



DEPARTMENT OF LICENSING AND REGULATORY AFFAIRS
DIRECTOR'S OFFICE
OCCUPATIONAL HEALTH STANDARDS

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(By authority conferred on the director of the department of consumer and industry services by sections 14 and 24 of 1974 PA 154, MCL 408.1014 and 408.1024, and Executive Reorganization Order Nos. 1996-1 and 1996-2, MCL 330.3101 and 445.2001)

R 325.50251, R 325.50252, R 325.50253, R 325.50254, R 325.50255, R 325.50256, R 325.50257, and R 325.50258 are added to the Michigan Administrative Code as follows:

PART 523. ABRASIVE BLASTING

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Rule 3201 Rescinded March 16, 2001.

Rule 3205 Replaced by R 325.50251.

R 325.50251 Abrasive blasting.

Rule 1. (1) Scope. This rule applies to all operations where an abrasive is forcibly applied to a surface by pneumatic or hydraulic pressure, or by centrifugal force. It does not apply to steam blasting or steam cleaning, or hydraulic-cleaning methods where work is done without the aid of abrasives.

(2) This rule replaces O.H. rule 3205.

R 325.50252 Adoption of standards.

Rule 2. (1) The National Fire Protection Association standard NFPA 68 "Explosion Venting Guide," 1954 edition is adopted by reference and is available from the National Fire Protection Association, One Batterymarch Park, P.O. Box 9101, Quincy, MA 02269-9101 or via the internet at website: www.nfpa.org, at a cost as of the time of adoption of these amendatory rules of \$26.00 or is available for inspection at the Michigan Department of Consumer and Industry Services, Standards Division, 7150 Harris Drive, P.O. Box 30643, Lansing, Michigan 48909.

(2) The following occupational safety and health administrative standards as referenced in these rules are available for inspection or distribution to the public at the offices of the Michigan Department of Consumer and Industry Services, Standards Division, 7150 Harris Drive, P.O. Box 30643, Lansing, Michigan 48909 or via the internet at website: www.cis.state.mi.us/bsr/divisions/std.

(a) General industry safety standard Part 39. "Design Safety Standard for Electrical Systems" being R 408.13901 et seq. of the Michigan Administrative Code.

- (b) Occupational health standard Part 451. "Respiratory Protection" being R 325.60051 et seq. of the Michigan Administrative Code.
- (c) Occupational health standard Part 301. "Air Contaminants" being R 325.51101 et seq. of the Michigan Administrative Code.

R 325.50253 Definitions.

Rule 3. As used in these rules:

- (a) "**Abrasive**" means a solid substance used in an abrasive-blasting operation.
- (b) "**Abrasive-blasting respirator**" means a respirator constructed so that it covers the wearer's head, neck, and shoulders to protect the wearer from rebounding abrasive.
- (c) "**Blast-cleaning barrel**" means a complete enclosure which rotates on an axis, or which has an internal moving tread to tumble the parts, in order to expose various surfaces of the parts to the action of an automatic blast spray.
- (d) "**Blast-cleaning room**" means a complete enclosure in which blasting operations are performed and where the operator works inside of the room to operate the blasting nozzle and direct the flow of the abrasive material.
- (e) "**Blasting cabinet**" means an enclosure where the operator stands outside and operates the blasting nozzle through an opening or openings in the enclosure.
- (f) "**Clean air**" means air that will not cause harm or discomfort to an individual if it is inhaled for extended periods of time.
- (g) "**Dust collectors**" means a device or combination of devices for separating dust from the air handled by an exhaust ventilation system.

- (h) **“Exhaust ventilation system”** means a system for removing contaminated air from a space that is comprised of 2 or more of the following elements:
 - (i) An enclosure or hood.
 - (ii) Duct work.
 - (iii) Dust-collecting equipment.
 - (iv) Exhauster.
 - (v) Discharge stack.
- (i) **“Particulate-filter respirator”** means an air-purifying respirator, commonly referred to as a dust or a fume respirator, which removes most of the dust or fume from the air passing through the device.
- (j) **“Respirable dust”** means airborne dust in sizes capable of passing throughout the upper respiratory system to reach the lower lung passages.
- (k) **“Rotary blast-cleaning table”** means an enclosure where the pieces to be cleaned are positioned on a rotating table and are passed automatically through a series of blast sprays.
- (l) **“Abrasive blasting”** means the forcible application of an abrasive to a surface by pneumatic pressure, hydraulic pressure, or centrifugal force.

R 325.50254 Dust hazards from abrasive blasting.

Rule 4.

- (a) Abrasives and the surface coatings on the materials blasted are shattered and pulverized during blasting operations and the dust formed will contain particles of respirable size. An employer shall consider the composition and toxicity of the dust from these sources in making an evaluation of the potential health hazards.
- (b) An employer shall ensure that the concentration of respirable dust or fume in the breathing zone of the abrasive-blasting operator or any other worker is kept below the exposure levels specified in R 325.51102 et seq., being the Michigan occupational health air contaminant standard.
- (c) Organic abrasives that are combustible shall be used only in automatic systems. If flammable or explosive dust mixtures may be present, then the construction of the equipment, including the exhaust system and all electric wiring, shall conform to the requirements of American National Standard (ANS) Installation of Blower and Exhaust Systems for Dust, Stock, and Vapor Removal or Conveying, Z33.1-1961 (NFPA 91-1961) as adopted by reference in this rule, and R 408.13901 et seq. being the Michigan general industry safety standard Part 39, Design Safety Standard for Electrical Systems. Printed copies of ANS Z33.1-1961 are available from Global Engineering Documents, 15 Inverness Way East, Englewood, Colorado 80112, telephone number 1-800-854-7179, website: www.global.ihs.com, at a cost as of the time of adoption of these amendatory rules of \$20.00 or is available for inspection at the Michigan Department of Consumer and Industry Services, Standards Division, 7150 Harris Drive, P.O. Box 30643, Lansing, Michigan 48909. The blast nozzle shall be bonded and grounded to prevent the buildup of static charges. If flammable or explosive dust mixtures may be present, then the abrasive blasting enclosure, the ducts, and the dust collector shall be constructed with loose panels or explosion venting areas, located on sides away from any occupied area, to provide for pressure relief in case of explosion, following the principles set forth in the

National Fire Protection Association Explosion Venting Guide (NFPA 68-1954).

- (d) With respect to operational procedures and general safety, dust shall not be permitted to accumulate on the floor or on ledges outside of an abrasive-blasting enclosure, and dust spills shall be cleaned up promptly. Aisles and walkways shall be kept clear of steel shot or similar abrasive that may create a slipping hazard.

R 325.50255 Blast-cleaning enclosures.

Rule 5.

- (a) Blast-cleaning enclosures shall be exhaust ventilated so that a continuous inward flow of air will be maintained at all openings in the enclosure during the blasting operation.
- (b) All air inlets and access openings shall be baffled or arranged so that, by combining inward air flow and baffling, the escape of abrasive or dust particles into an adjacent work area will be minimized and visible spurts of dust will not be observed.
- (c) The rate of exhaust shall be sufficient to provide prompt clearance of dust-laden air within the enclosure after the cessation of blasting.
- (d) Before the enclosure is opened, the blast shall be turned off and the system shall be run for a sufficient period of time to remove the dusty air within the enclosure.
- (e) Where hard deep-cutting abrasives are used, safety glass protected by screening shall be used in observation windows.
- (f) Slit abrasive-resistant baffles shall be installed in multiple sets of all small access openings where dust might escape and shall be inspected regularly and replaced when needed.
- (g) Doors on blast-cleaning enclosures shall be flanged and tight when closed.
- (h) Doors on blast-cleaning rooms shall be operable from both inside and outside, except that where there is a small operator access door, the large work access door may be closed or opened from the outside only.

R 325.50256 Exhaust ventilation systems.

Rule 6.

- (a) The construction, installation, inspection, and maintenance of exhaust systems shall conform to the principles and requirements set forth in American National Standard Fundamentals Governing the Design, Construction, and Ventilation for Spray Finishing Exhaust Systems, Z9.3-1985, and ANS Z33.1-1961 which is adopted by reference in R 325.50254. Printed copies of ANSI Z9.3-1985 are available from Global Engineering Documents, 15 Inverness Way East, Englewood, Colorado 80112, telephone number 1-800-854-7179, website: www.global.ihs.com, at a cost as of the time of adoption of these amendatory rules of \$25.00 or is available for inspection at the Michigan Department of Consumer and Industry Services, Standards Division, 7150 Harris Drive, P.O. Box 30643, Lansing, Michigan 48909.
- (b) If dust leaks are noted, then repairs shall be made as soon as possible.
- (c) The static pressure drop at the exhaust ducts leading from the equipment shall be checked when the installation is completed and periodically thereafter to assure continued satisfactory operation. If an appreciable change in the pressure drop indicates a partial blockage, then the system

shall be cleaned and returned to normal operating condition.

- (d) In installations where the abrasive is recirculated, the exhaust ventilation system for the blasting enclosure shall not be relied upon for the removal of fines from the spent abrasive instead of an abrasive separator. An abrasive separator shall be provided for the purpose.
- (e) The air exhausted from blast-cleaning equipment shall be discharged through dust-collecting equipment. Dust collectors shall be set up so that the accumulated dust can be emptied and removed without contaminating other working areas.

R 325.50257 Respiratory protection.

Rule 7.

- (a) An employer shall implement a respiratory protection program in accordance with R 325.60051 et seq., being the Michigan occupational health respiratory protection standard Part 451., when respirators are required by this rule.
- (b) Abrasive-blasting respirators shall be worn by all abrasive-blasting operators in all of the following situations:
 - (i) When working inside blast-cleaning rooms.
 - (ii) When using silica sand in manual blasting operations where the nozzle and blast are not physically separated from the operator in an exhaust-ventilated enclosure.
 - (iii) Where concentrations of toxic dust dispersed by the abrasive blasting may exceed the

exposure limits set in R 325.51102 et seq., being the Michigan occupational health air contaminant standard, and the nozzle and blast are not physically separated from the operator in an exhaust-ventilated enclosure.

- (c) Employers may use properly fitted particulate-filter respirators, commonly referred to as dust-filter respirators, for short, intermittent, or occasional dust exposures such as cleanup, dumping of dust collectors, or unloading shipments of sand at a receiving point when it is not feasible to control the dust by enclosure, exhaust ventilation, or other means. The respirator used shall be for protection against the specific type of dust encountered.
- (d) Dust-filter respirators may be used to protect the operator of outside abrasive-blasting operations where nonsilica abrasives are used on materials that have low toxicities.
- (e) Dust-filter respirators shall not be used for continuous protection if silica sand is used as the blasting abrasive or if toxic materials are blasted.

R 325.50258 Air supply and air compressors.

Rule 8. An employer shall ensure that air for abrasive-blasting respirators is free of harmful quantities of dusts, mists, or noxious gases, and meets the requirements for supplied-air quality and use specified in R 325.60051 et seq., being the Michigan occupational health respiratory protection standard



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