

**WAC 296-155-77120 Conveyors.** (1) All conveyors in use must meet the applicable requirements for design, construction, inspection, testing, maintenance, and operation, as prescribed in ANSI B20.1-1976, Safety Code for Conveyors, Cableways, and Related Equipment.

(2) **Starting precautions.**

(a) When the entire length of a conveyor is visible from the starting switch, the operator must visually check to make certain that all persons are in the clear before starting the conveyor.

(b) When the entire length of the conveyor is not visible from the starting switch, you must install and operate a positive audible or visible warning system to warn persons that the conveyor will be started.

(c) You must take all reasonable precautions by the operator prior to starting a conveyor, to assure that no person is in a hazardous location where they may be injured when the conveyor is started.

(3) **Riding and walking on conveyors.**

(a) Riding on conveyor chains, belt, or bucket elevators must be prohibited.

(b) You must not allow people to walk on conveyors except for emergency purposes and then only after the conveyor has been deenergized and the person can do so safely.

(c) You must only permit riding conveyors on the manlift steps and platforms with handholds attached and other safety factors as specified in chapter 296-96 WAC, Safety regulations and fees for all elevators, dumbwaiters, escalators, and other conveyances.

(4) **Stop controls.**

(a) Means for stopping the motor or engine of a conveyor must be provided at the operator's station.

(b) If the operator's station is at a remote point, similar provisions for stopping the motor or engine must be provided at the motor or engine location.

(5) **Emergency controls.** Emergency stop switches must be arranged so that the conveyor cannot be started again until the actuating stop switch has been reset to running or "on" position.

(6) **Screw type conveyors.** You must guard screw or auger type conveyors to prevent employee contact with turning flights.

(7) **Overhead conveyors.**

(a) Where a conveyor passes over work areas, aisles, or thoroughfares, you must provide guards to protect persons required to work below the conveyors.

(b) Where a conveyor crosses over an aisle or passageway, you must conspicuously mark it by suitable signs, as required by Part E of this chapter.

(c) When the return strand of a conveyor operates within 7 feet of the floor you must provide a trough of sufficient strength to carry the weight resulting from a broken chain. If the strands are over a passageway, you must provide a means to catch and support the ends of the chain in the event of a break.

(8) **Emergency stop.**

(a) Conveyors must be provided with an emergency stopping device (panic-type) which can be reached from the conveyor.

(b) The emergency stopping device must be located near the material entrance and must stop the conveyor a sufficient distance away from the hazard to prevent injury.

(c) Where the conveyor leading into such equipment is under constant control of an operator who has full view of the material en-

trance who is located or restrained where they cannot possibly fall onto the conveyor an emergency stopping device is not mandatory.

(9) **Conveyor lockout.**

(a) You must lock out conveyors with a padlock at any time repair, maintenance, or clean-up work is being performed.

(b) Tags or push-button stops are not acceptable.

(10) Where conveyors are in excess of 7 feet in height, you must provide means to safely permit essential inspection and maintenance operations.

(11) **Conveyor repair.**

(a) You must carefully inspect any part showing signs of significant wear and replace it prior to reaching a condition where it may create a hazard.

(b) Replacement parts must be equal to or exceed the manufacturer's specifications.

[Statutory Authority: RCW 49.17.010, 49.17.040, 49.17.050, 49.17.060. WSR 16-09-085, § 296-155-77120, filed 4/19/16, effective 5/20/16. Statutory Authority: RCW 49.17.010, 49.17.040, 49.17.050, 49.17.440, 49.17.060, and 29 C.F.R. 1926, Subpart CC. WSR 12-01-086, § 296-155-77120, filed 12/20/11, effective 2/1/12.]