

**OREGON OCCUPATIONAL SAFETY AND HEALTH DIVISION
DEPARTMENT OF CONSUMER AND BUSINESS SERVICES**

PROGRAM DIRECTIVE

Program Directive **A-120**
Issued June 30, 1981
Revised March 9, 2001

SUBJECT: Guarding: Portable Abrasive Grinders When Used for Internal Grinding

AFFECTED CODES

DIRECTIVES: OAR 437-02-1910.215(a)(1), 437-02-242(7)(a), Abrasive Wheel Machinery; OAR 437-05-1915.134(d), Ship Repair and Building; 437-004-2230(3)(a), Agriculture; and OAR 437-03-1926.303(b)(4), Construction

PURPOSE: To clarify the intent of the affected rules.

BACKGROUND: With some exceptions, all portable grinders require guards to protect the operator in the event the abrasive wheel breaks. One of these exceptions is for internal grinding. The term "internal grinding" is defined as "the precision grinding of the inside surface of the hole in a work piece." This does not include snagging or off hand grinding operations such as grinding the welds inside a box or frame or the concave areas of auto bodies. Disc type abrasive wheels are rarely used for internal grinding. Since internal grinding increases the risk of the wheel breaking due to the increased stresses imposed on the wheel because of a larger surface contact with the work piece, it is even more important that the operator be protected.

ACTION: For internal grinding only, portable right angle head grinders may be used without a guard if the nature of the work is such that it is impossible or impractical to use it with a guard and the grinding wheel is entirely within the work being ground to the extent that the operator has protection equal to that provided by a correctly installed guard. Safety flanges shall be provided in accordance with the applicable standards.

EFFECTIVE

DATE: This directive is effective immediately and will remain in effect until cancelled or superseded.