

**Industrial Press Operations Hydraulic and Mechanical**

Business Name:		ABN:	
Business Address:			
Contact Person:	Phone:	Email:	

**THIS RISK ASSESSMENT IS APPROVED BY THE PCBU ON THIS PROJECT**

Under the Work Health and Safety Regulation (WHS Regulation), a person conducting a business or undertaking (PCBU) is required to ensure that a RISK ASSESSMENT is prepared before the proposed work starts.

Full Name:		
Signature:	Title:	Date:

**CLIENT OR PRINCIPAL CONTRACTOR DETAILS**

Client:	SCOPE OF WORKS
Project Name:	
Project Address:	
Project Manager:	
Contact Phone:	
Date Risk Assessment supplied to Project Manager:	



RISK MATRIX									
LIKELIHOOD	INSIGNIFICANT	MINOR	MODERATE	MAJOR	CATASTROPHIC	SCORE	ACTION	HIERARCHY OF CONTROLS	
ALMOST CERTAIN	3 HIGH	3 HIGH	4 ACUTE	4 ACUTE	4 ACUTE			<b>Elimination</b> Remove the hazard.	
LIKELY	2 MODERATE	3 HIGH	3 HIGH	4 ACUTE	4 ACUTE	4A ACUTE	DO NOT PROCEED	<b>Substitution</b> Replace the hazard.	
POSSIBLE	1 LOW	2 MODERATE	3 HIGH	4 ACUTE	4 ACUTE	3H HIGH	Review before work starts.	Isolation Isolate People from the hazard	
UNLIKELY	1 LOW	1 LOW	2 MODERATE	3 HIGH	4 ACUTE	2M MODERATE	Ensure control measures in place.	<b>Engineering</b> Isolate the hazard	
RARE	1 LOW	1 LOW	2 MODERATE	3 HIGH	3 HIGH	1L LOW	Monitor and keep records.	<b>Administrative</b> Change	
								<b>PPE</b>	

  

Risk Rating & Required Action:	
<b>4A</b>	Stop work. The risk is intolerable. Eliminate the hazard or redesign the activity before proceeding. A Safe Work Method Statement (SWMS) or higher-level authorisation is required.
<b>3H</b>	Review and approve additional controls before task starts. Senior supervisor sign-off needed.
<b>2M</b>	Ensure all nominated controls are in place and effective. Proceed with caution; monitor conditions.
<b>1L</b>	Proceed, following standard operating procedures. Monitor and keep records.

  

Consequence Scale:			
Consequence	People (injury/illness)	Project / Assets	Compliance / Reputation
<b>Catastrophic</b>	Fatality or permanent total disability	project shutdown	Significant regulator intervention; criminal prosecution
<b>Major</b>	Serious injury/illness (hospital > 5 days)	critical delay	Improvement notice; major media coverage
<b>Moderate</b>	Medical-treatment injury; lost-time > 1 day	moderate delay	Minor breach; adverse client comment
<b>Minor</b>	First-aid only, no lost time	negligible delay	Isolated non-conformance
<b>Insignificant</b>	No injury	no schedule impact	Deviation caught and corrected on site

  

**Notes on Hierarchy of Controls:**  
Remember to apply controls in the preferred order shown by the coloured pyramid:

1. **Eliminate**
2. **Substitute**
3. **Isolate**
4. **Engineering**
5. **Administrative**
6. **PPE**

Always document **why** a lower-order control is accepted if elimination or substitution is not reasonably practicable.

*aligned with Safe Work Australia's Managing the risk of fatigue at work (2023) and ISO 45001:2018 clauses 6–8.*

JOB STEP	POTENTIAL HAZARDS	IR	CONTROL MEASURES	RR
SPECIFIC WORK STEPS	HAZARDS THAT MAY ARISE	INITIAL RISK	SPECIFIC MEASURES TO BE PUT IN PLACE TO ELIMINATE OR CONTROL THE RISKS	RESIDUAL RISK
1. Governance, WHS Leadership and Legal Compliance	<ul style="list-style-type: none"> <li>Lack of documented WHS policy specific to press operations leading to inconsistent safety expectations</li> <li>Failure to identify and comply with WHS Act 2011, WHS Regulations and relevant Australian Standards for industrial presses</li> <li>Inadequate allocation of resources (time, budget, competent personnel) for managing press safety systems</li> <li>No formal WHS objectives, KPIs or performance indicators for press safety performance</li> <li>Poor safety leadership and visible commitment from management resulting in risk-tolerant culture</li> <li>Failure to consult with workers and Health and Safety Representatives (HSRs) on changes to press plant, layouts or procedures</li> <li>Inadequate officer due diligence in monitoring and verifying management systems for hydraulic and mechanical presses</li> </ul>	4A	<ul style="list-style-type: none"> <li>Develop and endorse a site-specific WHS policy that explicitly addresses industrial press operations (air, arbour, fly, gasket cutting, hydraulic cylinder cut cracker, hydraulic press, kick press, power mechanical press, manual punch press and press-fitting activities)</li> <li>Ensure legal register and compliance obligations are documented, maintained and reviewed for WHS Act 2011, WHS Regulations, and relevant standards (e.g. AS 4024 series for Safeguarding of Machinery, AS 1219, AS 1788 as applicable)</li> <li>Assign clear WHS roles, responsibilities and accountabilities for press safety to officers, managers, supervisors and workers, with position descriptions reflecting these duties</li> <li>Establish measurable KPIs for press safety (e.g. completion of inspections, action closure rates, near miss reporting) and review them at management meetings</li> <li>Implement formal consultation mechanisms (toolbox meetings, WHS committee, HSR forums) to discuss press safety risks, changes and improvement actions</li> <li>Ensure officers demonstrate due diligence by regularly reviewing press risk assessments, audit reports, incident data and verifying the effectiveness of controls</li> <li>Include press operations and plant change projects in annual WHS planning and budgeting, ensuring resources for guarding upgrades, training and maintenance are secured</li> <li>Conduct periodic external or internal compliance audits specifically targeting press operations and management systems</li> </ul>	3H
2. Plant Design, Guarding and Safety Systems	<ul style="list-style-type: none"> <li>Presses provided with inadequate fixed and interlocked guards over danger zones and pinch points</li> <li>Over-reliance on operator instead of engineered guarding to prevent access to tooling during stroke</li> <li>Inadequate design of two-hand controls, light curtains or presence sensing devices (e.g. not fail-safe, poor positioning, easily bypassed)</li> <li>Lack of safety category / Performance Level (PL) design verification for safety-related parts of control systems</li> <li>Inadequate guarding for associated equipment such as air supply lines, hydraulic cylinders, flywheels, belts, and rotating arbour shafts</li> </ul>	4A	<ul style="list-style-type: none"> <li>Undertake engineering review of all industrial presses (air, arbour, fly, kick, gasket cutting, hydraulic, mechanical power presses, manual punch presses and press-fitting jigs) against AS 4024 series and relevant plant standards</li> <li>Install fixed guards, interlocked moveable guards, and presence sensing devices that prevent access to danger zones during press stroke, designed to an appropriate safety category / Performance Level</li> <li>Ensure two-hand control systems are designed to prevent defeat, require synchronous operation and are located outside the hazard zone reach distance</li> <li>Verify all safety control systems (e.g. emergency stop, interlocks, light curtains, anti-tie-down) are designed and validated by a competent engineer and documented in a safety-related control system report</li> <li>Fit power presses with single stroke or anti-repeat devices and ensure continuous mode operation is controlled, risk-assessed and restricted to suitable applications with additional guarding</li> <li>Standardise guarding arrangements across presses to minimise variation and reduce the likelihood of incorrect operation or bypassing</li> </ul>	2M

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	<ul style="list-style-type: none"> <li>Poorly designed access for tooling changes and maintenance, leading to guard removal or bypassing</li> <li>Non-standard or home-made presses (e.g. modified hydraulic benches, nut crackers) without engineering verification</li> <li>Absence of anti-repeat / single stroke mechanisms on power presses, allowing unintended continuous cycling</li> </ul>		<ul style="list-style-type: none"> <li>Provide hinged or removable guards with captive fasteners for tooling changes, with interlocks that prevent press operation when guards are open or removed</li> <li>Implement a management of change (MoC) process for any modification to press design, guards or control systems, requiring engineering sign-off and updated risk assessment</li> <li>Clearly label all safety devices and guards with purpose and operating instructions, and maintain up-to-date electrical and pneumatic/hydraulic schematics</li> </ul>	
3. Press Procurement, Commissioning and Decommissioning	<ul style="list-style-type: none"> <li>Acquisition of presses that do not comply with Australian WHS requirements or are not fit for intended use</li> <li>Lack of pre-purchase risk assessment for new or second-hand presses and associated tooling</li> <li>Insufficient commissioning checks leading to presses being put into service with critical safety functions not validated</li> <li>Use of imported or refurbished presses with undocumented modifications or unknown mechanical issues</li> <li>Poorly planned commissioning, relocation or disposal resulting in uncontrolled stored energy and increase in instability</li> <li>Failure to ensure suppliers provide manuals, specifications, conformity/verification documentation and training materials</li> </ul>		<ul style="list-style-type: none"> <li>Establish a formal procurement process requiring WHS risk assessment and engineering review before purchasing an industrial press or major component</li> <li>Specify WHS compliance requirements in purchase contracts, including conformity with WHS Regulations Part 5.1 and relevant Australian Standards for safeguarding and control systems</li> <li>Require suppliers to provide documentation (manuals, CE/AS compliance evidence, safety integrity manuals/PL calculations, electrical and hydraulic/pneumatic diagrams) prior to acceptance</li> <li>Implement a commissioning checklist for all new or modified presses, including functional verification of guards, interlocks, emergency stops, control modes and pressure/force limits</li> <li>Ensure commissioning is undertaken and signed off by competent persons (mechanical, electrical and hydraulic/pneumatic specialists as required)</li> <li>Include validation that the press is matched to its intended tasks (e.g. appropriate tonnage, stroke, daylight, throat depth) to avoid overloading or unsafe workarounds</li> <li>Develop and apply procedures for safe decommissioning, isolation, energy dissipation and physical stabilisation when presses are removed from service or relocated</li> <li>Maintain an asset register that records acquisition date, specifications, modifications, commissioning records and decommissioning status for all presses</li> </ul>	2M
4. Press Selection, Capacity and Tooling Management	<ul style="list-style-type: none"> <li>Incorrect matching of press capacity and stroke to task (e.g. exceeding tonnage limits for press-fitting bearings or bushings)</li> <li>Use of unsuitable or damaged tooling, dies, punches or arbour press fixtures that can fracture or eject</li> <li>Lack of standardisation and traceability for tooling sets across gasket cutting, power mechanical and hydraulic presses</li> </ul>	4A	<p>[REDACTED]</p> <p>[REDACTED]</p> <p>[REDACTED]</p>	2M

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	<ul style="list-style-type: none"> <li>Improvised jigs and fixtures on hydraulic cylinder bench nut crackers and manual punch presses without engineering verification</li> <li>Insufficient system for inspection, registration and preventive maintenance of tooling and fixtures</li> <li>Tooling changes performed without consideration of altered guarding requirements or changed load paths</li> </ul>		[REDACTED]	
5. Control of Energy Sources and Isolation Systems	<ul style="list-style-type: none"> <li>Uncontrolled movement or press cycling during maintenance, cleaning, setup or fault clearing due to inadequate isolation systems</li> <li>Stored energy in hydraulic accumulators, press cylinders, counterbalances, springs or flywheels not identified or released before intervention</li> <li>Inadequate lockout/tagout (LOTO) procedures for electrical, pneumatic, hydraulic and mechanical energy</li> <li>Multiple power sources (e.g. air pre with separate electrical and pneumatic feeds) not all isolated when required</li> <li>Reliance on emergency stops as an isolation method rather than positive energy isolation</li> <li>Unclear responsibilities for isolation when contractors or multiple trades work on presses</li> </ul>	4A	[REDACTED]	2M
6. Maintenance, Inspection and Reliability Management	<ul style="list-style-type: none"> <li>Lack of structured preventive maintenance program resulting in failure of critical safety devices (interlocks, light curtains, emergency stops, valves)</li> <li>Hydraulic leaks, hose failures or pressure spikes due to poor maintenance increasing risk of</li> </ul>	4A	[REDACTED]	2M

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	<p>component rupture or uncontrolled press movement</p> <ul style="list-style-type: none"> <li>• Mechanical wear of clutches, brakes, linkages and flywheels on power mechanical presses leading to over-run or failure to stop</li> <li>• Out-of-calibration pressure gauges and tonnage monitors on hydraulic presses leading to overloads</li> <li>• Failure to detect cracks or fatigue in frames, bolster plates, rams, arbour press columns and press-fitting fixtures</li> <li>• Inadequate records of inspections, repairs and part replacements, reducing ability to manage lifecycle and reliability</li> <li>• Reactive repair culture leading to operation with known defects or temporary bypasses of safety systems</li> </ul>		[REDACTED]	
7. Competency, Licensing and Training Systems	<ul style="list-style-type: none"> <li>• Operators and setters of hydraulic and mechanical presses lacking formal competency assessment</li> <li>• Supervisors unaware of their responsibilities for monitoring safe press operation and enforcing procedures</li> <li>• Inadequate training in specific hazards associated with different presses (e.g. air press, kick press, flywheels, nut cutting press, hydraulic cylinder nut cracker, manual punch press)</li> <li>• Insufficient understanding of safe guarding principles, interlock functions and emergency stop limitations</li> <li>• No refresher training or competency reassessment following incidents, equipment upgrades or procedural changes</li> <li>• Reliance on informal buddy training and undocumented on-the-job learning</li> </ul>	4A	[REDACTED]	2M

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8. Safe Systems of Work, Procedures and Permit Controls	<ul style="list-style-type: none"> <li>Absence of documented safe operating procedures (SOPs) and safe systems of work specific to each press type</li> <li>Overly generic procedures that do not distinguish between the hazards of hydraulic presses, mechanical power presses, arbor presses, fly presses, kick presses and manual punch presses</li> <li>Uncontrolled non-routine activities such as clearing jams, setting dies, gasket cutting, trial tooling and first-off runs</li> <li>Lack of permit systems for high-risk tasks (e.g. work inside press envelope, troubleshooting with guards defeated for testing)</li> <li>Inadequate management of change when modifying procedures, production methods or introducing new materials</li> <li>Procedures not accessible or not followed on shift, particularly during overtime, night shift or high production demand</li> </ul>	3H	[REDACTED]	2M
9. Layout, Access, Housekeeping and Traffic Management	<ul style="list-style-type: none"> <li>Poor workshop layout leading to congestion around presses, increasing risk of struck-by or caught-between incidents</li> <li>Inadequate clearance around large hydraulic presses and bench presses, restricting safe access for maintenance and tooling changes</li> <li>Uncontrolled interaction between forklifts, pallet jacks and personnel at loading/unloading areas near presses</li> <li>Trip hazards from hoses, offcuts, scrap, and tooling stored on floors around press workstations</li> <li>Insufficient lighting around press operations preventing clear visibility of controls, indicators and workpieces</li> </ul>	3H	[REDACTED]	2M

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	<ul style="list-style-type: none"> <li>Inadequate storage systems for tooling, gaskets, bearings and bushings leading to manual handling issues and disorganised work areas</li> </ul>		[REDACTED]	
10. Human Factors, Fatigue and Workload Management	<ul style="list-style-type: none"> <li>High production pressure leading to bypassing of guards or shortcuts in changeover and fault-clearing processes</li> <li>Fatigue from repetitive press operations, extended shifts or overtime increasing error likelihood</li> <li>Monotony and repetitive tasks at manual punch presses, arbour presses and small power presses leading to lapses in attention</li> <li>Inadequate staffing or supervision on night shifts for press operations</li> <li>Poorly designed controls, displays and labelling leading to operator confusion incorrect mode selection or inadvertent activation</li> <li>Inadequate consideration of ergonomics factors (reach distance, force requirements, posture) in press station design</li> </ul>	3H	[REDACTED]	2M
11. Emergency Preparedness, Incident Management and First Aid	<ul style="list-style-type: none"> <li>Inadequate emergency response planning for crush injuries, amputations or hydraulic fluid injection injuries associated with presses</li> <li>Lack of accessible and functional emergency stop devices or misunderstanding of their capabilities and limitations</li> <li>Delayed medical response due to poor communication systems or unclear emergency procedures in press areas</li> <li>Insufficient first aid resources and trained first aiders for high-risk press operations</li> <li>Failure to investigate near misses, minor injuries or equipment damage</li> </ul>	4A	[REDACTED]	2M

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	<ul style="list-style-type: none"> <li>events involving presses, leading to missed learning opportunities</li> <li>No systematic process to review and improve press safety systems after serious incidents</li> </ul>		[REDACTED]	
12. Safety Culture, Behaviour and Consultation	<ul style="list-style-type: none"> <li>Normalisation of risk where workers and supervisors accept unsafe behaviours around presses as standard practice</li> <li>Reluctance to report near misses, equipment faults or bypassed guards due to fear of blame or production loss</li> <li>Lack of meaningful worker participation in press safety decisions, leading to impractical procedures and low buy-in</li> <li>Inconsistent enforcement of safety rules for press operations by different supervisors</li> <li>Poor communication of changes to plant, tooling or procedures that affect press safety</li> </ul>	3H	[REDACTED]	2M
13. Contractor and Visitor Management for Press Areas	<ul style="list-style-type: none"> <li>Contract maintenance personnel working on presses without adequate understanding of site-specific hazards and isolation requirements</li> <li>External technicians modifying press control systems or guards without following site management of change processes</li> <li>Visitors, suppliers or auditors entering press areas without awareness of exclusion zones and emergency procedures</li> </ul>	3H	[REDACTED]	2M

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	<ul style="list-style-type: none"> <li>Inconsistent supervision of contractors performing high-risk tasks on hydraulic power units, electrical systems or structural components of presses</li> </ul>		[REDACTED]	
14. Environmental Conditions, Substances and Utilities	<ul style="list-style-type: none"> <li>Hydraulic oil leaks from presses creating slip hazards and potential for skin exposure or injection injuries</li> <li>Accumulation of airborne contaminants (oil mist, fumes from gasket cutting or heated press operations) affecting respiratory health</li> <li>Inadequate ventilation, temperature control or humidity management affecting both worker safety and press performance</li> <li>Unstable or inadequate power supply quality leading to unexpected press behaviour or control system faults</li> <li>Compressed air quality or pressure issues affecting reliable operation of air presses and air-operated safety devices</li> </ul>	3H	[REDACTED]	2M

**EMERGENCY RESPONSE – CALL 000 FOR EMERGENCIES**

Ensure to have an Emergency Management Plan in place as well as adequate numbers of trained first aid staff with easy access to fully stocked first aid kits, rescue equipment, material safety data sheets, adequate access to emergency communication equipment and fire-fighting equipment suitable for all classes of fire and ignition sources.

**LEGISLATIVE REFERENCES**

RELEVANT LEGISLATION AND CODES OF PRACTICE. DELETE THE LEGISLATIVE REFERENCES FOR ANY STATE THAT ARE NOT APPLICABLE

**Queensland & Australian Capital Territory**

Work Health and Safety Act 2011  
 Work Health and Safety Regulations 2011  
 Legislation QLD: <https://www.worksafe.qld.gov.au/laws-and-compliance/work-health-and-safety-laws>  
 Codes of Practice QLD: <https://www.worksafe.qld.gov.au/laws-and-compliance/codes-of-practice>  
 Legislation ACT: <https://www.worksafe.act.gov.au/laws-and-compliance/acts-and-regulations>  
 Codes of Practice ACT: <https://www.worksafe.act.gov.au/laws-and-compliance/codes-of-practice>

**Victoria**

Occupational Health and Safety Act 2004  
 Occupational Health and Safety Regulations 2017  
 Legislation VIC: <https://www.worksafe.vic.gov.au/occupational-health-and-safety-act-and-regulations>  
 Codes of Practice VIC: <https://www.worksafe.vic.gov.au/compliance-codes-and-codes-practice>

**New South Wales**

Work Health and Safety Act 2011  
 Work Health and Safety Regulations 2025  
 Legislation NSW: <https://www.safework.nsw.gov.au/legal-obligations/legislation>  
 Codes of Practice NSW: <https://www.safework.nsw.gov.au/resource-library/list-codes-of-practice>

**Western Australia**

Work Health and Safety Act 2020  
 Work Health and Safety Regulations 2022  
 Legislation Western Australia: <https://www.commerce.wa.gov.au/worksafe/legislation>  
 Codes of Practice WA: <https://www.commerce.wa.gov.au/worksafe/codes-practice>

**Northern Territory**

Work Health and Safety (National Uniform Legislation) Act 2011  
 Work Health and Safety (National Uniform Legislation) Regulation 2011  
 Legislation NT: <https://worksafe.nt.gov.au/laws-and-compliance/workplace-safety-laws>  
 Codes of Practice NT: <https://worksafe.nt.gov.au/laws-and-compliance/codes-of-practice>

**Safe Work Australia Links**

Law and Regulation (All States): <https://www.safeworkaustralia.gov.au/law-and-regulation>  
 Model Codes of Practice: <https://www.safeworkaustralia.gov.au/resources-publications/model-codes-of-practice>

**South Australia**

Work Health and Safety Act 2012 (SA)  
 Work Health and Safety Regulations 2012 (SA)  
 Legislation for SA: <https://www.safework.sa.gov.au/resources/legislation>  
 Codes of Practice for SA: <https://www.safework.sa.gov.au/workplaces/codes-of-practice#COPs>

**Model Codes of Practice**

- Managing noise and preventing hearing loss at work
- Confined spaces
- Labelling of workplace hazardous chemicals
- Managing risks of hazardous chemicals in the workplace
- Welding processes
- First aid in the workplace
- Managing the risk of falls at workplaces
- Hazardous manual tasks
- Managing the risk of falls in housing construction
- Managing electrical risks in the workplace
- Demolition work
- Excavation work
- Work health and safety consultation, cooperation and coordination
- Managing the work environment and facilities
- How to manage work health and safety risks
- Managing risks of plant in the workplace
- Construction work

**Tasmania**

Work Health and Safety Act 2012  
 Work Health and Safety (Transitional and Consequential Provisions) Act 2012  
 Work Health and Safety Regulations 2012  
 Work Health and Safety (Transitional) Regulations 2012  
 Legislation for TAS: <https://worksafe.tas.gov.au/topics/laws-and-compliance/acts-and-regulations>  
 Codes of Practice for TAS: <https://worksafe.tas.gov.au/topics/laws-and-compliance/codes-of-practice>

Details of permits, licenses or access required by regulatory bodies (add or delete as required):

- Permits from local council
- Authorisation to commence work
- Any required documents.