



Brady Corporation

LOTO - Past, Present and Future

August 25, 2022



Agenda

LOTO - Past, Present and Future

- Brady Overview
- LOTO importance
- Past
- Present
- Future
- Contact Us

Who is Brady?

- Founded in 1914
- Publicly-traded since 1984 and listed on the NYSE
- Employs 5,400 people at operations in the Americas, Europe and Asia-Pacific
- Operations in 33 countries
- Distribution in more than 79 countries

No matter your business, Brady brings the benefits of innovation, clarity and our people.



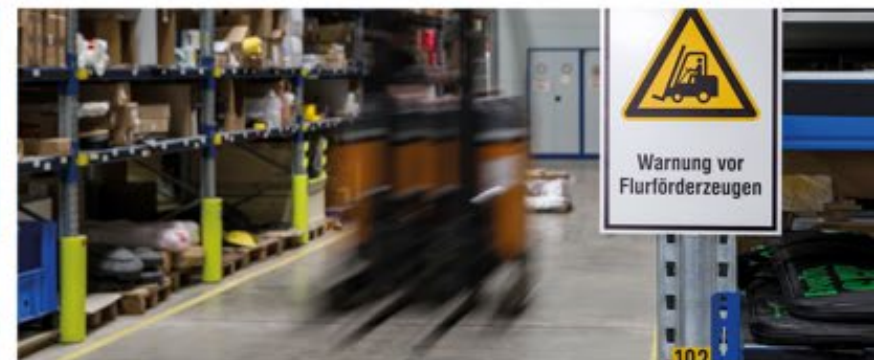
What we make

Our mission: To identify and protect

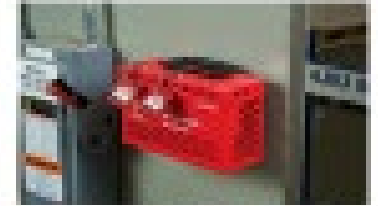
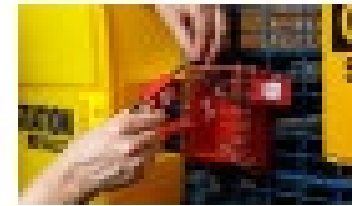
People

Products

Places



LOTO - Total Solution Offering



LINK360®
SAFETY SOFTWARE

Question

When was your last incident / close call on LOTO?

- 1 - 90 days ago
- 91 - 180 days ago
- 181 - 270 days ago
- 271 + days ago



Why Lockout Tagout is Important

Everyone goes home safely



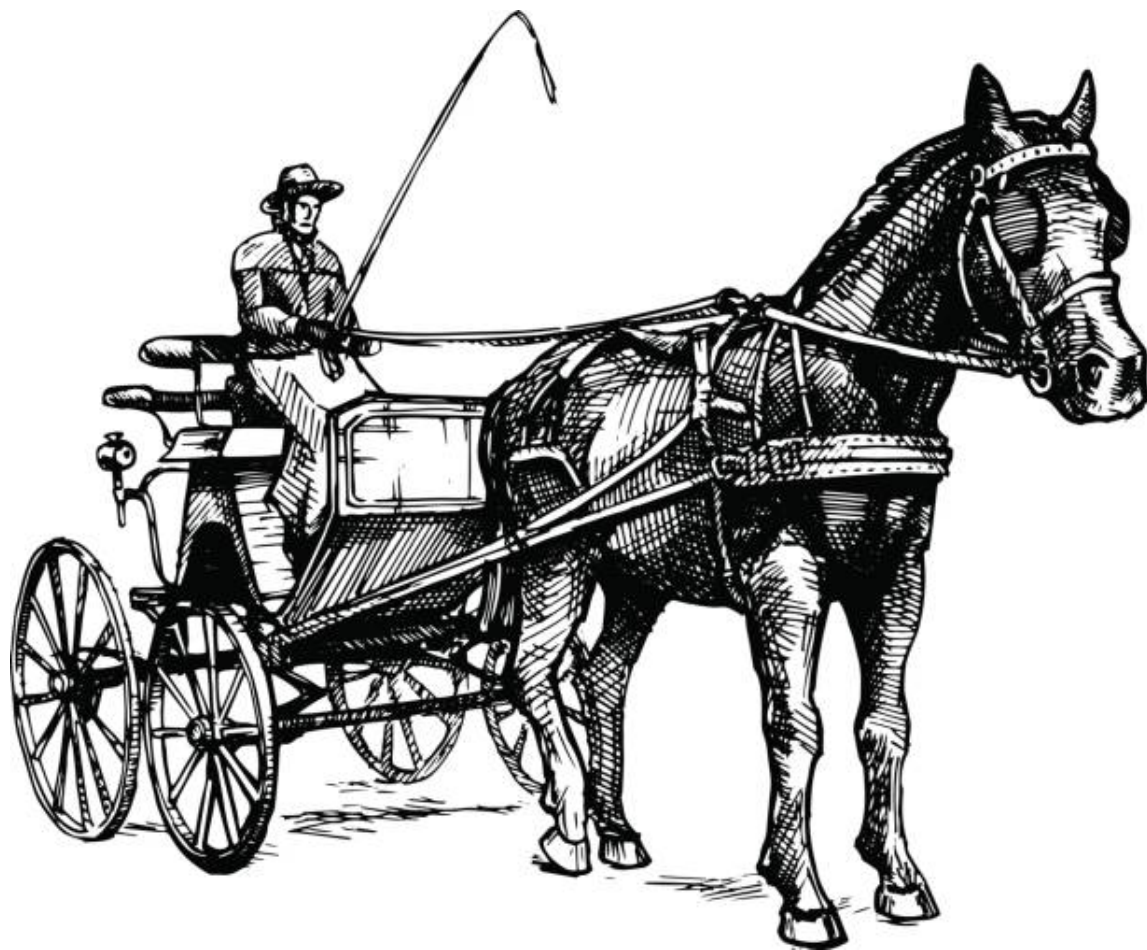
Compliance

2021 "Willful or Serious" Violations

STANDARD	STANDARD	TOTAL VIOLATIONS
1	Fall Protection – General Requirements (1926.501)	4,251
2	Respiratory Protection (1910.134)	2,057
3	Ladders (1926.1053)	1,830
4	Scaffolding (1926.451)	1,785
5	Lockout/Tagout (1910.147)	1,339
6	Personal Protective and Life Saving Equipment – Eye and Face Protection (1926.102)	1,275
7	Hazard Communication (1910.1200)	1,259
8	Fall Protection – Training Requirements (1926.503)	1,091
9	Powered Industrial Trucks (1910.178)	995
10	Machine Guarding (1910.212)	907

OSHA defines a “serious” violation as “one in which there is a substantial probability that death or serious physical harm could result, and the employer knew or should have known of the hazard.”

Past



How LOTO was performed

No procedures

- You learned on the Job
- Senior employees taught the new employees
- You either asked where a lockout point was, looked it up on a P&ID drawing or worse guessed
- All of these options were efficient or unsafe

No real verification process

Learn as you go environment

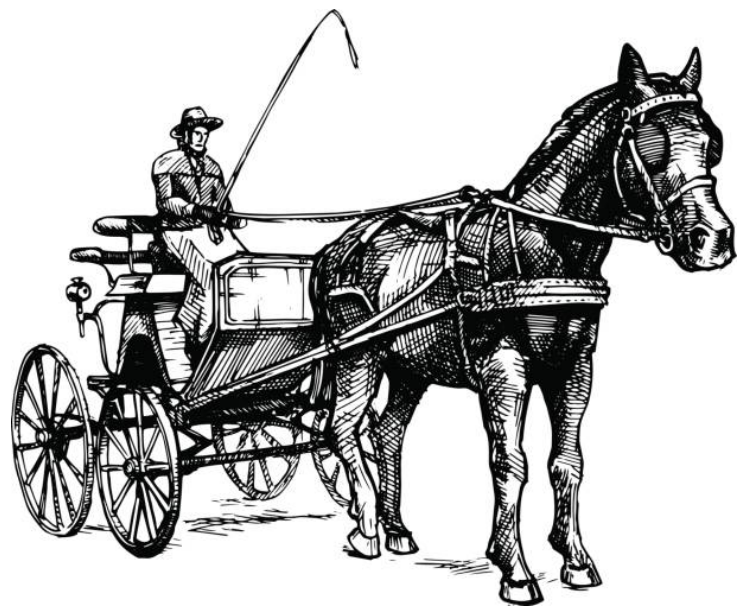
No management of change

- Document management
- Outdated process

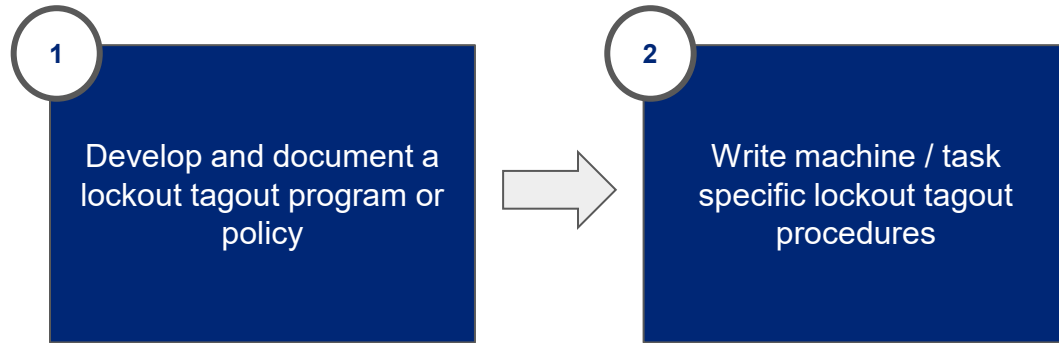
No single point of truth



Present



What makes a strong LOTO program?



Question

What do you currently use to create your lockout procedures?

- Microsoft Word
- Microsoft Excel
- LOTO specific software
- Home grown software
- Don't have procedures
- Other

Procedure Creation and Maintenance

Home grown system


- Internal process but may not be able to be expanded
- IT no longer wants to be responsible
- Creator no longer at the company

Microsoft Excel / Word

- No history
- Working from the latest version?
- Where are they stored (USB, shared folder, etc.)
- Controlling access

Purchased software



Lockout/Tagout Posted Procedure			
ID#:	E0040	Facility:	
Created:	7/7/2020	Location:	
Revised:	7/7/2020	Description:	
7	Lockout Points	Note: Notify all affected employees that servicing or maintenance is required (including what must be done) and that the machine or equipment must be shut down and locked out to perform the service or maintenance.	
Lockout Steps			
Step #	Action	Info	Verification
1 Steam S-1 Potential Energy Gravity	Isolation point on North wall (front) of furnace 2965. After door is fully opened and before power is shut off, slide pins S-1 into designated slots on either side of the door.	Use a Slide Pin.	Make sure pin is all the way pushed in. Pin is in all the way when it hits the stop.
2 Electrical E-1 480V	Isolation point across from South wall of (back) furnace 2965. Move E-1 breaker #5 to off. Lock out with device.	Use a Breaker lockout device.	Attempt restart at 2965 Control Panel and have operator attempt to start up 2965.
3 Electrical E-2 480V	Isolation point across from South wall of (back) furnace 2965. Move E-2 disconnect to off. Lock out.	Use a Padlock.	Attempt restart at 2965 Control Panel and have operator attempt to start up 2965.
4 Electrical E-3 120V	Isolation point across from South wall of (back) furnace 2965. Move E-3 disconnect to off. Lock out.	Use a Breaker lockout device.	Attempt restart at 2965 Control Panel and have operator attempt to start up 2965.
5 Electrical E-4 120V	Isolation point across from South wall behind furnace 2965. Power off E-4 (UPS 2965 on top). Unplug E-4 (UPS 2965). Lock out with device.	Use a Universal plug device.	Verify zero voltage reading with meter.
6 Gas G-1 Natural Gas Inlet - 35 PSI	Isolation point on East wall of furnace 2965. Turn G-1 valve to closed position. Lock out with a ball valve lock out device. Open bleed valve. Use a Ball valve device.		Verify pressure has bled off at local gauge.

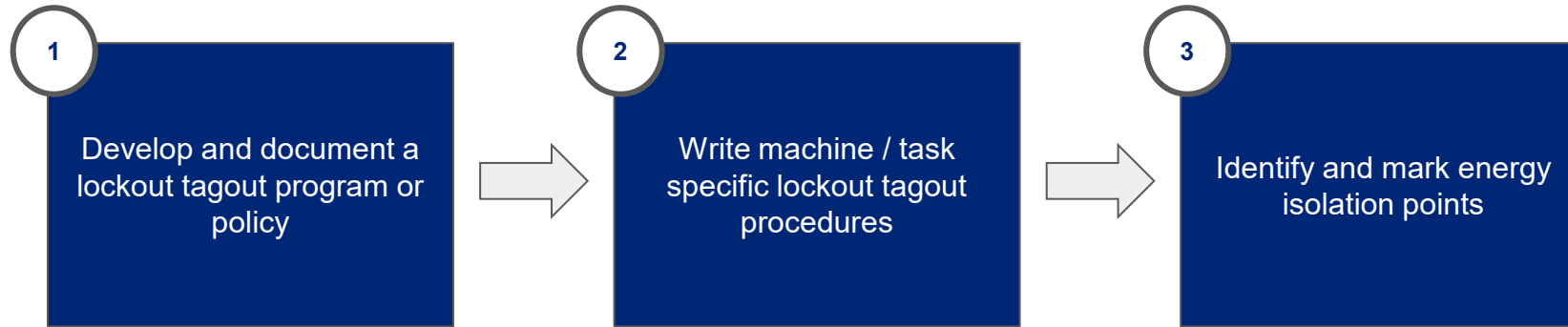
Question

What is missing from the image on the right?

- Isolation point identification
- Pipe labeling
- Lockout procedure
- All the above



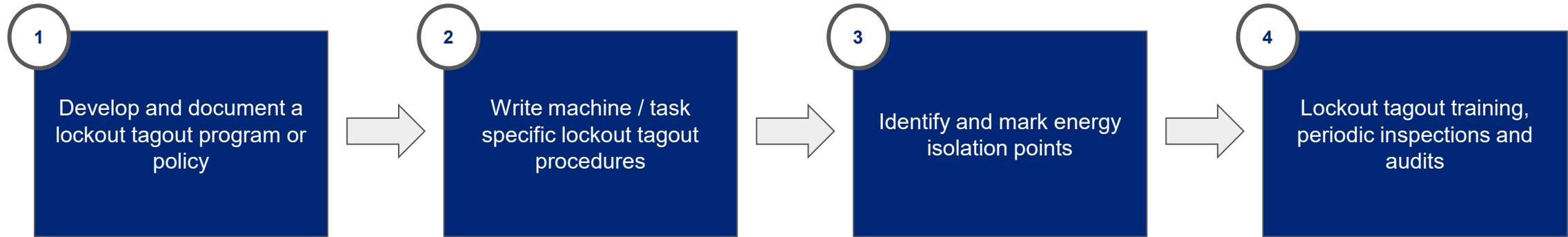
What makes a strong LOTO program?



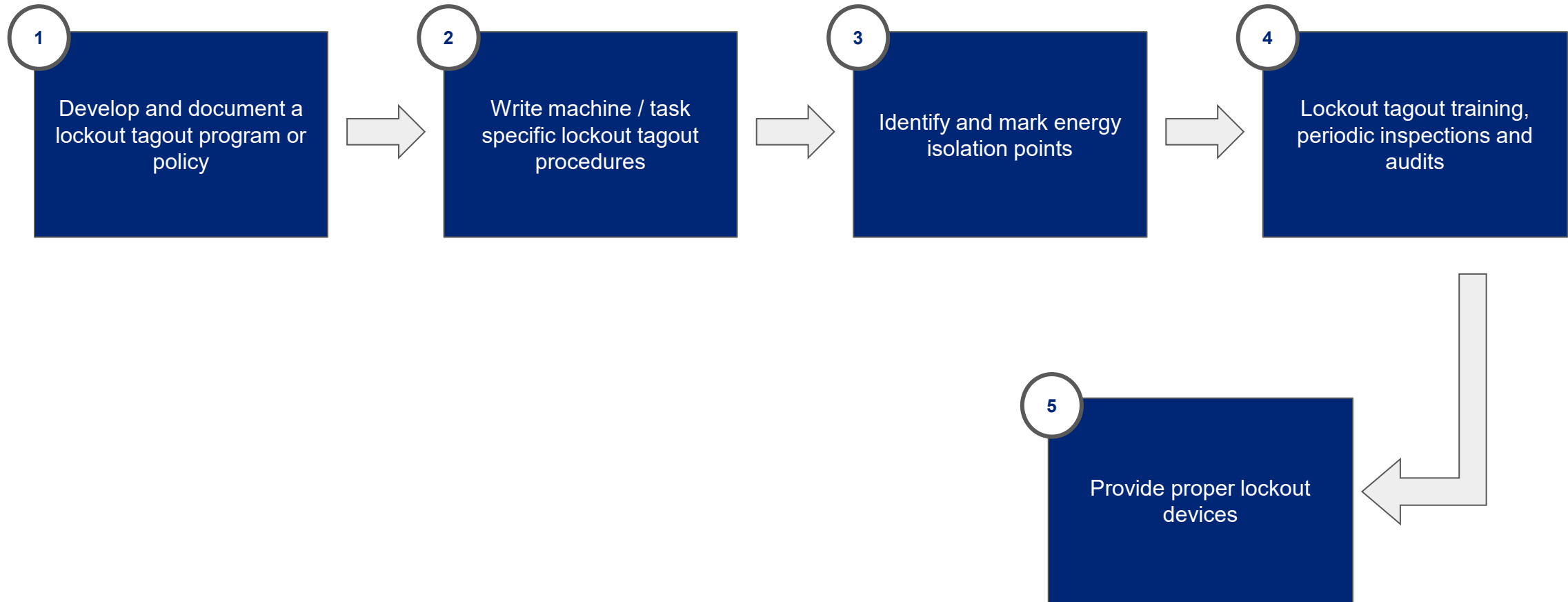
Visual Identification



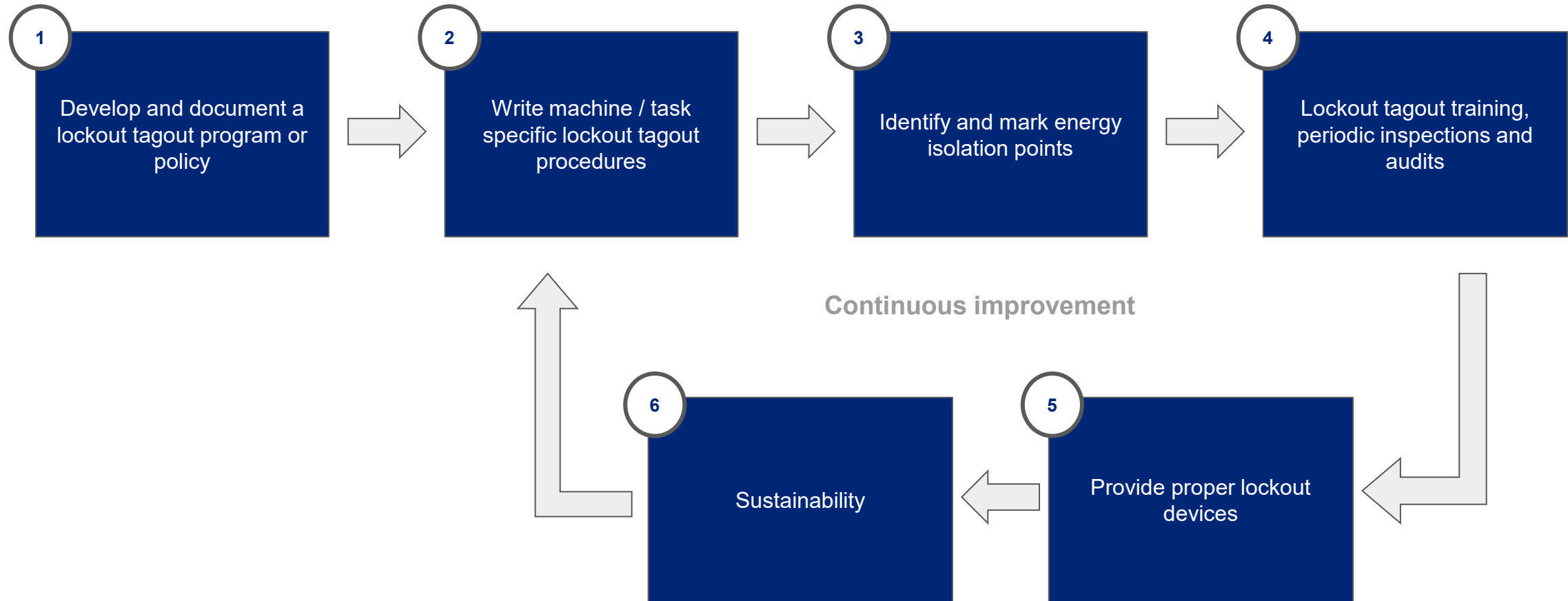
What makes a strong LOTO program?



What makes a strong LOTO program?



What makes a strong LOTO program?



Sustainability

Ability to generate reports

Update procedures if something changes

Stay up to date on annual audits

Similar procedures

Show: All Procedures Due for Audit Export to Excel Export to PDF Email Report

All Procedures Due for Audit

Date Range: All Overdue

Location: ☒ All Sites All Areas All Equipment ☐ All Regions Setup Regions Run Report

Name	Audit Due	ID	Status	Revised	Last Changed By	Created	Site	Ar
DESTACKER #2	10/3/2006 2:27:	082MUS1002	Published	10/3/2005 2:27:	Brady Technical Support	9/26/2005 2:57:24 AM	Springfield, OH	LD PL
BLOWMOLD JUG BA	10/3/2006 5:26:	082BBA2001	Published	10/3/2005 5:26:	Brady Technical Support	9/26/2005 2:57:24 AM	Springfield, OH	BLOW
COOLING BED #1 BL	10/3/2006 5:52:	082BCT2001	Published	10/3/2005 5:52:	Brady Technical Support	10/3/2005 5:50:00 AM	Springfield, OH	BLOW

STEP DETAILS

[Cancel](#) [Done](#)


ENERGY SOURCE

Type
⚡ Electrical [>](#)

Description
480V [>](#)

480V

IMAGE



[Caption](#)

LOCKOUT DETAILS

Energy Source Location
Custom [>](#)

Lockout Method

Future



Question

Do you allow your maintenance team to use mobile devices?

- Yes, we have wifi throughout our facility
- Yes, mobile devices are cell enabled
- Yes, we would need offline capabilities
- No, we see this as a liability
- No, we are working on getting approval
- Other

Technology to lead the way

Smart LOTO devices

Live dashboards

- Know what is being worked on and by who

Isolation point validation







- Help your staff know that they are lockout out the correct thing



Procedure Management

[Home](#) / Procedure Management

NEW PROCEDURE

Procedure Name	Processes	Equipment	Site	Area	Location	
 #1 Boiler Procedure	#1 Boiler	#1 Boiler	Calvert City	Chemical Plant		
#1 Boiler Procedure	#1 Boiler		Calvert City	Chemical Plant	Utilities	
 Boiler 1 - Full Line Procedure	Boiler 1 - Full Line		Lake Charles	Boiler Room	East Side	
Buffalo Boiler Process Procedure	Buffalo Boiler Process		Buffalo, NY	Boiler Room	North Side	

Q & A

Contact Us

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Locked in on all things Lockout Tagout, since the inception of CFR 1910.147



Services

Comprehensive programs, customized to meet your requirements, keep your employees safe and ensure compliance

[Lockout Service Options](#)



Software

Set a new pace for productivity, standardization and sustainability of critical safety programs, no matter your size or complexity

[Learn About LINK360](#)



Padlocks

Brady offers a wide range of padlock options, including material, size, color and customizations to meet your specific needs

[Padlock Selector Guide](#)

<https://www.bradyid.com/lockout-tagout>