

SAFE WORK PRACTICES

METAL SAWS – HOT CUTOFF/CHOP SAWS *Page 1 of 2*

**This information does not take precedence over OH&S. All employees should be familiar with the Saskatchewan Employment Act and the OH&S Regulations.*

General: Make sure you understand operating instructions and are properly trained before operating a hot metal saw. Hot metal saws, often referred to as cut-off saws or chop saws, use an abrasive cut-off wheel. The making may be dry or wet, low or high speed, and either hand operated or automatic.

1. Wear safety glasses and hearing protections.
2. Handle and store wheels as directed by the manufacturer.
3. Inspect all wheels for possible damage before mounting. Check the machine speed against the established, maximum safe operating speed marked on the wheel.
4. Ensure that mounting flanges are equal and the correct diameter (at least ¼ of the wheel diameter).
5. Use mounting blotters when they are supplied with wheels.
6. Clamp work firmly in place when using non-reinforced cut-off wheels.
7. Use properly designed safety guard covering at least one half of the grinding wheel.
8. Ensure that saw has a ***start/stop*** button within easy reach.
9. Allow mounted wheels to run at operating speed, with guards in place, for one minute before cutting.
10. Bring wheel into contact with the work without bumping on impact.
11. Turn off coolant before stopping the wheel to avoid an out-of-balance condition.
12. Keep working surface clean of scraps, tools and materials. Keep floor around saw clean and free of oil and grease.

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- **DON'T** use a cracked wheel or one that has been dropped or damaged.
- **DON'T** force a wheel into the machine or alter the size of the mounting hole; if the wheel does not fit the machine, get one that will.
- **DON'T** exceed the maximum operating speed marked on the wheel.
- **DON'T** use mounting flanges whose bearing surfaces are not equal, clean, flat and free of burrs.
- **DON'T** tighten the mounting nut excessively.
- **DON'T** grind on the side of the wheel.
- **DON'T** start the machine until the wheel guard is in place.
- **DON'T** stand directly in front of the cutoff wheel.
- **DON'T** jam, bend or pinch the wheel.
- **DON'T** force cutting so that the motor slows.
- **DON'T** cut without proper ventilation.

