



Ohio Administrative Code Rule 4123:1-9-05 Rolling operations.

Effective: January 1, 2025

(A) Subways or crossovers.

Subways with overhead protection or crossovers shall be provided at established passageways which cross the rolling line.

(B) Coupling boxes, spindles, and wobblers.

Coupling boxes, spindles, and wobblers seven feet (2.1 meters) or less above floor level shall be guarded.

(C) Access to top of housing.

Steps or equivalent means shall be provided for reaching the top of housing(s) four feet (1.2 meters) or more above floor level.

(D) Rolling tables.

Stop guards shall be placed at the dead end of all rolling tables.

(E) Bosh tank.

The top of the bosh tank shall be guarded unless it is at least forty-two inches (1.1 meters) above floor level.

(F) Stop guards.

Adjustable stop guards shall be installed at the outside of hot beds and skids.



(G) Looping posts.

Looping posts shall be used on small non-automatic repeater type mills where bars are being rolled in more than one pass in a continuous operation.

(H) Tubular products.

(1) Openings in welding and heating furnaces.

Charging and discharging openings in heating furnaces shall be provided with shields.

(2) Signal system.

A signal system shall be provided between the charging and discharging openings of all heating furnaces.

(3) Barring to prevent passage.

Space between ends of troughs, conveyors, or tables and roll stands shall be barred to prevent passage of employees.

(4) Butt weld mills.

Movable draw benches and chains on butt weld mills shall be guarded.

(5) Cross roll troughs.

Stops or guards shall be provided at the delivery end of cross roll troughs.

(I) Wire mills.

(1) Overhead protection - passageways.



Passageways under hot wires from annealing furnaces shall be provided with overhead protection.

(2) Wire drawing machines.

Wire drawing machines shall be equipped with an emergency stopping device such as an electric eye, trip cord, or similar means.

(3) Bull blocks.

All bull blocks shall be provided with a substantial back guard.