Second Revision No. 17-NFPA 91-2024 [Detail]

[Add annex to 4.1]

4.1* Terminology.

A.4.1

The combustibility-related definitions in Section 4.1 apply to materials of construction of the ductwork and the materials external to and in close proximity to the ductwork, not the materials being conveyed.

Submitter Information Verification

Committee: CMD-HAP
Submittal Date: Tue Aug 13 12:11:02 EDT 2024

Committee Statement

Committee Statement: This statement provides clarity regarding the application of Section 4.1.
Response Message: SR-17-NFPA 91-2024

Second Revision No. 11-NFPA 91-2024 [Section No. 1.1]

1.1* Scope.

This standard provides minimum requirements for the design, construction, installation, operation, testing, and maintenance of exhaust systems for air conveying of vapors, gases, mists, and particulate solids, including combustible particulate solids and hybrid mixtures, as they relate to fire and/or explosion prevention, except as addressed, modified, or amplified by other applicable NFPA standards.

A.1.1

The following NFPA standards contain information on the application of exhaust systems to specific industries or operations:

(1) NFPA 1

(2) NFPA 30

(3) NFPA 30B

(4) NFPA 32

(5) NFPA 33

(6) NFPA 34

(7) NFPA 35

(8) NFPA 36

(9) NFPA 45

~~NFPA 61~~

(10) NFPA 68

(11) NFPA 85

(12) NFPA 86

(13) NFPA 92

(14) NFPA 96

(15) NFPA 120

(16) NFPA 204

(17) NFPA 211

(18) NFPA 303

(19) NFPA 318

(20) NFPA 409

~~NFPA 484~~

~~NFPA 654~~

~~NFPA 655~~

(21) NFPA ~~664~~ 660

(22) NFPA 801

~~1.1.1~~

~~This standard does not cover exhaust systems for conveying combustible particulate solids that are covered in other NFPA standards *(see A.1.1)* .~~

Supplemental Information

File Name	Description	Approved
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Submitter Information Verification

Committee: CMD-HAP

Submittal Date: Mon Aug 12 11:29:01 EDT 2024

Committee Statement

Committee Statement: NFPA 61, 654, 655, 664, and 484 (and 652) are being consolidated into NFPA 660.

This revision also clarifies the scope of NFPA 91 and how the standard works together with the other applicable standards. A second statement is no longer needed because the first statement covers both combustible and noncombustible particulate solids.

Response Message: SR-11-NFPA 91-2024

Public Comment No. 1-NFPA 91-2024 [Section No. 1.1]

Second Revision No. 1-NFPA 91-2024 [Section No. 2.4]

2.4 References for Extracts in Mandatory Sections.

NFPA 30, *Flammable and Combustible Liquids Code,* 2024 edition.

~~NFPA 652, *Standard on the Fundamentals of Combustible Dust,* 2019 edition.~~

~~NFPA 654, *Standard for the Prevention of Fire and Dust Explosions from the Manufacturing, Processing, and Handling of Combustible Particulate Solids,* 2020 edition.~~

NFPA 68, *Standard on Explosion Protection by Deflagration Venting,* 2023 edition.

NFPA 660, *Standard for Combustible Dusts and Particulate Solids,* 2025 edition.

NFPA 5000®, *Building Construction and Safety Code®,* 2024 edition.

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Submitter Information Verification

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Committee Statement

Committee Statement: This revision updates extracted text in accordance with the Extract Policy. For substantiation on any changes, see the First and Second Draft reports for the source document.

Response Message: SR-1-NFPA 91-2024

Second Revision No. 3-NFPA 91-2024 [Section No. 3.3.1]

3.3.1* Air–Material Separator (AMS).

A device designed to separate the conveying air/gas from the material being conveyed. [~~652~~ **660** , ~~2019~~ 2025]

A.3.3.1 Air–Material Separator (AMS).

Examples include cyclones, ~~bag filter houses, scrubbers, demisters, and electrostatic precipitators~~ enclosureless dust collectors, point-of-use dust collectors, and bin vents .

An AMS technically could be an oversized section of ductwork (e.g., a drop-box).

Typically, an AMS used in a dust collection system will, in addition to separating the conveyed material from the air/gas stream, include the ability to collect the separated material within the AMS to allow for continuous discharge of that material.

[**660**, 2025]

Submitter Information Verification

Committee: CMD-HAP

Submittal Date: Fri Aug 09 22:22:23 EDT 2024

Committee Statement

Committee Statement: NFPA 652 is being consolidated into NFPA 660.

Response Message: SR-3-NFPA 91-2024

Second Revision No. 4-NFPA 91-2024 [Section No. 3.3.2]

3.3.2* Air-Moving Device.

A power-driven fan, blower, or other device that establishes an airflow by moving a given volume of air per unit time. [~~652~~ 660 , ~~2019~~ 2025]

A.3.3.2 Air-Moving Device.

An air-moving device is a fan or blower. A general description of each follows:

(1) Fans~~:~~

(a) ~~A~~ Fans include a wide range of devices that utilize an impeller, contained within a housing, that when rotated create air/gas flow by negative (vacuum) or positive differential pressure.

(b) These devices are commonly used to create comparatively high air/gas volume flows at relatively low differential pressures.

(c) These devices are typically used with ventilation and/or dust collection systems.

(d) Examples are centrifugal fans, industrial fans, mixed or axial flow fans, and inline fans.

(2) Blowers~~:~~

(a) ~~A~~ Blowers include a wide range of devices that utilize various shaped rotating configurations, contained within a housing, that when rotated create air/gas flow by negative (vacuum) or positive differential pressure.

(b) These devices are commonly used to create comparatively high differential pressures at comparatively low air/gas flows.

(c) The most common uses of these devices are with pneumatic transfer, high-velocity, low- volume (HVLV) dust collection, and vacuum cleaning systems.

(d) Examples are positive displacement (PD) blowers, screw compressors, ~~multi-stage~~ multistage centrifugal compressors/blowers, and regenerative blowers.

[~~652~~ 660 , ~~2019~~ 2025]

Submitter Information Verification

Committee: CMD-HAP

Submittal Date: Fri Aug 09 22:25:23 EDT 2024

Committee Statement

Committee Statement: NFPA 652 is being consolidated into NFPA 660.

Response Message: SR-4-NFPA 91-2024

Second Revision No. 14-NFPA 91-2024 [New Section after 3.3.3]

3.3.5 Combustible Particulate Solid.

Any solid material composed of distinct particles or pieces, regardless of size, shape, or chemical composition, that, when processed, stored, or handled in the facility, has the potential to produce a combustible dust. [**660** , 2025]

Submitter Information Verification

Committee: CMD-HAP

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Committee Statement

Committee Statement: Since the scope statement has been modified, the definitions of combustible particulate solid, combustible dust, and hybrid mixture are added to aid in application.

Response Message: SR-14-NFPA 91-2024

Second Revision No. 16-NFPA 91-2024 [New Section after 3.3.3]

3.3.4 Combustible Dust.

A finely divided combustible particulate solid, including combustible fibers/flyings, that presents a flash fire hazard or explosion hazard when suspended in air or the process-specific oxidizing medium over a range of concentrations. [**660**, 2025]

Submitter Information Verification

Committee: CMD-HAP

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Committee Statement

Committee Statement: Since the scope statement has been modified, the definitions of combustible particulate solid, combustible dust, and hybrid mixture are added to aid in application.

Response Message: SR-16-NFPA 91-2024

Second Revision No. 5-NFPA 91-2024 [Section No. 3.3.3]

3.3.3* Centralized Vacuum Cleaning System.

A fixed-pipe system utilizing variable-volume negative-pressure (i.e., vacuum) air flows from remotely located hose connection stations to allow the removal of dust accumulations from surfaces and conveying those dusts to an air-material separator (AMS). [~~652~~ **660** ,~~2019~~ 2025]

A.3.3.3 Centralized Vacuum Cleaning System.

This system normally consists of multiple hose connection stations hard-piped to an AMS located out of the hazardous area. Positive displacement or centrifugal AMDs can be used to provide the negative pressure air flow. The hoses and vacuum cleaning tools utilized with the system should be designed to be conductive or static-dissipative in order to minimize any risk of generating an ignition source. Low MIE materials should be given special consideration in the system design and use. A primary and secondary AMS separator combination (e.g., cyclone and filter receiver or wet separator) can be used if large quantities of materials are involved. However, most filter receivers or wet separators are capable of handling the high material loadings without the use of a cyclone. [~~652~~ **660** ,~~2019~~ 2025]

Submitter Information Verification

Committee: CMD-HAP
Submittal Date: Fri Aug 09 22:28:53 EDT 2024

Committee Statement

Committee Statement: NFPA 652 is being consolidated into NFPA 660.
Response Message: SR-5-NFPA 91-2024

Second Revision No. 6-NFPA 91-2024 [Section No. 3.3.5]

3.3.7* Dust Collection System.

A combination of equipment designed to capture, contain, and control airborne dust, and pneumatically convey ~~fugitive~~ the captured dust to an air-material separator (AMS) ~~in order to remove the dust from the process equipment or surrounding area~~ . [**~~652~~ 660** ,~~2019~~ 2025]

A.3.3.7 Dust Collection System.

A typical dust collection system consists of the following:

(1) Hoods — devices designed to contain, capture, and control the airborne dusts by using an induced air flow in close proximity to the point of dust generation (local exhaust zone) to entrain fugitive airborne dusts.

(2) Ducting — piping, tubing, fabricated duct, ~~etc.~~ and so forth , used to provide the controlled pathway from the hoods to the dust collector (AMS). Maintaining adequate duct velocity ~~(~~ [usually 4000 ~~fpm~~ ft/min (20.3 m/sec) or higher~~)~~] is a key factor in the proper functioning of the system.

(3) Dust collector — an AMS designed to filter the conveyed dusts from the conveying air stream. Usually these devices have automatic methods for cleaning the filter media to allow extended use without blinding. In some systems, a scrubber or similar device is used in place of the filter unit.

(4) Fan package — an AMD designed to induce the air flow through the entire system.

The system is designed to collect only suspended dusts at the point of generation and not dusts at rest on surfaces. The system is also not designed to convey large amounts of dusts as the system design does not include friction loss due to solids loading in the pressure drop calculation. Thus, material loading must be minimal compared to the volume or mass of air flow.

[**~~654~~ 660** ,~~2020~~ 2025]

Submitter Information Verification

Committee: CMD-HAP

Submittal Date: Fri Aug 09 22:31:24 EDT 2024

Committee Statement

Committee Statement: NFPA 652 and NFPA 654 are being consolidated into NFPA 660.

Response Message: SR-6-NFPA 91-2024

Second Revision No. 15-NFPA 91-2024 [New Section after 3.3.9]

3.3.12* Hybrid Mixture.

An explosible heterogeneous mixture, comprising gas with suspended solid or liquid particulates, in which the total flammable gas concentration is ≥10 percent of the lower flammable limit (LFL) and the total suspended particulate concentration is ≥10 percent of the minimum explosible concentration (MEC). [**68**, 2023]

A.3.3.12 Hybrid Mixture.

The presence of flammable gases and vapors, even at concentrations less than the lower flammable limit (LFL) of the flammable gases and vapors, adds to the violence of a dust-air combustion.

The resulting dust-vapor mixture is called a *hybrid mixture* and is discussed in NFPA 68 . In certain circumstances, hybrid mixtures can pose a flash fire or explosion hazard, even if the dust is below the MEC and the vapor is below the LFL. Furthermore, dusts determined to be nonignitible by weak ignition sources can sometimes be ignited when part of a hybrid mixture.

Examples of hybrid mixtures are a mixture of methane, coal dust, and air or a mixture of gasoline vapor and gasoline droplets in air.

[**660**, 2025]

Submitter Information Verification

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Committee Statement

Committee Statement: Since the scope statement has been modified, the definitions of combustible particulate solid, combustible dust, and hybrid mixture are added to aid in application.

Response Message: SR-15-NFPA 91-2024

Second Revision No. 7-NFPA 91-2024 [Section No. 3.3.12]

3.3.15* Minimum Explosible Concentration (MEC).

The minimum concentration of a combustible dust suspended in air, measured in mass per unit volume, that will support a deflagration. [~~**652**~~ **660** ,~~2019~~ 2025]

A.3.3.15 Minimum Explosible Concentration (MEC).

Minimum explosible concentration is defined by the test procedure in ASTM E1515, *Standard Test Method for Minimum Explosible Concentration of Combustible Dusts*. MEC is ~~equivalent~~ analogous to the lower flammable limit for flammable gases. Because it has been customary to limit the use of the lower flammable limit to flammable vapors and gases, an alternative term is necessary for combustible dusts. ~~[**652,** 2019]~~

The MEC is dependent on many factors, including particulate size distribution, chemistry, moisture content, and shape. Consequently, designers and operators of processes that handle combustible particulate solids should consider those factors when applying existing MEC data. Often, the necessary MEC data can be obtained only by testing.

[~~**652**~~ **660** ,~~2019~~ 2025]

Submitter Information Verification

Committee: CMD-HAP

Submittal Date: Fri Aug 09 22:35:11 EDT 2024

Committee Statement

Committee Statement: NFPA 654 is being consolidated into NFPA 660.

Response Message: SR-7-NFPA 91-2024

Second Revision No. 8-NFPA 91-2024 [Section No. 3.3.15]

3.3.18* Pneumatic Conveying System.

An equipment system that transfers a controlled flow of solid particulate material from one location to another using air or other gases as the conveying medium, and that is comprised of the following components: a material feeding device; an enclosed ductwork, piping, or tubing network; an air-material separator; and an air-moving device. [~~652~~ 660 , ~~2019~~ 2025]

A.3.3.18 Pneumatic Conveying System.

Pneumatic conveying systems include a wide range of equipment systems utilizing air or other gases to transport solid particles from one point to another. A typical system comprises the following:

(1) A device used to meter the material into the conveying air stream

(2) Piping, tubing, hose, etc., used to provide the closed pathway from the metering device to the AMS

(3) An AMS designed for the separation of comparatively large amounts of material from the conveying air/gas stream

(4) An additional metering device (typically a rotary airlock valve or similar device) that might be used to allow discharge of the separated material from the conveying air stream without affecting the differential pressure of the system

(5) An AMD designed to produce the necessary pressure differential and air/gas flow in the system (positive or negative)

A pneumatic conveying system requires the amount of material conveyed by the system to be considered as a major factor in the system pressure drop calculations.

Both positive and negative (i.e., vacuum) differential pressure are used for pneumatic conveying. The decision of which is the best for a specific application should be based ~~on~~ upon a risk analysis, equipment layout, and other system operational and cost factors.

Dense phase conveying can also be considered for the application, especially with more hazardous materials (e.g., low MIE). The inherent design and operational features of this approach can provide significant safety and operational advantages over other types of pneumatic conveying systems.

For high-risk materials (e.g., some metal powders with low MIE), the use of a “closed-loop” pneumatic conveying system (i.e., dilute, dense, or semi-dense phase) with a suitable inert gas as the conveying medium is a feasible approach for transferring such materials from one location to another. Special design considerations could be necessary.

[~~654~~ 660 , ~~2020~~ 2025]

Supplemental Information

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Submitter Information Verification

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Committee Statement

Committee Statement: NFPA 654 and NFPA 652 are being consolidated into NFPA 660.

Response Message: SR-8-NFPA 91-2024

Second Revision No. 20-NFPA 91-2024 [Section No. 4.2.3 [Excluding any Sub-Sections]]

Unless the circumstances stipulated in 4.2.3.1, 4.2.3.2, or 4.2.3.3 exist, ~~in systems conveying flammable vapors, gases, or mists, the concentration shall not exceed 25 percent of the LFL.~~ the following concentration limits shall apply:

(1) In systems conveying flammable vapors, gases, or mists, the concentration shall not exceed 25 percent of the LFL.

(2) In systems conveying combustible particulate solids, the concentration shall not exceed 25 percent of the MEC.

(3) In systems conveying hybrid mixtures, the combined percentage of the lower flammable limit (LFL) of flammable vapors and the percentage of the minimum explosible concentration (MEC) of combustible dusts shall not exceed 25 percent.

Supplemental Information

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Submitter Information Verification

Committee: CMD-HAP

Submittal Date: Tue Aug 13 13:40:05 EDT 2024

Committee Statement

Committee Statement: This standard applies to more than just flammable vapors, gases, and mists, and the other materials were not addressed by this statement. The other concentration limits needed to be clarified.

Response Message: SR-20-NFPA 91-2024

Second Revision No. 2-NFPA 91-2024 [Section No. 4.5.9]

4.5.9*

~~All ductwork shall be sized to provide the air volume and air velocity necessary to keep the duct interior clean and free of residual material. [**654:** 9.3.3.2.6.6]~~ The system shall be designed and maintained to ensure that the air-gas velocity used meets or exceeds the minimum required to keep the interior surfaces of all piping or ducting free of accumulations under all normal operating modes. [**660:** 9.4.3.1.1]

A.4.5.9

The minimum gas velocity to transport materials varies considerably due to the material characteristics, conveying rates, conveying distances, and other factors. If the velocity falls below the minimum requirement, plugging and other upset conditions could occur and lead to an unsafe operating condition. Typically the minimum gas velocities are established by testing or are based on existing data from the system designer or vendor.

Dust collection systems and centralized vacuum cleaning systems handling combustible dusts usually use branched duct networks with multiple pickup points and variable material loading. In contrast, dilute phase and dense phase pneumatic conveying systems are typically linear systems with controlled infeed and consistent material loading. Dust collection systems for combustible dusts represent a significant increase in deflagration risk compared with most pneumatic conveying systems. A properly designed system is critical to minimizing that risk. For guidance on determining proper dust collection system design, refer to the ACGIH publication, *Industrial Ventilation: A Manual of Recommended Practice* ~~*for Design*~~ . ~~[**654:** A.9.3.3.2.6.6]~~

According to *Industrial Ventilation: A Manual of Recommended Practice* , the duct air velocity can range from a minimum of 3500 fpm (18 m/sec) to significantly higher levels. However, that document is for all dusts, including noncombustible dusts. A velocity of 4000 fpm (20 m/sec) is recommended as a minimum value for the conveying of combustible dusts. Also, some combustible dusts have material characteristics (e.g., cohesiveness, adhesiveness, particle shape and size, particle density) that require significantly higher duct velocities to minimize the possibility of accumulations in the ducts.

[**660:** A.9.4.3.1.1]

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Submitter Information Verification

Committee: CMD-HAP

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Committee Statement

Committee Statement: NFPA 654 is being consolidated into NFPA 660.

Response Message: SR-2-NFPA 91-2024

Second Revision No. 18-NFPA 91-2024 [Section No. 7.1.1]

7.1.1

Air–material separators ~~handling both noncombustible particulates as well as a flammable gas, vapor, or mist~~ shall comply with the requirements of all relevant sections in this chapter.

Submitter Information Verification

Committee: CMD-HAP

Submittal Date: Tue Aug 13 12:15:36 EDT 2024

Committee Statement

Committee Statement: At one time, NFPA 91 did not cover combustible particulate solids, but the scope was revised in 1999 to cover both combustible and noncombustible particulates.

Response Message: SR-18-NFPA 91-2024

Second Revision No. 9-NFPA 91-2024 [Section No. 8.2.3.1]

8.2.3.1

Nonconductive system components shall be permitted where all of the following conditions are met:

(1)* Hybrid mixtures and flammable gas/vapor atmospheres are not present.

A.8.2.3.1(1)

This requirement is intended to prevent ignition of hybrid mixtures or flammable gas/vapor atmospheres by brush discharges from nonconductive surfaces. [~~**652**~~ **660** :A.~~9.4.7.1.2~~ 9.6.6.1.2 (1)]

(2)* Conductive particulate solids are not handled.

A.8.2.3.1(2)

This requirement is intended to prevent ignition of combustible dusts by the isolation of conductive particulate solids where they can accumulate charge and create capacitive spark discharges to grounded conductive objects. [~~**652**~~ **660** :A.~~9.4.7.1.2~~ 9.6.6.1.2 (2)]

(3)* The nonconductive components do not result in isolation of conductive components from ground.

A.8.2.3.1(3)

This requirement is intended to prevent ignition of combustible dusts by capacitive sparks from isolated process equipment. [~~**652**~~ **660** :A.~~9.4.7.1.2~~ 9.6.6.1.2 (3)]

(4)* The breakdown strength across nonconductive sheets, coatings, ~~or~~ membranes, or pipe/vessel wall with thickness less than 0.3 in. (8 mm) does not exceed 4 kV, and the breakdown strength across nonconductive woven ~~objects~~ materials does not exceed 6 kV, when used in high surface charging processes.

A.8.2.3.1(4)

This requirement is intended to prevent ignition of combustible dusts by propagating brush discharges. Pneumatic conveying ~~is an~~ and milling are examples of ~~a~~ process operations that can generate high surface charging. [~~**652**~~ **660** :A.~~9.4.7.1.2~~ 9.6.6.1.2 (4)]

[~~**652**~~ **660** :~~9.4.7.1.2~~ 9.6.6.1.2]

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Submitter Information Verification

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Committee Statement

Committee Statement: NFPA 652 is being consolidated into NFPA 660.

Response Message: SR-9-NFPA 91-2024

Second Revision No. 19-NFPA 91-2024 [Section No. A.7.2]

A.7.2

~~Combustible particulate solids are outside the scope of this document.~~ If the system is handling a combustible particulate solid, refer to NFPA ~~654~~ 660 for additional guidance .

Submitter Information Verification

Committee: CMD-HAP

Submittal Date: Tue Aug 13 12:16:33 EDT 2024

Committee Statement

Committee Statement: At one time, NFPA 91 did not cover combustible particulate solids, but the scope was revised in 1999 to cover both combustible and noncombustible particulates, so the first sentence conflicts with the current scope.

Response Message: SR-19-NFPA 91-2024

Second Revision No. 13-NFPA 91-2024 [Section No. B.1.2.1]

B.1.2.1 ACGIH Publications.

American Conference of Governmental Industrial Hygienists, 3640 Park 42 Drive, Cincinnati, OH 45241.

Industrial Ventilation: A Manual of Recommended Practice ~~for Design~~ , ~~31st edition,~~ 2023.

Submitter Information Verification

Committee: CMD-HAP

Submittal Date: Tue Aug 13 11:45:25 EDT 2024

Committee Statement

Committee Statement: "A Manual of Recommended Practice for Design" and "A Manual of Recommended Practice for Operation and Maintenance" are bundled together by ACGIH and should not be listed separately in this annex. Also see SR no. 12

Response Message: SR-13-NFPA 91-2024

Second Revision No. 12-NFPA 91-2024 [Section No. B.2]

B.2 Informational References. (Reserved)

~~The following documents or portions thereof are listed here as informational resources only. They are not a part of the requirements of this document.~~

~~*Industrial Ventilation: A Manual of Recommended Practice for Operation and Maintenance* , 2007.~~

Submitter Information Verification

Committee: CMD-HAP

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Committee Statement

Committee Statement: "A Manual of Recommended Practice for Design" and "A Manual of Recommended Practice for Operation and Maintenance" are bundled together by ACGIH and should not be listed separately in this annex. See SR no. 13

Response Message: SR-12-NFPA 91-2024

Second Revision No. 10-NFPA 91-2024 [Section No. B.3]

B.3 References for Extracts in Informational Sections.

NFPA 68, *Standard on Explosion Protection by Deflagration Venting*, 2023 edition.

NFPA 329, *Recommended Practice for Handling Releases of Flammable and Combustible Liquids and Gases*, ~~2020~~ 2025 edition.

~~NFPA 652 , *Standard on the Fundamentals of Combustible Dust* , 2019 edition~~

~~NFPA 654 , *Standard for the Prevention of Fire and Dust Explosions from the Manufacturing, Processing, and Handling of Combustible Particulate Solids* , 2020 edition.~~

NFPA 660 , *Standard for Combustible Dusts and Particulate Solids* , 2025 edition.

NFPA 5000®, *Building Construction and Safety Code®*, 2024 edition.

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Committee Statement: This revision updates extracted text in accordance with the Extract Policy. For substantiation on any changes, see the first and second draft reports for the source document.

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