

**SUBJECT:** Abrasive Operations Using Cutoff Wheels and Masonry Saws

**Purpose:** This instruction provides guidelines for violations related to guards for cutoff wheels and masonry saws.

**Scope:** This instruction applies MNOSHA-wide.

**Reference:** 29 CFR 1910.215, 29 CFR 1926.303, 29 CFR 1926.702(i).

**Cancellation:** This instruction supersedes MNOSHA Instruction STD1-12.26A, Abrasive Operations Using Cutoff Wheels and Masonry Saws, dated May 15, 2006.

**Background:** Cutoff machines utilizing abrasive wheels are used in general industry and construction. Abrasive wheels are covered under 29 CFR 1910.215(b)(5) and 1926.303(d). The source standard, ANSI B7.1-1970, "Safety Code for the Use, Care and Protection of Abrasive Wheels", allows a maximum angular exposure of 150-degrees on such equipment. Later updates to ANSI B7.1 in 1978 and 1988 and 2000 permit a maximum angular exposure of 180 degrees.

Masonry saws used in construction to cut brick, tile and concrete block utilize either an abrasive wheel or a tungsten carbide or diamond blade (water cooled). Such equipment is covered under 1926.702(i), which allows an angular exposure of 180-degrees ("a semicircular enclosure over the blade").

Conflicts exist on the maximum allowable angular exposure, but OSHA has no information to support a choice between 150° and 180° maximum angular exposure, or to substantiate any direct and immediate relationship of such a choice to safety and health.

**ACTION:**

- A. When the guard for an abrasive cutoff wheel (not used for masonry) does not comply with the 150-degree maximum angular exposure required at 29 CFR 1910.215(b)(5) or 29 CFR 1926.303(d), but does not allow greater than 180-degree maximum angular exposure, no citation should be proposed.
- B. When the guard for a masonry saw used in construction (i.e., used to cut tile, brick, concrete block, but not steel) or a tungsten or diamond blade (water cooled) is semicircular, it is in compliance as set forth in 1926.702(i).

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**Distribution:** OSHA Compliance and WSC Director

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