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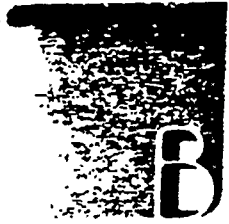
**FIBER RELEASE STUDY
INDUSTRIAL FITTINGS
MAKING GASKETS WITH
A BALL PEEN HAMMER**

November 5, 1996
BAI Project #1418A-4602



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**FIBER RELEASE STUDY
INDUSTRIAL FITTINGS
MAKING GASKETS WITH A BALL PEEN HAMMER**

EXECUTIVE SUMMARY

Objectives

The purpose of the study was to determine the concentration of fibers in the air while gaskets were made from stock material with a ball peen hammer.

Background

The study was performed using intact flanges from industrial fittings. The fittings and flanges had been in service many years and were obtained from a decommissioned power house.

The study was conducted in an isolation chamber to eliminate outside influences. The study was conducted at the rate of one (1) gasket per hour over an 8-hour period.

The study was conducted on November 1, 1996 by Mr. Fred Boelter. This report presents the results of the study described herein.

Sample Results

All samples measured concentrations of fibers in air well below the U.S. Department of Labor Occupational Safety and Health Administration (USDOL-OSHA) 8 hour Time Weighted Average (TWA) Permissible Exposure Limit (PEL) of 0.1 fibers per cubic centimeter (f/cc). Sample results are presented in the accompanying tables.



METHODOLOGY

PCM Sampling Procedure

Samples were collected and analyzed following NIOSH Method 7400. Air was drawn through a 25mm, conductive cowl cassette with a 0.8 micron mixed cellulose ester (MCE) filter for collecting airborne particulate. The cassette was connected to a dedicated Gilian servo-drive pump. The pump was used to maintain a flow rate of two (2) liters per minute (lpm) for both personal and area room air samples.

A Brooks rotameter was used to calibrate the pumps prior to and post sample collection. The rotameter was calibrated against a primary standard.

The samples were sealed, labeled and shipped to the laboratory for analysis. Samples were signed by BEC, placed in a UPS shipping envelope, sealed, tracked by UPS, and arrived at the laboratory by next day air.

Personal Samples

Personal samples were collected by attaching the cassette in the breathing zone of the individual performing the work for the duration of the test. The sampling pump was worn on the individual's belt.

Average Room Air Samples

The isolation chamber was subdivided into 3,600 one cubic foot (1ft³) modules. For purposes of identification, each module was assigned a discrete, consecutive number.

To determine the average room air concentration, eight (8) of the modules were selected using a random number generator. A sample cassette was located in the center of the respective module for the duration of the test.

Background Air Samples for TEM Analysis

Prior to conducting the test, the room was sampled to verify cleanliness. Five (5) samples were analyzed by transmission electron microscopy (TEM) following AHERA Protocol.

Just prior to collecting the samples, a "leaf blower" was utilized to aggressively disturb the isolation chamber's interior surfaces.

Air was drawn through a 25mm, conductive cowl cassette with a 0.8 micron mixed cellulose ester (MCE) filter for collecting airborne fibers. The cassette was connected to a dedicated Gast high volume pump. The pump was used to maintain a flow rate of 10 liters per minute (lpm).

A BGI rotameter was used to calibrate the pumps prior to and post sample collection. The rotameter was calibrated against a primary standard.



The samples were sealed, labeled and shipped to the laboratory for analysis. Samples were signed by BEC, placed in a UPS shipping envelope, sealed, tracked by UPS, and arrived at the laboratory by next day air.

Background Air Samples for PCM Analysis

Simultaneous with collecting the five (5) samples for analysis by AHERA Protocol, three (3) additional air samples were collected in accordance with NIOSH 7400 for PCM analysis "on-site" in the BEC office. The same analytical procedures were followed in the BEC office as were used in the laboratory. An Olympus Model CH-2 phase contrast microscope was used for the BEC analyses.

Light Microscopy Analysis

Samples were analyzed in accordance with NIOSH Method 7400. Total fiber counts were determined by phase contrast microscopy (PCM) in accordance with the NIOSH Manual of Analytical Methods, Fourth Edition, dated 8/15/94, A Rules. Values for PCM analysis are provided in the Appendix A and Appendix B spreadsheets.

Only fibers longer than 5 microns which have a length to width ratio equal to or greater than 3:1 are counted. PCM analysis counts all fibers meeting the specified dimensions. The analysis is not specific for asbestos but is the method specified to be used in the OSHA regulations.

The PCM laboratory reports are presented in Appendix C.

Electron Microscopy Analysis

AHERA Protocol transmission electron microscopy (TEM) analysis was performed on all background samples to verify the cleanliness of the isolation chamber prior to beginning the test. The sample analysis was performed as described in the Federal Register Vol. 52, No. 210, the Asbestos Hazard Emergency Response Act (AHERA Protocol).

Small squares were cut from each filter, processed appropriately, placed onto 200 mesh copper screens (grids) and transferred to a modified Jaffe Wick Washer containing acetone solvent. After the appropriate processing time, the grids were examined with a JEOL 1200EX or 100CX TEM. Grid openings from each sample were scanned at 20,000X.

When fibers or structures of various shapes were encountered, they were assessed for morphological characteristics and crystalline structure with selected area electron diffraction (SAED).

The TEM laboratory reports are presented in Appendix D.

Statistical Comparisons

Data was formatted in spreadsheets for analysis. Statistical functions were performed including maximum, average, minimum, standard deviation, and variance.



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The spreadsheets in Appendices A and B present the data and summarize the statistical analyses performed.

Laboratory Accreditation

The samples were shipped to and analyzed by R. J. Lee Group, Inc. in their Monroeville, Pennsylvania laboratory. R. J. Lee is accredited for TEM analysis by the National Institute of Standards and Technology (NIST) under the National Voluntary Laboratory Accreditation Program (NVLAP) as Lab #101208. R. J. Lee is also accredited for PCM analysis by the American Industrial Hygiene Association (AIHA) as Lab #8204.

DISCUSSION OF FINDINGS

Isolation Test Chamber

Testing was performed in the Boelter Environmental Consultants' (BEC's) Isolation Test Chamber. The chamber is 20 feet wide by 20 feet deep and is 9 feet in height. The chamber was constructed of 6 mil polyethylene sheeting to physically separate the activity being tested from outside of the chamber influences. The chamber is shown in Figure 1.

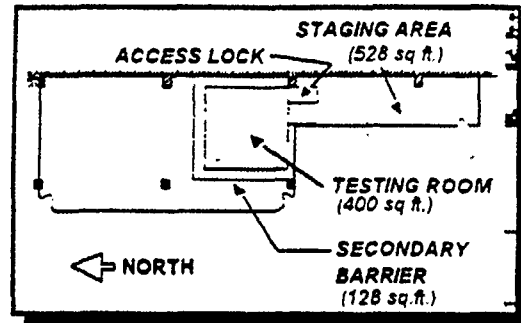


FIGURE 1 - BEC Isolation Test Chamber

The chamber was a static environment. During the test, there was no air movement into the chamber and there was no air movement out of the chamber. During cleaning, the room was ventilated with HEPA filtered air. Entry into the chamber was only through an access airlock.

Background Sampling Results

Prior to conducting any tests, the isolation chamber was systematically cleaned. Following the cleaning, a series of background samples were analyzed from five (5) area sampling locations in accordance with AHERA protocol.

Background samples were collected under "aggressive" conditions with analysis by TEM in accordance with AHERA Protocol.

Results of the Pre-Test Background sampling are shown in the following table:

STATISTICAL FUNCTION	Aggressive Air TEM (s/mm ²) - Background -
MAXIMUM	50.3
AVERAGE	16.8
MINIMUM	8.4
STAND. DEV	16.8
VARIANCE	280.9
COUNT	5

The levels met the AHERA Clearance Criteria of an average of less than seventy structures per millimeter squared (<70 s/mm²) for the 5 samples and the room was considered clean. Results are shown in the spreadsheet presented in Appendix B.

Selection of Fittings

Four (4) fittings with a total of eight (8) flanges were selected for making gaskets with a ball peen hammer. Fittings which were selected for the test were as shown in the following table:

TABLE I - FITTINGS SELECTED					
HOUR	FITTING / FLANGE NUMBER	FLANGE DIAMETER (in.)	GASKET OUTSIDE DIAMETER (in.)	GASKET INSIDE DIAMETER (in.)	GASKET BOLT HOLE QUANTITY
1	29A	9	6 9/16	4 1/4	8
2	29B	8	5	3 1/8	4
3	17B	10	7 5/8	5 1/8	8
4	17A	10 1/16	7 3/4	5	8
5	7A	9 1/16	6 1/16	3 15/16	8
6	7B	9	6 1/4	4	8
7	10E	9	6 3/4	3 7/8	8
8	10D	9 1/16	6 7/8	4	8

All fittings were obtained by Mr. Boelter from a decommissioned power house.¹ All fittings had intact gaskets and flanges and were carefully cleaned prior to being used in the test.²

Gasket Making Test Method

A work bench and hoist was placed in the center of the test chamber. The eight (8) fittings selected for the test (See Table I) were all placed in the isolation chamber.

Personal and average room air samplers were started prior to beginning the testing. The samplers were stopped after completion of the testing.

Testing started at about 8:00am and was concluded at about 5:00pm ("test cycle"). There was about a one hour break starting at about 12 noon. During the testing, no one left or entered the isolation chamber.

Each hour during the test cycle, one of the eight fittings was positioned in the center of the room on the work bench ("cycle event").

Each of the eight cycle events were essentially the same. During the hourly cycle event, similar procedures were followed as described in Table II:

¹ The decommissioned power house was located in Peoria, Illinois.

² The fittings were carefully blasted with glass beads to remove surface corrosion, rust, paint, insulation, etc. The gaskets were left intact. A light coat of clear lacquer was spray applied to the fitting after cleaning to prevent rusting. The edge of the flange was masked off during spraying to protect the gasket. If not removed, the surface corrosion, rust, paint, and insulation would have interfered with the analysis. The flanges used for gasket making had the original gaskets removed in prior tests. The flanges were cleaned prior to using them as a base for making gaskets.



TABLE II - TYPICAL HOURLY CYCLE EVENT		
STEP	ACTIVITY	PHOTO
1	Cutting of stock gasket material	1
2	Separate flange	2
3	Shaping of gasket material at center portion	3
4	Shaping of gasket material at bolt holes	4
5	Completed gasket	5
6	Tighten bolts to 60 ft. lb.	6

Thumbnail photographs depicting the various steps described in Table II follow below. Full size photographs are presented the Appendix E.



PHOTO 1 - Cutting gasket material.



PHOTO 2 - Separated flange. Fitting #10D is shown.



PHOTO 3 - Shaping gasket. Fitting #10D is shown.



PHOTO 4 - Shaping the gasket. Fitting #17B is shown.

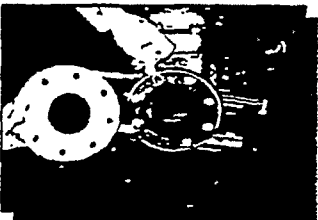


PHOTO 5 - Completed gasket. Fitting #7B is shown.



PHOTO 6 - Tighten bolts. Fitting #7A is shown.

Sampling Results During Test

Results of 8-Hour Time-Weighted Average Permissible Exposure Limit sampling are:

STATISTICAL FUNCTION	PCM Analysis by NIOSH 7400 (Total f/cc)	
	- Personal Samples -	- Average Room Air -
MAXIMUM	0.052	0.048
AVERAGE	0.045	0.040
MINIMUM	0.038	0.030
STAND DEV	0.007	0.006
VARIANCE	0.005	0.000
COUNT	2	8



All sample results show the concentrations to be well below the current OSHA Permissible Exposure Limit of 0.1 f/cc as sampled over an 8-hour time-weighted average period of time. Refer also to Figure 2 for a graphical presentation of the air sample results.

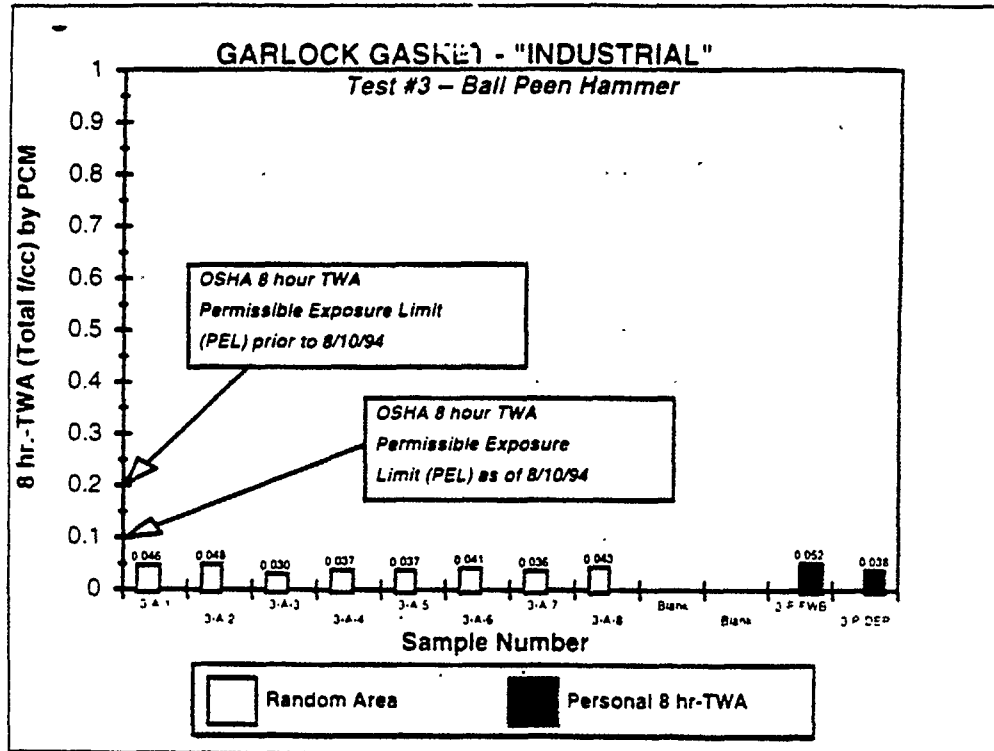


Figure 2 - Graphical presentation of the air sample results.

The Appendix A spreadsheets and charts present and depict the results of the testing in detail.



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CONCLUSIONS

Gaskets were made at the rate of one (1) per hour. Eight (8) room air samples and two (2) personal samples were collected during the processing.

All sample results show the airborne concentrations of fibers to be well below the current OSHA Permissible Exposure Limit of 0.1 f/cc as sampled over an 8 hour time weighted average period of time.

Respectfully submitted,

BOELTER ENVIRONMENTAL CONSULTANTS

Frederick W. Boelter, CIH, PE, DEE, OEP

Reviewed by,

Gary N. Crawford, CIH

Enclosures

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APPENDIX A

Compilation Spreadsheets and Graphs
TESTING RESULTS



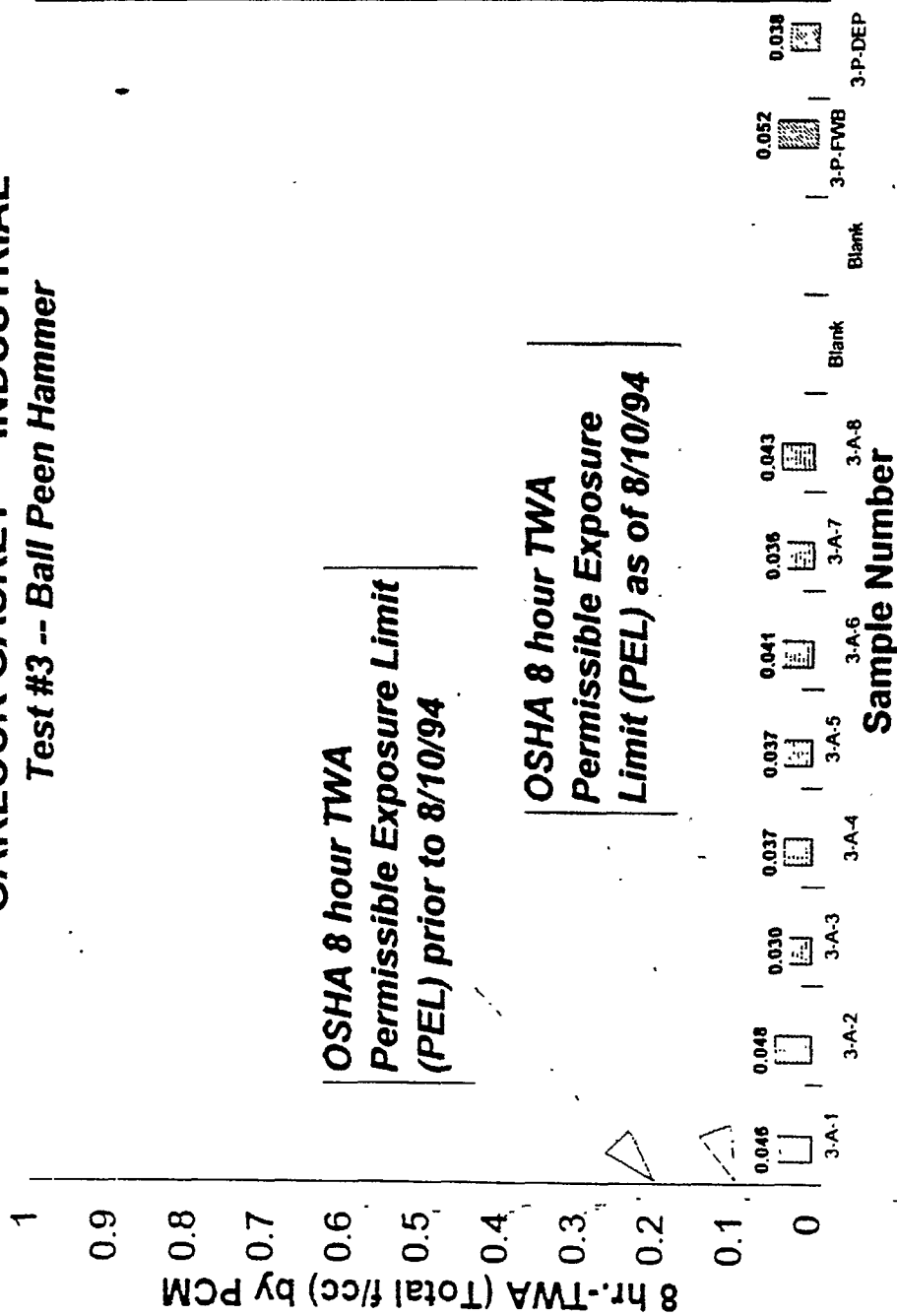
**Privileged & Confidential
Attorney Work Product**

MAXIMUM	AVERAGE	MINIMUM	STAND DEV	VARIANCE	COUNT
100	50	0	28.87	833.33	10

EXPERIMENT 14: TESTING WBI

GARLOCK GASKET - "INDUSTRIAL"

Test #3 -- Ball Peen Hammer

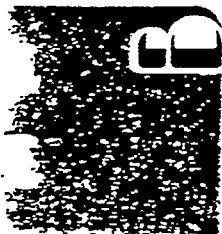


	Random Area
	Personal 8 hr-TWA



APPENDIX B

Compilation Spreadsheets and Graphs
PRE-TEST BACKGROUND RESULTS



PRE-ACTIVITY BACKGROUND TESTING RESULTS

Coltec Industries/Garlock Packing

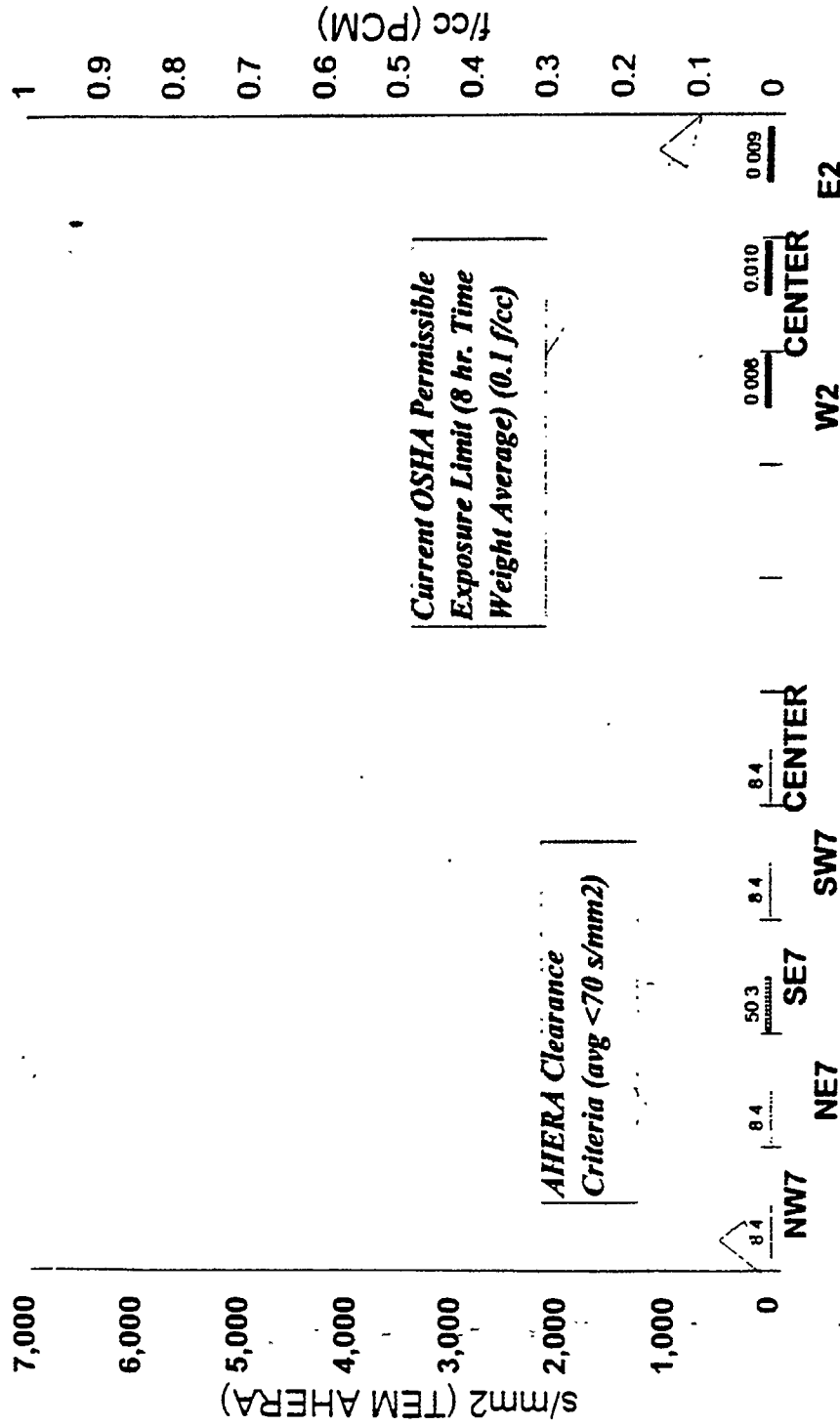
BAI Project #1418A-4600

TEST NUMBER DATE	SAMPLE NUMBER	SAMPLE TYPE	SAMPLE LOCATION	SAMPLE TIME	SAMPLE RATE	SAMPLE VOLUME	AGGRESSIVE AIR TEM RESULTS (Total Asbestos s/mm2) (avg <70 s/mm2)	LESS THAN LIMIT OF ANALYTICAL SENSITIVITY (<16.8 s/mm2)
1 30-Oct-96	3-B-1	AREA	NW7	130	10	1300	8.4	16.8
1 30-Oct-96	3-B-2	AREA	NE7	130	10	1300	8.4	16.8
1 30-Oct-96	3-B-3	AREA	SE7	130	10	1300	50.3	
1 30-Oct-96	3-B-4	AREA	SW7	130	10	1300	8.4	16.8
1 30-Oct-96	3-B-5	AREA	CENTER	130	10	1300	8.4	16.8
1 30-Oct-96	3-B-6	BLANK						
1 30-Oct-96	3-B-7	BLANK						

MAXIMUM	50.3
AVERAGE	16.8
MINIMUM	8.4
STAND DEV.	16.8
VARIANCE	280.9
COUNT	5

BACKGROUND TESTS - OCT 25, 1996

BAI Project 1418A-4600



TEM AHERA (Aggressive) PCM 7400 (Aggressive)



APPENDIX C

PCM Laboratory Reports

Test Report

Total Fiber Concentrations

PCM Air Analysis

Project AOH611534

Sample Number	Client Sample Number	Analyzed Area (sq. mm)	Volume (Liters)	Fibers	Fields	Concentration (fibers/sq. mm)	Concentration† (fibers/cc)	95% Upper Confidence Interval‡	Limit of Quantification†	Analyst	Analysis Date
0564745BHPC	3-A-1	0.785	1050	98.5	100	125.4777	0.0460	0.0630	0.0026	RFW	11/5/96
0564746BHPC	3-A-2	0.7615	1050	100	97	131.3284	0.0482	0.0659	0.0026	RFW	11/5/96
0564747BHPC	3-A-3	0.785	1050	63.5	100	80.8917	0.0297	0.0412	0.0026	RFW	11/5/96
0564748BHPC	3-A-4	0.785	1050	80	100	101.9108	0.0374	0.0515	0.0026	RFW	11/5/96
0564749BHPC	3-A-5	0.785	1050	79	100	100.6369	0.0369	0.0508	0.0026	RFW	11/5/96
0564750BHPC	3-A-6	0.785	1050	88	100	112.1019	0.0411	0.0564	0.0026	RFW	11/5/96
0564751BHPC	3-A-7	0.785	1050	77	100	98.0892	0.0360	0.0496	0.0026	RFW	11/5/96
0564752BHPC	3-A-8	0.785	1050	92.5	100	117.8344	0.0432	0.0592	0.0026	RFW	11/5/96
0564753BHPC	3-A-9	0.785	Blank	0	100	<7.0064*	§	§	§	RFW	11/5/96
0564754BHPC	3-A-10	0.785	Blank	0	100	<7.0064*	§	§	§	RFW	11/5/96
0564755BHPC	3-P-FWB	0.785	896	94.5	100	120.3822	0.0517	0.0709	0.0030	RFW	11/5/96
0564756BHPC	3-P-DEP	0.785	896	69.5	100	88.5350	0.0380	0.0526	0.0030	RFW	11/5/96

Samples received on: Thursday, November 14, 1996

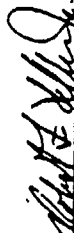
† Analytical results based upon the volumes provided by Boelter Environmental Consultants

‡ Prepared, Counted, and Calculated in accordance with NIOSH 7400. Fiber counts and concentrations are blank corrected.

* Results Below Analytical Sensitivity

§ Sample is a Blank, or no volume was supplied. Calculation could not be done.

Authorized Signature



Robert F. Wellman, Microscopist

Date Tuesday, November 5, 1996

RJ Lee Group, Inc.
Headquarters

350 Hochberg Road
Monroeville, PA 15146

Phone (412) 325-1776
Fax (412) 733-1799



APPENDIX D

TEM Laboratory Reports

Test Report

Total Asbestos Structure Concentration

TEM AHERA Analysis

Project ATH610828

RI Lee Group Sample Number	Client Sample Number	Filter Area (sq mm)	Volume† (Liters)	Area Analyzed (sq. mm)	Structures		Analytical Sensitivity †		Concentration		Analysis Date
					Chr	Amp	(S/sq. mm)	(S/sec)	(S/sq. mm)	(S/sec)	
007667HIT	3-B-1	385	1300.00	0.0596	0	0	16.8	0.0050	<16.8*	<0.0050*	10/30/96
0076678HIT	3-B-2	385	1300.00	0.0596	0	0	16.8	0.0050	<16.8*	<0.0050*	10/30/96
0076679HIT	3-B-3	385	1300.00	0.0596	3	0	16.8	0.0050	50.3	0.0149	10/30/96
0076680HIT	3-B-4	385	1300.00	0.0596	0	0	16.8	0.0050	<16.8*	<0.0050*	10/30/96
0076681HIT	3-B-5	385	1300.00	0.0596	0	0	16.8	0.0050	<16.8*	<0.0050*	10/30/96
0076682HIT	3-B-6	385	Blank	N/A	-	-	-	-	-	-	10/30/96
0076683HIT	3-B-7	385	Blank	N/A	-	-	-	-	-	-	10/30/96

† Volumes provided by Boelter Environmental Consultants for Project 1418A-4600 were used to calculate analytical results and sensitivities.

† Analytical sensitivity is the calculated concentration based on one structure in the area analyzed.

Samples received on: Monday, October 28, 1996

(Chr - Chrysotile, Amp - Amphibole)

* Results Less Than Analytical Sensitivity.

N/A - Sample not analyzed.

Authorized Signature

Kimberly A. Addison, Manager-TEM Analysis

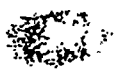
Date Thursday, October 31, 1996

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Headquarters

350 Hochberg Road
Monroeville, PA 15146

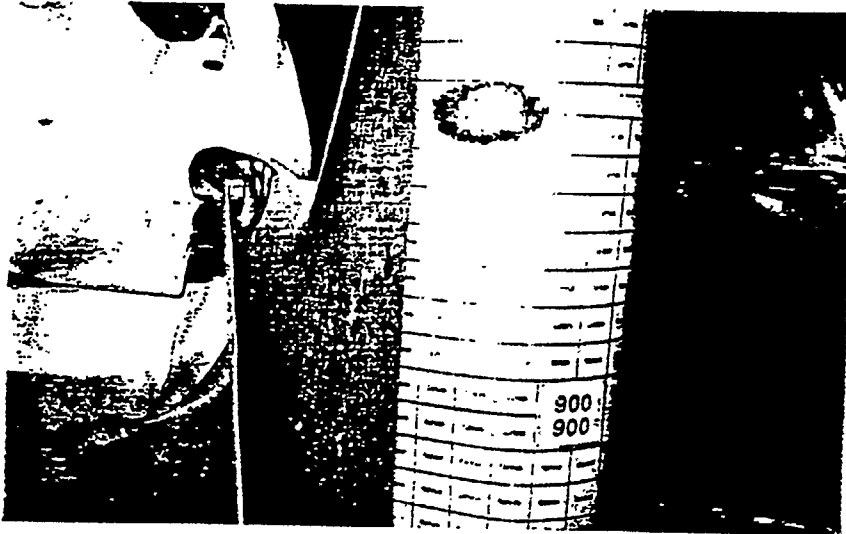
Test Report Page: 1 of 1

Phone (412) 325-1776
Fax (412) 733-1799

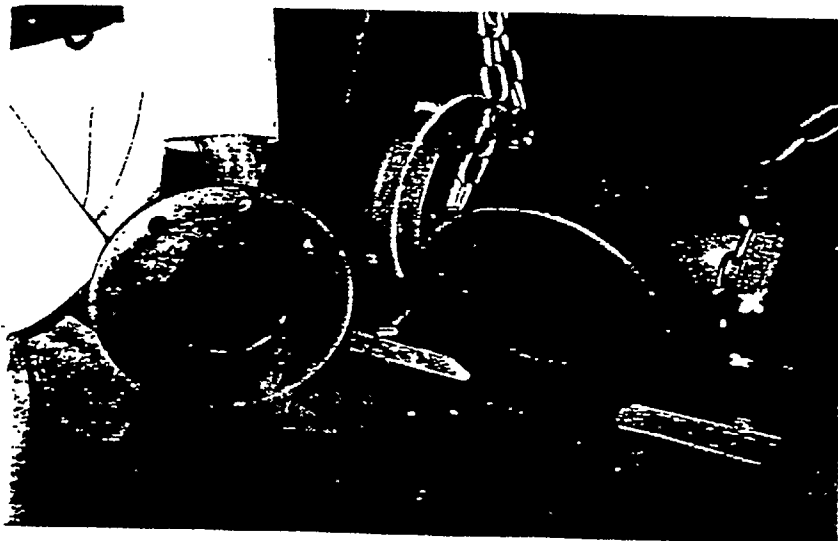


APPENDIX E

Original Photographs



-Photo 1-
Cutting of stock gasket material.

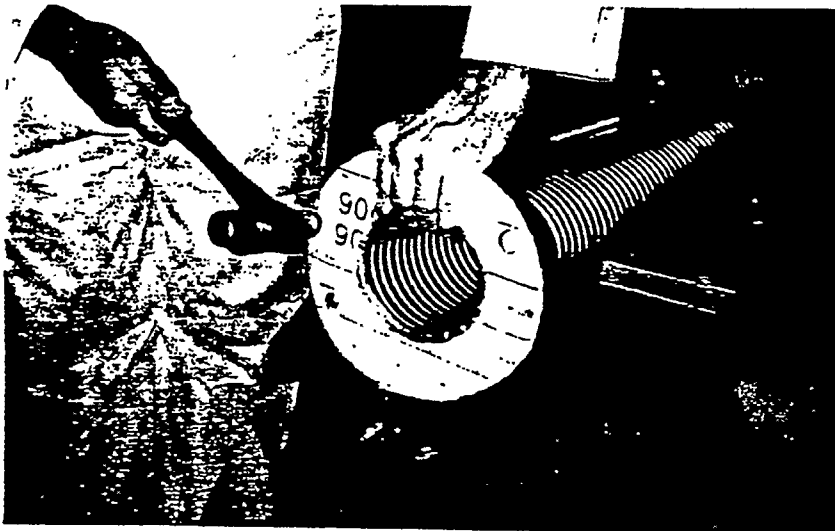


-Photo 2-
Separated flange. Fitting #10D is shown.

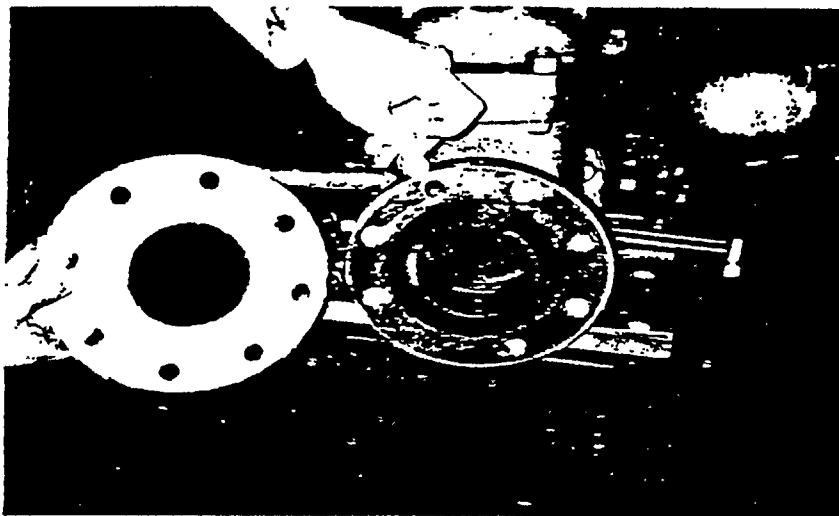
C:\COLTECPH\PHOTO 3P1



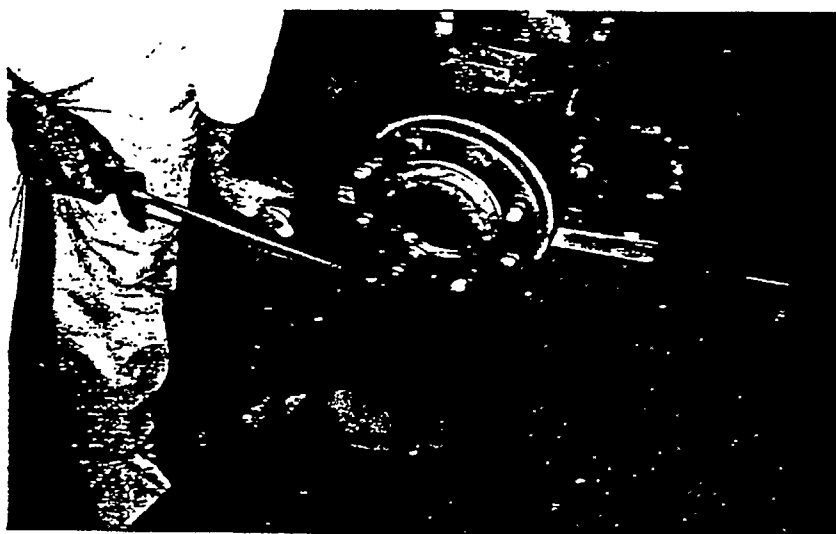
-Photo 3-
Shaping of gasket material at center portion. Fitting #10D
is shown.



-Photo 4-
Shaping gasket material at bolt holes. Fitting #17B is
shown.



-Photo 5-
Completed gasket. Fitting #7B is shown.



-Photo 6-
Tightening bolts. Fitting #7A is shown.