

TABLE 2. SIZE OF CONNECTIONS FOR GRINDING AND BUFFING WHEELS

DIAMETER OF WHEELS	MAX. GRINDING SURFACE SQ IN.	MIN. DIAM. OF BRANCH PIPES IN INCHES
Grinding—		
6 in. or less, not over 1 in. thick.....	19	3
7 in. to 9 in., inclusive, not over 1½ in. thick.....	43	3½
10 in. to 16 in., " " " 2 in. ".....	101	4
17 in. to 19 in., " " " 3 in. ".....	180	4½
20 in. to 24 in., " " " 4 in. ".....	302	5
25 in. to 30 in., " " " 5 in. ".....	472	6
Buffing—		
6 in. or less, not over 1 in. thick.....	19	3½
7 in. to 12 in., inclusive, not over 1½ in. thick.....	57	4
13 in. to 16 in., " " " 2 in. ".....	101	4½
17 in. to 20 in., " " " 3 in. ".....	189	5
21 in. to 27 in., " " " 4 in. ".....	338	6
27 in. to 33 in., " " " 5 in. ".....	518	7

TABLE 3. SUCTION PRESSURES REQUIRED AT HOODS

	STATIC SUCTION IN INCHES OF WATER
Exhausting from grinding and buffing wheels.....	1½-5
Exhausting from tumbling barrels.....	2
Exhausting from wood-working machinery—light duty.....	2
Exhausting from wood-working machinery—heavy duty.....	2-4
Shoe machinery exhaust.....	2-3
Exhausting from rubber manufacturing processes.....	2
Flint grinding exhaust.....	2
Exhausting from pottery processes.....	2
Lead dust and fume exhaust.....	2-4
Fur and felt machinery exhaust.....	2-3
Exhausting from textile machinery.....	2-3
Exhausting from elevating and crushing machinery.....	2
Conveying bulky and heavy materials.....	3-5

measure of the air volume handled and consequently of the air velocity at the opening of the hood. The elimination of any dusty condition requires added information concerning the shape, size and location of the hood used with regard to the operation in question.

In some states grinding, polishing and buffing wheels are subject to regulation by codes. The static suction requirements, which range from 1½ to 5 in. water displacement in a U-tube, should be followed although in several instances they may appear to be excessive. Frequently, in these operations, a large part of the wheel must be exposed and the dust-laden air within the hood is thrown outward by the centrifugal action of the wheel, thus counteracting useful inward draft. This tendency may be diminished by locating the connecting duct so as to create an air flow of not less than 200 fpm about the lower rim of the wheel.

Exact determinations of hood control velocities are not available, but

it is safe to assume that for most dusty operations they should not be less than 200 fpm at the point of origin. For granite dust generated by pneumatic devices, Hatch et al¹ give velocities from 150 to 200 fpm, depending on the type of hood used, as sufficient for safe control. Considering the character of the industry, air velocities of this order may be extended to similar dusty operations. The method for approximately determining these velocities in terms of the velocity at the hood opening is given below.

DESIGN OF HOODS

No set rule can be given regarding the shape of a hood for a particular operation, but it is well to remember that its essential function is to create an adequate velocity distribution. The fact that the zone of greatest effectiveness does not extend laterally from the edges of the opening may frequently be utilized in estimating the size of hood required. Where complete enclosure of a dusty operation is contemplated, it is desirable to leave enough free space to equal the area of the connecting duct. Hoods for grinding, polishing and buffing should fit closely, but at the same time should provide an easy means for changing the wheels. It is advisable to design these hoods with a removable hopper at the base to capture the heavy dusts and articles dropped by the operator. Such provisions are of assistance in keeping the ducts clear. Air volumes used to control many dust discharges may often be reduced by effective baffling or partial enclosure of an operation. This procedure is strongly urged where dusts are directed beyond the zone of influence of the hood.

Axial Velocity Formula for Hoods

When the normal flow of air into a hood is unobstructed, the following formula may be used to determine the air velocity at any point along the axis:

$$\frac{Y}{100 - Y} = \frac{0.1A}{x^2} \quad (1)$$

where

Y = per cent of velocity at opening.

A = area of opening, square inches (or square feet).

x = distance outward from opening, inches (or feet).

It is important to note that the velocity function varies in direct proportion to the area. Hence, under certain conditions, a large opening may function more effectively than a small one for the same volume of flow. The formula, of course, presumes that the air velocity distribution across the hood opening is uniform⁴.

Example 1. A small hood 64 sq in. in area handles 400 cfm. What will be the air velocity at a point 5 in. outward along the axis if the flow is unobstructed?

¹Hatch, Theodore, Drinker, Philip, and Choate, Sarah P. Control of the Silicosis Hazard in the Hard Rock Industries. I. A Laboratory Study of the Design of Dust Control Systems for Use with Pneumatic Granite Cutting Tools. (Journal of Industrial Hygiene, Vol. XII, No. 3, March, 1930).

⁴Velocity Characteristics of Hoods under Suction, by J. M. DallaValle (A.S.H.V.E. TRANSACTIONS Vol. 38, 1932).