

PROGRAM DIRECTIVE

Program Directive A-20
Issued January 1, 1979
Revised March 8, 2001

SUBJECT: Abrasive Wheel Machinery - Work Rests

**AFFECTED CODES/
DIRECTIVES:** OAR 437-02-1910.215(a(4), Abrasive Wheel Machinery

PURPOSE: To provide clarification on acceptable methods for use of work rests.

BACKGROUND:

- A. There have been several variance requests and inquiries received concerning the use of work rests on offhand grinding machines. A problem exists when, due to the size, shape, weight, and finishing areas of workpieces, interferences with the work rest or contacts with the wheel below the horizontal plane of the spindle are unavoidable.
- B. The stated purpose of a work rest, properly adjusted to within 1/8 inch of the wheel, is to prevent workpiece from being jammed, thereby causing wheel breakage which could result in injury to the operator. In those instances, where due to the size of the workpiece, jamming is precluded, the enclosure (side guard) itself may provide protection.
- C. The need for stabilizing the workpieces when grinding tools such as bits, chisels, drill bits, etc., is clear.

ACTION: In those instances where jamming or contact with a grinding wheel is precluded by the size of the workpiece, a side guard offers sufficient protection to the operator. Accordingly, in such situations, the failure to have a work rest shall be cited as minimal. It is not the intent of this clarification to minimize the use of work rests, when required, to protect the operator of a wheel grinder from injury.

**EFFECTIVE
DATE:** This program directive is effective December 1, 1979, and shall remain in effect until cancelled or superseded.