BRITISH WOOD TURNERS ASSOCIATION

Notes On

Limited Cutter Projection Tooling (LCPT)
&
Fitting of Braking Devices.

Further to telephone conversations with a number of members regarding the above please find set out below some notes that I have culled from various documents on the subjects of "Limited Cutter Projection Tooling (LCPT)" and "Fitting of Braking Devices" which I hope you will find useful and clarify the requirements as I understand them under the PUWER regulations.

With regard to the specific requirements for LCPT I believe that the phrase highlighted in my notes is in line, almost verbatim, to the form of wording that was agreed by Peter Chalke on behalf of the BWTA after his visit to Lisbon in 1993 and Munich in 1994.

Limited Cutter Projection Tooling (LCPT) Notes

A changeover to LCPT should be made when replacing tooling or by 5 December 2003, whichever is the sooner.

Detachable cutters and limiters should be capable of being mounted in such a way as to prevent them being ejected. With regard to Rotary Knife turning machines *the HSE information sheets No 28,* states
"The risk of flying cutters should be minimised. In some cases, this may be achieved by positive retention, where the cutters are held by bolts through a closed slot" Further, "A safe system of work should be specified for the tool setter, including the identification of manufacturers torque settings for each type of tooling used" etc. see *information sheets No 28* for more information.

Machines which should use LCPT are the following hand fed machines:

- Vertical spindle moulders;
- Single-end tenoners;
- **Rotary knife and copy lathes where the hazards of ejection and contact with the tool are not prevented by a system of fixed guards and/or interlocked moveable guards and/or self closing guards; and**
- Any other machine onto which a moulding tool can be fitted, e.g. if a moulding tool is fitted onto a circular saw, the tool should be of a limited cutter projection type.

See HSE information sheets No 18 (revised), No 28, No 37

See page 43 BWF Guide to Health & Safety

Fitting of Braking Devices Notes

Each machine must have easily accessible controls which will bring the equipment to a stop in a safe manner. Any braking device must operate in priority to other controls.

"If a machine has a rundown time of more than 10 seconds and there is a risk of injury to the operator or any other person then an automatic braking device should be fitted that reduces the run-down time to 10 seconds or less."

While it is possible to fit some form of breaking to any woodworking machine, for some machines, bringing them to rest within 10 seconds might be positively harmful to the machine and dangerous to the operator or others close by. This is the case where:

- large amounts of energy have to be dissipated during braking (example the band re-saw) and
- there is a danger of blades breaking, for example a result of a crack, as may be the case on a machine fitted with a band blade.

The overriding consideration should be to bring the machine to a safe stop. The rundown time should be less than the runup time with an overriding maximum of 30 seconds (35 seconds for bandsaws).

If the risk assessment shows that there is no added safety benefit, then braking does not have to be provided.

One example would be where the cutters are enclosed by interlocked guards which incorporate guard locking, so the guards cannot be opened until the cutters have come to rest. Alternatively, the whole machine is enclosed by a noise hood, but the same interlocking requirements apply i.e. the hood cannot be opened until the cutters have come to rest.

Another example is where the blade, tool or cutters returns automatically to a position of safety, such as a cross-cut saw fitted with a spring which retracts the blade into a protective housing at the conclusion of the cut.

The main and acceptable ways of providing braking are:

- Replace the existing unbraked motor with a braked motor;
- Fit a direct current (DC) injection braking device to the existing unbraked motor;
- Fit a power-operated mechanical brake;
- Fit a manual or foot-operated brake.

Date for compliance.

5 December 2003.

Circular saw benches, dimension saws, powered and hand-fed cross-cut saws, single end tennoners and combined machines incorporating a circular saw and /or tenoning attachment.

5 December 2005

Narrow bandsaws, re-saws, vertical spindle moulding machines (unless fitted with a manual or foot operated brake), hand-fed routing machines, thicknessing machines, planing/thicknessing machines and surface planing machines.

5 December 2008

For any machine not specified, but for which the risk assessment shows braking to be necessary.

See HSE information sheets No 38

See pages 41 & 42 BWF Guide to Health & Safety

Kind regards

Roger Pugh.
Honorary Secretary.