

Safety Engineering Tables

TABLE 47-K (Concluded)

Moulders, Matchers, and Sizers		Single Planers	
Max size	cfm per head	Working width	cfm
Up to 4 in	550 for side 550 for top 800 for bottom	Up to 20 in max	800
Over 4 to 6 in	660 for side 800 for top 800 for bottom	Over 20 to 26 in	1 100
Over 6 to 8 in	800 for side 1,100 for top 800 for bottom	Over 26 to 32 in	1 400
Over 8 in	800 for side 1 400 for top 1 400 for bottom	Over 32 to 38 in	1 800
NOTE Where profiler is used, provide additional volume not less than that specified for top head		Over 38 in	2,200
Sash Stickers		Double Planers	
One 4 in branch on each head	350	Working width	cfm per head
Wood Shapers		Up to 20 in max	800 for upper 550 for lower
Horsepower per spindle	cfm per spindle	Over 20 to 26 in	1 100 for upper 800 for lower
Up to 1	350	Over 26 to 32 in	1 400 for each
Over 1 to 3	550	Over 32 to 38 in	1 800 for upper 1 400 for lower
Over 3 to 5	800	Over 38 in	2 200 for upper 1 400 for lower
Over 5 to 7½	1 100	Automatic Lathes	
Over 7½	1,400	Per foot of cutting length	350
NOTE Where one continuous hood includes two or more spindles the air volume required for the hood may be based on a volume per spindle of 250 cfm less than specified above but in no case less than 350 cfm per spindle		NOTE Branch pipes shall be located to provide effective air removal over full face of hood	
Tenoners		Pulley Pockets	
Top and bottom tenon heads	550 for each	550 cfm	
Cope and dado heads	550 for each	Pulley Stiles	
Cutoff saws up to 12 in diam	350	550 cfm	
Over 12 in diam saw	550	Hogs	
Jointers		Tons of refuse per hour	cfm
Knife width	cfm	Up to 1	1 600
Up to 6 in	350	Over 1	50 per pound of refuse conveyed
Over 6 to 12 in	550	NOTE Use branch and main velocity not less than 4 500 cfm Separate exhaust system should be provided but additional separator is not required if separator used for other woodworking equipment is adequate	
Over 12 to 20 in	800	Floor Sweeps	
Over 20 in	1 100	NOTE Air volume of branches to floor sweeps with covers which are kept closed when not in use need not be included in computing total air volume	
Portable Sanders		NOTE Conform to requirements for portable grinders	
Machines Not Specifically Listed in This Table		Air volume shall be at least 350 cfm and hood shall be so arranged that an inward flow of air into the ventilating system is maintained during the operation of the machine with adequate velocity to control air contaminants	

From Exhaust Systems Industrial Code Rule 18 (April 1961) New York State Department of Labor