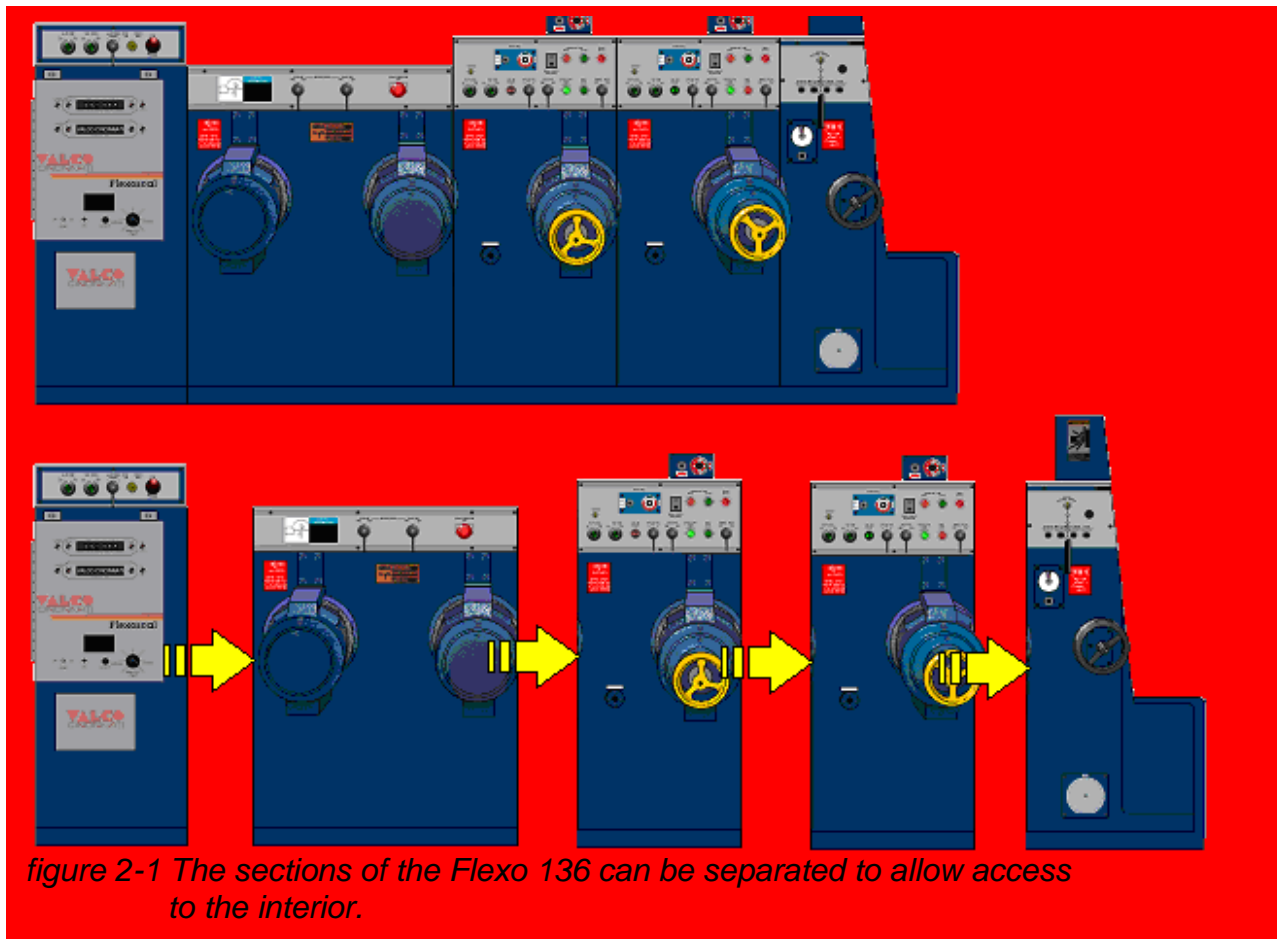


2. SAFE PROCEDURE FOR MOVING BETWEEN OPEN SECTIONS OF THE FLEXO 136

The **FLEXO 136** opens into five sections to allow operators access to the interior to make adjustments (*fig. 2-1*).



There are two **KEY CONTROL BOXES** on the **FLEXO 136**. Each **KEY CONTROL BOX** has three positions, each corresponding with one of the positions assigned to the **136**. One **KEY CONTROL BOX** is located on the **FEED SECTION** (*fig. 2-2*) and the other is located at the bottom of the **SATURN II CONTROL PANEL** (*fig. 2-3*).

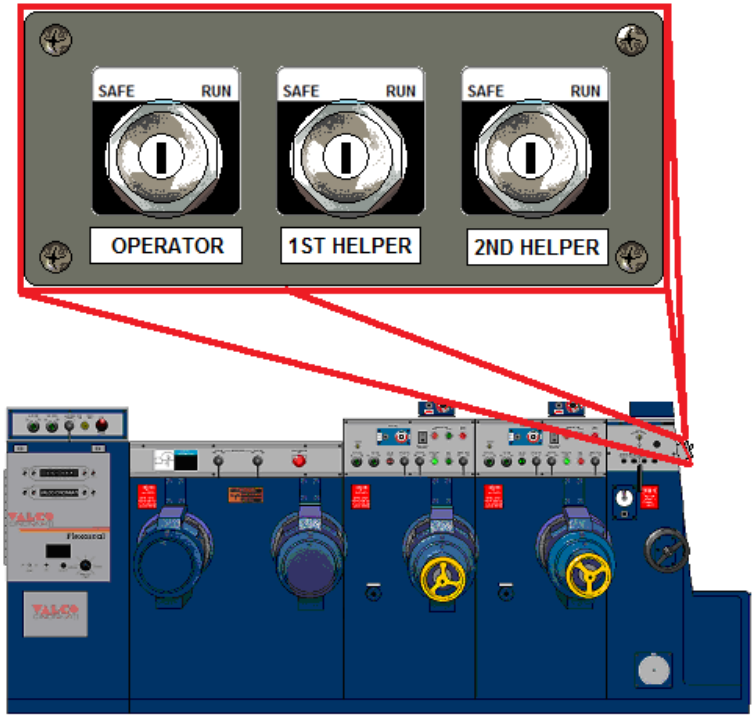


fig. 2-2: The key control box on the feed section of the Flexo 136.

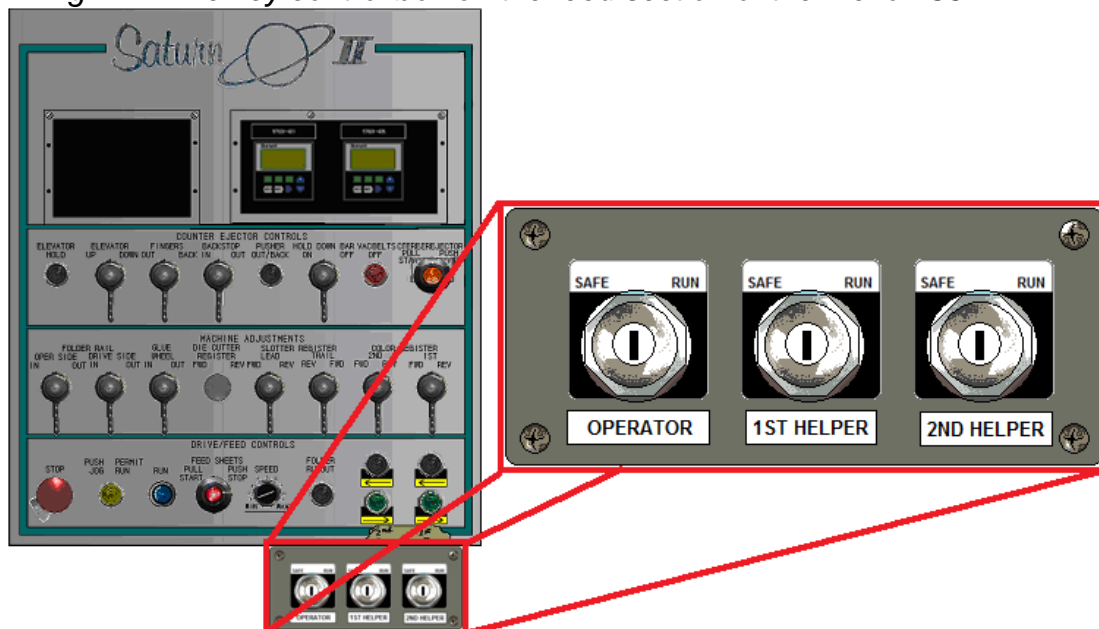


fig. 2-3: The key control box on the Saturn II control panel.

When a key is in each position, the **136** can run. Removing any single key will prevent others from starting or jogging the **136** before personnel have completed work, but it will not put the **136** in a **Zero Energy State**.

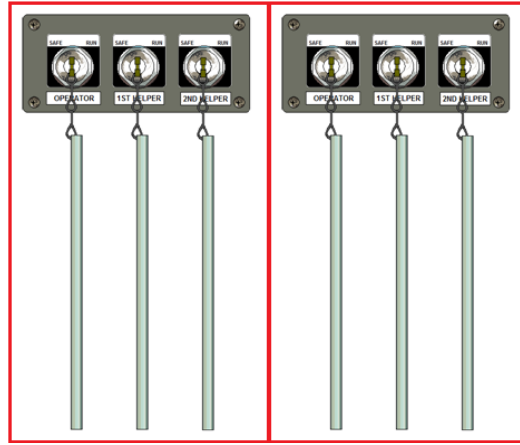


figure 2-5: All six keys must be in place for the Flexo 136 to operate.

Removal of any single key will put the **FLEXO 136** in **ESP**. Each employee working on the machine that removes their key will put their key in his/her pocket. When ready to take the machine out of **ESP**, employee will put the key back in the **KEY CONTROL BOX** (fig. 2-6).

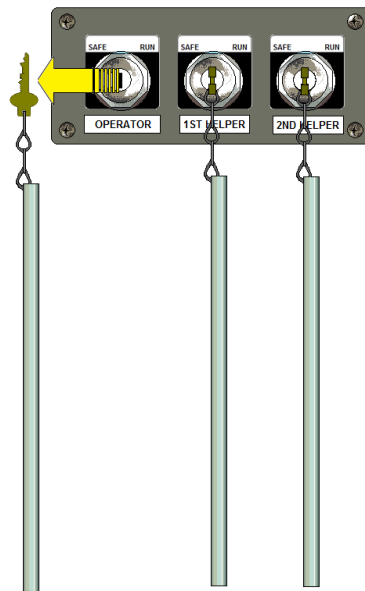


figure 2-6: Removal of one key puts the Flexo 136 into ESP.