Johns-Manville

Internal Correspondence

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

Date: March 28, 1974

K. J. W. APR 1 1974

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

Copies: J. P. Kline, J. Goldfield, W. A. Sells - 2S/1, D. W. French - Denison, E. J. Mitchell - 2S/1, File & Chrono

PLAINTIFF'S EXHIBIT JMMC-181

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 provice 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	2.6 to 1
West Collector:	2.6 to 1	3.1 to 1

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

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

START COPY	INITIALS	DATE

BOX NO./FILE DRAWER NO.	SEGMENT NO.

SIGNIFICANT

NOTES

04-01906

START COPY	INITIALS	DATE

BOX NO./FILE DRAWER NO.	SEGMENT NO.

SIGNIFICANT

NOTES

04-01906

ENVIRONMENTAL EVALUATION REVIEW FOR AR PROPOSALS AND ACQUISITIONS

DIVISION: Pipe PLANT: Denison PROJECT: AR-026-EC-817

F) TOXICOLOGY ASPECTS:

List all raw materials used in process:

Asbestos fiber, cement, silica, water, Polyfloc, Calgon, Tamol SN, triethanolamine, sodium silicate, muriatic acid

Potentially hazardous substances formed in process, if known:

None

Potentially harmful properties of finished products, if known:

Asbestos and/or silica may cause cancer or respiratory damage

Explanatory comments as may be appropriate:

G) ENVIRONMENTAL DESCRIPTION:

Use this space to describe the environmental aspects of proposed projects that do not conveniently fit the preceding format, or to enter additional comments to complement information already provided.

This project is designed to reduce the possibility of employee exposure to excessive amounts of airborne asbestos fiber.

H) REVIEW CONFIRMATION:

	PRESCRIBED: SIGNATURE & DATE	OTHERS: SIGNATURE & DATE
PLANT MANAGER	L Richards 3-10-76	
DIV. PROD. MGR.		
DIRECTOR, E.C. Engr.		

Form AR-4 (2/75) Back

ENVIRONMENTAL EVALUATION REVIEW FOR AR PROPOSALS AND ACQUISITIONS

It is essential that each AR request for significant funds include information relevant to the environmental consequences of the proposed project. The same is true for planned acquisitions. This sheet should be used to provide such data. Space under Item G (reverse side) may be used to describe special situations, or to enter pertinent additional data.

DIVISION: Pipe PLANT: Denison PROJECT: AR-026-EC-817

A) IN-PLANT CONDITIONS

What OSHA requirements will not be met (explain):

None

B) AIRBORNE EMISSIONS:			
Emitting Sources (identify)	P/M Willow Feed		
No. of Exhaust Outlets	Two		
Air Volume (total CFM)	Unknown		
Type of Contaminants (list):	Asbestos fiber		
Intended Control Facilities	Increased Ventilation		
Cost of Control Facilities	$4950		

What future emission problems could be encountered (explain):

None

C) FLUID DISCHARGES: None			
Wastewater Sources (Identify)			
No. of Discharge Points			
Effluent Flow (total GPD)			
Types of Contaminants (list):			
Intended Control Facilities			
Cost of Control Facilities			

What future discharge problems could be encountered (explain):

D) SOLID WASTE DISPOSAL: None			
Solid Waste Sources (Identify)			
Characteristics (pieces, fines, inert, organic, etc.)			
Accumulation Rate (lbs./day)			
Potential Contaminants (list)			
Intended Disposal Method			

What future adverse ecological effects could develop (explain):

E) COMMUNITY NOISE FACTORS: None			
Significant Sources (Identify)			
Characteristics (repetitive, continuous, day only, etc.)			
Nearest Point Affected (yds.)			

What noise abatement plans will be implemented (explain):

APPROVED DIST:
1. Finance Manager W. E. Roush, Denison
2. Div. General Manager C.J. DeBiase - DHQ
3. HAC
4. Dir. Plt. Eng. M. B. Jamin, GHQ
5. Dir. Env. Eng. D. E. Hillier, GHQ
6. Dir. Profit Plan E. R. Brady, GHQ
7. V.P. Pur.&Eng. Serv. D. H. Lyons, GHQ

LOCAL: L.I.Richards
H.T.Brode (2
H.F.Lloyd
J. A. Dukes
C.G.Stelchek
File: 1.14.2

Date Prepared: 3-10-76

APPROPRIATION REQUEST

No. 026-EC-817
10.3.1.3

LOCATION DENISON DIVISION PIPE DEP'T NAME FORMING DEP'T NO. 070

TITLE: MODIFY PIPE MACHINE WILLOW FEEDS

I. PURPOSE:
Provide funds to modify the 10' & 13' P/M willow feeds.

II. PRESENT FACILITIES:
Each P/M has a willow feed consisting of a 19-ft. enclosed belt conveyor, 5 sliding feed doors, a 19-ft. feed shelf, a pallet staging table, and a bag disposal fixture.

The large feed area results in a large area contaminated with fiber and inefficient dust collection.

III. PROPOSED FACILITIES:
Both pallet staging tables will be replaced by one 20' diameter carousel. Each belt conveyor will be shortened to 6' and each feed shelf to 2'. Each P/M will have one feed station and a bag disposal fixture (vented).

IV. ESTIMATED COST:

Expense Item	Description	Cost	Account	Systems 1112 Par. #
1.	Labor	$3,000	62000	.2A
2.	Materials	1,500	62000	.2A
	Total Expense	$4,500		
	10% Contingency	450		
	TOTAL APPROPRIATION	$4,950		

V. BENEFITS OR SAVINGS:
Housekeeping requirements will be reduced and dust collection efficiency increased.

VI. OTHER INVESTMENT: None

VII. DISPOSITION OF PROPERTY: Scrapped

VIII. LABOR & UTILITY REQUIREMENTS: None

IX. REMARKS: 1. Job Order No. 5182

☒ 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. Brode, Plt. Engr.
Time to complete 3 Months
Coordinator J. T. Armstrong, Ind. Engr.
Approval authorizes exped. of $4950

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

REFER TO SYSTEMS 3419 FOR REQUIRED APPROVAL LEVEL

TITLE	INITIAL	DATE	TITLE	INITIAL	DATE
~~PRES. ($400M/$300M Cap.)~~			~~V.P. J-M CORP. ($35M)~~		
~~EXEC V.P. FIN. & ADM. ($200M)~~			DIV. GEN. MGR. ($25M)	CJD	3/23/76
~~SR. V.P. PROD. & ENG. ($75M)~~			DIV. PROD. MGR. ($2M)		
~~SR. V.P. CORP. MKT. ($50M & S/F)~~			RES. DIR. ($2M)		
~~SR. V.P. J-M CORP. ($50M)~~			DIR. GEN. SERV. ($2M)		3/16/76
			PLT. or MINE MGR. ($1M)		3-16-76

Form AR-1 (2/75)
PRINTED IN U.S.A.

NOTE: Strike out those that do not have to approve

N. Sfiscko, DHQ March 10, 1976

L. I. Richards, Denison

AR 026-~~EE~~R-817
MODIFY PIPE MACHINE WILLOW FEEDS

The above Appropriation is submitted for approval. This project is included in the 1976 CEP. A budget addition is requested.

LIR/is
by: J. A. Dukes

attachment

Johns-Manville

CC: WER DaR

Internal Correspondence

To: W. E. Volwiler

Date: June 18, 1976

JUN 21 1976

From: W. B. Gillespie WBG

Copies: L. I.Richards-Denison, H. T. Brode-Denison, N. Sfiscko
File/chrono

Subject: ENGINEERING COMMENTS
MODIFY PIPE MACHINE WILLOW FEEDS-DENISON
AR026-R-817-S1 - $3,500 SUPPLEMENT ($8,450 Total)

The subject AR Supplement is a request for funds to complete replacement of the willow feed equipment at Denison. Due to the urgent nature of the original AR to eliminate an asbestos dust station over 2.0F/cc, estimates were not of the usual accuracy. The supplemental funds are necessary to complete the project as designed to reduce fiber levels below the new TLV.

The funds requested are sufficient to complete this project without delay. The additional labor required has been adjusted into the current six months operating plan schedule for prompt completion.

I would recommend prompt approval of this supplemental request in order to permit completion of this project to eliminate this remaining over 2.0F/cc station at Denison.

ma

Johns-Manville

Internal Correspondence

To: W. A. Sells

MAR 1 7 1976

Date: March 15, 1976

From: S. B. Gillespie

JMD Keep 4/AR

Copies: L. I. Richards-Denison, N. Sfiscko, H. T. Brode-Denison
AR file 026-R-817, file/chrono

Subject: ENGINEERING COMMENTS
MODIFY PIPE MACHINE WILLOW FEEDS
AR026-R-817 - $4,950

The subject AR requests funds for the replacement of willow feed stations for both Denison Pipe Machines. The objective is to decrease housekeeping requirements without increasing operating costs. As a side benefit I anticipate a reduction in the fiber exposure levels for the Willow Operator.

It is proposed to install a 20' diameter turn table to handle individual pallets of fiber. Powered rotation of the turn table controlled by the Operator will deliver each required pallet in turn to a point opposite the fiber feed station for the appropriate machine. This will permit the Operator to place the unopened fiber bag in a ventilated dump station with a single move of about three feet. The fiber bag will be opened entirely within and disposed of thru the side of this ventilated dump station. The minimization of areas of possible spills subject now to immediate clean up will eliminate the requirement to add a second Willow Operator.

The funds requested can be expected to cover this replacement which will be handled in-house in accord with the current six months operating plan schedule.

I would recommend prompt approval of this request in order that advantage may be taken of dust control improvements to help guarantee that this station will have a dust count below 2.0 F/cc before July 1, 1976.

SBG
/ma

FINANCIAL STATUS AS OF 6-3-76

AR-026-R-817

COST COMPARISON:

Expense:	Original Estimate	New Estimate
Labor	$3,000	$5,750
Materials	1,500	2,250
Total Expense	$4,500	$8,000
10% Contingency	450	800
TOTAL APPROPRIATION	$4,950	$8,800

SPENT AND/OR COMMITTED TO DATE:

J. O. NO. 5182	$5,380

FUNDS REQUIRED TO COMPLETE PROJECT:

Additional Funds Required	$3,070
Amount Spent to Date	5,380
Total Amount Required to Complete	$8,450
Approved A. R. Amount	$4,950
Total Supplemental Funds Required	$3,500

COMMENT:

The supplemental funds requested in this A. R. are necessary due to low original estimates. The urgent nature of this project made detailed engineering analysis impossible; therefore, the original estimates were inacurrate.

LOCAL: L.I.Richards
H.T.Brode (2
H.F.Lloyd
J. A. Dukes (
C.G.Stelchek
File: 1.14.2

APPROVED DIST:
1. Finance Manager W. E. Roush, Denison
2. Div. General Manager W. A. Sells - DHQ
3. HAC c/o N. Sfiscko
4. Dir. Plt. Eng. M. B. Jamin, GHQ
5. Dir. Env. Eng. D. E. Hillier, GHQ
6. Dir. Profit Plan E. R. Brady, GHQ
7. V.P. Pur.&Eng. Serv. D. H. Lyons, GHQ

10.3.1.3

Date Prepared: 6/3/76

APPROPRIATION REQUEST

No. 026-R-817-S1

LOCATION DENISON DIVISION PIPE DEP'T NAME FORMING DEP'T NO. 070

TITLE: MODIFY PIPE MACHINE WILLOW FEEDS - SUPPLEMENTAL

I. PURPOSE:
This appropriation is to provide supplemental funds to complete the modification of the 10' & 13' P/M willow feeds.

II. PRESENT FACILITIES:
Each P/M has a willow feed consisting of an enclosed belt conveyor with 5 sliding feed doors. With this arrangement, a large area is contaminated with fiber and dust collection is inefficient.

III. PROPOSED FACILITIES:
Both pallet staging tables will be replaced by one 20' diameter carousel. Each P/M will have only one feed station.

IV. ESTIMATED COST:

See attachment.

V. BENEFITS OR SAVINGS:
Housekeeping requirements will be reduced and dust collection efficiency increased.

VI. OTHER INVESTMENT: None

VII. DISPOSITION OF PROPERTY: Scrapped

VIII. LABOR & UTILITY REQUIREMENTS: None

IX. REMARKS:
1. Job Order No. 5182

☒ 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. Brode, Plt. Engr.
Time to complete 1 month
Coordinator J. T. Armstrong, Ind. Engr.
Approval authorizes exped. of $3500

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

REFER TO SYSTEMS 3419 FOR REQUIRED APPROVAL LEVEL

TITLE	INITIAL	DATE	TITLE	INITIAL	DATE
~~PRES. ($400M/$300M Cap.)~~			~~V.P. J-M CORP. ($35M)~~		
~~EXEC. V.P. FIN. & ADM. ($200M)~~			DIV. GEN. MGR ($25M)	WAS	7/5/76
~~SR. V.P. PROD. & ENG. ($75M)~~			DIV. PROD. MGR. ($2M) RES. DIR. ($2M)		
~~SR. V.P. CORP. MKT. ($50M & S/F)~~			DIR. GEN. SERV. ($2M)	[illegible]	6/30/76
~~SR. V.P. J-M CORP. ($50M)~~			PLT. or MINE MGR ($1M)	[illegible]	6-4-76