


## Plant Hazard Analysis & Risk Assessment

<b>Model:</b> Forst ST6PHD	<b>Date:</b> 27/02/2026
	<p><b>Person conducting / reviewing assessment:</b> S. Parlevliet</p> <p>This Hazard Identification and Risk Assessment document is Model specific. It is based on the knowledge that all new machines of this model were/are produced to the same specification and design. It assumes all examples of this exact model currently in service to be as per the original specification, and to have been and continue to be operated and maintained in accordance with the Manufacturers requirements, and with all applicable statutory and regulatory requirements of an original example of the Model for which it was prepared. This Assessment must be reviewed by all stakeholders as required:</p> <ul style="list-style-type: none"> <li>• Having regard to the manufacturers approved options</li> <li>• Having regard to the general arrangement of miscellaneous equipment or facilities that may be provided on the plant according to the end users requirements or specification</li> <li>• According to the particular circumstances under which the plant is used and maintained</li> <li>• As new Hazards are identified and/or as risks are reassessed</li> <li>• As existing risk control measures are revised or new risk control measures are introduced and implemented</li> <li>• As and when work procedures are altered or revised</li> <li>• Having regard to any unauthorised alterations or modifications made to the design or operation of the equipment</li> </ul> <p>Monitor has made every attempt to identify all reasonably foreseeable operating circumstances in preparing this Assessment, however no guarantee as to the completeness of this Assessment is provided or implied. It is the responsibility of Owners, Employers and Operators to identify all hazards associated with the use of this equipment specifically applicable to the task to be carried out and to where the equipment is to be used or located. They must assess the risk potential for each of the identified hazards and ensure that all reasonably practicable steps are taken to ensure those risks are effectively controlled.</p> <ul style="list-style-type: none"> <li>• All operators must be trained and competent in the safe use of this particular piece of equipment, and hold appropriate qualifications as required by applicable regulatory requirements</li> <li>• Operators of the equipment to which this Plant Risk Assessment refers must read and understand the Instructions for Use and Warnings contained within the Operators Manual prior to use</li> <li>• All Daily Pre-Start Checks, Routine and Periodic Inspections, Maintenance and Repairs to this equipment must be carried out in accordance with the requirements of AS 4024.3701:2020.</li> </ul>

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ID	Description of Hazard Potential		Activity	Risk control measures already implemented	Risk	Supplementary risk control measures	Risk score
	Origin	Consequence					
1	Operator Competency						
1.1	<p>Untrained operator, not following proper operating procedures.</p> <p>Distracted operator.</p> <p>Following a poor system of work.</p> <p>Operator working alone.</p>	<p>Entanglement (amputation/death)</p> <p>Laceration / cuts / bruises / fractures</p> <p>Serious injury or death</p>	<p>Set up</p> <p>Operation</p> <p>Maintenance</p>	<p>Operation instructions explained in operator's manual</p>	<p>C4 Extreme</p>	<p>Train operators on safe use of the plant.</p> <p>Operator training should include at least the following:</p> <ul style="list-style-type: none"> <li>• pre-operation inspections</li> <li>• safe operation of plant</li> <li>• regular maintenance tasks</li> <li>• understanding of plant operation</li> <li>• capabilities and limitations</li> <li>• emergency procedures</li> </ul> <p>Do not operate the plant unless proper training has been received.</p> <p>Ensure operator's manual is kept with the plant for reference.</p> <p>Do not operate the plant when distracted, ill, excessively fatigued, or under the influence of drugs or alcohol.</p> <p>Implement appropriate system of work based on manufacturer's recommendations (e.g. operating instructions shown in operator's manual).</p>	<p>B1 Low</p>
1.2	Misuse	Entanglement (amputation/death)	Operation	Operator's manual warns about not using the plant for other than its intended purpose.	C4 Extreme	Do not use the plant for any other purpose than its intended use as	C4 Extreme

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	Unauthorised use of plant	Laceration / cuts / bruises / fractures Serious injury or death				explained in the operator's manual. Do not operate the plant unless proper training has been received. Keys are not to remain in an unattended machine.	
2	Plant Limitations						
2.1	Excessive incline causing plant to overturn	Roll over	Driving Operation	Operator's manual recommends that you do not drive on ground with an incline in excess of 20°.	C3 High	Do not drive the plant over ground slopes which exceeds its limitations. Avoid driving on ground too soft to support the machine's weight. Make sure the engine and hydraulic oil are warm before working on inclined ground. If the machine has to be stopped on an incline, make sure that the machine is pointing either up or down the slope. Also chock both wheels at the downhill end.	B2 Low
3	Operation						
3.1	Damaged control panel	Crushing Impact	Set up Operation		C2 Medium	Regularly inspect control panel.	A1 Rare
3.2	Moving chipper into position	Overturning Crushing	Driving Set up	Follow maximum inclination limits set by manufacturer. Found in operator's manual.	C4 Extreme	Carry out job site risk assessment to determine suitability of the site before commencing any work.	B2 Low

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						<p>Avoid driving on steep ground; find alternative routes whenever possible.</p> <p>Do not drive at fast speeds.</p> <p>Avoid harsh use of the levers as both levers used in extreme opposition will cause the machine to spin on its axis.</p> <p>Avoid driving on ground too soft to support the machine's weight.</p> <p>Do not stand on the lower side of the plant while driving on steep ground.</p> <p>Never drive across steep ground, always drive with the wheels parallel to ground inclination.</p>	
3.3	Set up	Struck by flying debris – sticks, branches, timber	Operation	Operator's manual states when in use, woodchip and debris are ejected with considerable force from the chute and can travel up to 10m.	D3 High	<p>Ensure only operators are within work area - ensure the exclusion zone is in place and operational.</p> <p>Do not allow discharge to be directed onto roads or public rights of way.</p> <p>Make sure the chute directs woodchip to a safe location so that no one can be harmed or property damaged.</p>	B2 Low
3.4	Prestart inspection	Laceration / cuts / bruises / fractures	Operation	Prestart inspection as per manufacturers recommendation.		Ensure any fitted safety devices or equipment are in good condition	A1 Low

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				Chipper fitted with <ul style="list-style-type: none"> <li>- E-Stop</li> <li>- Forward reverse buttons</li> <li>- Stop bar</li> </ul>		and functional during Pre-start check.	
3.5	Uncontrolled movement of plant components	Entanglement (amputation/death) Laceration / cuts / bruises / fractures Serious injury or death Muscular stress / Musculoskeletal Disorder	Set up Operation Maintenance Cleaning Troubleshoot	Prestart inspection as per manufacturers recommendation.  Feed and engine speed are controlled with a "No Stress" function ensuring that cutting conditions are kept within optimum limits. This maximises throughput while minimising jams and blockages. There will be times when material is being cut and the feed will momentarily stop until engine speed increases. At this point, the feed will start without warning.	C3 High	Isolate power to plant and remove the main switch key when performing maintenance and cleaning tasks.  Maintenance to be carried out by a competent person.  Pay attention to hazard decals to machine.	B2 Low
3.6	Operator safety	Entanglement (amputation/death) Laceration / cuts / bruises / fractures Serious injury or death	Set up Operation Maintenance Cleaning Troubleshoot	Ensure operator: <ul style="list-style-type: none"> <li>- Has no loose clothing or jewellery, hair tied back</li> <li>- Has snug fitting PPE with no cuffs or strings</li> <li>- Has clothing tucked in where applicable.</li> </ul>	D4 Extreme	May require dust mask dependant on type of timber being chipped.	B2 Low

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				<ul style="list-style-type: none"> <li>- Is provided with correct rated hearing protection.</li> <li>- Safety footwear</li> </ul>			
3.7	Feeding material into chipper	Entanglement (amputation/death) Laceration / cuts / bruises / fractures Serious injury or death Muscular stress / Musculoskeletal Disorder	Operation	Operator's manual recommends that you do not try to force material over 203mm in diameter or 254mm wide into the machine. Use speed (RPM) as directed by manufacturer. Do not exceed.	D4 Extreme	Ensure material to be chipped is clear of metal, stones, plastic, fauna, pests, diseases, rope or other contamination. Ensure material of suitable size for chipper. De-limb/cut as required. Load materials from side of in-feed chute. Do not stand in front during loading. Place butt-end first. Push short stubs through with longer branches. Lay shorter branches of top of longer ones. Do not place hands or body parts into in-feed chute. Once in-feed grabs material, step back from chipper. Do not use force to push materials through.	B3 Medium
3.8	Discharge	Struck by flying debris – sticks, branches, timber Entanglement (amputation/death) Laceration / cuts /	Operation	Follow procedure in operator's manual if blockage occurs.	D4 Extreme	Ensure discharge chute pointed downwards (reduce dust). Clear away discharge regularly.	B2 Low

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		bruises / fractures- Serious injury or death				If chipper begins to vibrate or shake violently, stop work immediately and stop machine.  Always stop machine, wait for moving parts to stop and lock out power to chipper before removing any blockages.  NEVER climb or stand on chipper/in-feed.	
3.9	Faulty/out of order, or poorly maintained plant	Entanglement (amputation/death) Laceration / cuts / bruises / fractures Serious injury or death Muscular stress / Musculoskeletal Disorder	Operation Emergency Maintenance	Operator's manual outlines plant maintenance schedule.  Current maintenance inspections up to date as per manufacturers recommendation.	B4 High	Always perform pre-operation inspection before operating the plant.  Implement 'tag out' procedure to isolate faulty/out of order plants.  Do not use an 'out of order' plant.  Record all faults in logbook.  Perform plant maintenance as per manufacturer's maintenance schedule.  Keep maintenance records / plant logbook up to date.	B1 Low
3.10	Refuelling	Explosion Fire			B4 High	When refuelling: <ul style="list-style-type: none"> <li>• Keep away from ignition sources</li> <li>• Do not smoke</li> <li>• Avoid spilling fuel over hot engine.</li> </ul>	A2 Low
3.11	Engine exhaust pipe	Burn	Operation	Exhaust pipe guarded. "Hot surface" decal in place.	C2 Medium	Do not touch exhaust pipe when hot.	A1 Low

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3.12	Plant modifications after completion of risk assessment.	Crushing Overturning	Operation Set up		C5 Extreme	Ensure modifications made to the plant are inspected, assessed, and approved by a competent person.  Review hazard analysis and risk assessment after plant modifications.	B1 Low
4	Transport / Handling						
4.1	Unsecured vehicle	Impact	Transport		C4 Extreme	Ensure the machine is secured in accordance with the requirements described in the manual and with relevant transport regulations.	A2 Low
4.2	Injury sustained when hitching to or unhitching machine from towing vehicle	Strains / Sprains Crush Impact	Transport	Trailer is fitted with park brake and safety chain. Jockey wheel fitted to lift machine to tow coupling height.	C3 High	Ensure park brake is applied before unhitching from vehicle.  Ensure jockey wheel and tow coupling are maintained or replaced if damaged.	A2 Low
4.3	Towing Machine	Overturning Impact	Transport		C3 High	Ensure machine is in transportation mode before departing:  <ul style="list-style-type: none"> <li>• Hopper tray is secured in the up position</li> <li>• Discharge chute is securely fixed at the inboard position</li> <li>• Rear support stand up.</li> </ul> Clear machine of loose woodchip material before departing.	A2 Low

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4.4	Incorrect replacement tyre fitted	Crushing Overturning Impacting	Operation	Maintain correct tyre inflation pressures as per manufacturers recommendation.	B4 High	Ensure replacement tyres match the plant manufacturer specifications.	A1 Low
4.5	Flat tyre	Overturning Crushing Impact	Operation	Prestart inspection as per manufacturers recommendation.	C4 Extreme	Regularly check condition of pneumatic tyres. Avoid driving over sharp obstacles or debris.	B1 Low
4.6	Lifting	Crush Impact	Transport Lifting	Lifting procedure included in Operator's Manual.  Data plate on machine and specifications in Operators Manual show the machine gross weight.  Machine fitted with a lifting eye.	C5 Extreme	Follow appropriate lifting procedure.  The lifting eye can only support the weight of the woodchipper.	B2 Low
5	Plant Failure						
5.1	Power Failure Burst hydraulic hose	Crushing Overturning Burn Skin irritation	Set up Operation Maintenance		A3 Medium	Check hydraulic hose condition during periodic maintenance. Report and "tag out of service" if identified.	A2 Low
5.2	Excessive hydraulic oil pressure.	Impact Crushing	Set up Operation		C3 High	Check pressure settings during preventative maintenance.	A1 Low
5.3	Emergency Stop not available	Crushing Impact Trauma	Emergency Maintenance		C4 Extreme	Check that the emergency stop button functions correctly.	B1 Low
5.4	Inadequate maintenance procedures	Crushing Impact	Maintenance	Maintenance procedures included in Operator's Manual.	C3 High	Allow only qualified service personnel to perform maintenance tasks.	A2 Low

RISK MATRIX						ACTION	HEIRACHY OF CONTROLS	
		CONSEQUENCE						
		1. Insignificant	2. Minor	3. Moderate	4. Major	5. Catastrophic		
LIKELIHOOD	<b>E. Almost Certain</b> Is expected to occur immediately or within a short timeframe	HIGH	HIGH	EXTREME	EXTREME	EXTREME	<p><b>EXTREME</b> – Do not proceed, until further control measures are implemented to lower the risk. Senior management attention required.</p> <p><b>HIGH</b> – Review and introduce additional controls to lower level of risk. Needs senior management attention.</p> <p><b>MEDIUM</b> – Monitor and maintain supervision and controls. Specify management responsibility.</p> <p><b>LOW</b> – Monitor and manage by routine procedures and monitoring.</p>	<ol style="list-style-type: none"> <li>1. Elimination – controlling the hazard at the source</li> <li>2. Substitution – e.g. replacing one substance or activity with a less hazardous one</li> <li>3. Isolation – e.g. use of barriers to shield or isolate the hazard, enclosures for noisy machinery, installing guards on machinery</li> <li>4. Engineering – e.g. design and install equipment to counteract the hazard</li> <li>5. Administration – policies and procedures for safe work practices</li> <li>6. Personal Protective Equipment – e.g. respirators, ear plugs, face masks, safety glasses, safety shoes</li> </ol>
	<b>D. Likely</b> Will probably occur in most circumstances	MEDIUM	HIGH	HIGH	EXTREME	EXTREME		
	<b>C. Possible</b> Could happen and has occurred here or elsewhere	LOW	MEDIUM	HIGH	EXTREME	EXTREME		
	<b>B. Unlikely</b> Unlikely to occur	LOW	LOW	MEDIUM	HIGH	EXTREME		
	<b>A. Rare</b> Not expected to occur	LOW	LOW	MEDIUM	HIGH	HIGH		

CONSEQUENCE DESCRIPTORS			
SEVERITY	SAFETY	ENVIRONMENT	BUSINESS
<b>5. Catastrophic</b>	Potential for incident resulting in serious damage and/or fatality	The aspect is legally or contract regulated and has the potential for a disastrous long term impact resulting in prosecution.	Loss > \$1M
<b>4. Major</b>	Potential for incident resulting in serious damage and/or permanent disabling illness or injury	The aspect is legally or contract regulated and has the potential for a serious long term impact resulting in prosecution.	Loss of service provision
<b>3. Moderate</b>	Potential for incident resulting in significant damage and/or temporary disabling illness or injury	Significant environmental aspect with short term impact resulting in improvement notice.	Loss \$100K - \$1M
<b>2. Minor</b>	Potential for incident resulting in moderate damage and/or requiring medical treatment.	The aspect is legally or contract regulated and has the potential for a moderate reversible short term impact resulting in an improvement notice.	Prolonged reduction in service provision or productivity
<b>1. Insignificant</b>	Potential for incident resulting in minor damage and/or injury requiring first aid treatment	The aspect is not legally or contract regulated and has the potential for a minor negligible impact.	Loss \$10K - \$100K