

# STANDARD OPERATING PROCEDURE

Hydraulic Hose Manufacturing - Marking

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Revision Number: 3

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Latest Revision Date: Sep 11, 2025

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## HYDRAULIC HOSE MANUFACTURING – MARKING

*Tammy Siver*

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*The following is a step-by-step procedure on how to complete a specific task or meet a facility specific requirement. Standard Operating Procedures (SOPs) are written for all identified critical tasks. By virtue of the hazard or complexity associated with critical tasks it is paramount that the SOP be followed as written. SOPs contain a listing of high-level hazards associated with the task, for detailed hazard analysis reference the applicable Task Hazard Assessments. SOPs do not replace the requirements contained in the company Standards, Codes, and Processes nor does it replace the need to comply with required legislation. Section 8.0 references documentation that the worker shall understand before work commences.*

## 1.0 PURPOSE

- To establish a Company standard to safely and effectively carry out work as it applies to the marking process for hydraulic hose manufacturing.

## 2.0 SCOPE AND APPLICATION

- This document applies to all company Heavy Construction Mining operations. Ensure all site-specific requirements are being met or exceeded before performing the task.

## 3.0 HAZARDS AND CONTROLS

- Risk of injury from flying projectiles while marking the hose.
  - Wear eye protection when operating the Dot Peen marker, as the marking pin could fracture and send a hardened piece of the pin flying.
- Risk of pinching or crushing injuries to fingers and hands.
  - Always keep body parts and hands outside the marking zone. Use the clamping vise to securely hold any pieces that need to be marked.
  - Do not hold parts by hand during the marking process. This can result in serious injuries, including puncture wounds from the marking pin.

## 4.0 CHECKLIST

- ☐ Attend all preparatory meetings (i.e.: daily PSI; job scope; review of JSA's and SOP's for the job).
- ☐ Complete FLRA cards before starting the work.
- ☐ Ensure all personnel involved in the task are aware of the hazards and the controls to be used, as identified in the SOP's, JSA's, and FLRA's.
- ☐ Conduct a pre-job inspection of all equipment to be worked on and tools to be used.
- ☐ **Standard of Training required for working on this job: On-the-job training.**

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## 5.0 DEFINITIONS

### 5.1 Company

Means North American Construction Group Ltd. (NACG) and all directly or indirectly owned subsidiary companies, including joint ventures.

### 5.2 Company Personnel

Includes the Company's employees, officers, directors, agents, associates, consultants/contractors, temporary employees, and third-party processors.

### 5.3 HSE

Refers to the Health, Safety & Environment department.

## 6.0 PROCEDURE

- 1) Complete a hazard assessment (i.e. FLRA) for the task. Notify supervision if unsure of task or if hazards are outside of the worker's control.
- 2) Inspect tooling and work area prior to task. Remove from service and notify supervision of any damaged or defective tooling. Do not use unsafe tooling.
- 3) Raise the Marking Head and lift the marking head well above the vise to ensure clearance.
- 4) Load the Shell by placing the shell to be marked into the vise and clamping it securely.
- 5) Push the "Home" button on the control to re-establish the home position. **Important:** Ensure that the marking head will not crash into anything while moving to the home position.
- 6) Run the Positioning Job - Execute the positioning job according to the Production Instruction Tag.
- 7) Adjust the Z-axis height as specified in the Production Instruction Tag.
- 8) Run the Marking Job - Execute the marking job per the Production Instruction Tag. **Important:** Keep your hands clear of the marking area during operation.
- 9) Unload the Shell by removing the shell from the vise.

## 7.0 NOTES

If this task is to be done by a method different than described in this SOP, the work must **STOP** and the alternate method must be **DOCUMENTED** with an adequate hazard assessment tool such as a JSA. The document must be **APPROVED** by a supervisor before such procedures are implemented.

## 8.0 REFERENCES

- Refer to the Manufacturer's Operation Manual or OEM Parts Manual for operation and setup details.
- Alberta Occupational Health and Safety Act, Regulation and Code
- 950C-C-025 Hand Tools Code
- 950C-C-050 PPE General Code
- 960C-SOP-504 Hand Tools; Use of

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- 960C-SOP-505 Hand Tools Powered Use
- 960C-SOP-112 Air Line Control and Dangers

## 9.0 APPENDICES

- No appendices.