

NEWS FEATURES . . .

VCM-Exposure Standards: Too Tough Too Soon?

After virtually ignoring industry's findings on cancer risk for a decade, the U. S. government is now calling for zero-detectable ambient levels of vinyl chloride monomer (VCM) in plants that make or use it. At hearings this week, some clashes are expected as industry tells why it thinks the timetable should be extended.

Hearings begin tomorrow—June 25th—in Washington on just what level of exposure to vinyl chloride monomer (VCM) can be tolerated by workers without seriously endangering their health. Once again, and ironically in this instance, a clash between government agencies and industry seems inevitable.

The Occupational Safety and Health Administration (OSHA) proposes to set a standard for employee exposure at "zero," as determined by a sampling and analytical method capable of detecting vinyl chloride in concentrations of 1 ppm (with an accuracy of ± 0.5 ppm).

OK, But . . .—VCM manufac-

turers are not basically opposed to reducing exposure levels as much as possible—for example, B. F. Goodrich Chemical Co. (the U. S.'s largest vinyl chloride producer) now operates at levels of about 15 ppm in its polymer plant, and even lower in its monomer facility. What bothers manufacturers is having to achieve, in a telescoped time-period "no detectable level of exposure."

As a Goodrich spokesman explains, "The situation we're facing with vinyl chloride exposure levels is not dissimilar to the zero pollution legislation for controlling water pollution—the final last percentage points are achievable only at enormously high costs."

The irony of this particular situation is that producers of vinyl chloride voluntarily alerted the government of the chemical's involvement in several deaths from liver cancer (angiosarcoma).

In fact, over 13 years ago Dow Chemical Co. reported that longterm VCM exposures of animals to 100 ppm VCM for 4½ to 6 mo. (at the equivalent of "normal working hours") resulted in slight liver damage. At that time, Dow recommended that exposure levels be reduced to 50 ppm, though the government's maximum allowable concentration was 500 ppm. The Dow recommendation was not accepted by the American Conference of Governmental Industrial Hygienists (ACGIH). In 1962, on the basis of work done at Yale University, ACGIH concluded that 500 ppm offered an adequate safety margin for human exposure to VCM, and published 500 ppm as the recommended standard. That same level was also accepted by OSHA as a national standard in 1971.

However, beginning in the mid-1960s, the Manufacturing Chemists Assn. funded an investigation of the possible health dangers involved in VCM manufacture. In mid-1972,

MCA established technical liaison with European researchers who were also investigating the safe-exposure limits of VCM.

One decision by MCA arising from this agreement was to initiate an epidemiological study of VCM/PVC (polyvinyl chloride) workers in the U. S. And in early 1973, MCA signed a contract with Industrial Bio-Test Laboratories, Inc., (Northbrook, Ill.).

In late June 1973, MCA requested a meeting with the National Institute for Occupational Safety and Health; this was arranged for July 17, 1973. A summary of the published toxicity data on vinyl chloride, and other pertinent information, was presented to NIOSH at that time. A physician representing the European researchers reported at the meeting on studies in Europe in which tumors were observed in rats at exposure levels as low as 250 ppm.

Six months later, in January 1974, B. F. Goodrich Chemical Co. informed NIOSH that the deaths of several of its employees from angiosarcoma might have been occupationally related. In the succeeding months, similar reports were made to NIOSH of possibly job-related liver angiosarcoma by Union Carbide Corp., Goodyear Tire & Rubber Co. and Firestone Plastics Co.

In early April, OSHA acted and issued an Emergency Temporary Standard that reduced exposure levels from 500 ppm to 50 ppm, with the understanding that this new standard was to be in effect only until October while the whole question of VCM exposure safety levels was explored more closely.

Timetable Too Fast?—Despite what seems to be a long history of self-investigation and concern by the vinyl chloride industry, this week's scheduled hearings in Washington are expected to spark some clashes. The industry is deeply concerned about the possible economic impact

Photo: Anatole J. Spinn Co.



DEVICE measures VCM exposure by drawing air through sorbent tube.

of a "no detectable level" being established immediately.

In an effort to assess what the costs might be, the Soc. of the Plastics Industry, which is expected to participate in the hearings, has hired Arthur D. Little, Inc., the Cambridge, Mass., consulting firm, to prepare an economic impact survey.

Even the unions concur that economic hardships for workers could result from the proposed standard. However, as Anthony Mazzocchi, legislative director of the Oil, Chemical and Atomic Workers Union (which represents about 1,200 VCM/PVC workers) notes, "The men at Niagara Falls [where Goodrich has a plant] are caught. They're in a dilemma. What's their option? Work and eat today so they can die 20 years from now?" (Goodrich says the morale of its workers is good—men are still applying for jobs on its vinyl chloride line.)

What's Being Done—Simply stated, there are two major areas of concern in a VCM plant—ambient air containing vinyl chloride monomer particles, and the need to periodically enter the reactor vessels for cleaning. Research has indicated that the workers who clean the polymerization reactors by scraping are exposed to VCM concentrations of 600 to 1,000 ppm at hand level.

One monitoring device being looked at with interest is a personal sampling pump, manufactured by Anatole J. Sipin Co. (Although area-monitoring instruments have the advantage of immediate detection, they may not measure exact working conditions.) The Sipin device continuously draws an air sample from a worker's breathing zone through a sorbent tube over an 8-hr working an April of the organic materials breathed by a worker. The personal sample pump was looked at with interest by some Cincinnati-based NIOSH personnel at a meeting on monitoring for VCM, held in Houston.

As for reactor cleaning, GAF Corp. has developed a system whereby a solvent, trademarked M-Pyrol (*n*-methyl-2-pyrrolidone), is pumped through the heating unit and sprayed into the reactor to be cleaned. When about one-quarter full, the reactor is shut off and the

solvent recirculated. The heavy spray of hot solvent absorbs the vinyl chloride monomer and, at the same time, dissolves the PVC residue.

Although PVC itself is considered an unusually inert material, residual monomer can be entrapped within the pores of the polymer. Up to now, the industry has not made it a practice to strip the residual monomer from the polymer. However, work is

now underway to develop the required technology. Experts say that the residual monomer could be dropped by dilution with compounding agents and by the mixing action during such compounding.

Goodrich, for one, is already exploring possible approaches to removing the residual monomer, and plans to set up a pilot operation soon.—JMN

New Catalyst Lowers Polypropylene Costs

Belgium's Solvay has a new catalyst that it claims can cut up to 20% off the capital cost of a polypropylene polymerization plant.

For 20 years, the U.S.'s Hercules and Italy's Montecatini have been battling over patent rights on catalysts used to make polypropylene. But that contest may now be academic: Hercules has just purchased a license from Solvay, and other big polypropylene producers are likely to follow suit.

What Solvay has apparently done is develop a catalyst that is 4-5 times more active than previous choices and yields a product with only 15-20 ppm of titanium catalyst residue. Thus, the expensive alcohol washing and purification steps that have been required to lower the titanium content below 100 ppm are not required.

The Old Way—The standard polypropylene catalyst now on the market uses trichlorinated titanium in the form of hexagonal or cubic crystals. These form tiny nodules or balls that are ball milled to obtain a larger surface for exposure to the monomer. The problem is that relatively large quantities of the catalyst often find their way into the polymer, harming the polymer's thermal and other physical characteristics. Also, the ball-milling process damages the surface of the catalyst crystals, which in turn affects the shape of the polymer particles.

Researchers have tried to over-

come the titanium problem by increasing the catalyst surface area, thus cutting down the amount of catalyst required and thus the amount of carryover. One approach has been the use of porous nodules, but the problem has been that the percent of useless (atactic) polymer has risen from about 6% to 10%, thus negating the benefit of the increased activity.

Solvay's Way—The porous nodule approach was also chosen by Solvay, but with its version the atactic waste is only 4-5%.

Solvay's catalyst takes the form of tiny dense spheres that are 20-40 microns dia.; monomer seeps inside, breaking them into smaller fragments that finally measure only about 60 Å and are composed of 3-4 crystals each. The surface area thus achieved is up to 200 m²/g, vs. only about 4-5 m²/g conventionally.

To make the new catalyst, says the company, a standard trichlorinated titanium product is reduced in an organo-aluminum solution, then a complexing agent is added followed by a dose of quadrichlorated titanium—the very product that usually leads to atactic polymer.

Solvay is building an industrial-scale plant to produce the new catalyst, and is soon to start construction of a 50,000-ton/yr polypropylene plant due onstream by the end of 1975; expansion is planned up to an eventual 100,000 tons/yr. And Hercules has plans for a 100,000-ton/yr polypropylene plant in Belgium. #

ing. A small boiler will back up the solar equipment, but the solar designers, Bridgers and Paxton Consulting Engineers, Inc. (Albuquerque, N.M.), believe the boiler will not be needed in practice.

Colorado Gov. John Vanderhoof has approved a \$736,700 outlay for the heating system, including building insulation and double windows. Some controversy still swirls about the project economics. The architects predict a payback of 10.7 yr on the solar heating system if the price of natural gas rises by 300% between 1973 and 1990. But consulting chemical engineer O. G. Lof, of Denver, believes the economic case-study has flaws, and says the project cannot be justified on economic grounds alone.

A dormant coal-to-gasoline pilot plant comes to life with a new mandate, as the U.S. Office of Coal Research (OCR) engages Fluor Engineers and Constructors to convert the former Project Gasoline pilot plant at Cresap, W. Va., into a multipurpose OCR facility for testing various liquid-fuels-from-coal processes.

Consolidation Coal started up the plant in 1967 as an experimental facility to make gasoline from coal, but it was closed down a few years later due to technical and labor problems. Some of the Project Gasoline technology lives on, however—as part of the underpinning for Old Ben Coal Corp.'s forthcoming \$73-million coal-conversion demonstration venture (*Chem. Eng.*, Dec. 24, 1973, p. 18).

Electron-beam irradiation treats wastewater and sewage sludge in a one-year Massachusetts Institute of Technology feasibility program supported by a \$113,700 grant from the National Science Foundation.

High-energy electrons can kill a wide range of microorganisms, such as viruses, bacteria, molds, algae and protozoa; and electron-beam irradiation already serves to sterilize, e.g., surgical materials. The technique promises an extra benefit when treating wastewater and sludge: the breaking down of complex organic molecules to promote their oxidation.

Similar studies elsewhere have employed nuclear irradiation, including gamma rays, for waste treatment. Indeed, a large-scale operation already started up last year in Germany (*Chem. Eng.*, Oct. 1, 1973, p. 23). But the MIT researchers believe the electron-beam approach is safer (there is no radioactivity), and easier to tailor for treatment situations of a given throughput. If the feasibility study bears fruit, the next step is likely to be a 100,000-gal/d pilot unit at a wastewater-treatment plant.

The latest big ammonia plant to be announced is a \$70-million, 1,200-ton/d facility that W. R. Grace & Co. will design and build near Woodward, Okla. The company believes that the plant, due onstream in mid-1977, has a reliable supply of feed-stock natural gas: from Oklahoma Natural Gas, which in turn recently obtained access to the Anadarko gas basin in western Oklahoma. Nevertheless, gas supply to the plant may be subject to reduction during peak-demand winter periods.

A 400,000-bbl/d oil refinery in Long Island Sound, off Connecticut? That state has a request from Pepco International, Inc., North Chelmsford, Mass., for permission to lease land in the Sound, near the mouth of the Connecticut River, that could accommodate such a large clean-fuels (naphtha and heavy fuel oil) offshore refinery. In negotiating the request, Pepco suggests that the project might pay the state \$2.5 million in annual royalties (presumably in lieu of taxes).

As an input for its decision, Connecticut awaits findings of a taskforce project, due completed late this year, on the implications of petroleum operations in general for the economy and well-being of the state.

Pepco International is elusive, and little information is in hand at presstime

June 24, 1974

about the company. However, this project could shape up as the latest effort by Aristotle Onassis' Olympic Refineries to establish a refinery toehold in New England, after recent environmental rebuffs in, e.g., New Hampshire and Rhode Island. Pepco has indicated to Connecticut that Olympic might become the operating company for the venture.

A plant to make ethylene glycol without intermediate production of ethylene oxide is making the capital-budget-approval rounds at Oxirane Corp.'s headquarters in Princeton, N.J. The proposed Channelview, Tex., plant, which could be making fiber-grade glycol by 1977, uses a process believed to work as follows: ethylene, oxygen and acetic acid react in the liquid phase, and the resulting ethylene glycol diacetate is hydrolyzed to the glycol, plus acetic acid for recycle. The technology is from Halcon International, co-owner of Oxirane.

Initial capacity of the trans-Alaska pipeline may well be doubled, to 1.2 million bbl/d. A major participant—Arco Pipe Line, which now owns 28.08% of the joint oil-company venture—has made that proposal to the other partners. Of the two other main participants, Exxon Pipeline (25.52%) has no comment at presstime, but Sohio Pipeline (28.08%) says it supports the idea. The stepup, which would dovetail with U.S. petroleum-demand projections and make the system more economical, could be implemented by more pumping capacity, plus presumably some additional storage at the pipeline terminus at Valdez, Alaska.

Hand in hand with its proposal, Arco seeks to reduce its ownership to 21%. The difference might well be taken up by Sohio, whose involvement with Alaskan North Slope oil reserves is increasing.

For a recent overview of the trans-Alaska project, with emphasis on engineering aspects, see *Chem. Eng.*, Mar. 18, pp. 42-44.

In Washington . . .

Vinyl chloride draws new attention as an air pollutant, apart from (but related to) the occupational-health hazard it poses as a suspected carcinogen.

In preliminary tests, the Environmental Protection Agency recently found varying minute concentrations of vinyl chloride (typically less than 1 ppm) in ambient air near several vinyl and polyvinyl chloride plants. EPA believes there is no threat to public health. Even so, the agency has (1) asked monomer and polymer manufacturers for data on their vinyl emissions, and (2) urged as a matter of prudence, in light of the cancer problem, that the manufacturers lessen emissions as much as possible. At present, there is no federal pollution-control standard on the monomer.

EPA's present focus is on the vinyl concentration in air. However, the agency has also tested effluent liquid streams, finding typical levels of 3 ppm.

As for latest news on the Occupational Safety and Health Administration's concern over worker exposure to vinyl chloride, see p. 110.

Meanwhile, four new industry-sponsored studies on vinyl chloride and cancer in animals, and the implications for human exposure, are being set up by the Manufacturing Chemists Assn. Expected to cost at least \$400,000, the study-projects will center upon (1) metabolism, (2) teratogenesis (monstrous animal fetuses), (3) chronic inhalation of vinyl chloride at concentrations below 50 ppm., (4) acute inhalation during massive exposure, as might be suffered by persons in the vicinity of a tank-car rupture.

MCA will publicly disclose the program's findings.