

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

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**PROGRAM DIRECTIVE**

Program Directive: A-236

Issued: April 4, 2000

**SUBJECT:** Guarding: Metal Lathe Chucks (Engine Lathes)

**AFFECTED STANDARDS/**

**DIRECTIVES:** 1910.212(a)(1), ANSI B11.6

**PURPOSE:** To establish criteria for determining when guarding should be required for metal lathe chucks.

**BACKGROUND:** Differing opinions exist over what kind of chuck guard, if any should be required to protect operators from inadvertent contact with rotating chucks or work holding attachments.

**ACTION:** The following issues should be considered when evaluating the need for chuck guarding to protect operators from rotating chuck components. When exposure exists, some form of chuck guarding should be considered.

Loose clothing of any kind that could be caught in rotating parts should not be worn. Jewelry such as rings, watches, and necklaces should not be worn.

1. Does the rotating chuck have a smooth surface or does it have protruding chuck jaws that could snag or hit the operator? Usually exposure will vary with the diameter of material held in the chuck.
2. Does the work-holding device have arms or extensions that could be guarded and still have the work accessible to the tooling and the operators view?
3. How close to the chuck is the work being performed on the piece being turned?
4. If the work is a distance from the chuck what hazard is the chuck presenting to the operator or others?
5. How focused, skilled and trained are the lathe operators?
6. Is the work environment distracting by people or surrounding activities?
7. Guards must not create additional hazards by design or condition. Guards may be built in house or purchased from outside suppliers.

**EFFECTIVE DATE:** This directive is effective immediately and will remain in effect until canceled or superseded.

**History:** Issued 4-4-2000