

PROGRAM DIRECTIVE

Program Directive A-92
Issued October 1, 1980
Revised March 9, 2001

SUBJECT: Guarding: Mechanical Power Presses

**AFFECTED CODES/
DIRECTIVES:** OAR 437-02-1910.217(d)(3), 1910.217(d)(5), and 1910.217(d)(9)

PURPOSE: Instructions for applying point-of-operation guarding requirements on mechanical power presses during diesetting operations.

BACKGROUND: 1910.217(c)(1)(i) requires protection of employees through the use of point-of-operation guards or devices (as defined in 1910.211(d)(11) and 1910.211(d)(32)) on every operation performed on a mechanical power press. Diesetters working on mechanical power presses are covered by the provisions of these rules.

- A. 1910.217(d) through 1910.217(h)(13) provide specifically for the protection of diesetters. 1910.217 (d)(9)(i) was intended to clarify that the provision of 1910.217(c)(1)(i), (ii) through 1910.217(c)(5)(iii) to diesetters concerning point-of-operation guarding.
- B. Mechanical power presses equipped with part revolution clutches comply with point-of-operation safeguarding for diesetters when an inch mode is installed as specified in 1910.217(b)(7)(iv)(b). Use of the inch mode in accordance with 1910.217(b)(7)(iv)(b) constitutes use of a "device" within the meaning of 1910.211(d)(11).
- C. Full revolution mechanical power presses cannot normally be safeguarded with guards during diesetting operations. However, in instances when guards are not applicable and for presses provided with barring holes in the flywheel, the diesetter is protected if:
 - 1. The power press is de-energized and the flywheel is

brought to rest; and

2. The prime mover power to the power press is locked out; and
 3. The slide is moved by manually turning the crankshaft with the aid of a turnover bar (a lever) inserted through the barring hole in the flywheel.
- D. On some full revolution mechanical power presses, primarily those over 60 tons in size, the slide cannot be moved manually during diesetting. Safeguarding is provided if they are equipped with a jog mode of operation, and
1. the flywheel is brought to rest and the clutch is engaged before the drive motor is jogged, and
 2. the jog control requires two-hand operation, or
 3. the jog control is single control protected against accidental actuation and so located that the worker cannot reach into the point-of-operation while operating the single control.
- E. For full revolution mechanical power presses, safe-guarding of the diesetter, as set forth in paragraphs C. and D., constitutes a "device" in 1910.211(d)(11).
- F. ANSI B11.1.1971, Section 2.51 regarding turnover bars states: Two methods of ensuring the removal of the turnover bar from the barring hole have been found acceptable. They are (1) use of spring action on the end of the bar; and (2) use of storage pockets for the bar, incorporating an interlock switch.

ACTION:

For compliance purposes, OR-OSHA field staff will assure that the requirements of Division 2/O are interpreted in the following manner:

- A. When diesetters are operating a mechanical power press, such as running test and production parts, diesetting or troubleshooting, they shall be protected by point-of-operation guards or devices. Failure to provide such safeguards shall constitute a violation of 1910.217(c)(1)(i).
- B. When diesetters operate a mechanical power press, equipped with a part revolution clutch, in the inch mode where such device is not

installed per 1910.217(b)(7)(iv)(b), a violation exists and a citation shall be issued if no alternative safeguard is provided.

- C. On mechanical power presses equipped with part revolution clutches, turnover bar operations shall comply with 1910.217(b)(7)(xv).

**EFFECTIVE
DATE:**

This directive is effective immediately and will remain in effect until cancelled or superseded.