
29 C.F.R. § 1910.215

Abrasive wheel machinery.

(a) *General requirements*—(1) *Machine guarding*. Abrasive wheels shall be used only on machines provided with safety guards as defined in the following paragraphs of this section, except:

- (i) Wheels used for internal work while within the work being ground;
- (ii) Mounted wheels, used in portable operations, 2 inches and smaller in diameter; and
- (iii) Types 16, 17, 18, 18R, and 19 cones, plugs, and threaded hole pot balls where the work offers protection.

(2) *Guard design*. The safety guard shall cover the spindle end, nut, and flange projections. The safety guard shall be mounted so as to maintain proper alignment with the wheel, and the strength of the fastenings shall exceed the strength of the guard, except:

(i) Safety guards on all operations where the work provides a suitable measure of protection to the operator, may be so constructed that the spindle end, nut, and outer flange are exposed; and where the nature of the work is such as to entirely cover the side of the wheel, the side covers of the guard may be omitted; and

(ii) The spindle end, nut, and outer flange may be exposed on machines designed as portable saws.

(3) *Flanges*. Grinding machines shall be equipped with flanges in accordance with paragraph (c) of this section.

(4) *Work rests*. On offhand grinding machines, work rests shall be used to support the work. They shall be of rigid construction and designed to be adjustable to compensate for wheel wear. Work rests shall be kept adjusted closely to the wheel with a maximum opening of one-eighth inch to prevent the work from being jammed between the wheel and the rest, which may cause wheel breakage. The work rest shall be securely clamped after each adjustment. The adjustment shall not be made with the wheel in motion.

(5) *Excluded machinery*. Natural sandstone wheels and metal, wooden, cloth, or paper discs, having a layer of abrasive on the surface are not covered by this section.

(b) *Guarding of abrasive wheel machinery*—(1) *Cup wheels*. Cup wheels (Types 6 and 11) shall be protected by:

(i) Safety guards as specified in paragraphs (b) (1) through (10) of this section;

(ii) Band type guards as specified in paragraph (b)(11) of this section; and

(iii) Special “Revolving Cup Guards” which mount behind the wheel and turn with it. They shall be made of steel or other material with adequate strength and shall enclose the wheel sides upward from the back for one-third of the wheel thickness. The mounting features shall conform with all requirements of this section. It is necessary to maintain clearance between the wheel side and the guard. This clearance shall not exceed one-sixteenth inch.

(2) *Guard exposure angles.* The maximum exposure angles specified in paragraphs (b) (3) through (8) of this section shall not be exceeded. Visors or other accessory equipment shall not be included as a part of the guard when measuring the guard opening, unless such equipment has strength equal to that of the guard.

(3) *Bench and floor stands.* The angular exposure of the grinding wheel periphery and sides for safety guards used on machines known as bench and floor stands should not exceed 90° or one-fourth of the periphery. This exposure shall begin at a point not more than 65° above the horizontal plane of the wheel spindle. (See Figures O-6 and O-7 and paragraph (b)(9) of this section.)

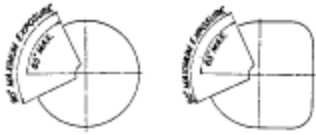


Figure No. O-6 Figure No. O-7

Wherever the nature of the work requires contact with the wheel below the horizontal plane of the spindle, the exposure shall not exceed 125°. (See Figures O-8 and O-9.)



Figure No. O-8 Figure No. O-9

(4) *Cylindrical grinders.* The maximum angular exposure of the grinding wheel periphery and sides for safety guards used on cylindrical grinding machines shall not exceed 180°. This exposure shall begin at a point not more than 65° above the horizontal plane of the wheel spindle. (See Figures O-10 and O-11 and subparagraph (9) of this paragraph.)



Figure No. O-10 Figure No. O-11

(5) *Surface grinders and cutting-off machines.* The maximum angular exposure of the grinding wheel periphery and sides for safety guards used on cutting-off machines and on surface grinding machines which employ the wheel periphery shall not exceed 150°. This exposure shall begin at a point not less than 15° below the horizontal plane of the wheel spindle. (See Figures O-12 and O-13)



Figure No. O-12 Figure No. O-13

(6) *Swing frame grinders.* The maximum angular exposure of the grinding wheel periphery and sides for safety guards used on machines known as swing frame grinding machines shall not exceed 180°, and the top half of the

wheel shall be enclosed at all times. (See Figures O-14 and O-15.)



Figure No. O-14 Figure No. O-15

(7) *Automatic snagging machines.* The maximum angular exposure of the grinding wheel periphery and sides for safety guards used on grinders known as automatic snagging machines shall not exceed 180° and the top half of the wheel shall be enclosed at all times. (See Figures O-14 and O-15.)

This document is only available to subscribers. Please log in or purchase access.

[Purchase Login](#)