

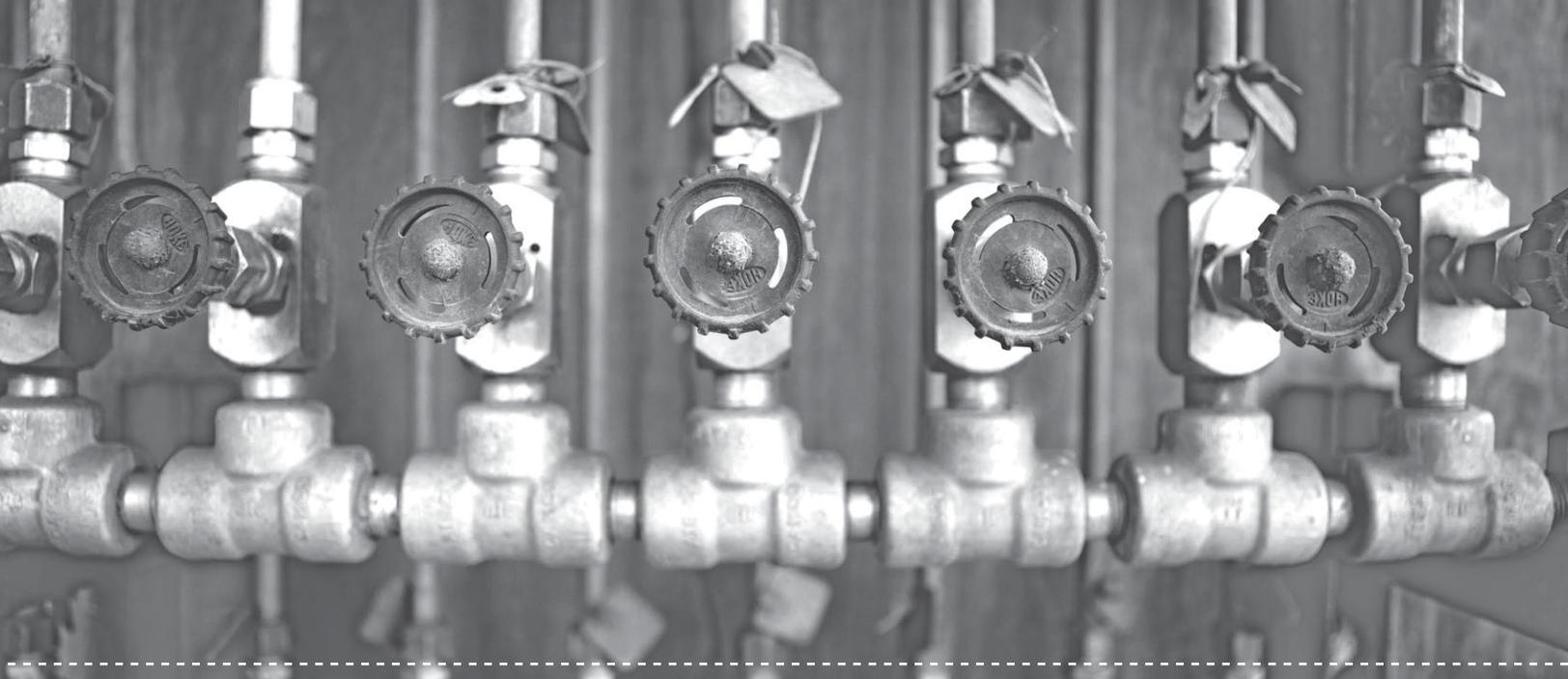


VOL 17

INDUSTRY UPDATE

SECONDARY FLAME-RESISTANT APPAREL





THE LEADER IN SECONDARY FLAME-RESISTANT APPAREL



Bulwark® is the leading provider of secondary flame-resistant apparel in the world. Bulwark garments offer superior flame-resistant protection, comfort, and durability to thousands of workers in electrical utilities and the chemical, oil, gas, mining and petrochemical industries. Bulwark has a 44-year heritage of technical innovation and industry leadership, always remembering that wearer safety is the primary concern. The Bulwark brand makes up the industry's most comprehensive flame-resistant product line in the broadest range of proven thermal protective fabrics.

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INDUSTRY UPDATE

Bulwark® closely follows the continually evolving development of both domestic and world wide resources of flame-resistant and thermally protective fibers and fabrics.

OBJECTIVES

- Educate specifiers in the need for and function of flame-resistant protective apparel
- Provide independent evaluations of available flame-resistant fabrics
- Update developments in the areas of fibers, fabrics, and garments
- Advise changes in standards and regulatory requirements

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INTRODUCTION TO FR APPAREL AND STANDARDS

The flame-resistant garment business is standards and specifications driven. A basic understanding of how flame resistance is defined and measured is very important. Included is an overall listing of common industry standards, as well as a discussion of the requirements of standards related to specific activities, such as power generation and distribution or petroleum refining.

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DO EVERYDAY WEARING APPAREL AND NORMAL WORK CLOTHES HAVE THE SAME FLAMMABILITY CHARACTERISTICS?

Yes. Normal work apparel and everyday wearing apparel are made from fabrics that are similar in weight, fiber content and flammability characteristics. **All clothing that is not flame-resistant will ignite and continue to burn if exposed to an ignition source.** To protect the public from garments that are dangerously flammable both everyday apparel and normal work apparel are required to meet the same federal flammability standard, 16 CFR 1610.

16 CFR 1610

The standard, administered by the Consumer Products Safety Commission, was originally adopted in 1954 as CS 191-53, the Flammable Fabrics Act. The purpose of the standard is to reduce the danger of injury and loss of life by providing, on a national basis, standard methods of testing and rating the flammability of textiles for clothing use. This standard does not apply to children's sleepwear or flame-resistant protective clothing. The standard measures two fabric attributes: ease of ignition and speed of flame spread. A specimen mounted at a 45° angle is exposed to a one second ignition.

If the specimen ignites, the flame spread time is recorded. The Act establishes three classes of flammability based on ease of ignition and flame spread time.

WHAT ARE THE THREE CLASSES OF FABRIC FLAMMABILITY?

CLASS		FLAME SPREAD TIME (Plain Surface Textile Fabric)
CLASS 1	Normal Flammability	3.5 seconds or more. May or may not ignite when exposed to the standard 1 second ignition source.
CLASS 2	Intermediate Flammability	Does not apply to plain surface textile fabrics
CLASS 3	Rapid, Intense Burning not suitable for clothing	Less than 3.5 seconds, dangerously flammable

WHAT CLASS MUST GARMENTS MANUFACTURED OR SOLD IN THE U.S. MEET?

All wearing apparel made from plain surface textile fabric and sold in the U.S. must be made of fabric rated Class 1.

No wearing apparel can be made of fabric rated Class 3.

IS THERE A NEED FOR FLAME-RESISTANT PROTECTIVE GARMENTS?

All fabrics made of untreated natural fibers and most synthetic fibers are combustible. It is normal and expected that they will ignite and continue to burn when exposed to an ignition source such as flame or electric arc. Because clothing constructed from these normal fabrics meets flammability requirements established by 16 CFR Part 1610, it is generally accepted as having no unusual burning characteristics.

Resistance to ignition and burning is an abnormal condition of wearing apparel.

When work environments or occupations pose a risk of garment ignition and burning, flame-resistant apparel should be considered and selected.

HOW DO NON-FR FABRICS REACT TO IGNITION?

Non-FR fabrics and garments will burn away from the point of ignition with an increasing rate of flame spread and continue to burn after removal of the ignition source. Non-FR fabrics will continue to burn until they are extinguished or all flammable material is consumed.

HOW DO FR FABRICS REACT TO IGNITION?

Flame-resistant (FR) fabrics and garments are intended to resist ignition, to prevent the spread of flames away from the immediate area of high heat impingement, and to self-extinguish almost immediately upon removal of the ignition source.

DO FR GARMENTS PREVENT BURN INJURY?

FR garments will not provide significant protection from burn injury in the immediate area of contact with the ignition source. However, flame-resistant garments do provide protection against clothing ignition and sustained flame spread thereby minimizing the extent of burn injury.

WHAT TYPE UNDERGARMENTS SHOULD BE WORN?

National Fire Protection Association (NFPA) 70E, Standard for Electrical Safety in the Workplace, states that non-melting, flammable fiber undergarments may be used in conjunction with FR garments. Flame-resistant t-shirts, henleys and base layer garments can provide additional wearer protection.

ARE FR GARMENTS STILL EFFECTIVE IF CONTAMINATED WITH FLAMMABLE SUBSTANCES?

Flammable substances on FR garments will ignite and continue to burn on the surface of the FR garment. Flame-resistant garments should be immediately removed and replaced with clean FR apparel if they become fouled with flammable material. If laundering or dry cleaning cannot remove flammable contaminants, the contaminated garments should be removed from service.

IS 100% COTTON FABRIC “FLAME-RESISTANT”?

There is a common perception that untreated 100% cotton fabric is somehow “flame-resistant”. This is simply not true. While heavyweight untreated 100% cotton fabrics may be more difficult to ignite, they can and will ignite and continue to burn if exposed to an ignition source.

WHAT ARE SOME COMMON CAUSES OF IGNITION AND BURNING OF WORK APPAREL?

1. Ignition of flammable liquids and/or other flammable soils on the garment.
2. Contact with, or close proximity to, molten metals.
3. Contact with sparks and slag from flame cutting or welding.
4. Contact with open flames.
5. High energy electrical discharges or other electric arc events.
6. Explosion of vapors from volatile liquids or from flammable gases.
7. Ignition of combustible dusts.

Where any risk of ignition exists in the workplace, there is a need for flame-resistant garments.

WHAT IS THE EMPLOYER'S RESPONSIBILITY?

Under paragraph 5a1, the General Duty clause of the federal OSHA Act, it is the employer's responsibility to identify risks and hazards in the workplace and seek out appropriate protective garments and equipment for the protection of workers.

In making this hazard assessment, the employer must consider the risks present and the most appropriate means of addressing those risks. Where ignition risks are present, flame-resistant protective apparel is an essential element of an action plan to address these concerns.

HOW DO I CHOOSE THE CORRECT FLAME-RESISTANT GARMENTS?

Any flame-resistant fabric must provide the wearer with the expected degree of protection for the useful life of the garment. Garments are specified based on the employer's evaluation of workplace hazards. Protective garments, which function as wearing apparel for normal work activities, must be comfortable and durable while achieving appearance that is acceptable to both the employer and the wearer. In addition to these general considerations, there may be other hazards present such as chemical or molten substance exposure. Finally, these multi-use garments must be able to withstand laundering to remove soils and flammable contaminants and be returned to service without excessive color loss, fuzzing/pilling (surface appearance change) or excessive shrinkage.

FLAME-RESISTANT

The characteristic of a fabric or garment to resist ignition and to self-extinguish if ignited.

FLAME RETARDANT

A chemical substance used to impart flame resistance.

PRIMARY PROTECTIVE CLOTHING*

Protective clothing designed to be worn for work activities during which significant exposure to molten substance splash, radiant heat, and flame is likely to occur. Secondary protective garments, like Bulwark's FR protective work apparel, would be worn under primary garments.

SECONDARY PROTECTIVE CLOTHING*

Protective clothing designed for continuous wear for work activities in designated locations in which intermittent exposure to molten substance splash, radiant heat, and flames is possible. FR work apparel, since it is designed for continuous wear, is considered to be secondary protection. The protection afforded by any secondary protective FR garment can be negated by an overwhelming exposure.

CHEMICAL RESISTANCE

As used in this Update, "Chemical Resistance" relates only to the ability of fabrics to withstand exposure to various chemicals without affecting their physical properties or flame resistance.

With the exception of Bulwark® disposable/limited use garments and rainwear, none of the fabrics discussed offer personal protection from chemical exposure. These fabrics will either become wet and transfer chemicals to the wearer, or they are porous and allow chemicals to pass through. Chemically protective barrier garments are specialized kinds of primary protective clothing.

REUSABLE PROTECTIVE CLOTHING

Garments which are capable of withstanding laundering to remove soil and other contaminants, yet retain the garment's protective characteristic.

FR DISPOSABLE/LIMITED USE PROTECTIVE CLOTHING

FR garments which generally cannot be cleaned; usually provided for supplemental protection from a specific hazard, or to prevent soiling expensive reusable garments. Note: limited use FR disposables will burn in the presence of an ignition source, but will self-extinguish when the ignition source is removed. They must be worn over suitable FR apparel, and not used alone for FR protection. **Non-FR disposable garments should never be worn over FR garments.**

STOLL CURVE

A plot of thermal energy and time used to predict a pain sensation, or the occurrence of a second degree burn in human tissue.

ARC RATING

The maximum incident energy resistance of a material expressed in calories per square centimeter prior to breakdown or the onset of a second-degree burn.

Arc Thermal Performance Value or ATPV.

The incident energy, expressed in cal/cm², on a material or a multilayer system of materials that results in a 50% probability that sufficient heat transfer through the tested specimen is predicted to cause the onset of a 2nd degree burn injury based on the Stoll curve.

Breakopen Threshold Energy or E_{BT}

is reported when the ATPV cannot be determined because the fabric breaks open in response to the thermal energy exposure of the electric arc. The lower value of either Breakopen Energy Threshold or ATPV is reported as the arc rating for the material.

*As defined by the American Society for Testing Materials (ASTM) in Standard F1002

In order to serve the market for flame-resistant protective garments, there must be a continuing focus on the customer's requirements based on their evaluation of existing hazards in the workplace and applicable regulations and standards.

Important considerations in any flame-resistant protective apparel program are testing and standards requirements. Outside of military specifications, the primary existing and proposed tests and standards for the civilian clothing market are as follows:

PERFORMANCE STANDARDS AND TEST METHODS

	IDENTIFICATION	CLASS	SPONSORING ORGANIZATION	GOV'T LEVEL MANDATING	COMMENTS
GENERAL WEARING APPAREL	D1230	(Test)	ASTM	None	Clothing and textiles intended for clothing
	16 CFR 1610	(Standard)	CPSC	Federal	Clothing and textiles intended for clothing except hats, gloves, footwear, and interlining fabrics
	16 CFR 1616	(Standard)	CPSC	Federal	Children's sleepwear; 7-14 (FF 5-74)
PROTECTIVE CLOTHING	CSA Z462	(Standard)	Canadian Standards Association	None	Canadian version of NFPA 70E. Initially based on 70E, but to be modified and updated for Canadian requirements
	CSA Z96	(Standard)	Canadian Standards Association	None	Canadian requirements for high-visibility safety apparel.
	F 2700	(Test)	ASTM	None	Test method used to determine TPP and HTP
	D6413	(Test)	ASTM	None	Any textile. Measures vertical flame resistance of textiles. (Note: ASTM version of FTM 5903.1)
	F1506	(Standard)	ASTM	None	Material for clothing for use by electrical utility workers
	F1891	(Standard)	ASTM	None	Rainwear for employees exposed to the hazard of flames or electric arcs
	F1930	(Test)	ASTM	None	Simulated flash fire exposure test using a mannequin
	F1958	(Test)	ASTM	None	Ignitability of clothing by electric arc exposure using a mannequin
	F1959	(Test)	ASTM	None	Determining Arc Thermal Performance Value (ATPV) of flame-resistant textile materials for clothing by electric arc exposure using instrumental sensor panels
	F2178	(Test)	ASTM	None	Determines Arc Rating of face protective products
	F2302	(Performance Specification)	ASTM	None	Minimum requirements for labeling protective garments as flame and thermal resistant
	F2733	(Standard)	ASTM	None	Rainwear for employees exposed to the hazard of flash fire.
	ISEA/ANSI 107	(Standard)	ISEA/ANSI	Federal	High-visibility safety apparel and headwear. Adopted by Federal Highway Administration for workers on federally aided roads.
	CGSB 155.20	(Standard)	CGSB	None	Workwear for protection from hydrocarbon flash fire (Canada)
	FTMS 191A; 5903.1	(Test)	GSA	Federal	Any textile. Generally has been replaced by ASTM D6413.

	IDENTIFICATION	CLASS	SPONSORING ORGANIZATION	GOV'T LEVEL MANDATING	COMMENTS
PROTECTIVE CLOTHING (CONTINUED)	NFPA 70	Standard	NFPA	None*	National Electrical Safety Code (NESC) sets rules for safeguarding personnel during installation, operation, or maintenance of electric supply and communication lines and associated equipment.
	NFPA 70E	(Standard)	NFPA	None*	Clothing for employees working on energized electrical circuit parts
	NFPA 654	(Standard)	NFPA	None*	General industry standard for combustible dust; addresses need for FR clothing
	NFPA 702	(Test)	NFPA	None*	Clothing except hats, gloves, footwear, and interlinings
	NFPA 1971	(Standard)	NFPA	None*	Performance requirements for fabrics and garments used for protection in structural fire fighting
	NFPA 1975	(Standard)	NFPA	None*	Performance requirements for fabrics and garments used in firefighter's station uniforms
	NFPA 1977	(Standard)	NFPA	None*	Performance requirements for fabrics and garments used for protection in wildlands firefighting
	NFPA 2112	(Standard)	NFPA	None*	Performance requirements for garments and fabrics for industrial flash fire protection
	NFPA 2113	(Standard)	NFPA	None*	Selection, care & use of garments for industrial flash fire protection
	29 CFR 1910.269	(Standard)	OSHA	Federal	Clothing for employees exposed to the hazards of flames or electric arcs
	29 CFR 1910.132	Standard	OSHA	Federal	US general requirement for employers to assess hazards in the workplace and provide appropriate PPE
	ISO 13688 (formerly EN 340)	Standard	ISO	See Note**	European general requirements for protective clothing
	ISO 20471 (formerly EN 471)	Standard	ISO	See Note**	European requirements for high-visibility safety apparel.
	EN ISO 11612 (formerly EN 531)	Standard	ISO	See Note**	European requirements for workers exposed to heat and flame
	IEC 61482-2	Standard	IEC	See Note**	European requirements for workers exposed to electric arcs
EN1149-5	Standard	ISO	See Note**	European requirements for electrostatic properties of PPE	

ASTM = ASTM International

CGSB = Canadian General Standards Board

CPSC = Consumer Products Safety Commission

FTMS = Federal Test Method Standard

IEC = International Electrotechnical Commission

GSA = General Services Administration, Office of Federal Supply Services

ISO = International Standards Organization

NFPA = National Fire Protection Association

OSHA = Occupational Safety and Health Administration, Department of Labor

* NFPA documents may be cited by any government level and therefore take on the force of law

**Note: Directive 89/686/EEC on personal protective equipment is EU law. Standards are not legislated, but provide technical translation of the essential requirements of the PPE Directive.

WHAT TEST IS MOST COMMONLY USED TO MEASURE FLAME RESISTANCE?

The most commonly used test for measuring the flame resistance of fabrics is ASTM D6413, Standard Test Method for Flame Resistance of Textiles (Vertical Method). The Federal Test Standard equivalent is FTS 191A Method 5903.1 (Flame Resistance of Cloth: Vertical).

HOW IS THE TEST “FLAME RESISTANCE OF CLOTH: VERTICAL” CONDUCTED?

In an enclosed cabinet, 12-inch long fabric specimens are vertically suspended in a holder with the fabric restrained on three sides. A controlled flame is impinged on the bottom cut edge of the fabric for 12 seconds.

WHAT RESULTS ARE RECORDED FROM THIS TEST?

The flame is extinguished at the end of 12 seconds and three sets of data are recorded:

Afterflame: The number of seconds (in tenths of seconds) during which there is a visible flame remaining on the fabric.

Afterglow: The number of seconds (in tenths of seconds) during which there is a visible glow remaining on the fabric. (Reported, but not part of most performance standards.

Char Length: The length of fabric (in tenths of inches) destroyed by the flame that will readily tear by application of a standard weight.

Five specimens cut in each fabric dimension (length and width) are tested. The individual results of the five specimens are averaged and reported as the test result.

DOES THE VERTICAL FLAME RESISTANCE TEST METHOD ESTABLISH A STANDARD FOR PERFORMANCE REQUIREMENTS?

No. ASTM D6413 establishes a test method only with no pass/fail criteria.

WHAT PERFORMANCE STANDARDS DO GARMENT MANUFACTURERS USE?

Various specifications and performance requirements have been established based on ASTM D6413 testing. For example, NFPA 1975 specifies a maximum of 2.0 seconds Afterflame and 6.0 inches char length for fire fighter’s station uniforms. ASTM Performance Specification F2302 applies the same criteria as minimum requirements for all protective clothing labeled as heat and flame-resistant. Both the Canadian General Standards Board (CGSB) and the National Fire Protection Association (NFPA) require a maximum of 2.0 seconds Afterflame and 4.0 inches (100 mm) Char Length for protection against hydrocarbon flash fires. **In the absence of other specifications, Bulwark® follows ASTM F2302, Standard Performance Specification for Labeling Protective Clothing as Heat and Flame-Resistant, as a minimum requirement.** Other performance requirements may apply to specific garments and will be so indicated on the garment label.

Be aware of misinformation in the market. Many items are labeled “FR” that actually only meet general wearing apparel standards or standards that are only applicable to upholstery or curtains. ASTM F2302 Standard Performance Specification for Labeling Protective Clothing as Heat and Flame-resistant is the minimum standard for labeling protective clothing as heat and flame-resistant. This standard requires an Afterflame time of no more than 2.0 seconds and Char Length of less than 6.0 inches when tested in accordance with ASTM Test Method D6413 (vertical flame resistance). No melting or dripping of the specimens is allowed during the test. Also, the fabric may not ignite, melt, drip, separate or shrink more than 10% when exposed in a forced air oven at 500°F (260°C) for 5 minutes.

WHAT STANDARDS ARE USED FOR WORKERS EXPOSED TO FLASH FIRE HAZARDS?

NFPA 2112, *Standard on Flame-Resistant Garments for Protection of Industrial Personnel Against Flash Fire*, and its companion standard, NFPA 2113, *Selection, Care, Use, and Maintenance* of the same, specify design, performance, certification requirements, and test methods for flame-resistant garments for use in areas at risk from flash fires. Third party certification of garments is also required. In addition to the usual fabric performance requirements for flame resistance, heat resistance and thermal shrinkage, this standard introduced some new requirements and revised some old ones.

- » Flame resistance of each fabric layer is required to be tested as received and after 100 cycles of washing and drying and/or dry cleaning.
- » Heat Transfer Performance (HTP), formerly known as TPP, must be tested both with the fabric specimen in contact with the sensor assembly and separated from the sensor by a ¼-inch spacer. A minimum HTP rating of 6.0 is required for “spaced” and 3.0 for “contact”.
- » Coveralls made to a standard pattern from candidate fabrics are tested for overall flash fire exposure on an instrumented mannequin in accordance with ASTM Test Method F1930. The exposure heat flux is 84 kW/m² (2.02 cal/cm²/sec) with an exposure time of 3.0 seconds. The average total predicted body burn must not exceed 50%.

NFPA 2113 provides guidance in the selection and specification of flame-resistant garments, including workplace hazard assessment. Other sections cover use and care and maintenance recommendations. There is extensive appendix material that amplifies and explains many of the issues including an explanation of the meaning and application of the testing required in NFPA 2112.

Canadian General Standards Board (CGSB) CAN/CGSB 155.20, *Workwear for Protection Against Hydrocarbon Flash Fire*, is the Canadian flash fire standard.

In addition to flame resistance, heat resistance and thermal shrinkage requirements, this standard also requires that the garment label be in both English & French. For single layer garments, the TPP values for both spaced and contact tests must be reported on the garment label.

DOES NFPA 2112 ADDRESS OUTERWEAR?

Yes. In the summer of 2013, a TIA (Temporary Interim Amendment) was issued to clarify language in the standard that prescribes the certification of outerwear. The changes specifically address the unique features of cold weather gear which is sometimes designed with a removable lining.

In the instance where the shell and lining can be worn separately, each stand alone piece must be independently certified. In the case where the insulation layer is permanently attached (sewn into) the certified outer shell, the performance requirements of the insulation layer were adjusted to account for the added protection afforded by the outer shell.

According to NFPA rules, a TIA applies only to the current edition of the standard, and the Technical Committee is required to formally re-consider the issue during the next revision cycle. The next edition of NFPA 2112 is due in 2017.

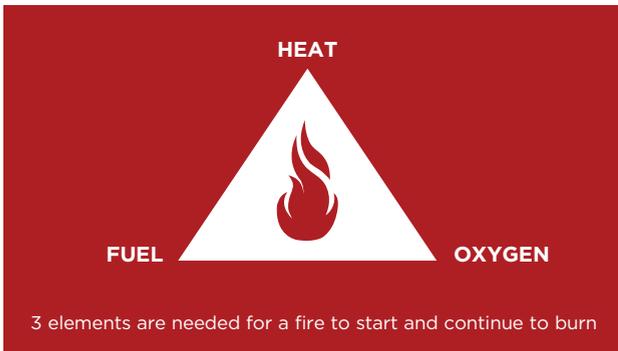
WHAT STANDARDS AND REGULATIONS APPLY TO WORKERS WHO ARE EXPOSED TO COMBUSTIBLE DUST IN THEIR WORKPLACE?

NFPA® 654, *Standard for the Prevention of Fire and Dust Explosions from the Manufacturing, Processing and Handling of Combustible Dust Particulate Solids*, is considered the general industry standard when combustible dust presents a hazard. Combustible dust has the potential to exist in almost every industry, but those with the largest number of explosions in 2008 were the food, wood, chemical, metal, rubber/plastics, utility and paper segments. Combustible dust, as defined by the 2006 Edition of NFPA 654, is a particulate solid that presents a fire or deflagration hazard when suspended in air or some oxidizing medium over a range of concentrations, regardless of particle size or shape. Other, less formal definitions, strictly relate particle size to the assessment of when a dust can be deemed combustible; less than 420 microns is usually the threshold.

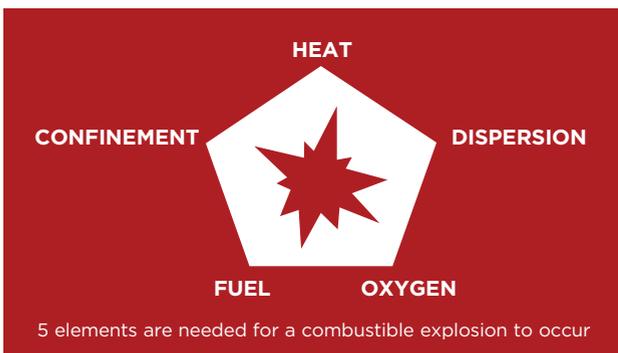
Most combustible dust is often generated as a by-product of a process through activities such as grinding, pulverizing, sifting, etc. Left unnoticed or unattended, dust can accumulate to dangerous levels in plain sight or in areas that are completely unseen such as on overhead beams or light fixtures and above the tiles of a suspended ceiling. These obscure locations pose a significant threat since they may never be addressed in routine

housekeeping protocol and could house years of particulate accumulation which has the potential to fuel a combustible dust fire.

The mere presence of dust does not create a hazard; the potential for a combustible dust explosion only exists when 5 factors occur simultaneously. In this respect, it differs substantially from what is normally required for a fire. The “fire triangle” visually describes that three elements are necessary for a fire to start and continue to burn. Fuel, oxygen and heat are essential to initiate and sustain combustion.



However, when dust is fueling a fire, 2 additional factors must be present. The dust must somehow become airborne in a confined space and at the appropriate concentration. In an industrial environment, the source of ignition starting the fire can be an open flame, mechanical sparks, electric arc, frictional heat, welding slag or another variety of thermal energy. If any one of these 5 elements is not present, a combustible dust explosion cannot occur. The icon illustrating these required constituents is known as the “combustible dust pentagon”.



Combustible dust accidents are usually characterized by a series of explosions. The initial explosion sends shock waves through nearby areas which dislodge overhead accumulations of latent dust. This new source

of dust becomes suspended in the air and has the potential to charge a subsequent explosion in an adjacent area of the plant. These ensuing events often cause the majority of damage and loss of life.

The question of how much dust creates a hazard is heavily debated. Some of the literature offers an exact response: if the layer of particulate measures more than 1/32” in 5% of the total square footage (consider all lateral surfaces, not just floors), a combustible dust hazard may exist.* A less formal means of gauging a potential hazard is to notice if visible footprints are left behind when walking across a surface covered with dust or if the color of that covered surface cannot be discerned.

In response to heavily publicized combustible dust accidents/explosions, OSHA initiated a National Emphasis Program (NEP) which sought to train OSHA compliance officers on the recognition of combustible dust hazards. To date, OSHA has held stakeholder meetings but has not yet issued a federal regulation on combustible dust. The current edition of NFPA 654 requires that in facilities where combustible dust exists a hazard assessment be conducted in accordance with NFPA 2113, *Standard of Selection, Care, Use and Maintenance of Flame-Resistant Garments for Protection of Industrial Personnel Against Flash Fire*, to determine the need for flame-resistant clothing.

*As stated in NFPA® 654, 2013 Edition

WHAT STANDARDS ARE USED FOR STATION/WORK UNIFORMS FOR EMERGENCY SERVICES PERSONNEL?

The National Fire Protection Association (NFPA) standard on Station/Work Uniforms for Fire and Emergency Services - NFPA 1975 - establishes minimum performance and certification requirements for textiles and other materials used in the construction of station/work uniforms for emergency services personnel. The standard specifies requirements for the design, performance, testing and certification of nonprimary protective station work uniforms that will not contribute to burn injury severity. Minimum requirements are established for thermally stable flammable textiles that will not melt or shrink excessively as well as optional requirements for fabrics represented as flame-resistant. There are separate labeling requirements for garments assembled from flame-resistant and non FR fabrics.

Garments meeting the standard are required to be certified by a third party listing organization and the manufacturer is required to be registered to ISO 9000, Quality Management Systems-Requirements.

Manufacturers are also required to have a written safety alert system and a written product recall system in the event they decide or are directed to issue a product alert or recall.

The standard sets base requirements for all garments. These include heat and thermal shrinkage resistance, thermal stability, seam strength and label durability. There are also optional flame resistance requirements for FR fabrics. Garments being tested to base level requirements alone are tested after 25 home wash cycles. Garments tested to the optional FR requirements are tested after 100 home wash cycles. When garments are made from FR fabrics, they are required to be constructed with inherently FR sewing thread.

WHAT STANDARDS ARE USED FOR ELECTRIC POWER GENERATION, TRANSMISSION AND DISTRIBUTION?

In April 2014, OSHA issued the long awaited revision to Final Rule OSHA 1910.269 Electric Power Generation, Transmission and Distribution; Electrical Protective Equipment. The document became law July 10, 2014, although OSHA has adopted delayed compliance deadlines until April 1, 2015 for certain requirements including Fall Protection, PPE, new determination of minimum approach distances (MAD) and arc flash hazard assessment. Citations for non-compliance were also delayed.

Important changes from a fabric/garment standpoint that were delayed until April 1, 2015 are that employers must provide and pay for protective clothing that covers the entire body, is flame resistant, and has an arc rating equal to or greater than the estimated heat energy when it exceeds 2.0 cal/cm².

Additionally, by January 1, 2015 employers must make a reasonable effort to conduct an arc flash hazard analysis on systems operating between 50 and 240 volts. Appendix E to the standard provides tables listing incident heat energies for common exposures found in electric power transmission and distribution work. Employers may use these tables to estimate incident heat energy under the exposure conditions covered by the tables. In addition, Appendix E provides guidance on assessing the workplace for flame and electric-arc hazards, selecting a reasonable incident-

energy calculation method under various conditions, and selecting reasonable parameters for use in calculating incident heat energy. Appendix E also provides guidance on selection of appropriate protective clothing and arc rated head and face protection.

The National Electrical Safety Code (NESC®) is published by the IEEE. It sets the ground rules for practical safeguarding of persons during the installation, operation, or maintenance of electric supply and communication lines and associated equipment.

The NESC requires that the employer determine potential exposure to an electric arc for employees who work on or near energized parts or equipment operating at 50 volts or greater. If the exposure is greater than 2 cal/cm², employees are required to wear clothing with an arc rating not less than the anticipated level of arc energy as determined by completing a detailed arc hazard analysis or by using tabulated values found in table 410-1. Table 410-1 outlines equipment types, nominal voltage ranges and the arc thermal performance value (ATPV) cal/cm², for clothing or clothing systems for employees working on or near energized lines, parts or equipment. Depending on the voltage, effective arc ratings can range from 4 calories to as much as 60 calories/cm². Certain meltable fabrics are not allowed.

The NESC also contains requirements that risk factors such as equipment condition and work methods must be considered in implementation of an arc flash program and that a job briefing must be conducted by a first-level supervisor or person in charge.

WHAT ARE THE ELECTRICAL SAFETY REQUIREMENTS FOR THE WORKPLACE?

National Fire Protection Association (NFPA) Standard 70E, Standard for Electrical Safety in the Workplace, is designed to provide a practical safe working area for employees relative to the hazards arising from the use of electricity.

This standard addresses electrical safety related work practices for activities such as inspection, operation, repair or demolition of electric conductors, electric equipment, signaling and communications conductors and equipment, and raceways. It also includes safe work practices for employees performing other work activities that can expose them to electrical hazards such as installation of conductors and equipment; or in installations used by the electrical utility, but are not an

integral part of a generating plant, substation or control center.

The 2015 Edition of NFPA 70E made changes in three significant areas: new Personal Protection Equipment (PPE) tables, elimination of both the Hazard/Risk Category Zero (CAT 0) and the Prohibited Approach Boundary (PAB).

The elimination of CAT 0 effectively requires arc rated clothing for all electrical work, but with an important exception. If enclosed electrical equipment operating at 600 volts or less is “operating normally”, it is not likely to expose the employee to an electrical hazard and therefore PPE is not required. Normal operation is defined as the equipment is properly installed, maintained, all doors are closed and secured, all covers are in place and secured, and “there is no evidence of impending failure”. Because it is unlikely that equipment will fully meet all of these criteria, qualified persons will still need to assess the risks involved in performing any task and wear appropriate PPE. 70E continues to allow non-melting flammable (non-arc rated) materials to be used as undergarments. However, garments that are not arc-rated cannot be used to increase the arc rating of a garment or a clothing system.

The 2015 revision includes formatting changes to the PPE tables (130.7(C)(15)). In the new format the table is split into two tables. The first table is used to determine if an arc flash hazard exists. If a hazard exists, the second table would be used to choose the arc flash category of the recommended clothing and PPE. This is based on the same limits as the current table and the categories remain the same, but PPE categories are no longer based on perceived risk. This eliminates the downrating of CAT categories based on perceived risk. If there is an arc flash hazard, you must wear all the required PPE and clothing.

The Prohibited Approach Boundary was the closest of the three shock boundary lines, although it did not trigger any restriction or action. It was eliminated to avoid confusion. The Restricted Approach Boundary (RAB) remains the point beyond which only qualified personnel can pass, and they need to wear insulating gloves and necessary PPE. The Limited Approach Boundary (LAB) is the closest an unqualified person can get to exposed energized circuit parts.

Under NFPA 70E employers must document and implement an overall electrical safety

program that includes hazard/risk evaluation and job briefing procedures. This program must be audited annually. If energized electrical conductor or circuit parts operating at 50 volts or more are not placed in an electrically safe work condition, written authorization by work permit is required. Employees must be qualified to do the work and trained to understand the specific hazards and potential injury associated with electrical energy. Employees exposed to shock hazards must be retrained annually in cardiopulmonary resuscitation.

Employers must conduct both shock and flash hazard analysis to establish a flash protection boundary. When work will be performed within the arc flash protection boundary, the employer must document the incident energy exposure in calories per square centimeter. Arc rated clothing conforming to the requirements of ASTM F1506 and appropriate PPE must be worn either based on the incident energy determined for the specific task or by using NFPA 70E Table 130(C)(15) to determine the hazard/risk category.

Canadian Standards Association Standard Z462-08, *Workplace Electrical Safety*, is the Canadian standard for electrical workplace safety. Garments meeting the requirements of NFPA 70E also meet the requirements specified in CSA Z462-08, Section 4.3.7. Z462 PPE requirements are currently essentially identical to the 2009 Edition of NFPA 70E. Future plans are to modify Z462 for Canadian requirements.

WHAT ARE THE GARMENT PERFORMANCE REQUIREMENTS FOR WORKERS EXPOSED TO ELECTRIC ARCS?

The ASTM F1506, Specification for *Flame-Resistant Textile Materials for Wearing Apparel for Use by Electrical Workers Exposed to Momentary Electrical Arc and Related Thermal Hazards*, covers performance properties of textile materials to be used for wearing apparel by electrical workers exposed to electric arcs. These materials must meet the following performance requirements:

- » A general requirement that thread, findings, and closures used in garment construction not contribute to the severity of wearer injuries in the event of an electric arc exposure.
- » A set of minimum performance specifications for knit and woven fabrics.
- » The fabric must not melt, drip, or have more than 2.0 seconds Afterflame or 6.0 inches

Char Length when tested as received and after 25 launderings or dry cleanings. Testing for flame resistance is in accordance with ASTM Test Method D6413.

- » The fabric may not have more than 5.0 seconds Afterflame time when tested as received in accordance with ASTM Test Method F1959. The arc rating is reported as either: arc rating ATPV or arc rating E_{BT} (if the ATPV cannot be calculated because of fabric breakopen). The arc rating is reported as guidance on the performance of the fabric in arc exposure testing. There is no minimum required value for arc rating.

Garments conforming to the requirements of F1506 must be labeled with a tracking code, a statement that the garments meets the requirements of F1506, the manufacturer's name, size information, care instructions and fiber content, and the arc rating (ATPV) or (E_{BT}). When garments are made with a different number of fabric layers in different areas; e.g., double layer front panels, the arc rating for each area must be designated. Pockets, trim, closures, seams, etc. are not considered extra layers.

HOW ARE PROTECTIVE GARMENTS FOR WORKERS EXPOSED TO ELECTRIC ARC TESTED?

Two standards relating to performance of textiles materials intended for use as protective clothing for workers exposed to electric arcs have been issued by ASTM International:

- » F1958, *Standard Test Method for Determining Ignitability of Non-Flame-Resistant Material for Clothing for Electric Arc Exposure Method Using Mannequins:*

This test method exposes a material to heat energy from an electric arc and determines the incident exposure energy that causes ignition. The test also determines the probability that ignition will occur. Material performance is determined by the ignitability of the specimen(s). Materials that meet the flame resistance requirements of Specification F1506 do not require testing by this method unless they meet these requirements by melting to escape from the flame.

Textile materials, either in single or multiple layers, are fabricated as shirts and exposed to an electric arc while mounted on at least two mannequins. The mannequins are arranged in a circle centered on the

arc. Results are reported as a probability of ignition at various incident exposure energy levels at a specified amperage and distance. Multiple tests are required to assure statistical significance.

- » F1959, *Standard Test Method for Determining the Arc Thermal Performance Value for Materials for Clothing:*

This test method is used to measure the arc rating of materials intended for use as flame-resistant clothing for workers exposed to electric arcs that can generate heat flux rates from 2 to 600 cal/cm²/second. It is not intended for non-flame-resistant materials. Arc ratings are expressed in cal/cm² and are derived from the Arc Thermal Performance Value (ATPV) or Breakopen Threshold Energy (E_{BT}).

Textile materials in the form of flat specimens mounted on three two-sensor panels are exposed to an electric arc. The panels are equally spaced in a circle around the arc. Arc parameters are 8 +/- 1-kA arc current, 12-inch electrode gap, stainless steel electrodes, and 12-inch distance between the arc centerline and the test specimen surface. The incident energy range is achieved by increasing or decreasing the arc duration.

The amount of heat energy transferred by the textile materials is measured by copper calorimeters mounted in the sensor panels. A series of at least seven tests are run over a range of incident energies. From the heat transfer data, the Arc Thermal Performance Value (ATPV) is calculated as the incident energy that results in a 50% probability of the onset of a second-degree burn. This is determined based on the Stoll Curve, a skin burn injury model produced from data on human tissue tolerance to heat that is used as an overlay for the plot of the sensor responses. The Heat Attenuation Factor (HAF) is the percentage of total energy the fabric has prevented from reaching the panel sensors.

A minimum of 20 data points is required for data analysis, of which 15% must always exceed the Stoll second degree burn criteria and 15% must never exceed the Stoll criteria. At least 50% of the values must be within +/- 20% of the final ATPV. Some of these values will exceed and some will not exceed the Stoll burn injury criteria. If two or more occurrences of material breakopen are noted at less than 20% above the ATPV determination, a breakopen response is determined as the 50% probability that breakopen will occur. In

this case the lower value of either Breakopen Threshold Energy (E_{BT}) or ATPV is reported as the arc rating for the material.

ARE THERE SPECIAL REQUIREMENTS FOR FLAME-RESISTANT RAINWEAR?

There are two standards that address rainwear exposed to the hazards of electric arc and flames. ASTM F1891, *Standard Specification for Arc and Flame-Resistant Rainwear*, applies to rainwear for use by workers exposed to thermal hazards of electric arcs and open flames. ASTM F2733, *Standard Specification for Flame-resistant Rainwear for Protection against Flame Hazards*, establishes requirements for workers exposed to industrial hydrocarbon fires or other petrochemical fire hazards.

Both standard specifications establish applicable test methods, minimum physical and thermal performance requirements, suggested sizing charts, and suggested purchasing information for rainwear.

These standards establish a requirement that the FR rainwear material must have a trapezoidal tear resistance greater than 6 pounds, withstand 30 PSIG water pressure without leaking, and have seams that demonstrate a hydrostatic resistance of 3 PSIG for 2 minutes. All mechanical fastener closures such as buttons and snaps must be covered by the rainwear outer layer material and a layer of material on the inside of the garment to reduce heat transfer to the skin. For garments meeting F1891, all fabrics, trim and findings used to manufacture rainwear must be electrically non-conductive. Markings and reflective trim must not degrade the protective performance of the rainwear.

The rainwear material must not melt, drip, or have more than 2.0 seconds Afterflame when tested in accordance with ASTM Test Method D 6413. F1891 requires a maximum of 6.0 inches Char Length; F2733 has a more stringent requirement of 4.0 inches Char Length, maximum. Testing is conducted on rainwear material as received and after five cleaning and drying cycles following the manufacturer's care instructions.

Rainwear for protection from electric arcs is tested for thermal resistance to an electric arc by ASTM Test Method F1959 to determine the arc rating and heat attenuation factor (HAF). The arc rating is expressed in calories per square centimeter and is derived from the Arc Thermal Performance Value (ATPV) or

Breakopen Threshold Energy (E_{BT}). The arc rating must be equal or greater than 5.0 cal/cm². Response characteristics of the rainwear material; Afterflame time, breakopen, charring, electric arc ignition, embrittlement, melting and shrinkage are determined and reported at exposures equal to the arc rating. No dripping of the material is permitted at exposures twice the arc rating.

Rainwear for protection from hydrocarbon fires and related hazards is tested to determine percent body burn following exposure on an instrumented mannequin in accordance with ASTM Test Method F1930. The exposure heat flux is 84 kW/m² (2.02 cal/cm²/sec) with an exposure time of 3.0 seconds. Three coverall specimens made in accordance with the standard garment requirements of F1930, Section 8.3.2, are laundered and dried one time following the manufacturer's care instructions before testing. The average predicted second and third-degree burn areas and total area of burn injury is determined. Both the third-degree burn area and the total area of burn injury are reported. The average predicted burn area must be equal to or less than 40%. Other material responses to the simulated flash fire are also reported including afterflame time, breakopen, charring, dripping, garment ignition, embrittlement, melting and shrinkage.

Garments meeting the requirements of ASTM F1891 and/or F2733 must be labeled with a statement that the garments conform to the specification, the manufacturer's name, style designation, size information, care instructions and fiber content. Garments for protection from electric arcs must be labeled with the arc rating (ATPV or E_{BT}) of the base material. If the rainwear also meets the requirements of ANSI/ISEA Standard for High-Visibility Safety Apparel and Headwear, it must also be labeled with a statement that the garment meets this standard. Other labeling requirements include the Performance Class and Level and the durability of the garment to appropriate cleaning processes.

WHAT ARE THE REQUIREMENTS FOR HIGH VISIBILITY SAFETY APPAREL?

ANSI/ISEA 107, *American National Standard for High-Visibility Safety Apparel and Headwear*, establishes design, material, photometric and physical performance requirements, care labeling and marking rules for high visibility garments. Garments compliant to ANSI/ISEA 107 are intended to provide visibility to the user in hazardous

situations under any light conditions by day and under illumination by vehicle headlights in the dark.

High-visibility garments marked as flame resistant must comply with the requirements of at least one of the following standards in its entirety: ASTM F1506, ASTM F1891, ASTM F2302, ASTM F2733, or NFPA 2112.

As mandated by the Federal Highway Administration (FHWA), all workers within the rights-of-way of a federally-aided highway who are exposed to either traffic or construction equipment within the work area must wear high-visibility safety apparel. This apparel must meet the Performance Class 2 or 3 requirements of ANSI/ISEA 107. Class 2 garments provide a superior level of visibility for higher risk occupations when work backgrounds are complex and/or weather is inclement, workers' attention is diverted from approaching traffic and vehicle speed is typically greater than 25 mph. Class 3 garments are worn when workers are a high risk due to limited sight distances and/or extreme weather conditions and high speed vehicle traffic. These garments must enable the wearer to be identified as a person.

EN/ISO STANDARDS

ISO 13688:2013 (formerly EN 340) Protective clothing - General requirements ISO 13688 specifies general performance requirements for protective clothing designed to protect against one or more hazards such as heat & flame, moving parts, weather, chemicals or cuts/stabs. It is always cited in combination with another standard which addresses more specific performance requirements for the identified hazard. Performance requirements covered by this standard include:

- » Basic health and ergonomic requirements (innocuousness, design and comfort) to guarantee that the clothing will not adversely affect the health or hygiene of the user. Particular requirements address concerns associated with exposure to nickel (in metal components of garment), pH of fabric, colorfastness to perspiration and the presence of restricted dyestuffs.
- » Ageing requirements measure how initial properties of the protective clothing might change over time. For example, performance thresholds are established for colorfastness to light and laundry shrinkage. Woven textile materials shall not shrink or

extend more than 3% in either length or width (5% for knitted textiles).

- » Size designations (body dimensions shall be marked that correspond with the size)
- » Product labelling to include proper CE marking, applicable pictograms and care instructions. All labels are required to be printed legibly and durably in the appropriate languages.
- » Extensive user information including details about the manufacturer, material content, instructions for use, explanation of pictograms, etc.

ISO 11612:2008 Protective clothing - Clothing to protect against heat and flame ISO 11612 is intended to protect workers against contact with heat and flame. This clothing is suitable for a wide range of working environments where there is a need for clothing with limited flame spread properties in combination with protection against heat transmission (radiant, convective or contact heat and molten metal splashes). Minimum performance consists of flame spread (surface and/or edge ignition, respectively Code A1/A2) in combination with one of these heat transmission codes. "0" means no protection offered.

Codes:

- A : Limited flame spread (A1 = surface ignition, A2 = edge ignition)
- B : Convective heat (B1-B3)
- C : Radiant heat (C1-C4)
- D : Molten Aluminum splash (D1-D3)
- E : Molten Iron splash (E1-E3)
- F : Contact heat (F1-F3)

IEC 61482-2 : 2009 Live working - Protective clothing against the thermal hazards of an electric arc - Part 2 : Requirements. IEC 61482-2 guarantees that the consequences of exposure to an electric arc will not be aggravated by the clothing itself. It addresses both the design of the garment and the materials used in manufacture. Minimum performance requirements for garment materials include limited flame spread properties, mechanical properties as well as arc thermal resistance properties.

EN 1149-5:2008 : Protective Clothing - Electrostatic properties - Part 5: Material performance and design requirements EN 1149 is a series of standards for test methods and performance requirements on electrostatic properties of materials and garments. Protective clothing complying with Part 5 of this European Standard is intended to prevent

the occurrence of electrostatic discharges that may cause ignition of an explosive atmosphere. This type of dissipative clothing is always used as part of a grounded system (footwear, dissipative flooring, etc.) EN 1149-5 specifies design and material requirements. The electrostatic behavior of fabric used in protective clothing can be assessed by measuring the surface resistivity as described in EN 1149-1:2006 (requirement: $2.5 \times 10^9 \Omega$, max) or the charge decay according to the test method outlined in EN 1149-3:2004 (requirement: shielding factor higher than 0.2 sec and/or half decay time less than 4 sec).

WHAT IS THE DIFFERENCE BETWEEN INHERENT FLAME RESISTANCE AND TREATMENTS?

Flame and thermal resistant fibers and fabrics can generally be divided into two groups: those that are inherently flame-resistant, and those that achieve flame resistance through special treatments.

Inherently flame-resistant fibers/fabrics – Flame resistance is an essential characteristic of the fiber from which textiles are made.

Treated fibers/fabrics – Have an applied chemical treatment to change the original level of a specific property or properties, in this instance flame resistance.

BE ADVISED

A number of temporary water soluble flame retardant treatments for cotton have been used. Borax and boric acid salt combinations are the most common. These treatments are strongly discouraged by Bulwark® because of the potential lack of control in application or conditions of wear.

HOW LONG HAVE FR GARMENTS BEEN AVAILABLE?

From earliest times, exposure to fire has been a concern. Various combinations of ammonium salts of sulfuric, hydrochloric, or phosphoric acid have been used to impart flame resistance to cotton textiles. THPC (sold as ROXEL® or FR2®) was the original commercially successful flame-resistant treatment for cotton work apparel. These fabrics had many shortcomings and the treatment was not durable for the life of the garment. Today, flame retardant finishes for 100% cotton and cotton blend fabrics are available with varying levels of durability, including finishes guaranteed for the life of the garment.

Synthetic flame-resistant fibers were developed in the 1950's. The first fiber introduced was NOMEX® from DuPont. As with the development of FR cotton, new finishes and additional fibers have been produced to address identified shortcomings. Currently, various blends and finishes are available for a variety of end uses.

WHAT IS THE BEST FR FIBER AND/OR FABRIC?

There is no perfect flame-resistant garment system that meets all needs. Each FR fiber or treated fabric has certain properties that can be either benefits or shortcomings. Blending different fibers attempts to balance these properties for maximum fabric performance. It is important to be aware of these properties so garments may be selected to meet the specific requirements of a given application.

WHAT KEY POINTS SHOULD I CONSIDER WHEN CHOOSING FR GARMENTS?

Your review of fabrics should consider thermal protection, static resistance, comfort, durability, stability, employee acceptance, appearance, ease of laundry maintenance, color availability and relative cost. You also need to be aware of any special circumstances, such as electric arc, molten substance or chemical hazards.

On the following pages you will find detailed descriptions of the fibers and fabrics currently used to manufacture work apparel.

FLAME-RESISTANT FIBERS

GENERIC NAME	FIBER	MANUFACTURER	MOISTURE REGAIN%*	TENACITY G/DEN**	COMMENTS
Aramid (meta)	Nomex [®] Conex [®]	Dupont Teijin (Japan)	5.5	4.0-5.3	• Long chain synthetic polyamide fiber • Excellent thermal stability. Will not melt and drip. • Excellent chemical and abrasion resistance • Fair colorfastness to laundering and light exposure
Aramid (para)	KEVLAR [®] TWARON [®] TECHNORA [®]	Dupont Teijin Teijin (Japan)	4.3 4.0	21-27 22.6	• Long chain synthetic polyamide fiber • Blended with Nomex [®] for fabric integrity in high temperature exposures • Fair abrasion resistance • Sensitive to chlorine bleach, light, and strong mineral acids
Polyamide imide	KERMEL [®]	KERMEL [®] (France)	3.4	4.0-4.5	• Long chain synthetic polyamide fiber. Excellent thermal stability. Will not melt and drip. • Excellent chemical and abrasion resistance • Fair colorfastness to laundering and light exposure
Melamine	BASOFIL [®]	BASOFIL [®] LLC	5.0	2.0	• A melamine fiber formed when methylol compounds react to form a three dimensional structure of methylene ether and methylene bridges • Resistant to many solvents and alkalis. Moderately resistant to acids. • Will not shrink, melt or drip when exposed to a flame
Modacrylic	Protex [®]	Kaneka (Japan)	2.5	1.7-2.6	• Long chain synthetic polymer fiber containing acrylonitrile units modified with flame retardants • Excellent chemical resistance • Fair abrasion resistance • High thermal shrinkage
FR Acrylic	Super Valzer [®]	Kanebo (Japan)	2.5	1.7-2.6	• Long chain synthetic polymer fiber containing acrylonitrile units modified with flame retardants • Excellent chemical resistance • Fair abrasion resistance • High thermal shrinkage
PBI	PBI Gold [®]	PBI Performance Products Inc.	15.0	2.8	• Polymer is a sulfonated poly (2,2-m-phenylene-5,5 bibenzimidazole). Will not ignite, does not melt. • Excellent chemical resistance • Dyeable in dark shades only
Polyimide	P84 [®]	Inspec Fibres (Austria)	3.0	4.3	• Long chain synthetic polyimide fiber • High thermal shrinkage • Thermal properties inferior to Nomex [®]
FR Viscose	Lenzing FR [®]	Lenzing (Austria)	10.0	2.6-3.0	• Man-made cellulosic, properties similar to cotton • Fiber contains flame retardants
FR Cotton	FR Cotton	Natural Fiber	8.0	2.4-2.9	• Flame retardant treated in fabric form. Poor resistance to acids. • Relatively poor abrasion resistance • Relatively poor colorfastness to laundering and light exposure • Wear properties similar to untreated cotton
FR Polyester	AVORA [®] FR Polyester Trivera CS	INVISTA Trivera (GERMANY)	0.4	4.5	• Polyester with proprietary organic phosphorus compound incorporated into the polymer chain • Properties similar to regular polyester except as modified by flame retardants • Melt point 48.2°F (9°C) lower than regular polyester
Carbon/ Oxidized PAN	CarbonX [®] Carbtex [®] Tecgen	Chapman Innovations Carbtex Technology Invista	N/A	3-5	• Oxidized polyacrylonitrile (O-PAN). High limiting oxygen index (LOI). Remains strong on exposure to high temperature. Fiber is black in color.
Polyamide	Nylon	INVISTA Solutia	4.5	6.0-8.0	• Long chain synthetic polyamide in which less than 85% of the amide linkages are attached • Blended with FR cotton to improve abrasion resistance, wear properties significantly better than untreated cotton
Vinal	VINEX [®] FR9B [®]		3.0	3.0	• Fabric blended of 85% Vinal/15% rayon • Fiber composed of vinyl alcohol units with acetal crosslinks • Sheds aluminum splash • Very sensitive to shrinkage from wet and dry heat

*A measure of ability to absorb moisture. (Percent by weight of moisture gained from a bone dry state at 65% relative humidity)

**A measure of strength and durability. (Tenacity is defined as force per unit linear density to break a known unit of fiber)

» FAST FACTS

- » All manufactured garments are required to meet U.S. flammability standards.
- » The standard 16 CFR Part 1610 measures ease of ignition and flame spread time. All non-FR fabrics fit into one of three classes:
 - Class 1:** Normal flammability
 - Class 2:** Intermediate flammability
 - Class 3:** Rapid/Intense burning
- » All wearing apparel made from plain surface textile fabric and sold in the U.S. must be made of fabric rated Class 1.
- » Everyday wearing apparel will ignite and continue to burn if exposed to an ignition source.
- » When work environments or occupations pose a risk of garment ignition and burning, flame-resistant apparel should be considered and selected.

PG 8

- » Flame-resistant fabrics and garments provide protection against clothing ignition and sustained flame spread.
- » FR fabrics and garments self-extinguish almost immediately upon removal of ignition source.
- » FR undergarments provide additional protection to the wearer; non-FR undergarments are acceptable only if they are made from non-melting fibers (cotton or other natural fiber).
- » Remove FR garments at once if contaminated with flammable materials.
- » Where any risk of ignition exists in the workplace, there is a need for flame-resistant garments.
- » Regardless of their weight, untreated 100% cotton fabrics are not flame-resistant.

PG 9

- » Common causes of ignition of work apparel:
 - Flammable liquids and gases
 - Combustible dusts
 - Slag from flame cutting
 - Electric arc events
 - High energy electrical discharges
 - Flammable soils
 - Molten metals
 - Open flames
 - Welding
 - Sparks
- » It is the employer's responsibility to identify risks and hazards in the workplace and to protect employees.
- » When choosing flame-resistant garments, evaluate the workplace, wearer comfort requirements, durability, appearance, and availability of laundry options.

PG 10

- » **Flame-Resistant** - The characteristic of a fabric to resist ignition and to self extinguish if ignited.

- » **Flame Retardant** - A chemical substance used to provide flame resistance.
- » **Primary Protective Clothing** - For activities where significant exposure to flame or heat is likely.
- » **Secondary Protective Clothing** - For continuous wear in designated areas where intermittent exposure to flame or heat is possible.
- » **Chemical Resistance** - Relates to the ability of fabrics to withstand exposure to various chemicals.
- » **Stoll Curve** - Developed by Alice Stoll in the 1960's, and used in many tests to predict the thermal protective performance of textile materials for FR apparel.
- » **Arc Rating** - The maximum incident energy resistance of a material expressed in calories per square centimeter prior to breakopen or the onset of a second-degree burn.
- » **ATPV** - The incident energy, expressed in cal/cm², on a material or a multilayer system of materials that results in a 50% probability that sufficient heat transfer through the tested specimen is predicted to cause the onset of a 2nd degree burn injury based on the Stoll curve.

PG 13

The Flame Resistance of Cloth: Vertical test records:

» AFTERFLAME

The number of seconds there is a visible flame on the fabric after the ignition source is extinguished.

» AFTERGLOW

The number of seconds there is a visible glow on the fabric after the ignition source is extinguished.

» CHAR LENGTH

The length of fabric destroyed by flame.

- » ASTM D6413 establishes a test method only with no pass/fail requirements.

PG 14

NFPA 2112 Requires

- » Approval by a third party listing organization, such as UL®.
- » Both "spaced" and "contact" HTP requirements.
- » Predicted body burn of less than 50% in mannequin test.

PG 15

Fire and EMS Station / Work Uniforms NFPA 1975 Requires

- » Approval by a third party listing organization, such as UL®.
- » Component recognized fabric must not ignite, melt and drip, or separate in a forced air oven test.
- » FR or untreated 100% cotton or wool fabrics are acceptable.
- » ISO registration of garment manufacturer is required.

PG 16

Electrical Hazards OSHA 1910.269 Requires

- » The use of FR/arc rated clothing be worn by all electrical workers who could be exposed to an electric arc while on the job.
- » That hazard analyses of incident energies be complete by Jan 1, 2015.
- » Employees must be properly clothed in FR/arc rated garments having arc ratings equal to or greater than the estimated incident energies.

» FAST FACTS

NESC Requires

- » Employer must conduct hazard analysis.
- » Arc rated clothing required if exposure is greater than 2 cal/cm².
- » Arc protection required based on tables in the standard, or a minimum effective rating of 4 cal/cm².

PG 14

Combustible Dust

- » NFPA® 654, Standard for the Prevention of Fire and Dust Explosions from the Manufacturing, Processing and Handling of Combustible Dust Particulate Solids is considered the general industry standard when combustible dust presents a hazard.
- » Combustible dust is a particulate solid that presents a fire or deflagration hazard when suspended in air OR some oxidizing medium.
- » Combustible dust explosions can occur only when 5 factors are present; Heat, Confinement, Dispersion, Fuel, and Oxygen.
- » OSHA has implemented an NEP (National Emphasis Program) on combustible dust and has initiated the rulemaking process to establish a federal standard; however, no deadline for completion has been established.

PG 16

Electrical Safety NFPA 70E Requires

- Employees must use safe work practices and personal protective equipment (PPE), which includes arc rated clothing based upon the incident energy associated with the specific task. Total system arc rating of layered ensembles must be determined by a multilayer arc test. Employers must document an overall safety program including hazard/risk assessment and job briefing procedures. This program must be audited annually.
- » Arc rated clothing required for all electrical work, but with exceptions for “normally operating” equipment.
 - » PPE tables split. The first table is used to determine if an arc flash hazard exists; the second is used to determine the arc flash category of the PPE.
 - » All layers used to determine total system arc rating must be FR. Arc ratings cannot be added together, each ensemble must be tested layered as it will be worn.
 - » CSA Z462 is the Canadian standard for electrical workplace safety. As currently written, the PPE requirements are virtually identical to NFPA 70E with modifications in formatting and style that give Z462 a different look and feel than 70E. There are also changes to Lockout requirements, references to Canadian Standards and additional Canadian annexes not found in 70E.

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Workers Exposed to Electric Arcs, ASTM F1506 Requires

- » Thread, findings and closures do not contribute to the wearer's injuries in an electric arc exposure.
- » Knit or woven fabrics may not melt and drip, or have more than 2.0 seconds Afterflame or 6.0 inches Char Length.

- » Fabrics can not have more than 5.0 seconds Afterflame in an electric arc exposure test.
- » Arc rating must appear on garment labels.

PG 18

ASTM F1958

- » Determines probability of ignition at a range of arc exposures.
- » Used to test FR and non-FR materials.
- » Fabrics are tested as shirts mounted on mannequins.

ASTM F1959-99

- » Determines arc rating of materials based on electric arc exposure.
- » Fabrics are mounted on flat panels for testing.
- » Ratings are expressed in cal/cm².
- » E_{BT} determined if material shows breakopen response above the ATPV.

PG 19

ASTM Standard Specifications for Flame and Thermal Protective Rainwear

- » Material must withstand 30 PSIG water pressure without leaking.
- » Seam hydrostatic resistance requirement 3 PSIG/2 minutes.
- » No melt and drip permitted in vertical FR testing. Maximum allowable Char Length is no more than 4.0 inches for F2733 or 6.0 inches for F1891.
- » For rainwear for protection from electric arcs, the arc rating (either ATPV or E_{BT}) must be equal to or greater than 5.0 calories per square centimeter. The material response characteristics are evaluated at the arc rating and no dripping is permitted at twice the exposure level of the arc rating.
- » Rainwear for protection from hydrocarbon fires and related hazards must have an average predicted total burn area equal to or less than 40% when exposed to a 3 second simulated flash fire.
- » Garments meeting the requirements of F1891 and/or F2733 must be labeled with a statement that the garments conform to the specification, the manufacturer's name, style designation, size information, care instructions and fiber content. Garments for protection from electric arcs are required to be labeled with the arc rating (ATPV or E_{BT}) of the base material.



TREATED FABRIC

Fabrics that are treated with a flame retardant chemical to make them flame-resistant. The fibers used in these fabrics, such as cotton, are not normally considered protective and become flame-resistant because of the treatment. The durability of the treatment can vary from very limited to life of the garment.

- | | |
|-----------|---|
| 27 | Amplitude® |
| 28 | Durable FR 100% Cotton |
| 29 | Durable FR Cotton Blends |
| 31 | FR Disposables |
| 32 | Limited Durability FR Treated 100% Cotton |
| 33 | iQ Series™ Knits |
| 35 | iQ Series™ Wovens |

AMPLITUDE® BY MILLIKEN® 88% COTTON/12% NYLON

Milliken Amplitude® is made from a blend of cotton and nylon fibers. Amplitude® is differentiated from conventional 88/12 fabrics that are constructed with warp yarns that are a blend of 75% cotton and 25% nylon and 100% cotton filling yarns. Amplitude® is an intimate blend of 88% cotton and 12% nylon. This means that every yarn, warp and filling, consists of 88% cotton and 12% nylon. This fabric is also finished by a patented process without the use of ammonia. Westex® by Milliken® fabrics under the Amplitude® brand are available in a variety of weights, including a 6.0 oz sateen weave version that is designed to achieve NFPA® 70E CAT 2 and NFPA® 2112 compliance.

Bulwark® Protective Apparel markets garments made from Milliken Amplitude® durable FR cotton blend fabrics under the brand name “Excel-FR® ComforTouch®”.

APPLICATIONS

Utilities, petrochemical, chemical, oil and gas. Nearly all areas involving ferrous metals such as foundries, flame cutting, welding, etc.

NOT RECOMMENDED FOR

Use around molten “white metals” such as aluminum, magnesium, or zinc. Because of their relatively low melt/freezing temperatures, these metals may stick to the fabric. Flame-resistant fabrics treated with a phosphorus containing flame retardant should not be used in chemical operations where contact with strong oxidizers (e.g. >10% sodium hypochlorite, NaOCl) or reducing agents (e.g. sodium hydrosulfite, Na₂S₂O₄) is possible. Contact with these chemicals may result in chemical burns to the wearer. These fabrics are not recommended for use in critical static control operations.

FLAME RESISTANCE

When laundered by recommended procedures, Milliken Amplitude® fabric is guaranteed to be flame-resistant for the life of the garment.

COLORS

Dyeable in a wide range of colors. Colorfastness to laundering is variable and similar to untreated cotton.

EFFECT OF ACIDS AND ALKALIS

Resistant to alkalis and most solvents, but many acids will completely destroy cotton,

both FR and non-FR. The fabric does not provide personal chemical protection to the wearer. Where chemical exposure is a hazard, appropriate specialized barrier garments should be selected.

EFFECT OF BLEACHES AND SOLVENTS

Cotton is unaffected by chlorine bleach at correct temperature and pH ranges. However, repeated chlorine bleach launderings will destroy the flame-retardant polymer.

Chlorine bleach must not be used on flame retardant treated durable FR cotton blend fabrics. Detergents containing bleach alternatives (sodium perborate) are acceptable for home laundering, but **industrial laundry detergents containing hydrogen peroxide must not be used.**

EFFECT OF MILDEW, AGING, SUNLIGHT AND ABRASION

Cotton has relatively poor resistance to mildew, aging, and sunlight. Abrasion resistance is also relatively poor. Nylon is added to the blend to improve abrasion resistance. Direct exposure to ultraviolet rays in welding can cause actinic degradation resulting in fabric strength and color loss.

THERMAL STABILITY

Milliken Amplitude® has good resistance to dry heat and is a natural insulator. In a thermal exposure, the nylon portion of the 88% cotton/12% nylon blend is completely absorbed by the majority cotton fiber. It does not flow or lead to skin contact. This fabric is acceptable for use in occupations exposed to electric arc hazards.

Phosphorus treated cotton blends cannot be used around molten white metals such as aluminum, magnesium or zinc. Because of the low surface tension of these substances in liquid form, they will stick to FR cotton blends. See the sections on Wool/Rayon Blends, and coated aluminum splash fabrics for information on fabrics appropriate for use around white metals.

MOISTURE REGAIN/STATIC CONTROL

Moisture regain of Milliken Amplitude® is excellent which results in low static propensity. The addition of a small amount of nylon and the flame resistant process has only a minor affect on moisture regain. However, since static control depends on ambient relative humidity, the garment should not be considered for applications where

critical static control is required without proper wearer grounding. **It is especially important that these garments not be donned or removed in a hazardous area.**

PROCESSING

Flame-resistant apparel should be washed using water with hardness not exceeding 1.5 grains (25 ppm). Hard water can affect cleaning and contains mineral salts that can form insoluble deposits on the fabric. These deposits can negate the flame-resistant characteristics of the garment and may serve as fuel if garments are exposed to an ignition source.

Durable FR cotton/nylon blend garments made from Milliken Amplitude® fabrics can be laundered by normal procedures used for any 100% cotton garments. Laundry shrinkage of up to 3.5% can be expected, although exposure to excessive dryer temperatures will result in much higher shrinkage. Starches, fabric softeners, and other laundry additives should be avoided. **DO NOT USE CHLORINE BLEACH DO NOT USE INDUSTRIAL LAUNDRY DETERGENTS OR OTHER CHEMICALS CONTAINING HYDROGEN PEROXIDE.** Detergents containing bleach alternatives (sodium perborate) are acceptable for home laundering. The fabric can be tunnel finished up to 280°F (138°C) fabric temperature or pressed at normal utility press temperature (300°F / 149°C). See Bulwark Care & Cleaning Information Bulletin RK-78 or www.bulwark.com for more information.

GARMENT COST

Milliken Amplitude® durable FR cotton/nylon blend garments cost about 20% more than equivalent weights of durable FR 100% cotton.

GARMENT LIFE

Garment life under normal wear conditions is about 40-50% more than durable FR 100% cotton fabric, and perhaps 1/2 that of NOMEX®.

DURABLE FR 100% COTTON

These fabrics are made flame-resistant by application of a flame retardant finish. This finish can be either a phosphonium salt precondensate polymerized with gaseous ammonia (THPOH-NH₃), or a heat-cured dialkylphosphonamide. These processes bind the flame retardant to cotton fiber for FR durability. Either process has only a minor effect on fabric hand and performance. Among fabrics produced by the “ammonia cure” process are AMTEX® by Mount Vernon Mills, Inc., Banox Certified® by ITEX, Inc. and INDURA® by Westex® by Milliken®. Fabrics produced by the heat cure process include Dale AntiFlame® and many of the cotton knit and fleece fabrics.

Bulwark® Protective Apparel markets garments made from durable flame-resistant 100% cotton fabrics under the brand name “EXCEL FR®”.

APPLICATIONS

Utilities, petrochemical and chemical plants, oil, gas, military applications, and wildland fire fighting. Nearly all areas involving ferrous metals such as foundries, flame cutting, welding, etc.

NOT RECOMMENDED FOR

Use around molten “white metals” such as aluminum, magnesium, or zinc. Because of their relatively low melt/freeze temperatures, these metals may stick to the fabric. Flame-resistant fabrics treated with a phosphorus containing flame retardant should not be used in chemical operations where contact with strong oxidizers (e.g. >10% sodium hypochlorite, NaOCL) or reducing agents (e.g. sodium hydrosulfite, Na₂S₂O₄) is possible. Contact with these chemicals may result in chemical burns to the wearer. These fabrics are not recommended for use in critical static control operations.

FLAME RESISTANCE

When laundered by recommended procedures, durable flame-resistant 100% cotton fabrics are guaranteed to be flame-resistant for the life of the garment.

COLORS

Dyeable in a wide range of colors. Colorfastness to laundering is variable and similar to untreated cotton.

EFFECT OF ACIDS AND ALKALIS

Cotton is resistant to alkalis and most solvents, but many acids will destroy cotton fabric. The

fabric does not provide personal chemical protection to the wearer. Where chemical exposure is a hazard, specialized barrier garments should be selected.

EFFECT OF BLEACHES AND SOLVENTS

Cotton fabric is unaffected by chlorine bleach. However, repeated chlorine bleach launderings will destroy the flame-resistant finish. Chlorine bleach must not be used on durable flame retardant treated cotton fabrics. Detergents containing bleach alternatives (sodium perborate) are acceptable for home laundering. Industrial laundry detergents containing hydrogen peroxide must not be used.

EFFECT OF MILDEW, AGING, SUNLIGHT AND ABRASION

Cotton has relatively poor resistance to mildew, aging, and sunlight. Abrasion resistance is also relatively poor. Direct exposure to ultraviolet rays in welding can cause actinic degradation resulting in fabric strength and color loss.

THERMAL STABILITY

Durable FR cotton fabrics have good resistance to dry heat and are a natural insulator. Some molten white metals such as aluminum, magnesium, or zinc have low surface tension. In an accident, the molten metal will stick to these fabrics. Durable FR cotton fabrics cannot be used around these materials. See the sections on Wool/Rayon Blends, and coated aluminum splash fabrics for information on fabrics for use around white metals.

MOISTURE REGAIN/STATIC CONTROL

Moisture regain of durable FR cotton is excellent, resulting in low static propensity. However, without proper wearer grounding these fabrics should not be considered for critical static control applications. **It is especially important that these garments not be donned or removed in a hazardous area.**

PROCESSING

Flame-resistant apparel should be washed using soft water (<1.5 grains (25 ppm)). Hard water affects cleaning and contains mineral salts that form insoluble deposits on the fabric. These deposits can negate the flame-resistant characteristics of the garment, and may serve as fuel if garments are exposed to an ignition source.

Durable FR 100% cotton garments can be laundered by normal cotton processes. Laundry shrinkage of up to 5% can be expected. Exposure to excessive dryer temperatures will result in higher shrinkage. Avoid use of starches, fabric softeners, and other laundry additives. **DO NOT USE CHLORINE BLEACH. DO NOT USE INDUSTRIAL LAUNDRY DETERGENTS OR OTHER CHEMICALS CONTAINING HYDROGEN PEROXIDE.** Detergents containing bleach alternatives (sodium perborate) are acceptable for home laundering. Garments can be tunnel finished up to 280°F (138°C) fabric temperature or pressed at normal utility press temperatures (300°F / 149°C). See Bulwark® Care & Cleaning Information Bulletin RK-78 or www.bulwark.com for more information.

GARMENT COST

Garments of durable FR 100% cotton fabrics cost about twice as much as conventional 65% polyester/35% cotton, or about ½ the cost of NOMEX®.

GARMENT LIFE

Garment life under normal wear conditions is the same as regular 100% cotton, about 1/2 to 2/3 that of 65% polyester/35% cotton, and perhaps 1/3 of NOMEX®.

DURABLE FR COTTON BLENDS 88% COTTON/12% NYLON

Blends of cotton and nylon are designed to increase abrasion resistance compared to similar woven and knit fabrics. Woven fabrics may be made from an intimate blend of 88% cotton and 12% nylon. They may also be constructed with a 75% cotton/25% nylon warp and a 100% cotton filling for an overall blend of 88% cotton/12% nylon. Knit fabrics may be made with an intimate blend of cotton and nylon, or by other methods like plating. These fabrics are made flame-resistant by application of a flame retardant. This finish can be either a phosphonium salt precondensate polymerized with gaseous ammonia (THPOH-NH₃), or a heat-cured dialkylphosphoramidate. These processes bind the flame retardant to cotton fiber FR for durability. Either process has little effect on fabric hand and performance. Among fabrics produced by the "ammonia cure" process are AMTEX® by Mount Vernon Mills, Inc., Banwear® by ITEX, Inc. and Westex® Ultra Soft® by Westex® by Milliken®. Many knit and fleece fabrics are produced by the heat cure process.

Bulwark® Protective Apparel markets these garments under the brand name "EXCEL FR® ComforTouch®".

APPLICATIONS

For utilities, petrochemical, oil, gas, military, and wildland fire fighting. Nearly all areas involving ferrous metals such as foundries, welding, etc.

NOT RECOMMENDED FOR

Use around molten “white metals” such as aluminum, magnesium, or zinc. Because of their relatively low melt/freezing temperatures, these metals may stick to the fabric. Flame resistant fabrics treated with a phosphorus containing flame retardant should not be used in chemical operations where contact with strong oxidizers (e.g. >10% sodium hypochlorite, NaOCl) or reducing agents (e.g. sodium hydrosulfite, Na₂S₂O₄) is possible. Contact with these chemicals may result in chemical burns to the wearer. These fabrics are not recommended for use in critical static control operations.

FLAME RESISTANCE

When laundered by recommended procedures, durable FR cotton blends 88% cotton/12% nylon fabrics are guaranteed to be flame-resistant for the life of the garment.

COLORS

Dyeable in a range of colors. Colorfastness to laundering is similar to untreated cotton.

EFFECT OF ACIDS AND ALKALIS

Cotton and nylon are resistant to alkalis and most solvents, but many acids will destroy cotton fiber. The fabric does not provide personal chemical protection to the wearer. Where chemical exposure is a hazard, specialized barrier garments should be selected.

EFFECT OF BLEACHES AND SOLVENTS

Cotton fabric is unaffected by chlorine bleach. However, repeated chlorine bleach launderings will destroy the flame-resistant finish. Chlorine bleach must not be used on durable flame retardant treated cotton fabrics. Detergents containing bleach alternatives (sodium perborate) are acceptable for home laundering. Industrial laundry detergents containing hydrogen peroxide must not be used.

EFFECT OF MILDEW, AGING, SUNLIGHT AND ABRASION

Cotton has relatively poor resistance to mildew, aging, and sunlight. Nylon in the blend improves abrasion resistance. Direct exposure to ultraviolet rays in welding causes actinic

degradation resulting in fabric strength and color loss.

THERMAL STABILITY

These fabrics have good resistance to dry heat and are a natural insulator. In a thermal exposure, the nylon portion of the blend is absorbed by the cotton fiber and does not contact the skin. These fabrics are acceptable for use in occupations exposed to electric arc hazards. Some molten white metals including aluminum, magnesium, and zinc have low surface tension. Treated FR fabrics cannot be used around these metals. In an accident, the molten metal will stick to the fabric. See the sections on Wool/Rayon Blends, and coated aluminum splash fabrics for information on fabrics for use around white metals.

MOISTURE REGAIN/STATIC CONTROL

Moisture regain is excellent, resulting in low static propensity. However, without proper wearer grounding these fabrics should not be considered for critical static control applications. **It is especially important that these garments not be donned or removed in a hazardous area.**

PROCESSING

Flame-resistant apparel should be washed using soft water (<1.5 grains (25 ppm)). Hard water affects cleaning and contains mineral salts that form insoluble deposits on the fabric. These deposits can negate flame resistance and may serve as fuel if garments are exposed to an ignition source.

Durable FR cotton blend garments can be laundered by normal cotton processes. Shrinkage of up to 5% can be expected. Excessive dryer temperatures will result in higher shrinkage. Avoid use of starches, fabric softeners, and other laundry additives. **DO NOT USE CHLORINE BLEACH. DO NOT USE INDUSTRIAL LAUNDRY DETERGENTS OR OTHER CHEMICALS CONTAINING HYDROGEN PEROXIDE.** Detergents containing bleach alternatives (sodium perborate) are acceptable for home laundering. Garments can be tunnel finished up to 280°F (138°C) fabric temperature or pressed at normal utility press temperatures (300°F / 149°C). See Bulwark® Care & Cleaning Information Bulletin RK-78 or www.bulwark.com for more information.

GARMENT COST

Durable FR cotton blend garments cost about 20% more than durable FR 100% cotton.

GARMENT LIFE

Garment life under normal wear conditions is about 50-60% more than durable FR 100% cotton, and perhaps 1/2 that of NOMEX®.

FR DISPOSABLES 55% WOODPULP/ 45% POLYESTER

The Bulwark® line of FR Disposables is made from Precision Fabrics Group limited use/disposable hydro entangled nonwoven fabrics. These fabrics are topically treated with flame retardant chemicals. The FR treatment is a non-durable phosphate based compound with a fluorochemical additive for water and oil repellency. In this form the fabric is primarily used for dust and solid particle protection, but finished garments can withstand minor splashes without saturation.

The base hydro entangled nonwoven fabric can also be laminated to a clear PVC film with hot melt polyurethane making an impervious laminate with chemical resistant properties.

Both of these fabrics will burn in the presence of an ignition source, but will self-extinguish when the ignition source is removed.

APPLICATIONS

The **Bulwark® FR Disposable Coverall** is made from the base hydro entangled nonwoven fabric. It is highly breathable and offers about 80% filtration efficiency against particles in the 2-5 micron range. It is classified as acceptable for use in Class C: Particulate Abatement activities. Garments made of this fabric can extend the life of more expensive thermal protective garments by preventing flammable contaminants from soiling the fabric.

The **Bulwark® Chemical Splash Flame-Resistant Coverall** is made from the base nonwoven fabric with clear PVC laminate providing chemical resistant properties. Chemical penetration testing of this garment has been conducted in accordance with ASTM F1001, liquid challenges only, using ASTM F903, Procedure C. Please refer to applicable product literature for data related to specific chemical challenges. The Bulwark® Chemical Splash Flame-Resistant Coverall is also classified as acceptable for use in Class C: Particulate Abatement activities.

NOT RECOMMENDED FOR

Neither of these disposable coveralls is designed as a primary source of thermal protection and must be worn over suitable flame-resistant apparel. Not for asbestos removal over suitable flame-resistant apparel.

FLAME RESISTANCE

Both of these disposable coveralls meet the flammability requirements of NFPA 701. The Bulwark® Chemical Splash Flame-Resistant Coverall also meets the flammability requirements of CAN/CGSB 4.2-M77.

COLORS

These coveralls are only available in Sky Blue.

EFFECT OF ACIDS AND ALKALIS

The Bulwark® FR Disposable Coverall has very limited chemical resistance. Refer to applicable product literature for the performance characteristics of the Bulwark® Chemical Splash Flame-Resistant Coverall.

EFFECT OF BLEACHES AND SOLVENTS

The Bulwark® FR Disposable Coverall has very limited chemical resistance. Refer to applicable product literature for the performance characteristics of the Bulwark® Chemical Splash Flame-Resistant Coverall.

EFFECT OF MILDEW, AGING, SUNLIGHT AND ABRASION

As disposable limited use covering garments, exposure in storage to sunlight and/or moist conditions that could result in mildew should be avoided. Neither fabric has significant abrasion resistance.

THERMAL STABILITY

Both of these disposable coveralls will burn in the presence of an ignition source, but will self-extinguish when the ignition source is removed. These limited use disposable garments are not designed as a primary source of thermal protection and **must** be worn over suitable flame-resistant clothing.

PROCESSING

Neither coverall is washable. Always dispose of in a responsible manner when soiled.

GARMENT COST

The Bulwark® FR Disposable Coverall costs about 1/3 as much as a 65% polyester/35% cotton coverall. The Bulwark® Chemical Splash

Flame-Resistant Coverall costs about 1/2 as much as a 65% polyester/35% cotton coverall.

GARMENT LIFE

These coveralls are designed to be used as disposable supplemental protection from a specific hazard, or to prevent soiling expensive reusable protective garments. Although a single use of each garment is anticipated, number of possible wearings will depend on work activities during use.

LIMITED DURABILITY FR TREATED 100% COTTON

Fabrics produced with the gaseous ammonia or ammonia cure reaction, but whose finish is not guaranteed for the life of the garment. Cotton is soft and widely viewed as the most comfortable fiber. The ammonia cure flame-resistant process has only a minor effect on either fabric hand or performance characteristics. Limited durability FR treated 100% cotton fabrics include Banox® by ITEX, Inc.

APPLICATIONS

Molten metals industry and some welding operations where harsh environmental exposures are destructive to the fabric itself. Because the garments themselves have a relatively short service life, durability of the FR finish to extended laundry processing is not seen as a benefit.

NOT RECOMMENDED FOR

Use around molten “white metals” such as aluminum, magnesium, or zinc. Because of their relatively low melt/freezing temperatures, these metals may stick to the fabric. Flame-resistant fabrics treated with a phosphorus containing flame retardant should not be used in chemical operations where contact with strong oxidizers (e.g. >10% sodium hypochlorite, NaOCl) or reducing agents (e.g. sodium hydrosulfite, Na₂S₂O₄) is possible. Contact with these chemicals may result in chemical burns to the wearer. These fabrics are not recommended for use in critical static control operations.

FLAME RESISTANCE

Durability of these 100% cotton fabrics may vary. Manufacturers certify the flame resistance of these fabrics through 25 industrial washes at 185°F (85°C) or through 50 home washings at 140°F (60°C). See garment manufacturer for more information.

COLORS

Dyeable in a wide range of colors. Colorfastness to laundering is variable and similar to untreated cotton.

EFFECT OF ACIDS AND ALKALIS

Cotton is resistant to alkalis and most solvents, but many acids will completely destroy both FR cotton and non-FR. The fabric does not provide personal chemical protection to the wearer. Where chemical exposure is a hazard, appropriate specialized barrier garments should be selected.

EFFECT OF BLEACHES AND SOLVENTS

Bleach resistance deserves a special comment. Cotton itself is unaffected by chlorine bleach if it is properly used (correct temperature and pH ranges). However, repeated chlorine bleach launderings will destroy the flame retardant polymer in treated cotton fabric. Chlorine bleach must not be used on flame retardant treated cotton fabrics. Detergents containing bleach alternatives (sodium perborate) are acceptable for home laundering, but industrial laundry detergents containing hydrogen peroxide must not be used.

EFFECT OF MILDEW, AGING, SUNLIGHT AND ABRASION

Cotton has relatively poor resistance to mildew, aging and sunlight. Abrasion resistance is also relatively poor. Direct exposure to ultraviolet rays in welding can cause actinic degradation resulting in fabric strength and color loss.

THERMAL STABILITY

FR cotton fabric has good resistance to dry heat and is a natural insulator. Phosphorus treated 100% cotton cannot be used around molten white metals such as aluminum, magnesium, or zinc. Because of the low surface tension of these substances in liquid form, they will stick to FR cotton. See the sections on Wool/Rayon Blends, and coated aluminum splash fabrics for information on fabrics appropriate for use around white metals.

MOISTURE REGAIN/STATIC CONTROL

Moisture regain of cotton is excellent, and results in low static propensity. However, since static control depends on ambient relative humidity, without proper wearer grounding, the fabric should not be considered for applications where critical static control is required. **It is especially important that these**

garments not be donned or removed in a hazardous area.

PROCESSING

Flame-resistant apparel should be washed using soft water (<1.5 grains (25 ppm)). Hard water can affect cleaning and contains mineral salts that can form insoluble deposits on the fabric. These deposits can negate the flame-resistant characteristics of the garment, and may serve as fuel if garments are exposed to an ignition source. Limited durability FR treated 100% cotton garments can be laundered by normal procedures used for any 100% cotton garments. Laundry shrinkage of up to 5% can be expected, although exposure to excessive dryer temperatures will result in much higher shrinkage. Avoid starches, fabric softeners, and other laundry additives.

DO NOT USE CHLORINE BLEACH. DO NOT USE INDUSTRIAL LAUNDRY DETERGENTS OR OTHER CHEMICALS CONTAINING HYDROGEN PEROXIDE. Detergents containing bleach alternatives (sodium perborate) are acceptable for home laundering. The fabric can be tunnel finished up to 280°F (138°C) fabric temperature or pressed at normal utility press temperatures (300°F / 149°C).

GARMENT COST

Garments made from limited durability FR treated 100% cotton fabrics cost about 10-15% less than equivalent weight garments made of durable FR 100% cotton.

GARMENT LIFE

Garment life under normal wear conditions is the same as untreated 100% cotton garments of the same construction and weight.

WESTEX G2™ FLAME-RESISTANT KNIT FABRIC BY MILLIKEN®

Through the use of insights, research, and design, Westex® by Milliken® brings new wearability to flame resistant workwear fabrics. Westex G2™ fabrics by Milliken® break the manufacturing barriers traditionally associated with flame-resistant (FR) materials by increasing the levels of comfort, appearance, care, durability, protection and functionality. This group of improved “look good” “wear well” benefits result in a collection of fabrics that are easier to put on and wear in all types of work environments. Westex G2™ fabrics incorporate dual elemental chemistry which is a tailored combination of phosphorus acting as an insulator and a nitrogen source that helps provide increased comfort. These fabrics are available exclusively through Bulwark’s iQ Series™ garments.

WESTEX G2™ COMFORT KNIT FABRIC BY MILLIKEN® 69% COTTON/25% MICRODENIER POLYESTER/6% POD

The Westex G2™ Comfort Knit fabric is created from a blend of high performance fibers including microdenier polyester, polyoxadiazole (POD) and cotton. This unique fiber blend and two-layered fabric construction provides increased moisture management. By moving moisture away from the body and into the fabric structure where it spreads and evaporates quickly, this fabric keeps the wearer drier and more comfortable. Milliken’s unique dual elemental FR treatment provides excellent protection. The Westex G2™ Comfort Knit fabric is finished with a sustainable patent pending FR technology. The fabric is designed to be worn next to the skin and weighs 5.4 ounces per square yard. Fabric protection is NFPA® 70E CAT 2 and NFPA® 2112 compliant.

Bulwark Protective Apparel markets garments made from Westex G2™ Comfort Knit fabrics under the brand name Bulwark iQ Series™.

APPLICATIONS

Utilities, petrochemical, chemical, oil and gas.

NOT RECOMMENDED FOR

Use around molten “white metals” such as aluminum, magnesium, or zinc. Because of their relatively low melt/freezing temperatures, these metals may stick to the fabric. Flame-resistant fabrics treated with a phosphorus containing flame retardant should not be used in chemical operations where contact with strong oxidizers (i.e. >10% sodium hypochlorite, Na₂S₂O₄) is possible. Contact

with these chemicals may result in chemical burns to the wearer. These fabrics are not recommended for use in critical static control operations. See the sections on Wool/Rayon blends, and coated aluminum splash fabrics for information on fabrics appropriate for use around white metals.

FLAME RESISTANCE

When laundered by recommended procedures, Westex G2™ Comfort Knit fabric is guaranteed to be flame-resistant for the life of the garment.

COLORS

Dyeable in a wide range of colors. Colorfastness to home laundering has been found to be good in standard testing. Colorfastness to light is excellent.

EFFECT OF ACIDS AND ALKALIS

Resistant to alkalis and most solvents, but many acids will completely destroy cotton, both FR and non-FR. The fabric does not provide personal chemical protection to the wearer. Where chemical exposure is a hazard, appropriate specialized barrier garments should be selected.

EFFECT OF BLEACHES AND SOLVENTS

Cotton, POD and polyester fibers are unaffected by chlorine bleach at correct temperature and pH ranges. However, repeated chlorine bleach launderings could destroy the flame-resistant polymer. Chlorine bleach must not be used on flame-resistant treated durable Westex G2™ blended fabrics. Detergents containing bleach alternatives (sodium perborate) are acceptable for home laundering, but industrial laundry detergents containing hydrogen peroxide must not be used.

EFFECT OF MILDEW, AGING, SUNLIGHT AND ABRASION

Westex G2™ Comfort Knit fabric is engineered for various work environments and is highly resistant to mildew, aging, and sunlight. This fabric incorporates microdenier polyester and POD performance fibers that have excellent abrasion resistance. Direct exposure to ultraviolet rays in welding can cause actinic degradation resulting in fabric strength and color loss.

THERMAL STABILITY

Westex G2™ Comfort Knit fabric has good resistance to dry heat and is a natural insulator. In a thermal exposure, the polyester portion of

the blend is protected by the flame-resistant polymer structure and the cellulosic fibers which prevent sticking, melt flow, dripping and provide excellent protection to the body. This fabric is acceptable for use in occupations exposed to electric arc.

MOISTURE REGAIN/STATIC CONTROL

Moisture regain of Westex G2™ Comfort Knit fabric is excellent which results in low static propensity. The addition of synthetic fibers and the flame-resistant process has only a minor effect on moisture regain. However, since static control depends on ambient relative humidity, the garment should not be considered for applications where critical static control is required without proper wearer grounding. **It is especially important that these garments not be donned or removed in a hazardous area.**

PROCESSING

Flame-resistant apparel should be washed using water with hardness not exceeding 1.5 grams (25 ppm). Hard water can affect cleaning and contains mineral salts that can form insoluble deposits on the fabric. These deposits can negate the flame-resistant characteristics of the garment and may serve as fuel if garments are exposed to an ignition source.

Durable FR garments made from Westex G2™ Comfort Knit fabric have been tested for home laundering. It has performed well for wash fastness, strength retention and appearance. Shrinkage results will vary depending upon the temperature and cycle used to launder the garment. Recommended dryer temperatures are between 140-160° F (60-70° C). Excessive temperatures in the washer and dryer cycles can have negative impact on shrinkage and color retention. Refer to individual garment specifications for exact shrinkage standards. Starches, fabric softeners and other laundry additives should not be used in processing.

GARMENT LIFE

Westex G2™ Comfort Knit fabrics have held up well in a variety of wash and wear tests but garment life will vary depending upon wear and laundering conditions.

WESTEX G2™ FLAME-RESISTANT WOVEN FABRIC BY MILLIKEN®

Through the use of insights, research, and design, Westex® by Milliken® brings new wearability to flame-resistant workwear fabrics. Westex G2™ fabrics by Milliken® break the manufacturing barriers traditionally associated with flame-resistant (FR) materials by increasing the levels of comfort, appearance, care, durability, protection and functionality. This group of improved “look good” “wear well” benefits result in a collection of fabrics that are easier to put on and wear in all types of work environments. Westex G2™ fabrics incorporate dual elemental chemistry which is a tailored combination of phosphorus acting as an insulator and a nitrogen source that helps provide increased comfort. These fabrics are available exclusively through Bulwark’s iQ Series™ garments.

WESTEX G2™ COMFORT WOVEN FABRIC BY MILLIKEN® 88% LYOCELL/12% POLYESTER

The Westex G2™ Comfort Woven fabric is created from a blend of two performance fibers; Lyocell and Polyester fibers. The fabric incorporates superior fabric engineering and Milliken’s dual elemental FR engineering process provides excellent protection. The unique fiber blend provides increased moisture management. By moving moisture away from the body and into the fabric, this fabric keeps the wearer drier and more comfortable. The fabric weighs 5.7 ounces per square yard and is designed to achieve NFPA® 70E CAT 1 and NFPA® 2112 compliance.

APPLICATIONS

Utilities, petrochemical, chemical, oil and gas.

NOT RECOMMENDED FOR

Use around molten “white metals” such as aluminum, magnesium, or zinc. Because of their relatively low melt/freeze temperatures, these metals may stick to the fabric. Flame-resistant fabrics treated with a phosphorus containing flame retardant should not be used in chemical operations where contact with strong oxidizers (i.e. >10% sodium hypochlorite, Na₂S₂O₄) is possible. Contact with these chemicals may result in chemical burns to the wearer. These fabrics are not recommended for use in critical static control operations. See the sections on Wool/Rayon blends, and coated aluminum splash fabrics for information on fabrics appropriate for use around white metals.

FLAME RESISTANCE

When laundered by recommended procedures, Westex G2™ Comfort Woven fabric is guaranteed to be flame-resistant for the life of the garment.

COLORS

Dyeable in a wide range of colors. Colorfastness to home laundering has been found to be good in standard testing. Colorfastness to light is excellent.

EFFECT OF ACIDS AND ALKALIS

Resistant to alkalis and most solvents, but many acids will completely destroy both FR and non-FR cellulose like Lyocell. The fabric does not provide personal chemical protection to the wearer. Where chemical exposure is a hazard, appropriate specialized barrier garments should be selected.

EFFECT OF BLEACHES AND SOLVENTS

Lyocell and polyester fibers are unaffected by chlorine bleach at correct temperature and pH ranges. However, repeated chlorine bleach launderings could destroy the flame-resistant polymer. Chlorine bleach must not be used on flame-resistant treated durable Westex G2™ blended fabrics. Detergents containing bleach alternatives (sodium perborate) are acceptable for home laundering, but industrial laundry detergents containing hydrogen peroxide must not be used.

THERMAL STABILITY

Westex G2™ Comfort Woven fabric has good resistance to dry heat and is a natural insulator. In a thermal exposure, the polyester portion of the blend is protected by the flame-resistant polymer structure and the cellulosic fibers which prevent sticking, melt flow, dripping and provide excellent protection to the body. This fabric is acceptable for use in occupations exposed to electric arc.

MOISTURE REGAIN/STATIC CONTROL

Moisture regain of Westex G2™ Comfort Woven fabric is excellent which results in low static propensity. The addition of synthetic fibers and the flame resistant process has only a minor effect on moisture regain. However, since static control depends on ambient relative humidity, the garment should not be considered for applications where critical static control is required without proper wearer grounding. **It is especially important that these garments not be donned or removed in a hazardous area.**

PROCESSING

Flame-resistant apparel should be washed using water with hardness not exceeding 1.5 grams (25 ppm). Hard water can affect cleaning and contains mineral salts that can form insoluble deposits on the fabric. These deposits can negate the flame-resistant characteristics of the garment and may serve as fuel if garments are exposed to an ignition source.

Do not subject garments made of Westex G2™ Comfort Woven fabric to a commercial or industrial laundering process.

Durable FR garments made from Westex G2™ Comfort Woven fabric have been tested for home laundering. It has performed well for wash fastness, strength retention and appearance. Home washing and drying using "Permanent Press" cycles is recommended. Excessive temperatures in the washer and dryer cycles can have negative impact on shrinkage and color retention. Refer to individual garment specifications for exact shrinkage standards. Starches, fabric softeners, and other laundry additives should not be used in processing.

GARMENT LIFE

Westex G2™ Comfort Woven fabrics have held up well in a variety of wash and wear tests but garment life will vary depending upon wear and laundering conditions.



TREATED FIBERS

Fabrics made from synthetic fibers that are extruded with a flame retardant chemical in the fiber-forming process. These fabrics become flame-resistant for the life of the garment because the flame retardant cannot be removed by wear or laundering.

- 39 | Lenzing FR® 100% Rayon
- 40 | Blends of Modacrylic and Cotton
- 41 | Molten Metals Industry Protective Fabrics

LENZING FR® 100% RAYON

Lenzing FR® is a man-made cellulosic fiber made by Lenzing AG. It is permanently flame retardant treated in the fiber forming process. Lenzing FR® has been extensively used in fabric blends where it provides increased moisture absorption and comfort without compromising protection.

APPLICATIONS

For industrial protective clothing, Lenzing FR® is commonly blended with other fibers such as para and meta aramids, P84®, and PBI. Lenzing FR® can be used in knits, wovens, and non-wovens.

NOT RECOMMENDED FOR

Use in outer shell fabrics, bunker gear, or other applications where abrasion resistance and extreme physical durability are required.

FLAME RESISTANCE

Lenzing FR® is permanently flame-resistant and this property cannot be degraded by laundering. A solid, non-soluble flame retardant is incorporated at the fiber spinning stage.

COLORS

Dyeable in a wide range of colors. Colorfastness to laundering is variable and similar to normal viscose fiber.

EFFECT OF ACIDS AND ALKALIS

Lenzing FR® is stable when exposed to a wide variety of acids and alkalis. Avoid prolonged exposure to high concentrations of sulfuric acid, sodium hydroxide, dimethyl formamide, and dimethyl sulfoxide. The fabric does not provide personal chemical protection to the wearer. Where chemical exposure is a hazard, appropriate specialized barrier garments should be selected.

EFFECT OF BLEACHES AND SOLVENTS

Lenzing FR® is stable when exposed to a wide variety of bleaching agents and organic solvents.

EFFECT OF MILDEW, AGING, SUNLIGHT AND ABRASION

Lenzing FR® has good UV resistance. Exposure to sunlight (UV rays) does not cause premature aging of the fiber. Resistance to abrasion is fair. Mildew resistance is relatively poor.

THERMAL STABILITY

Lenzing FR® has good resistance to dry heat and is a natural insulator. It will not melt or

drip. High tenacity fibers, such as aramids, are commonly blended with Lenzing FR® to enhance physical durability and thermal stability of the fabric.

MOISTURE REGAIN/STATIC CONTROL

Moisture regain is excellent and results in low static propensity. However, since static control depends on ambient relative humidity, without proper wearer grounding fabric containing Lenzing FR® should not be considered for applications where critical static control is required. **It is especially important that garments containing Lenzing FR® not be donned or removed in a hazardous area.**

PROCESSING

Flame-resistant apparel should be washed using soft water (<1.5 grains (25 ppm)). Hard water can affect cleaning and contains mineral salts that can form insoluble deposits on the fabric. These deposits can negate the flame-resistant characteristics of the garment, and may serve as fuel if garments are exposed to an ignition source.

Garments made of Lenzing FR®, or blends thereof, can be laundered or dry cleaned by normal procedures. Shrinkage can typically vary up to 5%, and is primarily a function of fabric construction and the fabric finishing process. Since Lenzing FR® is often blended with other fibers, it is recommended that the laundering instructions for these fabrics be followed.

GARMENT COST

As Lenzing FR® is commonly blended with other fibers for industrial applications, garment cost will vary depending on the fabric weight and fiber blend.

GARMENT LIFE

As Lenzing FR® is commonly blended with other fibers for industrial applications, garment life will vary depending on the fabric weight and fiber blend.

BLEND OF MODACRYLIC AND COTTON

Various blends of Modacrylic and cotton fibers have been introduced in both woven and knit fabric constructions for use in T-shirts, polo shirts, sweatshirts, hoods, shirts, pants, and coveralls. These fabrics are characterized by excellent, cotton-like hand and include Firewear® from Springfield LLC, a 55% Modacrylic/45% cotton blend, Valzon FR®, a 60% Modacrylic/40% cotton blend from Westex by Milliken and DRIFIRE®, a 85% Modacrylic/15% cellulosic blend from DRIFIRE Inc.

APPLICATIONS

Utilities, and for fire fighters station/work uniforms.

NOT RECOMMENDED FOR

Use around molten substances or welding operations or in critical static control applications.

FLAME RESISTANCE

The FR acrylic fiber is treated with a flame retardant in the fiber forming polymer. Flame resistant properties are permanent and cannot be degraded by laundering. The cotton is not treated for flame resistance but derives its self-extinguishing characteristic from the presence of the FR acrylic fiber.

COLORS

Dyeable in a wide range of colors with good colorfastness. Fabrics may be overprinted.

EFFECT OF ACIDS AND ALKALIS

Chemical resistance is similar to 100% cotton. These fabrics are resistant to alkalis and most solvents. Many acids will completely destroy the cotton portion of the blend. The fabrics do not provide personal chemical protection to the wearer. Where chemical exposure is a hazard, appropriate specialized barrier garments should be selected.

EFFECT OF BLEACHES AND SOLVENTS

Laundering with chlorine bleach is not recommended because it will cause the fabric to lose color. However, chlorine has no effect on the flame resistance of the fabric.

EFFECT OF MILDEW, AGING, SUNLIGHT AND ABRASION

Overall blend has relatively poor resistance to mildew, aging, and sunlight. Abrasion resistance is similar to cotton.

THERMAL STABILITY

Not recommended for use around any molten substance or welding exposure. Thermal stability is excellent and the fabric will not melt.

MOISTURE REGAIN/STATIC CONTROL

Moisture regain of the blend is excellent. Except in very low relative humidity, these fabrics should have little static propensity. However, it should not be considered for use in critical static control applications without proper wearer grounding. **It is especially important that these garments not be donned or removed in a hazardous area.**

PROCESSING

Modacrylic/cotton blend fabrics should be laundered in soft water (<1.5 grains (25 ppm)) without chlorine bleach. Hard water can form insoluble deposits on the fabric. These deposits can negate the flame-resistant characteristics of the garment, and may serve as fuel if garments are exposed to an ignition source.

Best appearance and garment life results are achieved with low temperature (120°F / 49°C) laundering using surfactant chemistry detergents. Wash temperatures higher than 120°F (49°C) may cause fabric to shrink excessively. May be conditioned and tunnel finished at up to 230°F (110°C) fabric temperature. In home laundering, use the Permanent Press settings on the washer and dryer. See www.bulwark.com for more information.

GARMENT COST

Garments made from blends of Modacrylic and cotton cost about the same as comparable garments made from durable FR 100% cotton.

GARMENT LIFE

Garment life under normal wear conditions is about 1 1/2 times that of durable FR 100% cotton.

WOOL AND RAYON BLENDS ALUMINUM INDUSTRY PROTECTIVE FABRICS

Several fabrics are available for use by the molten metals industry in general and the aluminum smelting and casting industry in particular. These fabrics are primarily blends of wool and rayon or Lenzing FR® and include PR-97® from Melba Industries and TenCate OASIS™ from TenCate™ Southern Mills™. These fabrics are designed to shed both molten aluminum and cryolite or “bath” (Na₃AlF₆), a catalyst used in smelters to extract aluminum metal from ore. These fabrics are available in both shirt and pant weights.

Bulwark® Protective Apparel markets TenCate™ Southern Mills™ TenCate OASIS™ under the category Molten Metal Protection.

APPLICATIONS

The molten metals industries, including red metals and aluminum smelting and casting.

NOT RECOMMENDED FOR

Use in critical static control applications.

FLAME RESISTANCE

Lenzing FR® and other FR rayon products are treated in the fiber forming process and laundering cannot degrade this property. The wool portion of the blend may or may not be FR treated. See information provided by the fabric or garment manufacturer.

COLORS

Dyeable in a wide range of colors.

EFFECT OF ACIDS AND ALKALIS

Wool is resistant to attack by acids, but is extremely vulnerable to attack by weak alkalis, even at low dilutions.

EFFECT OF BLEACHES AND SOLVENTS

Wool is irreversibly damaged by dilute oxidizing bleaches such as hypochlorite. Reducing agents cause wool to dissolve. Wool is generally very resistant to solvents except those capable of breaking the disulfide crosslinks in the fiber.

EFFECT OF MILDEW, AGING, SUNLIGHT AND ABRASION

Wool is attacked by short ultraviolet wavelengths in sunlight. Resistance to abrasion is fair to good, but resistance to mildew is poor.

THERMAL STABILITY

Wool burns very slowly even in contact with a flame. FR treatment can enhance this characteristic. Rayon has good resistance to dry heat and is a natural insulator.

MOISTURE REGAIN/STATIC CONTROL

Moisture regain of wool is high – 13 to 18% under standard conditions. Due to its affinity for water, wool does not build up significant static charges. Since static control depends on ambient relative humidity, without the proper wearer grounding the fabric should not be considered for applications where critical static control is required. **It is especially important that these garments not be donned or removed in a hazardous area.**

PROCESSING

Flame-resistant apparel should be washed using soft water (<1.5 grains (25 ppm)). Hard water can affect cleaning and contains mineral salts that can form insoluble deposits on the fabric. These deposits can negate the flame-resistant characteristics of the garment, and may serve as fuel if garments are exposed to an ignition source.

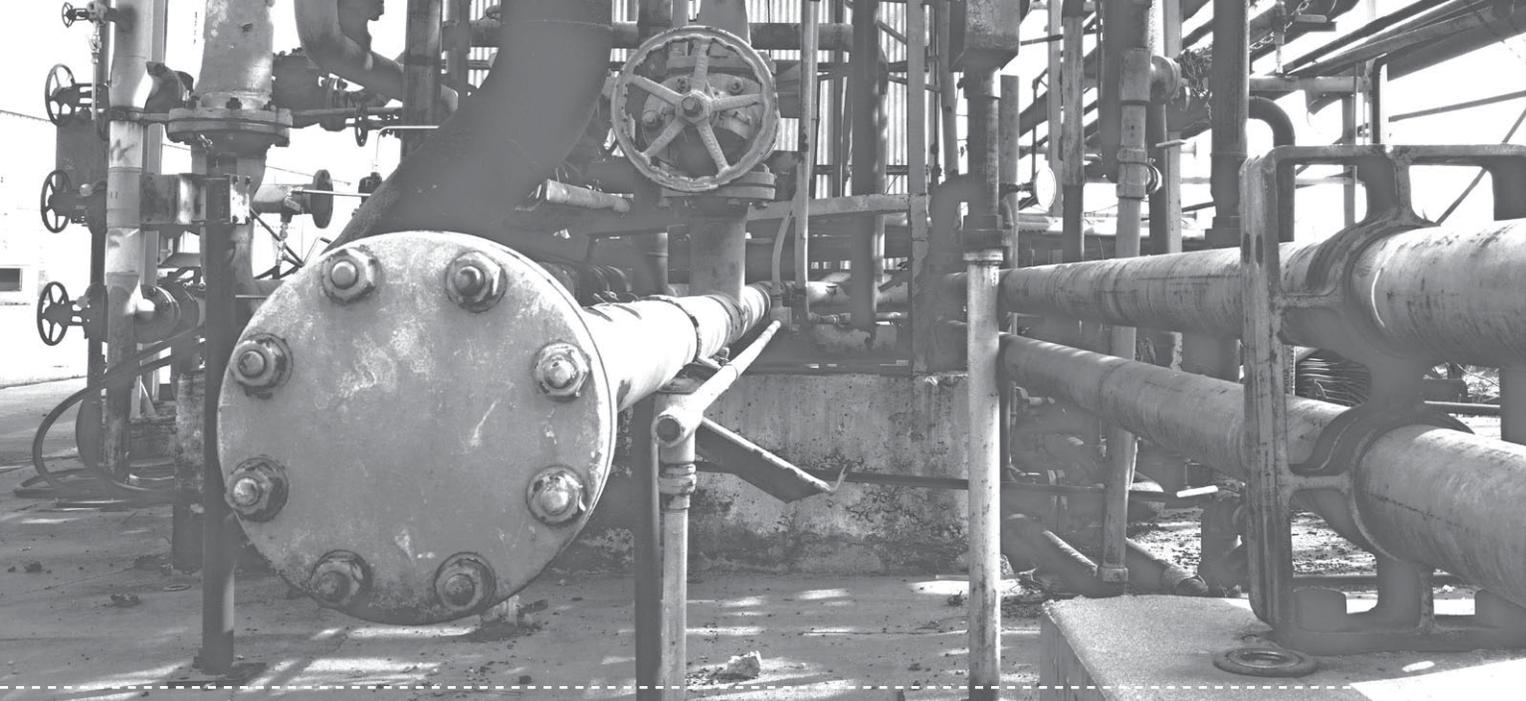
Follow garment manufacturer's recommendations. Molten splash protective wool and rayon blend garments should be washed separately in buffered surfactant chemistry detergents at a maximum temperature of 120°F (49°C). **Neither chlorine bleach nor perborate may be used because they will destroy the wool fiber.** Maximum dryer temperature must not exceed 150°F (65.5°C) and garments must be removed from the dryer with 35% moisture content or excessive shrinkage will result. Fabrics may be pressed at a low temperature for wool. For home laundering use the delicate or gentle cycle and rinse in cold water. Use the minimum temperature setting available and remove clothes when still damp to minimize shrinkage. Press with hand iron on wool setting. See Bulwark® Care & Cleaning Information Bulletin RK-80 or www.bulwark.com for more information.

GARMENT COST

Garments made of wool and rayon blend fabrics cost about 10% more than garments made from 6.0 oz NOMEX®.

GARMENT LIFE

Under normal wear conditions, garment life is expected to fall between FR cotton and 65% polyester/35% cotton, or between 2 and 3 years.



BLENDINGS OF TREATED AND INHERENTLY FR FIBERS

Fabrics that are made from a mixture of inherently flame-resistant fibers, such as NOMEX®, with fibers that are treated in the fiber-forming process, such as Lenzing FR®. These fabrics become flame-resistant for the life of the garment because the flame retardant cannot be removed by wear or laundering.

NOMEX®/FR RAYON BLENDS

NOMEX® has been blended with Lenzing FR® which produces a durable fabric with higher moisture regain than 100% aramid. These blends include Comfort Blend, a 65/35 blend of Nomex and Lenzing FR, and Comfort MP, a 50/40/10 blend of Nomex, Lenzing FR and Tencel. Both Comfort Blend and Comfort MP are manufactured by Tencate™.

APPLICATIONS

Petrochemicals, utilities, and for fire fighter station wear.

NOT RECOMMENDED FOR

Use around molten substances or welding operations, or in critical static control applications.

FLAME RESISTANCE

Fabrics made from blends of NOMEX®/FR Rayon are mixtures of inherently flame-resistant aramid fibers with permanently FR treated Lenzing FR® which means that this property cannot be removed by wear or laundering.

COLORS

The aramid fiber may be solution dyed, which means the fiber is dyed in the fiber forming process, or piece dyed, depending on the color. Similarly, the Lenzing FR® fiber may be piece dyed, or undyed, depending on the color.

EFFECT OF ACIDS AND ALKALIS

The aramid fiber is unaffected by most acids, and has generally good resistance to alkalis. The chemical resistance of the viscose portion of the blend is similar to cotton in that it is destroyed by strong acids.

EFFECT OF BLEACHES AND SOLVENTS

These garments are unaffected by most bleaches and solvents. However, the fabric does not provide personal chemical protection to the wearer. Where chemical exposure is a hazard, appropriate specialized barrier garments should be selected.

EFFECT OF MILDEW, AGING, SUNLIGHT AND ABRASION

The aramid portion of the blend has excellent resistance to mildew, aging, and abrasion. Natural aramid fiber will yellow with exposure to sunlight.

Lenzing FR® has good resistance to sunlight and aging, fair resistance to abrasion, and poor resistance to mildew.

THERMAL STABILITY

Aramid fiber has good thermal stability and does not melt. Lenzing FR® has good resistance to dry heat and is a natural insulator. Fabrics made from blends of NOMEX®/ FR Rayon are inappropriate and not recommended for use around molten substances or welding operations.

MOISTURE REGAIN/STATIC CONTROL

The high ambient moisture regain properties of Lenzing FR® exceed that of cotton. Except in very low relative humidity, these garments should have little static propensity. However, without proper wearer grounding they should not be considered for use in critical static control applications. **It is especially important that these garments not be donned or removed in a hazardous area.**

PROCESSING

Flame-resistant apparel should be washed using soft water (<1.5 grains (25 ppm)). Hard water can affect cleaning and contains mineral salts that can form insoluble deposits on the fabric. These deposits can negate the flame-resistant characteristics of the garment, and may serve as fuel if garments are exposed to an ignition source.

Garments made from blends of NOMEX®/FR Rayon fabric should be washed separately in low alkalinity, surfactant based detergents at 140°F (60°C) maximum. pH values in laundering should not exceed 10.0. Color loss, excessive shrinkage, and reduced garment life may result from repeated exposure to excessive temperature and pH in laundering.

These garments should be dried at 140°F (60°C) to 160°F (71°C) maximum stack temperature so that the temperature in the dryer basket does not exceed 280°F (138°C). Exceeding these temperatures will accelerate color loss. **DO NOT USE CHLORINE BLEACH.** These garments can be dry cleaned in perchloroethylene solvent. Garments may be pressed or tunnel finished if desired. Garment temperature should not exceed 280°F (138°C). See Bulwark® Care & Cleaning Information Bulletin RK-63 or www.bulwark.com for more information.

GARMENT COST

Garments made from blends of NOMEX®/FR Rayon cost about 10% less than NOMEX®/III A and 2 times as much as durable FR 100% cotton.

GARMENT LIFE

Under normal wear conditions, garment life should be about 80% to 90% that of NOMEX® and 2-3 times the life of durable FR 100% cotton.



INHERENTLY FR FIBERS/FABRICS

Fabrics made from synthetic fibers whose flame resistance is an essential characteristic of the fiber chemistry, such as NOMEX®. The flame-resistant property of these fabrics cannot be removed by wear or laundering.

- 49 COOL TOUCH® 2
- 50 KERMEL®
- 51 NOMEX®
- 52 PBI Gold®
- 53 Modacrylic/Aramid Blend Fabrics
- 54 Carbon/Oxidized Pan Fiber Fabrics
- 55 Quilted Lining Systems
- 56 Rainwear

COOL TOUCH® 2

COOL TOUCH® 2 garments are made from Tecasafe™ Plus fabric manufactured by TenCate™. COOL TOUCH® 2 is available in two blends: 48% modacrylic/ 37% lyocell/ 15% para-aramid and 45% modacrylic/ 35% lyocell/ 15% polyamide imide/ 5% para-aramid. The fabric is durable with higher moisture regain than 100% Aramid fabrics and is designed to achieve NFPA 70E CAT 2 and NFPA 2112 compliance.

Bulwark® Protective Apparel markets TenCate Tecasafe™ Plus fabric under the brand name "COOL TOUCH® 2".

APPLICATIONS

Petrochemicals, electrical workers, and for fire fighter station wear.

NOT RECOMMENDED FOR

Use around molten substances or welding operations or in critical static control applications.

FLAME RESISTANCE

COOL TOUCH® 2 garments are made from Tecasafe™ Plus fabric which is a blend of fibers that are inherently flame-resistant which means that this property cannot be removed by wear or laundering. The Lyocell fiber is not treated for flame resistance, but derives its self-extinguishing characteristic from the presence of the other fibers.

COLORS

Dyeable in a range of colors with good colorfastness.

EFFECT OF ACIDS AND ALKALIS

The fabric is resistant to alkalis and most solvents, but does not provide personal chemical protection to the wearer. Where chemical exposure is a hazard, appropriate specialized barrier garments should be selected.

EFFECT OF BLEACHES AND SOLVENTS

Flame-resistant properties of COOL TOUCH® 2 garments are unaffected by most bleaches and solvents. Laundering with chlorine bleach is not recommended. This will weaken the fabric and accelerate color loss. Use of oxygen bleach is acceptable where necessary.

EFFECT OF MILDEW, AGING, SUNLIGHT AND ABRASION

The fabric has excellent resistance to mildew, aging, and abrasion. Colorfastness to sunlight is superior to aramid fabrics.

THERMAL STABILITY

COOL TOUCH® 2 garments are made of Tecasafe™ Plus fabric which has excellent thermal stability and does not melt. COOL TOUCH® 2 garments are inappropriate and not recommended for use around molten substances or welding operations.

MOISTURE REGAIN/STATIC CONTROL

The high ambient moisture regain properties of Lyocell exceed that of cotton. Except in very low relative humidity, COOL TOUCH® 2 garments should have little static propensity. However, they should not be considered for use in critical static control applications without proper wearer grounding. **It is especially important that COOL TOUCH® 2 garments not be donned or removed in a hazardous area.**

PROCESSING

Flame-resistant apparel should be washed using soft water (<1.5 grains (25 ppm)). Hard water can affect cleaning and contains mineral salts that can form insoluble deposits on the fabric. These deposits can negate the flame-resistant characteristics of the garment, and may serve as fuel if garments are exposed to an ignition source.

For good colorfastness, COOL TOUCH® 2 garments should be washed separately in low alkalinity, surfactant based detergent at laundry temperatures up to 140°F (60°C). Processing in hotter formulas may be required to remove soils but could affect color and shrinkage.

COOL TOUCH® 2 garments should be dried at 140°-160°F (60°-71°C) maximum stack temperature so that the temperature in the dryer basket does not exceed 280°F (138°C). Exceeding these temperatures will accelerate color loss. In home laundering, use the permanent press setting on the washer and dryer. Remove promptly from the dryer.

DO NOT USE CHLORINE BLEACH. COOL TOUCH® 2 garments can be dry cleaned in perchloroethylene solvent. Garments may be pressed or tunnel finished if desired. Garment temperature should not exceed 280°F (138°C). See Bulwark® Care & Cleaning Information Bulletin RK-81 or www.bulwark.com for more information.

GARMENT COST

COOL TOUCH® 2 garments of Tecasafe™ Plus fabric cost about 30% less than 6.0 oz NOMEX®IIIA and 1 ½ times as much as durable FR 100% cotton.

GARMENT LIFE

Under normal wear conditions, garment life should be comparable to NOMEX® and 3-5 times the life of durable FR 100% cotton.

KERMEL® SYNTHETIC POLYAMIDE IMIDE ARAMID FIBER

KERMEL® is a synthetic polyamide imide aramid fiber manufactured in France by Kermel. KERMEL® fiber is only offered in fabrics blended with other fibers. KERMEL® is blended with wool for dress uniforms, sweaters and underwear, and with high tenacity aramid for bunker gear and gloves. In the professional fire fighter and work wear areas, KERMEL® is offered in both knit and woven constructions in a 50/50 blend with FR viscose rayon.

For the purposes of this review, KERMEL® will refer to the 50/50 blend with FR rayon.

APPLICATIONS

Petrochemical, utilities and professional fire fighters.

NOT RECOMMENDED FOR

Use around any molten substances or welding operations, or in critical static control operations.

FLAME RESISTANCE

KERMEL® is inherently flame-resistant and this property cannot be degraded by laundering.

COLORS

The fiber is solution dyed, which means it is dyed in the fiber forming process. This limits the color selection, but provides improved colorfastness.

EFFECT OF ACIDS AND ALKALIS

KERMEL® is highly resistant to most acids and to low concentrations of cold alkali.

EFFECT OF BLEACHES AND SOLVENTS

KERMEL® is resistant to most solvents (except phenols and solvents that are very polar), and chlorine bleach. KERMEL® fabric resists alkalis, bleaches, and solvents, but is subject to damage by acids. **KERMEL® must not be laundered with chlorine bleach.**

The fabric is available with a water repellent finish to help protect against chemical splashes and help provide acid resistance for the FR rayon. However, the fabric does not provide personal chemical protection to the

wearer. Where chemical exposure is a hazard, appropriate specialized barrier garments should be selected.

EFFECT OF MILDEW, AGING, SUNLIGHT AND ABRASION

KERMEL® has excellent resistance to mildew, aging, sunlight and abrasion.

THERMAL STABILITY

KERMEL® has excellent thermal stability and does not melt. KERMEL® blended with FR rayon is not recommended for use around any molten substances or welding operations. KERMEL® will stick to hot molten contact and form holes. Blends of KERMEL® and wool are recommended for use near molten processes.

MOISTURE REGAIN/STATIC CONTROL

Moisture regain is comparable to cotton and has a soft hand. Except in low relative humidity, KERMEL® would have little static propensity. However, without proper wearer grounding it should not be considered for use in critical static control applications. **It is especially important that garments containing KERMEL® fibers not be donned or removed in a hazardous area.**

PROCESSING

Flame-resistant apparel should be washed using soft water (<1.5 grains (25 ppm)). Hard water can affect cleaning and contains mineral salts that can form insoluble deposits on the fabric. These deposits can negate the flame-resistant characteristics of the garment, and may serve as fuel if garments are exposed to an ignition source.

KERMEL® garments should be washed separately in low alkaline, surfactant based detergents at 140°F (60°C), maximum. They should be dried at 140°F (60°C) stack temperature so that fabric temperature measured in the basket does not exceed 280°F (138°C). Exceeding these recommendations can result in significant shrinkage and/or loss of physical properties and durability. **KERMEL® must not be laundered with chlorine bleach.**

GARMENT COST

Garments of KERMEL® cost about 6 times more than conventional 65% polyester/35% cotton, and about 2 ½ times more than durable FR 100% cotton. Prices are equal to, or slightly more than, 6.0 oz NOMEX®.

GARMENT LIFE

Under normal wear conditions, garment life should be equal to conventional 65% polyester/35% cotton garments or about ½ that of NOMEX®.

NOMEX®

NOMEX® is a meta aramid fiber manufactured by DuPont. For clothing applications, it is offered as NOMEX® IIIA, a blend of 93% NOMEX®, 5% KEVLAR®, and 2% static dissipative fiber.

APPLICATIONS

Petrochemicals, utilities, military applications, auto racing, volunteer and professional fire fighters.

NOT RECOMMENDED FOR

Use around any molten substances, welding operations, or in a critical static control application.

FLAME RESISTANCE

NOMEX® is inherently flame-resistant and this property cannot be degraded by laundering.

COLORS

NOMEX® is dyeable in a wide range of colors. Colorfastness to laundering varies depending on the shade. The fiber is also available in a solution dyed form where it is dyed in the fiber forming process. This limits color selection, but provides improved color fastness at increased cost.

EFFECT OF ACIDS AND ALKALIS

NOMEX® is unaffected by most acids, except for some strength loss after long exposure to hydrochloric, nitric, and sulfuric acid. It has generally good resistance to alkalis.

EFFECT OF BLEACHES AND SOLVENTS

The fiber is unaffected by most bleaches and solvents, except for slight strength loss from exposure to sodium hypochlorite bleach. However, the fabric does not provide personal chemical protection to the wearer. Where chemical exposure is a hazard, appropriate specialized barrier garments should be selected.

EFFECT OF MILDEW, AGING, SUNLIGHT AND ABRASION

NOMEX® has excellent resistance to mildew, aging and abrasion. Natural (undyed) NOMEX® fiber is not white and will yellow with exposure

to sunlight. Accordingly, some lighter dyed shades will discolor rapidly. These lighter shades are available in solution dyed form.

THERMAL STABILITY

NOMEX® has good thermal stability and does not melt. The fiber decomposes between 700°-800°F (371°-427°C). NOMEX® is not recommended for use around any molten substances or welding operations. Hot molten contact will stick to the fiber, forming holes.

MOISTURE REGAIN/STATIC CONTROL

Moisture regain is moderate compared to other synthetic flame-resistant fibers, but only about 70% of cotton.

Because of the presence of static dissipative fiber, antistatic performance of NOMEX® IIIA is not dependent on ambient relative humidity. It is important to recognize that NOMEX® IIIA is designed to combat nuisance static only and, like 100% cotton, without proper wearer grounding it should not be considered for use in critical static control applications. **It is especially important that NOMEX® garments not be donned or removed in a hazardous area.**

PROCESSING

Flame-resistant apparel should be washed using soft water (<1.5 grains (25 ppm)). Hard water can affect cleaning and contains mineral salts that can form insoluble deposits on the fabric. These deposits can negate the flame-resistant characteristics of the garment, and may serve as fuel if garments are exposed to an ignition source.

For best color retention, laundry processing should be carried out at 140°F (60°C) or less in buffered, nonionic detergents. However, higher temperature/harsher detergent laundering will only affect the color, not the FR performance of the fabric. NOMEX® garments may be dry cleaned in either perchloroethylene or petroleum solvents. They may be conditioned or tunnel finished at up to 280°F (138°C) fabric temperature. See Bulwark® Care and Cleaning Information Bulletin RK-63 or www.bulwark.com for more information.

GARMENT COST

Garments of NOMEX® IIIA cost about five times as much as garments made from conventional 65% polyester/35% fabrics, and about 2 times more than garments made from durable FR 100% cotton fabrics.

GARMENT LIFE

Under normal wear conditions, NOMEX® garments can last as long as 3-5 years, or 2-3 times the life of conventional 65% polyester/35% cotton, and 3-5 times the life of durable FR 100% cotton.

Garments made of NOMEX® IIIA are extremely durable and can be expected to perform well for many years in applications where longevity can be utilized.

PBI

PBI is a synthetic polybenzimidazole fiber made by PBI Performance Products Inc., which may be used alone or in blends. PBI Gold® is a 60% KEVLAR® Aramid/40% PBI blend fabric offered by TenCate™ Southern Mills™ for career apparel applications. PBI TriGuard™ is a blend of 20% PBI, 30% LENZING FR® and 50% Micro Twaron®.

Although there has been some market interest in PBI TriGuard™, this review will focus on PBI Gold®.

APPLICATIONS

PBI Gold® is used in turnout gear for professional fire fighters and other career apparel.

NOT RECOMMENDED FOR

Critical static control applications.

FLAME RESISTANCE

PBI Gold® is inherently flame-resistant and this property cannot be degraded by laundering.

COLORS

PBI Gold® is gold in color. It is dyeable in dark shades only.

EFFECT OF ACIDS AND ALKALIS

PBI fiber has excellent resistance to most acids and alkalis.

EFFECT OF BLEACHES AND SOLVENTS

PBI has excellent resistance to solvents. PBI Gold® loses strength when exposed to chlorine bleach. PBI Gold® does not provide personal chemical protection to the wearer. Where chemical exposure is a hazard, appropriate specialized barrier garments should be selected.

EFFECT OF MILDEW, AGING, SUNLIGHT AND ABRASION

PBI has good resistance to mildew and aging. Prolonged exposure to sunlight will cause darkening and loss of tensile strength. PBI fiber

has fair abrasion resistance, but the PBI Gold® blend has very good abrasion resistance.

THERMAL STABILITY

PBI Gold® will not ignite and does not melt. PBI has excellent thermal stability and retains fiber integrity and suppleness after flame exposure. Molten substance contact with PBI Gold® will cause pinholing in the fabric.

MOISTURE REGAIN/STATIC CONTROL

Moisture regain of PBI fiber is excellent and actually exceeds that of cotton and rayon. Average stiffness is very low, yielding a good hand and drape. PBI is by far the most natural feeling synthetic fabric. Without proper wearer grounding, PBI Gold® should not be considered for use in critical static control applications. **It is especially important that garments containing PBI® fibers not be donned or removed in a hazardous area.**

PROCESSING

Flame-resistant apparel should be washed using soft water (<1.5 grains (25 ppm)). Hard water can affect cleaning and contains mineral salts that can form insoluble deposits on the fabric. These deposits can negate the flame-resistant characteristics of the garment, and may serve as fuel if garments are exposed to an ignition source.

Garments made from PBI Gold® fabric should be washed separately in low alkaline, surfactant based detergents at 140°F (60°C), maximum. Wash pH should be 10.0 or lower. Chlorine bleach weakens the fabric. Do not over dry. Fabric temperature in the dryer basket should not exceed 210°F (99°C). Exceeding these recommendations can result in significant garment shrinkage. Garments of PBI Gold® can be tunnel finished, but fabric temperatures should not exceed 210°F (99°C). See Bulwark® Care & Cleaning Information Bulletin RK-73 or www.bulwark.com for more information.

GARMENT COST

Garments made from PBI Gold® fabrics cost about 2 times more than NOMEX® and about 3-4 times as much as durable FR 100% cotton.

GARMENT LIFE

Under normal wear conditions, PBI Gold® garments can be expected to last about ½ to ¾ as long as comparable weights of NOMEX® and 1 ½ times as long as durable FR 100% cotton garments.

MODACRYLIC/ARAMID BLEND FABRICS

Protera™ is a DuPont trademark for garments made from 65% Modacrylic/23% Nomex®/10% Kevlar®/2% static dissipative fiber. Available in both shirt and pant weights, these fabrics are durable and designed to achieve NFPA® 70E CAT 2 and NFPA® 2112 compliance.

APPLICATIONS

Petrochemicals, electrical workers, and for fire fighter station wear.

NOT RECOMMENDED FOR

Use around molten substances or welding operations or in critical static control applications.

FLAME RESISTANCE

Protera™ garments are made from a blend of fibers that are inherently flame-resistant which means that this property cannot be removed by wear or laundering.

COLORS

Dyeable in a range of colors with good colorfastness.

EFFECT OF ACIDS AND ALKALIS

The fabric is resistant to alkalis and most solvents, but does not provide personal chemical protection to the wearer. Where chemical exposure is a hazard, appropriate specialized barrier garments should be selected.

EFFECT OF BLEACHES AND SOLVENTS

Flame-resistant properties of Protera™ garments are unaffected by most bleaches and solvents. Laundering with chlorine bleach is not recommended. This will weaken the fabric and accelerate color loss.

EFFECT OF MILDEW, AGING, SUNLIGHT AND ABRASION

The fabric has excellent resistance to mildew, aging, and abrasion and fair resistance to sunlight. Garments are not to be line dried or stored in sunlight.

THERMAL STABILITY

Protera™ fabric has good thermal stability and does not melt. Protera™ is inappropriate and not recommended for use around molten substances or welding operations.

MOISTURE REGAIN/STATIC CONTROL

Moisture regain is moderate and comparable to other synthetic flame-resistant fibers, but less than cotton. Because of the presence of static dissipative fiber, anti-static performance of Protera™ is not dependent on ambient relative humidity. It is important to recognize that Protera™ is designed to combat nuisance static only and without proper wearer grounding should not be considered for use in critical static control applications. **It is especially important that Protera™ garments not be donned or removed in a hazardous area.**

PROCESSING

Flame-resistant apparel should be washed using soft water (<1.5 grains (25 ppm)). Hard water can affect cleaning and contains mineral salts that can form insoluble deposits on the fabric. These deposits can negate the flame-resistant characteristics of the garment, and may serve as fuel if garments are exposed to an ignition source.

For best color retention, Protera™ garments should be washed before wearing and separately by color after each subsequent wearing in low alkalinity, surfactant based detergent at laundry temperatures up to 140°F (60°C). Processing in hotter formulas may be required to remove soils but could affect color and shrinkage. The FR properties of the garments are not affected by hotter formulas. Avoid use of chlorine bleach.

Protera™ garments should be dried at 140°-160°F (60°-71°C) maximum stack temperature so that the temperature in the dryer basket does not exceed 280°F (138°C). Exceeding these temperatures will accelerate color loss. In home laundering, use the permanent press setting on the washer and dryer. Remove promptly from the dryer. Do not line dry or store in sunlight.

Protera™ garments can be dry cleaned in perchloroethylene solvent. Garments may be pressed or tunnel finished if desired. Garment temperature should not exceed 280°F (138°C).

GARMENT COST

Protera™ garments cost about 20% less than 6.0 oz NOMEX®IIIA and 2 times as much as durable FR 100% cotton.

GARMENT LIFE

Under normal wear conditions, garment life should be comparable to NOMEX® and 2-3 times the life of durable FR 100% cotton.

CARBON/OXIDIZED PAN FIBER FABRICS

Polyacrylonitrile (PAN) is an oxidized, thermally stabilized black fiber that will not burn, melt, soften or drip. Because it has a high LOI (Limiting Oxygen Index) value, PAN is used for heat resistant, thermal and acoustic insulation and technical textiles. PAN is usually blended with at least one additional fiber such as para-aramid in order to provide increased tensile strength and abrasion resistance. Fabrics may also be intimate or discrete blends containing modacrylic, FR rayon, nylon or other fibers.

Companies including CarbonX (Chapman Innovations), TECGEN (Invista) and Spentex (GSL Inc.) offer fabric and/or garments in knit, woven and nonwoven constructions made from Carbon/Oxidized PAN blended fiber fabrics.

APPLICATIONS

Typical applications are fire blocking fabrics for seating in aircraft, trains, buses and cars, or reinforcements for fire fighters turnout gear, race car drivers and workers in the molten metals, electric utility and petrochemical industries.

NOT RECOMMENDED FOR

Use in critical static control applications.

FLAME RESISTANCE

Carbon/Oxidized PAN fiber fabrics are generally blends of inherently flame-resistant fibers; this property cannot be degraded by wear or laundering.

COLORS

May be available in a various colors, but the black oxidized PAN fiber limits color selection.

EFFECT OF ACIDS AND ALKALIS

Carbon/Oxidized PAN fiber fabrics are fairly inert except for weakness to highly concentrated acids and strong bases.

EFFECT OF BLEACHES AND SOLVENTS

Excellent resistance to organic solvents. Poor resistance to oxidizing agents and bleaches.

EFFECT OF MILDEW, AGING, SUNLIGHT AND ABRASION

Depending on the fiber surface treatment Carbon/Oxidized PAN fiber fabrics can have excellent resistance to mildew, aging, sun exposure and abrasion.

THERMAL STABILITY

Carbon/Oxidized PAN fiber fabrics have excellent thermal stability and will not burn, melt, soften or drip. They are often used in molten metal exposures as the outer primary protection garment and as gloves, sleeves and gauntlets for specific applications.

MOISTURE REGAIN/STATIC CONTROL

Depending on the fibers used for blending, moisture regain and stiffness/hand of blended Carbon/Oxidized PAN fiber fabrics can be excellent yielding a good hand and drape. Carbon/PAN fibers are very conductive; however, without proper wearer grounding, the blended fabric should not be considered for use in critical static control applications.

It is especially important that these FR garments not be donned or removed in a hazardous area.

PROCESSING

Garments made from Carbon/Oxidized PAN fiber fabrics should be washed using soft water (<1.5 grains (25 ppm)). Hard water can affect cleaning and contains mineral salts that can form insoluble deposits on the fabric. These deposits can negate the flame-resistant characteristics of the garment and may serve as fuel if garments are exposed to an ignition source.

Always follow the individual garments manufacturers' laundry recommendations, but generally garments made from Carbon/Oxidized PAN fiber may be home laundered in warm or hot water and dried on a medium/permanent press setting. The fabric dries quickly so some adjustment in drying time may be required.

GARMENT COST

Garments made from Carbon/Oxidized PAN fiber fabrics cost from 20 - 60% more than equivalent weights of NOMEX®.

GARMENT LIFE

Under normal wear conditions, garment life is expected to be 12-18 months, or roughly equivalent to the wear life of 100% FR Cotton garments of equivalent fabric weight.

QUILTED LINING SYSTEMS

Quilted garment linings must provide varying levels of protection from the climate, be compatible with the outer shell fabric and serve as part of the flame-resistant protection package in case of garment ignition – all while helping control the overall cost of the finished garment. The components of the quilted lining package must also work together. For example, the face cloth must prevent fiber migration and shifting of the insulation, while being durable to extended laundering.

Quilted linings may be constructed of flame-resistant treated fabrics, inherently flame-resistant fabrics or a combination of both. However, for maximum protection, both the face cloth and batt layers of the assembly should be flame resistant. The use of non-FR materials, such as polyester fiberfill, may contribute to wearer injury in case the flame-resistant body fabric breaks open following a flame or thermal exposure.

FABRIC NAME (MANUFACTURER)	DESCRIPTION (WEIGHTS)	COMPONENTS	
Q/9* (TenCate™ Southern Mills)	Composite quilted liner (9.3 oz.)	Backing Face Stitching	100% aramid needled 6.0 batt 3.3 oz. Plain Weave face Aramid Thread / “Chicken Wire” Pattern
Q/15WB* (TenCate™ Southern Mills)	Composite quilted liner (14.2 oz.) Wind barrier protection	Backing Face Stitching	100% Aramid needled batt 3.3 oz. Plain Weave and Light (0.5 oz.) PE/ PET scrim Aramid Thread / “Big Onion” Pattern
THERMATEX® 6B (TenCate™ Southern Mills)	Composite quilted liner (10.1 oz.)	Backing FaceStitching	6.0 oz. lofted batt of loose virgin Aramid fiber 3.2 oz. (Plain Weave or Rip-Stop) and two layers of lightweight Reemay® scrim Aramid Thread / Diamond Pattern
THERMATEX® 6B/VAPRO® (TenCate™ Southern Mills)	Composite quilted liner (12.4 oz.) Wind/ rain protection and breathability	Backing FaceStitching	6.0 oz. lofted batt of loose virgin Aramid fiber Micro-porous FR membrane laminated to batt 3.2 oz. (Plain Weave or Rip-Stop) and two layers of lightweight Reemay® scrim Aramid Thread / Diamond Pattern
THERMATEX® 9B/VAPRO® (TenCate™ Southern Mills)	Composite quilted liner (13.4 oz.) Wind/ rain protection and breathability	Backing FaceStitching	9.0 oz. lofted batt of loose virgin Aramid fiber Micro-porous FR membrane laminated to batt 3.2 oz. (Plain Weave or Rip-Stop) and two layers of lightweight Reemay® scrim Aramid Thread / Diamond Pattern
MODA-QUILT® (MidWest Quilting)	Composite quilted liner (10.25 oz. and 13.50 oz.)	Backing Face Stitching	Fiber fill of inherently flame-resistant Modacrylic fiber Plain Weave FR cotton Aramid Thread/Diamond Pattern
FLAME-QUILT® (Westex by Milliken)	Composite non-woven quilted FR thermal barrier liner (10.75 oz.)	Backing Face Stitching	Fiber fill of 50% BASOFIL® and 50% FR Rayon Plain Weave FR cotton Aramid Thread/Diamond Pattern

RAINWEAR

FR rainwear is designed to provide protection from wind and rain for personnel who must work outdoors in all types of weather conditions. It must also provide protection from other hazards existing in the workplace such as flame exposures, electric arcs or flash fires. In addition, most rainwear is expected to provide high visibility protection so that the worker may be seen under adverse conditions of limited visibility compounded by weather.

Arc-rated rainwear is tested and labeled to ASTM F1891, *Standard Specification for Arc and Flame-Resistant Rainwear*. Rainwear for protection from **flash fire** is tested and labeled to F2733, *Standard Specification for Flame-Resistant Rainwear for Protection against Flame Hazards*. Most rainwear that meets the requirements of F2733 will also provide some protection against hot liquid splash hazards. ASTM F2701, *Test Method for Evaluating Heat Transfer through Materials for Protective Clothing upon Contact with a Hot Liquid Splash*, can be used to evaluate protection from this hazard. Certain rain suits are tested and rated to both arc and flash fire hazards.

Some rainwear labeled as “FR” may be made from meltable synthetic fabrics that will melt if exposed to an ignition source or thermal hazard. This type of rainwear may only be tested to a general wearing apparel standard or even a standard intended for upholstery and table linen. Rainwear tested and certified by its manufacturer to ASTM requirements must not melt, drip, or ignite when exposed to the thermal energy generated in a flash fire or electric arc.

Most arc-rated and/or flash fire-rated rainwear meets the high visibility requirements conforming to the American National Standards Institute ANSI/ISEA 107, *Standard for High-Visibility Safety Apparel and Headwear*. However, as with arc and flash fire protection, the end user must ensure that the rainwear is labeled as meeting the requirements of this standard.

Arc-rated and/or flash fire-rated rainwear is available in both breathable and non-breathable body fabrics; however, most generally available rain suits are made from non-breathable materials.

NON-BREATHABLE FABRICS

Are made by single or double coating an arc-rated and/or flash fire-rated with flame-resistant polychloroprene, PVC, or other waterproof, non-breathable substance. Please note that some products labeled as “FR” use a nylon substrate. This material is inferior to coated NOMEX® fabrics.

BREATHABLE FABRICS

Are made by laminating an arc-rated and/or flash fire-rated woven outer shell fabric to a waterproof breathable polyurethane or ePTFE membrane in a trilaminate system.

APPLICATIONS

Electric utilities, oil and gas operations, and other work activities where a risk of thermal exposure exists in a wide range of climatic conditions.

NOT RECOMMENDED FOR

Non-breathable rainwear with PVC waterproof coating should never be used for protection from a flash fire hazard. Always ensure your rainwear is labeled ASTM F2733 for protection against flash fire hazards.

Use around any molten substances, welding operations, or in critical static control applications.

FLAME RESISTANCE

The NOMEX® fabric used in both breathable and non-breathable rainwear is inherently flame-resistant and this property cannot be degraded by laundering. The waterproof coating on non-breathable rainwear is flame-resistant.

COLORS

Arc-rated and/or flash fire-rated rainwear is usually specified in bright yellow/green or orange to meet high visibility requirements. If the rainwear also meets the requirements of ANSI/ISEA Standard for High-Visibility Safety Apparel and Headwear it must also be labeled with a statement that the garment meets this standard.

EFFECTS OF ACIDS AND ALKALIS

Arc-rated and/or flash fire-rated rainwear is resistant to most acids and will provide wearers some low-level chemical splash protection. Please see manufacturer's product literature for specific recommendations. However, flame-resistant rainwear is primarily intended to protect from rain. Where major chemical exposure is a hazard, appropriate specialized barrier garments should be selected.

EFFECT OF BLEACHES AND SOLVENTS

Do not use chlorine bleach. Do not dry clean. Do not use fabric softener.

EFFECT OF MILDEW, AGING, SUNLIGHT AND ABRASION

Non-breathable rainwear has excellent resistance to mildew, aging, sunlight and abrasion.

THERMAL STABILITY

Fabrics used in arc-rated and/or flash fire-rated rainwear do not melt. They have extreme thermal stability. Molten substance contact with flame-resistant rainwear will cause burn through and pinholing.

MOISTURE REGAIN/STATIC CONTROL

Not applicable.

PROCESSING

Arc-rated and/or flash fire-rated rainwear should be wiped clean with a mild detergent/water solution and rinsed, or machine-washed, warm, using mild detergent. Hang to dry. Do not use solvents or abrasive cleaners. Do not dry clean.

GARMENT COST

Non-breathable rainwear will cost about 3 times more than a NOMEX® coverall.

GARMENT LIFE

Expected garment life under normal wear conditions should approach NOMEX® and be 3-5 times more than durable FR 100% cotton garments. However, abrasion from hard use under adverse conditions, such as climbing poles, could result in shorter service life.



IN CONCLUSION

The Bulwark® brand makes up the most comprehensive flame-resistant product line in the broadest range of proven thermal protective fabrics. While always leading in innovation, Bulwark® provides industry-leading technical support and advice to our customers.

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WHAT DEVELOPMENTS ARE ON THE HORIZON IN FR FABRICS AND GARMENTS?

New fibers and fabrics based on them are constantly being developed in response to changing needs of the market. The ultimate success of these developments will depend on market requirements as well as the cost effectiveness of the materials.

On 7 February 2008, a sugar refinery explosion, possibly caused by static electricity igniting fine sugar dust, killed 14 people and injured over 40. OSHA had been criticized in a 2006 US Chemical Safety Board report for lack of preparation for such explosions and a safety program which “inadequately addresses dust explosion hazards”. This has led to increased emphasis on prevention of combustible dust explosions and providing PPE for workers exposed to this hazard.

On March 19, 2010 OSHA issued an interpretation of the flash fire standard NFPA® 2112 as it related to policy for citing the general industry standard for PPE, 29 CFR 1910.132(a) for failure to provide and use FR clothing in oil and gas well drilling, servicing and production related operations. OSHA stated that use of FRC is inconsistent among operators and contractors in areas with clear potential for flash fires.

This interpretation has become known simply as the OSHA Memo. Combined with several drilling platform accidents that resulted in loss of life, and the Gulf of Mexico accident and spill, the result has been a renewed emphasis on NFPA® 2112 and market demand for garments compliant to this performance standard.

In the electric arc flash protection market, NFPA® 70E Hazard Risk Category 2 (4.0 – 25 cal/cm²) has become the most recognized requirement for industrial applications. OSHA has stepped up enforcement activities in the area of workplace electrical safety using 70E as evidence of hazard recognition in evaluating General Duty Clause violations under the OSHA Act. The newly revised Final Rule for Electric Power Generation, Transmission, and Distribution Maintenance and Construction (29 CFR 1910.269) requires that employers conduct an arc flash analysis and provide arc rated FR protective garments for workers exposed to the hazard of electric arcs and associated hazards

These developments have led to demands for multi-purpose or “dual hazard” PPE that has an

arc rating of CAT 2 and is compliant to NFPA® 2112. These garments are also expected to be lightweight and comfortable to wear by providing moisture absorption and wicking characteristics along with improved durability and appearance retention – at competitive prices.

HOW DOES BULWARK® FR APPAREL SATISFY THE SAFETY AND PERSONNEL NEEDS OF MY COMPANY?

Bulwark® garments are designed to (1) be comfortable, (2) fit well, (3) not shrink excessively, (4) not lose color when laundered, (5) retain their shape and surface appearance, and (6) reflect the image the specifier wishes to present, in terms of color and style. In other words, Bulwark® flame-resistant protective apparel must serve all of the expected functions of conventional wearing apparel, yet retain flame-resistant properties for the useful life of the garments.

WHAT FR FABRICS DOES BULWARK® USE FOR ITS FR WORK APPAREL?

Bulwark® markets the following flame-resistant protective garments:

EXCEL FR® Durable FR 100% Cotton

EXCEL FR® ComforTouch® Durable FR 88% Cotton / 12% Nylon

Particle and chemical resistant FR Disposable non woven garments

NOMEX® IIIA

COOL TOUCH® 2 45% modacrylic / 35% lyocell / 15% polyamide imide 5% para-aramid

COOL TOUCH® 2 48% modacrylic / 37% lyocell / 15% para-aramid

PBI Gold®

Tencate Oasis®

PVC/Kevlar®/NOMEX® rainwear

NOMEX® and modacrylic blend fleeces

WESTEX G2™ fabrics by Milliken®

Additional fabrics have been approved for use in Bulwark® garments and are available upon request as a make to order.

WHAT IS THE BEST WAY TO REPAIR FR GARMENTS?

Minor repairs that do not affect the integrity of the garment should be made with like materials by sewing on patches or darning small holes. To provide continued flame resistance, garments must be repaired with materials that have at least the same FR performance characteristics as the original fabric and sewing threads.

HOW IMPORTANT IS THE CLEANING OF FR GARMENTS?

Proper cleaning and maintenance of any flame-resistant garment is essential to remove potentially hazardous soils and avoid a build up of materials that could mask performance. This includes flammable soils as well as other contaminants such as build up of hard water ions that can coat fibers with flammable material. ASTM has two standard guides that provide good general references for care and cleaning of flame-resistant and thermal protective clothing; ASTM F1449, *Guide for Home Laundering, Care and Maintenance, of Flame, Thermal, and Arc Resistant Clothing* and ASTM F2757, *Guide for Industrial Laundering of Flame, Thermal and Arc Resistant Clothing*.

Always follow garment manufacturer's care label recommendations and other published instructions or recommendations.

CAN EMBLEMS AND EMBROIDERY BE ADDED TO FR GARMENTS?

The question of garment identification and personalization is always difficult to answer. The only comment of the consensus standards writing organizations, such as NFPA and ASTM International, is that nothing on an article of clothing may increase the extent of wearer injury in case of garment ignition. No OSHA or military standards address this area. SFI, the race car driver's association, has not addressed this issue.

Bulwark® does not recommend the use of non-flame-resistant embroidery or emblem attachment to flame-resistant garments. However, wearer identification is a safety issue in itself. In the final analysis, the end user must weigh the benefits of identification and personalization against the potential risk from using non-FR materials.

WHAT IF LOCAL CONDITIONS REQUIRE CLEANING PROCEDURES DIFFERENT FROM THE MANUFACTURER'S RECOMMENDATION?

To ensure continued flame-resistant performance, it is necessary to follow the manufacturer's recommendations for textile maintenance processing of each type of

flame-resistant garment. Whenever deviations from manufacturer's recommendations are necessitated by local conditions, testing must be conducted to ensure that the protective properties are maintained through the expected service life of the garment.

IS THERE ADDITIONAL INFORMATION ON LAUNDERING FR GARMENTS? IF SO, HOW CAN I GET IT?

Bulwark® provides care instructions on the garment label for all garments as required by the Federal Trade Commission (FTC). In order to provide a more consistent label format and ensure that all information required for maintaining flame resistance of the garment is provided, Bulwark® is currently in the process of revising its labels. You can access the latest information at our website, www.bulwark.com. Additional information can also be found in Bulwark® Care and Cleaning Information Bulletins that provide laundry instructions for our flame-resistant protective apparel. These bulletins are available on-line, or from VF Imagewear Technical Services at 545 Marriott Drive, Nashville, TN 37214.

IS STATIC ELECTRICITY A CONCERN FOR FR GARMENTS?

The generation of static electricity on clothing depends on a number of factors: the relative humidity, the fabrics involved, the use of grounding devices, and the task being performed. Synthetic fabrics such as polyester absorb less moisture and retain more static than natural fiber fabrics. Synthetic FR fabrics such as NOMEX® IIIA contain 2% static dissipative fiber to control nuisance static. Garments made from NOMEX® IIIA fiber do not require moisture in the atmosphere to conduct static electricity. However, these garments alone without other engineering controls will not address the hazards associated with static.

Natural fabrics made from cotton and synthetic cellulosic fibers like Lyocell® have little static build-up in high humidity conditions because the fiber absorbs water from the atmosphere. The water conducts and helps distribute the static charge. Cellulosic fiber fabrics are ineffective at dissipating static charges at low relative humidity (<20% RH).

Donning or removing garments can generate static charge through triboelectric generation by friction and cause charge separation between the layers of clothing. Testing of a Bulwark vest showed a 5X increase in static charge when the vest was removed.

In the final analysis, no garment alone will provide protection from hazardous static charges. A static control program,

of which the garments are only a part, is required for protection of personnel in hazardous environments.

WHAT IS THE “LIFE OF A BULWARK® GARMENT”?

Bulwark® guarantees that our reusable garments will retain their flame-resistant properties for the life of the garment as long as our recommended laundering guidelines are followed. The life of a Bulwark® garment is not defined by the age of the garment, the number of times it has been worn or the number of times it has been laundered.

A Bulwark® garment is removed from service for the same reasons as everyday clothing: it no longer fits comfortably; it is contaminated with a flammable substance that cannot be completely removed; there are stubborn, unsightly stains; it has become threadbare. Finally, if a garment has rips, tears or holes which cannot be repaired it must be removed from service.

» FAST FACTS

- » Flash fire emphasis from combustible dust and petro-chem markets based on garment certification to NFPA® 2112.
- » NFPA® 70E CAT 2 category dominates industrial applications.
- » Demand for dual-purpose garments with performance characteristics

Bulwark® garments are designed for continuous wear. They meet the flame resistance requirements specified in ASTM International Standard F 2302 for labeling protective clothing as heat and flame-resistant. They also meet the performance requirements of National Fire Protection Association (NFPA) Standard 70E, *Electrical Safety Requirements for Employee Workplaces*, 2012 Edition, ASTM Standard F1506, *Flame-Resistant Materials for Wearing Apparel for Use by Electrical Workers Exposed to Momentary Electric Arc and Related Thermal Hazards*. Because these fabrics are flame-resistant, they are acceptable under the Occupational Safety & Health Administration (OSHA) Final Rule 1910.269, *Final Rule on Electrical Protective Equipment*. For complete information on these products, as well as laundering instructions, please visit www.bulwark.com.

Bulwark®, a brand of  VF Imagewear, Inc.

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