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#16

DUST ABATEMENT

MANVILLE PLANTS

JOHNS-MANVILLE

JM

PRODUCTS

11 2434

EA109

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Dust Abatement
Manville Plants

The following is the recommended program for dust abatement at the Manville Plants.

The objective is to control dusts and maintain housekeeping standards to the extent that the plants will be regarded as "clean" by each of the several interested groups - management, employees, state labor and health officials.

This objective requires that both hygienic and visual dusts be controlled to acceptable limits.

The J-M standards for toxic materials provide appropriate criteria for evaluating the extent of hygienic exposures and the effectiveness of present controls. Details of the Threshold Limits for toxic materials are contained in Attachment I.

The importance of visual dust and good housekeeping to the attitude of our employees and the New Jersey labor, compensation and health authorities cannot be over-emphasized. Since there is no established standard for the nuisance, visible dusts, the following definition for maximum allowable concentration is to be applied:

a. The general atmosphere of the building shall not contain visible floating dust sufficient to produce a haze.

b. Horizontal surfaces shall be clean to the extent that dust will not be made airborne by natural drafts or mechanical operations such as truck traffic, machine operation.

c. Building members, beams and pipes shall be clean to the extent that there is no build-up or pyramiding of dust and that dust is not made airborne by building vibration.

The final responsibility for dust abatement rests with the Senior Officer of the Division.

The procedure to accomplish the objective shall be:

1. Survey and inspection to identify the problem areas.

2. Establish a priority for all identified problem areas.

   In both hygienic and visual dust problems, the degree of excessiveness and the number of people in the affected area should be considered.

3. Assign the projects in order of priority to a task team.

   Details of the task team procedure are contained in Attachment II.

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4. Status of projects, identified in Step 1, shall be reported periodically.

   Typical reports of the Lompoc program are illustrated in Attachment III.

The Lompoc experience clearly indicates that increased dust collection capacity is not necessarily the answer to the dust control problem. Important approaches to be followed are:

1. Elimination or isolation of the dust source, or removal of dust at its source.

   This may frequently be accomplished through job methods, equipment layout, process sequence changes, or by removal of the dust before product transport.

2. Assignment of schedule and responsibility for cleanup.

   - Most job standards have an allowance for cleanup time. A specific assignment and schedule for each job can produce better control with no increase in expense. (Refer to O. B. Westmont letter - Attachment IV)

3. Maintenance responsibilities, routines and inspections.

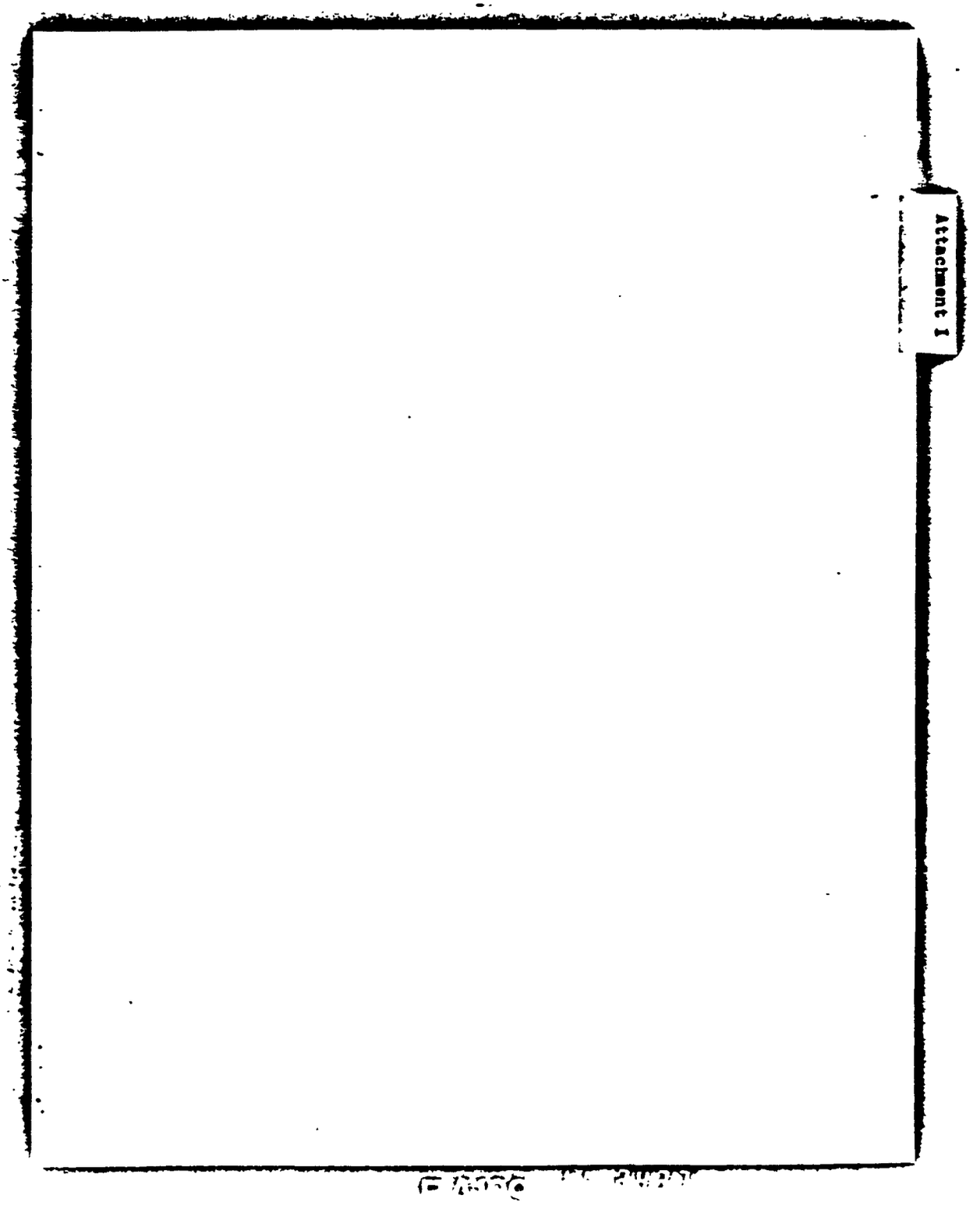
   Preventive maintenance through frequent inspection and routine cleanout, adjustments and replacements can prevent the "breakdown" or "leak" sources of dust. The General Engineering manual, INSTRUCTIONS FOR THE OPERATION OF DUST COLLECTORS, outlines positive control procedures for maintaining dust control systems at high efficiency.

4. Periodic "housekeeping" inspections and reports.

   Evaluation of performance periodically is essential to maintenance of standards. (Refer to O. B. Westmont letter - Attachment IV)

The studies initiated by the need for dust abatement have very frequently resulted in improved methods, cost reduction and better employee morale. In addition to these benefits to be anticipated from a rigorous and continuing program of dust abatement at the Manville Plants, this approach offers the principle method of reducing and controlling current and predicted Workmen's Compensation costs.

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THRESHOLD LIMIT VALUES FOR 1957

Values are given in the following tabulation for the maximum average atmospheric concentration of contaminants to which workers may be exposed for an eight-hour working day without injury to health.

These values are based on the best available information from industrial experience, from experimental studies, and, when possible, from a combination of the two. They are not fixed values but are reviewed annually by the Committee on Threshold Limits for changes, revisions, or additions as further information becomes available. Threshold Limits should be used as guides in the control of health hazards and should not be regarded as fine lines between safe and dangerous concentrations. They represent only conditions under which it is felt workers may be repeatedly exposed, day after day, without adverse effect on their health. The figures listed refer to average concentrations of an eight-hour working shift rather than a maximum which is not be be exceeded even momentarily. The amount by which these figures may be exceeded for short periods during the work day depends upon a number of factors such as the nature of the contaminant, whether very high concentrations even for short periods produce acute poisoning, whether the results are cumulative, the frequency with which high values occur and for what periods of time. All must be taken into consideration in arriving at a decision as to whether a hazardous situation is deemed to exist.

These values are not intended for use, or for modification for use, in the evaluation or control of community air pollution or air pollution nuisances.

ESTABLISHED VALUES

Gases and Vapors

Substance	PPM (a)	Substance	PPM (a)
Acetaldehyde	200	Cellosolve (2-ethoxyethanol)	200
Acetic Acid	10	Cellosolve acetate (2-ethoxyethyl acetate)	100
Acetic anhydride	5	Chlorine	1
Acetone	1,000	Chlorine Trifluoride	0.1
Acrolein	0.5	Chlorobenzene (monochlorobenzene)	75
Allyl alcohol	5	Chloroform (trichloromethane)	100
Allyl chloride	5	1-Chloro-1-nitropropane	20
Allyl propyl disulfide	2	Chloropicrin	1
Ammonia	100	Chloroprene (2-chloro-1,3-butadiene)	25
Amyl acetate	200	Cresol (all isomers)	5
Amyl alcohol (isoamyl alcohol)	100	Cyclohexane	400
Aniline	5	Cyclohexanol	100
Arsine	0.05	Cyclohexanone	100
•Benzene (benzol)	25	Cyclohexene	400
Benzyl chloride	1	Cyclopropane	400
Bromine	1	Decaborane	0.05
Butadiene (1,3-butadiene)	1,000	Diacetone alcohol (4-hydroxy-4-methyl-2-pentanone)	50
Butanone (methyl ethyl ketone)	250	Dibroane	0.1
Butyl acetate (n-butyl acetate)	200	o-Dichlorobenzene	50
Butyl alcohol (n-butanol)	100	Dichlorodifluoromethane	1,000
Butylamine	5	1,1-Dichloroethane	100
•Butyl cellosolve (2-butoxyethanol)	50	1,2-Dichloroethane (ethylene dichloride)	100
Carbon dioxide	5,000	Dichloroethyl ether	15
Carbon disulfide	20	1,2-Dichloroethylene	200
Carbon monoxide	100		
Carbon tetrachloride	25		

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Substance	PPM (a)
Dichloromonofluoromethane	1,000
1,1-Dichloro-1-nitroethane	10
Dichlorotetrafluoroethane	1,000
Diethylamine	25
Difluorodibromoethane	100
Diisobutyl ketone	50
Dimethylaniline (N-dimethylaniline)	5
Dimethylsulfate	1
Dioxane (diethylene dioxide)	100
Ethyl acetate	400
Ethyl acrylate	25
Ethyl alcohol (ethanol)	1,000
Ethylamine	25
Ethylbenzene	200
Ethyl bromide	200
Ethyl chloride	1,000
Ethyl ether	400
Ethyl formate	100
Ethyl silicate	100
Ethylene chlorohydrin	5
Ethylene diamine	10
Ethylene dibromide (1,2-dibromo-ethane)	25
Ethylene imine	5
*Ethylene oxide	50
Fluorine	0.1
Fluorotrichloromethane	1,000
Formaldehyde	5
Furfural	5
Gasoline	500
Heptane (n-heptane)	500
Hexane (n-hexane)	500
Hexanone (methyl butyl ketone)	100
Hexone (methyl isobutyl ketone)	100
Hydrazine	1
Hydrogen bromide	5
Hydrogen chloride	5
Hydrogen cyanide	10
Hydrogen fluoride	3
Hydrogen peroxide, 90%	1
Hydrogen selenide	0.05
Hydrogen sulfide	20
Iodine	0.1
Isophorone	25
Isopropylamine	5
Mesityl oxide	50
Methyl acetate	200
Methyl acetylene	1,000
Methyl acrylate	10
Methyl alcohol (methanol)	200
Methyl bromide	20
Methyl cellosolve (2-methoxy-ethanol)	25
Methyl cellosolve acetate (ethylene glycol monomethyl ether acetate)	25
Methyl chloride	100
Methylal (dimethoxymethane)	1,000
Methyl chloroform (1,1,1, trichloroethane)	500
Methylcyclohexane	500
Methylcyclohexanol	100
Methylcyclohexanone	100
Methyl formate	100
Methyl isobutyl carbinol (methyl amyl alcohol)	25
Methylene chloride (dichloromethane)	500
Naphtha (coal tar)	200
Naphtha (petroleum)	500
Nickel carbonyl	0.001
Nitric acid	5
p-Nitroaniline	1
Nitrobenzene	1
Nitroethane	100
Nitrogen dioxide	5
Nitroglycerin	0.5
Nitromethane	100
2-Nitropropane	50
Nitrotoluene	5
Octane	500
Ozone	0.1
Pentane	1,000
Pentanone (methyl propyl Ketone)	200
Perchlorethylene (tetrachloroethylene)	200
Phenol	5
Phenylhydrazine	5
Phosgene (carbonyl chloride)	1
Phosphine	0.05
Phosphorus trichloride	0.5
Propyl acetate	200
Propyl alcohol (isopropyl alcohol)	400
Propyl ether (isopropyl ether)	500
Propylene dichloride (1,2-dichloro-propane)	75
Propylene imine	25
Pyridine	10
Quinone	0.1
Stibine	0.1
Stoddard Solvent	500
Styrene monomer (phenylethylene)	100
*Sulfur dioxide	5
Sulfur hexafluoride	1,000
Sulfur monochloride	1
Sulfur pentafluoride	0.025
p-Tertiarybutyltoluene	10
1,1,2,2-Tetrachloroethane	5
Tetrahydrofuran	200

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Substance	PPM (a)	Substance	PPM (a)
Tetranitromethane	1	Trifluoromonobromomethane	1,000
Toluene (toluol)	200	Turpentine	100
o-Toluidine	5	Vinyl chloride (chloroethylene)	500
Trichloroethylene	200	Xylene (xylol)	200

TOXIC DUSTS, FUMES AND MISTS

Substance	Mg. per Cu. M(b)	Substance	Mg. per Cu. M.(b)
Aldrin (1,2,3,4,10,10-hexachloro-1,4,4a, 5,8,8a-hexahydro-1,4,5,8-dimethano-naphthalene)	0.25	Mercury	0.1
Ammate (ammonium sulfamate)	15	Mercury (organic compounds)	0.01
Antimony	0.5	Methoxychlor (2,2-di-p-methoxyphenyl-1,1,1-trichloroethane)	15
ANTU (alpha-naphthyl-thiourea)	0.3	Molybdenum	
Arsenic	0.5	(soluble compounds)	5
Barium soluble compounds	0.5	(insoluble compounds)	15
Cadmium oxide fume	0.1	Nicotine	0.5
Chlordane (1,2,4,5,6,7,8,8-octachloro-3a,4,7,7a-tetrahydro-4,7-methanoidine)	2	Parathion (O,O-diethyl O-p-nitrophenyl thiophosphate)	0.1
Chlorinated camphene, 60%	0.5	Pentachloronaphthalene	0.5
Chlorinated diphenyl oxide	0.5	Pentachlorophenol	0.5
Chlorodiphenyl (42% chlorine)	1	Phosphorus (yellow)	0.1
Chlorodiphenyl (54% chlorine)	0.5	Phosphorus pentachloride	1
Chromic acid and chromates (as CrO_3)	0.1	Phosphorus pentasulfide	1
Crag herbicide (sodium 2-(2,4-dichloro phenoxy) ethanol hydrogen sulfate)	15	Picric acid	0.1
Cyanide (as CN)	5	Pyrethrum	2
2,4-D (2,4-dichlorophenoxyacetic acid)	10	Rotenone	5
DDT (2,2-bis(p-chlorophenyl)-1,1,1-trichloroethane)	1	Selenium compounds (as Se)	0.1
Dieldrin (1,2,3,4,10,10-hexachloro-6,7-epoxy-1,4,4a,5,6,7,8,8a-octahydro-1,4,5,8-dimethano-naphthalene)	0.25	Sodium hydroxide	2
Dinitrobenzene	1	Sodium fluoroacetate (1080)	0.1
Dinitrotoluene	1.5	Strychnine	0.15
Dinitro-o-cresol	0.2	Sulfuric acid	1
EPN (O-ethyl O-p-nitrophenyl thiono-benzenephosphonate)	0.5	TEDP (tetraethyl dithionopyrophosphate)	0.2
Ferbam (ferric dimethyl dithiocarbamate)	15	TEPP (tetraethyl pyprophosphate)	0.05
Ferrovanadium dust	1	Tellurium	0.1
Fluoride	2.5	Tetryl (2,4,6-trinitrophenylmethyl-nitramine)	1.5
HETP (hexaethyl tetraphosphate)	0.1	Thiram (tetramethyl thiuram disulfide)	5
Hydroquinone	2	*Thallium (soluble compounds)	0.1
Iron Oxide Fume	15	Titanium dioxide	15
*Lead	0.2	Trichloronaphthalene	5
Lead arsenate	0.15	Trinitrotoluene	1.5
Lindane (hexachlorocyclohexane gamma isomer)	0.5	Uranium	
Magnesium oxide fume	15	(soluble compounds)	0.05
Malathion (O,O-dimethyl dithiophosphate of diethyl mercaptosuccinate)	15	(insoluble compounds)	0.25
Manganese	6	Vanadium	
		(V_2O_5 dust)	0.5
		(V_2O_5 fume)	0.1
		Warfarin (3-(a acetonylbenzyl)-4-hydroxycoumarin)	0.5
		Zinc oxide fumes	15
		Zirconium compounds (as Zr)	5
		Calcium arsenate	0.1

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MINERAL DUSTS

Substance	MPPCF(c)	Substance	MPPCF(c)
Aluminum oxide	50	Silica	
Asbestos	5(d)	high (above 50% free SiO_2)	5
Dust (nuisance, no free silica)	50	medium (5 to 50% free SiO_2)	20
Mica (below 5% free silica)	20	low (below 5% free SiO_2)	50
Portland cement	50	Silicon carbide	50
Talc	20	Soapstone (below 5% free SiO_2)	20

TENTATIVE VALUES

Substance	PPM(f)	Approx.Mg. Per Cu. M.(e)
Acetylene tetrabromide	1	14
Allyl glycidyl ether (AGE)	10	45
Beryllium		2y/m3
Boron trifluoride	1	3
n-Butyl glycidyl ether (BGE)	50	270
Butyl mercaptan	10	35
Chloracetaldehyde	1	3
Chlorobromomethane ($ClBrCH_2$)	400	2,100
Diglycidyl ether (DGE)	10	55
Dimethyl formamide	20	60
Dipropyleneglycolmethylether	100	600
Ethyl mercaptan	250	640
Furfuryl alcohol	50	200
Glycidol	50	150
Isopropyl glycidyl ether (IGE)	50	240
Lithium hydride		25y/m3
Methyl mercaptan	50	100
a Methyl styrene	100	480
Monomethyl aniline	2	9
Paradichlorobenzene	75	450
Perchloromethyl mercaptan	0.1	0.8
Phenyl glycidyl ether (PGE)	50	310
Propylene oxide	100	240
Tertiary butyl alcohol	100	300
Tolylene-2,4-diisocyanate	0.1	0.7
Triethyl amine	25	100
Vinyl toluene	100	480
Yttrium and inorganic compounds		
Xylidine	5	25
ee Teflon decomposition products	0	0
ee Pentaborane (B_5H_9)	0	0
Per & Tri Chloroethylene	100	

*Change in threshold limit values.

**Until more data are forthcoming, it is important that atmospheric concentrations of these materials to which workers are exposed must be kept as near 0 as possible.

Adopted at the Nineteenth Annual Meeting of the American Conference of Governmental Industrial Hygienists, St. Louis, April 23, 1957.

Return to Law H

NOISE THRESHOLD LIMIT

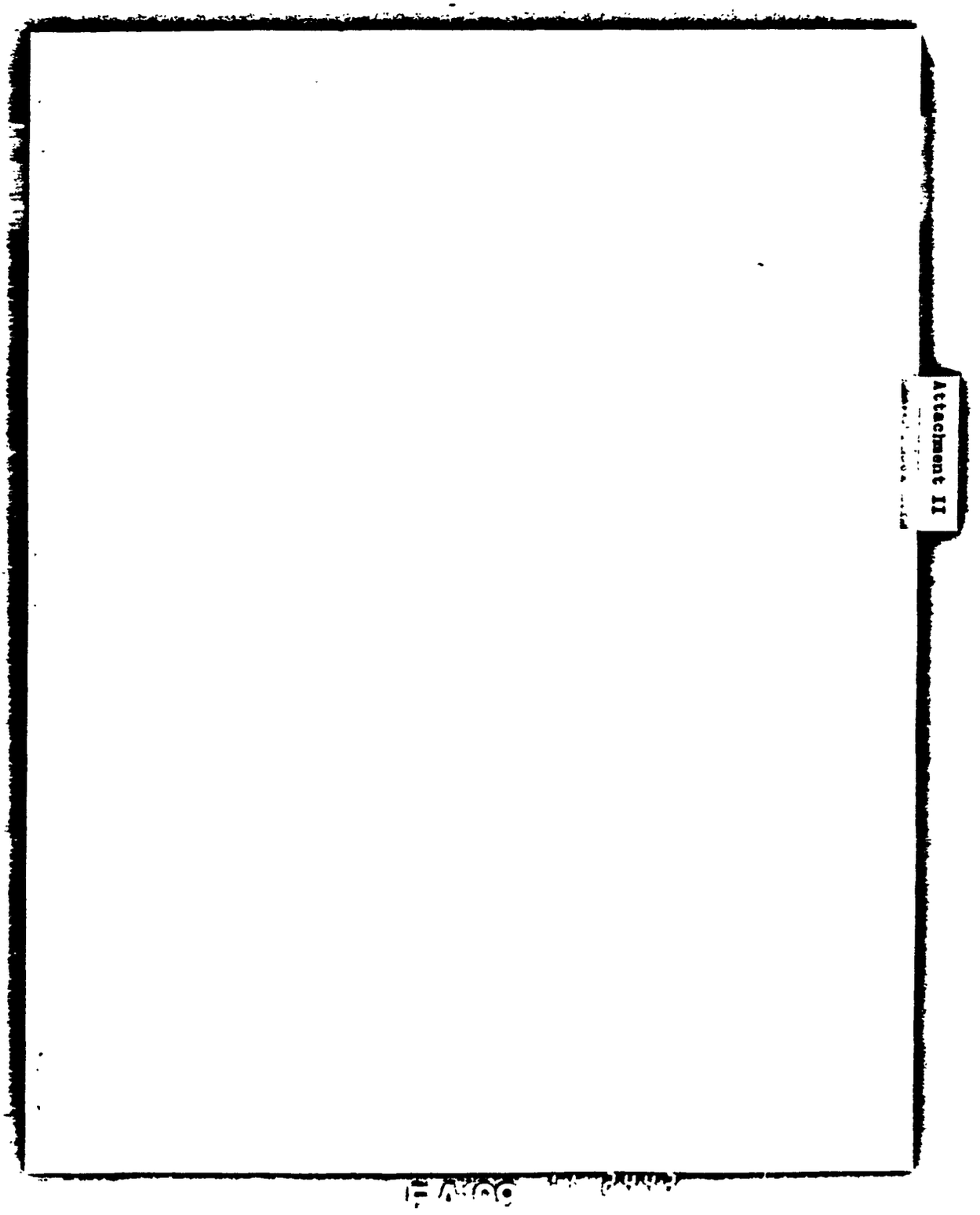
J-M standard is 95 decibels in each octave band between 300 and 10,000 cycles per second.

Radioactivity: For permissable concentration of radioisotopes in air, see "Maximum Permissable Amounts of Radioisotopes in the Human Body and Maximum Permissable Concentrations in Air and Water", Handbook 52, U. S. Department of Commerce, National Bureau of Standards, March 1953. In addition, see "Permissable Dose from External Sources of Ionizing Radiation", Handbook 59, U. S. Department of Commerce, National Bureau of Standards, September 24, 1954.

(a) Parts of vapor or gas per million parts of air by volume.
(b) Milligrams of dust, fume or mist per cubic meter of air.
(c) Millions of particles per cubic foot of air.
(d) J-M standard applied to asbestos exposure is 1 million fibres per cubic foot.
(e) Approximate milligrams per cubic foot of air.
(f) Parts of substance per million parts of air by volume.

Complete revision.

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To Be Made Effective:

Immediately **Executiv** 6 Revised

, 1957

Evaluation of Industrial Hazards

In order to safeguard the health of employees and residents of the community, through control of industrial health hazards, it is essential that we obtain continuous, dependable and objective data on plant and mine conditions that may create such exposure.

Control of an industrial health hazard and other liabilities arising from industrial wastes is usually complex because of the many factors involved. For that reason, effective, overall solution usually calls for the combined skills and judgment of a number of specialists in our Company.

Recent experience in Johns-Manville has proved the merit of a coordinated "task team" approach to evaluating situations that are potentially a health hazard or community problem for their control or elimination.

Therefore, on all problems related to prevention or abatement of industrial hazards it will be J-M practice to use the task team method. This team is to prepare a thorough analysis and evaluation of all such problems and projects for their solution.

The Plant or Mine Manager will appoint the task team from the following sources:

A methods engineer from the Industrial Engineering Department.
The safety engineer or individual responsible for plant safety.
The production superintendent or production supervisor concerned.
An engineer from Plant Engineering or Maintenance Department.

When investigating a hazard involving community relations, the task team, through the Plant or Mine Manager, will keep informed the office of the General Attorney and the Director of Public Relations, using their specialized assistance as needed. Final recommendations for the solution of the problem will include comments by the legal and public relations responsibilities.

The Plant Manager assigns the project and designates who will be responsible for coordination within the task team and who will be responsible for completion of the project to make effective policies outlined in President's Bulletin 124, dated April 5, 1957, on "External and Internal Aspects of Dust and Fume Abatement."

The manner in which the task team proceeds with its assignment is outlined in detail in the Industrial Health Section of the Standard Practices Manual; see subject revised IH-96, copy of which is attached.

K. W. Huffine

Attachment (IH-96)

TO: 101, 104, 471, 474, 511, 512, 52, 551
H. W. Allen, H. M. Jackson

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To Be Made Effective:

Immediately

Executive Bulletin

33-26 Revised

May 6, 1957

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Attachment (IH-96)

TO: 101, 104, 471, 474, 511, 512, 52, 551
E. W. Allen, E. M. Jackson

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*Evaluation of Industrial Hazards
Task Team Survey Method - Plant

1. Foreword

Executive Bulletin 33-26 established the "task team" approach to the evaluation * of projects for dust and fume control. The revision of May 6, 1957 expanded the application of the task team method to all industrial hazards, and included provision for foreseeing and endeavoring to prevent legal and/or community relations problems.

* Industrial hazards should be understood to include those created, for example, by dust, fumes, vapors, gases, noise, heat and effluence.

* 2. Coordination with General Attorney and Public Relations

The plant manager (or Assistant to the Vice President for Production where appropriate) is responsible for keeping informed the General Attorney and the Director of Public Relations, GHQ, or their delegates.

3. Selection of Task Team

The plant manager assembles a task team from some or all of the following personnel. Members of the task team are designated hereafter by the initials indicated, for the sake of brevity.

ME - Methods engineer from Industrial Engineering Department

SE - Safety engineer, or person responsible for safety at plant

PS - The production superintendent or other production supervisory person concerned

PE - Engineer from Plant Engineering or Maintenance Department

4. Responsibility of Task Team and of Individual Members

The function of the task team is to conduct and prepare a thorough analysis, and an evaluation of the project. Work of the task team continues until the condition is satisfactory.

- m o r e -

This subject is distributed not only to holders of the Manual of Standard Practices, but also as an attachment to Bulletin 33-26, Revised May 6, 1957, "Evaluation of Industrial Hazards" to 101, 104, 471, 474, 511, 512, 52, 551, H. W. Allen, H. M. Jackson

* Revision X

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IH-96, pg. 3, 5-6-57 (Cancels IH-96, pg. 3, 7-1-55)

5. Outline of Procedure by Task Team (cont,)

C. If major equipment changes are recommended

a. ME prepares the project description from data accumulated by the task team and gives it to the plant manager. Project description and the accumulated data are forwarded by the plant manager to division production engineer#. When approved, division production engineer# issues project assignment to General Plant Engineering Department through Director of Engineering ~~Department through Director of Engineering~~, and informs the plant manager of his action.

b. Copy of the project description and all accumulated reports and data on the study are forwarded to General Plant Engineering Department with the assignment.

c. General Plant Engineering Department prepares project specifications for the division approval.

d. General Plant Engineering Department writes engineering report and appropriation which is submitted to division for approval through usual procedure.

e. General Plant Engineering Department arranges for the installation of equipment and supplies the division with recommended maintenance and equipment operation procedures.

f. When General Plant Engineering Department advises division that installation is completed, equipment or operation should be operated for as long as necessary to become stabilized. ME with concurrence of PE and General Plant Engineering Department decides when operation is stabilized.

g. ME, SE, PE, and General Plant Engineering Department agree on any minor equipment and/or methods changes that may be evidenced in the course of stabilization.

h. When all new equipment is working and operation completely stabilized, SE requests technician to repeat survey and evaluation.

i. If survey results are not satisfactory, General Plant Engineering Department and ME determine source of contaminant, by additional surveys if necessary, and agree on minor revisions to equipment, additional equipment, etc. General Plant Engineering Department, with the approval of the division production engineer#, arranges for the revisions or additions to equipment.

- m o r e -

This subject is distributed not only to holders of the Manual of Standard Practices, but also as an attachment to Bulletin 33-26, Revised May 6, 1957, "Evaluation of Industrial Hazards", to 101, 104, 471, 511, 512, 52, 551, H. W. Allen, H. M. Jackson

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5. Outline of Procedure by Task Team (cont.)

j. If further major changes are necessary, General Plant Engineering Department prepares amendment to project specification for division approval

k. Repeat f through j until hygiene survey results are satisfactory.

l. When satisfactory condition is achieved, prepare report as in 5-E below.

D. Nuisance conditions

a. Substitute for survey techniques - For conditions involving nuisance contamination only, with no hygienically important exposure, the approach to dust and fume abatement and control will be as above except that the usual survey techniques, 5-A-b, are not applicable. In place of those techniques, an evaluation of the extent of the problem and of the effectiveness of controls should be made through:

(1) Photographs
(2) Data re frequency of nuisance condition
(3) List of employee complaints and grievances

b. When satisfactory condition is achieved, prepare report as in 5-E below.

E. Report of project

a. ME prepares a close-out report containing summary of:

(1) What was accomplished
(2) The changes which were recommended and installed (in sufficient detail to establish standard methods of operation)
(3) Recommendations for routine follow-up hygiene surveying
(4) Comment from General Attorney, and from Director of Public Relations, when appropriate.

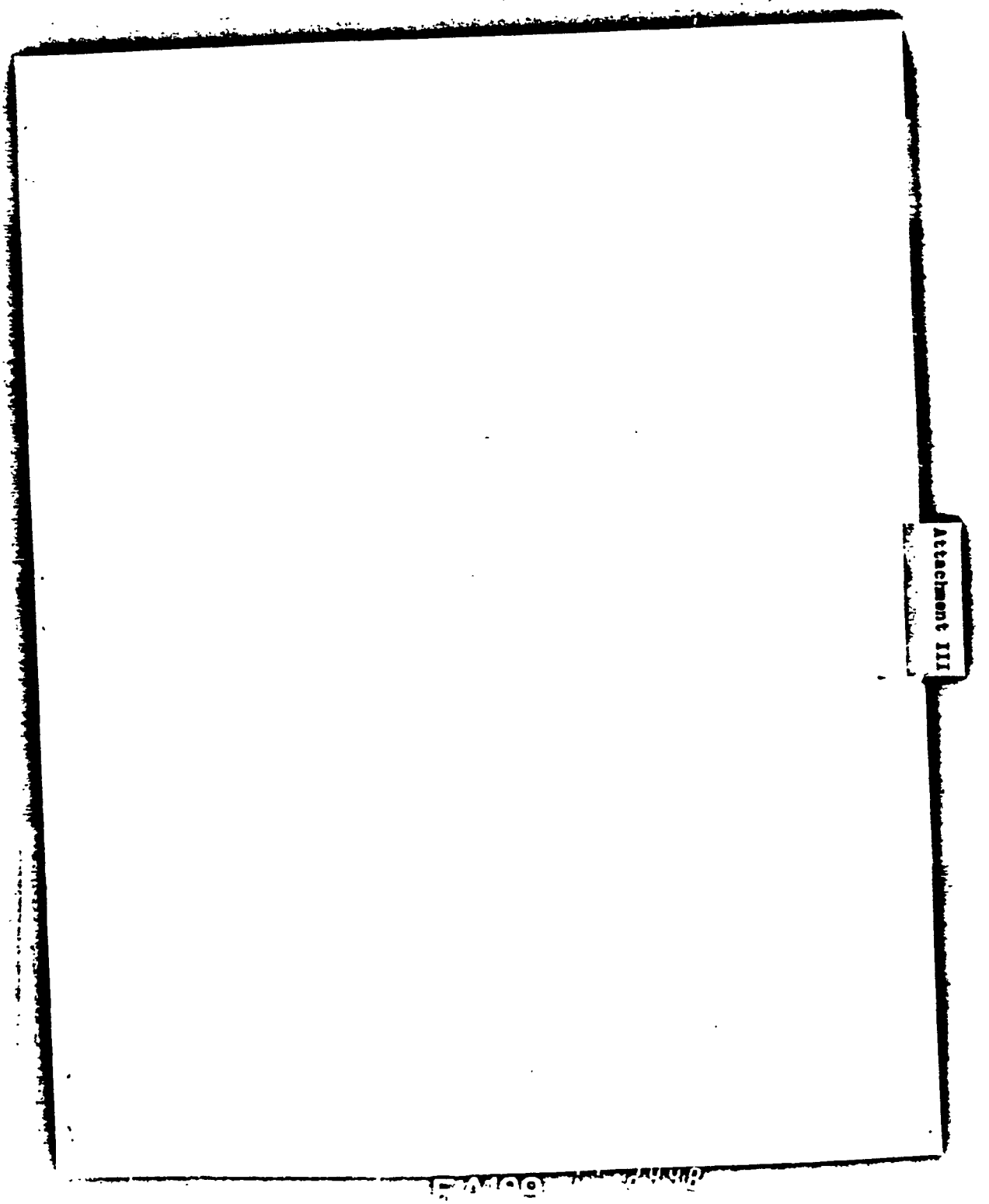
• b. Distribution - Copies of report are sent to plant manager, Manager of Industrial Health Program, division production engineer#, General Plant Engineering Department if major project has been involved, also to General Attorney if the report contains a comment from him, and to Director of Public Relations if the report contains a comment from him.

E N D

• Revision

Or, if none, the division production manager.

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INDUSTRIAL ENGINEERING DEPARTMENT
JOHNS-MANVILLE

Lompoc Plant

Report No. 700-FO-204

Page No. 1

Date November 4, 1957

Subject: LOMPOC DUST ABATEMENT PROJECTS
MONTHLY PROGRESS REPORT
OCTOBER 1957

I. GENERAL

Dust abatement projects on which the outstanding progress was made during October are listed below:

A. Preliminary Investigation

1. Empty Pallet Cleaner.
2. Bag Air Washer - No. 4 K.E. Packing Station.

B. Design and Construction of Approved Projects

1. Ventilated Personnel Blow-Off Booths.
2. Test Mechanical Shakers - Sly Co. Collector - Gen. Waste.
3. General - Improvements of Open Baghouses.

C. Evaluation of Completed Projects

1. Brick Press House Ventilation.
2. Ventilation & Vacuum Systems for the Aggregate Plant.

II. PROJECT SUMMARY

Attached is a complet list of all major projects currently in progress and planned for the near future, showing status and work accomplished during the past month.

DISTRIBUTION:

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Prepared by P. M. Pisano Requested by O. B. Westmoot Approved H. G. Thompson

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Lompoc Plant
April 16, 1958

GENERAL HOUSEKEEPING INSPECTION

To all Department Heads:

1155 WAREHOUSE: Excellent.

SUPER-CEL: Down. Very good.

COLLECTORS: All that were operating were performing properly.

WET BAGHOUSES: Very good.

POWDER MILLS: Very good to excellent except clean up needed in the Sno Floss Plant at elevation 472 and around the #3 Packer empty pallet storage area.

E-P PLANT: Down. Excellent.

TUNNEL "A" & CRUSHING PLANT: Excellent

1118 WAREHOUSE: Excellent.

DRY BAGHOUSES: Very good to excellent.

R & R: Shops-excellent. Outside areas-excellent.

SILICATE PLANT: Dry end good to very good. Wet end excellent.

BRICK PLANT: Excellent.

QUALITY CONTROL: Excellent.

SUMMARY: Areas inspected generally excellent. It is quite apparent there is a steady increase in the housekeeping efforts in all departments.

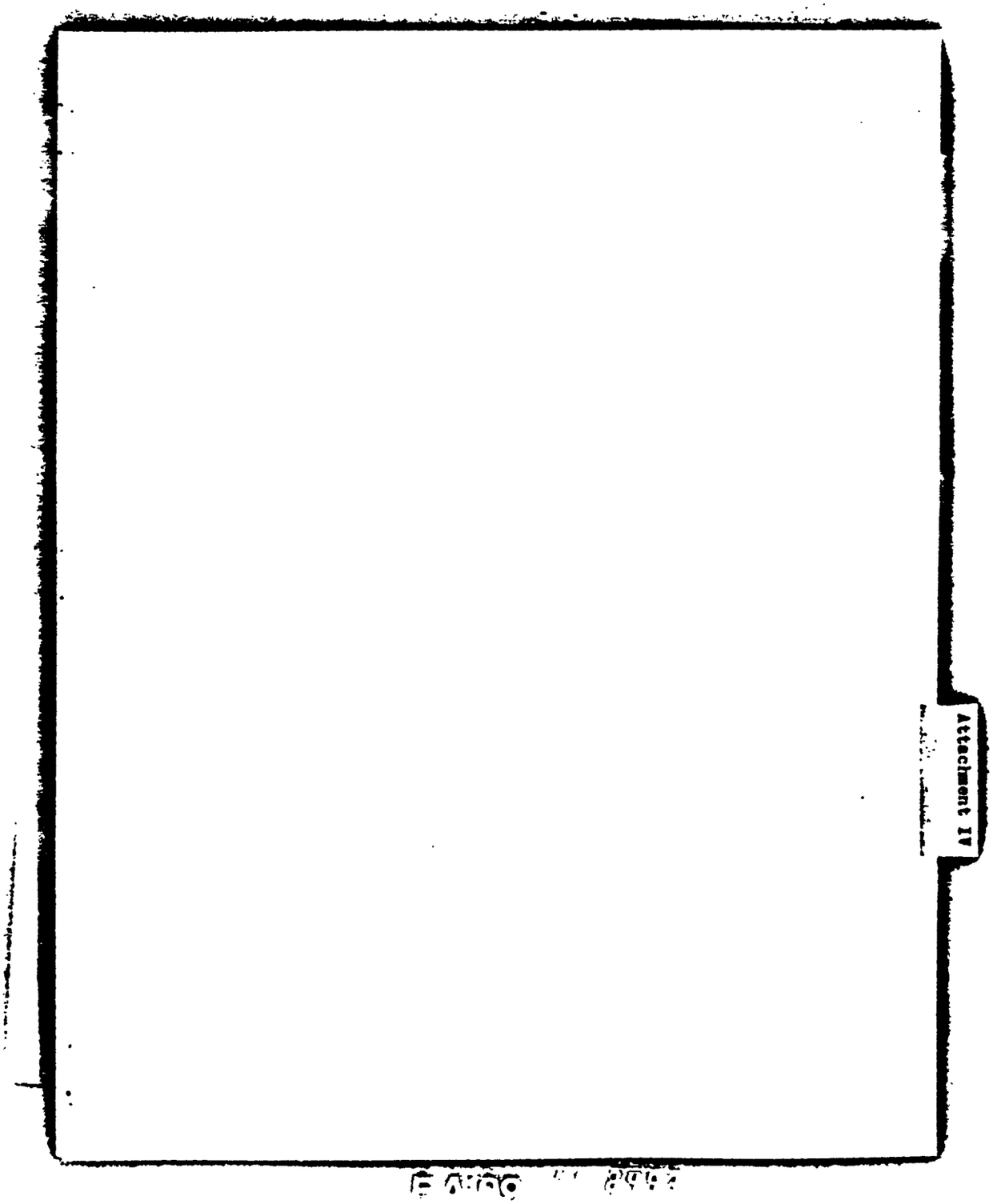
W. P. Capehaw
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The amount expended for sweeping and cleaning labor in 'Shipping Cost' is relatively constant, which is due to fixed schedule for operation of the mobile vaccum cleaner. This cost will be reduced considerably when we change to single shift loading of powder products.

O. B. Westmont

cc: Dr. K. W. Smith
H. M. Jackson
C. C. Schuknecht
R. D. Newcomb
File



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INDUSTRIAL ENGINEERING DEPARTMENT
JOHNS-MANVILLE
Lompoc Plant

Report No. 592-BP-36
Page No. 1
Date January 18, 1955

Subject: RENOVATION AND VENTILATION OF THE PELLET PLANT
APPROPRIATION 983-IR-127
CLOSE-OUT REPORT

I. SCOPE OF PROJECT

1. Object

Appropriation 983-IR-127 was approved for the installation of dust collecting systems at the Mortar Plant, Pellet Plant and Tunnel Kiln Car blow-off station, and for the replacement of the Mortar Plant mixing and packing equipment. The vent[illegible] systems to have a common baghouse of the enclosed type, with automatic stocking shakers and a capacity of 25,000 c.f.m., which would be adequate to ventilate an additional mixer and packer at the Mortar Plant.

This report covers the ventilation of the Pellet Plant and Tunnel Kiln Car blow-off only. A Close-Out Report was prepared for the Mortar Plant vent[illegible] and equipment replacement July 29, 1954. (Report No. 567-BP-35.)

2. Purpose

The purpose of installing dust control equipment in the Pellet Plant area was to reduce dust concentrations in this area to within allowable limits and to improve working conditions and housekeeping.

II. VENTILATING EQUIPMENT INSTALLED IN THE PELLET PLANT AREA

1. The following equipment in the Pellet Plant was provided with ventilation:

   (a) Mixer Hopper
   (b) Bucket Elevator
   (c) Pellet Breaker & Screener

2. Piping was extended to the existing Tunnel Kiln Car blow-off hood to exhaust the air through the dust collector.

III. EVALUATION BY THE DUST ABATEMENT TASK TEAM

1. Mechanical Changes - Completed

The Task Team started work on this project in June 1954. Some hood changes were made immediately to improve dust control and to simplify the work.

The immediate changes were:

(a) Mixer hopper hood revised to eliminate the doors over the hopper, provide adequate head room for the operator to dump bags, improve air movement over the hopper - thus giving better dust control and all flat surfaces were eliminated to prevent spillage from collecting around the hopper opening.

(b) Minor changes were made in the pellet breaker that reduced dust emission from this equipment.

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Final Task Team recommendations were presented in a Methods Analysis Summary September 16, 1954.

The final changes were:

(a) A hood was provided at the pellet breaker hopper.

(b) A hood was installed at the edge of the pellet dryer car tracks where pellets are removed from the dryer cars and charged into the pellet breaker.

(c) A switch damper was installed in the 11½ inch diameter duct leading to the Tunnel Kiln Car blow-off hood and branch duct work was installed to provide exhaust at items (a) & (b), above.

(d) A second set of water jets was installed in the mixer hopper to reduce dust emission from the jet action of the water striking the powders.

(e) The pellet breaker hopper was lowered 18" to simplify charging.

(f) The Tunnel Kiln Car blow-off hood was provided with a canopy, canvas side curtains and the plates on the hood sides were enlarged to prevent dust from being blown beyond the range of the hood.

2. Suggested Changes to Methods

(a) When cleaning the Tunnel Kiln Car, blow-off the top of the car only.

(b) Stop each car under the hood before blowing off. (Relocate the control button to simplify this step).

(c) When vacuum facilities are available, vacuum the car tops before blowing off; or vacuum the cars as an alternate to blowing off and retire the blow-off equipment.

3. Long Term Possibility

(a) If production rates increase sufficiently; continuous drying, screening and calcining of pellets should be re-investigated for cost reduction.

IV. DUST COUNTS

1. Dust Counts Before Ventilation Installed (U.S. Public Health Service dust survey - 1953)

JM Sta. No. PP-1 - Loading Mixer Hopper - 23.3, 26.1, 31.2, 125.0 m.p.p.c.f.
JM Sta. No. PP-3 - Handling Wet Pellets - 3.7, 5.8, 9.2, 10.0 40.2 m.p.p.c.f.
JM Sta. No. PP-4 - Screening & Handling Dry Pellets - 5.8, 8.6, 15.3, 25.4, 25.7, 26.9 m.p.p.c.f.

2. Recent Dust Counts (Dust Abatement Task Team dust survey - 1954 - 1955)

The most recent dust counts (Dwg. No. SK-13-2) and sample station chart (Dwg. No. B-122-69) are attached. These recent dust counts show that the area now meets the specifications recommended by the U.S. Public Health Service and the State of California Bureau of Adult Health.

The only station that may be questioned is the Tunnel Kiln Car blow-off but this operation only takes place 10-15 minutes per 8 hour shift and improvements should result from vacuuming the cars, when vacuum facilities are available. Another improvement should result from positioning and stopping each car under the hood instead of blowing off the cars while they are still moving.

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