Assessment of Industrial Hazardous Waste Practices, Rubber and Plastics Industry Executive Summary

Foster D. Snell, Inc., Florham Park, N.J.

Prepared for

Environmental Protection Agency, Washington, D.C. Hazardous Waste Management Div

Mar 78

DEPARTMENT OF DEFENSE
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ASSESSMENT OF INDUSTRIAL HAZARDOUS WASTE PRACTICES,
RUBBER AND PLASTICS INDUSTRY

Executive Summary

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U.S. ENVIRONMENTAL PROTECTION AGENCY
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Assessment of Industrial Hazardous Waste Practices, Rubber & Plastics Industry

Joel M. Kushnir and Stephen F. Nagy

Foster D. Nell, Inc.
Hanover Road
Florham Park, NJ 07932

EPA Office of Solid Waste Management Programs
Hazardous Waste Management Division
401 M Street, S.W.
Washington, D.C. 20460

This industry study is one of a series under the Office of Solid Waste Management Program of the Hazardous Waste Management Division, U.S. Environmental Protection Agency. The report concentrates on the rubber and plastics industry. It characterizes these industries in terms of number, location, size and age of plants, products, processes, etc.; identifies and quantifies those wastes which are or may be generated by these industries; describes current practices for treatment and disposal of potentially hazardous wastes; determines the control technologies which might be applied to reduce hazards presented by these wastes upon disposal; and estimates the cost of control technology implementations.

The information presented in the report was acquired from a review of published information; trade association participation; personal contacts; visits to various plants and corporate offices of germane companies; waste sample analysis; and the application of an econometric model to project waste loads for 1977 and 1983.
This report was prepared by Foster D. Shell, Inc., Florham Park, New Jersey, under Contract No. 68-01-3154.

Publication does not signify that the contents necessarily reflect the views and policies of the U.S. Environmental Protection Agency, nor does mention of commercial products constitute endorsement by the U.S. Government.

An environmental protection publication (SW-163c.1) in the solid waste management series.
ACKNOWLEDGEMENTS

The preparation of this report was accomplished through the efforts of the staff of Foster D. Snell, Inc., a subsidiary of Booz-Allen & Hamilton Inc., Florham Park, New Jersey.

Mr. Matthew A. Straus, Staff Engineer, Hazardous Waste Management Division, was EPA Project Officer for the study. His assistance, leadership, careful review and advice made an invaluable contribution to the preparation of this final report.

Appreciation is extended to the following trade associations for assistance and cooperation in this program:

- Rubber Manufacturers Association
- International Institute of Synthetic Rubber Producers
- Manufacturing Chemists Association
- Textile Economics Bureau
- Society of the Plastics Industry

Appreciation is also extended to the many rubber products manufacturers, plastic resin, synthetic rubber and fiber producing companies, who cannot be mentioned by name due to reasons of confidentiality, without whose assistance this report could not have been written.

Acknowledgement is also made of state and Federal agencies who gave invaluable assistance and cooperation in this program.
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I. EXECUTIVE SUMMARY -- ASSESSMENT OF INDUSTRIAL HAZARDOUS WASTE PRACTICES, RUBBER AND PLASTICS INDUSTRY

This chapter introduces the study, describes how the report is organized and provides a summary of the major findings and conclusions.

1. INTRODUCTION

This industry study is one of a series by the Office of Solid Waste Management Programs, Hazardous Waste Management Division. The studies were conducted for information purposes only and not in response to a Congressional regulatory mandate. As such, the studies serve to provide EPA with: (1) an initial data base concerning current and projected types and quantities of industrial wastes and applicable disposal methods and costs; (2) a data base for technical assistance activities; and (3) a background for guidelines development work.

The definition of "potentially hazardous waste" in this study was developed based upon contractor investigations and professional judgment. This definition does not necessarily reflect EPA thinking since such a definition, especially in a regulatory context, must be broadly applicable to widely differing types of waste streams. Obviously, the presence of a toxic substance should not be a major determinant of hazardousness if there were mechanisms to represent or illustrate actual effects of wastes in specified environments. Thus, the reader is cautioned that the data presented in this report constitute only the contractor's assessment of the hazardous waste management problem in these industries.

Foster D. Snell, Inc., a subsidiary of Booz-Allen & Hamilton Inc., began this program for the Environmental Protection Agency (EPA), Office of Solid Waste Management Programs (OSWMP), on May 28, 1975. It covers Standard Industrial Classifications (SIC) 282, the plastic materials and synthetics industry and SIC 30, rubber products industry (exclusive of SIC 3079, miscellaneous plastic products).

The basic objectives of this study are to:

- Characterize the industry in terms of number, location, size and age of plants, products, processes, etc.

- Identify and quantify those total and potentially hazardous wastes which are or may be generated by the rubber and plastic industry.
Describe current practices for treatment and disposal of potentially hazardous wastes.

Determine the control technologies which might be applied to reduce hazards presented by these wastes upon disposal.

Estimate the cost of control technology implementation.

This report is organized into three chapters:

Chapter I -- EXECUTIVE SUMMARY

Chapter II -- PLASTICS MATERIALS AND SYNTHETICS INDUSTRY, SIC 282

Chapter III -- RUBBER PRODUCTS INDUSTRY, SIC 30

The industrial hazardous waste practices were assessed separately for the rubber and plastics industry segments of the report. This assessment was performed in four phases of effort.

Phase I -- Industry Characterization.
A characterization of the industry with regard to the number, location, size and production of manufacturing establishments

Phase II -- Waste Characterization.
Identified and quantified those total and potentially hazardous wastes which are or will be generated by the rubber and plastics industry

Phase III -- Treatment And Disposal Technology.
Described current practices for treatment and disposal of total and potentially hazardous wastes and determined control technologies which might be applied to reduce potential hazards presented by these wastes upon disposal

Phase IV -- Cost Analysis.
Estimated the cost of control technology implementation, and compared this cost with an appropriate business indicator.

The individual elements of each of these phases are presented in detail in their respective sections of this report.
2. SYNOPSIS OF PROGRAM METHODOLOGY

There were three major steps taken by the study team in preparing the report: data acquisition, data analysis and the development of the criteria for the determination of which wastes which should be considered potentially hazardous. Figure I-1 summarizes the program logic. Appendix A, at the end of the report, details the program methodology.

2.1 Data Acquisition

The data required for this study were obtained from five sources:

- Review of published information and data in:
  - technical literature
  - trade journals
  - government reports
  - technical and economic surveys conducted by industry associations

Some of these references are cited throughout this report.

Utilization of data collected during our previous work in these industries, which included:

- A study of hazardous waste materials, hazardous effects and disposal methods for EPA
- An industrial energy study of the plastics and rubber industries for the Federal Energy Administration

Trade association participation, including:

- Rubber Manufacturers Association
- International Institute of Synthetic Rubber Producers
- Manufacturing Chemists Association
- Textile Economics Bureau
- Society of the Plastics Industry
I. **ANALYSES TO BE PERFORMED**

- **INDUSTRY CHARACTERIZATION**: TASK 1

- **WASTE CHARACTERIZATION AND SCREENING**: TASK 2

- **TREATMENT AND DISPOSAL TECHNOLOGY CHARACTERIZATION**: TASK 3

- **COST ANALYSIS OF DISPOSAL TECHNOLOGY**: TASK 4

II. **WASTE DISPOSAL PRACTICE**

**RUBBER AND PLASTICS INDUSTRIES**

- Wastes Destined For Land Disposal:
  - Wastes whose physical properties are typified by:
    - solid
    - liquid
    - sludge phases
  - Wastes directly generated from manufacturing processes
  - Wastes produced by air or water pollution control procedures

- **HAZARDOUS WASTES**
  - Especially those containing:
    - asbestos, arsenic, beryllium, cadmium, chromium, copper, cyanides, lead, mercury, halogenated hydrocarbons, pesticides, selenium, zinc and carcinogens, including those which are radioactive.

- **POTENTIALLY HAZARDOUS WASTES**
  - i.e., those which might be suspected to cause a reaction and form a hazardous substance.

- **WASTE DISPOSAL METHODS INCLUDING:**
  - Burial, deep surface
  - Chemical and biological detoxification
  - Lagooning
  - Recovery and reuse
  - Deep well injection
  - Mine disposal
  - Open burning
  - Incineration
  - Open dumping
  - Combinations of the above
  - Ocean dumping

Notes:
1. Wastes destined for release to air or water at plant site are viewed to be outside the scope of this study.
2. Includes industry waste quantification on state and national levels, (wet and dry basis).

Source: Small review and analysis of study requirements.

III. **DESIRED OUTPUTS**

- **INDUSTRY DESCRIPTION**
  - Plants and locations
  - Distribution of number of firms and plants
  - Distribution of plant size as a function of employees
  - Manufacturing process distribution
  - Location distribution
  - Age distribution
  - Product line

- **METHODS OF WASTE TREATMENT AND DISPOSAL**
  - Detailed waste description and disposal methodology
  - Process changes necessitated by reduction in hazardous waste production
  - Levels of proficiency for disposal based on survey
    - Level I - techniques presently employed
    - Level II - best technology currently employed
    - Level III - technology necessary to provide adequate health and environmental protection = developing technology beyond Level

- **COSTS OF ADEQUATE DISPOSAL**
  - Investment costs
  - Operating costs
Data acquisition by personal contacts and visits to the various plants and corporate offices of companies classified in this industry and to waste disposal firms handling potentially hazardous wastes. During the course of this study, a total of 88 field trips were made as follows:

- Visits to 64 production units in SIC 282 and 30
  - Nineteen in SIC 2821
  - Thirteen in SIC 2822
  - Two in SIC 2823
  - Seven in SIC 2824
  - Eight in SIC 3011
  - One in SIC 3031
  - Four in SIC 3041
  - Ten in SIC 3069

- Visits to 10 waste disposal facilities
  - Five in SIC 282
  - Five in SIC 30

- Nine visits to industry associations

- Five visits to government agencies

In addition, 39 waste samples were analyzed in our laboratories

- Twenty-one samples from SIC 282
- Eighteen samples from SIC 30

A detailed description of the analytical procedures used and the results obtained are in Appendix B. Due to the numerous products and processes used in the industries studied, the sampling program could not obtain a statistically valid overview of waste stream compositions. Instead, results were used as a guide in validating assumptions made regarding potentially hazardous constituents in the waste streams studied.
Estimates of industry growth in order to project waste loads for the years 1977 and 1983 were based on the use of the Interindustry Economic Research Project of the University of Maryland (INFORUM) input/output model of the U.S. economy, information obtained from the sources listed above and Snell estimates. The INFORUM model is described in Appendix A.

2.2 Data Analysis

Data analysis involved the following major tasks:

- Review of collected information for reliability

- Assembly of a data base composed of the reliable information so that estimates and projections can be made

- Tabulations of the wastes on a state, EPA region and national basis from estimates and projections made possible by the data assembly task

The excellent cooperation of the Rubber Manufacturers Association and its members provided such in-depth information that the data base, potentially hazardous waste aggregations and treatment and disposal technology cost estimates for the Rubber Products Industry, SIC 30, are generally the most accurate of the two major groups studied. These are estimated to have an accuracy of ± 20 percent. The accuracy of data reported for SIC 282, Plastic Materials and Synthetics Industry, vary with the product manufactured.

In those cases where raw plant data was obtained, accuracy is estimated to be as good as ± 20 percent. The situation was found for SIC 282 in general and the major products of the other segments.

For products such as phenolics, alkyds and epoxy resins, engineering estimates had to be made due to the many and varied plants and processes used to produce these resins. These estimates may have an accuracy of ± 50 percent and should be considered to be illustrative in nature.

At times engineering estimates were made due to lack of cooperation or data being withheld to avoid disclosure of confidential information. The accuracy of this data could be considerably less. Where the data is of questionable validity, it is so noted within the report.
2.3 Criteria For Determining Which Wastes Should Be Considered Potentially Hazardous

A detailed discussion of these criteria is presented in Appendix A, which describes the methodology used for this study. Essentially, the methodology involved an examination of the types of wastes generated on a case by case basis utilizing published information, engineering and scientific judgment by the study team and spot checks of wastes obtained during the sampling program.

2.3.1 Classification Of A Waste

For the purposes of this study, a waste is classified as:

- Land destined wastes whose physical properties can be categorized as:
  - Solid
  - Liquid
  - Sludge (semi-solid)

- Wastes directly generated from manufacturing processes and not disposed of as part of the plant water and air effluents

- Wastes produced by air or water pollution control processes

By-products which are sold are not considered to be wastes within the context of the study, unless there is a significant likelihood that these will become wastes in the future due to changing economic conditions.

2.3.2 Definition Of A Potentially Hazardous Waste

A potentially hazardous waste refers to any waste or combination of wastes which pose a substantial present or potential hazard to human health or living organisms because such wastes may be suspected of being:

- Toxic (including carcinogenic)
Flammable or explosive

Corrosive or reactive

Biologically magnified or persistent

These types of hazards represent four out of the five basic hazardous characteristics of wastes which were established in Report to Congress -- Disposal of Hazardous Wastes, Office of Solid Waste Management Programs (SW-115), U.S. Environmental Protection Agency, 1974. The fifth characteristic, radioactivity, does not apply to the wastes generated in the industries under study.

2.3.3 Criteria For Determining Potential Hazard

The two industries studied -- plastics (SIC 282) and rubber (SIC 30) use different processes in the manufacture of their products. SIC 282 industries are manufacturers of polymers, while SIC 30 fabricates finished products using many of the materials produced by SIC 282. Due to the differences in processes between these two groups, there is a great dissimilarity in the waste types produced.

Wastes produced by SIC 30 are similar in the physical and chemical properties and generally consist of the materials used in manufacturing their products either in a free state or entrapped in a cured or uncured rubber matrix.

Wastes produced by SIC 282, on the other hand, are of a variety of types including:

- Off-grade products
- Still bottoms
- Spent adsorbents and filters
- Spent catalysts
- Waste oils
- Waste water treatment sludges
However, the same criteria were applied in deciding on the potential hazard of the wastes generated by the two industries. This was done because a very conservative approach was used in developing the criteria.

Wastes identified by unit operation were examined on a case by case basis to identify its constituents. The constituents were identified from the results of industry interviews, published literature, scientific and engineering judgment of the study team and the results of the analysis of waste samples obtained from industry.

Detailed original toxicological, chemical and biological investigations to determine the potential for hazard creation of the literally thousands of chemical substances in those industries which may become wastes was not to be a requirement according to the mandate given by Foster D. Snell, Inc. by EPA. Therefore, published sources which are compendia of information on criteria for hazards classification were used.

The published sources were searched for the wastes' constituents. The waste was then classified as potentially hazardous if it contained constituents in the unbound state, which are, according to the reference(1).

Toxic to Humans

- Very highly toxic causing death or residual injuries to persons exposed to relatively low concentrations or has potential to be carcinogenic

- Those substances where short intense exposures or continued exposures at lower concentration levels may cause serious temporary or minor residual injury

- Those substances whose toxicity has not as yet been determined

(1) See Appendix A for reference.
Flammable, Explosive, Corrosive or Reactive

- Readily capable of detonation and explosive decomposition or reaction at normal ambient temperatures and pressures. Will detonate as result of mechanical shock or local thermal shock. Reacts readily with own oxides or with oxidizing materials. Can ignite spontaneously and/or react violently if exposed to moisture in soil. Ignition or reaction can product lethal vapors, fumes, etc.

- Those substances which can readily undergo violent chemical change with rapid release of energy, but will not detonate explosively or react violently, except under very special circumstances such as heating under confinement. Can ignite and burn rapidly to produce harmful, though not lethal, vapors and fumes if exposed to modest increase of temperature or if moisture is encountered.

- Those substances with unknown properties.

Biologically Magnified or Persistent or Otherwise Ecologically Destructive

- Highly lethal on contact to most vegetation and/or earth organisms. May be soluble in water and can flow with surface or ground waters to affect vegetation and/or aquatic life in remote streams, ponds, lakes, etc. Potential hazard to public or private fresh water supplies because of persistence.

- On substances which are lethal on contact to only sensitive species of plants and/or earth organisms. General damage to vegetation and earth organisms may be substantial, but is reversible. May affect remote vegetation on aquatic life only under unusual circumstances of surface drainage or ground water penetration.

- Those substances with unknown properties.
3. **SUMMARY OF THE STUDY**

The industries studied in this project were as follows:

- Plastic Materials and Synthetics, SIC 282
  - Plastics Materials and Resins, SIC 2821
  - Synthetic Rubber, SIC 2822
  - Cellulosic Manmade Fibers, SIC 2823
  - Organic Fibers, Non-Cellulosic, SIC 2824
- Rubber Products Industry, SIC 30
  - Tires and Inner Tubes, SIC 3011
  - Rubber and Plastics Footwear, SIC 3021
  - Reclaimed Rubber, SIC 3031
  - Rubber and Plastics Hose and Belting, SIC 3041
  - Fabricated Rubber Products, N.E.C., SIC 3069

This section of the Executive Summary presents a synopsis of the major findings and conclusions and an analysis of key information developed on those industries. The plastics industry will be discussed first, followed by the rubber industry.

3.1 **Summary Of The Plastics Materials And Synthetics Industry, SIC 282**

This section briefly summarizes industry structure, manufacturing processes, total and potentially hazardous wastes generated, and treatment and disposal technologies and associated costs for potentially hazardous wastes identified for SIC 282. A detailed discussion of these topics is presented in Chapter II of this report.
3.1.1 Industry Characterization

This section presents the number of production units, total industry production and employment for those establishments classified in SIC 282 based on information developed by the study team. Note that a production unit is a facility making a particular resin within an SIC. These production units may be combined to form plants or plant complexes manufacturing a wide variety of products in one or many SICs.

SIC 2821 has approximately 616 production units, a total production for 1974 in excess of 120,000 KKg (metric tons) and a total employment of about 56,000.

SIC 2822 has approximately 120 production units, a total production for 1974 in excess of 40,000 KKg (metric tons) and employed about 17,000.

SIC 2823 has about 13 production units still in operation, produced upwards of 5,380 KKg (metric tons) of product in 1974 and employed about 5,000.

SIC 2824 has 153 production units in operation, produced over 136,000 KKg (metric tons) of product in 1974 and employed about 100,000.

Most of the plants in SIC 2821 and 2822 are located in the Gulf States such as Louisiana and Texas and California areas (EPA Regions VI and IX) near suppliers of their feed stocks. The majority of SIC 2823 and 2824 plants are located in the South Atlantic states such as Tennessee, North Carolina and South Carolina (EPA Regions III and IV) near the textile mills which consume their output.

An alphabetical listing of plants classified in SIC 282 is contained in EPA, OSWMP, Hazardous Waste Management Division files.
3.1.2 Waste Characterization

In general, the two major processes used in the plastic materials and synthetics industry:

- Polymerization, or the chemical linking together of simple building blocks (monomers) of recurring structural units to form long chain length molecules (polymers)

- Spinning, or the extrusion of polymers through spinnerets to form fibers.

Polymerization is used in all segments of SIC 282, except SIC 2823. Spinning is used in SIC 2823 and 2824.

3.1.2.1 Potentially Hazardous And Non-Hazardous Wastes

The six general waste streams associated with the processes used in SIC 282 are:

- Off-grade products
- Still bottoms
- Spent adsorbents and filters
- Spent catalysts
- Waste oils
- Waste water treatment sludges

Depending on the product manufactured, all, some or none of the wastes may be present and/or potentially hazardous.
3.1.2.2 Criteria For The Determination Of Which Wastes Should Be Considered Potentially Hazardous

Wastes classified as potentially hazardous may be generated from essentially all the unit operations carried out in SIC 282. These wastes are so classified because they are likely to:

- Contain known toxic or possibly carcinogenic materials, e.g., be contained in floor sweepings, sludges and still bottoms in an unbound and unreacted state
- Be composed of significant quantities of materials having low flash points and therefore be potentially flammable, e.g., still bottoms and bad batches.

3.1.2.3 Methodology Used In Sampling And Analyzing The Various Waste Streams

Sampling of waste streams was used to spot check the presence and concentration of suspected compounds. The information obtained from the sampling program was from selective samples and not samples from the total industry.

Samples were obtained of a wide variety of wastes from cooperating establishments in each of the SIC 282 industry segments under the supervision of Shell team members.

The tests performed on the samples, where required, were as follows:

- Water extraction -- designed to determine quantitatively the water soluble fraction of the sample
- Water content of liquid samples -- designed to aid in the calculation of the wet versus dry basis of waste loads to be disposed
- Flammability of liquid samples
Ash residue -- provides a measure of the percent of total inorganic content of the sample.

Emission spectroscopy -- provides a semi-quantitative value for the concentrations of metals in the sample by type.

Atomic absorption spectroscopy -- performed selectively to provide quantitative values for the concentrations of particular metals identified by emission spectroscopy and those which cannot be, e.g., mercury, cadmium, and lead.

Special tests -- these tests were performed on a selective basis on waste streams judged to contain special hazardous components. These tests included:

- Residual vinyl chloride monomer determinations on wastes from plants producing polyvinyl chloride based polymers
- Phenol determination on wastes from plants producing phenolic resins
- Boron and fluoride determinations from waste streams generated by coumarone-indene resin plants

Detailed methodology and test results for the sampling program are discussed in Appendix B.

3.1.2.4 Identification Of Those Hazardous Constituents Found In Waste Streams

Potentially hazardous constituents found in SIC 282 waste streams and the criteria which caused it to be so classified include:

- Flammable proprietary waste solvents from silicone rubber production
Aromatic and chlorinated hydrocarbons present in still bottoms from monomer or solvent recovery due to their flammability and possible carcinogenic properties

Phenol and formaldehyde contained in sludges and partially polymerized material from phenolic resin production due to their toxicity

Formaldehyde contained in bad batches (off-grade product) still bottoms and filter cake from amino resin production due to its toxicity

Maleic acid contained in contaminated floor sweepings from alkyd production due to its toxicity

Boron and fluoride contained in spent clays from coumarone-indene resin production due to its toxicity

Significant concentrations of zinc salts contained in sludges from rayon and acrylic fiber wet spinning operations due to their toxicity

Wastes produced from the manufacture of polyvinyl chloride (PVC) resins are not considered to be potentially hazardous in the opinion of the study team. Waste samples obtained from manufacturers showed vinyl chloride monomer concentrations in the wastes of less than 10 ppm. Companies manufacturing the polymers have improved and are improving stripping technology significantly to reduce this level further. The residual vinyl chloride monomer is entrapped in the PVC matrix and has a low probability of escape into the environment.
Recently, it has been reported that deaths have occurred of workers involved in styrene production attributable to leukemia. Investigations by Government Agencies are now being carried out to determine the connection between employment of a styrene plant and mortality due to leukemia. Since the results of the investigation are not yet available, wastes produced from processes involving styrene are not considered to be potentially hazardous. However, if in the future, the cause of leukemia is attributed to styrene, it will be possible to estimate the quantity of the potentially hazardous fraction of the waste produced by plants using styrene from information contained in this report.

Over the past few months Snell has learned from personnel in the Technical Assistance Program of EPA, HWMD that Kevlar, an organic fiber manufactured by duPont at their Richmond, Virginia plant contains HMPA, hexamethylphosphoric triamide. HMPA is a suspect carcinogen and is reported by EPA personnel to be present in the fiber at a concentration of between 20 to 30 ppm. Since this information was obtained by our organization well after the data collection phase of this project was completed, a detailed investigation by Snell was not undertaken. If the allegations are true, an investigation of wastes produced during Kevlar manufacture should be undertaken.

3.1.2.5 Waste Quantification For 1974, 1977 And 1983

Wastes for the industry in 1974 were estimated by multiplying the total and potentially hazardous waste factors for each of the products manufactured by the production values for the product.

For 1977 and 1983, the basic factors influencing the evaluation of solid waste volumes are:

- Production volume changes
- The effects of more stringent requirements of water pollution control
The waste loads for 1977 are only expected to vary with changes in production output. The effect of the 1977 Water Effluent Guidelines Regulations is not expected to be significant due to the fact that most of the plant personnel interviewed indicated that technology necessary to meet the 1977 requirements was already in place. Thus, the waste factors developed in this study already account for this technology.

For 1983, the cumulative effect of uncertainties in changes of production volumes and water pollution control regulations is such that the only feasible approach to making the waste projections in terms of sound engineering judgement was to discount elements other than production growth.

Estimates of production for the years 1977 and 1980 were obtained from the Interindustry Economic Research Project of the University of Maryland (INFORUM) input/output model of the U.S. economy.

Table I-1 presents the waste quantifications for the years of interest as a summary for the entire SIC 282. The waste quantities are presented on both a dry and wet basis.

From the table it can be seen that total and potentially hazardous waste loads on a dry and wet basis for the country as a whole are as follows:

<table>
<thead>
<tr>
<th>Year</th>
<th>Total Wastes Wet (KKg/Yr)</th>
<th>Total Wastes Dry (KKg/Yr)</th>
<th>Potentially Hazardous Wastes Wet (KKg/Yr)</th>
<th>Potentially Hazardous Wastes Dry (KKg/Yr)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1974</td>
<td>2,751,319</td>
<td>1,504,408</td>
<td>740,351</td>
<td>157,347</td>
</tr>
<tr>
<td>1977</td>
<td>3,329,095</td>
<td>1,820,407</td>
<td>895,824</td>
<td>190,339</td>
</tr>
<tr>
<td>1983</td>
<td>4,294,533</td>
<td>2,348,326</td>
<td>1,155,614</td>
<td>245,602</td>
</tr>
</tbody>
</table>

Source: Foster D. Snell, Inc.
<table>
<thead>
<tr>
<th>Region</th>
<th>Wet Basis</th>
<th></th>
<th></th>
<th></th>
<th></th>
<th>Dry Basis</th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Total</td>
<td>Potentially Hazardous</td>
<td>Total</td>
<td>Potentially Hazardous</td>
<td>Total</td>
<td>Potentially Hazardous</td>
<td>Total</td>
<td>Potentially Hazardous</td>
<td>Total</td>
</tr>
<tr>
<td></td>
<td>---------</td>
<td>--------------------</td>
<td>-------</td>
<td>--------------------</td>
<td>-------</td>
<td>--------------------</td>
<td>-------</td>
<td>--------------------</td>
<td>-------</td>
</tr>
<tr>
<td>I</td>
<td>100,287</td>
<td>29.857</td>
<td>121,347</td>
<td>36.127</td>
<td>156,538</td>
<td>46.604</td>
<td>57,966</td>
<td>8.606</td>
<td>70,139</td>
</tr>
<tr>
<td>IV</td>
<td>1,185,274</td>
<td>181.940</td>
<td>1,434,182</td>
<td>220,147</td>
<td>1,850,094</td>
<td>283,990</td>
<td>661,614</td>
<td>33.377</td>
<td>800,553</td>
</tr>
<tr>
<td>V</td>
<td>346,462</td>
<td>123.746</td>
<td>421,639</td>
<td>149,733</td>
<td>543,914</td>
<td>193,155</td>
<td>152,093</td>
<td>25.010</td>
<td>184,032</td>
</tr>
<tr>
<td>VI</td>
<td>385,425</td>
<td>126.824</td>
<td>466,364</td>
<td>153,457</td>
<td>601,610</td>
<td>197,960</td>
<td>256,877</td>
<td>42.732</td>
<td>310,821</td>
</tr>
<tr>
<td>VII</td>
<td>11,312</td>
<td>8.670</td>
<td>13,688</td>
<td>10.491</td>
<td>17,657</td>
<td>13.533</td>
<td>4,214</td>
<td>1.575</td>
<td>5,099</td>
</tr>
<tr>
<td>VIII</td>
<td>1,310</td>
<td>1.310</td>
<td>1,585</td>
<td>1.585</td>
<td>2,045</td>
<td>2.045</td>
<td>183</td>
<td>182</td>
<td>211</td>
</tr>
<tr>
<td>X</td>
<td>38,883</td>
<td>37.710</td>
<td>47,048</td>
<td>45.629</td>
<td>60,692</td>
<td>58.861</td>
<td>5,865</td>
<td>4.812</td>
<td>7,097</td>
</tr>
<tr>
<td>Total</td>
<td>2,751,319</td>
<td>740.351</td>
<td>3,329,095</td>
<td>895.824</td>
<td>4,724,533</td>
<td>1,155.614</td>
<td>1,504,469</td>
<td>157.347</td>
<td>1,829,407</td>
</tr>
</tbody>
</table>

Source: Foster D. Snell, Inc.
Figure 1-2, pictorially presents the estimated geographic distribution of total wastes (dry basis). Figure 1-3, does the same for potentially hazardous wastes (dry basis) for the year 1974. The estimated geographic distribution of wastes will not change for 1977 and 1983 in relation to 1974.

Generally, the greatest total and potentially hazardous waste loads (dry basis) are distributed among the states in EPA Regions IV, VI and III reflecting the heavy concentration of SIC 282 establishments in the Gulf and South Atlantic states.

In terms of total wastes (dry basis), EPA Region IV has the greatest quantity of wastes to be disposed of.

In terms of potentially hazardous wastes (dry basis), EPA Region VI is first.

Tables in Chapter II break out total and potentially hazardous wastes generated by manufacture of SIC 282 products. The largest contribution to potentially hazardous wastes include:

- Flammable and possibly carcinogenic still bottoms from styrene based polymer production (SIC 2821 and 2822)
- Toxic off-grade products, still bottoms and wastewater treatment sludges from phenolic and amino resin production (SIC 2821 and 2822)
- Toxic zinc containing wastewater treatment sludges from acrylic spinning operations (SIC 2824)

The largest single contributor is phenolics with an estimated 366,000 KKG (wet weight) in 1974 of an aqueous solution of phenol and formaldehyde as the potentially hazardous constituents.
3.1.3 Treatment And Disposal Technology

This section briefly reviews the various treatment and disposal technologies practiced by the plastic materials and synthetics industry and identifies the three levels for those waste streams considered potentially hazardous.

3.1.3.1 Present Potentially Hazardous Waste Treatment And Disposal Practices

The treatment and disposal methods presently practiced in this industry are:

- Incineration
- Landfill
- Lagooning
- Storage

Note that contract disposal ultimately results in the use of one or more of these methods.

Incineration is used to dispose of waste streams usually containing significant amounts of organics. It is universally practiced in SIC 282 industries, especially for the disposal of still bottoms.

Landfilling represents the other major disposal technology used in this industry for those wastes classified as potentially hazardous. These wastes are usually waste water treatment sludges contaminated with metal ions. This method is employed, for example, for sludges emanating from rayon and acrylic fiber production.

Lagooning is sometimes used as an alternate to landfilling. Lagooning is more land intensive than landfilling because a substantial amount of water is stored with the sludge. Ultimately, the settled sludge in a lagoon usually is transferred to landfill. In effect, lagooning is more a form of storage than disposal. Lagooning has been used for the sludges from rayon spinning operations.

Storage in metal drums or concrete pits, as practiced in some phenolic resin plants, can only be a temporary measure pending development or installation of adequate treatment and disposal technology.
3.1.3.2 Identification Of The Levels Of Treatment And Disposal Technology For Those Streams Considered To Be Potentially Hazardous

The levels of treatment and disposal technology are characterized as follows:

. Level I -- Technology Currently Employed By Typical Facilities

. Level II -- Best Technology Currently Employed

. Level III -- Technology Necessary To Provide Adequate Health And Environment Protection

These levels were evaluated for the potentially hazardous wastes generated by SIC 282 by the use of ten factors:

. I -- Physical and Chemical Properties of the Waste

. II -- Amount of Waste

. III -- Factors Affecting Hazardousness of the Waste

. IV -- Adequacy of Technology

. V -- Non-Land Environmental Impact

. VI -- Problem Areas or Comments

. VII -- Compatibility With Existing Facilities

. VIII -- Monitoring and Surveillance Techniques

. IX -- Installation Time For New Facility

. X -- Energy Requirements

Levels of treatment and disposal technology are described for important potentially hazardous wastes in a series of tables in Chapter II. These wastes are:

. Liquid Phenolic Wastes, SIC 2821

. Solid/Semisolid Phenolic Wastes, SIC 2821

. Still Bottoms (Aromatic, Aliphatic, Chlorinated, etc.), SIC 282
Off-Grade Product in Amino Resin Production, SIC 2821

Zinc Oxide Sludges From Waste Water Treatment in Cellulosic and Acrylic Fiber Production, SICs 2823 and 2824

The data indicates that in most cases potentially hazardous wastes are being disposed in an environmentally adequate fashion as shown in Table I-2. For those cases where improvement is needed (phenolics), technology is under development.

3.1.4 Cost Analysis For The Treatment And Disposal Of Potentially Hazardous Wastes, Plastic Materials And Synthetics Industry

The analyses performed are of an illustrative nature and not necessarily true costs for the entire industry. The existence of well defined, self contained production facilities for most of the products of this industry are exceptions to the rule. These facilities are shared at most locations with those required to handle the wastes of other products. These "co-products" may belong to SIC 282 or in entirely different classifications.

The estimates presented were prepared on an engineering basis, using accepted engineering format. No attempt was made to prepare estimates which would reflect impact on individual companies' financial statements. Inclusion of tax considerations, product pricing and other such factors would entail practices unique to each company and should be recognized as beyond the scope of this report.

3.1.4.1 Case Studies Of Potentially Hazardous Waste Treatment And Disposal Costs

Based on the considerations outlined above, the individual costs for typical plants in SIC 282 have been calculated. The results of these calculations are presented in nine tables in Chapter II.
## TABLE I-2

**SUMMARY OF THREE LEVELS OF TREATMENT AND DISPOSAL TECHNOLOGY FOR SIC 282**

<table>
<thead>
<tr>
<th>Waste</th>
<th>SIC Code</th>
<th>Level I</th>
<th>Level II</th>
<th>Level III</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Liquid Phenolic Wastes</td>
<td>2821</td>
<td>Incineration/Storage (metal drums or concrete pits)</td>
<td>Incineration</td>
<td>Same as Level II</td>
</tr>
<tr>
<td>2. Solid/Semisolid Phenolic Waste</td>
<td>2821</td>
<td>Storage (metal drums or concrete pits)</td>
<td>Same as Level I</td>
<td>None identified</td>
</tr>
<tr>
<td>3. Still Bottoms (Aromatics, Aliphatics, Chlorinated, etc.)</td>
<td>282</td>
<td>Incineration with necessary air pollution control</td>
<td>Same as Level I</td>
<td>Same as Level I</td>
</tr>
<tr>
<td>4. Off-Grade Product and Bed Batches From Amino Resin Production</td>
<td>2821</td>
<td>Material is placed in steel drums at plant and then incinerated by contractor off-site with necessary air pollution control</td>
<td>Same as Level I</td>
<td>Same as Level I</td>
</tr>
<tr>
<td>5. Waste Catalyst from Polyester Production</td>
<td>2821 and 2824</td>
<td>Storage in steel drums</td>
<td>Same as Level I</td>
<td>None identified</td>
</tr>
<tr>
<td>6. Zinc Oxide Sludge From Waste Water Treatment in Cellulosic and Acrylic Fiber Production</td>
<td>2823 and 2824</td>
<td>Secured Landfill</td>
<td>Recovery</td>
<td>Same as Level II</td>
</tr>
</tbody>
</table>

**Source:** Foster D. Snell, Inc.
Detailed costs are not provided for the treatment and disposal of solid and liquid potentially hazardous wastes from amino resin production because these costs would be insignificant and production techniques are so varied that even illustrative examples would not be valid.

3.1.4.2 Extrapolation Of Technology Costs To The Entire Plastic Materials And Synthetics Industry, SIC 282

Yearly expenditures for potentially hazardous waste treatment and disposal are presented in Table I-3. These costs may be summarized as follows:

<table>
<thead>
<tr>
<th>T/D Level(1)</th>
<th>Million Dollars (1974)</th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Technology</td>
<td>I  II  III</td>
<td>1</td>
<td>2</td>
</tr>
<tr>
<td>SIC 282</td>
<td>13.33</td>
<td>4.37(2) 14.33</td>
<td>4.37(2)</td>
</tr>
</tbody>
</table>

(1) Assumes that each production facility is operating at their respective levels of full production.
(2) The total reflects the net profit from zinc recovery in rayon and acrylic fiber production.

Source: Foster D. Snell, Inc.

The totals presented above are purely illustrative. They would be substantially affected by shifts in the relative importance of the various products manufactured in each segment of the industry.

3.1.4.3 Comparison Of Technology Costs With Production Value For The Entire Plastic Materials And Synthetics Industry

Table I-4 presents the percent of production value allocated to treatment and disposal of potentially hazardous wastes. These relationships are summarized as follows for SIC 282.
<table>
<thead>
<tr>
<th>SIC Code</th>
<th>Product</th>
<th>Production (KKg/yr.)</th>
<th>Wastes (KKg/yr.)</th>
<th>T/D Level Technology I</th>
<th>II</th>
<th>III</th>
<th>III</th>
</tr>
</thead>
<tbody>
<tr>
<td>2821</td>
<td>Phenolics(1)</td>
<td>610</td>
<td>361,000</td>
<td>10.50</td>
<td>11.50</td>
<td>11.50</td>
<td>N.A.</td>
</tr>
<tr>
<td>2822</td>
<td>Styrene Butadiene Rubber</td>
<td>2,116</td>
<td>12,700</td>
<td>.46</td>
<td>.46</td>
<td>.46</td>
<td>N.A.</td>
</tr>
<tr>
<td>2821</td>
<td>Polystyrene</td>
<td>1,844</td>
<td>18,440</td>
<td>.56</td>
<td>.56</td>
<td>.56</td>
<td>N.A.</td>
</tr>
<tr>
<td>2822</td>
<td>ABS-SAN</td>
<td>440</td>
<td>2,200</td>
<td>.06</td>
<td>.06</td>
<td>.06</td>
<td>N.A.</td>
</tr>
<tr>
<td>2821</td>
<td>Polypropylene</td>
<td>1,026</td>
<td>10,260</td>
<td>.23</td>
<td>.23</td>
<td>.23</td>
<td>N.A.</td>
</tr>
<tr>
<td>2822</td>
<td>Rayon</td>
<td>1,170</td>
<td>11,700</td>
<td>.26</td>
<td>.26</td>
<td>.26</td>
<td>N.A.</td>
</tr>
<tr>
<td>2823</td>
<td>Acrylics/Modacrylics</td>
<td>360</td>
<td>36,000</td>
<td>.03</td>
<td>(2.10)</td>
<td>.03</td>
<td>(2.10)</td>
</tr>
<tr>
<td>2824</td>
<td></td>
<td>1,390(3)</td>
<td>278,000</td>
<td>1.23</td>
<td>(6.60)</td>
<td>1.23</td>
<td>(6.60)</td>
</tr>
<tr>
<td>2821</td>
<td>Subtotals</td>
<td></td>
<td></td>
<td>11.35</td>
<td>12.35</td>
<td>12.35</td>
<td>12.35</td>
</tr>
<tr>
<td>2822</td>
<td></td>
<td></td>
<td></td>
<td>.46</td>
<td>.46</td>
<td>.46</td>
<td>.46</td>
</tr>
<tr>
<td>2823</td>
<td></td>
<td></td>
<td></td>
<td>.03</td>
<td>(2.10)</td>
<td>.03</td>
<td>(2.10)</td>
</tr>
<tr>
<td>2824</td>
<td></td>
<td></td>
<td></td>
<td>1.23</td>
<td>(6.60)</td>
<td>1.23</td>
<td>(6.60)</td>
</tr>
<tr>
<td>2821</td>
<td>Total</td>
<td></td>
<td></td>
<td>13.33</td>
<td>4.37(4)</td>
<td>14.33</td>
<td>4.37(5)</td>
</tr>
</tbody>
</table>

**Note:** For technology definitions see individual cost tables.

(1) This represents a summation of two waste streams: liquid and solid.
(2) Net profit from zinc recovery.
(3) The wastes originate in spinning operations only.
(4) The total reflects the net profit from zinc recovery in rayon and acrylics. Recovery is assumed at all production sites.
(5) The total includes costs of Level I technologies for those products which do not have Level III-2 technologies.

N.A. = Not Applicable.

**Source:** Foster D. Snell, Inc.
<table>
<thead>
<tr>
<th>SIC Code</th>
<th>T/D Level Technology</th>
<th>Percent Of Production Value</th>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>I</td>
<td>II</td>
<td>III</td>
<td>I</td>
<td>II</td>
</tr>
<tr>
<td>2821</td>
<td></td>
<td>0.25</td>
<td>0.28</td>
<td>0.28</td>
<td>0.28</td>
<td></td>
</tr>
<tr>
<td>2822</td>
<td></td>
<td>0.042</td>
<td>0.042</td>
<td>0.042</td>
<td>0.042</td>
<td></td>
</tr>
<tr>
<td>2823</td>
<td></td>
<td>0.0048</td>
<td>(0.33)(1)</td>
<td>0.0048</td>
<td>(0.33)(1)</td>
<td></td>
</tr>
<tr>
<td>2824</td>
<td></td>
<td>0.034</td>
<td>(0.18)(1)</td>
<td>0.034</td>
<td>(0.18)(1)</td>
<td></td>
</tr>
<tr>
<td><strong>Total</strong></td>
<td></td>
<td>0.14</td>
<td>0.045(1)</td>
<td>0.15</td>
<td>(0.045)(1)</td>
<td></td>
</tr>
</tbody>
</table>

(1) These figures reflect the net profit from zinc recovery in rayon and acrylics. Recovery assumed at all production sites.

Source: Foster D. Snell, Inc. analysis of industry interviews and literature data.
SIC 282

<table>
<thead>
<tr>
<th>T/D Level(1)</th>
<th>I</th>
<th>II</th>
<th>III</th>
</tr>
</thead>
<tbody>
<tr>
<td>Technology</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Value Of Industry Shipments (million dollars)

9,796.9 0.14% 0.045%(2) 0.015% 0.005%(2)

(1) Assumes that each production facility is operating at their respective levels of full production.
(2) These figures reflect the net profit from zinc recovery in rayon and acrylic fiber production. It is assumed at all production sites.

Source: Foster P. Snell, Inc.

The summary of the relationships presented in Tables 1-3 and 1-4 are illustrative and are not necessarily representative. They would be substantially affected by shifts in the relative importance of the various products manufactured in each segment of the industry.

However, based on the assumptions of a static product mix, the percent of production value allocated to treatment and disposal of potentially hazardous wastes generated by this industry is relatively insignificant and is estimated at 0.15% or less.

Table 1-5 presents a synopsis of the findings concerning the potentially hazardous waste streams, their nature, amounts generated annually, the treatment and disposal technologies and associated costs on a product-by-product basis.
### Table 1-5
SYNOPSIS OF THE FINDINGS ON TREATMENT/DISPOSAL
METHODS AND COSTS FOR THE PLASTIC MATERIALS AND
SYNTHESES INDUSTRY—SIC 282

<table>
<thead>
<tr>
<th>SIC Code</th>
<th>Product</th>
<th>Waste Stream</th>
<th>Quantity of Potentially Hazardous Waste Generated (Kg/yr.)</th>
<th>Technology</th>
<th>T/D Level (1)</th>
<th>Costs (2)</th>
</tr>
</thead>
<tbody>
<tr>
<td>2621</td>
<td>Phenolic Resins</td>
<td>Liquid fraction from reactor condensate</td>
<td>325,000</td>
<td>Incineration</td>
<td>I &amp; II</td>
<td>16.3</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Solid sediments from reactor condensate</td>
<td>36,000</td>
<td>Storage</td>
<td>I</td>
<td>1.0</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Incineration with other materials</td>
<td>II-III</td>
<td>2.59</td>
</tr>
<tr>
<td>2822</td>
<td>Styrene, Butadiene Rubber</td>
<td>Still bottoms from monomer and solvent recovery</td>
<td>12,700</td>
<td>Incineration</td>
<td>I-II-III</td>
<td>0.22</td>
</tr>
<tr>
<td>2821</td>
<td>Polystyrene</td>
<td>Still bottoms</td>
<td>18,440</td>
<td>Incineration</td>
<td>I-II-III</td>
<td>0.30</td>
</tr>
<tr>
<td>2821</td>
<td>ABS-SAN</td>
<td>Still bottoms</td>
<td>2,700</td>
<td>Incineration</td>
<td>I-II-III</td>
<td>0.13</td>
</tr>
<tr>
<td>2821</td>
<td>Polypropylene</td>
<td>Still bottoms</td>
<td>22,000</td>
<td>Incineration</td>
<td>I-II-III</td>
<td>0.22</td>
</tr>
<tr>
<td>2824</td>
<td>Rayon</td>
<td>Zinc containing sludge</td>
<td>7,200</td>
<td>Secured landfill Recovery</td>
<td>I-III-1</td>
<td>0.80</td>
</tr>
<tr>
<td>2824</td>
<td>Acrylics</td>
<td>Zinc containing sludge</td>
<td>278,000</td>
<td>Secured landfill Recovery</td>
<td>I-III-2</td>
<td>(11.7) (3)</td>
</tr>
</tbody>
</table>

**T/D = Treatment/Disposal**

2. This is the cost for a "typical" plant, at about the average production capacity for the particular product.
3. This represents a net profit from the value of the recovered zinc.
4. This represents the value of the recovered zinc at the typical plant.

**Source:** Summation of the information presented in Tables II-55 through II-62, II-66 and II-69
3.2 Summary Of The Rubber Products Industry, SIC 30

This section briefly summarizes industry structure, manufacturing processes, total and potentially hazardous wastes generated, and treatment and disposal technologies and associated costs for potentially hazardous wastes identified for SIC 30. A detailed discussion of these topics is presented in Chapter III of this report.

3.2.1 Industry Characterization

Table I-6 presents the number of plants, products produced, average size of plant, total industry production and employment for those establishments classified in SIC 30 based on information developed by the study team. The information presented in this table can be summarized as follows:

- SIC 3011 has approximately 206 plants, a total production volume for 1974 in excess of 3,424 KKKg (1,000 metric tons) and a total employment of 107,500

- SIC 3021 has approximately 44 plants, a total production for 1974 of 81 KKKg (1,000 metric tons) and employed 86,800 individuals

- SIC 3031 has only 9 plants, produced 135 KKKg (1,000 metric tons) of reclaimed rubber and employed only 800 workers

- SIC 3041 has 87 plants, produced 370 KKKg (1,000 metric tons) of product and employed 38,200 workers

- SIC 3069 had approximately 1,100 plants, produced 890 KKKg (1,000 metric tons) of product and employed about 100,000 workers.

The plants classified in SIC 30 are generally widely dispersed throughout the country with concentrations in the Northeastern states such as Massachusetts, Connecticut and New York and also in Ohio; EPA Regions I, II and V.

An alphabetical listing of plants classified in SIC 30 is contained in the EPA, OSWMP, Hazardous Waste Management Division files.
### TABLE I-6
GENERAL CHARACTERIZATION OF THE RUBBER PRODUCTS INDUSTRY, SIC 30

<table>
<thead>
<tr>
<th>Code</th>
<th>Typical Product</th>
<th>Number (2)</th>
<th>Typical (1) Plant Production</th>
<th>1974 Total Industry Production (2)</th>
<th>Employment (1000)</th>
</tr>
</thead>
<tbody>
<tr>
<td>3011</td>
<td>Tires</td>
<td>206</td>
<td>59,400</td>
<td>3,424</td>
<td>107.5</td>
</tr>
<tr>
<td>3021</td>
<td>Canvas rubber</td>
<td>44</td>
<td>1,700</td>
<td>81</td>
<td>36.6</td>
</tr>
<tr>
<td>3031</td>
<td>Reclaimed rubber</td>
<td>9</td>
<td>2,500</td>
<td>135</td>
<td>.8</td>
</tr>
<tr>
<td>3041</td>
<td>Reinforced rubber hose</td>
<td>87</td>
<td>2,000</td>
<td>370</td>
<td>38.2</td>
</tr>
<tr>
<td>3069</td>
<td>Dry processed miscellaneous rubber products</td>
<td>1,102</td>
<td>900</td>
<td>890</td>
<td>99.5</td>
</tr>
</tbody>
</table>

| Totals | 1,448 | X | 4,900 | 282.6 |

X not applicable

(1) Typical plant production corresponds to the typical product produced.
(2) These values are for the entire industry segments not just for the typical plant.

Source: Foster D. Snell cumulation of data presented in various tables in Chapter III.
3.2.2 Waste Characterization

In general, the processing operations of the rubber products industry are based on mechanical and dry processing techniques. The exceptions are the comparatively insignificant production found in rubber reclaiming and the wet processing of rubber goods.

Typical rubber processing involves: molding, extruding, sheeting, foaming, coating, fabrication of sections and vulcanization. The initial manufacturing operations involve batch treatment of the stock to incorporate colorants, extenders, reinforcements and special additives such as accelerators and antioxidants. After the batching step, the production operations can be continuous, semi-continuous or batch-continuous.

In general, the eight major steps or operations for the production of rubber products are:

- Raw materials receiving
- Raw materials storing
- Compounding
- Mixing
- Forming
- Curing
- Finishing and inspection
- Shipping

3.2.2.1 Potentially Hazardous And Non-Hazardous Wastes

The unit operations listed above generate the following wastes:

- Floor sweepings, consisting of material from broken bags, fiber packs, etc. and spillages in receiving, storage, compounding and milling areas

- Dusts and powders from the bag houses of dust collection equipment operating in the compounding and mixing areas
Dusts and powders generated from general plant maintenance and equipment cleanout

Oils used to lubricate the seals of mixing equipment contaminated with "oozings" containing process chemicals from the material being mixed

Cured and uncured rubber

3.2.2.2 Criteria For The Determination Of Which Wastes Are Potentially Hazardous

Wastes classified as potentially hazardous are those arising from such unit operations as receiving, storing, compounding and mixing. These wastes are so classified because they are likely to contain known toxic or possibly carcinogenic substances in an unbound and unreacted state which may consist of such materials as pigments, antioxidants, accelerators, promotors, etc.

The seal oils from mixing equipment are likewise contaminated with processing chemicals and are therefore also classified as being potentially hazardous.

Wastes in which the potentially hazardous materials are either absent or have been compounded into the highly insoluble rubber matrix are strongly bound or reacted and therefore do not constitute a potential hazard. These wastes include:

Cured and uncured rubber

General plant trash such as pallets, packaging materials, etc.

Such wastes constitute 90% of the materials to be disposed of by the industry.
3.2.2.3 Methodology Used In Sampling And Analyzing The Various Waste Streams

Sampling of waste streams was used to spot check for the presence and concentrations of suspect compounds. The information obtained from the sampling program does not represent samples from the total industry studied. Samples were obtained of a wide variety of wastes from cooperating establishments in each of the SIC 30 industry segments under the supervision of Snell team members. Due to the randomness of wastes generated in this industry, truly representative samples were not obtained.

The results do point to the wide variability of physical and chemical properties of the samples studied. They support the findings from the visits and interviews that the chemicals which make the wastes potentially hazardous find their way into the materials to be discarded in a completely random manner.

The tests performed on the samples are as follows:

- **Water extraction** -- designed to determine qualitatively the water soluble fraction of the samples

- **Water content of liquid sample** -- designed to aid in the calculation of the wet versus dry basis of waste loads to be disposed

- **Flammability of liquid samples**

- **Ash residue** -- provides a measure of the percent of total inorganic content of the sample

- **Emission spectroscopy** -- provides a semi-quantitative value for the concentration of metals in the sample by type
Atomic absorption spectroscopy -- performed selectively to provide quantitative values for the concentration of particular metals identified by emission spectroscopy and those which cannot be, e.g. mercury, cadmium and lead.

Detailed methodology and test results are discussed in Appendix B.

3.2.2.4 Identification Of Those Hazardous Constituents Found In Waste Streams

Examples of hazardous constituents found in SIC 30 waste streams include:

. Diamines  
. Phenylamines  
. Benzothiazyl disulfide  
. Dithiocarbamates

These chemicals are regarded (1) as toxic or possibly carcinogenic agents.

As discussed above, the potentially hazardous wastes resulting from manufacturing in this industry generally appear as a result of spillages from bulk material handling, accidental rupture of bags and fiber packs, the collection of dusts from particulate control apparatus and "oozings" of oil contaminated with raw materials from mixing equipment seals.

It is impossible to predict with any degree of confidence which bags will break on a particular occasion at a plant. In any given time period, a container of an antioxidant such as phenylenediamine, an agent suspected of causing bladder tumors in humans, may rupture. For that time period, floor sweepings may contain significant amounts of the suspect carcinogen.

On the other hand, during the next time period, only a container of titanium dioxide, an innocuous substance, may rupture, producing floor sweepings which are not considered to be potentially hazardous.

Due to the chance occurrence of the breakage of particular containers, it is not possible to predict what precise potentially hazardous component, if any, a waste may contain during any given time period. Likewise, concentrations of the potentially hazardous components are not possible to arrive at with any degree of confidence.

3.2.2.5 Waste Quantification For SIC 30 For 1974, 1977 And 1983

In Table I-7 the waste quantification for the years of interest as a summary for the entire SIC 30 is presented. The information is presented in terms of total wastes and potentially hazardous wastes. There are insignificant amounts of water present in the waste materials, therefore total and potentially hazardous waste quantities are presented on a dry basis only. Potentially hazardous wastes are not broken down into their constituents due to the randomness of their appearance and concentrations. Finally, based on information obtained from interviews performed of industry personnel, no significant increase in waste loads are expected due to the estimated effects of the 1977 and 1983 Water Effluent Limitation Guidelines Regulations.

From the table it can be seen that total and potentially hazardous waste loads on a national basis, are as follows:

<table>
<thead>
<tr>
<th></th>
<th>Total (Kg/yr)</th>
<th>Potentially Hazardous (Kg/yr)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1974</td>
<td>502,795</td>
<td>48,479</td>
</tr>
<tr>
<td>1977</td>
<td>548,324</td>
<td>52,212</td>
</tr>
<tr>
<td>1983</td>
<td>568,983</td>
<td>54,122</td>
</tr>
</tbody>
</table>

Source: Foster D. Snell, Inc.
<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>IV</td>
<td>21665</td>
<td>2842</td>
<td>22457</td>
<td>3646</td>
<td>23750</td>
<td>3150</td>
</tr>
<tr>
<td>IX</td>
<td>1126</td>
<td>40</td>
<td>635</td>
<td>49</td>
<td>853</td>
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<tr>
<td>VI</td>
<td>6728</td>
<td>782</td>
<td>7204</td>
<td>830</td>
<td>7462</td>
<td>866</td>
</tr>
<tr>
<td>IX</td>
<td>35149</td>
<td>3677</td>
<td>38099</td>
<td>3849</td>
<td>39515</td>
<td>4093</td>
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<tr>
<td>VIII</td>
<td>5426</td>
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<td>7756</td>
<td>568</td>
<td>8070</td>
<td>564</td>
</tr>
<tr>
<td>III</td>
<td>10996</td>
<td>838</td>
<td>10983</td>
<td>910</td>
<td>11406</td>
<td>945</td>
</tr>
<tr>
<td>III</td>
<td>10996</td>
<td>838</td>
<td>10983</td>
<td>910</td>
<td>11406</td>
<td>945</td>
</tr>
<tr>
<td>IV</td>
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<td>172</td>
<td>249</td>
<td>185</td>
<td>261</td>
<td>203</td>
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<tr>
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<td>718</td>
<td>10792</td>
<td>838</td>
<td>11109</td>
<td>865</td>
</tr>
<tr>
<td>IX</td>
<td>18419</td>
<td>1789</td>
<td>20071</td>
<td>1935</td>
<td>20630</td>
<td>2001</td>
</tr>
<tr>
<td>V</td>
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<td>2758</td>
<td>36539</td>
<td>3039</td>
<td>40358</td>
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<tr>
<td>V</td>
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<td>1395</td>
<td>11887</td>
<td>148</td>
<td>12306</td>
<td>1532</td>
</tr>
<tr>
<td>VII</td>
<td>4892</td>
<td>910</td>
<td>7309</td>
<td>872</td>
<td>7761</td>
<td>1095</td>
</tr>
<tr>
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<td>8776</td>
<td>818</td>
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<td>864</td>
<td>7518</td>
<td>897</td>
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<td>25</td>
<td>2748</td>
<td>25</td>
</tr>
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<td>III</td>
<td>7027</td>
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<td>744</td>
<td>7853</td>
<td>775</td>
</tr>
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<td>2347</td>
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<td>2169</td>
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<td>2448</td>
</tr>
<tr>
<td>V</td>
<td>2542</td>
<td>2045</td>
<td>2747</td>
<td>2043</td>
<td>2645</td>
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<tr>
<td>V</td>
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</tr>
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<td>9477</td>
<td>1080</td>
<td>9821</td>
<td>1118</td>
</tr>
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<td>520</td>
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<td>368</td>
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<td>362</td>
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</tr>
<tr>
<td>VII</td>
<td>1702</td>
<td>54</td>
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<td>72</td>
<td>1974</td>
<td>73</td>
</tr>
<tr>
<td>II</td>
<td>8180</td>
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<td>591</td>
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<td>615</td>
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<td>1352</td>
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<td>9897</td>
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<tr>
<td>VI</td>
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<td>1315</td>
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</tr>
<tr>
<td>I</td>
<td>1233</td>
<td>87</td>
<td>1325</td>
<td>87</td>
<td>1420</td>
<td>191</td>
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<tr>
<td>I</td>
<td>2382</td>
<td>2690</td>
<td>26272</td>
<td>2272</td>
<td>26858</td>
<td>2802</td>
</tr>
<tr>
<td>I</td>
<td>4015</td>
<td>403</td>
<td>4477</td>
<td>426</td>
<td>4658</td>
<td>235</td>
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<tr>
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<td>2353</td>
<td>1084</td>
<td>10949</td>
<td>1156</td>
<td>10405</td>
<td>1196</td>
</tr>
<tr>
<td>I</td>
<td>12438</td>
<td>1025</td>
<td>13468</td>
<td>1422</td>
<td>13968</td>
<td>1473</td>
</tr>
<tr>
<td>I</td>
<td>2472</td>
<td>56</td>
<td>855</td>
<td>82</td>
<td>890</td>
<td>65</td>
</tr>
<tr>
<td>I</td>
<td>574</td>
<td>41</td>
<td>614</td>
<td>48</td>
<td>666</td>
<td>47</td>
</tr>
<tr>
<td>I</td>
<td>1327</td>
<td>67</td>
<td>1490</td>
<td>74</td>
<td>1539</td>
<td>78</td>
</tr>
<tr>
<td>I</td>
<td>1493</td>
<td>1144</td>
<td>11648</td>
<td>1228</td>
<td>12275</td>
<td>1265</td>
</tr>
<tr>
<td>TOTAL</td>
<td>502795</td>
<td>48479</td>
<td>568324</td>
<td>52212</td>
<td>568983</td>
<td>54122</td>
</tr>
</tbody>
</table>

(1) Excludes SIC 3931, whose wastes are insignificant in a weight basis.
(2) Solid wastes from SIC 39 are essentially all dry and contain under 1% water on a weight basis.
Tables within Chapter III present the above information for each four digit SIC within the rubber products industry.

Figure I-4, pictorially presents the estimated geographic distribution of total wastes (dry basis). Figure I-5, does the same for potentially hazardous wastes (dry basis) for the year 1974. The estimated geographic distribution of wastes will not change for 1977 and 1983 in relation to 1974.

Generally, the greatest total and potentially hazardous waste loads are distributed among the states in EPA Regions IV and V reflecting the heavy concentrations of SIC 30 establishments in these regions.

3.2.3 Treatment And Disposal Technology

This section briefly reviews the various treatment and disposal technologies practiced by the rubber products industry and identifies the three technology levels for those waste streams considered potentially hazardous.

3.2.3.1 Present Potentially Hazardous Waste Treatment And Disposal Practices

Land destined potentially hazardous wastes from this industry originate incidentally from the manufacturing processes; that is, from housekeeping practices, or from air pollution control systems. The potentially hazardous wastes from all segments of SIC 30, exclusive of SIC 3031, Rubber Reclaiming, are in general very similar. They are predominantly fine powders composed of the raw materials consumed by this industry in the free or unbound state. The small quantity of potentially hazardous wastes generated by SIC 3031 are contaminated devulcanizing agents in the form of liquids.

The potentially hazardous wastes generated by SIC 30 are generally restricted to landfill for disposal. Recovery of these materials is not possible, in most cases, due to the randomness of the concentrations of their constituents. In general, these landfills are of the general purpose type, that is, they are not impervious to water and do not have monitoring for leachate and are therefore not adequate for the disposal of these types of wastes due to possible leaching into the water table.
FIGURE I-4

GEOGRAPHIC DISTRIBUTION OF TOTAL WASTES, RUBBER PRODUCTS INDUSTRY, SIC 30
(DRY OR WET BASIS)
(Kg/yr) (1974)

Source: Foster D. Snell, Inc.
Waste oils contaminated with raw materials used in rubber products manufacturing from the mixing equipment are generally stored on land in steel drums at a remote corner of the plant.

On the surface the present "store it and forget it" practice would appear grossly inadequate. The oils, however, will set up or vulcanize after about 1 to 2 years. It is recalled that the vulcanization process has been considered in effect a chemical detoxification of the mixture of raw materials used in rubber products operations, then the oils once vulcanized can be considered to have lost their potentially hazardous character. These oily wastes may then be disposed in a general purpose landfill without further precaution.

Aside from the waste devulcanizing agents or oils from SIC 3031 to be discussed next, the only other potentially hazardous waste stream identified in this industry are the wastes from the production of lead cured hose in SIC 3041. These wastes are present in three forms and are disposed as follows:

- Pure lead scrap -- recycled at the plant
- Lead dross (lead oxide) -- sold to reclaimers for lead recovery
- Lead salts in sludges from wastewater treatment -- In most cases plants do not pretreat their lead laden wastewaters but send these streams to municipal sewage treatment facilities. One hose plant visited had on-site water treatment. Lead bearing sludges were placed in a general purpose landfill in sealed and labelled polyethylene bags.

Waste devulcanizing agents from the rubber reclaiming industry are reused in most cases. In one instance they were reprocessed for a fee by a waste oil reclaimer.

Table I-8 summarizes the potentially hazardous wastes from SIC 30.
<table>
<thead>
<tr>
<th>SIC</th>
<th>Industry</th>
<th>1974 Total Industry Production (KKg/yr)</th>
<th>Typical Product Produced</th>
<th>Typical Plant Production (KKg/yr)</th>
<th>Significant Potentially Hazardous Waste Stream</th>
<th>Size of Typical Plant Total Waste Stream (Dry Basis)</th>
</tr>
</thead>
<tbody>
<tr>
<td>3011</td>
<td>Tire and Inner Tube</td>
<td>3,424</td>
<td>Tires</td>
<td>59,400</td>
<td>Floor sweepings (receiving, warehousing and compounding areas) 113</td>
<td>4,241</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>(2) Dust from compounding and mixing collected by pollution control equipment 493</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>(3) Oily wastes 29</td>
<td></td>
</tr>
<tr>
<td>3021</td>
<td>Rubber and Plastics Footwear</td>
<td>81</td>
<td>Canvas rubber footwear</td>
<td>1,700</td>
<td>Floor sweepings (receiving, warehousing and compounding areas) 1,8</td>
<td>907</td>
</tr>
<tr>
<td>Industry</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>(2) Dust from compounding and mixing collected by pollution control equipment 6.9</td>
<td></td>
</tr>
<tr>
<td>3031</td>
<td>Rubber Reclaiming</td>
<td></td>
<td>Reclaimed rubber</td>
<td>2,600</td>
<td>Oils contaminated with devulcanizing agents 30</td>
<td>720</td>
</tr>
<tr>
<td>3041</td>
<td>Rubber and Plastics Hose and</td>
<td>370</td>
<td>Reinforced rubber hose</td>
<td>2,000</td>
<td>Floor sweepings (receiving, warehousing and compounding areas) 3.5</td>
<td>258</td>
</tr>
<tr>
<td>Beltng</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>(2) Dust from compounding and mixing collected by pollution control equipment 15.5</td>
<td></td>
</tr>
<tr>
<td>3069</td>
<td>Rubber Products Industry, N.E.C.</td>
<td>890</td>
<td>Dry processed miscellaneous rubber products</td>
<td>900</td>
<td>Floor sweepings (receiving, warehousing and compounding areas) 2.7</td>
<td>241</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>(2) Dust from compounding and mixing collected by pollution control equipment 11.7</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>(3) Oily wastes Negligible</td>
<td></td>
</tr>
</tbody>
</table>

Source: Foster D. Snell analysis of literature and industry interviews.
3.2.3.2 Identification Of The Three Levels Of Treatment And Disposal Technology For Those Streams Considered To Be Potentially Hazardous

The levels of treatment and disposal technology are characterized as follows:

- **Level I -- Technology Currently Employed By Typical Facilities**
- **Level II -- Best Technology Currently Employed**
- **Level III -- Technology Necessary To Provide Adequate Health And Environmental Protection**

These levels were evaluated for the potentially hazardous wastes generated by SIC 30 by the use of ten factors as listed previously on page I-24.

The three levels of treatment and disposal technology are described for each of the five, four digit SICs that comprise the rubber products industry in a series of tables in Chapter III.

The data indicates that the prevalent treatment and disposal practice for SIC 30 potentially hazardous wastes is the almost universal use of general purpose landfills as shown in Table I-9. Environmentally adequate disposal would be achieved by using secured landfills, that is, those where the following safeguards are in effect:

- Disclosure by the landfill user of the composition and volume of each hazardous waste and approval by pertinent regulatory agencies
- The site is geologically and hydrologically approved for the hazardous waste
- Monitoring wells are provided
- If required, leachate control and treatment is provided
- Records of burial coordinates are kept to avoid any chemical interactions.

I-45
3.2.4 Cost Analysis For The Treatment And Disposal Of Potentially Hazardous Wastes, Rubber Products Industry

The basis for the cost analysis presented here is the average values developed from the industry interviews. Since the methods used in SIC 30 for waste disposal do not involve chemical engineering nor any other significant form of capital investment, with the exception of the hypothetical upgrading of landfill sites, this analysis is straightforward.

The factors involved are:

- Volume of wastes
- Contracting fees for disposal
- Long distance haulage, if required
- Cost of containing material
- Capital costs for upgrading a presently used landfill
- Labor costs at the plant

3.2.4.1 Typical Cases Of Potentially Hazardous Waste Disposal Costs

Based on the cost elements presented above, the individual costs for a typical plant in each of the industry groupings have been calculated.

The individual cases are presented in tables in Chapter III for SICs 3011, 3021, 3041 and 3069. It is to be noted that no cost analysis has been presented for SIC 3031, Rubber Reclaiming. The reason for the omission is that less than 135 K Kg/yr potentially hazardous waste has been identified for this industry to be land disposed. Similarly, the volumes of hazardous wastes generated by such processes as the wet processes in SIC 3069 and plastic hose in SIC 3041 are less than 300 K Kg/yr and therefore too small to warrant specific discussion.

3.2.4.2 Extrapolation Of Technology Costs To The Entire Rubber Products Industry

Yearly expenditures for potentially hazardous wastes disposal are presented in Table I-9. These costs are summarized for SIC 30 as follows:
<table>
<thead>
<tr>
<th>SIC Code</th>
<th>Production (KKKg/yr)</th>
<th>Hazardous Waste (KKg/yr)</th>
<th>Technology</th>
<th>I</th>
<th>II</th>
<th>III</th>
<th>IV</th>
</tr>
</thead>
<tbody>
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<td>3011</td>
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<td></td>
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<td>1,780,000</td>
<td>1,780,000</td>
<td>1,960,000</td>
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<td>81</td>
<td>390</td>
<td></td>
<td>13,000</td>
<td>13,000</td>
<td>13,000</td>
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<td>370</td>
<td>3,000</td>
<td></td>
<td>99,000</td>
<td>99,000</td>
<td>99,000</td>
<td>-</td>
</tr>
<tr>
<td>3089</td>
<td>890</td>
<td>10,000</td>
<td></td>
<td>353,000</td>
<td>353,000</td>
<td>353,000</td>
<td>-</td>
</tr>
</tbody>
</table>

Treatment/Disposal Technology

- **Level I**: Unsecured municipal landfill, offsite.
- **Level II**: Same as Level I, but the municipal landfill is secured.
- **Level III-1**: Same as Level II
- **Level III-2**: Ship 150 Kms to a secured landfill
- **Level III-3**: Upgrading a portion of an existing landfill to secured status with a 10 year capacity
- **Level III-4**: Simple municipal landfill. Offsite but the material is disposed of in polyethylene lined steel drums.

Source: Foster D. Snell, Inc.
3.2.4.3 Comparison Of Technology Costs With Production Value For The Entire Rubber Products Industry

Table I-10 presents the percent of production value allocated to treatment and disposal of potentially hazardous wastes. These relationships are summarized as follows for SIC 30.

<table>
<thead>
<tr>
<th>T/D Level</th>
<th>I</th>
<th>II</th>
<th>III&lt;sup&gt;(1)&lt;/sup&gt;</th>
</tr>
</thead>
<tbody>
<tr>
<td>Technology</td>
<td>1</td>
<td></td>
<td>4</td>
</tr>
</tbody>
</table>

Value of Industry

<table>
<thead>
<tr>
<th>Shipments (million dollars)</th>
</tr>
</thead>
<tbody>
<tr>
<td>10,227.8</td>
</tr>
</tbody>
</table>

0.022%<sup>(2)</sup> 0.022%<sup>(2)</sup> 0.022% 0.035%

(1) Levels III-2 and III-3 are not included because they are not representative for the entire industry.
(2) Based on interview results, no cost difference was found, on the average, between unsecured and secured municipal landfills.

Level I: Unsecured municipal landfill, offsite.
Level II: Same as Level I, but the municipal landfill is secured.
Level III-1: Same as Level II
Level III-2: Ship 150 Km to a secured landfill
Level III-3: Upgrading a portion of an existing landfill to secured status with a 10 year capacity
Level III-4: Simple municipal landfill, Offsite but the material is disposed of in polyethylene lined steel drums.

Source: Foster D. Snell, Inc.

From the above table it can be seen that, the percent of production value allocated to treatment and disposal of potentially hazardous wastes generated by this industry is insignificant and is estimated to be 0.035% or less.

Table I-11 presents a synopsis of findings on treatment and disposal technologies and associated costs on a product-by-product basis.
<table>
<thead>
<tr>
<th>SIC Code</th>
<th>T/D Level Technology</th>
<th>Percent of Production Value</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>I</td>
</tr>
<tr>
<td>3011</td>
<td>0.032</td>
<td>0.032</td>
</tr>
<tr>
<td>3021</td>
<td>0.0026</td>
<td>0.0026</td>
</tr>
<tr>
<td>3041</td>
<td>0.011</td>
<td>0.011</td>
</tr>
<tr>
<td>3069</td>
<td>0.014</td>
<td>0.014</td>
</tr>
</tbody>
</table>

N.A. = Not Applicable

Treatment/Disposal Technology

- **Level I**: Simple municipal landfill, off-site
- **Level II**: Same as Level I, but municipal landfill is secured
- **Level III**: 1. Same as Level II
  2. Ship 150 km to a secured landfill
  3. Upgrading a portion of an existing landfill to secured status with 10 year capacity
  4. Simple municipal landfill, off-site, with the material disposed of in polyethylene lined steel drums.

Source: Foster D. Snell, Inc. analysis of industry interviews and literature data.
<table>
<thead>
<tr>
<th>SIC Code</th>
<th>Typical Product</th>
<th>Potentially Hazardous Waste</th>
<th>Total Estimated Potential Hazardous Waste Produced (Kg/yr)</th>
<th>Technology</th>
<th>T/D Level</th>
<th>$/Kg Product</th>
<th>Per Plant $/Year</th>
</tr>
</thead>
<tbody>
<tr>
<td>3011</td>
<td>Tires</td>
<td>Floor sweepings and dust from air pollution control equipment</td>
<td>30,700</td>
<td>Disposal in unsecured municipal landfill, off-site</td>
<td>I</td>
<td>0.82</td>
<td>36,900</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Disposal in secured municipal landfill, off-site</td>
<td>II</td>
<td>0.62</td>
<td>36,900</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Same as Level II</td>
<td>III (1)</td>
<td>0.82</td>
<td>36,900</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Ship 150 km to secured landfill</td>
<td>III (2)</td>
<td>0.69</td>
<td>40,700</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Upgrading portion of existing unsecured landfill to secured status with 10 year capacity</td>
<td>III (3)</td>
<td>0.75</td>
<td>44,600</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Material disposed of in polyethylene lined steel drums in unsecured municipal landfill, off-site</td>
<td>III (4)</td>
<td>0.94</td>
<td>55,100</td>
</tr>
<tr>
<td>3021</td>
<td>Canvas and Rubber Footwear</td>
<td>Floor sweepings and dust from air pollution control equipment</td>
<td>390</td>
<td>Disposal in unsecured municipal landfill, off-site</td>
<td>I</td>
<td>0.18</td>
<td>275</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Disposal in secured municipal landfill, off-site</td>
<td>II</td>
<td>0.18</td>
<td>275</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Material disposed of in polyethylene lined steel drums in unsecured municipal landfill, off-site</td>
<td>III</td>
<td>0.31</td>
<td>525</td>
</tr>
<tr>
<td>3041</td>
<td>Reinforced Rubber Hose</td>
<td>Floor sweepings and dust from air pollution control equipment</td>
<td>3,000</td>
<td>Disposal in unsecured municipal landfill, off-site</td>
<td>I</td>
<td>0.28</td>
<td>550</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Disposal in secured municipal landfill, off-site</td>
<td>II</td>
<td>0.28</td>
<td>550</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Material disposed of in polyethylene lined steel drums in unsecured municipal landfill, off-site</td>
<td>III</td>
<td>0.53</td>
<td>1,050</td>
</tr>
<tr>
<td>3069</td>
<td>Miscellaneous Rubber Products</td>
<td>Floor sweepings and dust from air pollution control equipment</td>
<td>10,000</td>
<td>Disposal in unsecured municipal landfill, off-site</td>
<td>I</td>
<td>0.40</td>
<td>360</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Disposal in secured municipal landfill, off-site</td>
<td>II</td>
<td>0.40</td>
<td>360</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Material disposed of in polyethylene lined steel drums in unsecured municipal landfill, off-site</td>
<td>III</td>
<td>0.73</td>
<td>660</td>
</tr>
</tbody>
</table>

T/D = Treatment/Disposal
(1) Costs for a "typical plant" operating at average production capacity for the particular product.
Source: Foster D. Snell, Inc.
### Treatment/Disposal Technology

<table>
<thead>
<tr>
<th>Level</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Level I</td>
<td>Unsecured municipal landfill, offsite</td>
</tr>
<tr>
<td>Level II</td>
<td>Same as Level I, but the municipal landfill is secured</td>
</tr>
<tr>
<td>Level III-1</td>
<td>Same as Level II</td>
</tr>
<tr>
<td>Level III-2</td>
<td>Ship 150 Km to a secured landfill</td>
</tr>
<tr>
<td>Level III-3</td>
<td>Upgrading a portion of an existing landfill to secured status with 10 year capacity</td>
</tr>
<tr>
<td>Level III-4</td>
<td>Simple municipal landfill. Offsite but the material is disposed of in polyethylene lined steel drums</td>
</tr>
</tbody>
</table>

Source: Foster D. Snell Inc.

The disposal technologies used by all segments of SIC 30 are similar, and therefore the levels are not discussed separately for each segment but rather on an industry-wide basis.

There is no cost difference between Level I and Level II. For Level III, it should be noted that three alternative technologies are envisioned for SIC 3011 only. The reason for this is that the plants of the other segments do not have the volume to justify these technologies. For instance long distance hauling cannot be contemplated for loads of less than, say 15,000 Kg (33,000 lbs). It is to be noted that it would take almost two years for a canvas rubber footwear plant to accumulate this volume. The same consideration applies to the upgrading of a landfill site. For instance, the volume of potentially hazardous waste generated by a typical reinforced rubber hose plant is 33 cu. m. (40 cu. yd) per year. This is less than the volume of clay necessary to provide the required barrier for this amount of material. On the other hand, it should be noted that the cost of drumming the waste for a tire plant is the most expensive solution for this type of operation.
This chapter provided a summary of our findings and conclusions regarding the assessment of industrial hazardous waste practices for the rubber and plastics industry. The following chapter discusses in-detail information on the plastic materials and synthetics industry, SIC 282. The last chapter does the same for the rubber products industry.