Sump Opening Guard Guidelines
According to 29 CFR 1910 Subpart O machinery and machine guarding.

Four examples of sump guards based on distance from grain floor to auger flights or conveyor paddle.

<table>
<thead>
<tr>
<th>Distance between Protective Covering and Moving Parts of Equipment</th>
<th>Maximum vertical opening (Horizontal openings are unlimited)</th>
</tr>
</thead>
<tbody>
<tr>
<td>¼ to 1 ½ inches</td>
<td>¼ inches</td>
</tr>
<tr>
<td>1 ½ to 2 ½ inches</td>
<td>¼ inches</td>
</tr>
<tr>
<td>2 ½ to 3 ½ inches</td>
<td>½ inches</td>
</tr>
<tr>
<td>3 ½ to 5 ½ inches</td>
<td>¾ inches</td>
</tr>
<tr>
<td>5 ½ to 6 ½ inches</td>
<td>¾ inches</td>
</tr>
<tr>
<td>6 ½ to 7 ½ inches</td>
<td>¾ inches</td>
</tr>
<tr>
<td>7 ½ to 12 ½ inches</td>
<td>1 ¼ inches</td>
</tr>
<tr>
<td>12 ½ to 15 ½ inches</td>
<td>1 ½ inches</td>
</tr>
<tr>
<td>15 ½ to 17 ½ inches</td>
<td>1 ⅛ inches</td>
</tr>
<tr>
<td>17 ½ to 31 ½ inches</td>
<td>2 ⅛ inches</td>
</tr>
<tr>
<td>31 ½ inches to less than 7 feet</td>
<td>6 inches</td>
</tr>
<tr>
<td>More than 7 feet</td>
<td>Protective Covering not required</td>
</tr>
</tbody>
</table>

Evaluate Opening:
less than 6” may be necessary to avoid tripping hazard.

Bin Floor

Greater than 31.5” deep

31.5” - 17.5” deep

15.5” - 12.5” deep

5” - 3 1/2” deep

GRAIN & FEED ASSOCIATION of Illinois