

COSHH ASSESSMENT — CUTTING AND THREADING OILS

COSHH — SUBSTANCE ASSESSMENT

Metalworking fluids for threading, tapping, drilling and cutting steel and pipe

KD-COSHH-CO-038 Rev A0

COSHH 2002 reg 6: exposure is assessed BEFORE the work starts; reg 7: it is prevented, or adequately controlled, working down the hierarchy — eliminate, substitute, engineer, then RPE last. This assessment covers the substance family below; it is completed against the actual products (their safety data sheets alongside) and the actual task, and briefed to the people exposed. The current workplace exposure limit, where one applies, comes from EH40 and the SDS on the day — write it in below.

1 ASSESSMENT DETAILS

SITE / PROJECT

TASK ASSESSED

PRODUCTS IN USE (SDS TO HAND)

ASSESSED BY

DATE

2 THE SUBSTANCE — WHAT IT IS AND WHAT IT DOES

WHERE IT IS MET: Threading and cutting steel pipe and conduit, tapping, drilling and cold-cutting steel with neat oils and soluble oils. Exposure is skin contact with the oil and the swarf, and mist from high-speed machines.

THE HARM: Neat and soluble oils cause dermatitis and oil acne on repeated contact, and contaminated soluble oils breed bacteria that make dermatitis worse and, breathed as mist, cause occupational asthma and hypersensitivity pneumonitis. Swarf cuts let the oil in. Some older oils are suspected carcinogens on prolonged skin contact.

3 EXPOSURE — ROUTES, PEOPLE, LIMIT

Inhalation — dust, fume, vapour or mist

Ingestion — hand to mouth

Skin and eye contact

Others affected — adjacent trades, occupiers, public

WHO IS EXPOSED, HOW LONG, HOW OFTEN

WEL / LIMIT (FROM EH40 AND THE SDS TODAY)

4 CONTROLS — IN THE REG 7 HIERARCHY, ALL IN PLACE BEFORE WORK STARTS

Modern, low-hazard fluids chosen and kept clean — contaminated soluble oil is the health problem

Nitrile gloves and sleeves; oil-soaked clothing changed, not worn all day

Splash guards and mist control on threading machines; swarf cleared with a brush or hook, not by hand

Wash before breaks with proper skin cleanser; moisturise

Cuts covered before work and cleaned promptly

SITE-SPECIFIC CONTROLS FOR THIS TASK

RPE WORN (TYPE, AND FACE-FIT WHERE TIGHT-FITTING)

OTHER PPE FOR THIS SUBSTANCE

5 HEALTH SURVEILLANCE, HYGIENE AND FIRST AID

Skin checks for regular users, and respiratory questionnaires where threading machines make mist; dermatitis reported and investigated.

6 STORAGE, SPILLAGE AND DISPOSAL

Containers sealed and labelled; used fluid and oily swarf to the hazardous waste stream; spills absorbed, never hosed.

WHERE IT IS STORED ON THIS SITE

SPILL RESPONSE AT THE WORK

7 SIGN-OFF AND BRIEFING

The assessment is complete when the people exposed have been briefed on it. Reassess when the product, task, quantity or location changes — not on an anniversary.

ASSESSOR — PRINTED NAME

SIGNATURE

DATE

WORKFORCE BRIEFED (DATE / RECORD REF)

R REVISION HISTORY

Every revision of this document, and every review that found nothing to change. The revision on the front of this sheet is the one you are holding — check kubitdocs.com for the current one before use.

Rev	Date	Class	What changed	Authorised by
D0	2026-09-01	first-issue	First issue.	— not yet approved —
A0	2026-09-01	review	Approved for issue by the author. Content unchanged from the reviewed draft; the draft status strip is removed. No independent third-party review has been carried out.	Author — director, UK principal contractor, SMSTS. Not an independent review.

Class: first-issue · material (the law, a control, a field or the scope changed — past buyers are notified) · editorial (wording or layout only) · review (checked, nothing changed) · withdrawal. Revision prefix D = draft, not approved and not for sale; A = approved for issue by the person named, on the date shown.