# **TIPS FOR MANAGING** Dangerous Dust in Manufacturing Facilities

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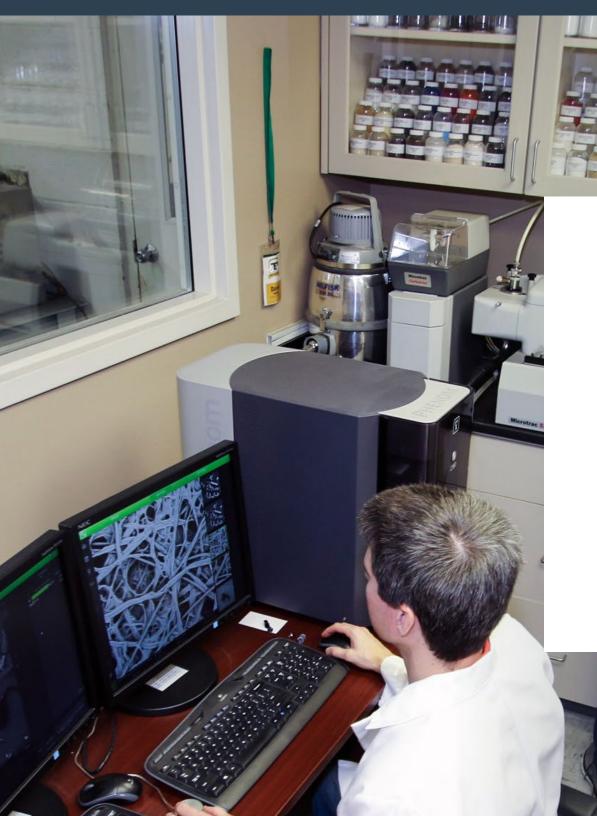
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Manufacturing facilities must be diligent in controlling hazardous dust in order to ensure worker safety, proper equipment performance and regulatory compliance.

To maintain a clean and safe work environment, airborne dusts must be captured and contained. This is done by constantly circulating "dirty" air through an industrial dust collection system to filter out the dust particles. After the dust is removed from the air, the clean air is safely returned indoors or exhausted outdoors.

A well-designed and maintained dust collection system cost-effectively captures and contains all hazardous contaminants and nuisance dust generated during manufacturing processes. This eBook covers important considerations when creating a dust management plan for your facility.





### CONDUCT A DUST HAZARD ANALYSIS

Performing a dust hazard analysis (DHA) is the best way to evaluate your facility's risk for employee exposure and is a required task per NFPA 652 if there is a combustible dust hazard.

Get to know all the dust you generate by:

- Conducting a dust analysis to identify all the dust characteristics
- Completing dust explosivity testing
- Having an industrial hygiene or environmental engineering assessment performed

OSHA's General Duty Clause, Section 5(a)(1), stipulates that it's an employer's responsibility to identify and abate hazards in the workplace. OSHA also requires employers to keep records of these dusts, and it provides guidelines on <u>hazard identification and assessment</u>.

### TEST FOR EXPLOSIVENESS AND FLAMMABILITY

National Fire Protection Association (NFPA) standards 652 and 654 require a combustible dust hazard analysis (DHA) to assess risk and determine the necessary fire and explosion protection.

Facilities producing combustible dust during their processes must complete a DHA by the fall of 2020 and demonstrate reasonable progress toward completion of the DHA each year before the deadline.

**The first step is to determine whether your dust is explosive.** The results found in your dust explosivity testing should include the Kst and Pmax, which indicate the amount of pressure an explosion can generate and how fast it can travel. NFPA classifies dusts according to explosibility in terms of their Kst values and by type—organic or metal.

Kst is the normalized maximum rate of explosion pressure rise, measured in bar m/s. A bar is a metric unit of pressure, which is slightly less than the average atmospheric pressure on earth at sea level. Your dust collection equipment supplier will need the Kst and Pmax values to correctly size explosion venting and suppression systems.

Facilities producing combustible dust must complete a DHA by the FALL OF 2020

#### **Combustible Dust Classifications**

Dust Explosion Class	Kst	Characteristic
St-0	0	Not Explosible
St-1	≤200	Weak to Moderately Explosible
St-2	201-300	Strongly Explosible
St-3	>300	Very Strongly Explosible

#### **Combustible Dust Properties**

- Kst Deflagration index (bar-m/s)
- Pred Reduced pressure after venting (bar)
- Pstat Vent static burst pressure (psi)
- **Pmax** Max pressure for an unvented dust explosion (bar)
- (dp/dt) Rate of pressure rise (bar/s or psi/s)
- **Pes** Enclosure strength = 2/3 of yield strength of weakest part or 2/3 of ultimate strength if deformation is allowed



### ASSESS EMPLOYEE EXPOSURES AND ASSESS DUST HAZARDS

An industrial hygiene assessment helps you identify and control harmful exposures to dusts. This assessment includes evaluating your facility to ensure you are meeting OSHA permissible exposure limits (PELs) for the dusts that your processes produce.

Ask your dust collection equipment supplier to recommend an industrial hygienist or environmental engineering company that is experienced in identifying dusts specific to your operation.

#### **DUST HAZARDS TESTING**

It's also important to analyze dust characteristics to determine the best dust collection system design for your operation. The following dust characteristics are determined by bench testing a sample of your dust:

- Particle size
- Gravity
- Abrasiveness

Dust shape

Moisture level

It's also important to look at whether your dust is a type that tends to generate static electricity. Those types of dusts can be an ignition source for dust explosions. Dust collection equipment suppliers often can conduct dust testing and work with you to specify the best system and required filter media. Dust testing is an excellent tool to better understand the physical properties of your dust, which forms the basis for equipment selection. To create a complete picture of your operation, the testing laboratory should ask for detailed application data.



### **CREATE AIR QUALITY GOALS**

Your dust management program should include air quality goals based on both of the following sources:

- Guidelines found in Industrial Ventilation: A Manual of Recommended Practice for Design from the American Conference of Governmental Industrial Hygienists (ACGIH).
- OSHA regulations regarding the PELs for applicable dusts, particularly where workers are at risk for long-term health effects.

Review the results from your industrial hygiene assessment, OSHA guidelines, explosive dust testing and dust analysis. As you explore solutions to capture and contain dusts, evaluate these methods in order:

Source capture (dust arms, bench hoods and hoods) 1

- Enclosures 2
- Overhead hoods 3
- 4 Ambient ventilation

Addressing employee concerns by listening, observing and questioning your workers is an important part of your assessment. They can let you know if current engineering controls are effectively managing dusts at the facility and suggest areas for improving processes and equipment.

When recirculating the cleaned air Keep below OSHA PELs for contaminants.

#### When exhausting the air outdoors

You are subject to EPA National Emission Standard for Hazardous Air Pollutants (NESHAP) Rule 6X and must perform an EPA Method 22 Fugitive Emission test. The test is conducted using a visual determination of fugitive emissions from exhaust sources and is performed by a trained observer.

### ISOLATE AND CONTAIN TOXIC DUSTS

The best way to reduce workers' exposure to toxic dusts is to install a collection system with high-efficiency primary cartridge-style filters and secondary safety monitoring filters.

Capturing dust at its source prevents it from expanding throughout the plant. You can accomplish this by incorporating extraction arms, hoods or enclosures at the process or workstation. Source capture is extremely effective.

Work to isolate toxic dusts from the rest of the facility and contain them in a specific area. You can also designate these areas to be kept under negative pressure. Often the filtered air can be safely returned into the facility to create an airflow pattern to improve the contaminant control.

If your facility works with materials that are subject to restrictive OSHA particle counts or has set standards that exceed current OSHA PELs, you can expect to pay more for your dust and dust management solution. That's because you'll need to use a highly engineered system, with high-efficiency cartridge filters and HEPA secondary filters for the best control for respirable particulates.





### CONSULT WITH PEERS AND YOUR LOCAL AHJ

Networking with peers is another way to discover processes, equipment and vendors to help you manage airborne dust. Also, consult with professional associations and certification groups. Ask your authority having jurisdiction (AHJ), such as Factory Mutual or local fire marshals, for their safety guidelines.

When selecting an air pollution control supplier, look for one that is experienced in your industry and manufacturing processes as well as knowledgeable about OSHA, NFPA and EPA requirements. The supplier also needs to have the technical resources to develop an engineered solution. They should offer a full range of equipment in order to give unbiased advice on the right type of system for your facility. **The most experienced suppliers also provide testing services and training.** 

## **KEY QUALITIES OF A DUST COLLECTION EQUIPMENT SUPPLIER:**

- Experience in your industry and processes
- Knowledge about OSHA, NFPA and EPA requirements
- Access to technical resources
- Ability to offer a full range of equipment
- Testing services
- Training

### MANAGE CONTAINABLE SOURCES OF DUST

An industrial dust collector designed specifically for your operation is a proven engineering control for hazardous airborne contaminants. There are three general types of cartridge dust collection systems:

#### SOURCE CAPTURE

These systems typically use flexible source capture arms, slotted dust hoods or smaller slotted hoods with side shields on a workbench operation.

#### • ENCLOSURES AND CANOPIES

Hoods are often used if the footprint area is less than 12 feet by 20 feet. Curtains or walls may be added to the sides of a hood to create an enclosure, as long as they don't interfere with workspace. Some applications use a full enclosure over and around the process area.

#### AMBIENT SYSTEMS

You can filter all the air in a shop using one central system or multiple smaller collectors. Ambient systems are often favored for larger work areas involved in multiple operations, but they may require a bank of HEPA safety monitoring filters (also called secondary or after-filters). Secondary filters provide backup protection, particularly where air is returned indoors downstream of the collector. Since ambient systems don't remove dust particles from the breathing zone, personal protection equipment may also be required.





#### DESIGN SYSTEM THAT MINIMIZES OPERATING COSTS

A safe dust collection system can also be very cost-effecive. A properly designed system will **minimize energy usage and operating costs**. For example, system zoning allows you to operate the collection system where it is needed, while other areas can be turned down or shut off.

Incorporating variable speed drives for fans on dust collectors saves energy, because fans run only when required. The variable speed drive produces a steady airflow, because the system only runs the motor as needed to maintain the static pressure setpoint. Also, it automatically reacts to filter loading or movable applications. Having this feature increases reliability, extends filter life, reduces maintenance and saves energy.

### Recirculating the filtered air is an ideal way to save energy and maximize return on investment.

Recirculating heated or air-conditioned air back through the plant instead of venting it outdoors, eliminates the cost of replacing that air. Facilities in all regions of the United States report five- to six-figure annual energy savings, with the greatest savings seen in northern climates that experience longer, colder winters. In addition, you can eliminate the complex EPA paperwork and monitoring procedures involved when dusts are exhausted outdoors.

It is a good idea to use a secondary safety filter when recirculating into your facility to obtain the required OSHA PEL levels.

#### Managing dusts in manufacturing facilities is necessary for the safety and well being of employees and to achieve regulatory compliance.

Conducting proper dust hazard analysis with industrial hygiene assessment, explosive dust testing and dust analysis will help you to develop your dust management plan. Incorporate components that provide flexibility, increase reliability, reduce maintenance and maximize energy savings.

A dust collector system designed specifically for your operation and containing high-efficiency cartridge and secondary filters is an accepted and proven engineering control that filters hazardous respirable particulates and makes indoor environments safer and healthier.

> For further information, contact 1-800-479-6801 or 1-870-933-8048; email filterman@camfil.com or visit www.camfilapc.com.





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