June 19, 1969

MANVILLE TEXTILE PLANT SURVEY
NEW METHOD - SURVEY & ANALYSIS

PROBLEM AREAS

Station No. 1 FP

Fiber Feeder #2 & #3. 16.1 fibers/cc
Feeding Station #2 has glove box installed. Subsequent survey on 6/6 on #2 shows - other equipment shut down - showed count of 2.2. Glove box for #3 is now 90% completed--to be installed within two months; therefore, should substantially reduce the dust level for the total job. Operator now wearing respirator. Therefore, no further action--recheck when #3 glove box installed.

Station No. 5 FP

Hand Banding. 21.6 fibers/cc
General Engineering now developing fly conveying system which will eliminate this operation. No target date for completion yet established. Operator now wearing respirator. Therefore, no further action other than completion of project.

Station No. 9 FP

Automatic Banger. 12.4 fibers/cc
A recheck of this station was made on 5/21 after installation of new hood to catch "puff" when bag is completely filled. Count was 4.7. Operator wears respirator. Therefore, no further action other than regular re-surveys of station.

Stations Nos. 1-C through 3-C

Card Tender. Tender for Card Nos. 47 & 48 showed 14.7 fibers/cc; for Card Nos. 30, 31, 40 & 41 - 15.5 fibers/cc; others below 12 fibers/cc.
A special survey on 5/17 (a Saturday) on Card #10 enclosed and Card #11 open showed count levels of 1.9 and 3.5 respectively. Mr. Krochta advises that an Engineering report is being prepared to cover all cards and it is estimated that it will take a year after appropriation approval to complete the installation. Since the average of the seven Card Tender areas surveyed is 10.9, it is recommended that decision on the mandatory use of respirators be held pending resolution of the job and incentive standards problems discussed below.

Station No. 4-C

Stretcher. 11.9 fibers/cc
A special survey was made on 5/17 (a Saturday) to check the use of the new design of fiber container for feeding stock to the cards. The count was 4.8.

(continued)

6/6 2 Coppus + AT's out.
Quality of Engineering.

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PROBLEM AREAS

Station No. 4-C (cont'd) The extension of the container approach to other cards hinges on the determination of the feasibility of the direct lap feeding process which is to be evaluated by December 1969. Utilization of this method would eliminate the present stocker operation. Since it will involve considerable time to complete either of these approaches, it is recommended that the mandatory use of respirators be considered in conjunction with the resolution of the job and incentive standards facet of the problem.

Station Nos. 1-S through 6-S

Spinning Frames. Average of 6 locations - 21.1 fibers/cc; range - 19.1 - 22.9 fibers/cc.

On 5/20, counts were made with spinning frame slowed down to 1650 RPM. The average of 6 locations was 14.3, and ranged from 9.9 to 26.0. Visual improvement was observed by the operators. Mr. Krechta advises that there are operating economies in the slower running speeds that would probably result in lower cost per unit. In addition, the current program will eliminate (with the exception of one or two frames) the spinning operations by the end of 1969. On this basis, we would recommend that the use of respirators not be made mandatory at this time for this operation.

Station Nos. 1-T through 13-T

Twisting Frames. Range - 8.4 to 22.3 fibers/cc

A special check was made operating the twisting frames at slower speeds from 2400-2700 RPM's. The counts ranged from 8.0 to 14.1 (five twisters) on dry twisters. Another special check on 5/17 - with no other equipment running - showed wet twisting on #5 and #6 twisters at 3.2 and 4.4 fibers/cc respectively, and dry twisting at 14.7 and 11.4.

Mr. Krechta advises that the program for gang wet twisting will be completed by the end of 1969. Therefore, we would recommend that the mandatory use of respirators not be required at this time, subject to re-evaluation when this project is completed.

Station No. 15-T	Twister Piper	18.5 fibers/cc
Station No. 16-T	Twister Oiler	13.4 fibers/cc
Station No. 17-T	Bumper Spin & Twist Rept.	17.7 fibers/cc
Station No. 20-T	North End Universal Winder	19.9 fibers/cc
Station No. 2-W	2) Ware Operator	13.2 fibers/cc
Station No. 3-W	23 Ware Operator	14.6 fibers/cc

These functions are all carried out in the twisting area and, therefore, the recommendation is the same as for the twisters; i.e., that mandatory respiratory usage not be required until evaluation of the gang wet twisting is completed by the end of 1969.

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PROBLEM AREAS

Section Nos. 13-W through 15-W

Slasher looms. 18.0 - 26.9 fibers/cc; average - 11.5 fibers/cc The high counts at these machines (interwined in the same general area as the cloth looms) cannot be explained by operating management, since the open atmosphere is visibly clean. Further evaluation is to be undertaken immediately to determine whether there are variations in fiber levels related to the particular material being run. It is recommended that decision re the mandatory use of respirators be related to these further measurements and the resolution of the job and incentive standards problem.

JOB AND INCENTIVE STANDARDS

Job standards now have provision for point values for adverse work conditions and the use of respirators. The full allowance, however, affects the total not more than a few cents.

Incentive standard allowance for respirators increases the standard hour per 100 units by 10%. This means that an individual working at 120% incentive rate, excluding respirator allowance, would be paid at 132% when required to wear a respirator (on a $3.00 average earnings job, the allowance would approximate 30 cents/hour).

To determine the present status of respirator requirements and allowances at the Manville Plants, General Industrial Engineering will review the job and incentive standards for all jobs. It was the consensus that there are many jobs on which this allowance is already built in, for which the use of respirators is not now mandatory.

It was also the consensus that a specific allowance, as a "premium", would be the best and most equitable method of providing for mandatory use. It would also facilitate the addition or withdrawal of the allowance on the basis of environmental control conditions. This premium would be applied to both incentive and non-incentive operations.

If this approach were to be adopted, the application would have to be negotiated with the union. Without such an approach, numerous difficulties are anticipated.

The job and incentive standards review will be completed in 30 days. This data will be the basis for a more specific recommendation of implementing mandatory use of respirators as a job requirement.

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