

**Occupational Safety and Health Admin., Labor****§ 1926.307**

The drain valve on the air receiver shall be opened and the receiver completely drained frequently and at such intervals as to prevent the accumulation of excessive amounts of liquid in the receiver.

(3) *Gages and valves.* (i) Every air receiver shall be equipped with an indicating pressure gage (so located as to be readily visible) and with one or more spring-loaded safety valves. The total relieving capacity of such safety valves shall be such as to prevent pressure in the receiver from exceeding the maximum allowable working pressure of the receiver by more than 10 percent.

(ii) No valve of any type shall be placed between the air receiver and its safety valve or valves.

(iii) Safety appliances, such as safety valves, indicating devices and controlling devices, shall be constructed, located, and installed so that they cannot be readily rendered inoperative by any means, including the elements.

(iv) All safety valves shall be tested frequently and at regular intervals to determine whether they are in good operating condition.

[58 FR 35176, June 30, 1993]

**§ 1926.307 Mechanical power-transmission apparatus.**

(a) *General requirements.* (1) This section covers all types and shapes of power-transmission belts, except the following when operating at two hundred and fifty (250) feet per minute or less: (i) Flat belts 1 inch (2.54 cm) or less in width, (ii) flat belts 2 inches (5.08 cm) or less in width which are free from metal lacings or fasteners, (iii) round belts  $\frac{1}{2}$  inch (1.27 cm) or less in diameter; and (iv) single strand V-belts, the width of which is thirteen thirty-seconds ( $\frac{13}{32}$ ) inch or less.

(2) Vertical and inclined belts (paragraphs (e) (3) and (4) of this section) if not more than  $2\frac{1}{2}$  inches (6.35 cm) wide and running at a speed of less than one thousand (1,000) feet per minute, and if free from metal lacings or fastenings may be guarded with a nip-point belt and pulley guard.

(3) For the Textile Industry, because of the presence of excessive deposits of lint, which constitute a serious fire hazard, the sides and face sections only

of nip-point belt and pulley guards are required, provided the guard shall extend at least 6 inches (15.24 cm) beyond the rim of the pulley on the in-running and off-running sides of the belt and at least 2 inches (5.08 cm) away from the rim and face of the pulley in all other directions.

(4) This section covers the principal features with which power transmission safeguards shall comply.

(b) *Prime-mover guards—(1) Flywheels.* Flywheels located so that any part is 7 feet (2.128 m) or less above floor or platform shall be guarded in accordance with the requirements of this subparagraph:

(i) With an enclosure of sheet, perforated, or expanded metal, or woven wire;

(ii) With guard rails placed not less than 15 inches (38.1 cm) nor more than 20 inches (50.8 cm) from rim. When flywheel extends into pit or is within 12 inches (30.48 cm) of floor, a standard toeboard shall also be provided;

(iii) When the upper rim of flywheel protrudes through a working floor, it shall be entirely enclosed or surrounded by a guardrail and toeboard.

(iv) For flywheels with smooth rims 5 feet (1.52 m) or less in diameter, where the preceding methods cannot be applied, the following may be used: A disk attached to the flywheel in such manner as to cover the spokes of the wheel on the exposed side and present a smooth surface and edge, at the same time providing means for periodic inspection. An open space, not exceeding 4 inches (10.16 cm) in width, may be left between the outside edge of the disk and the rim of the wheel if desired, to facilitate turning the wheel over. Where a disk is used, the keys or other dangerous projections not covered by disk shall be cut off or covered. This subdivision does not apply to flywheels with solid web centers.

(v) Adjustable guard to be used for starting engine or for running adjustment may be provided at the flywheel of gas or oil engines. A slot opening for jack bar will be permitted.

(vi) Wherever flywheels are above working areas, guards shall be installed having sufficient strength to hold the weight of the flywheel in the

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event of a shaft or wheel mounting failure.

(2) *Crank and connecting rods.* Cranks and connecting rods, when exposed to contact, shall be guarded in accordance with paragraphs (m) and (n) of this section, or by a guardrail as described in paragraph (o)(5) of this section.

(3) *Tail rods or extension piston rods.* Tail rods or extension piston rods shall be guarded in accordance with paragraphs (m) and (o) of this section, or by a guardrail on sides and end, with a clearance of not less than 15 (38.1 cm) nor more than 20 inches (50.8 cm) when rod is fully extended.

(c) *Shafting—(1) Installation.* (i) Each continuous line of shafting shall be secured in position against excessive endwise movement.

(ii) Inclined and vertical shafts, particularly inclined idler shafts, shall be securely held in position against endwise thrust.

(2) *Guarding horizontal shafting.* (i) All exposed parts of horizontal shafting 7 feet (2.128 m) or less from floor or working platform, excepting runways used exclusively for oiling, or running adjustments, shall be protected by a stationary casing enclosing shafting completely or by a trough enclosing sides and top or sides and bottom of shafting as location requires.

(ii) Shafting under bench machines shall be enclosed by a stationary casting, or by a trough at sides and top or sides and bottom, as location requires. The sides of the trough shall come within at least 6 inches (15.24 cm) of the underside of table, or if shafting is located near floor within 6 inches (15.24 cm) of floor. In every case the sides of trough shall extend at least 2 inches (5.08 cm) beyond the shafting or protuberance.

(3) *Guarding vertical and inclined shafting.* Vertical and inclined shafting 7 feet (2.128 m) or less from floor or working platform, excepting maintenance runways, shall be enclosed with a stationary casing in accordance with requirements of paragraphs (m) and (o) of this section.

(4) *Projecting shaft ends.* (i) Projecting shaft ends shall present a smooth edge and end and shall not project more than one-half the diameter of the shaft

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unless guarded by nonrotating caps or safety sleeves.

(ii) Unused keyways shall be filled up or covered.

(5) *Power-transmission apparatus located in basements.* All mechanical power transmission apparatus located in basements, towers, and rooms used exclusively for power transmission equipment shall be guarded in accordance with this section, except that the requirements for safeguarding belts, pulleys, and shafting need not be complied with when the following requirements are met:

(i) The basement, tower, or room occupied by transmission equipment is locked against unauthorized entrance.

(ii) The vertical clearance in passageways between the floor and power transmission beams, ceiling, or any other objects, is not less than 5 ft. 6 in. (1.672 m).

(iii) The intensity of illumination conforms to the requirements of ANSI A11.1-1965 (R-1970).

(iv) [Reserved]

(v) The route followed by the oiler is protected in such manner as to prevent accident.

(d) *Pulleys—(1) Guarding.* Pulleys, any parts of which are 7 feet (2.128 m) or less from the floor or working platform, shall be guarded in accordance with the standards specified in paragraphs (m) and (o) of this section. Pulleys serving as balance wheels (e.g., punch presses) on which the point of contact between belt and pulley is more than 6 ft. 6 in. (1.976 m) from the floor or platform may be guarded with a disk covering the spokes.

(2) *Location of pulleys.* (i) Unless the distance to the nearest fixed pulley, clutch, or hanger exceeds the width of the belt used, a guide shall be provided to prevent the belt from leaving the pulley on the side where insufficient clearance exists.

(ii) [Reserved]

(3) *Broken pulleys.* Pulleys with cracks, or pieces broken out of rims, shall not be used.

(4) *Pulley speeds.* Pulleys intended to operate at rim speed in excess of manufacturers' normal recommendations shall be specially designed and carefully balanced for the speed at which they are to operate.

(e) *Belt, rope, and chain drives—(1) Horizontal belts and ropes.* (i) Where both runs of horizontal belts are 7 feet (2.128 m) or less from the floor level, the guard shall extend to at least 15 inches (38.1 cm) above the belt or to a standard height except that where both runs of a horizontal belt are 42 inches (106.68 cm) or less from the floor, the belt shall be fully enclosed.

(ii) In powerplants or power-development rooms, a guardrail may be used in lieu of the guard required by paragraph (e)(1)(i) of this section.

(2) *Overhead horizontal belts.* (i) Overhead horizontal belts, with lower parts 7 feet (2.128 m) or less from the floor or platform, shall be guarded on sides and bottom in accordance with paragraph (o)(3) of this section.

(ii) Horizontal overhead belts more than 7 feet (2.128 m) above floor or platform shall be guarded for their entire length under the following conditions:

(a) If located over passageways or work places and traveling 1,800 feet or more per minute.

(b) If center to center distance between pulleys is 10 feet (3.04 m) or more.

(c) If belt is 8 inches (20.32 cm) or more in width.

(iii) Where the upper and lower runs of horizontal belts are so located that passage of persons between them would be possible, the passage shall be either:

(a) Completely barred by a guardrail or other barrier in accordance with paragraphs (m) and (o) of this section; or

(b) Where passage is regarded as necessary, there shall be a platform over the lower run guarded on either side by a railing completely filled in with wire mesh or other filler, or by a solid barrier. The upper run shall be so guarded as to prevent contact therewith either by the worker or by objects carried by him. In powerplants only the lower run of the belt need be guarded.

(iv) Overhead chain and link belt drives are governed by the same rules as overhead horizontal belts and shall be guarded in the same manner as belts.

(3) *Vertical and inclined belts.* (i) Vertical and inclined belts shall be enclosed by a guard conforming to stand-

ards in paragraphs (m) and (o) of this section.

(ii) All guards for inclined belts shall be arranged in such a manner that a minimum clearance of 7 feet (2.128 m) is maintained between belt and floor at any point outside of guard.

(4) *Vertical belts.* Vertical belts running over a lower pulley more than 7 feet (2.128 m) above floor or platform shall be guarded at the bottom in the same manner as horizontal overhead belts, if conditions are as stated in paragraphs (e)(2)(ii) (a) and (c) of this section.

(5) *Cone-pulley belts.* (i) The cone belt and pulley shall be equipped with a belt shifter so constructed as to adequately guard the nip point of the belt and pulley. If the frame of the belt shifter does not adequately guard the nip point of the belt and pulley, the nip point shall be further protected by means of a vertical guard placed in front of the pulley and extending at least to the top of the largest step of the cone.

(ii) If the belt is of the endless type or laced with rawhide laces, and a belt shifter is not desired, the belt will be considered guarded if the nip point of the belt and pulley is protected by a nip point guard located in front of the cone extending at least to the top of the largest step of the cone, and formed to show the contour of the cone in order to give the nip point of the belt and pulley the maximum protection.

(iii) If the cone is located less than 3 feet (0.912 m) from the floor or working platform, the cone pulley and belt shall be guarded to a height of 3 feet (0.912 m) regardless of whether the belt is endless or laced with rawhide.

(6) *Belt tighteners.* (i) Suspended counterbalanced tighteners and all parts thereof shall be of substantial construction and securely fastened; the bearings shall be securely capped. Means must be provided to prevent tightener from falling, in case the belt breaks.

(ii) Where suspended counterweights are used and not guarded by location, they shall be so encased as to prevent accident.

(f) *Gears, sprockets, and chains—(1) Gears.* Gears shall be guarded in accordance with one of the following methods:

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- (i) By a complete enclosure; or
- (ii) By a standard guard as described in paragraph (o) of this section, at least 7 feet (2.128 m) high extending 6 inches (15.24 cm) above the mesh point of the gears; or
- (iii) By a band guard covering the face of gear and having flanges extended inward beyond the root of the teeth on the exposed side or sides. Where any portion of the train of gears guarded by a band guard is less than 6 feet (1.824 m) from the floor a disk guard or a complete enclosure to the height of 6 feet (1.824 m) shall be required.

(2) *Hand-operated gears.* Paragraph (f)(1) of this section does not apply to hand-operated gears used only to adjust machine parts and which do not continue to move after hand power is removed. However, the guarding of these gears is highly recommended.

(3) *Sprockets and chains.* All sprocket wheels and chains shall be enclosed unless they are more than 7 feet (2.128 m) above the floor or platform. Where the drive extends over other machine or working areas, protection against falling shall be provided. This subparagraph does not apply to manually operated sprockets.

(4) *Openings for oiling.* When frequent oiling must be done, openings with hinged or sliding self-closing covers shall be provided. All points not readily accessible shall have oil feed tubes if lubricant is to be added while machinery is in motion.

(g) *Guarding friction drives.* The driving point of all friction drives when exposed to contact shall be guarded, all arm or spoke friction drives and all web friction drives with holes in the web shall be entirely enclosed, and all projecting belts on friction drives where exposed to contact shall be guarded.

(h) *Keys, setscrews, and other projections.* (1) All projecting keys, setscrews, and other projections in revolving parts shall be removed or made flush or guarded by metal cover. This subparagraph does not apply to keys or setscrews within gear or sprocket casings or other enclosures, nor to keys, setscrews, or oilcups in hubs of pulleys less than 20 inches (50.8 cm) in diameter

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where they are within the plane of the rim of the pulley.

(2) It is recommended, however, that no projecting setscrews or oilcups be used in any revolving pulley or part of machinery.

(i) *Collars and couplings*—(1) *Collars.* All revolving collars, including split collars, shall be cylindrical, and screws or bolts used in collars shall not project beyond the largest periphery of the collar.

(2) *Couplings.* Shaft couplings shall be so constructed as to present no hazard from bolts, nuts, setscrews, or revolving surfaces. Bolts, nuts, and setscrews will, however, be permitted where they are covered with safety sleeves or where they are used parallel with the shafting and are countersunk or else do not extend beyond the flange of the coupling.

(j) *Bearings and facilities for oiling.* All drip cups and pans shall be securely fastened.

(k) *Guarding of clutches, cutoff couplings, and clutch pulleys*—(1) *Guards.* Clutches, cutoff couplings, or clutch pulleys having projecting parts, where such clutches are located 7 feet (2.128 m) or less above the floor or working platform, shall be enclosed by a stationary guard constructed in accordance with this section. A "U" type guard is permissible.

(2) *Engine rooms.* In engine rooms a guardrail, preferably with toeboard, may be used instead of the guard required by paragraph (k)(1) of this section, provided such a room is occupied only by engine room attendants.

(l) *Belt shifters, clutches, shippers, poles, perches, and fasteners*—(1) *Belt shifters.* (i) Tight and loose pulleys on all new installations made on or after August 31, 1971, shall be equipped with a permanent belt shifter provided with mechanical means to prevent belt from creeping from loose to tight pulley. It is recommended that old installations be changed to conform to this rule.

(ii) Belt shifter and clutch handles shall be rounded and be located as far as possible from danger of accidental contact, but within easy reach of the operator. Where belt shifters are not directly located over a machine or bench, the handles shall be cut off 6 ft. 6 in. (1.976 m) above floor level.

(2) *Belt shippers and shipper poles.* The use of belt poles as substitutes for mechanical shifters is not recommended.

(3) *Belt perches.* Where loose pulleys or idlers are not practicable, belt perches in form of brackets, rollers, etc., shall be used to keep idle belts away from the shafts.

(4) *Belt fasteners.* Belts which of necessity must be shifted by hand and belts within 7 feet (2.128 m) of the floor or working platform which are not guarded in accordance with this section shall not be fastened with metal in any case, nor with any other fastening which by construction or wear will constitute an accident hazard.

(m) *Standard guards—general requirements—(1) Materials.* (i) Standard conditions shall be secured by the use of the following materials. Expanded metal, perforated or solid sheet metal, wire mesh on a frame of angle iron, or iron pipe securely fastened to floor or to frame of machine.

(ii) All metal should be free from burrs and sharp edges.

(2) *Methods of manufacture.* (i) Expanded metal, sheet or perforated metal, and wire mesh shall be securely fastened to frame.

(n) [Reserved]

(o) *Approved materials—(1) Minimum requirements.* The materials and dimensions specified in this paragraph shall apply to all guards, except horizontal overhead belts, rope, cable, or chain guards more than 7 feet (2.128 m) above floor, or platform.

(i) [Reserved]

(a) All guards shall be rigidly braced every 3 feet (0.912 m) or fractional part of their height to some fixed part of machinery or building structure. Where guard is exposed to contact with moving equipment additional strength may be necessary.

(2) *Wood guards.* (i) Wood guards may be used in the woodworking and chemical industries, in industries where the presence of fumes or where manufacturing conditions would cause the rapid deterioration of metal guards; also in construction work and in locations outdoors where extreme cold or extreme heat make metal guards and railings undesirable. In all other industries, wood guards shall not be used.

(3) *Guards for horizontal overhead belts.* (i) Guards for horizontal overhead belts shall run the entire length of the belt and follow the line of the pulley to the ceiling or be carried to the nearest wall, thus enclosing the belt effectively. Where belts are so located as to make it impracticable to carry the guard to wall or ceiling, construction of guard shall be such as to enclose completely the top and bottom runs of belt and the face of pulleys.

(ii) [Reserved]

(iii) Suitable reinforcement shall be provided for the ceiling rafters or overhead floor beams, where such is necessary, to sustain safely the weight and stress likely to be imposed by the guard. The interior surface of all guards, by which is meant the surface of the guard with which a belt will come in contact, shall be smooth and free from all projections of any character, except where construction demands it; protruding shallow round-head rivets may be used. Overhead belt guards shall be at least one-quarter wider than belt which they protect, except that this clearance need not in any case exceed 6 inches (15.24 cm) on each side. Overhead rope drive and block and roller-chain-drive guards shall be not less than 6 inches (15.24 cm) wider than the drive on each side. In overhead silent chain-drive guards where the chain is held from lateral displacement on the sprockets, the side clearances required on drives of 20 inch (50.8 cm) centers or under shall be not less than  $\frac{1}{4}$  inch (0.635 cm) from the nearest moving chain part, and on drives of over 20 inch (50.8 cm) centers a minimum of  $\frac{1}{2}$  inch (1.27 cm) from the nearest moving chain part.

(4) *Guards for horizontal overhead rope and chain drives.* Overhead-rope and chain-drive guard construction shall conform to the rules for overhead-belt guard.

(5) *Guardrails and toeboards.* (i) Guardrail shall be 42 inches (106.68 cm) in height, with midrail between top rail and floor.

(ii) Posts shall be not more than 8 feet (2.432 m) apart; they are to be permanent and substantial, smooth, and free from protruding nails, bolts, and splinters. If made of pipe, the post shall be  $1\frac{1}{4}$  inches (3.175 cm) inside diameter,

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or larger. If made of metal shapes or bars, their section shall be equal in strength to that of 1½ (3.81 cm) by 1½ (3.81 cm) by  $\frac{3}{16}$  inch angle iron. If made of wood, the posts shall be two by four (2 × 4) inches or larger. The upper rail shall be two by four (2 × 4) inches, or two one by four (1 × 4) strips, one at the top and one at the side of posts. The midrail may be one by four (1 × 4) inches or more. Where panels are fitted with expanded metal or wire mesh the middle rails may be omitted. Where guard is exposed to contact with moving equipment, additional strength may be necessary.

(iii) Toeboards shall be 4 inches (10.16 cm) or more in height, of wood, metal, or of metal grill not exceeding 1 inch (2.54 cm) mesh.

(p) *Care of equipment*—(1) *General*. All power-transmission equipment shall be inspected at intervals not exceeding 60 days and be kept in good working condition at all times.

(2) *Shafting*. (i) Shafting shall be kept in alignment, free from rust and excess oil or grease.

(ii) Where explosives, explosive dusts, flammable vapors or flammable liquids exist, the hazard of static sparks from shafting shall be carefully considered.

(3) *Bearings*. Bearings shall be kept in alignment and properly adjusted.

(4) *Hangers*. Hangers shall be inspected to make certain that all supporting bolts and screws are tight and that supports of hanger boxes are adjusted properly.

(5) *Pulleys*. (i) Pulleys shall be kept in proper alignment to prevent belts from running off.

(6) *Care of belts*.

(i) [Reserved]

(ii) Inspection shall be made of belts, lacings, and fasteners and such equipment kept in good repair.

(7) *Lubrication*. The regular oilers shall wear tight-fitting clothing. Machinery shall be oiled when not in motion, wherever possible.

[58 FR 35176, June 30, 1993, as amended at 69 FR 31882, June 8, 2004]

## Subpart J—Welding and Cutting

AUTHORITY: Sec. 107, Contract Work Hours and Safety Standards Act (Construction Safety Act) (40 U.S.C. 333); secs. 4, 6, 8, Occupa-

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tional Safety and Health Act of 1970 (29 U.S.C. 653, 655, 657); Secretary of Labor's Order No. 12-71 (36 FR 8754), 8-76 (41 FR 25059), or 9-83 (48 FR 35736), as applicable.

### § 1926.350 Gas welding and cutting.

(a) *Transporting, moving, and storing compressed gas cylinders*. (1) Valve protection caps shall be in place and secured.

(2) When cylinders are hoisted, they shall be secured on a cradle, slingboard, or pallet. They shall not be hoisted or transported by means of magnets or choker slings.

(3) Cylinders shall be moved by tilting and rolling them on their bottom edges. They shall not be intentionally dropped, struck, or permitted to strike each other violently.

(4) When cylinders are transported by powered vehicles, they shall be secured in a vertical position.

(5) Valve protection caps shall not be used for lifting cylinders from one vertical position to another. Bars shall not be used under valves or valve protection caps to pry cylinders loose when frozen. Warm, not boiling, water shall be used to thaw cylinders loose.

(6) Unless cylinders are firmly secured on a special carrier intended for this purpose, regulators shall be removed and valve protection caps put in place before cylinders are moved.

(7) A suitable cylinder truck, chain, or other steadyng device shall be used to keep cylinders from being knocked over while in use.

(8) When work is finished, when cylinders are empty, or when cylinders are moved at any time, the cylinder valve shall be closed.

(9) Compressed gas cylinders shall be secured in an upright position at all times except, if necessary, for short periods of time while cylinders are actually being hoisted or carried.

(10) Oxygen cylinders in storage shall be separated from fuel-gas cylinders or combustible materials (especially oil or grease), a minimum distance of 20 feet (6.1 m) or by a noncombustible barrier at least 5 feet (1.5 m) high having a fire-resistance rating of at least one-half hour.

(11) Inside of buildings, cylinders shall be stored in a well-protected, well-ventilated, dry location, at least 20 feet (6.1 m) from highly combustible