

## **4123:1-7-11 Molds and cores.**

### **(A) Molds.**

- (1) No employee shall be required to work under molds suspended from cranes.
- (2) All molding machines shall be equipped with two-hand controls or equivalent protective devices for each employee assigned to the machine.
- (3) Automatic molding machines which go through a complete cycle without an operator shall be guarded.
- (4) Where the clearance between the mold conveyor and any fixed or portable object is less than eighteen inches, the space or clearance shall be blocked to prevent passage.
- (5) When a molding machine is to be repaired, all energy sources shall be shut off, locked out, and any pressure bled from the machine.

### **(B) Cores.**

- (1) The surfaces of all core boxes used in bench work shall be smooth and free from splinters or sharp edges.
- (2) Automatic or semi-automatic core blowing machines shall be guarded.
- (3) When a core machine is to be repaired, all energy sources shall be
- (4) Walk-in ovens shall be provided with a means of escape from the inside, such as emergency exit doors, kickout panel or plate, duplicate opening mechanism, etc.
- (5) In batch ovens, sufficient space shall be provided to allow unobstructed access for employees or machine loading.
- (6) Batch ovens having vertically sliding doors shall be provided with devices which keep the door in the raised position.

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