



Johns-Manville

Internal Correspondence

To: J. Goldfield

Date: July 24, 1974

From: J. P. Kline

Copies: D. E. Hillier
D. French - DEN
F. E. Brandt

H. Brode - DEN
E. J. Mitchell - 2S

PLAINTIFF'S
EXHIBIT
JMMC-199

Subject: P32-7159
FINISHING END DUST CONTROL SYSTEM
AR 026-EC-632

On April 28, 29, & 30, 1974, I visited the Denison pipe plant to analyze the poor performance of the Westinghouse exhaust fan on the west collector system, finishing end. After inspecting and determining the problem, we were to make and implement corrective measures.

We had arranged with Westinghouse, Sturtevant Division, to have a qualified field service engineer also visit the plant to study the problem. Mr. R. B. Diffen of the Westinghouse Dallas Office, arrived at approximately 2:30PM Tuesday afternoon, and stayed about two hours at the plant. During this time, we discussed the problem and inspected the installed equipment.

We pointed out to Westinghouse that all information received from them on this fan (performance, curves, and operating RPM) indicate that the fan will perform as expected, and asked their recommendations to bring this fan up to the performance we require. Since we did not purchase the fan for this particular application, but used it as existing equipment (purchased in 1957), they will not accept any responsibility for the poor performance. After discussing the relative merits of this position, we requested that they at least make an on-the-spot recommendation of how we could improve the fan performance. Mr. Diffen suggested that inlet straightening vanes would possibly help and if not, the only other solution was to purchase and install a larger fan.

The attached data sheet shows the actual performance of this fan and the required performance.

On April 29 and 30, the plant E&R shop constructed and installed straightening vanes at the inlet of the Westinghouse fan. They did nothing to improve the air flow problem.

The poor performance of the Westinghouse fan is due to a combination of errors. We requested, and received, operating and performance data from Westinghouse Corporation for the design conditions of this system. We accepted the information

J. Goldfield
Page 2
July 24, 1974

as being correct and proceeded to install and operate the unit. It has not, and definitely will not, perform as required. Although Westinghouse Corporation shares this problem with us in theory, we must accept full responsibility for not checking, recalculating and correcting their performance data at the beginning.

Based on the above, we were faced with the following alternatives to correct the problem:

1. Purchase and install a larger fan.
2. Purchase and install a second fan to operate in parallel.
3. Purchase and install a wider wheel (size D) for the existing fan, which would give the additional air flow required.

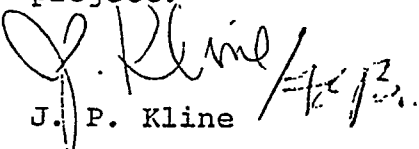
Upon my return to Denver, I conducted a search for spare fans, or "quick-ship" fans that we could use for this application. To my knowledge, there are none available.

The three alternatives were considered and it is my recommendation that we purchase and install one (1) replacement fan large enough to deliver the performance we require. The purchase requisition for the fan has been written on New York Blower. Shipment is estimated at January 6, 1975.

The plant has also requested that the MOA lathe hood be revised to duplicated the Stockton plant installation. As the hood we designed did not perform adequately, I have agreed to do this under the AR.

We estimate we require \$9,900 to complete all phases of this project. A breakdown of the status of this project is shown on the attachments. It shows that we will require a portion of the contingency funds approved for this project. I will prepare the modification for this appropriation and forward them through channels.

We wish to thank the plant personnel for their courtesy and cooperation which has always been extended to us during the project.


J. P. Kline

/jh
Attach.

To: J. P. Kline - 4N

Date: May 9, 1974

From: E. J. Mitchell *h/m*

Copies: W. A. Sells, D. W. French - Denison, H. Brode - Denison, D. E. Hillier - 4N,
J. Goldfield - 4N, F. E. Brandt - 4N, File/Chrono

Subject: FINISHING END DUST SYSTEM
AR-026-EC-632
P32-7159

As of the last day of February, the revised Finishing End Dust system was not performing satisfactorily. Since then I have heard only that something was wrong with the air volume being handled by the East Collector (coupling lathe aisle) and that you were "working on it".

For lack of other information, I must assume that you still have not diagnosed the cause of the low air volume and have not yet done anything about it. I hope you will correct me if I am wrong in this assumption.

Denison Plant was cited and fined recently by OSHA for failure to maintain clean working conditions. The inspector specifically noted the poor dust pick-up in the coupling aisle. He made some allowance for the fact that the dust system was new and not fully checked-out. We cannot expect a similar allowance on the next inspection.

I believe that you owe the Pipe Division a specific outline and schedule for correction of the outstanding deficiencies on this project. And I request that this be forthcoming without delay.

/mf



GREENWOOD PLAZA, DENVER, COLORADO 80217

DATE 1/3/74 DATE REQUIRED A.S.A.P. MARK FOR H. BRODE REQUISITION NO. 7159-012 PURCHASE ORDER NO. X27-03722 (E)

KEETCH METAL WORKS
200 N. FOCH
FT. WORTH, TEXAS 76107

IMPORTANT

THIS IS A—
RELEASE NO.

CHANGE OF PURCHASE ORDER

PLEASE OBSERVE THE FOLLOWING CHANGE
APPLYING TO OUR ORDER, AND ACKNOWLEDGE

TERMS F. O. B. VIA SHIPPED FROM P32-7159

DESCRIPTION	QUANTITY	UNIT	PRICE	PER
ADDITION TO OUR PURCHASE ORDER CONTRACT X27-03722 DATED OCTOBER 17, 1973.				
FABRICATE AND INSTALL THE FOLLOWING GATE VALVES: (1)-14", (2)-13", (1)-10", (1)-8", (2)-5", AND (8)-7" FLANGES	1	LOT	\$735.00	LOT
FABRICATE AND INSTALL NEW INLET CONNECTION TO DUST COLLECTOR EXHAUST FAN	1	LOT	883.83	LOT
ALL OTHER TERMS AND CONDITIONS OF ORIGINAL PURCHASE ORDER TO APPLY.				

ACCOUNTING CODE

PURCHASING DEPT.

826-FC-632
FOR JOHNS-MANVILLE USE ONLY:

6640

RECEIVING REPORT

DELIVERING CARRIER CJS/MLM SHIPPING POINT

SEALED TO: VENDOR CAR NO. PRO. NO.

ACCTS. PAYABLE-DENISON RECEIVING-DENISON

D. KLINE (2) DATE RECEIVED RECEIVED BY

D. ROTH

FILE



Johns-Manville

Internal Correspondence

HTB

To: K. J. Whalen - 2S/1

Date: March 28, 1974

From: D. E. Hillier - 4N/3

APR 01 1974

Copies: J. P. Kline
J. Goldfield

W. A. Sells - 2S/1
D. W. French - Denison

E. J. Mitchell - 2S/1
File & Chrono

Subject: FINISHING END DUST SYSTEM
P32-7159
AR 26-EC-632
YOUR LETTER 3/5/74

W. LaBadie's letter to me, dated June 21, 1972, outlined in detail the standards to apply to new installations or modifications to existing dust collectors for all Pipe Division plants.

We accepted the Pipe Division standards with one question regarding the thickness of steel for duct work. The standards were later revised in this regard.

We received an assignment for the Denison project on 9/5/72. This assignment was to correct the dust collecting condition at the MOA lathe and to provide an estimate and layout for A/R purposes to completely revise the finishing dust systems.

Environmental Engineering supplied the Pipe Division an estimate for the above on 11/20/72 in the amount of \$123,500. This amount was approved on 1/31/73. The estimate should have included all monies necessary to revise the finishing dust systems in accordance with Pipe Division standards. We erred in not including in the estimate monies for additional cloth collector capacity in order to reduce the air to cloth ratio in the existing collectors.

The actual work completed to date has consisted of new duct work and hoods at various finishing centers. The ducts were increased in size requiring increased air flow. To obtain greater air flow, the fans on the clean side of the collectors were speeded up resulting in higher air to cloth ratios as follows:

	Air to Cloth Ratios	
	Prior to Speed Up	After Speed Up
East Collector:	2.5 to 1	2.65 to 1
West Collector:	2.6 to 1	3.15 to 1

These air to cloth ratios are in excess of Pipe Division standards.

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K. J. Whalen
Denison

March 28, 1974

At present, I understand the west collector has a pressure drop of 1.75" and the east collector has a pressure drop of 1.5" compared to a normal pressure drop of 3.5" to 3".

Problems are currently being experienced with the west collector system. Expected air flows are not being achieved. Environmental Engineering is working on this now.

To complete this project in accordance with Pipe Division standards, it would be necessary to provide additional cloth collector capacity as follows:

West Finishing Collector

Purchase and install 10,000 sq. ft. of intermittent type cloth collector to be inter-connected both on the dirty and clean air sides. The present cloth is 15,450 sq. ft. which will be increased to 25,450 sq. ft., resulting in a two to one ratio. Estimated cost - \$69,000.

East Finishing Collector

Add 4,000 sq. ft. of cloth. Estimated cost - \$33,000.

There are insufficient funds remaining in the A/R to provide the above. We assume you will proceed to obtain approval of an A/R for additional funds.

I wish to assure you that in the future, we will, to the best of our ability, conform to Pipe Division standards for cloth collectors per W. LaBadie's letter dated June 21, 1972.

D. E. Hillier

DEH



Johns-Manville

Internal Correspondence

To: E. J. Mitchell - 2S

Date: May 24, 1974

From: J. P. Kline

Copies: D. E. Hillier
J. Goldfield/F. E. Brandt
H. Brode - DEN
Subject: P32-7159
DENISON FINISHING END
AR Nos. 026-EC-632 & 633

D. French - DEN

Finishing End Dust Control System

During the week of May 28, I will be at the Denison Pipe Plant with Mr. R. B. Diffen of Westinghouse Sturtevant Division. At this time we will analyze the poor performance of the Westinghouse 4040A exhaust fan and implement whatever is necessary to remedy this situation. We will keep all concerned informed of our schedule.

Vacuum Cleaning Systems

We are attempting to return the American Standard fans for credit. It is the position of Environmental Engineering that it will be advantageous to our negotiations with American Standard to shut down all seven booster fans. In this way we will not incur any more maintenance charges to keep them running and will eliminate additional wear and tear to the fans. We feel that by shutting down the systems, we will be in a better position to return these fans.

Please let us know when the fans are shut down.

J. P. Kline

/w

START COPY	INITIALS	DATE
BOX NO./FILE DRAWER NO.	SEGMENT NO.	
SIGNIFICANT	NOTES 04 - 01906	