| | | | | |
|---|---|---|---|---|
| Shakeouts<br>Foundry | Enclosure | 200 fpm through all openings in enclosure, but not less than 200 cfm per sq ft of grate area | 3,500 | Ref 20, 22 |
| Spray coating | Booth—operator inside<br>Booth—operator outside<br>Booth—downdraft | 100-200 fpm at booth cross section<br>150-200 fpm at booth cross section<br>100-200 fpm downdraft | 1,500-2,000<br>1,500-2,000<br>1,500-2,000 | Ref 15<br>Use higher ventilation rate for small booths 4 sq ft or less |
| Tanks, open surface | (See Table 47-L) | | | Ref 36, 37, 38, 39 |
| Tumbling mills<br>Hollow trunnion type | Exhaust connection by manufacturer | Use branch diameter same size as exhaust outlet For round mills branch diam should be $\frac{1}{6}$ diam of mill, for square mills branch diam should be 1 in plus $\frac{1}{6}$ side dimension of mill | 3,500-5,000 | Ref 14 |
| Tumbling mills, drums, cages, barrels | Enclosure | 400 fpm through openings but not less than 75 cfm sq ft plan area | 3,500 | Where equipment is enclosed and dust tight during rotation, enclosure may not be needed if feed and discharge operations can be otherwise run |
| Welding | Local hood with flange<br><br><br>Downdraft bench<br>Booth | 6 in from arc—150 cfm<br>6-9 in from arc—275 cfm<br>8-10 in from arc—425 cfm<br>10-12 in from arc—600 cfm<br>150-250 cfm per sq ft grille area<br>100 fpm at booth face | 2,000-4,000<br><br><br>2,000<br>2,000 | Ref 40 |
| Woodworking | (See Table 47-K) | | | Ref 22, 41 |
| Miscellaneous<br>Packaging machines, granulators, enclosed dust producing units Packaging, weighing, container filling, inspection | Complete enclosure<br><br><br>Booth<br><br>Downdraft | 100-400 fpm indraft through inspection or working openings, but not less than 25 cfm per sq ft of enclosed plan area<br>50-150 cfm per sq ft of open face area<br>75-150 cfm per sq ft of dust producing plan area | 3,000<br><br>3,000<br><br>3,500 | Ref 19 |

*From* ASHRAE Guide and Data Book, 1962, *Chapter 21* *Used by permission*