Public Review Draft
March 2024

Proposed Revisions
for
ASME B20.1-20XX
Revision to
ASME B20.1-2021
Safety Standard for Conveyors and Related
Equipment

TENTATIVE
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ASME Codes and Standards
Approved Revisions to B20.1-20XX

TN 19-2795

Proposed Revision to B20.1 Sections 5.3(a) Lubrication:

Conveyors shall not be manually lubricated while in operation if it exposes personnel to hazards unless it is impractical to shut them down for lubrication. Only trained and qualified personnel who are aware of the hazards of the conveyor in motion shall be allowed to lubricate a conveyor that is operating.

Rationale: Some conveyors are designed with remote activated lubrication systems designed to ensure through lubrication while keeping people away from the point of operation. As written, this type of system is not promoted and must first be deemed impractical. Suggest adding wording to indicate the presence of a worker near the point of operation and therefore possibly exposed to a hazard.

TN 19-2811

NEW Proposed Revision to B20.1 Sections 5.11.2(c)(2) and (3) E-Stop Devices:

5.11.2(c)(2) E-Stop Devices

5.11.2(c)(2) Emergency stop devices that are located away from a conveyor or conveyor system, such that their function is not obvious, shall identify the equipment that is controlled by the emergency stop device.

5.11.2(c)(3) The emergency stop device shall act directly on the control of the conveyor concerned and not depend on the stopping of any other equipment. The emergency stop devices shall be installed so that they cannot be overridden from other locations.

Rationale: Since the E-stop is mounted on a wall or column it is not intuitive what its purpose is.

TN 19-2812

Proposed Revision to B20.1 Para. 5.2(d) Maintenance (Repair):

5.2 Maintenance (Repair)

(a) Maintenance….

(d) When a conveyor is stopped for maintenance or service, the starting devices, prime movers, or powered accessories shall be locked or tagged out in accordance with a formalized procedure designed to protect all persons or groups involved with the conveyor against an unexpected restart. Maintenance personnel should be alerted to the hazard of stored energy (including, but not limited to, hydraulic, pneumatic, suspended weight, thermal), which may exist after the power source is locked out. Refer to ANSI/ASSP Z244.1-1982 and OSHA Standard 29 CFR 1910.147.

Rationale: Section 5.2 (d) is written under the premise that electrical energy (starters, motors, & powered accessories) is to be “locked or tagged out” to prevent against unexpected conveyor restart. It goes further to state that Personnel “shall” be alerted to the hazard of stored energy, which may exist after the power source is locked out.

Current Lock Out / Tag Out procedures require that all sources of energy be properly identified on a LOTO placard and properly controlled prior to performing maintenance or service on the conveyor.
TN 20-2748

Proposed Revision to B20.1, Para. 5.17 Dust Hazards:

5.17 Dust Hazards
Bulk material handling conveyor systems have the potential to create hazardous dust conditions. While this Standard does not address combustible, explosive or respirable dust hazards, they need to be considered in the overall system design and operation. Follow OSHA and MSHA standards that address these hazards.

Rationale: In keeping with the B20 Committee’s directive (see October 22, 2020 minutes, pages 6-7), the Project Team has agreed on the above disclaimer language and submits it for first consideration ballot.

TN 21-11

Proposed Revision to B20.1, New Para. 5.17 Dust Hazards:

5.17 Dust Hazards
Bulk material handling conveyor systems have the potential to create hazardous dust conditions. While this Standard does not address combustible, explosive or respirable dust hazards, they need to be considered in the overall system design and operation. Follow OSHA and MSHA standards that address these hazards. Follow applicable national, state, and local standards and codes to mitigate hazardous dust conditions.

Rationale:
1. The preferred ASME wording guide uses “shall”.
2. The proposed wording alerts the reader that there are more legal codes and standards than OSHA and MSHA standards that should be considered.

TN 23-796

Proposed Revision to B20.1, Paras. 4, 6.8.3, 6.13 Gendered Pronouns:

4 DEFINITIONS

qualified person: a person who, by possession of a recognized degree or certificate of professional standing or by extensive knowledge, training, and experience, has successfully demonstrated his/her the ability to solve problems relating to the subject matter and work.

6.8.3 Operation and Maintenance
(a) When a mobile conveyor exposed to high wind conditions creates a hazard to personnel, normal operation shall cease, and, if necessary, the conveyor shall be moved to a parking position and secured. Following OSHA and MSHA standards that address these hazards, Follow applicable national, state, and local standards and codes to mitigate hazardous dust conditions.

Rationale:
1. The preferred ASME wording guide uses “shall”.
2. The proposed wording alerts the reader that there are more legal codes and standards than OSHA and MSHA standards that should be considered.

6.13 Safety Considerations for Shuttle Conveyors, Belt Trippers, and Transfer Cars
(h) When a person is required to move with the shuttle, tripper, or transfer car, a workstation shall be provided for his/her that person's protection.

**Rationale:** ASME codes and standards should not use gendered pronouns (i.e., he, she, he/she, his, her, his/her, him, him/her, himself, and herself) for generic references to people. Neither should plural they or them replace a singular pronoun that refers to a singular antecedent. A new paragraph in the style guide, SG1-10, documents techniques for eliminating gendered pronouns.

When writing new standards or new sections of existing standards, avoid using pronouns. Carefully crafted, precisely worded sentences will not require pronouns. When revising existing standards, review for gendered pronouns and revise to gender-neutral language.