Johns-Manville

Internal Correspondence

To: R. J. Mitchell 3-07

Date: April 13, 1978

From: J. P. Kline 2-30

Copies: R. J. Johanson 3-04/F. E. Brandt 2-30
R. F. Henry/G. Jakelsky - MVL L.J. Richards/H.T. Brode-Den

Subject: P32-7483 Ball Mill Dust Collector
P54-7452 Silica Processing Dust Collector

As we discussed, the F.A. Walsh dust collector installed at Denison (and being installed at Manville) is experiencing problems with inadequate damper sealing. This sealing problem is serious enough to prevent proper shake-down of the dirty bags.

We expect that Frank Walsh will return to Denison within the next week to correct this problem. Upon satisfactory completion of his work at Denison he will go to Manville to make the same alterations to that unit. As he is scheduled to be at Manville for his routine maintenance checks soon,we are hoping to have both collectors modified within the next two to three weeks.

We'll keep you informed of future developments.

J. P. Kline

JPK/gcp.

Johns-Manville
Sales Corporation

Ken-Caryl Ranch
Denver, Colorado 80217
(303) 979-1000

April 6, 1978

Mr. Frank A. Walsh, Sr.
Frank A. Walsh & Sons
13000 Athens Avenue
Cleveland, Oh. 44107

RE: J-M PO#X07-07592
Ball Mill Collector - Denison

Dear Frank:

As we agreed on April 4, I am attaching a print of the Ball Mill system at Denison (Dwg. No.14695-2) plus a copy of our dust control layout (Dwg. No. 47829-2) for the new collector just installed. Both prints are marked up with pressure and volume readings so you can familiarize yourself with the system design.

We maintain that the dust bags are not deflating in the new collector due to leaks around the dampers, shaker arm boots, doors, etc. As we have explained previously, the entire ball mill dust collector system operates under negative pressure, not positive.

We are in the position where neither the Denison or Manville units (PO#X27-08155) will operate satisfactorily as you have supplied them. We will not agree to the installation of bleed-in dampers until each compartment is sealed tightly, preventing all airflow through the bags during the shake cycle.

Please do not delay in correcting this problem at both locations. We are assuming that whatever deficiencies are present in the Denison unit are also going to present themselves at start-up in Manville.

We appreciate your prompt response to the problem thus far and thank you in advance for your continued cooperation.

Very truly yours,

James P. Kline
Staff Engineer
Environmental Engineering Dept.

Attachments

JPK/gcp.

CC: R. Johanson 3-04/F.E. Brandt 2-30
C.C. Pascale 2-26 (P.O. #X27-07592 & X27-08155)
L. Richards/H.T. Brode - Denison
S. Gillespie 3-07/E.J. Mitchell 3-07

Johns-Manville

Internal Correspondence

To: S. B. Gillespie

MAY 16 1977

Date: May 11, 1977

From: E. J. Mitchell

c/c MEH HTB

Copies: W. E. Volwiler, L. I. Richards/Denison, AR File, file/chrono

Subject: REPLACE BALL MILL DUST COLLECTOR-DENISON PLANT
AR026-EC883R $111,900

This proposal would replace a collector which has been in service since 1958 and which would not be specified for a new installation of this type today. It is overloaded by present day standards and, as a consequence, cannot be maintained to meet J-M criteria for internal cleanliness, dust emissions and personnel exposure.

Bag-type dust collectors for service in J-M asbestos cement pipe plants must have air-to-cloth ratios not greater than 2:1. They must be shaker type with access to bags on the clean air side. They must be continuous-automatic, meaning that they clean themselves on a time cycle without interruption to the process they serve. And, they must be easily accessible for internal inspection while in operation.

Meeting all of the preceeding criteria means a larger collector which translates into high installation costs for structural modifications, conveyors and electrical work. An in-kind replacement is estimated to cost $21,000 for the collector ($53,400, installed) versus $30,000 for the proposed collector ($111,900, installed) which would meet all the criteria.

There would be a cost reduction (though not sufficient to justify this expenditure in itself) of about $3000 per year. Other than routine inspections, no bag replacement or shaker maintenance would be contemplated for three to five years. This improvement in collector reliability should also result in some increase in ball mill operating time, hence improvement in production of ground silica (SILEX).

Intergrinding of A/C pipe waste material with sand should be a reality within two to three years at Denison. This would increase the potential of personnel exposure and release to atmosphere of hazardous materials (Silica and Asbestos). It therefore, seems prudent to up-grade this collector to the "state of the art" level rather than a replacement-in-kind which would not perform the job as best we know how nor give maximum protection against personal risk to maintenance and operating personnel.

This is part of an item in the official 1977 CEP, under CR: "Improve Silica Classifier," for which $30,000 was originally planned.

All work would be by outside contract. Involvement of plant workforces would be minimal.

Approval is recommended.

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WHA 0158 16:04MDT DON 0042

16:24MDT 05/03/78

<DON 1074>

//23428LM// 5/03

H. BRODE

RE: BALL MILL WITH THE ELECTRICAL CHANGES YOU ARE MAKING CAN YOU OPEN THE DAMPERS FROM INSIDE THE COLLECTOR. ALSO DO YOU KNOW OF ANYBODY WHO REBUILDS DUST COLLECTORS IN THE FORT WORTH - DALLAS AREA. THANKS

JIM P KLINE 2-30

WHF 0132 16.02MST DON 0055

16.13MST 03/24/78

<DON 1132>

//23428LM// 3/24

H. BRODE

RE: B-11 MILL DUST COLLECTOR PER YOUR SUGGESTIONS I WILL BE AT DENISON ON TUE MARCH 28 AND WED MAR 29 WILL ARRIVE ABOUT 1:00 PM TUES REGARDS.

JIM KLINE 2-30

35

WII 0050 10:32MDT DON ###

10:47MDT 05/04/78

<DON DON 5050>

//04202AM// 5/4

L RICHARDS H BRODE

RE NEW BALL MILL DUST COLLECTOR --- IS EVERYTHING SATISFACTORY?

IF NOT, PLS LIST THOE THINGS NEEDING ATTENTION.

AT THIS TIME Everything is OK.

E J MITCHELL 304 My only reservations are (1.) How long will the Dampers last in the hot environment (2) How will the silica transporting line work in an extended period of damp weather.

Brode

<WHQ 35>

05/05/78

;MITCHELL, E J;

RE NEW BALL MILL DUST COLLECTOR -

AT THIS TIME EVERYTHING OK.

MY ONLY RESERVATIONS ARE

1. HOW LONG WILL THE DAMPERS LAST IN THE HOT ENVIRONMENT.

2. HOW WILL THE SILICA TRANSPORTING LINE WORK IN AN EXTENDED PERIOD OF DAMP WEATHER

BRODE

APPROVED DIST:
1. Finance Manager W.E. Roush-Denison
2. Mgr. W.A. Sells
3. MAC C/C S.B. Gillespie
4. Dir. Pln. Eng. W.L. Gregory
5. Dir. Env. Eng. D.E. Hillier
6. Dir. Profit Plan E.R. Brady
7. V.P. Pur.&Eng. Serv. M. Sivetts

LV.

Date Prepared: 5/5/77

APPROPRIATION REQUEST

No. 026-EC-883-R

LOCATION DENISON DIVISION I&PPM DEPT NAME TRANSITE DEPT NO. 070

TITLE: REPLACE BALL MILL DUST COLLECTOR

I. PURPOSE: To provide a new dust collector for the Ball Mill classifier system.

II. PRESENT FACILITIES: The present dust collector is a two-compartment automatic REESE dust collector. It was installed 18 yrs. ago. The shaker mechanism requires constant maintenance and the bags bleed through so there are several inches of dust on the floor in each compartment. The collector does not meet company guidelines of an air-to-cloth ratio of 2:1. The dust collector is necessary to prevent ground silica from being discharged into the atmosphere. Portions of the classifier system are being replaced in AR026-R-868.

III. PROPOSED FACILITIES: A new dust collector will be purchased and installed. The unit will be a 4-compartment continuous-automatic dust collector, shaker type, 3,500 CFM, and gross air-to-cloth ratio of 2:1. Engineering of project will be by General Environmental Engineering. (GEE)

IV. ESTIMATED COST:

Capital Item Description	Cost	Life Yrs.	Account	Systems 1112 Par. #
Dust Collector	$ 30,000	15	2415	3.A.2
Conveyor & Rotary valve	5,000	15	2415	3.A.2
Wiring & Controls	5,000	15	2415	3.A.2
Installation Labor	50,500	15	2415	3.A.2
Spare Parts	1,000	15	2415	3.A.2
Engineering	9,000	15	2415	3.A.2
Total Capital	$100,500			
Expense				
Taxes	2,400		812	2.H
Total Expense	2,400			
Sub-total	$102,900			
Contingency	9,000			
TOTAL APPROPRIATION	$111,900			

V. BENEFITS OR SAVINGS: The new dust collector will reduce emissions of silica from the ball mill classifier system, reduce exposure of maintenance personnel to silica dust and reduce mainterance costs.

VI. OTHER INVESTMENT: None

VII. DISPOSITION OF PROPERTY: Retire Dust Collector 026-RP-884

III. LABOR & UTILITY REQUIREMENTS: None

IX. REMARKS:
1. Job Order No. 6846
2. Cost Estimate J. P. Kline, GEI, 2-11.
3. Work to be done by outside contractor

☒ Yes ☐ No. Meet reqmts. of P. 331-1, 331-2, 332-1?
☒ Yes ☐ No. On offic. cap. projects list? P 331-3
☒ Yes ☐ No. RETIREMENT PROPOSAL attached?
Assigned to H. T. Brodo
Time to complete 9 months
Coordinator M.E. Hatley Ex. 267
Approval authorizes exped. of $111,900

☐ Yes ☒ No BUDGET ADDITION requested for expense portion?
Major acctg. classif. ____
Initials ____ Amount ____
FINANCIAL ANALYSIS/CERTIFICATION:
% Return DCF ____ By T. Jansen
☒ Yes ☐ No. Analysis attached? Date 5/13/77
☐ Yes ☐ No. Corp. Finance OK? ☐ Not amenable to FA

REFER TO SYSTEMS 3111 FOR REQUIRED APPROVAL LEVEL

TITLE	INITIAL	DATE	TITLE	INITIAL	DATE
[illegible]			V.P. J-M CORP. ($35M)		
EXEC V.P. FIN. & ADM. ($200M)	[illegible]	5/17/77	DIV. GEN. MGR. ($25M)	[illegible]	5/20/77
SR. V.P. PROD. & ENG. ($75M)	[illegible]	5/19/77	DIV. PROD. MGR. ($2M) RES. DIR. ($2M)	[illegible]	5/24/77
SR. V.P. CORP. MKT. ($50M & S/F)			DIR. GEN. SERV. ($2M)		
SR. V.P. J-M CORP. ($50M)	[illegible]	[illegible]	PLT. or MINE MGR. ($1M)		

IX. REMARKS: (cont.)

4. Capital Commitment:

1	2	3	4	5	6	7	8
35,000	10,000	7,400	-	-	45,000	14,500	-

Capital Spending:

1	2	3	4	5	6	7	8
-	-	-	10,000	-	42,000	30,000	29,900

START COPY	INITIALS	DATE

BOX NO./FILE DRAWER NO.	SEGMENT NO.
	04-01920

SIGNIFICANT

NOTES