



MNOSHA Instruction **STD 1-12.8B**

June 9, 2020

SUBJECT: Abrasive Wheels, Work Rests, Guards, and Tongue Guards

Purpose:

To establish uniform compliance guidelines and standard clarifications for abrasive wheels, work rests, tongue guards, and portable grinders. To clarify guarding of abrasive wheels to include the correct positioning of the work rest and tongue guard.

Scope:

This instruction applies MNOSHA wide.

References:

1. **1910.215**, Abrasive Wheel Machinery
2. **1910.243**, Guarding of Portable Powered Tools
3. **ANSI B7.1-2000**, Safety Requirements for the Use, Care and Protection of Abrasive Wheels

Cancellation:

This instruction cancels STD 1-12.8, Abrasive Wheels, Work Rests, Guards, and Tongue Guards, dated December 16, 2014.

ACTION:

- A. The OSHI must first determine if the equipment is exempted from the guarding requirements. The following is a partial list of abrasive wheels that are exempt from the standards:

1. Wheels used for internal work while within the work being ground;
 2. Mounted wheels used in portable operations, two inches and smaller in diameter;
 3. Types 16, 17, 18, 18R and 19 cones, plugs, and threaded hole pot balls where the work offers protection;
 4. Natural sandstone wheels and metal, wooden, cloth, or paper discs, having a layer of abrasive on the surface;
 5. Spindle end, nut, and outer flange need not be guarded if the work provides a suitable measure of protection to the operator.
 6. 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
- B. If the piece of equipment is not exempt and is in service, then cite for the appropriate hazard, such as but not limited to:

1. Stationary Grinders

- a. Spindle end, nut, and flange projections exposed - 1910.215(a)(2);
- b. Work rest not properly adjusted to within 1/8" of wheel, or missing - 1910.215(a)(4);
- c. Tongue guard not properly adjusted to within 1/4" of wheel, or missing - 1910.215(b)(9);
- d. Exposed shaft - 1910.219(c)(2)(i).

2. Portable Grinders

- a. Spindle end, nut, and flange projections not protected - 1910.243(c)(1)(ii)(a);
- b. Right angle head grinder guard exposure angle exceeds 180 degrees - 1910.243(c)(3).

NOTE: This is not meant to be an all-inclusive list of items that can be cited on grinders, merely a guide to some of the more commonly cited items.

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For the OSHA Management Team

Distribution: OSHA Compliance and WSC Director

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