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Standard Practice for Pressure Water Cleaning and Cutting¹

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1. Scope

1.1 This practice covers the personnel requirements, operator training, operating procedures, and recommended equipment performance/design for the proper operation of all types of pressure water-jet cleaning and cutting equipment as normally used by industries concerned with construction, maintenance, repair, cleaning, cutting, and demolition work.

1.2 The term ~~high-pressure~~ “high-pressure water jetting” covers all water jetting, including the use of additives or abrasives at pressures above 100.5 psig (0.69 MPa).

1.3 Any person required to operate or maintain pressure water-jetting equipment shall have been trained and have demonstrated the ability and knowledge to do so in accordance with the original equipment manufacturer’s instructions, specifications, and training programs.

1.4 The values stated in inch-pound units are to be regarded as the standard. The values in parentheses are for information only.

1.5 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.* See ~~3.1, 3.3, 2.3, 4.4, 5.7.2, 5.11, 5.14, 6.2, 6.7,~~ and Sections 8 and 11 for specific hazards statements.

1.6 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

[E1542 Terminology Relating to Occupational Health and Safety](#)

2.2 *ANSI/IEEE Standard:*³

[957-1987 IEEE Guide for Cleaning Insulators](#)

3. Terminology

3.1 For definitions of terms used in this standard, see Terminology [E1542](#).

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *dump system, n*—the discharge orifice operator-controlled, manually operated device or system that reduces the pressure to a level that yields a pressure flow at the nozzle that is considerably below the risk threshold.

3.2.2 *guard, n*—should be so designed, constructed and used that it ~~will:~~will:

- ~~—(a) provide positive protection;~~
- ~~—(b) prevent all access to the danger zone during operations;~~
- ~~—(c) cause the operator no discomfort or inconvenience;~~
- ~~—(d) not interfere unnecessarily with production;~~
- ~~—(e) operate automatically or with minimum effort;~~

¹ This practice is under the jurisdiction of ASTM Committee [E34](#) on Occupational Health and Safety and is the direct responsibility of Subcommittee [E34.10](#) on Industrial Safety.

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² For referenced ASTM standards, visit the ASTM website, [www.astm.org](#), or contact ASTM Customer Service at [service@astm.org](#). For *Annual Book of ASTM Standards* volume information, refer to the standard’s Document Summary page on the ASTM website.

³ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, [http://www.ansi.org](#).

- (f) be suitable for the job and the machine;
- (g) preferably constitute a design, integral built-in feature;
- (h) provide for machine oiling, inspection, adjustment and repair;
- (i) withstand long use with minimum maintenance;
- (j) be durable, fire- and corrosion-resistant;
- (k) not constitute a hazard by themselves (without splinters, sharp corners, rough edges, or other sources of accidents); and
- (l) protect against foreseeable use and foreseeable misuse of operational contingencies, not merely against normally expected hazards as determined from a job safety analysis

(1) Provide positive protection;

(2) Prevent all access to the danger zone during operations;

(3) Cause the operator no discomfort or inconvenience;

(4) Not interfere unnecessarily with production;

(5) Operate automatically or with minimum effort;

(6) Be suitable for the job and the machine;

(7) Preferably constitute a design, integral built-in feature;

(8) Provide for machine oiling, inspection, adjustment, and repair;

(9) Withstand long use with minimum maintenance;

(10) Be durable, fire and corrosion resistant;

(11) Not constitute a hazard by themselves (without splinters, sharp corners, rough edges, or other sources of accidents); and

(12) Protect against foreseeable use and foreseeable misuse of operational contingencies, not merely against normally expected hazards as determined from a job safety analysis.

3.2.3 *high-pressure water cleaning*, *v*—the use of high-pressure water, with or without the addition of other liquids or solid particles, to remove unwanted matter from various surfaces, where the pressure of the liquid jet exceeds 100.5 psig (0.69 MPa) at the orifice. (**Warning**—The limit of 100.5 psig (0.69 MPa) does not mean that pressures below 100.5 psig (0.69 MPa) cannot cause injury or require any less attention to the principles of this practice. Adequate precautions, similar to those of this practice, are required at all pressures.)

3.2.4 *high-pressure water cutting*, *v*—the use of high-pressure water, with or without the addition of other liquids or solid particles, to penetrate into the surface of a material for the purpose of cutting that material, where the pressure of the liquid jet exceeds 100.5 psig (0.69 MPa) at the orifice.

3.2.5 *hose assembly*, *n*—a hose with safety coupling, each indicating pressure capacities and attached in accordance with manufacturer's specifications.

3.2.6 *lance*, *n*—a rigid metal tube used to extend the nozzle from the end of the hose.

3.2.7 *lancing*, *v*—an application whereby a lance and nozzle combination is inserted into, and retracted from, the interior of a pipe or tubular product.

3.2.8 *moleing*, *v*—an application whereby a hose fitted either with a nozzle or with a nozzle attached to a lance is inserted into, and retracted from, the interior of a tubular product. It is a system commonly intended for cleaning the internal surfaces of tubes, pipes, or drains. It can be self-propelled by its ~~backward-directed~~ backward-directed jets and is manufactured in various shapes, sizes, and combinations of forward- and backward-directed jets.

3.2.9 *nozzle*, *n*—a device with one or more openings where the fluid discharges from the system. The nozzle restricts the area of flow of the fluid, accelerating the water to the required velocity and shaping it to the required flow pattern and distribution for a particular application. Combinations of forward and backward nozzles are often used to balance the thrust. Such nozzles are commonly referred to as tips, jets, orifices, etc.

3.2.10 *operator*, *n*—a person who has been trained in accordance with the original manufacturer's instructional training program and has demonstrated the knowledge, experience, and ability to perform the assigned task.

3.2.11 *operator trainee*, *n*—a person not fully qualified due to the lack of sufficient knowledge or experience, or both, to perform the assigned task without supervision.

3.2.12 *pressure water jet system*, *n*—water delivery systems that have nozzles or other openings whose function is to increase the speed of liquids that may cause injury. Solid particles or additional chemicals may also be introduced, but the exit in all cases will be in a free stream. The system shall include the pumps (pressure-producing devices), hoses, lances, nozzles, valves, safety devices, and personal protective equipment, as well as any heating elements or injection ~~systems~~ systems attached thereto.

3.2.13 *shotgunning*, *n*—an application whereby a lance or nozzle combination can be manipulated in virtually all planes of operation.

4. Significance and Use

4.1 This practice is intended to provide guidance on the proper operation of pressure water-jet cleaning and cutting equipment.

4.2 This practice is also applicable at lower pressures where there is foreseeable risk of injury.

4.3 This practice is provided to assist persons unfamiliar with the operation of water-jet cleaning and cutting equipment in learning to correctly use the equipment.

4.4 Correct operation and use of the pressure water-jet cleaning and cutting equipment requires that the operator has familiarized himself with the identification of pressure metal fittings, hoses, guns, and accessories in accordance with the original equipment ~~manufacturers~~ manufacturer's specifications, instructions, and programmed instructional ~~material~~ material; only then shall hydro-jetting begin. Modification of water-jetting equipment shall not be done without prior written approval by the manufacturer of the equipment. Employees shall be instructed in the recognition and avoidance of unsafe conditions as identified/required in 5.18. (**Warning**—Serious harm or injury may result from the misuse of water-jetting equipment and the use of improper fittings, hoses, or attachments.)

4.5 The use of pressure water-jet equipment for cutting and cleaning is a rapidly evolving technology. This practice will be periodically reviewed for any required changes at least every five years.

5. Apparatus

5.1 *Pressurizing Pump*—A unit designed to deliver pressure water or other fluid with or without chemicals or particle material. This is usually based on positive displacement pistons or rubber diaphragm/hydraulic systems and discharges water into a common manifold in which either flexible hoses or rigid tubing connect to lances and nozzles. These pumps can be either mobile or permanently mounted.

5.1.1 The pump shall have permanently mounted identification plates or tags which provide the following information:

5.1.1.1 Product and supplier,

5.1.1.2 Production model and serial number, or year of production,

5.1.1.3 Maximum performance, in terms of gallons per minute and pressure in pound-force per square inch, and

5.1.1.4 An outline of recommended safety procedures and warnings.

5.2 *Relief System*—The system shall be equipped with an automatic relief device on the discharge side of the pump and an auxiliary relief dump device as part of the pump.

5.3 *Relief System Types*—*System Types*—These may take the form of the following:

5.3.1 *Pressure Relief Valve or Bursting Disk in Holder*—Usually mounted on the pump discharge chamber to prevent the pressure exceeding the rated maximum pressure of the whole system.

5.3.2 *Automatic Pressure Regulating Valve (Unloading Valve)*—Limits the pressure at which the pump operates by releasing a preset proportion of the generated flow back to the pump suction chamber or to waste. It may be used to regulate the water pressure from the pump and is individually set for each operation. This device may be integral with the pump hydraulic assembly. Where there is no demand for pumpage, the pressure is brought down to zero.

5.3.3 *Bypass Valve*—Limits the pressure at which the pump operates by releasing a preset proportion of the generated flow back to the pump suction chamber or to waste. It may be used to regulate the water pressure from the pump and is individually set for each operation. This device may be integral with the pump hydraulic assembly.

5.4 *Pressure Gage*—The system shall be equipped with a gage indicating the pressure being developed. Gages shall have a scale range of at least 50 % above the maximum working pressure of the system.

5.5 *Filter or Strainer*—The water system shall be equipped with a filter or strainer to prevent particles from restricting the orifices in the nozzle. The strainer or filter shall be capable of removing particles smaller in size than the smallest orifice in the nozzle and usually smaller to protect pumps and other components.

5.6 *Dry Shut-Off Control Valve*—This operator-controlled valve, normally ~~hand-controlled~~, hand controlled, automatically shuts off flow to the lance or nozzle assembly, or both, when released by the operator but retains the operating pressure within the supply line when so shut off. This valve shall be used in systems with an automatic pressure regulating valve.

5.6.1 Release the pressure in the dry shut-off valve and line when the pump is shut down; otherwise, the valve operating lever may remain alive. This valve may alternatively be actuated by solenoid or pilot pressure mechanism.

5.7 *Dump System*—The system should be equipped with a device that will either shut down the unit, idle it to low revolutions per minute, bypass the flow, or reduce the discharge pressure to a low level. The dump system shall be manually controlled only by the nozzle orifice operator. The dump system actuator device should be shielded to preclude inadvertent operation. This device shall immediately shut off the pressure water stream if the operator loses control.

5.7.1 *Dump Control Valve*—An operator-controlled valve, normally ~~hand-operated~~, hand operated, that automatically terminates significant flow to the lance or nozzle assembly, or both, when released by the nozzle operator, thus relieving the operating pressure within the whole system by diverting the flow produced by the pump to atmosphere. A valve size should be selected that will not cause generation of significant back pressure at the maximum possible pumping rate of the pump. This valve may alternatively be actuated by a solenoid or a pilot pressure mechanism.

5.7.2 *Solenoid and Electrically Operated Control Dump Systems*—All electrically controlled dump systems should be of fail-safe design. (**Warning**—Voltage of an ~~alternating current~~ alternating current (ac) or ~~direct current~~ direct current (dc) dump system handled by personnel shall not exceed 24 V.)

5.8 *High-Pressure Hose and Couplings*—A flexible hose and coupling that connects two components and delivers the high-pressure fluid to the gun or nozzle components. The hose and fittings shall have a burst rating of a minimum of 2.5 times the maximum working pressure. Operating levels below this ratio should require a protective shielding around that hose and coupling. The hose and coupling shall be marked with the manufacturer’s symbol, serial number, the maximum permissible operating pressure, and the test pressure. High-pressure hose shall be tested at 2.5 times working pressure in accordance with the original equipment operators’~~operator’s~~ specifications, test methods, instructions, and training programs.

5.9 *End Fittings and Couplings*—Pressure hose end fittings and safety couplings shall be manufactured to be compatible with the hose and tested as a unit.

5.10 *Jetting Gun Extension*—A length or lengths of tube carrying pressure fluid to the nozzle. Each shall be manufactured from material suitable to the application. End connections shall be suitable for the application. The extension is used in conjunction with a control valve. The extension shall have a minimum burst strength of at least 2.5 times the highest actual operating pressure used.

5.11 *Nozzle*—The nozzle creates the water jet or jets at the required velocity, flow rate, pressure, shape, and distribution for a particular application. Combinations of forward and backward direct water jets are often used to balance the thrust. Such nozzles may be referred to as tips, jets, or orifices. (**Warning**—Personal protective equipment and nozzle guard shall be provided.)

5.12 *Water Jet*—A jet stream of water produced from the individual outlet orifice of a nozzle. The shape of the jet is determined by the form of the orifice, while the speed at which it travels is determined by the orifice design, orifice area, and flow. The pressure drop at the orifice is a result of an increase in velocity. The two most commonly used jet shapes are the ~~straight-jet~~ straight jet and fan-shaped jet.

5.12.1 *Straight Jet*—Concentrates the stream of water over a small area of the workpiece by minimizing the spread. A typical application is for cutting, or for general cleaning of matter with higher shear or bond strength, or both.

5.12.2 *Fan Jet*—Spreads the stream of water in one plane, thus giving a wide band coverage of the workpiece. A typical application is for cleaning larger areas requiring less energy to remove unwanted matter.

5.13 *Jetting Hand Manifold and Spray Bars*—These are pieces of equipment which individual nozzles are fitted for protection of the workmen.

5.14 *Foot Control Valve*—The orifice operator’s control valve may be arranged for actuation by the operator’s foot if desired, either in place of, or in addition to, ~~hand-control~~ hand control. (**Warning**—An adequate guard shall be fitted to prevent accidental operation, and the base plate should be sufficient to ensure stability in use. If of the dump type, the layout should ensure that the dump line used is restrained from whipping when the valve is released.)

5.15 *Jetting Gun*—A portable combination of operator’s control valve, lance, and nozzle resembling a gun in layout and assembly. The control valve is ~~hand-operated~~ hand operated by a ~~squeeze-action~~ squeeze-action, dead-man-type trigger for the hand of the operator who should always have control of this device and may be of the dry shut-off or dump type, the gun being named accordingly. The ~~hand-control~~ hand control normally takes the form of a trigger or lever that is provided with a guard adequate to prevent accidental operation and that shall have the means of being immobilized in the “off” position by means of a safety catch. The gun shall be fitted with a shoulder pad or hand grips to facilitate back-thrust control.

5.16 *Retro Gun*—A retro safety gun is fitted with forward- and backward-facing jets. This reduces the thrust experienced by the operator. This type of gun is used mainly for underwater jetting operations. The retro balance jet protection tube shall be sufficiently long or constructed so as to prevent the operator from directing a retro balance jet at himself.

5.17 *Changeover Valve*—An operator-controlled valve designed to properly direct pressure water flow from the pump to one or other items of equipment at the operator’s choice. It shall be designed to withstand 2.5 times the maximum system pressure, and may be power-operated.

5.18 *Original Equipment Manufacturer (OEM)*—The original equipment manufacturer shall design the equipment based upon the foreseeable uses and misuses and design recognized hazards out of the equipment. Hazards that cannot be designed out shall be guarded and warned to protect and alert the operator. Warnings and instructions shall never be used as a substitute for the elimination of hazards or guarding. Failure Mode and Effects Analysis (SAE J-1739) and Job Safety analysis shall be provided by the OEM in ~~there~~ their programmed instructional material.

6. Care and Maintenance of Equipment

6.1 *Pump Unit*—Maintain the pump unit in accordance with the manufacturer’s instructions, specifications, and programmed instructional material. Where applicable, this should include daily checks on the following items:

6.1.1 *Drive Unit*—Lubricating oil, water, hydraulic fluid, and fuel levels,

6.1.2 *Pump Unit*—Lubricating oil and gear box oil levels,

6.1.3 *Hydraulic Hose Reel*—Lubricating oil and fluid levels, and

6.1.4 *Condition of Guards and Shields*.

6.2 *Filters and Strainers*—Check all water ~~filters~~ filters at regular intervals, dependent upon the supply water conditions, and in accordance with the pump manufacturer’s recommendations. (**Warning**—Take extreme care to filter the water source through a

proper micron filtration device, to prevent foreign particles from cutting changeover valves and seating surfaces, and to prevent clogging the changeover valve operating mechanism. Such clogging can cause a loss of control, which can be dangerous to the operator.)

6.3 *Hose Assemblies*—Inspect all hose assemblies prior to use with respect to the following:

6.3.1 Correct pressure rating and size,

6.3.2 Free from external damage, that is, broken wires, and

6.3.3 All end fittings and couplings are in good order and of the correct pressure rating for the unit operating pressure.

6.4 *Nozzles*—Keep all jetting nozzles clean and check the orifice to ensure that it is not obstructed or damaged before installation. Do not use defective nozzles; replace or repair before installation. During the startup prior to operation, move the nozzle from the lance and flush the system thoroughly to remove air and foreign particles.

6.5 *Jetting Guns and Lances*—Check jetting guns and lances daily and examine the trigger mechanism and guard thoroughly to ensure correct operation. Observe all pressure connections during operation of the equipment. If a leak is observed, shut down the pump and repair or replace the connection before further operation.

6.6 *Foot Control Valves*—Check and clean all foot control valves and switches daily and give the foot mechanism and guard a thorough visual and mechanical examination to ensure correct operation and freedom from accidental actuation. When the nozzle operator is not the trigger operator, the nozzle operator shall use a guarded safety foot control valve to de-energize the flow in the event of an emergency.

6.7 *Electrical Equipment*—All electrically ~~operated~~operated pressure water-jet cleaning and cutting equipment units shall be checked daily for external damage, with special emphasis placed on connections, junction boxes, switches, and supply cables, and shall be of the waterproof type. (See National Electric Code Section 430-91.) (**Warning**—Ensure that the electrical system is protected from the ingress of ~~water~~water. Only ~~NEMA-classified~~NEMA-classified electrical equipment, which is of the waterproof type, shall be used. Check correct direction of rotation of the electric motor on initial installation and after every reconnection.)

6.8 *Trailers*—Check trailer-mounted units daily, examining the tires, braking systems, jacking points, towing hitch, lights, safety chains, structural damage, and for general cleanliness. Tow the units only by vehicles designed for that purpose.

6.9 *Engine Controls*—Check all throttle cables and engine stop devices daily to ensure that they are functioning properly.

6.10 *Maintenance Servicing and Repair*—The following operations should only be carried out by competent personnel:

6.10.1 Manufacturer's servicing requirements.

6.10.2 The following items should be overhauled and checked for correct functioning at the original manufacturer's recommended intervals:

6.10.2.1 Pressure relief valve,

6.10.2.2 Bursting disks, if used,

6.10.2.3 Pressure control valves,

6.10.2.4 Hand- or foot-operated dump control valve or dry shut-off control valve,

6.10.2.5 Dry shut-off valve or dump system,

6.10.2.6 Changeover valve, and

6.10.2.7 Personal protective equipment.

6.11 *Tools*—Use the correct size tools when maintaining or assembling jetting systems. The use of adjustable tools having serrated gripping jaws (for example, pipe wrenches) can damage equipment and is not recommended, particularly on the crimped portion of a hose fitting.

6.12 *Compatibility*—Check all component parts and fittings to ensure they are of the correct size and rating for the unit.

7. Operational and Training Requirements

7.1 *Qualified Operators*—Only personnel who have been trained in accordance with the ORIGINAL EQUIPMENT ~~MANUFACTURERS'~~MANUFACTURER'S programmed instructional material from the original equipment manufacturer shall operate pressure waterjetting equipment and supervise the training of new operators.

7.2 *Operator and Employer Training*—A personnel training program shall be developed utilizing the original equipment manufacturer's programmed instructional material and shall be presented to each operator and employee before assignment to the employee's first pressure water-jet cleaning and cutting equipment task. Such training shall include, as a minimum, coverage of all items listed in this practice that are relevant to safe operation, maintenance, and use of the equipment, and records of employee training shall be kept for five years.

7.3 *Cutting Action*—The cutting action of a pressure water jet and the potential hazard it poses to the human body shall be demonstrated through the use of audiovisual aids or actual use of equipment (by cutting through a piece of lumber, a concrete block, cleaning painted metal, etc.).

7.4 *Personal Protective Equipment*—The minimum personal protective equipment requirements shall be explained to each operator and employee. Instructions shall be given as to when and how specific clothing and other types of personal protective equipment shall be worn according to the type of work performed as specified in the original equipment manufacturer’s programmed instructional materials.

7.5 *System Operation*—The operation of the system shall be explained by pointing out potential problems and proper corrective action, based upon the foreseeable uses and misuses analysis (system safety) as provided by the original equipment manufacturer.

7.6 *Control Devices*—The operation of all control devices shall be explained. The importance of not tampering with any control devices, as well as the importance of keeping the control device in proper working order, shall be stressed.

7.6.1 *Equipment Maintenance*—Valves and seating surfaces in pressure-regulating devices encounter high wear during pressure water jetting. These items require frequent inspections, maintenance, or replacements, or a combination thereof, in order to provide proper operation as delineated by the instructions provided by the original equipment manufacturer.

7.7 *Hose*—The proper method of connecting hoses, including laying out without kinks, protection from excessive wear, and proper tools to use on couplings and fittings shall be explained to operators and employees as delineated by the instructions provided by the original equipment manufacturer.

7.8 *Stance*—The proper stance for sound footing and how to use the various devices for lancing, shotgunning, and moleing shall be demonstrated. The operator and employee trainees, under close supervision, shall use the various devices while the unit is slowly pressurized, as delineated by the instructions provided by the original equipment manufacturer.

7.9 *Proficiency*—Personnel shall demonstrate knowledge and skill in the proper operation, inspection, and maintenance of equipment through practical application.

7.9.1 The employer of operators and operator trainees is responsible for establishing and validating practices that are in compliance with relevant recommended practices and standards.

7.10 *General Requirements:*

7.10.1 The system shall be depressurized when:

7.10.1.1 It is not in use,

7.10.1.2 An unauthorized or inadequately protected person enters the barricaded area,

7.10.1.3 Replacement or repairs are made to the system, or

7.10.1.4 Any recommended practices are violated.

7.11 *Refresher Training*—Operator retraining shall be on an annual basis, or more frequently if needed.

8. Hazards

8.1 *Personnel Protection and Use of Protective Clothing:*

8.1.1 *Compliance*—All applicable recommended practices and regulations, instructions, and warnings covering personal protective equipment shall be followed as prescribed by the original equipment manufacturer’s programmed instructional material.

8.1.2 *Head Protection*—All operators shall wear the suitable head protection capable of withstanding the jet stream. This should include a full face shield, suitable for the type of work or operation being undertaken.

8.1.3 *Eye Protection*—Suitable eye protection (adequate for the purpose and of adequate fit on the person) shall be provided to all operators of pressure water-jetting equipment and must be worn within the working area. Where liquids liable to cause eye damage (see Material Safety Data Sheets) are encountered, it is necessary to use either a combination of visor and goggles or a full hood with shield.

8.1.4 *Body Protection*—All operators should be supplied with suitable jet-resistant waterproof clothing and personal protective equipment (for example, foot, leg guards) having application for the type of work being undertaken. Garments should provide full protective cover to the operator, including arms. Liquid- or chemical-resistant suits shall be worn where there is a reasonable probability of injury (see Material Safety Data Sheets) that can be prevented by such equipment.

8.1.5 *Hand Protection*—Adequate hand protection shall be supplied to all operators and shall be worn when there is a reasonable probability of injury that can be prevented by such equipment. (See original equipment manufacturer specifications.)

8.1.6 *Foot and Leg Protection*—All operators shall be supplied with waterproof boots with steel toecaps and shanks. A metatarsal guard and leg guards shall be used by the jetting gun operators where there is a reasonable probability of injury that will be prevented by such equipment.

8.1.7 *Hearing Protection*—Pressure water-jetting operations may produce noise levels in excess of 90 dB(A). Suitable ear protection issued in accordance with the recommended practices of the original equipment manufacturer must be worn. Provision should be made of regular inspection and maintenance, including daily cleaning of hearing protection devices that are of the reusable type. All personnel and operators shall receive instruction in the correct use of ear protectors such that noise exposure lies within the limits as specified by the original equipment manufacturer’s instructions.

8.1.8 *Respiratory Protection*—A respiratory protection program shall be implemented where there is a reasonable probability of injury that can be prevented by such a program.