

# **Augers/Conveyors**

# Requirements for Augers

# Access to Moving Parts

- Guards, shields, and access doors shall be in place when the equipment is in operation.
- Where removal of a guard or access door will expose an employee to any component which continues to rotate after the power is disengaged, the employer shall provide, in the immediate area, the following:
  - A readily visible or audible warning of rotation; and
  - A safety sign warning the employee to:
    - Look and listen for evidence of rotation; and
    - Not remove the guard or access door until all components have stopped.

# Requirements for Conveyors

- Employees may not ride a conveyor belt at any time.
- Employees may not cross over the conveyor belt, except at walkways, unless the conveyor's energy source has been deenergized and has been locked out or tagged out.
- A conveyor that could cause injury when started may not be started until personnel in the area are alerted by a signal or by a designated person that the conveyor is about to start.

# Warning Devices

- Conveyor systems shall be equipped with an audible warning signal to be sounded immediately before starting up the conveyor.
- If the operator's station is at a remote point, similar provisions for stopping the motor or engine shall be provided at the motor or engine location.

# Warning Devices

- If a conveyor that could cause injury when started is automatically controlled or is controlled from a remote location, an audible device shall be provided that sounds an alarm that will be recognized by each employee as a warning that the conveyor will start and that can be clearly heard at all points along the conveyor where personnel may be present.

# Warning Devices

- The warning device shall be actuated by the device starting the conveyor and shall continue for a period of time before the conveyor starts that is long enough to allow employees to move clear of the conveyor system.

# Emergency Stop Devices

- Remotely and automatically controlled conveyors, and conveyors that have operating stations which are not manned or which are beyond voice and visual contact from drive areas, loading areas, transfer points, and other locations on the conveyor path not guarded by location, position, or guards shall be furnished with emergency stop buttons, pull cords, limit switches, or similar emergency stop devices **unless the employer can demonstrate that the design, function, and operation of the conveyor does not expose an employee to hazards.**



# Emergency Stop Devices

- Emergency stop devices shall be easily identifiable in the immediate vicinity of such locations.
- An emergency stop device shall act directly on the control of the conveyor involved and may not depend on the stopping of any other equipment.
- Emergency stop devices shall be installed so that they cannot be overridden from other locations.

# Emergency Stop Devices

- Means for stopping the motor or engine shall be provided at the operator's station.
- Emergency stop switches shall be arranged so that the conveyor cannot be started again until the actuating stop switch has been reset to running or "on" position.

# Employee Contact with Conveyors

- Screw conveyors shall be guarded to prevent employee contact with turning flights.
- Where a conveyor passes over work areas, aisles, or thoroughfares, suitable guards shall be provided to protect employees required to work below the conveyors.
- All crossovers, aisles, and passageways shall be conspicuously marked by suitable signs.

# Employee Contact with Conveyors

- Conveyors shall be locked out or otherwise rendered inoperable, and tagged out with a "Do Not Operate" tag during repairs and when operation is hazardous to employees performing maintenance work.
- All conveyors in use shall meet the applicable requirements for design, construction, inspection, testing, maintenance, and operation, as prescribed in the ANSI B20.1-1957, Safety Code for Conveyors, Cableways, and Related Equipment.

# Employee Contact with Conveyors

- Wherever a conveyor passes over a main aisleway, regularly occupied work area, or passageway, the underside of the conveyor shall be completely enclosed to prevent broken chains or other material from falling in the passageway.
- Stop bumpers shall be installed on all delivery ends of conveyors, wherever manual removal of the product carried is practiced.
- Where hazard of getting caught exists, a sufficient number of stop buttons shall be provided to enable quick stopping of the conveyor.

# Summary

- Removing shields from machinery and not replacing them is an extremely common cause of injury.
- When shields are in place and undamaged, there is much less opportunity to become entangled with moving parts.

# Summary

- This facility has a number of these conveyors and augers.
- Not all of these augers or conveyors have walkways to cross over the top.
- Most of these of them have lids that are attached by bolts, clamps, or other means.
- Never attempt to walk on top of a lid or any type of cover unless using a walkway.

# Summary

- Report any defects to supervisor immediately or repair it yourself if it is something that needs repair immediately.
- Defects such as loose lids, missing bolts, missing clamps or any other noticeable defect could endanger you or any co-workers.



**Questions?**