



MNOSHA Instruction **STD 1-12.26B**

February 11, 2026

SUBJECT: Abrasive Operations Using Cutoff Wheels and Masonry Saws

Purpose:

This instruction provides guidelines for violations related to guards for cutoff wheels and masonry saws.

Scope:

This instruction applies MNOSHA-wide.

Reference:

1. General Industry Regulations and Standards, [29 CFR 1910.215](#), Abrasive Wheel machinery
2. Construction Industry Regulations and Standards, [29 CFR 1926.303](#), Abrasive Wheels and Tools
3. Construction Industry Regulations and Standards, [29 CFR 1926.702\(i\)](#), Requirements for Equipment and Tools
4. [Federal OSHA STD 01-12-026](#), “Abrasive Operation Using Cutoff Wheels and Masonry Saws”, 09/26/1994
5. [Federal OSHA Standard Interpretation dated 07/22/2010](#), “Hand-held gas-powered cut-off saws”.
6. American National Standards Institute, Inc. (ANSI) Standard ANSI B7.1-1970, Safety Code for the Use, Care and Protection of Abrasive Wheels
7. American National Standards Institute, Inc. (ANSI) Standard ANSI B7.1-a-1973 Supplement to ANSI B7.1-1970, Safety Code for the Use, Care and Protection of Abrasive Wheels
8. American National Standards Institute, Inc. (ANSI) Standard ANSI B7.1-2017, Safety Requirements for the Use, Care and Protection of Abrasive Wheels

Cancellation:

This instruction supersedes MNOSHA Instruction STD1-12.26A, Abrasive Operations Using Cutoff Wheels and Masonry Saws, dated, June 22, 2016.

Background:

Cutoff machines utilizing abrasive wheels are used in general industry and construction. Cutoff machines may be handheld or table-top, as well as part of a larger machining center. Abrasive wheels are covered under [29 CFR 1910.215\(b\)\(5\)](#) and [29 CFR 1926.303\(d\)](#).

The source standard, ANSI B7.1-1970, "Safety Code for the Use, Care and Protection of Abrasive Wheels", allows a maximum angular exposure of 150-degrees on "cutting-off machines". The standard was supplemented in 1973 to permit a maximum angular exposure of 180 degrees on masonry and concrete saws. Later updates to ANSI B7.1 permit a maximum angular exposure of 180 degrees.

Masonry saws used in construction to cut brick, tile and concrete block utilize either an abrasive wheel or a tungsten carbide or diamond blade (water cooled). Such equipment is covered under [29 CFR 1926.702\(i\)](#), which allows an angular exposure of 180-degrees ("a semicircular enclosure over the blade").

Conflicts exist on the maximum allowable angular exposure, but OSHA has no information to support a choice between a maximum angular exposure of 150-degrees and 180-degrees, or to substantiate any direct and immediate relationship of such a choice to safety and health.

ACTION:

- A. If the guard for an abrasive cutoff wheel used for cutting in general industry does not cover at least 150 degrees (regardless of material), CSHO shall propose a citation for [29 CFR 1910.215\(b\)\(5\)](#).
- B. If the guard for an abrasive cutoff wheel is used to cut substances other than masonry materials in construction and does not cover at least 150 degrees, CSHO shall propose a citation for [29 CFR 1926.303\(d\)](#).
- C. If the guard for a masonry saw used in construction to cut masonry materials (such as tile, brick, or concrete block), but not steel, does not cover at least half of the abrasive cutoff wheel 180 degrees), CSHO shall propose a citation for [29 CFR 1926.702\(i\)](#).

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For the MNOSHA Management Team

Distribution: OSHA Compliance and WSC Director

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