

Project:	Site Operations – London Depot	RA No:	99	Review Date
Operation / Task:	General lathe operation including turning, facing, threading, boring, and machining hydraulic rams.	Persons at risk:	Operators, maintenance personnel, others in the immediate vicinity.	31/01/2027
Location / Area:	Plant Service Workshop	Public at risk:	No	
Monitoring Responsibility:	Service Workshop Manager; Service Workstop Supervisor; HSQE Team.			

KEY		S = Severity Rating		L = Likelihood of Occurrence		RR = Risk Rating						
Most effective Least effective	Elimination Substitution Engineering Controls Administrative Controls PPE	1. Negligible 2. Minor Injury 3. Major Injury (RIDDOR) 4. Fatality 5. Multiple Fatality	1. Improbable 2. Remote 1 – 10% 3. Possible 10 – 50% 4. Probable 50 – 90% 5. Almost certain 90%+	Severity	5 4 3 2 1	5 4 3 2 1	10 8 6 4 2	15 12 9 6 3	20 16 12 8 4	25 20 15 10 5	R O Y G	Unacceptable risk, plan out or add further controls. Acceptable only if no other method viable & with high level controls in place. Acceptable with suitable controls. Acceptable, no further action required.
						Likelihood						
						12345						

Activity	Hazards/Risks Identified	Risk Rating			Control Measures	Residual Risk			Responsibility
		S	L	RR		S	L	RR	
Machine setup & securing workpiece	Entanglement with rotating chuck, jaws, spindle or workpiece. Ejection of workpiece due to incorrect clamping or speed selection. Manual handling risks when lifting or changing heavy chucks or components.	4	3	12	- Only trained and authorised personnel may operate the lathe. - Operators must complete pre-use visual checks and stop work immediately if defects are found, isolating the machine and notifying the Service Manager. - Clothing must be close-fitting and free from gloves or jewellery. - Workpieces must be clamped securely with minimal protrusion. - Chuck keys must be removed immediately after tightening. - Guards and interlocks must be used at all times. - Operators must stand clear of the rotational plane during startup. - Mechanical lifting aids must be used where possible to avoid manual handling of heavy chucks or components.	4	1	4	Lathe Operator; Service Supervisor / Manager.
Maintenance / cleaning	Unexpected start-up (failure to isolate) Electric shock	4	3	12	- All servicing and maintenance must follow manufacturer instructions and be carried out by competent and authorised personnel. - The lathe must be fully isolated before any maintenance or cleaning, including clearing jammed swarf or adjusting belts. - Emergency stop controls must be used during cleaning. - Interlocks must never be bypassed. - PAT and fixed-wire inspections must be completed and recorded.	4	2	8	Maintenance Personnel; Service Supervisor / Manager.

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Cutting Operations (Turning, Facing, Threading, Boring)	Contact with cutting tools causing cuts or puncture wounds. Tool breakage due to incorrect feed or speed. Noise exposure. Delay in emergency stop activation. Fire risk when machining certain materials.	4	3	12	- A safe system of work must be in place and briefed to operators. - Hands must remain clear of the tool post. - The machine must be fully stopped before adjustments. - Guards must be in good condition and kept closed during operation. - The correct chuck type must be selected. - Manufacturer speed and feed charts must be followed. - Speed selectors must not be moved while the spindle is rotating. - Eye protection must be worn. - Noise levels from lathe machine are well below 85 dB(A), but hearing protection is available if needed. - Emergency stop must be accessible and functional. - The work area must remain clear and free from flammable materials. - Coolant flow must be appropriate to prevent sparks. - Fire extinguishers must be present and maintained, and staff must be briefed on fire procedures.	4	1	4	Lathe Operator; Service Supervisor / Manager.
Use of emery cloth or abrasive strips on	Entanglement of hands or fingers.	4	4	16	- Loose or hand-held emery cloth must not be used on rotating workpieces. - Only fixed abrasive tools, files or lathe-mounted abrasive holders designed for safe use may be used.	4	2	8	Lathe Operator; Service

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rotating workpiece	Cloth catching on rotating components. Severe cuts, burns or amputations.				- Gloves must not be worn near rotating parts. - Emery cloth must never be wrapped around fingers or held with both ends in the hands. - If abrasive finishing cannot be completed using approved methods, the spindle must be fully stopped and abrasive applied with the workpiece stationary. - Operators must be briefed on correct methods and supervisors must intervene immediately if unsafe practices are observed.				Supervisor / Manager.
Use of coolant / metalworking fluids during lathe operation	Dermatitis from skin contact. Mist inhalation. Bacterial contamination in sump. Infection from cuts. Slips from coolant spills.	3	4	12	- COSHH assessments must be in place and briefed. - Direct skin contact must be avoided and early signs of dermatitis reported. - Nitrile gloves must be worn when handling concentrate, filters or contaminated materials. - Coolant concentration must be maintained within specification. - Sump hygiene must be maintained through skimming, biocide dosing and scheduled fluid changes. - Guards must remain closed to reduce mist exposure. - Spill kits must be available and spills cleaned promptly. - Oily rags must be disposed of in sealed containers.	3	2	6	Lathe Operator; Service Supervisor / Manager; Maintenance Personnel.

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Housekeeping / workshop environment Hazards	Slips from coolant spills. Trips from swarf, tools or offcuts. Fire risk from oily rags. Obstructed access to emergency stop. Poor lighting affecting safe operation.	3	3	9	- The area around the lathe must remain clear of swarf, tools, rags and offcuts. - Coolant spills must be cleaned immediately using absorbent materials. - Oily rags must be placed in designated bins. - Adequate lighting must be maintained. - Access to emergency stop controls must remain unobstructed. - The floor area must be kept clear and swarf removed frequently. - Coolant hoses must be positioned to avoid trip hazards. - Housekeeping standards must be maintained throughout the shift.	3	1	3	Lathe Operator; Service Supervisor.
Swarf removal and disposal	Cuts and puncture wounds from sharp swarf. Burns from hot swarf. Entanglement from long stringy swarf. Dermatitis from coolant-contaminated swarf.	3	3	9	- Swarf must only be removed using designated tools and never by hand while the machine is running. - Hot swarf must be allowed to cool before handling. - Long or stringy swarf must be broken down using tools before disposal to reduce entanglement and handling risks. - Swarf contaminated with coolant must be drained before disposal and placed in the workshop's designated metal waste bins. - Swarf bins must be kept covered, positioned in their designated area and emptied regularly by an approved waste contractor.	3	1	3	Lathe Operator; Service Supervisor.

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	Environmental contamination if swarf is disposed of incorrectly.				- Swarf must not be left on the floor, benches or machine surfaces where it may cause slips, puncture injuries or contamination. - Any spillage of swarf onto the floor must be cleaned immediately.				

Risk Assessment Prepared By:

Daniela Rizvan

Signature:

29/06/2026

Risk Assessment Reviewed By:

Paul Lynch

Signature:

29/06/2026



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