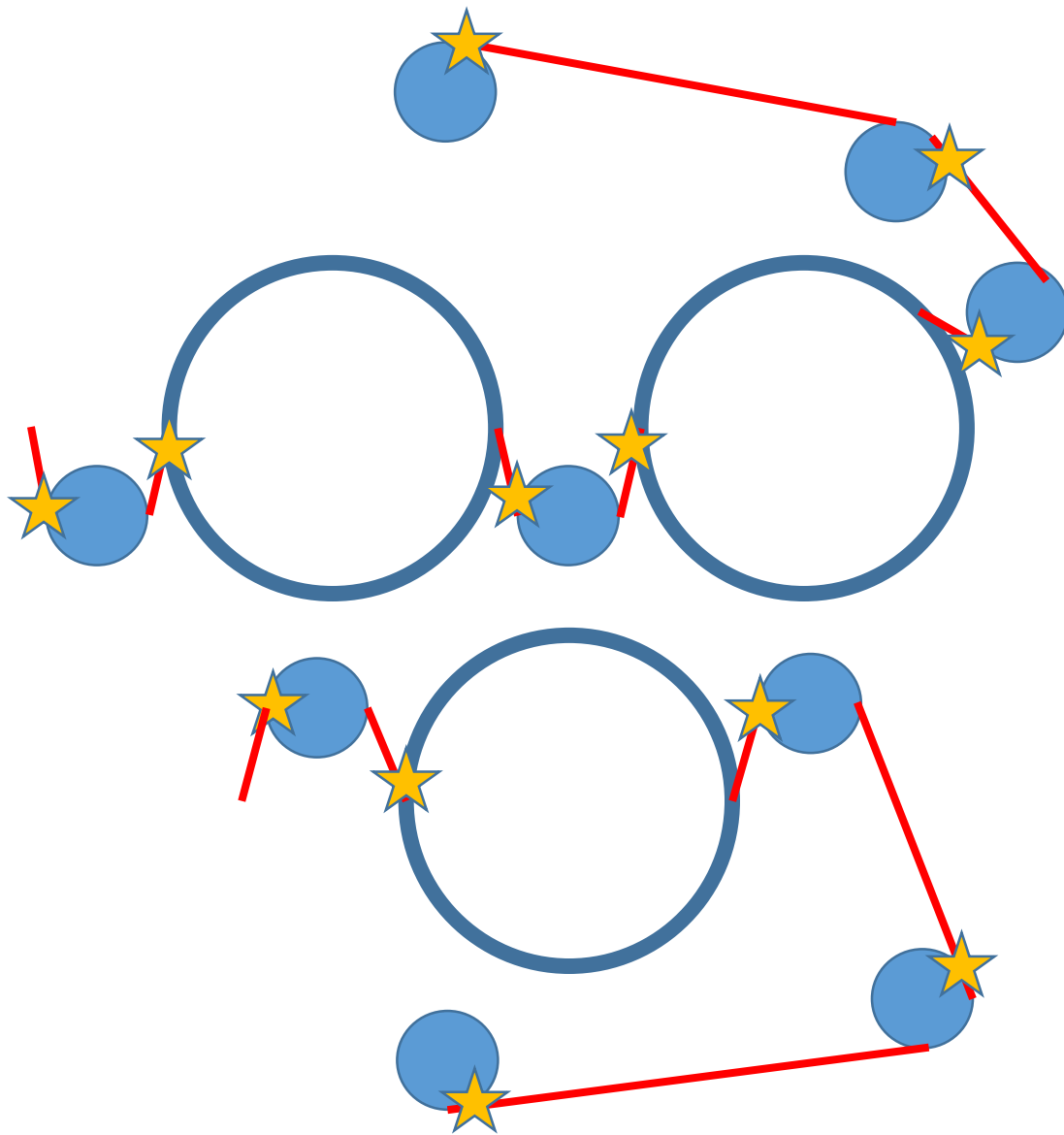
A QUICK SAFETY AUDIT

Are you really aware of ALL the nip points?



Three dryer cylinders, two
dryer fabrics.
How many ingoing nips?

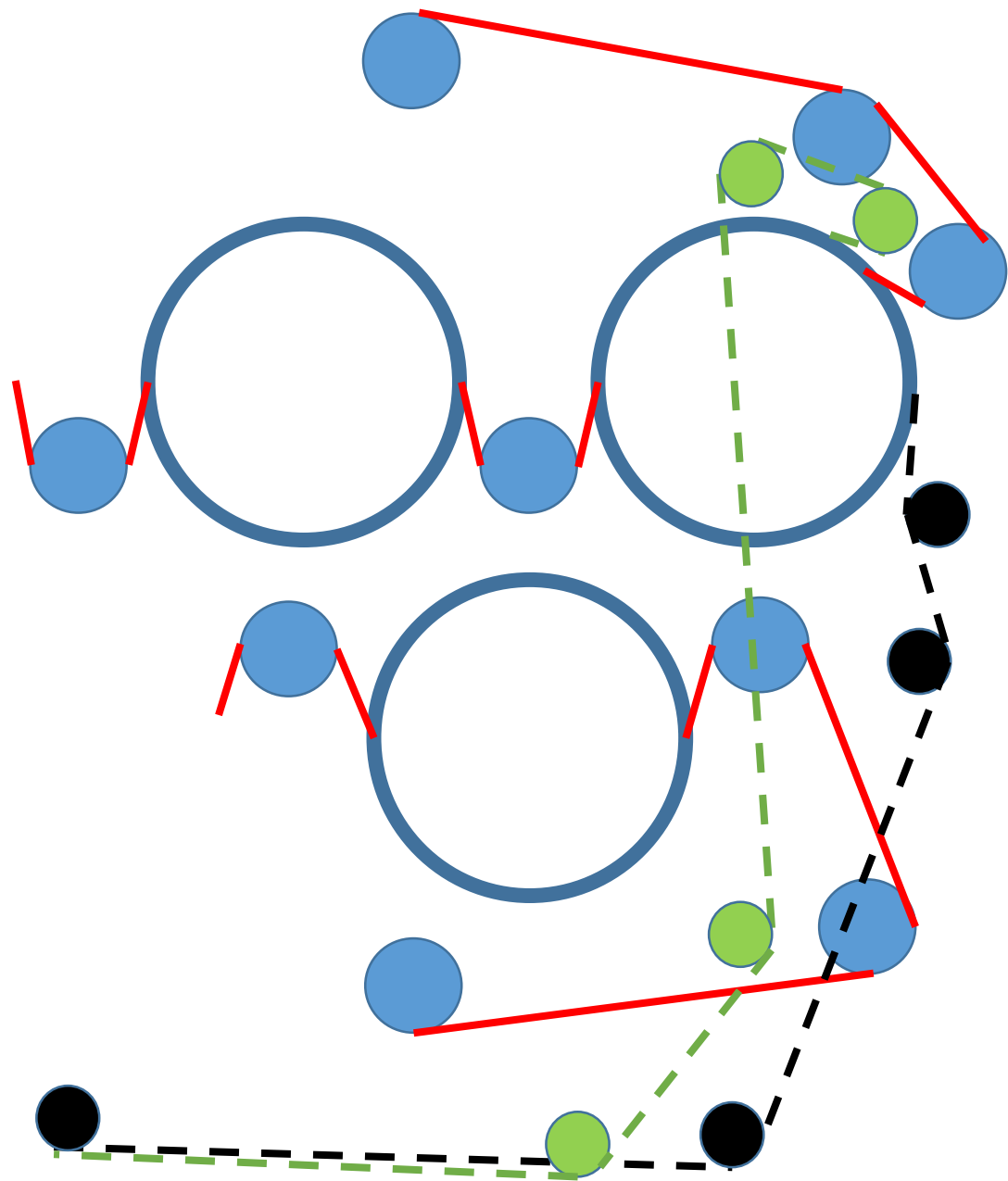
————— Dryer fabric



Three dryer cylinders,
two dryer fabrics.
How many ingoing nips?

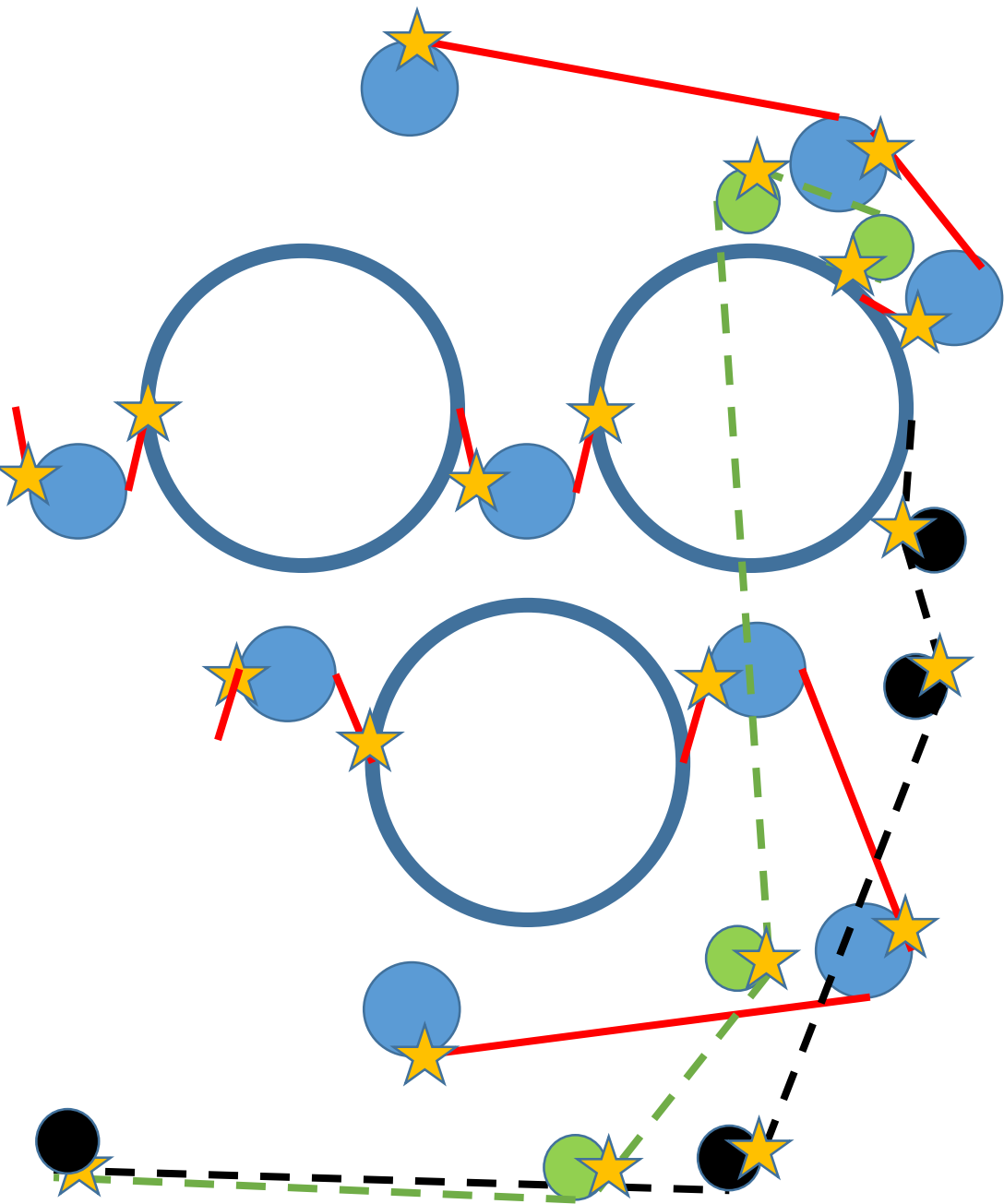
12 ingoing nips

————— Dryer fabric



Three dryer cylinders, two
dryer fabrics, two carrier ropes.
Now how many ingoing nips?

- Dryer fabric
- - - Inside rope
- - - Outside rope



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Now how many ingoing nips?

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HOW MANY NIPS?

How about **20** ingoing nips
surrounding 3 dryer cans *in less
than 50 feet of sheet travel.*

***DO YOU REALLY WANT TO
UNDERSTAND THE RISKS?***



OBSERVING IS NOT SIMPLY WATCHING

- What body positions are at risk in the process?
- What machinery does or does not lend itself to making the job safer?
- Is the guarding adequate and well identified?
- How many shortcuts are taken?
- Etc, etc, etc
- Spaghetti diagrams are a wonderful tool (especially on endless felts).

WHEN WAS THE LAST TIME YOU...

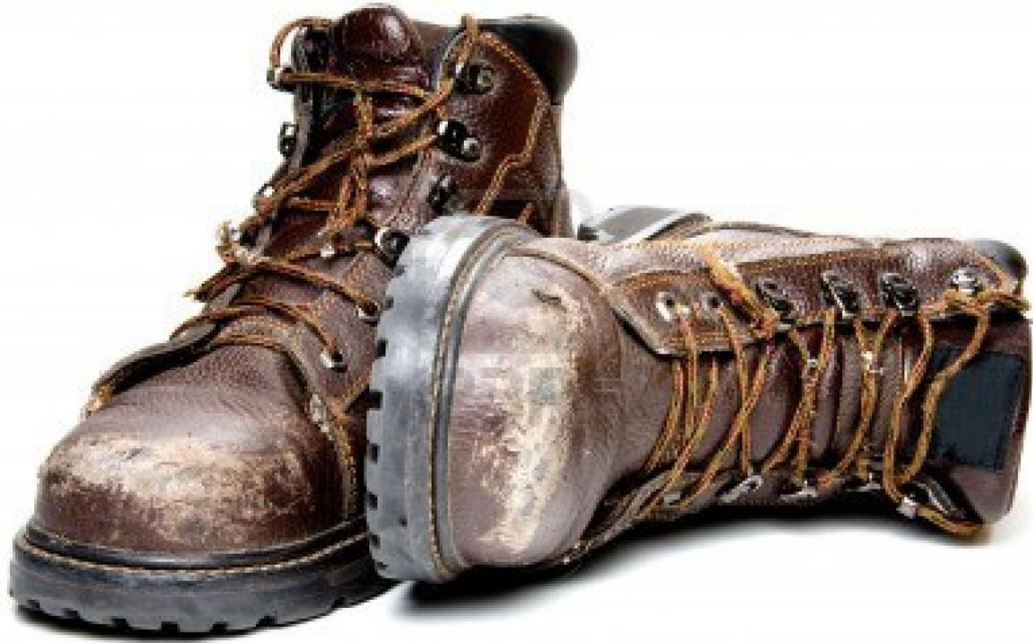
Observed a fabric change from start to finish?

Studied every step of a reel turn up?

Observed every step of tailing the machine?

Do you spend countless hours researching statistics and safety programs on the web? How much time do you spend researching your own employees while on the job? They know the existing hazards specific to their machine much more than any web site.

WORK A WEEK TOGETHER IN EACH OTHERS BOOTS. THE ONLY WAY YOU WILL TRULY UNDERSTAND THE RISKS IS TO EXPERIENCE THEM.



Those with the **highest risk** level have the perception they are the **least empowered** to implement change



Those with a **lower risk level** are typically **empowered with the ability** to implement change.

THE COMMON DENOMINATOR

Body beast	Nutrisystem	Safety360
P90X	Slimfast	BBS
Richard Simmons	Nuevo Metabol	DuPont Stop
Zumba	Atkins	10' Circle of Safety
Brazilian Butt	Hydroxycut	ZAC
Jazzercise	Xena	SafeStart

WHY DO THEY WORK

- Must be one of 'your' Core Beliefs

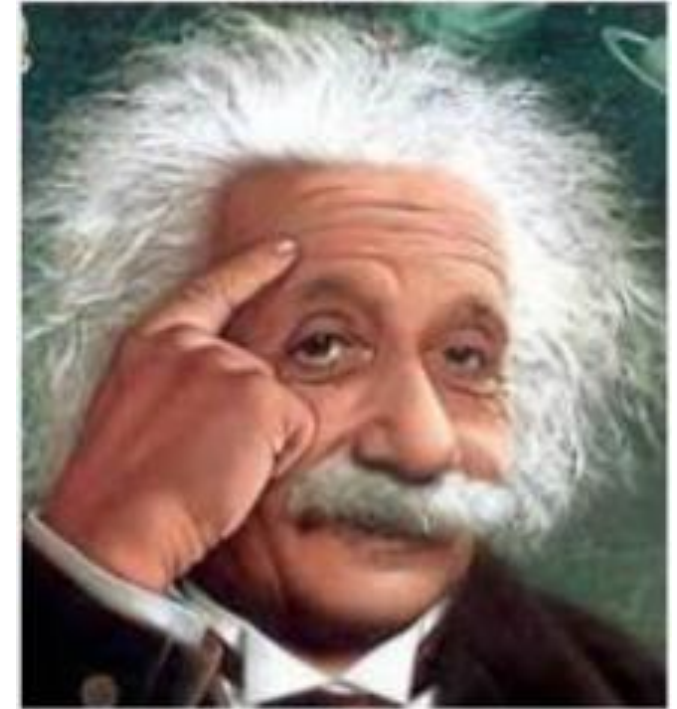
Core Beliefs:

- Foundations upon which all our expectations are formed
- Core beliefs are rooted in your sub-conscious mind

At a physical level:

- Core beliefs cause you to think & behave in specific ways
- What you think and feel shows up in how you behave

The most important PPE



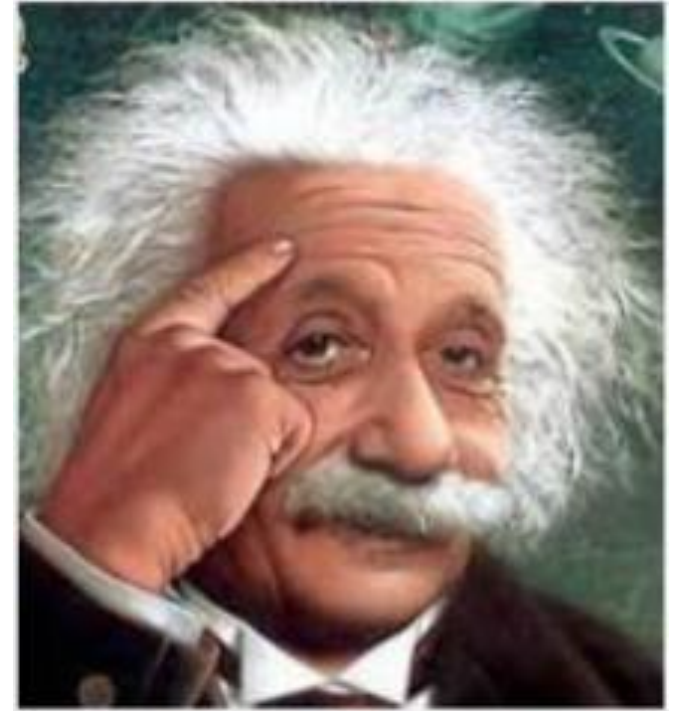
WHY DO THEY WORK

The only way any of these programs will work is with a:

PERSONNAL COMMITMENT

No one can force anyone to work safely.

The most important PPE



TO DO'S...

- ✓ **WALK IN THEIR SHOES**
- ✓ **OBSERVE & LEARN**
- ✓ **KNOW YOUR NIPS!**
- ✓ **PROACTIVE JHA'S, PROACTIVE JHA'S,**
- ✓ **TRAINING, TRAINING, TRAINING, TRAINING**
- ✓ **PROACTIVE JHA'S, PROACTIVE JHA'S**

SHOW ME THE MONEY

What percentage of your total cost structure is lost due to accidents and the costs associated with them?

Is 2% a fair estimate.

If your labor costs are 15%, could you not dedicate 10% more man hours to training.

10% of 15% is 1.5% of total costs. Where is the money better spent.



THANK YOU!

BE SAFE!

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WHAT THOUGHT FIRST COMES TO MIND?

- ☐ Is the employee okay?
- ☐ Is my bonus shot?
- ☐ Will the employee be a lost time?
- ☐ How soon can we get the machine running?

You cannot be held responsible for a condition or procedure without the authority to change factors affecting these situations.

Responsibility without authority is like wearing work boots without socks. You will get blisters.