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**GENERAL ORDERS ON
EXPLOSIVES**

Effective March 27, 1933

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Madison

CONTENTS

The orders marked with an asterisk (*) are existing orders relating to underground storage and use of explosives in mines, tunnels and caissons and were not considered by the Advisory Committee.

SECTION I

	Page
ORDER 650 Scope	10
651 Construction of Orders	10
652 Definitions	10
(a) Superintendent	10
(b) Foreman	10
(c) Explosives	10
(d) Magazine	11
(e) Primer	11
(f) Approved	11
(g) Efficient barricade	11
(h) Blaster	11
(i) Person	11
(j) Building	11
(k) Railroad	11
653 Storage of Explosives within Cities and Villages	11
(a) Sensitiveness to be limited	11
(b) Quantity and magazines	11
(c) Gunpowder	12
(d) Exception to amount stored	12
(e) Storage of blasting caps	12
(f) Chief of fire department to be notified	12
654 Storage Outside Corporate Limits of Cities and Villages	12
655 Storage With Other Materials	12
656 Location of Magazines	13
(a) Quantity and distance table	13
(b) Separation of one magazine from another	16
(c) Reduction of distances	16
657 Construction and Maintenance of Magazines	16
(a) Construction	17
(b) Danger signs	17
(c) Ventilation	17
(d) Cleanliness and dryness	17
(e) Magazine keeper	17
(f) Naked lights and smoking not permissible	17
(g) Opening containers	17

	Page
658 Storage, Daily Supply	17
659 Storage, Temporary Locations	18
660 Marking of Explosives	18
661 Explosives Unfit for Use	18
662 Transportation of Explosives	19
663 Certificates of Competency for Blasters.....	19
ORDER 664 Blasting Caps, Fuses and Primers	20
(a) Separate storage required	20
(b) Primers, use within 36 hours	20
(c) Preparation of primers	20
(d) Cap crimpers	20
(e) Caps and fuse unfit for use	20
665 Explosives, Blasting, Conveying, Misfires, etc.....	20
(a) Blasters	20
(b) Number of blasters, responsibility	20
(c) Conveying explosives	20
(d) Frozen dynamite	21
(e) Counting shots, misfires	21
(f) Misfires, treatment	21
(g) Firing by electricity	21
(h) Shot firing cables	21
(i) Examination after blast	22
(j) Tracing firing wires	22
(k) Galvanometers or circuit testers	22
(l) Fuse lengths, Table of Fuse Lengths.....	22
(m) Warning signals	23
(n) Protection from blasts, shelters	23
(o) Secondary blasting	24
(p) Tamping bars and punches	24
(q) Blasting within city and village limits.....	24

SECTION II

(From General Orders on Mines)

ORDER *310 Storage of Explosives	25
(a) Definition of magazine	25
(b) Quantity permitted underground	25
(c) Location of magazines	25
(d) Storage near working places	25
Underground magazines	25
(e) Distribution of explosives	25
*311 Blasting Caps and Fuse	26
(c) Storage, capping fuses, crimpers, transporta- tion, etc.	26
(d) Underground storage of fuse	26
(e) Opening containers	26

	Page
*313 Blasting	26
(a) Tamping rods, warning, etc.	26
(b) Counting shots	26
(c) Misfires—treatment of	27
(d) Firing by electricity	27
(e) Firing switches	27
ORDER *345 Rule 46 Transportation by locomotives	28
47 Placing near live wires	28
48 Removal from mine	28
49 Fuses, rate of burning	28

SECTION III

(From General Orders on Tunnels, Caisson and French
Construction)

ORDER *614 Explosives, Conveying, Thawing, Blasting, etc.....	29
(a) Blasters—experience	29
(b) Supervision by blasters	29
(c) Permissible explosives	29
(d) Quantity, transportation, storage	29
(e) Frozen dynamite	30
(f) Open lights in magazine	30
(g) Cap crimpers	30
(h) Transportation with other material.....	30
(i) Size of drill holes	30
(j) Counting shots, misfires	30
(k) Firing mis-shots	31
(l) Tamping rods	31
(m) Firing by electricity	31
(n) Disconnecting power wires	31
(o) Warning	31
(p) Examination of old holes	31
(q) Deepening old holes	31
(r) Tracing wires	31
(s) Approaching other workings	32
(t) Testing electric blasting caps	32
(u) Electrical blasting in shafts	32
(v) Firing switches	32

APPENDIX

Storage of Explosives	33
Specifications for storage magazines	33
Illustration of storage magazine	35
Illustration of portable magazine	36
Blasting Switch	37
Grounding Leading Wires, Portable Equipment	38
Use of Explosives	38

GENERAL ORDERS ON EXPLOSIVES

The existing general orders of the Industrial Commission pertaining to the transportation, storage and use of explosives have proven inadequate on account of the increased use of explosives in construction and particularly in highway construction. As a result of increased injuries by explosives and also owing to the fact that explosive regulations are not available in a single bulletin, the commission decided to revise its existing orders relating to this subject and to promulgate such new orders as were deemed necessary.

Following its usual practice in such matters, an advisory committee was appointed to make recommendations.

The personnel of this committee is as follows:

C. H. FISHER, Institute of Makers of Explosives,
Wilmington, Delaware.

W. J. MATHEWS, Institute of Makers of Explosives,
Chicago, Illinois.

JOHN MULLEN, Associated Contractors of Wisconsin,
Minneapolis, Minnesota.

F. S. CRAWFORD, United States Bureau of Mines,
Duluth, Minnesota.

E. L. ROETTIGER, Wisconsin Highway Commission,
Madison.

LAWRENCE PETERSON, Montreal Mining Company,
Montreal.

GEORGE CORMIER, Wisconsin Highway Commissioner's
Ass'n, Green Bay.

PROF. W. A. ROWLANDS, University of Wisconsin,
Madison.

ROBERT SPRAGUE, Wisconsin State Federation of Labor,
Milwaukee.

A. H. FINDEISEN, Industrial Commission of Wisconsin,
Madison.

A meeting of the advisory committee was held in Madison on March 11, 1932 and proposed regulations were recommended to the commission for adoption. The commission held public hearings on the proposed regulations as follows: Milwaukee, August 29; Fond du Lac, August 30; Green Bay, August 31; Wausau, September 1; Eau Claire, September 2 and Madison, September 6.

The advisory committee held another meeting in Madison on November 4, 1932 and after consideration of suggestions and criticisms that had been made during and after the public hearings submitted a final report to the commission.

On February 18, 1933, the Industrial Commission voted to repeal the following orders or parts of orders:

Nos. 310 (f), 311 (a), (b), 312, Rules 41, 42, 43, 44, 45 of 345, 360 (g), (h), (i), 385, 386, 387, 388, 389, 611, 612, 613, 6090, 6091, 6092 and 6093.

At the same time it was voted to adopt the following new general safety orders: Nos. 650, 651, 652, 653, 654, 655, 656, 657, 658, 659, 660, 661, 662, 663, 664 and 665. The repeal of the old orders and the adoption of the new orders to become effective thirty days after publication.

The orders were published on February 25, 1933 and became effective on March 27, 1933.

All orders of the Industrial Commission relating to explosives are published in this bulletin and for convenience are divided into sections as follows:

Section I. Contains those orders that are effective as of March 27, 1933.

Section II. Relates to the underground storage and use of explosives in mines.

Section III. Relates to the underground storage and use of explosives in tunnels.

Note: Section 101.06 of the statutes makes it the duty of all employers to provide a safe place of employment. The Industrial Commission cannot by order relieve employers of this obligation. No matter how the orders of the Industrial Commission may read, the employer is responsible if he does not provide safe employment. If any employe is injured through a violation of any order, of the Commission, he can recover a 15% increase in compensation, from his employer, under the provisions

of section 102.09 (5) (b). This order, consequently does not impose any obligation upon the employer which is not placed upon him by the statutes of the state, but makes it clear that this entire set of orders is not intended and cannot nullify the express provisions of section 101.06.

The attention of superintendents and foremen and of other persons having control of any employe or any operation, however, is directed to the fact that the term "employer" as used in section 101.01 is defined to include "every person, firm, corporation, agent, manager, representative, or other person having control or custody of any employment, place of employment, or of any employe." The duty to provide a safe place of employment rests not only upon the employer, but also upon the superintendent and foreman. Failure on the part of a superintendent or foreman to comply with any order contained in this code is a violation of law and renders him personally liable to a forfeiture of ten to one hundred dollars for each day and each instance of violation. This forfeiture can be collected at any time within two years after it is incurred through a civil suit brought by the attorney general. In such a suit the only possible defense is proof of compliance with the Commission's order.

Superintendents, foremen and others who are specifically charged with any duty by any order contained in these General Orders on Explosives will be held responsible by the Industrial Commission for the discharge of such duties. Employers, however, should also realize that they may become liable for increased compensation, if they do not see to it that the superintendents and foremen observe these orders.

GENERAL ORDERS ON EXPLOSIVES

SECTION I

Order 650—Scope.

These orders shall apply to the storage, handling and transportation of explosives but shall not include

1. Transportation upon vessels or railroad cars in conformity with the regulations adopted by the Interstate Commerce Commission.
2. The underground storage, handling or use of explosives in mines or tunnels.

Order 651—Construction of Orders.

Failure on part of superintendents, foremen, bosses and other persons having control of any place of employment, or of any employe and of any operations, to carry out any duty prescribed in these orders, is violation of such order by the employer.

Order 652—Definitions.

(a) *Superintendent.* The term "superintendent" when used in these orders shall mean the person having general supervision of the work.

(b) *Foreman.* The term "foreman" when used in these orders shall mean a person who at any one time is charged with the immediate direction of the work.

(c) *Explosives.* The term "explosives" when used in these orders, shall mean and include any chemical compound or mechanical mixture that is commonly used or intended for the purpose of producing an explosion, that contains any oxidizing and combustible units or other ingredients in such proportions, quantities or packing that an ignition by fire, by friction, by concussion, by percussion or by detonator of any part of the compound or mixture may cause such a sudden generation of highly heated gases that the resultant

gaseous pressures are capable of producing destructive effects on contiguous objects or of destroying life or limb.

(d) *Magazine.* The word "magazine" when used in these orders, means any building or other structure, used for the storage of explosives.

(e) *Primer.* The term "primer" when used in these orders shall be held to mean a capped fuse, electric exploder or other source of ignition inserted in a cartridge of explosive.

(f) *Approved.* The term "approved" shall be held to mean approved by the Industrial Commission.

(g) *Efficient Barricade.* The term "efficient artificial barricade" when used in these orders, shall be held to mean an artificial mound or properly revetted wall of earth of a minimum thickness of not less than three feet.

(h) *Blaster.* The term "blaster" shall mean any person or persons designated by the superintendent or employer to supervise blasting operations or to handle explosives.

(i) *Person.* The term "person" when used in these orders shall be held to mean and include a firm or body corporate as well as natural persons.

(j) *Building.* The term "building" or "buildings" when used in these orders shall be held to mean and include only a building or buildings occupied in whole or in part as a habitation for human beings, or any church, schoolhouse, railroad station, store or other building where people are accustomed to assemble.

(k) *Railroad.* The term "railroad" when used in these orders shall be held to mean and include any steam, electric or other railroad which carries passengers for hire.

Order 653—Storage of Explosives Within Cities and Villages.

(a) No nitroglycerin, dynamite, or other explosive preparations containing more than 60 per cent nitroglycerin or explosives of equivalent sensitiveness shall be kept or stored in any building, storeroom, wareroom, or in or on any premises within the corporate limits of any city or village.

(b) Not more than a total quantity of 50 pounds of explosives shall be kept or stored in or on any premises within the corporate limits of any city or village. Such 50 pounds or less of such explosives shall be kept and stored in a maga-

zine made of fire resistive materials or of wood covered with sheet iron and mounted on wheels, and kept securely locked except when opened necessarily for use by authorized persons. Such magazine shall be plainly marked "Explosives" and located within the building, on the floor nearest the street level and within 10 feet from the street entrance.

(c) Not more than 50 pounds of gunpowder may be kept or stored in any building within the corporate limits of any city or village. Such gunpowder shall be kept and stored in closed metal cannisters of not more than 12½ pounds capacity each in a store or wareroom away from artificial light or heat, such place of storage to be approved by the Chief of the Fire Department.

(d) Where blasting operations within a city or village require larger quantities of explosives than those specified above, the Chief of the Fire Department may permit the keeping of larger quantities of such explosives in a portable magazine, but not in excess of the quantity actually needed for one day's operation.

(e) Not more than 5,000 blasting caps or detonators may be kept or stored within the corporate limits of any city or village. In no case shall explosives and blasting caps or detonators be kept or stored in the same magazine.

Blasting caps shall be kept or stored in a similar, but separate magazine, similarly placed, in accordance with the specifications provided for in paragraph (b) of this order.

(f) The Chief of the Fire Department shall be notified of the place, extent and manner of storage of explosives and blasting caps or detonators within the corporate limits of any city or village.

Order 654—Storage Outside Corporate Limits of Cities and Villages.

All explosives in excess of the supply authorized to be stored in cities and villages shall be kept or stored in specially constructed magazines located according to the Quantity and Distance Table.

Order 655—Storage with Other Materials.

No tools or other materials except wooden wedges and wooden mallets shall be kept or stored in any magazine containing explosives.

Order 656—Location of Magazines.

(a) All magazines in which explosives are had, kept or stored shall be located at a distance from buildings, railroads and highways in conformity with the following Quantity and Distance Table, unless otherwise authorized by the Industrial Commission.

The Quantity and Distance Table governing the keeping and storage of explosives is as follows:

QUANTITY AND DISTANCE TABLE

Quantity that may be had, Kept or Stored				Distance from Nearest Building Feet	Distance from Nearest Railway Feet	Distance from Nearest Highway Feet
Blasting and Electric Blasting Caps		Other Explosives				
Number Over	Number not Over	Pounds Over	Pounds Not Over			
1,000	5,000			30	20	10
5,000	10,000			60	40	20
10,000	20,000			120	70	35
20,000	25,000			145	90	45
25,000	50,000	50		240	140	70
50,000	100,000	100		360	220	110
100,000	150,000	200		520	310	150
150,000	200,000	300		640	380	190
200,000	250,000	400		720	430	220
250,000	300,000	500		800	480	240
300,000	350,000	600		860	520	260
350,000	400,000	700		920	550	280
400,000	450,000	800		980	590	300
450,000	500,000	900		1,020	610	310
500,000	500,000	1,000		1,060	640	320
750,000	750,000	1,500		1,200	720	360
1,000,000	1,000,000	2,000		1,300	780	390
1,500,000	2,000,000	3,000		1,420	850	420
2,000,000	2,500,000	4,000		1,500	900	450
2,500,000	3,000,000	5,000		1,560	940	470
3,000,000	3,500,000	6,000		1,610	970	490
3,500,000	4,000,000	7,000		1,660	1,000	500
4,000,000	4,000,000	8,000		1,700	1,020	510
4,500,000	4,500,000	9,000		1,740	1,040	520
5,000,000	5,000,000	10,000		1,780	1,070	530
5,000,000	7,500,000	10,000	15,000			

QUANTITY AND DISTANCE TABLE—Continued

Quantity that may be had, Kept or Stored				Distance from Nearest Building Feet	Distance from Nearest Railway Feet	Distance from Nearest Highway Feet
Blasting and Electric Blasting Caps		Other Explosives				
Number Over	Number not Over	Pounds Over	Pounds Not Over			
7,500,000				1,950	1,170	580
10,000,000	10,000,000	15,000	20,000	2,110	1,270	630
12,500,000	12,500,000	20,000	25,000	2,260	1,360	680
15,000,000	15,000,000	25,000	30,000	2,410	1,450	720
17,500,000	17,500,000	30,000	35,000	2,550	1,530	760
20,000,000	20,000,000	40,000	40,000	2,680	1,610	800
		45,000	45,000	2,800	1,680	840
		50,000	50,000	2,920	1,750	880
		55,000	55,000	3,030	1,820	910
		60,000	60,000	3,130	1,880	940
		65,000	65,000	3,220	1,940	970
		70,000	70,000	3,310	1,990	1,000
		75,000	75,000	3,390	2,040	1,020
		80,000	80,000	3,460	2,080	1,040
		85,000	85,000	3,520	2,120	1,060
		90,000	90,000	3,580	2,150	1,080
		95,000	95,000	3,630	2,180	1,090
		100,000	100,000	3,670	2,200	1,100
		125,000	125,000	3,800	2,280	1,140
		150,000	150,000	3,930	2,360	1,180
		175,000	175,000	4,060	2,440	1,220
		200,000	200,000	4,190	2,520	1,260
		225,000	225,000	4,310	2,590	1,300
		250,000	250,000	4,430	2,660	1,340
		275,000	275,000	4,550	2,730	1,380
		300,000	300,000			

MAXIMUM ALLOWED. No quantity in excess of 300,000 pounds or in the case of blasting caps no number in excess of 20,000,000 caps, shall be had, kept or stored in any magazine in this state.

(b) *Separation of One Magazine from Another.* Magazines in which more than 50 pounds of explosives are kept and stored shall be detached from other structures, and magazines where more than 5,000 pounds of explosives are kept and stored shall be located at least 200 feet from any other magazine, except cap magazines. Magazines where quantities of explosives in excess of 25,000 pounds are kept and stored shall have an increase over 200 feet of $2\frac{2}{3}$ feet for each 1,000 pounds of explosives in excess of 25,000 pounds stored therein; provided, that the said distances between magazines may be disregarded where the total quantity stored in said magazines, considered as a whole, complies with the quantity and distance table in paragraph (a) of this order; except that, in all cases, the quantity of explosives contained in cap magazines shall govern in regard to spacing said cap magazines from magazines containing other explosives, but under no circumstances shall a magazine containing blasting caps be within a less distance than 100 feet, not barricaded, or 50 feet, barricaded, from any magazine other than cap magazine.

(c) *Reduction of Distances.* Whenever a magazine is effectually screened, from buildings, railroads or highways, either by natural features of the ground, or by an efficient artificial barricade of such height that any straight line drawn from the top of any sidewall of the magazine to any part of the building, to be protected, will pass through such intervening natural or efficient artificial barricade, and any straight line drawn from the top of any sidewall of the magazine, to any point 12 feet above the center of the railroad or highway to be protected, will pass through such intervening natural or efficient artificial barricade, the applicable distances, as prescribed by the quantity and distance table, in paragraph (a) of this order, and the distances separating magazines as prescribed in paragraph (b) of this order may be reduced one-half.

Order 657—Construction and Maintenance of Magazines.

All permanent magazines shall be constructed and maintained as follows:

(a) Every magazine shall be constructed of fire-resistant material and shall have no openings except for ventilation and entrance. Doors of such magazines shall be fire-resistant and at all times kept closed and securely locked except when it has to be entered by the person or persons in charge thereof. All nails in the interior of the magazine shall be countersunk. The ground around such magazines within 25 feet in all directions from the magazine shall be kept free from rubbish, dead grass, shrubbery, or other encumbrance.

Note: For the purpose of these orders, a magazine is fire resistant if constructed of cement mortar, tile or brick, and the door surfaced with sheet metal, or, if of wood construction consisting of double walls not less than 6 inches apart filled from sill to plate with dry, coarse sand and the structure completely surfaced on the outside with not less than No. 26 gauge galvanized iron.

(b) Upon each end of such magazine, above the side walls thereof, or upon its barricade, or on the premises, within a distance of 25 feet of the magazine, shall at all times be posted signs with the words "*Explosives—Keep Off*" legibly printed thereon in letters not less than 3 inches high.

(c) Magazines shall be ventilated and the openings for ventilation shall be so screened that sparks may not enter therein.

(d) Magazines shall be at all times kept clean and dry.

(e) Magazines shall be in charge of a person especially appointed for the purpose, who shall have in his possession the keys of the magazine and shall be responsible for the safe storage of explosives contained therein.

(f) No naked lights or other sources of heat shall be introduced into a magazine where powder, explosives, or other inflammable substance are stored. Smoking shall not be permitted in a magazine, or while handling explosives.

(g) A wooden wedge and a wooden mallet shall be used for the opening of all explosive boxes.

Order 658—Storage, Daily Supply.

Where explosives in excess of immediate requirements are removed from a magazine and delivered in the vicinity of a blasting operation they shall be kept in a stout, tight

box covered with not less than No. 24 gauge sheet iron and equipped with hinged lids, or, a small portable building similarly covered. Not more than 24 hours' supply of explosives shall at any time be kept or stored therein, and except when necessarily opened for use by authorized persons, shall at all times be kept securely locked. The magazine shall be located not less than 150 feet from the work in progress. Upon each such magazine there shall be kept conspicuously posted a sign with the words "*Explosives—Dangerous*" legibly printed thereon.

Order 659—Storage, Temporary Locations.

When the work is of a temporary nature, the magazine may be constructed in accordance with the specifications provided for in Order 658. The quantity of explosives kept on hand shall not exceed 24 hours' supply, and the magazine shall be located not less than 200 feet from any other structure, working place or public highway.

Exception: Where a distance of 200 feet cannot be obtained for storage within a city or village, storage is permitted at lesser distances provided there is no conflict with local regulations.

Note: Magazines should be located behind or under natural or artificial barriers to protect explosives from flying material when blasting. In no case should the magazine be located in direct line with the blast.

Order 660—Marking of Explosives.

Each package, except smokeless powder, shall be marked by means of a brand or stencil with the words "*Explosives—Dangerous*" followed by the specific name of the explosive, the name and address of the manufacturer, and a brief statement showing the net weight of the explosive.

Order 661—Explosives Unfit for Use.

Dynamite, blasting caps and fuse which have become deteriorated by age or improper storage shall not be used for blasting purposes and shall be immediately destroyed.

Note: Not more than 50 pounds of dynamite should be destroyed at one time. It should be taken to a safe distance from houses and roads, opening the cases very carefully, taking the cartridges out, slitting them and spreading them over the ground instead of piling them up. If the dynamite appears to be too wet to burn readily, a little kerosene may be poured over it. A

small pile of papers, shavings or other combustible material should be placed close enough to the dynamite so that the flame will burn along the paper and ignite the dynamite. After lighting the paper one should retire immediately to a safe distance until the dynamite is completely burned.

Order 662—Transportation of Explosives.

Motor trucks and (or) vehicles when used for transporting explosives, shall be marked or placarded on both sides and the rear with the words "*Explosives—Dangerous*" in letters not less than three inches high, or shall conspicuously display a red flag not less than twenty-four inches square marked with the word "*Danger*" in white letters not less than six inches high.

Vehicles transporting explosives shall be handled in a safe and careful manner and no person while smoking or under the influence of intoxicating liquor shall ride upon, drive, load or unload a vehicle carrying explosives.

No tools, blasting caps, matches, or other flame producing materials shall be carried in a vehicle containing explosives excepting tools for the operation and repair of such vehicle.

No stops except unavoidable stops shall be made during the journey and the speed of the vehicle shall not exceed 35 miles per hour.

Exposed metal parts in the interior of vehicles used to transport explosives shall be insulated from the explosives with wood, blankets or other fibrous material.

Explosives shall not be transported in any form of trailer, nor shall any trailer be attached to a motor truck or vehicle hauling explosives.

Order 663—Certificates of Competency for Blasters.

Within one year of the effective date of this code no person shall prepare explosive charges or conduct blasting operations unless such person holds a certificate of competency issued by the Industrial Commission.

Before issuing such certificate of competency the commission will determine the fitness of the candidate.

Persons authorized to prepare explosive charges or conduct blasting operations shall comply with all provisions of the General Orders on Explosives, and shall use every reasonable precaution to insure the safety of the workmen and general public.

This order shall not prevent the handling of explosives

by other employes provided the work is done under the direct supervision of a person holding a certificate of competency.

Order 664—Blasting Caps, Fuses and Primers.

(a) No blasting caps or electric blasting caps shall be stored in any magazine containing other explosives.

(b) All primers shall be exploded within 36 hours after making.

(c) No fuses shall be capped with blasting caps in any magazine or in any other place where blasting caps or other explosives are stored, but approved benches shall be provided at a safe distance from such storage place, where all fuses shall be capped.

(d) Only a crimper shall be used for attaching fuse to blasting caps. The operator shall furnish and keep in accessible places, ready for use, crimpers in good repair. Broad jaw crimpers shall be used.

(e) Blasting caps and fuse which have become deteriorated by age or improper storage shall not be used for blasting purposes and shall be destroyed.

Order 665—Explosives, Blasting, Conveying, Misfires, Etc.

(a) *Blasters.* Only experienced qualified men who have been selected and regularly designated by the employer or the superintendent in charge shall handle, transport, prepare or use dynamite or other high explosives.

(b) *Number of Blasters, Responsibility.* There shall be one blaster in charge of blasting in each section of any operation. He shall enforce these orders and directions and personally supervise the fixing of all charges and all other blasting operations and shall use every precaution to insure safety.

(c) *Conveying Explosives.* Explosives shall be conveyed in a suitable covered wooden box or in sacks provided for that purpose. Detonators and fuse shall be conveyed separately from other explosives in approved containers provided for that purpose.

Note: The carrying container for fuse and detonators shall be of rigid construction and provided with a hinged cover.

After blasting is completed, all explosives and detonators shall be returned at once to the regular storage places, observing the same rules as when bringing them to the work.

(d) *Frozen Dynamite.* No blaster shall attempt to use dynamite that is frozen.

(e) *Counting Shots, Misfires.* When a blaster fires a round of holes he shall count the number of shots loaded and check against those exploded, except in cases of instantaneous blasting by electricity. If there are any misfires, or any doubt as to the total number of shots exploding, no person shall be permitted to approach the charges until at least one-half hour shall have elapsed lest the trouble be a hangfire and not a misfire.

(f) *Misfires, Treatment.* Whenever feasible, a charge that has failed to explode shall be exploded by inserting a new primer in the hole on the old charge and detonating such primer.

(g) *Firing by Electricity.* When firing by electricity from power or lighting wires, a proper switch shall be furnished with lever down when "off". The switch shall be fixed in a box to which no person shall have access except the blaster. This box shall be constructed so that it can be closed and locked only when the switch is in the "off" position. The lead wires shall be furnished with plugs and shall not be connected with the switch till ready to fire. After blasting, the switch lever shall be pulled out, the wires disconnected, and the box locked before any person shall be allowed to return and shall remain so locked until again ready to blast. The lead wires shall be kept short-circuited and grounded until ready to be attached to the power switch or firing battery.

(h) *Shot Firing Cables.* Rubber covered insulated wires shall be used for shot firing cables. Permanent lines shall be properly supported and mounted on insulators. Special precautions shall be taken to prevent temporary or portable lines from coming into contact with lighting, power or other circuits or with any metal pipe lines. All portable devices for generating or supplying electricity for shot firing shall be in charge of a boss or blaster. No person other than the boss or blaster shall connect the firing machine or battery to the shot firing leader and such connection shall not be made until all other steps preparatory to the firing of a shot shall have been completed and the men removed to a safe distance.

(i) *Examination After Blast.* Before drilling is commenced on any shift, all remaining holes shall be examined for unexploded explosives, using a wooden stick, or any other method giving equivalent protection. If any explosives are found they shall be refired before work proceeds.

New drill holes shall not under any circumstances be started in the sockets or remaining ends of old or blasted holes.

(j) *Tracing Firing Wires.* All wires in broken rock shall be carefully traced and search made for unexploded cartridges.

(k) *Galvanometers.* When firing electrically, individual electric detonators shall be tested with a galvanometer or circuit tester, both before and after loading.

Each new galvanometer and each galvanometer which has been repaired or which has been equipped with a new battery shall be subjected to a test by connecting it up to an electric blasting cap, with but little resistance in the circuit, for 30 seconds. This test will determine the possibility of the galvanometer detonating a blasting cap under favorable or unfavorable conditions.

(l) *Fuse Lengths.* No man shall "spit" more than 10 fuses at one time. In no case shall the length of any 40 second fuse be less than 24 inches or any 30 second fuse be less than 30 inches. The minimum length of fuse and the number of shots that any one person shall be permitted or required to light at any one time shall be in accordance with the following table:

TABLE OF FUSE LENGTHS

Number of Shots in Blast to be Lighted by Each Man	Minimum Length of Fuse Permissible for Each Shot			
	40 Second Fuse		30 Second Fuse	
	Inches	Time	Inches	Time
(1)	(2)	(3)	(4)	(5)
1 -----	24	1 min. 20 sec.	30	1 min. 15 sec.
2 -----	26		33	
3 -----	28		36	
4 -----	30	1 min. 40 sec.	39	1 min. 38 sec.
5 -----	32		42	
6 -----	34		45	
7 -----	36	2 min. 0 sec.	48	2 min. 0 sec.
8 -----	38		51	
9 -----	40		54	
10 -----	42	2 min. 20 sec.	57	2 min. 22 sec.

Note: Column (1) indicates the various numbers of holes up to 10 which may be lighted at one time by one person provided the length of fuse for each hole agrees with the number of inches shown in column (2) if 40 second fuse is used or in column (4) if 30 second fuse is used. For convenience columns (3) and (5) are included to show the burning rate of 40 second and 30 second fuses respectively in steps of 6 inches each.

(m) *Warning Signals.* An audible warning signal shall be provided and sounded both before and after each shot with sufficient interval to permit persons to reach sheltered places and to announce that no further shots are to be fired.

(n) *Protection from Blasts.* Bomb-proof shelters sufficiently substantial to withstand flying objects from secondary shots shall be provided at a safe distance from the blasting operations and shall be of necessary capacity to accommodate the entire working crew.

Exception: Blasting shelters are not required if employes are required to retire to a distance of not less than 500 feet.

No shot shall be fired until all men are in the shelter provided for or have retired to a distance of not less than 500 feet.

Note: Employes should not be permitted to stand in the open but a place behind some barrier or object sufficient to withstand the force of flying objects should be selected and used.

Where highways or buildings are located within the danger zone, employes shall be sent in each direction to warn

the public when shots are to be fired. The persons giving the warning shall proceed not less than 500 feet from the blast and warning shall be accomplished by waving a red flag. A sign with the words "*Stop—Blasting*" printed thereon, in letters not less than 3 inches high, and attached to a pointed rod or standard, shall be provided and placed on the highway in addition to the red flag.

(o) *Secondary Blasting.* Secondary blasting on rock piles when the mud-capping method is used shall be conducted by successive stages. Boulders located at the foot of the piles shall be blasted separately from the boulders located midway or near the top of the slope, thus preventing the rolling of rocks on unexploded charges and consequently being thrown to a considerable distance.

(p) *Tamping Bars and Powder Punches.* All tamping bars and powder punches shall be of wood.

(q) When blasting operations are conducted within the confines of villages and cities, shots shall be effectively screened with approved blasting mats to hold or catch flying material. Shots shall be spaced, located and charged with explosives in a manner as to minimize the danger of flying material. Permission for the use of explosives is subject to the approval of the local authorities, as the mayor, president of the village, or the chairman of the town board.

Exception: Blasting operations may be conducted in existing quarries and other locations without the use of blasting mats, provided buildings, thoroughfares and persons are not subject to the danger of flying material and charges of explosives are kept as light as practicable with the nature of the work.

ORDERS RELATING TO UNDERGROUND STORAGE AND HANDLING OF EXPLOSIVES IN MINES

SECTION II

Note: These orders are quoted from the General Orders on Mines.

Order 310—Storage of Explosives.

(a) The term "magazine" as used in this section shall be held to mean and include any building or other structure or place in which explosives are stored or kept, whether above or below ground.

(b) Sufficient explosives may be stored within a mine to meet the estimated requirements of such mine during the succeeding week.

(c) No explosive shall be kept at any place within a mine where its accidental discharge would cut off the escape of miners working therein. No explosive shall be stored in a tunnel located in a pillar that is exposed on four sides, unless approved by the Industrial Commission.

(d) Not more than 75 pounds of explosives shall be kept in any working place on any one level at any one time, except that such explosive may be stored in an underground magazine, from which supplies required for immediate use shall be distributed to the various working places by an authorized and competent person or persons. Such underground magazine may consist of a separate drift or chamber. The entrance to such underground magazine shall be kept securely locked, except when it has to be entered by the person or persons in charge thereof.

(e) All explosives within the mine except in the magazine shall be kept in stout, tight boxes or bags from which the explosives shall be removed only as required for immediate use. No such boxes or bags containing explosives shall be kept near any track or electric conductors or in any

manway except for immediate use. No grains or particles of such explosives shall be permitted to remain on the outside or about the containers in which such explosives are held.

Order 311—Blasting Caps and Fuse.

(c) All detonators shall be stored above ground in a suitable magazine or magazines, properly protected against molestation, except that a sufficient supply for the needs of the mine during 48 hours may be stored underground, and if properly heated and ventilated storage is provided, one week's supply may be stored. No detonator shall be taken into any magazine containing other explosives. No fuses shall be capped with detonators in any magazine or in any other place where explosives are stored. Cap crimpers shall be furnished in sufficient quantity to avoid the necessity of crimping in any other way. No detonators shall be transported with other explosives, except when made into a primer with such other explosive. All primers shall be exploded within 24 hours after making. Not more than 1,000 detonators shall be kept underground in any one level at any time.

(d) Fuse shall not be stored underground for a longer period than 72 hours.

(e) When supplies of explosives or fuse are removed from a magazine those that have been longest in the magazine shall be taken first. No package of powder shall be opened with iron or steel instruments.

Order 313—Blasting.

(a) Bosses, shot firers, or other competent men shall be in immediate charge of and responsible for blasting within the mine. The use of any metal tools is prohibited for tamping or charging explosives. Detonators of not less strength than No. 6, shall be used in firing blasts. Bosses or shot firers and miners about to fire shots shall cause warnings to be given in every direction, and all entrances to the place or places where charges are to be fired shall be guarded by men.

(b) The number of explosions in every blast, except in case of simultaneous firing shall be counted by the man fir-

ing the same, and if the total number of explosions is less than the number of charges fired, a report shall be made to the foreman or man in charge and the miners shall not return without his permission.

(c) Wherever possible, a charge that has failed to explode shall be exploded by inserting a new primer in the hole on the old charge and detonating such primer. When tight tamping has been used, or when for any other reason a new primer cannot be inserted, no attempt shall be made to extract the explosive, but a new hole shall be drilled, which shall be a safe distance from the original hole, and such new hole shall be charged with a fresh charge of explosives and then detonated.

(d) When electricity is used to fire shots, no person shall knowingly enter the vicinity of the place where such shots have been fired until the cable from the source of electrical energy to the face of the blast shall have been disconnected. It shall be the duty of the boss, shot firer, or person in charge to see that special precautions are taken against the shot-firing cables or wires coming into contact with the lighting, power, or other circuits, or with any metal pipe lines. All portable devices for generating or supplying electricity for shot firing shall, when in the mine be in charge of a boss, shot firer, or other competent person. No person other than the man in charge of firing shall connect the firing machine or battery to the shot-firing leads, and such connection shall not be made until all other steps preparatory to the firing of a shot shall have been completed. The primary or secondary batteries used for shot firing shall be of approved construction. The plug or key shall be detached when not actually in use for firing a shot, and shall not, under any circumstances, pass from the custody of the boss or shot firer.

(e) Electricity from light or power circuits shall not be used for firing shots in a mine, except when the electrical connection to such light or power circuits are made within an enclosed switch box or room, which shall be kept securely locked and shall be accessible only to the authorized person in charge of firing.

Order 345.

Rule 46. Explosives shall not be carried on an electric locomotive, or in a trip hauled by an electric locomotive, or on a gasoline locomotive.

Rule 47. Explosives shall not be left or placed near live electric wires.

Rule 48. No person shall remove any explosive from a mine without the written consent of the superintendent of the mine.

Rule 49. Fuses. No fuse shall be used in any mine that burns faster than 3 feet in 80 seconds or slower than 3 feet in 130 seconds. From every case of fuse opened, or from every lot of 24,000 feet, two coils shall be selected at random and pieces cut from such two coils shall be tested for rate of burning.

ORDERS RELATING TO UNDERGROUND STORAGE AND HANDLING OF EXPLOSIVES IN TUNNELS AND CAISSONS

SECTION III

Note: These orders are quoted from the General Orders on Tunnel, Caisson and Trench Construction.

Order 614—Explosives, Conveying, Thawing, Blasting, Misfires, etc.

(a) Only experienced men who have been selected and regularly designated by the superintendent in charge and whose names have been posted in the field office or at the magazine shall handle, transport, prepare or use dynamite or other high explosives.

(b) There shall be one blaster in charge of blasting in each section and he shall enforce his orders and directions and personally supervise the fixing of all charges and all other blasting operations and shall use every precaution to insure safety.

(c) The composition of explosives shall be such as to cause the least amount of injurious gases. No explosives shall be used which have not been approved by the Industrial Commission.

Note: It will be the policy of the Commission to approve explosives which are listed as permissible by the U. S. Bureau of Mines. Therefore, such listed explosives may be used without submitting them to the Commission, unless upon due notice any such explosives have been disapproved by the Commission or have been improperly used or stored.

(d) No greater quantity of explosives than that which is required for immediate use shall be taken into the shaft or tunnel except for storage in any approved underground magazine.

Explosives shall be conveyed in a suitable covered wooden

box or in sacks provided for that purpose. Detonators shall be conveyed to the working place in a separate container from that for the explosive. The carrying container for fuse and caps should be of rigid construction, and have a soft lining for better protection of the detonators.

Explosives and detonators shall not be taken down the shaft on the same cage at the same time.

While explosives are being taken through locks, no men other than the lock tender and the carrier shall be permitted in the lock.

After blasting is completed all explosives and detonators shall be returned at once to the magazine, observing the same rules as when bringing them to the work.

Detonators and dynamite must be kept or stored separately underground.

Explosives shall not be left or placed near live electric wires.

(e) No blaster shall attempt to use dynamite that is frozen. Only approved methods of thawing shall be permitted. Dynamite or other high explosives shall not be thawed by placing it near a fire or near a steam boiler or by direct contact with steam.

(f) No naked light shall be used in the vicinity of open chests or magazines containing explosives, nor near where a charge is being primed.

(g) Detonators shall be crimped on the fuse only with a broad jaw cap crimper.

(h) No tools or other articles shall be carried with the explosives or with the detonators.

(i) All drill holes shall be of sufficient bore to admit of the free insertion to the bottom of the hole of a cartridge of explosive without the necessity of undue ramming or removing the dynamite from its original wrapper.

(j) When a blaster fires a round of holes he shall count the number of shots exploding, except in cases of instantaneous blasting by electricity. If there are any misfires, he shall remain until such misfires have been exploded or holes made safe.

Note: Misfires should not be approached even for the purpose of inspection until one hour has elapsed if fuse is used, or ten minutes have elapsed if electric blasting caps have been used, lest the trouble be a hangfire and not a misfire.

(k) Whenever feasible, a charge that has failed to explode shall be exploded by inserting a new primer in the hole on the old charge and detonating such primer.

(l) Blaster shall use only hardwood rods for tamping and he shall not tamp or load any hole with a metal bar, nor shall the wooden rod have any metal parts.

(m) When firing by electricity from power or lighting wires, a proper switch shall be furnished with lever down when "off". The switch shall be fixed in a locked box, to which no person shall have access except the blaster. There shall be provided flexible leads or connecting wires not less than 5 feet in length with one end attached to the incoming lines and the other end provided with plugs that can be connected to the switch on the inside shot-firing circuit when firing and that shall at all other times be connected to an effective ground. After blasting, the switch lever shall be pulled out, the wires disconnected and the box locked before any person shall be allowed to return, and shall remain so locked until again ready to blast, and blasting wires must be laid on the opposite side of the tunnel from the lighting and power wires.

(n) All power lines and electric light wires shall be disconnected at a point outside the blasting switch before the loading of holes is proceeded with. No current by grounding of power or bonded rails shall be allowed beyond blasting switch after explosives are taken in preparatory to blasting, and under no circumstances shall grounded current be used for exploding blasts.

(o) The blaster shall cause a sufficient warning to be sounded and shall be responsible that all persons retreat to safe shelter before he sets off blast, and shall also see that none return until he reports it safe for them. He shall report to the tunnel foreman and furnish names of all persons refusing to obey his caution.

(p) Before drilling is commenced on any shift, all remaining holes shall be examined with a wooden stick for unexploded charges or cartridges, and if any are found, same shall be refired before work proceeds.

(q) No person shall be allowed to deepen holes that have previously contained explosives.

(r) All wires in broken rock shall be carefully traced and search made for unexploded cartridges.

(s) Whenever blasting is being done, in a tunnel, at points liable to break through to where other men are at work, the foreman or person in charge shall, before any holes are loaded, give warning of danger to all persons that may be working where the blasts may break through, and he shall not allow any holes to be charged until warning is acknowledged and men are removed.

(t) When firing electrically individual electric detonators shall be tested with a galvanometer, both before and after loading.

(u) No blasts shall be fired with fuse, except electrically ignited fuse, in vertical or steep shafts.

(v) In shaft sinking where the electric current is used for firing a separate switch not controlling any electric lights shall be used for blasting and proper safeguards similar to those in tunnels shall be followed in order to insure against premature firing.

APPENDIX

Storage of Explosives

The American Table of Distances is considered a standard on which should be based the location of magazines in relation to surrounding improvements such as dwellings, railroads and highways. A magazine location should be selected with a view to both accessibility and safety. A good location in an isolated ravine where the surrounding hills provide protection and such location permits the reduction of distances to surrounding improvements.

Improper storage results in very rapid deterioration of explosives, particularly by the absorption of moisture and extremes in temperatures. A magazine properly constructed to provide good ventilation and insulation is required.

The size of the magazine depends upon the amount of explosives to be stored. The dimensions given in the following table are suitable for the amounts indicated.

Main Storage Magazines

DIMENSIONS		
<i>Quantity</i>	<i>Width</i>	<i>Length</i>
1000 lbs. -----	6 feet	6 feet
2000 lbs. -----	6 feet	7 feet
5000 lbs. -----	8 feet	9 feet
10000 lbs. -----	10 feet	12 feet
15000 lbs. -----	12 feet	12 feet
20000 lbs. -----	12 feet	16 feet
25000 lbs. -----	12 feet	18 feet
30000 lbs. -----	12 feet	20 feet
40000 lbs. -----	14 feet	22 feet
50000 lbs. -----	14 feet	24 feet

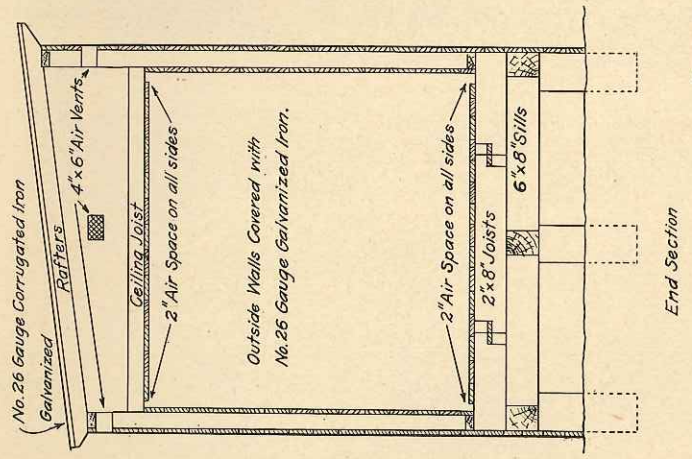
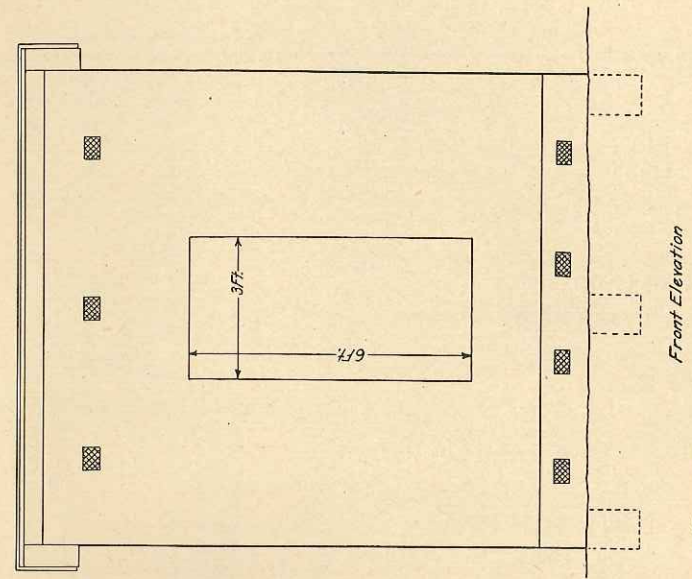
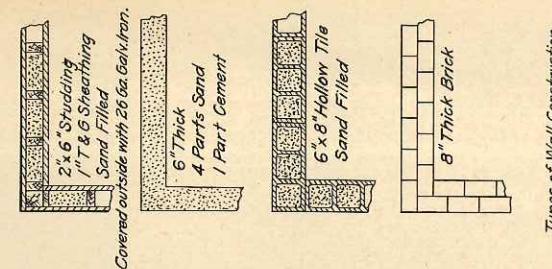
Specifications for Storage Magazines

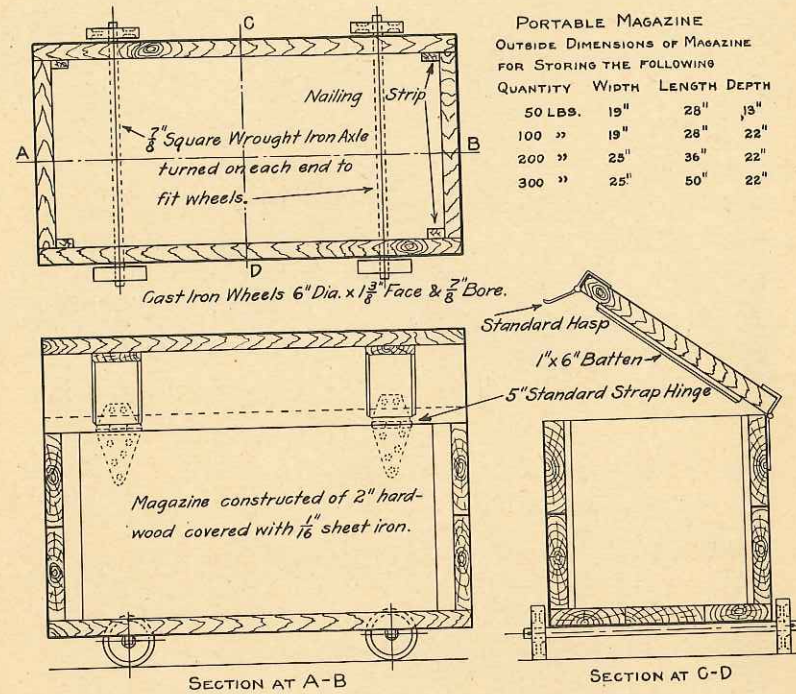
Permanent magazines should be constructed of soft brick or cement mortar but may be of wood construction covered with galvanized iron, the walls double sheathed and filled in

with dry sand. The following specifications for a wood constructed magazine may be used:

Specifications for Wood Constructed Magazine

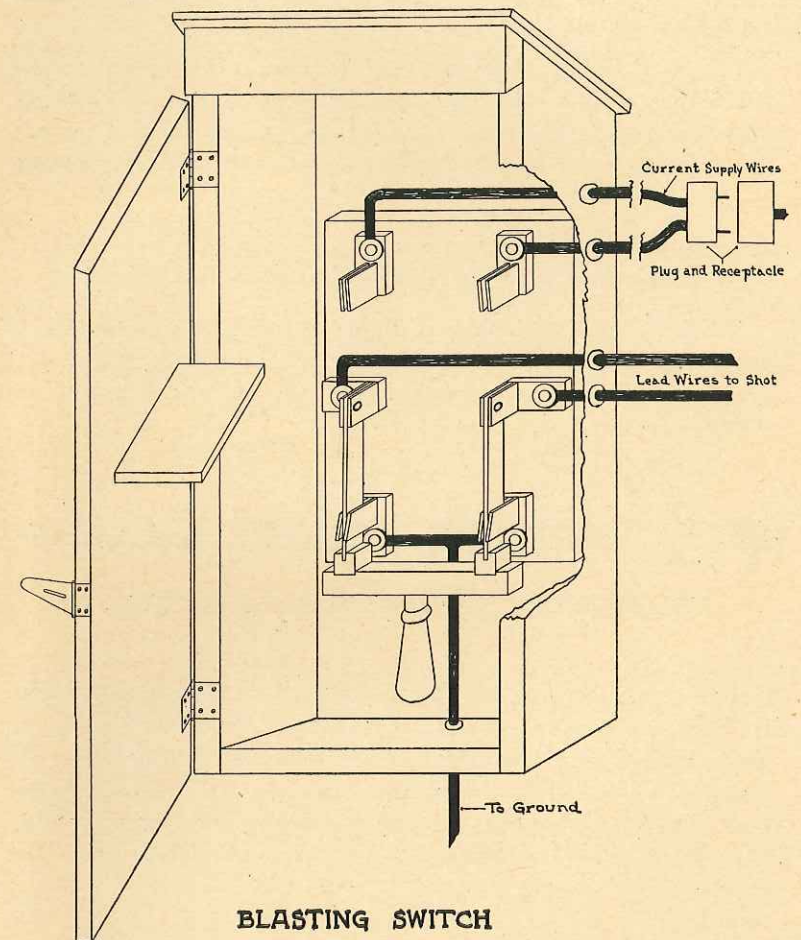
- Dimensions --- 9 feet 6 inches high in front; 8 feet 2 inches high in rear, and floor area according to capacity indicated.
- Sills ----- 6 x 10 inches.
- Floor Joists --- 2 x 8 inches, spaced 16 inches center to center.
- Sheathing --- Matched lumber, 1 inch material, either flooring, or outside and inside sheathing.
- Roof ----- 1 inch lumber same as sidewalls and covered with No. 26 gauge galvanized iron.
- Floor ----- 1 inch flooring, matched, and set back 2 inches from walls to provide ventilation.
- Outside Wall --- To be covered with galvanized iron, not less than No. 26 U. S. standard gauge.
- Studding ----- 2 x 6 inches, spaced 12 inches center to center.
- Door ----- 3 feet wide, 6 feet high, made of 3 inches of hard wood and covered on outside by $\frac{1}{4}$ inch steel plate firmly secured to door by bolts.
- Sand Filler --- Space between outside and inside walls to be filled with coarse, dry sand or cement mortar consisting of 1 part cement to 6 parts sand.
- Lock ----- Inside lock.
- Foundation --- Set on posts about 1 foot above ground or continuous concrete walls.
- Ventilation --- 4 x 6 inch openings below roof line and floor level, covered with wire screen. The floor and ceiling must be set back 2 inches to provide air circulation.
- Danger Signs --- Signs with words "Explosives—Dangerous" to be posted on magazines or grounds.





Blasting Switch

The blasting switch consists of a two pole double throw switch. It must be wired so that the power supply is disconnected when the lever is in a "down" or "off" position. The current supply wires are connected to the upper poles.



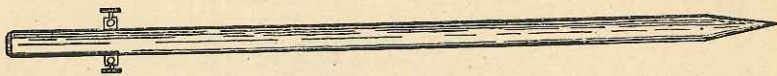
The leading wires supplying the shots are connected to the middle poles. The bottom poles are wired to an effective ground consisting of a pipe driven into moist soil or the water piping system.

When the switch is in an "off" position the shot wires are short circuited and grounded, preventing the introduction of "stray currents". The switch should be of the enclosed safety type and a locking device provided to lock the switch handle when in the "down" position. If an open knife switch is provided it must be mounted in a cabinet provided with a door and lock. The door must be designed so that it cannot be closed unless the switch handle is in the "down" or "grounded" position.

The switch box must be kept locked at all times except when in use and shall be operated only by the blaster. A plug and receptacle must be provided in the current supply line so that wires may be kept disconnected from the switch as an additional precaution.

Grounding Leading Wires, Portable Equipment

When firing shots with a portable blasting machine it is necessary to keep the leading wires short circuited and grounded to prevent a possibility of the introduction of stray currents and a premature blast.



Metal stake for grounding leading wires.

The grounding stake should consist of a pointed, metal rod or pipe preferably non-corrodible. Two binding posts are attached near the upper end to provide terminals for the leading wires. The grounding stake is driven into moist soil near the blasting machine and the leading wires attached before the opposite ends are connected with the shots.

Use of Explosives

The safe handling of explosives depends entirely upon the strict observance of safety rules. The blaster should not only be familiar with all the rules but should observe them in practice. It is the employer's duty to provide proper

storage facilities, blasting accessories and to employ only qualified men to handle the explosives. The employer is also responsible for strict enforcement of the safety rules. Lack of interest and discipline will sooner or later result in infractions of the rules.