

**GI Part 65. Mills and Calenders for Rubber and Plastic
Compared With
29 C.F.R. 1910.216 Mills and Calenders in the Rubber and Plastics Industries**

Summary: The significant differences between GI Part 65. Mills and Calenders for Rubber and Plastic and 29 C.F.R. Mills and Calenders in the Rubber and Plastics Industries are in:

- Employer’s responsibilities
- Employee’s responsibilities
- Illumination
- Floors and aisles
- Installation
- Hot surfaces
- Ventilation
- Maintenance
- Lubrication
- Steam pressure procedures
- Mill safety devices
- Mill stopping limits
- Calender safety devices
- Calender stopping limits

The below comparison show only those provisions where MIOSHA rules are different than OSHA or where MIOSHA rules are not included in 29 C.F.R.

MIOSHA	OSHA
<p>R 408.16511 Employer’s responsibilities. Rule 6511. An employer shall: (a) Provide training to an employee as to the hazards and safe operation of his assigned job. (b) Maintain the mills and calenders in a condition free of recognized hazards. (c) Establish and maintain a lockout procedure as prescribed in subrule (1) of rule 6527.</p>	No comparable OSHA provision
<p>R 408.16512 Employee’s responsibilities. Rule 6512. An employee shall: (a) Not use a mill or calender unless authorized and trained in its use. (b) Not remove a guard or safety device from a mill or calender except when necessary for servicing or where equivalent safety is provided. The guard shall be replaced before restarting the machine. All safety devices shall be replaced and tested before a mill or calender is put back into operation.</p>	No comparable OSHA provision

MIOSHA	OSHA
(c) Report defective machinery, equipment and hazardous conditions, when detected, to his supervisor.	
<p>R 408.16515 Illumination. Rule 6515. Illumination shall be provided to maintain a minimum of 20 foot candles intensity at an operator's work station</p>	No comparable OSHA provision
<p>R 408.16521 Installation. Rule 6521. (1) A mill or calender shall be secured in a manner to prevent unintentional movement. (2) Such a machine, except where installed in a laboratory, shall not be so placed as to require an operator to stand in an aisle. (3) ****</p>	No comparable OSHA provision
<p>R 408.16523 Hot surfaces. Rule 6523. Steam and hot water pipes and surfaces of machinery exposed to contact, except the mill and calender rolls, which would cause burns, shall be covered with an insulating material or guarded by a barrier.</p>	No comparable OSHA provision
<p>R 408.16525 Ventilation. Rule 6525. Materials processed on a mill or calender, which give off noxious or toxic materials that exceed the maximum allowable limits set by the Division of Occupational Health, shall be equipped with a ventilation system approved for this use.</p>	No comparable OSHA provision
<p>R 408.16527 Maintenance. Rule 6527. (1) **** (2) A braking or safety device for a mill or calender shall be inspected and tested weekly. The stopping distances shall be measured and recorded. Where the braking action does not meet or exceeds the requirements of rules 6502 and 6546, repairs or adjustments shall be made before operation is resumed.</p>	No comparable OSHA provision
<p>R 408.16528 Lubrication. Rule 6528. (1) Lubrication shall be accomplished by one of the following: (a) Manually when the machine can be shut off and locked out. (b) An automatic pressure or gravity feed system. (c) An extension pipe leading to an area outside of guards or away from any hazard.</p>	No comparable OSHA provision

MIOSHA	OSHA
<p>(d) Other means providing safety equal to or exceeding subdivisions (a), (b), or (c).</p> <p>(2) In any case rule 732 of the general industry safety standards commission standard, Part 7, Guards for Power Transmission, being R 408.10732 of the Michigan Administrative Code shall be followed.</p>	
<p>R 408.16531 Steam pressure procedures.</p> <p>Rule 6531. (1) Where a pressure reducing valve is used, not less than 1 relief valve, set at not more than the rated pressure of the equipment, shall be provided adjacent to the reducing valve on the low pressure side. The relief valve shall vent to an area which will not create a hazard to an employee.</p> <p>(2) A steam valve to machinery shall be opened slowly to avoid uneven expansion of a pressure chamber.</p> <p>(3) A cylinder type machine shall be in motion before steam is admitted.</p> <p>(4) The rated operating steam pressure of a machine shall not be exceeded.</p>	<p>No comparable OSHA provision</p>
<p>R 408.16541 Mill safety devices.</p> <p>Rule 6541. (1) Except where an employee cannot come in contact with a roll nip point or be caught between a roll and an adjacent object because of a fixed installation, a mill shall be provided with 1 of the following safety trip devices to activate breaking equipment:</p> <p>(a) A pressure sensitive bar which can be tripped by not more than a 40 pound pressure of an employee's body. The bar shall be installed at the front and back of the mill across the length of the rolls of each mill roll having a height of 46 inches or more. (See figure 1)</p> <p>(b) ****</p> <p>(2) A mill having automatic overhead blending rolls shall have the blender interlocked to the mill so that actuation of the mill safety device will stop the blender.</p> <p>(3) A safety device, after actuation, shall require manual resetting.</p> <p>(4) A laboratory mill may be guarded by an interlocked barrier in lieu of the requirements of subrule (1).</p>	<p>No comparable OSHA provision</p>

MIOSHA	OSHA
<p>R 408.16545. Calender safety devices. Rule 6545. (1) Except where an employee cannot come in contact with a roll nip point or be caught between a roll and an adjacent object because of a fixed installation, a calender shall be provided with the following safety trip devices to actuate braking equipment:: (a) **** (b) A safety cable shall be run vertically on both sides of the calender and connected to the safety switch. The cable shall be not more than 12 inches from the face of the rolls and not less than 2 inches from the calender frame. The cable shall be anchored not more than 6 inches from the floor and operated with either a push or pull motion. (2) ****</p>	<p>1910.217 (b) Mill safety controls 1910.217 (b)(1)(iii) Safety tripwire cable or wire center cord. Installed in the front and in the back of each mill and located within 2 inches of a vertical plane tangent to the front and rear rolls. The cables shall not be more than 72 inches above the level on which the operator stands. The tripwire cable or wire center cord shall operate readily whether cable or cord is pushed or pulled.</p>

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