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DEPARTMENT OF COMMERCE
BUREAU OF STANDARDS
S. W. STRATTON, DIRECTOR

NATIONAL SAFETY CODE FOR THE PROTECTION OF THE HEADS AND EYES OF INDUSTRIAL WORKERS

FIRST EDITION
DECEMBER, 1920

BUREAU OF STANDARDS
HANDBOOK SERIES

No. 2



PRICE, 10 CENTS

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Government Printing Office

WASHINGTON
GOVERNMENT PRINTING OFFICE
1921

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INTRODUCTION *

This is the second National Safety Code that has been developed by the Bureau of Standards. The first complete edition of the National Electrical Safety Code was published in 1916. The need for a series of national safety codes soon became manifest, and at the close of the war the matter of their preparation was actively taken up. Conferences were held at the Bureau of Standards on January 15 and December 8, 1919, to arrange for general cooperation in the work of developing safety codes and for the coordination of the work done by different agencies.

As a result of these conferences it was generally agreed that safety codes should be developed under the scheme of procedure of the American Engineering Standards Committee which had recently been organized through the efforts of the national engineering societies. As a result of action taken at the December conference and at the request of the American Engineering Standards Committee, a joint committee was organized by the International Association of Industrial Accident Boards and Commissions, the National Safety Council, and the Bureau of Standards. This committee included representatives of the above bodies, of a number of State industrial commissions, insurance interests, engineering societies, etc. This committee prepared a list of 37 subjects which it considered the most urgent ones to be covered by safety codes, and it recommended sponsors for a large number of these. The American Engineering Standards Committee accepted most of the recommendations and has arranged accordingly

* The preparation of this code is largely the work of Morton G. Lloyd and Charles E. Oakes, of the safety section of this Bureau, under the supervision of Edward B. Rosa, chief physicist. The optical division of the Bureau and the division of engineering testing have contributed through laboratory tests and advice.

for sponsors for these codes. Among them was the Code for the Protection of the Heads and Eyes of Industrial Workers, and the Bureau of Standards was requested to act as sponsor for such a code.

By the time this action had been taken the present code was nearly complete. The Bureau had already organized an advisory committee on this code, the scope and make-up of which correspond with that of the sectional committee contemplated by the rules of procedure of the American Engineering Standards Committee. The advisory committee consists of the following persons:

M. W. ALEXANDER, National Industrial Conference Board, Boston, Mass.

CLAUDE ALLING, Underwriters' Laboratories (Inc.), Chicago, Ill.

C. B. AUDEL, Westinghouse Electric & Manufacturing Co., East Pittsburgh, Pa.

H. J. BOGGIS, National Founders' Association, Cleveland, Ohio.

E. S. CHAPIN, Pennsylvania Railroad, Philadelphia, Pa.

R. J. CULLEN, State Industrial Commission, New York, N. Y.

GEORGE F. HARRIS, International Association of Machinists, Schenectady, N. Y.

C. H. KERR, American Optical Co., Southbridge, Mass.

F. G. LANGE, Ohio Industrial Commission, Columbus, Ohio.

B. W. NUTT, The Safety Equipment Service Co., Cleveland, Ohio.

J. A. OARTEL, Carnegie Steel Co., Pittsburgh, Pa.

F. D. PATTERSON, Pennsylvania Department of Labor and Industry, Harrisburg, Pa.

MAX POSER, Bausch & Lomb Optical Co., Rochester, N. Y.

G. E. SANFORD, American Society of Safety Engineers, West Lynn, Mass.

H. A. SCHULTZ, United States Steel Corporation, New York, N. Y.

W. C. SMITH, International Association of Machinists, Washington, D. C.

S. J. WILLIAMS, National Safety Council, Chicago, Ill.

FREDERICK WILLSON, Willson Goggles, Inc., Reading, Pa.

C. L. YORK, General Electric Co., Schenectady, N. Y.

In 1918 the Bureau cooperated with the safety engineers of the War and Navy Departments in the preparation of a

set of safety standards to be applied in the Government establishments. Among these standards was one for head and eye protection, and this formed the basis for the present national code. These rules were further developed through study and experimental work at the Bureau and conferences with other parties who had had experience in eye protection. Preliminary drafts were issued in December, 1918, and in May, September, and December, 1919. On March 12, 1920, the Advisory Committee met in Philadelphia and revised the latest draft but did not consider that the code was yet ready for final action. The questionable points were later settled by mail and subsequently the committee approved by letter ballot the present draft of this code. The Bureau takes this opportunity to thank the members of this committee for their assistance and for the interest that has been shown in developing the best possible code as a result of their wide knowledge and experience.

In the meantime the Pennsylvania Department of Labor and Industry had begun consideration of this subject. Several drafts of the code were drawn up and conferences and hearings were held at Harrisburg. Representatives of the Bureau participated in this work and the present draft of this code has benefited by the discussion and ideas brought out at the Pennsylvania conferences.

The arrangement of the code is such as to first present the general requirements, including a classification of the occupations which require eye protection. There then follows the detailed requirements for each group of occupations, operating rules, and finally the specifications for tests which must be met to insure that protectors will adequately fulfill their purpose. The last section of the code giving these specifications need only be considered by those who must determine whether protectors are suitable for the intended purpose; that is to say, by those agencies who will determine

the approval of goggles or other devices as complying with the requirements of this code, or, in the absence of such approval, by the purchasers of goggles who wish to determine for themselves the adequacy of the protectors offered for sale.

Following the code is a discussion of the rules which is intended to assist the reader in understanding the reasons for the rules and in interpreting the rules, and to give suggestions for the best means of carrying them out. It is hoped that those having occasion to apply the rules will contribute from their experience to amplify this part of the publication in future editions.

This code is one for which the Bureau of Standards was recognized as sponsor by the American Engineering Standards Committee. It has been submitted to the Standards Committee for approval as Recommended Practice.

The Bureau will be glad to receive criticisms of its provisions and recommendations for its improvement, especially such as are based upon actual experience in the application of its rules. After a period of trial and experience it is expected to issue a new edition, with such changes and corrections as that experience may dictate.

S. W. STRATTON, *Director*.

OCTOBER 26, 1920.

NATIONAL SAFETY CODE FOR THE PROTECTION OF THE HEADS AND EYES OF INDUSTRIAL WORKERS

SECTION 1. GENERAL REQUIREMENTS

10. Scope, Application, and Compliance

(a) *Scope*.—The following rules apply to all industrial operations or processes which, by reason of the nature of the operation or process, present a sufficiently serious hazard to the head, face, neck, or eyes of a workman as to be liable to injure them.

Protectors are not required if the machine is furnished with guards which adequately protect the worker from the hazards classified in rule 11.

(b) *Application*.—Employers shall furnish protectors of a type suitable for the work to be performed, and the employee shall use such protectors when employed in processes or operations, or those of similar hazard, designated in rule 11 by the following letters: A, B, D, E, F, H, and I. Employers shall furnish protectors upon application of employees working in the processes or operations classified in Groups C and G, rule 11.

(c) *Compliance*.—The method to be pursued to assure that protectors will be used which meet the specifications and tests prescribed by these rules, shall be determined by the proper administrative authority.

The word "shall," where used, signifies that the requirement is mandatory and "should" advisory.

11. Classification of Operations and Processes

The processes or operations in which it is necessary that the operator be given protection to the head or eyes, or both, are divided into nine groups, each of which requires a protector having distinctive features. The examples given for each group are illustrative only and are not intended to be complete lists of the operations or processes for which protection is necessary. These groups are as follows:

GROUP A.—Processes where protection from relatively large flying objects is required.

Examples of these processes are chipping, calking, and some riveting operations.

GROUP B.—Processes where protection from dust and small flying particles is required.

Examples are scaling and grinding of metals, stone dressing, and some woodworking operations.

GROUP C.—Operations where protection from dust and wind is required.

Examples are automobile driving, locomotive driving¹ and firing, and electric spot and butt welding, where there is no exposure to radiant energy.

GROUP D.—Processes where protection from splashing metal is required.

Examples are babbitting, pouring of lead joints for cast-iron pipes; casting of hot metal if there is a possibility that water is present; and dipping in hot metal baths.

GROUP E.—Processes where protection from gases, fumes, and liquids is required.

Examples are handling of acids and caustics, dipping in galvanizing tanks, and some japanning operations.

GROUP F.—Processes where protection from an excessive amount of dust and small flying particles is required.

An example of these processes is sand-blasting.

GROUP G.—Operations where protection is required from reflected light or glare.

Examples are long exposure to snow-covered ground, exposure to reflected sunlight from roofs, roadbeds, etc.

GROUP H.—Processes where protection from injurious radiant energy with a moderate reduction in intensity of the visible radiant energy is required.

Examples are oxy-acetylene and oxy-hydrogen welding and cutting; open-hearth, Bessemer, and crucible steel making; furnace work, electric resistance welding, brazing, and testing of lamps, involving exposure to excessive brightness.

GROUP I.—Processes where protection from injurious radiant energy with a large reduction of the visible radiant energy is required.

Examples are electric arc welding and cutting.

12. Definitions.

Protector.—A protector is a device which is placed in front of the eyes, face, or head to afford protection from the hazards in industrial processes or from the natural elements.

Goggles.—Goggles are an optical device worn before the eyes, whose predominant function is protection to the eyes only.

Face Mask.—A face mask is a device worn before the eyes and a portion or all of the face, whose predominant function is protection to the eyes and face.

Helmet.—A helmet is a rigid device worn by the operator, which shields the eyes, face, neck, and a portion or all of the other parts of the head and is held in place by suitable means.

Hood.—A hood is a device which completely covers the head, neck, and portions of the shoulders so as to exclude dust and flying particles.

Shield.—A shield is a device to be held in the hand, or supported without the aid of the operator, whose predominant function is protection to the eyes and face.

13. Classification of Protectors

The face mask, helmet, shield, and hood types of protectors are referred to in these rules by name.

For the purpose of clearly defining the application of the styles of goggles to the processes given in rule 11, and for clearly differentiating between the tests which are to be applied to them, goggles shall be considered as falling in two main classes, namely, rigid-front goggles and goggles with flexibly connected lens containers. Included in the class of goggles with rigid fronts are the nonadjustable rigid-bridge type and the adjustable metallic-bridge type of goggles, in both of which the bridge is rigidly fastened to the lens container. The flexibly connected type of goggles consists of those which have a flexible connecting link between the lens containers. The link is usually of leather, but any other material of equal serviceability may be used.

Goggles shall be designated according to styles as follows:

Style 1.—Goggles having rigid nonadjustable bridge (or adjustable metallic bridge) without side shields.

Style 2.—Goggles having rigid nonadjustable bridge (or adjustable metallic bridge) with side shields.

Style 3.—Goggles having flexibly connected lens containers shaped to conform to the configuration of the face.

14. Lenses for Persons Having Defective Vision

Employees whose vision requires the use of corrective lenses in spectacles, and who are required by these rules to wear protective goggles, shall be provided with goggles to be worn over the corrective spectacles. The goggles shall be so arranged that the optical adjustment of the spectacles will in no way be disturbed. In lieu of such goggles, employees

may be provided with goggles whose lenses provide the proper optical correction, but these lenses need not be subjected to the drop test as required by rule 21 (b). Where corrective lenses are used they shall be so marked that improper adjustment will be avoided.

15. Replacement of Lenses

Protectors, the lenses of which may be replaced, shall be so designed that this may be accomplished without the use of tools of special character and design.

Lenses, or windows, and lens containers should be substantially uniform as to dimensions so as to facilitate the replacing and interchanging of lenses. The employer shall be responsible for the proper replacement of lenses upon application of an employee.

16. General Requirements for Glass

(a) *All Glass*.—Glass for lenses and windows of protectors shall be hard, substantially free from striæ, air bubbles, waves, and other flaws. The front and rear surfaces shall be smooth and substantially parallel, except where the lens is ground to provide proper optical correction for defective vision.

(b) *Goggle Lenses*.—All lenses shall have dimensions not less than 1.5 inches (38 mm) in the vertical direction and 1.75 inches (44.5 mm) in one horizontal direction.

SEC. 2. PROTECTORS FOR CHIPPERS, RIVETERS, CALKERS, ETC.

GROUP A

20. Styles Permitted

Goggles of styles Nos. 2 and 3, face masks and helmets are the only permissible styles.

21. Specifications and Tests for Lenses

(a) *Specifications*.—Lenses shall transmit not less than 80 per cent of the visible light from the standard source specified in rule 124 (a). (See also rule 16.)

Each lens shall bear some permanent distinctive marking by which its source may be readily identified.

(b) *Test*.—Samples of lenses for use in operations included in Group A shall be submitted to the tests described in rule 123 to determine their quality. Lenses which are submitted to the drop test shall not be used in service.

22. Goggles of Style No. 2

(a) *Frames*.—Frames shall be made of a material that will withstand sterilization and will not corrode and will not discolor the skin. Frames shall have a smooth finish.

(b) *Lens Containers*.—Containers shall be suitable for holding lenses of dimensions specified in rule 16.

(c) *Side Shields*.—If goggles are provided with side shields, such shields shall be made of metal, leather, or other material of suitable durability. No quick-burning material shall be used. The material shall be sufficiently pliable to permit adjusting the shield to the contour of the face. The edges coming in contact with the face shall be finished in a manner to prevent irritating or cutting the skin. If the side shields are of metal, they shall be of wire mesh or of perforated sheet having openings not larger than 0.0394 inch (1 mm). Adequate ventilation shall be provided.

The construction of the goggles shall be such as to permit the folding of the temples so that they may be stored in a case or container.

(d) *Temples*.—Temples shall be made of a material which can be sterilized without deterioration and will not readily corrode and will not discolor the skin. Ear hooks for temples shall be flexible, properly formed to fit the ear, and so finished

or covered as not to cut or irritate the skin. No quick-burning material shall be used. If a covering be used, it shall extend for half the length of the temple and be of a material which will not readily deteriorate in service. The screw or rivet which fastens the temple to the frame shall not also be used to hold the lens in the container.

(e) *Short Temples*.—Short temples may be substituted for full-length temples. They shall be made of a material that will not readily corrode and will not discolor the skin. They shall be attached to the frame in the same manner as and be interchangeable with the full temples. A head band shall be fastened to the outer ends of the short temples and shall be adjustable as to length and easily replaceable.

(f) *Headband or Headgear*.—In lieu of full temples or short temples, a headband or headgear of any suitable material and design may be supplied that will properly retain the goggles in position and afford comfort and protection to the wearer. Such headgear shall be adjustable as to size or shall be supplied in properly assorted sizes.

(g) *Connection between Lens Containers*.—Nose pieces, bridges, or connecting links between lens containers shall have the portions that come in contact with the skin of a material that will not readily corrode and will not discolor the skin. The construction shall be substantial and the nose piece, bridge, or connecting link shall be securely fastened to the lens containers. If the weight of the goggle is borne by the bridge or nose piece resting on the crest or sides of the nose of the wearer, these portions of the goggles shall have broad comfortable surfaces. The nose piece, bridge, or connecting link shall be so constructed as to be readily adjustable, or the goggle shall be furnished in assorted sizes.

(h) *Marking*.—Each frame shall bear some permanent distinctive marking by which its source may be readily identified.

23. Goggles with Flexibly Connected Lens Containers, Style No. 3

(a) *Eyecups*.—Eyecups shall be made of rigid, nonflammable material that will not corrode and will not discolor the skin and can be sterilized without deterioration. They shall be shaped to conform to the configuration of the face and shall have edges which will not cut the face. Proper ventilation shall be provided and the goggles shall be fitted with a headband or headgear of cloth, leather, or other suitable material, which will retain them in their proper position with reasonable comfort.

(b) *Lens Containers*.—Containers shall be suitable for holding lenses of dimensions specified in rule 16 (b). They should be designed to permit easy replacement of lenses.

24. Test for Frames

The frames of goggles of style No. 2, having either adjustable or rigid bridges, used in processes included in Group A, shall withstand the tests prescribed in rules 121 (c), (d), and 122. The frames of protectors having rigid bridges used in processes included in Group A shall also withstand the tests prescribed in rule 121 (a) and (b). The frames of goggles of style No. 3, if used in operations included in Group A, shall withstand the tests prescribed in rules 121 (c) and 122.

If face masks or helmets are used, the lens containers shall be of such strength as to withstand the equivalent of the strength test prescribed in rule 121 (c).

SEC. 3. PROTECTORS FOR SCALING, GRINDING, ETC.

GROUP B

30. Styles

Goggles of styles Nos. 1, 2, and 3 are permissible styles. They need not comply with any strength tests.

31. Specifications for Lenses

Lenses shall transmit not less than 80 per cent of the visible light from the standard source specified in rule 124 (a). (See also rule 16.)

32. Goggle Frames

(a) *Styles Nos. 1 and 2.*—Frames of goggles of styles Nos. 1 and 2 for this class of service shall comply with rule 22 (except that the requirements of 22 (c) for side shields do not apply to goggles of style No. 1).

(b) *Eyecup Goggles.*—Eyecup goggles shall conform to the requirements of rule 23.

SEC. 4. PROTECTORS FOR EXPOSURE TO DUST AND WIND, ETC.

GROUP C

40. Styles

Goggles of styles Nos. 1, 2, and 3 are permissible styles. They need not comply with any strength tests.

41. Specifications

(a) *Goggle Frames.*—Frames and temples shall be substantially made. Eyecup goggles shall comply with rule 23.

(b) *Lenses.*—Lenses shall transmit not less than 80 per cent of the visible light from the standard source specified in rule 124 (a). (See also rule 16.)

SEC. 5. PROTECTORS FOR BABBITTING, ETC.

GROUP D

50. Styles

A face mask and goggles of styles Nos. 1, 2, and 3 are permissible styles. They need not comply with any strength tests.

51. Specifications for Masks

Face masks may be of woven wire, the openings of which shall not exceed 0.0295 inch (0.75 mm), vulcanized fiber, or equivalent material which can be sterilized without deterioration.

Masks shall be designed to hold lenses of dimensions specified in rule 53.

52. Specifications for Goggle Frames

Frames of goggles of styles Nos. 1 and 2 shall conform to the requirements of rule 22 (except that the requirements of rule 22 (c) for side shields do not apply to goggles of style No. 1). Goggles of style No. 3 shall conform to the requirements of rule 23.

Lens containers shall be so constructed as to retain the parts of the lens in position if it should become cracked.

53. Specifications for Lenses

Lenses shall have a thickness not less than 0.079 inch (2 mm).

If a single window is used in place of separate lenses, it shall have dimensions not less than 4.25 inches (10.8 cm) in one horizontal direction and not less than 2 inches (5.1 cm) in the vertical direction.

Lenses shall transmit not less than 80 per cent of the visible light from the standard source specified in rule 124 (a). (See also rule 16.)

SEC. 6. PROTECTORS FOR HANDLING CORROSIVE CHEMICALS, DIPPING, BRUSH COATING, ETC.

GROUP E

60. Styles

Eyecup goggles of style No. 3, face masks, and hoods are permissible styles. They need not comply with any strength tests.

61. Specifications for Goggles

(a) *Goggles for Handling Acids, Caustics, etc.*—Eyecups shall be of soft pliable rubber or equivalent noninflammable material and shall be flexible enough to conform readily to the configuration of the face. A suitable headband or headgear shall be provided, and it shall be impossible for splashing liquids to enter the eyes through the openings provided for ventilation. Where the presence of fumes would cause discomfort to the wearer if ventilating ducts were provided, goggles without ventilating openings shall be used.

(b) *Goggles for Use in Dipping and in Brush Coating.*—Eyecups shall conform to the requirements of rule 23. The design having solid eyecups except for a single ventilating opening near the lens is preferable. If the volume of fumes arising from the work is great, the eyecups shall be padded so that they fit the face closely.

62. Specifications for Face Masks

Face masks shall be of metal, vulcanized rubber, fiber, or equivalent material and shall have no openings in the front of the mask other than required for lenses. Masks shall be so shaped as to effectively protect the entire face.

63. Specifications for Hoods

Hoods shall cover the head and neck completely and shall extend below the shoulders so as to effectively exclude gases.

Ventilation may be secured from an external source, the air being conducted to the operator by means of a hose. The air pressure should be so reduced and the distribution of the air within the hood should be such that the employee is not subjected to physical discomfort during or as a result of his work. It is recommended that a separator trap be provided on the air line for the removal of oil, water, and other extraneous matter.

64. Specifications for Lenses

If a single window is used in place of separate lenses, it shall have dimensions not less than 4.25 inches (10.8 cm) in one hori-

zontal direction and not less than 2 inches (5.1 cm) in the vertical direction.

Lenses shall transmit not less than 80 per cent of the visible light from the standard source specified in rule 124 (a). (See also rule 16.)

For processes which will undesirably affect the surface of the glass either by deposits or chemical action, lenses of other material than glass, suitable for the process concerned, may be used. Lenses of cellulose acetate or other material substantially free from striae, air bubbles, waves, and other flaws may be used.

SEC. 7. PROTECTORS FOR SANDBLASTING

GROUP F

70. Styles

A hood is the only style permitted.

The use of sandblast cabinets so arranged that the operator can stand on the outside and direct the nozzle through an opening, observing the operation through a suitable window, is recommended. In this case no hood is required.

71. Specifications

Hoods shall cover the head and neck completely and shall extend below the shoulders, so as to effectively exclude dust and small particles.

A window of metal screen having openings not larger than 0.0295 inch (0.75 mm) shall be used. This window may be furnished with a glass lens inside of the metal screen. If no glass is used for the window, a suitable respirator shall be provided to filter the air.

Ventilation may be secured from an external source, the air being conducted to the operator by means of a hose. The air pressure should be so reduced and the distribution of the air within the helmet should be such that the employee is not subjected to physical discomfort during, or as a result of, his work. It is recommended that a separator trap be provided on the air line for the removal of oil, water, and other extraneous matter.

SEC. 8. PROTECTORS FOR EXPOSURE TO GLARE

GROUP G

80. Styles

Goggles of styles Nos. 1, 2, and 3 are permitted. They need not comply with any strength tests.

81. Specifications

(a) *Frames*.—The frames of goggles shall be substantially constructed.

(b) *Lenses*.—Lenses shall meet the tests for transmission of radiant energy prescribed in rule 124 (b). (See also rule 16.)

SEC. 9. PROTECTORS FOR OXY-ACETYLENE WELDING, FURNACE WORK, ETC.

GROUP H

90. Styles

Goggles of styles Nos. 1, 2, and 3, face masks, helmets, and shields are permitted. They need not comply with any strength tests.

91. Goggles of Style No. 1 or 2

The frames shall conform to the specifications given in rule 22 (except that the requirements of rule 22 (c) for side shields do not apply to goggles of style No. 1). To prevent burning, a heat-insulating material which can be sterilized without deterioration shall be used on all parts touching the face.

92. Eyecup Goggles, Style No. 3

Goggles shall consist of eyecups of noncorrodible opaque material, which can be sterilized without deterioration. They shall be shaped to fit the configuration of the face. They shall exclude light, except through the lenses, but shall afford adequate ventilation. Parts touching the face shall be made of heat-insulating material. The eyecups

shall be connected by a flexible coupling which will permit ready adjustment, or else goggles shall be furnished in assorted sizes.

The coupling shall be covered with or made of heat-insulating material. It shall withstand sterilization or be easily renewable. Goggles shall have a headband or headgear of any suitable material which will retain the goggles in their proper position. Each pair of goggles shall bear some permanent distinctive marking by which its source may be readily identified.

93. Face Masks

(a) *Masks and Headgear.*—Face masks shall be of fiber or equivalent material, which can be sterilized without deterioration and be shaped so as to protect the face of the operator above the mouth. Face masks shall have a headband or headgear of any suitable design and material so as to retain the mask in proper position. Each face mask shall bear some permanent distinctive marking by which its source may be readily identified.

(b) *Lens Containers.*—If a single window is used in place of separate lenses, it shall hold glass the dimensions of which are not less than 4.25 inches (10.8 cm) in one horizontal direction and 2 inches (5.1 cm) in the vertical direction. Containers shall be designed to accommodate cover glasses to protect the lenses. The design shall permit ready renewal of lenses.

94. Helmets

Helmets of the design specified in rule 101 (b) are permitted.

95. Specifications and Tests for Protective Glass

(a) *Optical.*—Lenses shall meet the transmission test for radiant energy prescribed in rule 124 (c).

Lenses constructed of two parts may be used if the lower half conforms to the requirements of rule 124 (c).

(b) *Marking*.—Glasses, except cover glasses, shall bear some permanent distinctive marking by which the source may be readily identified.

(c) *Cover Glasses*.—Cover glasses should be provided to protect the lenses. They shall be substantially free from striæ, air bubbles, and other flaws, and shall have substantially parallel surfaces. (See also rule 16.)

SEC. 10. PROTECTORS FOR ELECTRIC ARC WELDING AND CUTTING

GROUP I

100. Styles

The helmet and the shield are the only permissible styles.

101. Specifications for Protectors

(a) *Helmets*.—Helmets shall be capable of withstanding sterilization (for test see rule 110) and shall comply with one of the following specifications:

(1) *Pivotally Mounted Type*.—The helmet shall be made of a material, which is an insulator for heat and electricity, shaped so as to protect the face of the operator, and curved back on each side beyond the ears. The helmet may be pivotally mounted on adjustable headgear, so arranged that it can be tipped back over the operator's head when not in use. The shield shall have a window frame to accommodate and hold securely rectangular windows, single or in multiple, of the dimensions specified in rule 102, together with a cover glass, and shall be so designed as to permit easy renewal of the windows. The total weight of complete equipment shall not exceed 24 ounces (680 g.).

(2) *Shoulder-Supported Type*.—The helmet shall consist of opaque material, which is an insulator for heat and electricity, arranged so as to rest on the shoulders and (or) chest and of such size and so shaped that it will protect the face from direct radiant energy. It shall be fitted with an opening to carry

windows, single or multiple, of the dimensions specified in rule 102.

(b) *Shields*.—The shield shall consist of opaque material which is an insulator for heat and electricity. It shall be of such size and so shaped that it will protect the face from all direct radiant energy and shall be provided with an opening fitted to carry windows, single or multiple, of the dimensions specified in rule 102.

102. Specifications and Tests for Windows

(a) *Optical*.—Windows shall meet the tests for transmission of radiant energy prescribed in rule 124 (d). (See also rule 16.)

(b) *Dimensions*.—Windows for both helmets and shields shall have dimensions not less than 2 inches (5.1 cm) in the vertical direction and 4.25 inches (10.8 cm) in one horizontal direction. They shall be so mounted as to be not less than 2 inches (5.1 cm) from the eyes.

(c) *Marking*.—Glasses, except cover glasses, shall bear some permanent distinctive marking by which the source may be readily identified.

(d) *Cover Glass*.—A cover glass should be provided to protect the lenses. It shall be substantially free from striæ, air bubbles, and other flaws, and shall have substantially parallel surfaces.

103. Protection for Other Workers

A guard or shield shall be provided where necessary to protect other workers from exposure to the radiation from the electric arc, and no employee shall be required to work in such a position that his face is exposed to such radiation from any neighboring source.

It is recommended that permanent inclosures be supplied, where practicable, for arc welding and cutting.

SEC. 11. OPERATING RULES**110. Sterilization**

Goggles shall not be interchanged among employees unless they have been sterilized. The following methods for sterilization are recommended:

(1) Goggles, parts of which would ordinarily deteriorate if sterilized by either of the following methods, may be sterilized by an antiseptic gas for a period of 10 minutes. An atmosphere of formaldehyde is recommended.

(2) Goggles and cases shall be placed in boiling water for a period of 5 minutes.

(3) Goggles shall be placed for 10 minutes in a solution of formalin made by placing 0.106 ounce (3 g) of 40 per cent formaldehyde in a quart of water.

111. Supply and Fitting of Goggles

The employer shall advise his employees where within the works protectors may be obtained, and employees shall not be put at work where protectors are needed without being provided with them. Care shall be exercised to properly adjust protectors which are not an exact fit, to secure the greatest comfort consistent with adequate protection. Particular attention should be given when fitting goggles to be sure that the eyelashes of the wearer do not touch the surface of the glass.

A duly appointed agent or employee should be assigned the duty of distributing and fitting eye protectors as a result of indicated or demonstrated ability to perform this duty efficiently.

112. Replacement of Defective Protectors

The employee shall be responsible for immediately reporting any broken or otherwise defective protectors, and for making application to the employer for their repair or replacement.

The employer shall be responsible for the proper replacement of protectors or their defective parts.

Employees shall never wear defective protectors. Broken or damaged parts shall be replaced by new parts before the protectors are again used.

113. Inspection of Protectors

It is recommended that periodical inspection of all protectors be made by the employer or his authorized representative so that the wearing of protectors in good condition will be assured.

114. Cases

A suitable individual unlined metal case with rounded corners, capable of withstanding sterilization, should preferably be furnished to each employee using goggles.

115. Supply of Protectors or Repair Parts

Employers shall keep an adequate supply of protectors or repair parts in stock at all times.

Where rigid nonadjustable goggles are used, assorted sizes shall be kept in stock at all times.

SEC. 12. TESTS FOR FRAMES AND GLASS

120. Scope of Tests

The following tests for the frames and glass of protectors are intended to assure adequate strength and other qualities of protectors used in those processes named in the rules of the foregoing sections in which tests are required. The number of frames, lenses, or windows to be tested shall be determined by the proper administrative authority.

121. Mechanical Tests for Frames of Goggles

(a) *Flat Transverse Test.*—Each frame tested shall have the right lens container laid flat, with the outer surface of the lens downward, on a firm level support so that the left lens

and one-half of the bridge projects beyond the edge of the support and shall be held in this position. A spring balance shall be attached to the outermost portion of the frame of the left lens, and a downward force of 8 ounces (226 g) shall be applied while the right lens frame is rigidly held. After removal of the load no permanent deformation shall be apparent in the frame.

(b) *Edge Transverse Test*.—Each frame tested shall have the right lens container held vertically in one hand and the lower edge of the left lens container, as worn, pressed against one of the platforms of an equal-arm balance having a weight of 4 pounds (1.82 kg) on the other platform. The pressure shall be increased until the weight is balanced, whereupon the frame is removed and examined. No permanent deformation shall be apparent in the frame.

(c) *Strength Test for Lens Containers*.—Lens containers shall be substantial in construction and each container tested shall withstand, without distortion, the drop test prescribed in rule 123.

(d) *Test of Joints*.—If the lens containers are rigidly joined by a separate bridge or nose piece in any manner whatsoever, the joints shall be given the following tests to demonstrate their strength and durability. Goggles which have already passed the strength tests of paragraphs (a), (b), and (c) above may be used for this purpose. The lens containers with lenses in place shall be gripped one in each hand, the thumbs bearing on the outer surface near the bridge and the fingers on the inner surface of the lenses near the junction of the bridge and the lens container. The frames shall then be slowly bent, the direction of motion being in a plane perpendicular to the surface of the lenses, until the outer surfaces of the lenses face each other, the outer ends of the frames touching. The frames shall then be bent back to their original shape and a careful inspection made for failure in the joints. All frames tested shall pass this test without developing visible cracks.

If the bridge is constructed with individual members of the bridge in more than one plane parallel to the surface of the lenses, all of the members except those attached to the rims of the lens containers shall be cut and the above test applied to the remaining members.

122. Test for Corrosion

The corrodibility of the metal of the frame and side shields shall be determined by immersing a pair of goggles in a boiling aqueous 10 per cent (by weight) solution of sodium chloride for a period of 15 minutes. The frames upon being removed from this solution shall be immediately immersed in a 10 per cent (by weight) aqueous solution of sodium chloride at room temperature. They shall then be removed from this solution and, without having the adhering liquid wiped off, allowed to dry for 24 hours at room temperature. The metal parts shall then be rinsed in lukewarm water and allowed to dry. On inspection the surface shall still be smooth.

123. Mechanical Tests for Lenses

Drop Test.—Lenses shall be submitted to either of the two following tests to determine the quality of material used in the manufacture of such lenses, and are acceptable if they pass either test.

(1) A spherical steel ball 0.565 ounce (16 g) in weight, approximately 0.625 inch (1.59 cm) in diameter (weight must be correct within 2 per cent), shall be dropped 10 times from a height of 21.2 inches (54 cm) on the center of the horizontal outer surface of the lens when held in the frame. The lens shall be supported by the rim of the container only, on a rubber washer 0.25 inch (6.4 mm) thick, secured to the top of a board or block of wood. If one out of six lenses is fractured in this test, four more lenses shall be tested, and if any one of these is fractured, the lot shall be rejected.

(2) A spherical steel ball 0.565 ounce (16 g) in weight, approximately 0.625 inch (1.59 cm) in diameter (weight must be correct within 2 per cent), shall be dropped once from a

height of 39.37 inches (1 m) on the center of the horizontal outer surface of the lens when held in the frame. The lens shall be supported by the rim of the container only, on a rubber washer 0.25 inch (6.4 mm) thick, held upon the top of a board or block of wood. If one out of six lenses tested is fractured in such a way that a fragment of glass weighing more than 0.39 grain (25 mg) leaves the bottom surface, four more lenses shall be tested, and if one of these lenses fractures in the above-described manner the lot shall be rejected.

124. Optical Tests for Lenses

(a) *Standard Source of Radiant Energy.*—The standard source of radiant energy used for the measurement of transmission of visible light or total radiant energy shall be a 200-watt, 110-volt, gas-filled, tungsten-filament, electric incandescent lamp operating at 0.8 watt per spherical candle (approximate commercial rating).

(b) *Lenses for Group G.*—Lenses shall transmit not more than 1 per cent of radiant energy of any wave length less than 406 millimicrons. They shall transmit not more than 50 per cent of the visible light from the standard source.

(c) *Lenses for Group H.*—Lenses for helmet windows shall transmit not more than 1 per cent of radiant energy of any wave length less than 406 millimicrons. They shall transmit not more than 50 per cent of the total radiant energy from the standard source.

(d) *Windows for Group I.*—Helmet windows shall transmit not more than 1 per cent of radiant energy of any wave length less than 406 millimicrons. They shall transmit not more than 1 per cent of the visible light and not more than 10 per cent of the total radiant energy from the standard source.

DISCUSSION OF THE RULES

SECTION 1. GENERAL REQUIREMENTS

The need for definite requirements to protect the eyes of industrial workers is well illustrated by the fact that in the year 1918 there occurred in the State of Pennsylvania alone 705 industrial accidents resulting in the loss of one or both eyes. The hazards are such as frequently to go without attention in a particular shop until an accident occurs. Even in shops where goggles are provided, workmen frequently go unprotected. Hence, whereas shops providing goggles are likely to have a lower rate of eye injuries than others, this rate will not be entirely wiped out until the use of protectors in hazardous processes becomes universal.

The Pennsylvania Railroad has an active safety department and furnishes goggles to shop workers and locomotive drivers, yet, in the year 1918, 4.6 per cent of the injuries reported on the eastern lines were eye injuries. Almost invariably such injuries occur to men who fail to wear protectors, making the need of special attention to this subject by shop superintendents, and perhaps with the additional incentive of legal compulsion, very urgent. It is very seldom that a workman wearing protectors loses an eye, but occasionally a blow on the eye is so severe that no available goggles give protection. It is not feasible to protect at all times against such unusual conditions, but the rules and strength tests have been devised to give protection under ordinary working conditions.

10. Scope, Application, and Compliance

The scope of these rules is confined to industrial operations. Valuable guidance will be found for protection in other occupations, military, naval, sporting, etc., such as military expeditions over snow-covered ground. There are definite occupations, however, such as aviation, not yet of an industrial

or commercial character, in which protection to the head and eyes may be required, which are not definitely included in the scope of the rules.

It is obvious that those operations which provide their own protection from flying particles or from other possible source of injury to the head and eyes should not be hampered by the requirement to furnish and wear goggles in addition. Examples of such equipment are grinding wheels furnished with a glass shield behind which the operation is carried on, and the sand-blast cabinet which is so arranged that the operators stand outside and work through suitable apertures in the wall.

Operations can be divided into two general classes, namely, those where it is essential that the workers wear proper protectors, and those where it is optional with the workers to wear protectors. Examples of the first class are chipping and arc welding. Examples of the second class are automobile driving and exposure to glare. Obviously it is necessary that a proper supply of protectors be kept on hand. The employer should feel it incumbent upon him to so organize his work in all departments as to require workers to wear the proper protectors and not depend on the worker to judge whether the occupation in which he is engaged is of such nature as to require the use of protectors. On the other hand, the hazard involved in such occupations as auto driving is not great except under severe weather conditions. The worker recognizes the necessity for protection in these cases, since without the use of protectors physical discomfort ensues. He will accordingly request proper protectors, particularly where it is well understood that it is the established policy to furnish them on demand.

Where devices are available which have been subjected to examination by some properly qualified body, and found to comply with the general requirements of this code, such

devices should be used in preference to others which have not been so examined regarding their suitability for the given purpose.

In order to avoid the necessity for repetition of such examination by different examiners, frequently with inadequate facilities for such work, and to avoid the confusion which would result over conflicting reports, as to the suitability of devices examined for a given purpose, it is desirable that such examinations should be made under standard conditions, and the record made generally available through promulgation by organizations properly equipped and qualified for experimental testing, inspection of the run of goods at factories, and service-value determinations through field inspections, and whose findings are subject to appeal to the Bureau of Standards.

11. Classification of Operations and Processes

The use of goggles and other protectors in industries where processes are carried on which involve hazard to the head and eyes is widespread, especially in works such as the steel plants which have organized for safety. The operations and processes which are so hazardous as to make it desirable for workmen to be provided with special protection to the head and eyes are varied. Therefore no attempt has been made to name the specific operations or processes against which protection should be given, but rather an attempt has been made to classify the character of the hazards which are existent in industry, leaving it to the employer, or the administrative authority, or other responsible party to assign the particular operation concerned to its proper group.

The various operations and processes which require protection to the head and eyes have been classified into nine groups according to the degree of hazard, or because the peculiar nature of the hazard makes it necessary to provide a protector having distinctive features.

The hazards from flying solid particles ordinarily encountered are separated into three groups designated A, B, and C. The first group will contain all operations wherein the mechanical hazard is so great as to warrant the selection of protectors the parts of which have passed mechanical tests assuring adequate strength. In class B are grouped all operations in which the protector must prevent the entrance of small flying particles into the eye. The lens will not be subjected to severe blows and hence no mechanical tests are necessary. While strength of the frames of goggles used for this purpose is not a prime requisite, definite requirements for the material entering into their construction is necessary. Hence a separate group for these processes has been made. In class C, occupations similar to auto driving, protectors are used merely to keep small foreign particles out of the eyes and hence the protector need not withstand any special strength tests.

In processes where splashing metal is used the special hazard is from burns from molten metal which might be projected with force. The degree of hazard varies with the operations and therefore a number of different methods of protection are suitable. Workers handling fumes, gases, and liquids require protectors of various designs, each one having protective qualities peculiarly fitted for the work. These operations have accordingly also been classed in a separate group.

The hazards incident to sand-blasting are not met in any other process. Hence this subject is treated separately.

In the last three groups are classified all of the operations where the worker is exposed to harmful radiant energy. Definite limits to the transmission of the radiant energy through the lens or window of the protector have been set. These limits are based on the degree of hazard involved, an analysis of which results in the division of hazards into three groups.

12. Definitions

Under this rule are defined all of the devices used for protective purposes referred to in the rules. In general, the intention has been to define them in terms of the purpose to be attained rather than to define them in terms of their design features. In order to avoid confusion the word helmet is restricted to a protector which does not necessarily completely cover the head, whereas the hood does.

13. Classification of Protectors

The types of protectors in use vary in shape and construction according to the use for which they are designed. For use in certain operations protection to the head is required, whereas in others protection to the eye is all that is required. The designs of protectors which may be used to mitigate the hazards incident to a process or operation are varied. To insure adequate strength regardless of the design, certain strength tests are prescribed in the rules for protectors which might be subjected to severe blows, namely, those included in group A. For the purpose of distinguishing between the different forms and shapes of goggles, they have been classified according to design and a style number assigned to each class. This designation has no reference to strength or ability to meet tests. This avoids confusion when referring to the style of goggles whose use is permitted for a given kind of work and in differentiating between the tests to be applied to them.

14. Lenses for Persons Having Defective Vision

There is a difference of opinion among safety engineers as to the best method to pursue to give employees who have defective eyesight proper protection when their work is such that it could be properly classified in the groups mentioned in rule 11. There is general agreement that the spectacles

the worker ordinarily wears do not give sufficient protection, at least for most of the groups. Goggles should be furnished and worn over the spectacles, or else the lenses of the goggles should be ground to provide the proper optical correction. The latter method is looked upon with disfavor by many, but it is permitted as an alternative owing to the objections to wearing two frames.

Corrective lenses are exempted from the drop test because they are ground to individual order, and a lens which has been tested, even though it does not break, should not be used. Care should be taken that specimen blank lenses do, however, meet the drop test prescribed in rule 123.

15. General Recommendations

Some employers prefer to use goggles of such a design that the lenses are permanently and securely held in the frame and are not replaceable except by the employment of special means. Broken goggles are allowed to accumulate, broken ones being replaced by new goggles, until a large order can be sent to the manufacturer for replacement of lenses.

On the other hand, other employers prefer to replace their own lenses, in which case it is desirable that this may be easily done in order to discourage the retention in service of broken goggles. Goggles whose lenses may be replaced merely by unscrewing a portion of the lens container, by the proper manipulation of specially constructed parts of the frame, or by the use of a tool generally available, such as a screw driver, are suitable. To prevent the unintentional replacement of an unsuitable lens, lenses which meet special requirements must be marked (see rules 21 (a), 95 (b)).

It is desirable that lenses and lens containers of goggles designed for a given operation be made uniform as to dimensions so that they may be readily interchanged or replaced. Some manufacturers prefer to use a specially designed size

or shape for processes involving hazards of one degree and a different size or shape for hazards of another degree.

16. General Requirements for Glass

In this rule are grouped all of the general requirements for glass which apply to lenses and windows regardless of the processes in which employed, and whether they be used for mechanical protection or where radiant energy must be intercepted.

There is no uniformity among manufacturers of goggles as to size or shape of lenses. It seemed justifiable to place a minimum on the sizes of lenses since an adequate field of vision is necessary. In certain operations it may be desirable to exceed these dimensions, particularly when the protector is placed at a greater distance from the eye than is contemplated in the use of the goggle.

SEC. 2. PROTECTORS FOR CHIPPERS, RIVETERS, ETC.

20. Styles Permitted

Goggles used in such operations as chipping and riveting may be subjected to blows directed from any position in front of the operator. This makes it necessary for chippers' goggles to give side protection. This may of course be accomplished by using side shields or the eyecup style of goggle.

21. Specifications and Tests for Lenses

A high percentage transmission of light is of importance for this class of work. Almost any lens made of so-called "colorless" glass will transmit 80 per cent of incident light. Certain composition lenses when new will pass this requirement, but when subjected to heat, such as encountered by repeated sterilization in hot water, might deteriorate to such a degree that this requirement for transmission will no longer be met. Some lenses, composed of two glass elements held together by a layer of other material, might become cloudy

when subjected to heat, depending on the material which is used between the glass and the method of sealing the joints. These should not be used when working in processes where they might be subjected to high temperature.

Lenses for chippers' goggles must withstand certain strength tests. In order to properly identify them it is desirable therefore that they be plainly marked.

The relatively severe blows to which chippers' goggles are likely to be subjected, and should therefore be required to withstand, makes it necessary to prescribe a strength requirement for protectors used in operations involving this hazard. The requirement is of the nature of a mechanical test to which a certain portion of the goggles to be used for this service are subjected. Like all other mechanical tests which are of such nature that the object under test is destroyed or damaged, the quality of the lot must be judged by the performance of a portion selected for test. A discussion of the test is given under rule 123. It has been found that repeated blows alter the character of glass, making it more liable to fracture. Hence a tested lens should not be used for protection; neither should one which has received a severe blow in service.

22. Goggles of Style No. 2

Side shields are necessary in order that flying particles can not enter the spaces around the lens container. They may, of course, be solid or perforated but, if perforated, the holes should not be large enough to allow particles to enter. The frames of goggles should be of light substantial material. The principal requirements are comfort to the wearer and strength enough to withstand the service. This service requirement is determined by a strength test of the lens containers and the frames.

24. Test for Frames

The test for the lens containers is such as to insure the retention of the parts of the lenses, in case of breakage, in the container. The container should, therefore, withstand without deformation the drop test for lenses. In order to insure a reasonable life and strength of frames which when subjected to severe blows will not be distorted unduly, it is necessary to prescribe certain tests for frames which are minimum requirements. These tests are different for the different styles of goggles. A further discussion of the test for frames is given under rule 121.

Frames should be made of a material that will withstand sterilization. Sterilization is necessary because there may be interchange of goggles among employees. The material should be such that it will not react chemically with the perspiration from the skin. Such action, if it occurred, might cause irritation or discoloration. For the same reason the material should not readily corrode. Discoloring of the skin is objectionable to the worker and should be avoided.

The manner by which goggles are retained before the eyes is not of primary importance. Comfort is important, as this largely determines whether or not the goggles will be worn willingly by the workers, and unless worn willingly there will be great difficulty in securing their general use, and hence the necessary protection against accidents and loss of eyesight.

SEC. 3. PROTECTORS FOR SCALING, GRINDING, ETC.

The goggles used for scaling and grinding are not subjected to severe blows. The lenses serve merely to keep small particles which are thrown off during the course of the work from entering the eye. Hence, no strength tests are necessary. It is the practice of some shops to use the same style of goggles for grinding and scaling as for chipping, especially

where the two operations are carried on by the same men or in the same shop. This is a good practice because it avoids the danger involved in the interchange of protectors between workers using grinder's goggles and those using chippers' goggles. With two kinds of goggles some hazard is incurred; but as this may be overcome by proper supervision, it is not considered necessary to require all grinders to wear the heavier goggles which meet the strength test prescribed for chippers' goggles rule 21 (b).

Particles may be directed at an angle to the line of sight, and for this reason it is desirable to use lenses whose dimensions are at least equal to the minimum specified in rule 16. Side shields give slightly greater protection but a wide range of vision is desirable, and workmen who prefer to wear goggles without side shields should be allowed to do so.

SEC. 4. PROTECTORS FOR GROUP C

The hazard from exposure to dust and wind is not great. The chief considerations are that goggles should be comfortable and light in weight. There is danger of particles directed from an angle entering the eye, hence it is not desirable to waive the minimum requirement for size of lenses.

SEC. 5. PROTECTORS FOR BABBITTING, ETC.

50. Styles

The nature of the operation largely determines which style of protector should be used. If there is a probability of water being present, the danger of the molten metal exploding is great and hence protection to the face as well as the eyes is needed. It is desirable in this case to use the face mask. Protectors giving at least the degree of protection afforded by goggles should be used in all other cases to protect the eyes from splashing metal.

51. Specifications for Masks

It is not desirable to restrict the kind of material to be used for face masks or the designs to definite types. A variety of material is available for making masks to accomplish the purpose.

52. Specifications for Goggle Frames

Tests conducted by manufacturers and the Bureau of Standards demonstrate that the principal cause for failure of goggles is due to the heat of the molten metal and not to the impact of the explosion. The test consisted of dropping 5 g of molten lead from different heights on a number of lenses of different makes. It was found that in no case was the goggle frame injured, the damage being confined to cracking of the lens. With these facts in mind it is not necessary to specify a strength test for the frames. The design of the lens container should be such, however, that in case a lens cracks the fragments will be retained in position in the container. This prevents injury to the eye from flying glass.

53. Specifications for Lenses

As stated above, a molten-metal drop test on a large number of lenses showed that the heat of the metal and not the impact is the important element in the test. It was found that for glass of a given make the thickness of the lens determines to some extent at least the resistance to cracking when molten metal is poured on the surface of the lens.

It was therefore concluded that protection will be afforded by a lens that will withstand a moderate blow of molten metal, and a lens container that will retain a cracked lens in position. The former is sufficiently assured by placing a minimum limit for the thickness of glass.

The need of unimpaired vision in the pouring of molten metal is apparent. This is the reason for specifying a minimum light transmission. Almost any lens made of so-called

"colorless" glass will transmit 80 per cent of incident light. (See also the discussion under rule 21.)

SEC. 6. PROTECTORS FOR HANDLING ACIDS, ETC.

60. Styles

The nature of the process for which protection is furnished when handling acids, caustics, fumes, and other corrosive or poisonous chemicals, determines to a great extent the type of protector to use. The operations are so varied that it is not deemed advisable to prescribe in detail the type of protector to be used. Judgment and experience must determine this.

61. Specifications for Goggles

Goggles which do not fit the configuration of the face should not be used. In order to avoid splashing liquids coming in contact with the eyes it is desirable to use eyecups, which fit closely but which are provided with ventilating openings covered in such a manner as to prevent the entrance of liquid into the eye. This will afford a means for escape of the vapor arising from perspiration which would otherwise condense on the lenses and obscure vision. Even the provision of ventilating openings will not obviate this altogether. In those cases where the presence of fumes would undesirably affect the tissues or would irritate the eyes or nostrils, ventilation should not be provided.

62. Specifications for Face Masks

In processes where the operator is exposed to splashing or projection of large amounts of acids or caustics into his face, it is desirable to protect the entire face or even the entire head, as well as the eyes. A variety of material is available for making masks and hoods to accomplish the purpose, the design being such that there are no openings in the mask through which chemicals might pass.

63. Specifications for Hoods

When working in gases which affect the mucous membrane or skin, hoods which cover the head and neck must be used. Each process requires special attention. Therefore no detailed specification for the type of hood required can be made. Mitigation of the hazards in these processes is perhaps more in the province of the sanitary engineer and physician, since the health more than the safety of the operator is involved.

64. Specifications for Lenses

Protectors for these processes are not likely to be subjected to severe mechanical shocks, and for this reason no strength tests are necessary. The material of which the lens is made should be given consideration before the protector is put in use. For example, the chemicals used in the frosting of glass (such as lamp bulbs) undesirably affect the glass, and hence in handling such substances other material must be used for the lens. Cellulose acetate is widely used. A property of this compound which makes its use desirable is its slow-burning quality. In this respect it is much more satisfactory than cellulose nitrate or celluloid.

SEC. 7. PROTECTORS FOR SAND-BLASTING

The hazard to which operators in sand-blasting operations are exposed is the inhalation of large quantities of dust over a considerable period of time. A hazard of a smaller degree is the abrasion of the skin by small flying particles. The problem may therefore be classed as one in industrial hygiene. The hazard may be largely mitigated by the use of properly designed apparatus. Obviously the best protection is derived through the use of apparatus which does not require the operator to be subjected to the flying particles nor to a great deal of dust. Sand-blast cabinets which are so arranged that the operator directs the sand-blast nozzle on the work

through apertures in the wall of the cabinet have been successfully used on certain kinds of work. Where the worker is actually exposed, nothing less than a hood which completely covers the head is suitable.

All small particles and as much dust as possible must be excluded if effective protection is to be provided. The apparatus must be designed so that the operator is able to see his work. There are two designs of windows in general use. In one the hood is fitted with a glass which is provided with a suitable metal screen on the outer side which protects the glass from pitting. This combination effectually excludes the dust. In the other design the screen only is used, in which case a respirator to filter the air for breathing must be used. It is desirable to use goggles with this type of hood, inasmuch as the screen will not offer much resistance to the large flying particles.

The subject of ventilation of hoods has received consideration by a number of manufacturers. One large organization reports that the use of air under pressure caused operators physical discomfort because of colds in the head. Design of hoods to secure the proper distribution of air within and the proper air pressure to be used should receive further consideration.

SEC. 8. PROTECTORS FOR EXPOSURE TO GLARE

The style of goggle to be used for protection against sunlight reflected from snow and similar sources of glare is of no particular moment. The reduction of the intensity of radiation entering the eye is the end to be accomplished. Since this can be done by the provision of a large lens, the use of side shields should be left to the discretion of the wearer, as should also the density and tint of the colored glass used in the lenses.

SEC. 9. PROTECTORS FOR OXY-ACETYLENE WELDING AND FURNACE WORK

The style of protector to be used depends on the amount and nature of the work to be done. The more serious hazard of the process is the pathological effect on the eyes which is produced by the radiant energy from the light source. A hazard of lesser degree is small flying masses of molten metal. Manufacturing limitations and hard usage limit the minimum thickness which can be used. This limit of thickness is high enough to offer protection against flying particles. The protectors need not, therefore, meet any strength tests. The design should be such that no unfiltered radiant energy is allowed to enter the eye. For this reason it is desirable for operators to wear goggles of style No. 3 (with eyecups), face masks, or helmets, whenever two or more operators work in close proximity.

The heat radiated from the work is so great that unless the parts of the protectors which touch the face are made of heat-insulating material the operator will experience considerable discomfort, which will tempt him to discard the protectors. The use of heat-insulating material is therefore required.

95. Specifications and Tests for Protective Glass

A discussion of the optical tests for oxy-acetylene welder's glasses and the reasons therefor is given under rule 124.

The cobalt glass so commonly used by furnace men is not effective in providing protection from ultra-violet radiant energy. The judgment of many such men as to temperature and stage of reduction of a furnace charge has been developed while using such glass and may be dependent upon a continuation of its use. Moreover, inspection of the charge lasts but a few seconds at a time and consequently does not offer the same hazard as continued exposure to such sources of light. It is consequently suggested that the use of such cobalt glass

be permitted by those trained to work with it and who are responsible for judging heats, but that its use be gradually eliminated by educating the new men to judge the condition of the charge by the use of glass which will afford more perfect protection.

As required by rule 11, electric resistance lap and butt welding where a relatively large amount of radiant energy is encountered are classified in the same group as oxy-acetylene welding. The reasons for this classification are given in the discussion of the tests for lenses, rule 124.

Two-part lenses, the lower half colored and the upper half clear, are sometimes used, particularly when the work is intermittent and the operator's attention is frequently distracted from his work. When close attention to the work is required for considerable periods of time, protectors using entire colored lenses are preferable.

In order to be assured that lenses which are satisfactory may be duplicated by the user of protectors, it is desirable that the lenses be marked in some manner so that they may be identified.

For reasons of economy it is desirable that lenses be provided with cover glasses which on becoming pitted can be thrown away and a new one inserted. The life of the more expensive protective lens is thus lengthened.

SEC. 10. PROTECTORS FOR ELECTRIC WELDING

100. Styles

As in the case of oxy-acetylene welding the hazard to be protected against is the intense radiant energy. In this case the ultra-violet radiation is so intense that serious burning of the skin as well as injury to the eyes may result from long exposure. It is therefore necessary to protect the face and head as well as the eye. The material from which the helmets or shields are made must be opaque to ultra-violet and visible radiation.

101. Specifications for Protection

The forms of protector approved for electric-arc welders are the helmet and the shield. Helmets are generally of two types, the type supported by the head and that supported by the shoulders. Either type is satisfactory if properly designed. Helmets and shields should be so shaped as to protect the entire face. Care should be taken that protection is offered against the radiant energy from the arcs of other operators in the vicinity.

The design of helmets and shields is such that much better vision may be secured, while the welding or cutting is being carried on, by the use of a large single window than by the use of two separate lenses. This practice is common, and it is believed justifiable to restrict the dimension of windows to the minimum specified in rule 102, in order to insure to the operator an adequate range of vision.

102. Windows

A full discussion of the tests for arc welders' windows and the reasons therefor is given under rule 124. The use of cover glasses has been discussed under rule 95.

103. Protection for Other Workers

The protection of other workers who may be exposed to the radiation from an electric arc is accomplished by segregating the electric arc welders in a room separate from the others or by surrounding them with a suitable opaque inclosure. In no case should arc welding or cutting be done, if other workers are or are liable to be in the vicinity, unless this protection is provided.

SEC. 11. OPERATING RULES

110. Sterilization

Goggles which have been previously used should be sterilized before being given to another employee. This will

avoid spreading infectious diseases. It is desirable to furnish each employee with a pair of goggles for his own use, but even in this case they should be sterilized periodically.

Several methods for sterilizing goggles are suggested. The use of an antiseptic gas is perhaps the preferable method, but is not always the most practical because of inadequate facilities, in which case other methods must be used. Boiling water will destroy nearly all germs, but its use should be restricted to those styles of protectors which will not undergo deterioration when boiling water is used. Examples of material which might deteriorate are certain types of composition lens and leather for side shields.

It is desirable that the work of sterilizing protectors be carried on only under the direction of competent and authorized persons. In many cases the sterilizing agent used may be poisonous, hence its use by uninformed persons should be restricted. The use of phenol is not recommended.

111. Supply and Fitting of Goggles

Employees are required by rule 10 (b) to wear protectors when working in certain classes of operations of processes named in the rule. The mere fact that they are required to wear them will not always assure that this provision is carried out. It is incumbent on the employer to so organize his work that every employee is informed of the places within the works where he can go to obtain new protectors or have adjustments or replacements made. Constant supervision on the part of the foreman and superintendent will insure that full use of these facilities is made by the employees.

112. Replacement of Defective Protectors

To charge the employer with the responsibility of repairing defective protectors as soon as such defect appears would be an unnecessary burden, as it would require exceedingly close inspection. A more equitable division of responsibility is to

require the employee to report broken protectors whereupon the employer should repair or replace them.

113. Inspection of Protectors

While the responsibility of reporting broken protectors rests with the employee, the question as to what constitutes a broken protector depends on the judgment of the individual employee. Many protectors have been in use so long that the lenses have become pitted so as to interfere with vision, as in the case of oxy-acetylene cutting, or the frames have become bent out of shape. These conditions should be corrected by periodical inspections.

The provision of suitable cleaners should be given attention. Each employee need not necessarily be provided with a cloth, but a periodical inspection should be made to see that suitable cleaning material is available in convenient locations.

114. Cases

Goggles are liable to be damaged if carried loose in the pocket or with tools. The provision of a case for the goggles avoids carrying them unprotected. Unless a case is provided they are likely to be left in lockers or tool chests. This is particularly true when they are not continually in use. The employee can be more easily induced to carry goggles with him if a case is provided. They are then at hand when they are needed.

115. Supply of Protectors or Repair Parts

If employees are prohibited from wearing defective protectors and are required to report such defects to the employer and if the employer is charged with the responsibility of the replacement of protectors, it is obvious that an adequate supply of either the protectors or supply parts for them should be available.

SEC. 12. TESTS FOR FRAMES AND GLASS**120. Scope of Tests**

It is not intended that frames and lenses which are subjected to test will be used in service. Samples must be selected for this purpose. For frames, product of a factory should be fairly uniform, and approval of a model may be considered sufficient by the administrative authority. Lenses are not so uniform in quality, and samples from every large shipment should be tested.

121. Tests for Frames of Goggles

The severe usage and the mechanical shocks to which chippers' goggles are liable to be subjected makes it necessary that some assurance be given that the strength of the various parts of the frame is adequate. The flat transverse, the edge transverse, and the joint tests are designed to give some evidence as to the probability of the goggle withstanding the demands of service, so that in the event of the goggle being subjected to a blow, safety will not be decreased. The use of a frame which is too light may result in it becoming out of shape, thus causing discomfort, which may result in discarding the goggle. Under these conditions, even if worn, it may fail to protect.

It is obvious that if a goggle is to be effective the lens container must at least be strong enough to withstand the tests to which the lenses are subjected. This is the reason for the insertion of the requirement as to strength of lens containers.

As stated above, the test of the joints of the bridge and lens container is designed to give some evidence of the probability of the goggle withstanding the demands of service. Poor methods used in the assembly of the parts of the goggle will be shown by the presence of jagged ends appearing at the joints after the goggle has been in service some time. This service condition is simulated in the test, and if the

failure appears it is sufficient evidence that the goggle would not stand up under the demands of service.

The test consists merely in bending the frames so that the lenses face each other and restoring the goggle to its original shape as nearly as possible. This test subjects the joints to a stress which in poorly constructed goggles will be great enough to cause the bridge to separate from the container. Figs. 1 and 2 show the method of holding the lenses during conduct of the test and the appearance of the frame after bending.

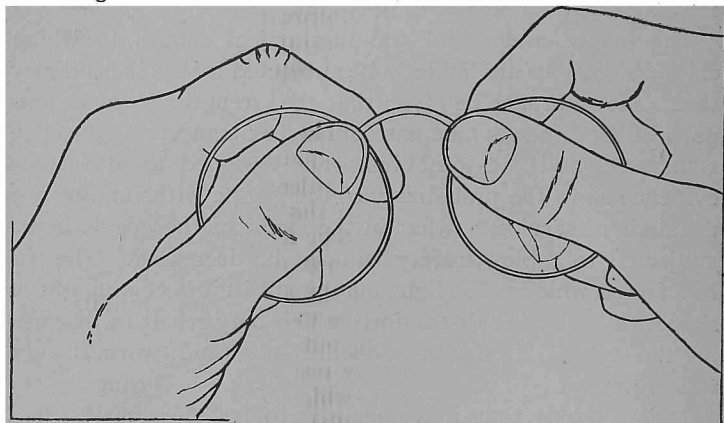


FIG. 1.—Method of holding frames of goggles in making tests of joints

122. Test for Corrosion

The test for corrosion as outlined in this rule is designed to show the ability of metals to resist the corrosive action of such chemicals as sodium chloride and sulphur dioxide which are encountered in industrial operations. This is an effective test, but is not necessarily the only one which can be used. For the sake of uniformity it is desirable to use the test specified in order that test results from separate sources may be compared.

It has been found by observation that the use of a boiling solution allows the liquid to penetrate farther into the outer surface of the material, because of the action of the heat expanding the metal and opening up the pores, than is the

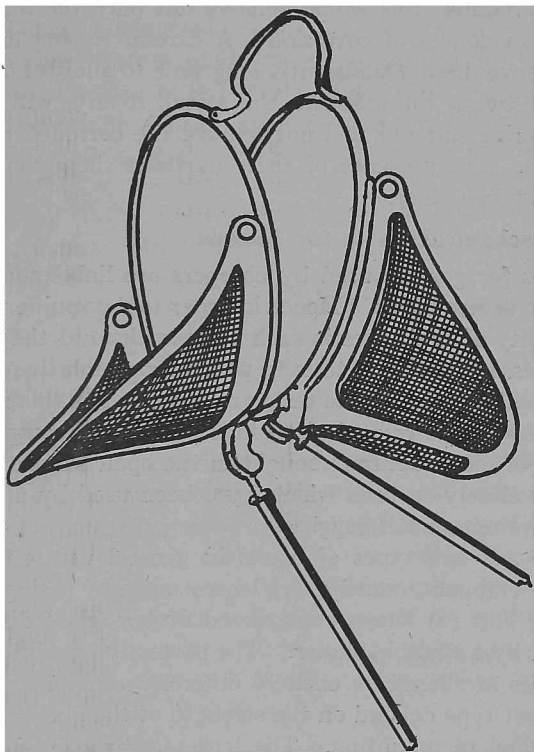


FIG. 2.—*Appearance of frame after bending*

case if a cold solution is used. In order to retain the salt in the pores it is necessary to bring the metal to room temperature. This should be done by cooling in a solution of the same salt (sodium chloride) in order that contact between

the solution and the metal be not lost by the flaking off of the crystals which would form if the frames were allowed to dry in the open air.

The frames should not be wiped off after removal from the solution because this would remove not only the liquid but also all evidences of corrosion. A careful rinsing after the frames have dried a sufficiently long time to allow of chemical action between the salt and the metal, if any, will remove the adhering salt but will not remove the corroded particles or flakes. The presence of these particles show that corrosion has taken place.

123. Mechanical Tests for Lenses

Lenses for goggles used by chippers are liable to be subjected to severe blows. Hence in order to determine whether the quality of the lenses is such as to withstand the service, it is necessary to devise tests to which representative samples may be subjected. These tests are described in this rule and are based on the results of an investigation of samples of a number of manufacturers bought in the open market. They conform closely to tests which have been used by a number of large purchasers of goggles.

There are two types of lenses in general use for goggles used by chippers, namely, (1) lenses made of a single piece of glass, and (2) lenses constructed of two glass disks held together by a suitable binder. The protective qualities of the two types are based on entirely different principles. Lenses of the first type depend on the strength of the glass and upon the method of mounting. The lenses are made of glass of such quality and so mounted that a severe blow may be received without fracture. There is no protection, of course, from the extremely severe blows which would drive the glass out of the frame and into the eye. However, for such a case, the wearing of goggles neither mitigates nor increases the hazard.

In the case of the two-element lens, a severe blow is expected to crack the lens, but the construction is such that the glass will adhere to the binder and the particles do not impinge on the eye. The construction of the lens container in both cases should be such that the lens will fail before the container is deformed.

Since the criterion upon which the protective quality is based in each case is the ability of the lens to withstand a blow without splinters of glass leaving the lens on the eye side, it is apparent that the test should include this as a basis for acceptance or rejection. In general, test (1) may be said to be a test for solid glass lenses and test (2) for laminated lenses, but compliance with test (2) on the part of one-piece lenses is satisfactory.

The manner of supporting the lens container or frame during test is important; and in order to obtain consistent results both in a plant where testing is conducted at regular intervals and by manufacturers of goggles, a uniform method should be adopted. The goggles should be mounted on the rubber test block so that only the rim of the container rests on the rubber washer. By this method of supporting the frame a test of the construction of the lens container as required in rule 121 (c) is obtained. In some cases it may be necessary to remove the side shields in order to mount the lens containers properly. In the case of the eyecup goggles the rubber washer and its support must be so prepared as to fit uniformly the contour of the eyecup and distribute the blow evenly over the whole surface.

124. Optical Tests for Lenses.

The pathologic effect of ultra-violet radiant energy upon the animal tissues has long been recognized, but it is only in recent years that detailed studies have identified the harmful rays and their specific action. The skin as well as the eye is affected by ultra-violet radiant energy, especially

when the intensity is high. The action is similar to sunburn. In such processes as arc welding, protection to the skin as well as the eyes is necessary. Excessive brightness must also be avoided. Still another possible cause of impairment of vision might arise through the absorption of an excessive amount of heat energy by tissues and humors of the eye, but there is no evidence that the eye is more subject to injury in this way than any other part of the body. The injurious effect of infra-red radiant energy on the eye has never been definitely proven. However, protection against this is so easy of accomplishment that it seems desirable to provide it.

In order to provide complete protection it is necessary to limit the radiant energy in the ultra-violet to a negligible quantity; the brightness of the source must be reduced to a degree that no discomfort will ensue if work is carried on continuously; the radiant energy in the infra-red should be reduced so that it will not be unnecessarily large.

In order to be assured that adequate protection is provided it becomes necessary to know the optical properties of the glass used for lenses and windows. This is done by subjecting the glass to definite tests which, however, require special apparatus, the manipulation of which should be attempted only by experts.

Before proceeding with a discussion of the detailed tests it appears desirable to give a discussion of the method of making the tests in order that their application and limitations will be understood.

Most sources of light emit mixed radiation. That is to say, light waves of a variety of wave lengths are present in radiant energy. This is true whether it comes from a body of molten metal, from a lamp filament or flame, or from the sun. The eye is unable to analyze such light and determine its components. In this respect the eye differs vastly from the ear, which can analyze a chord and perceive the individ-

ual elements or tones. The eye has no such power of analysis and gets only an impression due to the combination of wave lengths or colors of light which may be present. Moreover, the eye is very limited in the range of its perception, most of the radiation from the usual sources containing a majority of waves or rays which are not visible to the eye, since they lie outside of the range in which the eye is sensitive to light.

Light can be analyzed in a number of ways, the most familiar being by its passage through a prism of glass. This separates the waves of different wave lengths into a spectrum in which the different wave lengths appear as different colors. The visible spectrum ranges from the red to the violet. The waves outside of this range are designated as the infra-red on the one hand and the ultra-violet on the other.

When the light of different wave lengths is mixed together, the eye sums up the effect of the visible portion. Measurements of the intensity of the visible are made by means of the photometer, in which this intensity is compared by the eye with the intensity of the light from a standard source. For the portion of the radiant energy which is not visible other means must be used. Since when light is absorbed its energy may be entirely converted into heat, one of the most simple methods of measuring radiant energy, whether visible or not visible, is by means of a thermopile, where the absorbed light produces heat and this heat in turn produces a measurable electric current. The thermopile can be used to measure the total energy, or, if the radiation is analyzed into a spectrum, the energy of each particular wave length can be measured independently.

No glass transmits all of the light which is incident upon it, but some is always absorbed and some is reflected from its surface. Ordinary clear glass transmits a high percentage of the visible, but does not transmit either the very long

waves or the very short waves. When glass appears colored it is due to the fact that it does not transmit all of the visible rays but some of them are stopped by it. The transmission of glass is usually expressed as a percentage which gives the ratio of the amount of light transmitted to the amount which is incident upon it. This transmission is sometimes expressed in terms of the entire visible spectrum, sometimes in terms of a particular wave length which must of course be stated, and sometimes in terms of the entire radiant energy. It is measured by letting the light from a definite source fall upon the thermopile mentioned above and then interposing the glass whose transmission is desired. The ratio of the two deflections obtained will give the transmission.

The measurement can be carried out with any portion of the radiant energy from the source that may be desired. Thus one may use the total or one may spread the light out into the spectrum by the use of the prism and let only a single wave length or color fall upon the thermopile. Full details of the methods of making such measurements will be found in Technologic Paper of the Bureau No. 119, entitled "The Ultra-Violet and Visible Transmission of Eye-Protective Glasses," and in Scientific Paper No. 325, entitled "Spectroradiometric Investigation of the Transmission of Various Substances." Much of the information in the latter is also given in Technologic Paper No. 93, entitled "Glasses for Protecting Eyes from Injurious Radiation."

When the transmission for a particular wave length is measured it is almost immaterial what source of light is used, providing it can be kept constant during the measurement. Since the transmission for the total radiant energy is dependent upon the transmission for each particular wave length, and since the amount of energy which gets through will depend upon the amount of each particular wave length emitted by the source, it is evident that the result will depend upon the

composition of the energy received from the source. It is consequently necessary when considering total transmission to have a definite and reproducible source of radiant energy. The value of transmission measured will depend upon the spectral distribution of the energy from the source. Consequently a source which is especially strong in light of one color and weak in light of another color will not be suitable. An example of such a source is a mercury-vapor lamp. A source of suitable spectral distribution would be the sun or some artificial source having a somewhat similar distribution and sufficiently reproducible.

For the tests here specified a source of light which is sufficiently reproducible and which is easily obtainable has been stipulated. This source is an ordinary incandescent lamp operated under specified conditions. The spectral distribution of the light from such a source changes somewhat when its operating temperature is changed. But this change is a gradual one, and slight changes in the operating temperature of a filament are not important. In order to make the source sufficiently definite it has been specified that it shall be operated at such a voltage as to consume 0.8 watt per spherical candle, which corresponds to the commercial rating of the 200-watt lamp. This commercial rating may, of course, be changed from time to time, but such change is not likely to alter the conditions sufficiently to make it necessary for it to be taken into account in testing lenses for compliance with these specifications.

If it is found that a lamp is operating at a slightly different specific consumption (watts per candle) at its rated voltage, correction may be made by operating at a slightly different voltage. Within a small range the change in watts per spherical candle is proportional to the voltage and amounts to 0.013 for 1 volt. Accuracy of adjustment is not important, as values of transmission are only slightly altered by large changes in operating voltage.

It is well to point out that such an artificial source is preferable to sunlight for several reasons. In the first place it is more convenient for use in the laboratory and is independent of the weather. In the second place, sunlight is not so definite, as it varies with the condition of the atmosphere, and with the altitude of the sun in the sky. The latter varies not only from hour to hour during the day, but also with the season of the year. Indeed, sunlight is so variable that scientists have not been able to agree upon any specification for its use which would serve to give "sunlight" a definite value.

The specifications have been chosen so as to make the necessary tests as simple as possible. It has already been explained that the two principal purposes of optical specifications are to limit the visible and the ultra-violet light. The specifications nominally limit the ultra-violet which is transmitted to 1 per cent of that given out by the source. In reality, however, it does more than this and, indeed, it is desirable when intense sources of light like an electric arc are used to limit the ultra-violet to less than 1 per cent. The wave length of 406 millimicrons represents a bright line in the spectrum of light from a mercury-vapor lamp. This lamp is suitable for measurements of transmission at independent wave lengths although, as pointed out above, it is unsuitable for measurements of total transmission. This source is especially rich in ultra-violet light and is useful on that account of carrying out a test of transmission for the ultra-violet.

Light having the wave length stated is visible to the eye, and consequently a measurement at this wave length can be carried out with the more usual optical apparatus and the measurement at this wave length can be made with high accuracy.

For the shorter wave lengths designated as the ultra-violet photographic methods must be resorted to or else the measure-

ment carried out by means of some such instrument as the thermopile already referred to. The latter, however, is not very accurate for the short wave lengths.

Experience shows that glasses have a transmission for the ultra-violet which changes with the wave-length. Either the transmission increases rapidly, as the wave length is shortened below 406 millimicrons, or else diminishes rapidly, as the wave length is shortened. In the latter case, if the transmission is under 1 per cent at the wave length of 406 millimicrons, the transmission for the shorter wave lengths will be practically negligible.

In case the transmission at the shorter wave lengths is higher, a rough measurement at one of the shorter wave lengths will show it to exceed 1 per cent and it will consequently fail to comply with the specification.

It has not been attempted to limit the transmission of visible light to the definite amounts which will be proper in different processes and occupations, since the wearer of the goggles can decide very easily what is suitable for a particular purpose. No visible light which is comfortable to the observer will injure the eye. Consequently only rough and rather high limits have been set for the transmission of visible light.

To protect from glare the light must be cut down at least one-half. But still lower transmission will frequently be desirable.

For processes included in group H, such as oxy-acetylene welding and electric-resistance welding, no specific limit to the visible has been set, but the total radiant energy has been limited to 50 per cent. This insures considerable reduction in the visible as well as in the infra-red. The processes included in this group will require among themselves quite different reduction in the intensity of the visible light. The reduction must be much greater in acetylene welding than in much furnace work and any figures which might be set as

suitable for one would not be suitable for the other. The comfort of the wearer is a sufficient criterion for this purpose.

Electric-resistance welding differs very much in the conditions presented in different cases. Where the incandescent metal is almost entirely screened from the worker's eye by the apparatus or by the material itself, protection is optional with the worker. Where the intensely hot metal is exposed, the conditions are much the same as for furnace work and similar protection is prescribed. The intensity of light differs greatly in different cases and a general prescription for the transmission of visible light would not be satisfactory. This is left for determination in individual cases, and comfort to the worker's eye is a good criterion of the sufficiency of the protective glass in this respect.

For electric-arc welding a lower maximum for the total energy has been set, since the source of light in this work is much more intense. An upper limit has also been set for the visible light, although it may be questionable whether this has any great value. In practice a glass will usually be required which reduces the intensity considerably more than the limit set in the specification. In attaining this purpose it is not necessary that a single glass be used.

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