

# BAUMAN MACHINE INC.

## POWERED INDUSTRIAL TRUCK/FORKLIFT SAFETY PROGRAM

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## **POWERED INDUSTRIAL TRUCK/FORKLIFT SAFETY PROGRAM**

### **I. INTRODUCTION**

Powered industrial trucks are mobile, power-driven vehicles used to carry, push, pull, lift, stack, or tier material. The purpose of this Powered Industrial Truck/Forklift Safety program is to provide information on the safe use of powered industrial trucks. The Occupational Safety and Health Administration (OSHA) and the National Fire Protection Association (NFPA) have established rules and guidelines for the protection of workers and facilities in OSHA 1910.178, *Powered Industrial Trucks*, OSHA 1926.602, *Material Handling Equipment*, and NFPA 505, *Fire Safety Standard for Powered Industrial Trucks Including Type Designations, Areas of Use, Maintenance, and Operation*, which are incorporated into this Bauman Machine Inc. Truck/Forklift Safety Program.

### **II. SCOPE**

All employees who operate or anticipate operating a powered industrial truck/forklift during their employment must complete forklift safety training and evaluation, and comply with this program.

### **III. RESPONSIBILITIES**

#### **A. Management is responsible for:**

1. providing program oversight;
2. providing powered industrial truck/forklift safety training and certify that each operator has been trained and evaluated as required; and
3. annually reviewing this *Powered Industrial Truck/Forklift Program*.
4. designating and identifying employees responsible for operating powered industrial trucks/forklifts;
5. ensuring that no employee under their direction operates a powered industrial truck/forklift without proper certification; and
6. ensuring that forklifts are repaired when malfunctioning.

#### **B. Forklift operators are responsible for:**

1. attending and passing forklift safety training and evaluation before operating a powered industrial truck/forklift at least every three years;
2. operating and maintaining vehicles in a safe manner and according to the training provided; and
3. reporting all vehicle problems to his/her supervisor.

#### **IV. GENERAL VEHICLE REQUIREMENTS**

A. All powered industrial trucks acquired and used after February 15, 1972 are required to meet the design and construction requirements for powered industrial trucks established in the American National Standards Institute (ANSI) Standard for Powered Industrial Trucks, Part II, ANSI B56.1, except for vehicles intended primarily for earth moving or over-the-road hauling.

B. Nameplates and markings must be in place, must not be covered over with paint which may obscure the identification information, and the nameplates must be maintained in a legible condition.

C. Modifications and additions which affect capacity and safe operation without the manufacturer's prior written approval are prohibited. Capacity, operation, and maintenance instruction plates, tags, or decals should be modified accordingly.

#### **V. OPERATOR TRAINING AND EVALUATION**

Each powered industrial truck operator must be determined to be competent to operate a powered industrial truck safely, as demonstrated by the successful completion of the training and evaluation described in this section. Personnel who have not yet been trained to operate forklifts under the powered industrial truck/forklift safety program, or other approved training program, may operate a powered industrial truck/forklift for the purposes of training only, and only under direct supervision of the trainer.

A. Training shall consist of a combination of formal instruction ( lecture, discussion, interactive computer learning, video tape, written material), practical training (demonstrations performed by the trainer and practical exercises performed by the trainee), and evaluation of the operator's performance in the workplace.

B. Operator training and evaluation will be conducted by an approved personnel who have the knowledge, training, and experience to train forklift operators and evaluate their competence.

C. All powered industrial truck/forklift operators shall receive initial training in the following topics:

1. operating instruction, warning, and precautions for the types of truck the operator will be authorized to operate;
2. truck controls and instrumentation: location, purpose, and operation;
3. differences between a powered industrial truck/forklift and an automobile;
4. engine or motor operation;
5. steering and maneuvering;
6. visibility (including restrictions due to loading);
7. vehicle capacity;
8. vehicle stability;
9. any vehicle inspection and maintenance that the operator will be required to perform;
10. refueling and/or changing of batteries; and
11. operating limitations, and any workplace related topics (e.g., surface conditions,

narrow isles, pedestrian traffic, hazardous locations).

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D. Refresher training in all the above listed topics, and any other relevant topics, will be provided to all powered industrial truck/forklift operators:

1. when the operator has been observed to operate the vehicle in an unsafe manner;
2. when the operator has been involved in an accident or near-miss incident;
3. when the operator has received an evaluation that reveals that the operator is not operating the truck safely;
4. when the operator is assigned to drive a different type of truck, or conditions in the workplace change in a manner that would affect the safe operations of a forklift;

E. Upon completion of the training program, all operators will be evaluated by personnel for performance of proper procedures.

F. The will document/certify the training and evaluation and will include in the documentation the name of the operator, the date of the training, the date of the evaluation, and the identity of the person(s) performing the training or evaluation.

## **VI. INSPECTIONS**

### **A. PRE-USE INSPECTION**

1. A pre-use inspection identifies potential hazards that may be encountered from a damaged forklift and should be performed at least daily by the operator. If at any time a forklift is found to be in need of repair, defective, or in any way unsafe, the forklift should be removed from service until it has been restored to safe operating condition.
2. The pre-use inspection process is as follows.
  - a. Inspect the mast for broken or cracked weld points and any other obvious damage.
  - b. Ensure roller tracks are greased and that chains are free to travel.
  - c. Forks should be equally spaced and free from cracks along the blade and at the heels.
  - d. Check hydraulic fluid levels.
  - e. Check each hydraulic line and fitting for excessive wear or crimping.
  - f. Check lift and tilt cylinders for damage or leaking fluid.
  - g. Inspect mounting hardware on the cylinders.
  - h. Check tires for excessive wear, splitting or missing tire material.
  - i. Check pneumatic tires for proper pressure indicated on the tire.

### **1. Propane Power**

All LP-gas containers should be examined by the operator before replacing for the following defects or damage:

- a. dents, scrapes, and gouges of the pressure vessel;
- b. damage to the various valves and liquid level gauge;
- c. debris in the relief valve;
- d. damage to or loss of the relief valve cap;

e. indication of leakage at the valves or threaded connections.

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## **VII. FUEL HANDLING AND STORAGE**

- A. Liquid fuels such as gasoline and diesel not stored in underground or aboveground tanks should be stored in approved safety cans.
- B. The engine should be stopped, and the operator should not be on or inside the truck during refueling.
- C. A soap solution should be used to check for leaks. A match or open flame should not be used.
- D. Smoking is prohibited in the container refilling area and in the exchange area during the exchange of containers.
- E. Cylinders for liquified petroleum gas (LPG) shall be stored in the following manner.
  - 1. Cylinders in storage having individual LPG capacity greater than 1-pound shall be positioned so that the relief valve is in direct communication with the vapor space of the cylinder.
  - 2. Cylinders not in use shall be protected by:
    - a. screw-on-type caps, or;
    - b. collars;
    - c. closed, plugged, or capped cylinder outlet valves.
  - 3. Cylinders stored within buildings shall not be located:
    - a. near exits, stairwells, or in areas normally intended to be used for the safe egress of occupants, or
    - b. near athletic fields, or other areas of public gathering.
  - 4. Cylinders stored within buildings frequented by the public shall:
    - a. not exceed an LPG capacity of 1 pound per cylinder, and
    - b. be limited to a total combined capacity for all cylinders of less than 200 pounds of LPG.
  - 5. Cylinders storage within buildings not frequented by the public shall be limited to a total maximum quantity of no more than 300-pounds of LPG per storage location. Empty cylinders that have been in LPG service shall be considered as if full for the purposes of determining the maximum permissible quantity of LPG cylinders permitted.
  - 6. Cylinders storage locations outside of buildings shall:
    - a. be at least 5-feet from any doorway or openings in a building, or, for buildings with only one means of egress cylinders, be no closer than 10-feet from any doorway or opening;
    - b. be at least 20 feet from any automotive fuel dispenser;
    - c. be enclosed with at least a 6-foot high industrial-type fence, chain link fence, or equivalent protection;
    - d. have at least two means of egress from the enclosure, unless the enclosure is not over 100 square feet in area, the containers are not filled within the

enclosure, and the point of transfer is within 3 feet of the gate.

e. have lighting provided to illuminate storage containers, containers being loaded, control valves, and other equipment if operations are normally conducted during other than daylight hours.

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### **VIII. MAINTENANCE**

A. Do not use open flames to check for electrolyte level in batteries or liquid fuel level in tanks.

B. Do not conduct repairs to fuel and ignition systems of forklifts in areas where fire hazards exist.

C. Disconnect batteries prior to repairing electrical systems.

D. Use only replacement parts equivalent with those in the original design.

E. Do not alter the relative positions of various parts from what they were received from the manufacturer. Do not add any parts not supplied by the manufacturer nor delete any parts supplied by the manufacturer. No additional counterweighting of forklifts is permitted unless approved by the manufacturer.

F. Keep forklift mufflers in proper working condition and free of debris.

G. Keep the forklift in clean condition, free of lint, excess oil, and grease.

H. When antifreeze is used in the engine-cooling system, only glycol-based material should be used.

### **IX. FORKLIFT OPERATING GUIDELINES**

A. Only trained and authorized personnel eighteen (18) years old and older are permitted to operate a forklift.

B. Do not operate a gasoline-powered or diesel-powered forklift in an inside area.

C. Do not stand or pass under the elevated portion of any forklift.

D. Passengers are prohibited from riding on forklifts.

E. Do not place arms or legs between the uprights of the mast or outside the running lines of the truck.

F. When mounting or dismounting a forklift:

1. always face the vehicle,

2. never jump off,

3. always use a three-point stance (always have both hands and one foot or vice-versa in contact with the unit),

4. Always wear proper shoes (oil resistant and non-slippery),

5. Always wear proper clothing (do not wear loose clothing or dangling jewelry), and

6. restrain long hair.

G. After mounting the vehicle, always fasten the seat belt, apply the brake, and shift to neutral. Also, check around the forklift for clearance and pedestrians before moving.

H. A forklift is considered unattended when the operator is 25 feet or more away from the vehicle and it remains in his view, or whenever the operator leaves the vehicle and it is not in his/her view. When a forklift is left unattended:

1. fully lower load engaging means,
2. neutralize controls,
3. shut off power; and
4. set brakes.

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- I. Maintain a safe distance from the edge of ramps or platforms while on any elevated dock or platform.
- J. Forklifts are not to be used to open or close freight doors.
- K. Forklifts should not be used in areas of poor lighting (less than two lumens per square foot) unless they are equipped with auxiliary directional lighting and the lighting is turned on.
- L. Fixed jacks may be necessary to support a semitrailer and prevent upending during the loading or unloading when the trailer is not coupled to a tractor.
- M. Set brakes and block wheels with wheel chocks to prevent movement of trucks and trailers while loading or unloading when they are boarded by forklifts.
- N. Check the flooring of trucks and trailers for breaks and weakness before loading or unloading.
- O. Check for sufficient headroom under overhead hazards such as lights, pipes, or sprinkler systems.
- P. Do not lift personnel or allow personnel to be lifted or work from the fork lift without a properly attached lifting carriage.
- Q. Whenever a truck is equipped with a lifting carriage or forks for lifting personnel, take the following precautions:
  1. use safety platform firmly secured to the lifting carriage and/or forks,
  2. provide means whereby personnel on the platform can shut off power to the truck,
  3. provide protection from falling objects, and
  4. keep fire aisles, access to stairways, and fire equipment clear.

## **X. HANDLING AND MOVING LOADS**

### **A. TO PICK UP A LOAD**

1. Only pick up stable and safely arranged loads within the rated capacity of the forklift,
2. Adjust long or high (including multiple tiered) loads which may affect capacity.
3. Square up on the center of the load and approach it straight with forks in traveling position.
4. Stop when the tips of the forks are about a foot away from the load.
5. Level the forks and slowly drive forward until the load is resting against the backrest.
6. Lift the load high enough to clear whatever is under it.
7. Carefully tilt the mast back to stabilize the load.

### **B. DRIVING WITH A LOAD**

1. Starts and stops should be gradual.
2. Observe all traffic regulations and keep forklift under control at all times.
3. Reduce speed and sound horn at cross aisles and other locations where vision is

obstructed.

4. Pedestrians have the right-of-way. Always be aware of their presence especially in aisles and doorways.

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**B. DRIVING WITH A LOAD (cont.)**

5. Do not drive forklift up to anyone standing in front of a bench or other fixed object.
6. Keep a clear view of the path of travel. Always look in the direction of travel.
7. Always travel with a load tilted slightly back for added stability. Do not lift or lower the load when the forklift is in motion.
8. Travel with the load at a height of four to six inches at the tips and two inches at the heels to clear most uneven surfaces and avoid debris.
9. Horse play is not permitted.
10. Slow down for wet, slippery or uneven floors.
11. Avoid running over loose objects on the roadway surface.
12. Properly secure dockboards and bridgeplates before driving over them. Drive over slowly and never exceed their rated capacity.
13. Drive in reverse rather than looking around the load if you are unable to see over it.
14. Travel down inclines in reverse and up inclines going forward. Ascend or descend grades slowly. Drive loaded trucks with the load upgrade when ascending or descending grades in excess of 10%. On all grades, tilt the forks back and raise only as far as necessary to clear the road surface. Use low gear or the slowest speed when descending a grade.

**C. SAFE STEERING**

1. Never make a turn at normal traveling speed, always slow down to maintain balance.
2. Stay wide when turning into an aisle to help clear the sides and square up with the destination.
3. Allow enough room for forks to clear the sides before turning, when backing out of an aisle.
4. When negotiating turns, turn the steering wheel in a smooth sweeping motion. At very low speeds, turn the steering wheel at a moderate, even rate.
5. Never turn a forklift with the load lifted higher than the travel height (four to six inches at the tips and two inches at the heels).

**D. TO PUT A LOAD ON AN ELEVATED SURFACE**

1. Square up and stop about a foot away from the rack on which the load is to be placed.
2. Raise load 5-10 inches above the unloading point (space permitting).
3. Drive forward stopping 3-4 inches in front of deposit point.
4. Tilt mast forward to a right angle position so load is level.
5. Drive forward until load is aligned with the deposit point. Stop.
6. Lower load to resting-place.
7. Stack pallets loaded with cases, cartons straight and square. Stagger the top tier to "tie-in place".
8. Tilt the forks slightly forward to avoid hooking the load.

9. Look over both shoulders and back straight out until the forks clear the rack. Stop.
10. Lower the forks to about 2-4 inches above the ground, then continue to backup or turn to proceed to the next location. Do not turn with elevated forks.

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**E. TO PUT A LOAD DOWN**

1. Square up and stop about a foot away.
2. Level the forks and then drive the rest of the way in.
3. Lower the load.
4. Tilt the forks slightly forward to avoid hooking the load.
5. Look over both shoulders and back straight out until the forks clear the pallet.

