

LEADING CAUSES OF INJURIES IN THE F&B MANUFACTURING INDUSTRY

In recent years, the Food and Beverage (F&B) Manufacturing industry has continued to contribute significantly to workplace injuries. These injuries are typically caused by gaps in work processes, supervision, and equipment management.

1. Processes, Risk Assessment and Safe Work Procedures

A key contributing factor is the deviation from jam clearing procedures and failure to apply proper machine isolation through Lockout/Tagout (LOTO) procedures. These could result in workers being hurt by moving machine parts.

Picture1: Safety interlock installed to ensure cover is closed before operation



Recommendations:

- Conduct regular risk assessments to identify and address hazards associated with machine intervention activities.
- Establish and enforce Safe Work Procedures (SWPs) for jam-clearing and maintenance activities.
- Apply LOTO procedures before any machine intervention work.

2. Control of Personnel

Another major root cause observed is poor coordination between workers and inadequate supervision during shift changes. These gaps in coordination and communication can increase the risk of accidents, especially when machinery is involved.

Picture 2: Ensure machine operators understand how to use the machines safely



Recommendations:

Implement structured shift handover processes to ensure effective communication of hazards and machine status.

- Clearly define roles and responsibilities for machine operation and intervention tasks.
- Ensure supervisors actively monitor and correct unsafe work practices.

3. Control of Equipment and Work Environment

Injuries often occur when machine guarding is removed or inadequate. Before cleaning, maintenance, or repair work is carried out, equipment should always be properly isolated.

Picture 3: A properly implemented LOTO procedure protects workers from unexpected equipment start-up.



Recommendations:

- Install and maintain effective machine guards and interlocking safety devices.
- Conduct routine inspections and preventive maintenance of machinery and safety systems.

- Verify that all energy sources are isolated before cleaning, maintenance, or repair work. Clearly identify isolation points and provide workers with appropriate LOTO equipment.

4. Worker Behaviour and Situational Awareness

Unsafe worker actions can increase the risk of accidents, especially when controls are bypassed when clearing jams. Furthermore, repetitive tasks can lead to distraction or complacency, increasing the likelihood that workers may overlook potential hazards.

Picture 4: Ensure guards are in place and use appropriate tools to clear jams safely



Recommendations:

- Reinforce compliance with safety procedures and prohibit the bypassing of machine safeguards.
- Encourage workers to stop work and report unsafe conditions. Commend those who do so.
- Rotate repetitive tasks and provide adequate breaks to reduce fatigue and complacency.

For more information on preventing injuries in the F&B Manufacturing Industry, refer to the WSH resources below:

WSH Insights

- [12 May 2026 Strengthening WSH in Food Manufacturing](#)

WSH Pictogram

- [Basic WSH Rules for Food Manufacturing](#)

WSH Bulletin

- [14 November 2024 GIFs on Preventing STFs in the Food and Beverage Industry](#)

Video

- [I can prevent hand injuries](#)
- [Prevent accidents through behavioural observation and intervention](#)

Others

- [Common Hazards in the Food and Beverage Manufacturing Industry](#)