



Standard Specification for Shipboard Incinerators¹

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1. Scope

1.1 This specification covers the design, manufacture, performance, operation, functioning, and testing of incinerators intended to incinerate garbage and other shipboard wastes generated during the ship's normal service (that is, maintenance, operational, domestic, and cargo-associated wastes).

1.2 This specification is a companion document to Guide F 1322.

1.3 This specification applies to those incinerator plants with capacities up to 1500 kW per unit.

1.4 Additional information is given in Appendixes Appendix X1-Appendix X5.

1.5 This specification does not apply to systems on special incinerator ships, for example, for burning industrial wastes such as chemicals, manufacturing residues, and so forth.

1.6 This specification does not address the electrical supply to the unit, nor the foundation connections and stack connections.

1.7 This specification does not cover emissions requirements.

1.8 *This standard does not purport to address all of the safety concerns associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.* See 4.8.

2. Referenced Documents

2.1 ASTM Standards:

F 1322 Guide for Selection of Shipboard Incinerators²

2.2 ANSI Standard:

B 31.1 Power Piping³

ANSI/NFPA No. 70 National Electrical Code³

Article 430-7³

2.3 ASME Boiler and Pressure Vessel Code:

Section I, Power Boilers⁴

Section IX, Welding and Brazing Qualification⁴

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² *Annual Book of ASTM Standards*, Vol 01.07.

³ Available from the American National Standards Institute, 11 W. 42nd St., 13th Floor, New York, NY 10036.

⁴ Available from the American Society of Mechanical Engineers, 345 E. 47th St., New York, NY 10017.

2.4 Underwriter's Laboratory Standards:

UL 506 Standard for Specialty Transformers⁵

UL 814 Standard for Gas-Tube Signs and Ignition Cables⁵

2.5 Safety of Life at Sea Convention:

SOLAS 74 International Convention for the Safety of Life at Sea³

2.6 Other Documents:

International Convention for the Preventing of Pollution from Ships, 1973, as modified by the Protocol of 1978 (MARPOL 73/78)⁶

NOTE 1—Incinerators designed and manufactured in accordance with alternative standards must show compliance with this specification.

3. Terminology

3.1 Definitions:

3.1.1 *cargo-associated waste*—all materials that have become wastes as a result of use on board a ship for cargo stowage and handling. Cargo-associated waste includes but is not limited to dunnage, shoring pallets, lining and packing materials, plywood, paper, cardboard, wire, and steel strapping.

3.1.2 *cargo residues*—for the purposes of this specification, the remnants of any cargo material on board that cannot be placed in proper cargo holds (loading excess and spillage) or which remain in cargo holds and elsewhere after unloading procedures are completed (unloading residual and spillage). However, cargo residues are expected to be in small quantities.

3.1.3 *domestic waste*—all types of food wastes, sewage, and wastes generated in the living spaces on board the ship.

3.1.4 *fishing gear*—any physical device or part thereof or combination of items that may be placed on or in the water with the intended purpose of capturing, or controlling for subsequent capture, living marine or freshwater organisms.

3.1.5 *food wastes*—any spoiled or unspoiled victual substances, such as fruits, vegetables, dairy products, poultry, meat products, food scraps, food particles, and all other materials contaminated by such wastes, generated aboard ship, principally in the galley and dining areas.

3.1.6 *garbage*—all kinds of victual, domestic, and operational waste excluding fresh fish and parts thereof, generated during the normal operation of the ship and liable to be disposed of continuously or periodically. Those substances

⁵ Available from Underwriter's Laboratories, Inc., 333 Pfingsten Rd., Northbrook, IL 60062.

⁶ Available from the International Maritime Organization, 4 Albert Embankment, London SE1 7SR, UK.

which are defined or listed in Annexes, other than Annex V, to the International Convention for the Preventing of Pollution From Ships, 1973, as modified by the Protocol of 1978 (MARPOL 73/78) are excluded.

3.1.7 *incinerator*—shipboard facilities for incinerating solid wastes approximating in composition to household waste and liquid wastes arising from the operation of the ship, for example, domestic waste, cargo-associated waste, maintenance waste, operational waste, cargo residues, and fishing gear, and so forth. These facilities may be designed to use or not to use the heat energy produced.

3.1.8 *maintenance waste*—materials collected by the engine department and the deck department while maintaining and operating the ship, such as soot, machinery deposits, scraped paint, deck sweeping, wiping wastes, oily rags, and so forth.

3.1.9 *oily rags*—rags that have been saturated with oil as controlled in Annex I to the Convention. Contaminated rags are rags that have been saturated with a substance defined as a harmful substance in the other Annexes to the Convention.

3.1.10 *operational wastes*—all cargo-associated wastes and maintenance waste (including ash and clinkers) and cargo residues defined as garbage in 3.1.6.

3.1.11 *plastic*—a solid material that contains as an essential ingredient one or more synthetic organic high polymers and is formed (shaped) during either manufacture of the polymer or the fabrication into a finished product by heat or pressure, or both. Plastics have material properties ranging from hard and brittle to soft and elastic. Plastics are used for a variety of marine purposes including, but not limited to, packaging (vapor-proof barriers, bottles, containers, liners), ship construction (fiberglass and laminated structures, siding, piping, insulation, flooring, carpets, fabrics, paints and finishes, adhesives, electrical and electronic components), disposable eating utensils and cups, bags, sheeting, floats, fishing nets, strapping bands, rope, and line.

3.1.12 *ship*—a vessel of any type operating in the marine environment and includes hydrofoil boats, air-cushion vehicles, submersibles, floating craft, and fixed or floating platforms.

3.1.13 *waste*—useless, unneeded, or superfluous matter which is to be discarded.

4. Materials and Manufacture

4.1 Metal parts of the incinerator exposed to the combustion process shall be made of materials listed in Section I of the ASME Boiler and Pressure Vessel Code.

4.2 Where welded construction is used, welded joint design details, welding, and nondestructive testing of the combustion chamber shall be in accordance with Section I of the ASME Code. Welders and weld procedures shall be qualified in accordance with Section IX of the ASME Code.

4.3 Piping and piping components associated with incinerators for fuel, sludge, and liquid cargo residues shall comply with ANSI B31.1 for design and material requirements. Fuel oil pressure piping between service pumps and burners shall have a relief valve fitted which will discharge into the suction line or back into the tank. Pressure piping shall be of seamless steel with a thickness of at least Schedule 80. Short lengths of steel, or annealed copper nickel, nickel copper, or copper pipe

and tubing may be used at the burners. The use of nonmetallic materials for fuel lines is prohibited. Valves and fittings may be threaded in sizes up to and including 2-in. normal pipe size (NPS) (60-mm outside diameter), but threaded unions are not to be used on pressure lines in sizes 1-in. NPS (33-mm outside diameter) and over.

4.4 All rotating or moving mechanical and exposed electrical parts shall be protected against accidental contact. All electrical devices shall be enclosed in drip-proof or watertight enclosures.

4.5 Refractory shall be resistant to thermal shocks and resistant to normal ship's vibration. The refractory design temperature shall be equal to the combustion chamber design temperature plus 20 % (see 5.1).

4.6 Incinerating systems shall be designed such that corrosion will be minimized on the inside of the systems.

4.7 In systems equipped for incinerating liquid wastes, safe ignition and maintenance of combustion shall be ensured, for example, by a supplementary burner using gas oil/diesel oil or equivalent.

4.8 The incinerating furnace may be charged with solid waste either by hand or automatically. In every case, fire dangers must be avoided and charging must be possible without danger to the operating personnel.

4.8.1 For instance, where charging is carried out by hand, a charging lock may be provided that ensures that the charging space is isolated from the fire box as long as the filling hatch is open.

4.8.2 Where charging is not affected through a charging lock, an interlock shall be installed to prevent the charging door from opening while the incinerator is in operation or while the furnace temperature is above 220°C.

4.9 Incinerators equipped with a feeding sluice shall ensure that the material charged will move from the sluice to the combustion chamber. Examples for accomplishing this are the use of a clear path down or a mechanical pusher.

4.10 Interlocks shall be installed to prevent ash removal doors from opening while burning is in progress or while the furnace temperature is above 220°C.

4.11 The incinerator shall be provided with a safe observation port of the combustion chamber to provide visual control of the burning process and waste accumulation in the combustion chamber. Neither heat, flame, nor particles shall be able to pass through the observation port. An example of a safe observation port is high-temperature glass with a metal closure.

4.12 *Electrical Requirements:*

4.12.1 *General*—Installation requirements shall apply to controls, safety devices, and burners on incinerators.

4.12.1.1 A disconnecting means capable of being locked in the open position shall be installed at an accessible location at the incinerator so that the incinerator can be disconnected from all sources of potential. This disconnecting means shall be an integral part of the incinerator or adjacent to it (see 6.1).

4.12.1.2 All uninsulated live metal parts and all rotating or moving parts that may cause injury shall be guarded to avoid accidental contact.

4.12.1.3 The electrical equipment shall be so arranged so

that failure of this equipment will cause the fuel supply to be shut off.

4.12.1.4 The power supply to the electrical control system shall be from a two-wire branch circuit that has a grounded conductor; otherwise, an isolation transformer with a two-wire secondary shall be provided. When an isolation transformer is provided, one side of the secondary winding shall be grounded.

4.12.1.5 One side of all coils shall be electrically located in the grounded side of the circuit. All switches, contacts, and overcurrent devices shall be electrically located in the ungrounded or "hot" side of the circuit. All electrical contacts of every safety device installed in the same control circuit shall be electrically connected in series. However, special consideration shall be given to arrangements when certain devices are wired in parallel.

4.12.1.6 All electrical components and devices shall have a voltage rating commensurate with the supply voltage of the control system.

4.12.1.7 All electrical devices shall be at least NEMA Type 2 (Driptight). Electric equipment exposed to the weather shall be at least NEMA Type 4.

4.12.1.8 All electrical and mechanical control devices shall be of a type tested and accepted by a nationally recognized testing agency.

4.12.1.9 The design of the control circuits shall be such that limit and primary safety controls shall directly open a circuit that functions to interrupt the supply of fuel to combustion units.

4.12.2 *Overcurrent Protection:*

4.12.2.1 Conductors for interconnecting wiring that is smaller than the supply conductors shall be provided with overcurrent protection based on the size of the smallest interconnecting conductors external to any control box.

4.12.2.2 Overcurrent protection for interconnecting wiring shall be located at the point where the smaller conductors connect to the larger conductors. However, overall overcurrent protection is acceptable if it is sized on the basis of the smallest conductors of the interconnecting wiring.

4.12.2.3 Overcurrent protection devices shall be accessible and their function shall be identified.

4.12.3 *Motors:*

4.12.3.1 Motors exposed to dripping or spraying oil or water shall be of drip-proof construction. All motors shall be fully guarded as installed.

4.12.3.2 Motors shall be provided with a corrosion-resistant nameplate specifying information in accordance with NEC, Article 430-7.

4.12.3.3 Motors shall be provided with running protection by means of integral thermal protection, by overcurrent devices, or a combination of both in accordance with manufacturer's instructions that shall be based on the requirements of National Electrical Code, NFPA No. 70.

4.12.3.4 Motors shall be rated for continuous duty and shall be designed for an ambient temperature of 122°F (50°C) or higher.

4.12.3.5 All motors shall be provided with terminal leads or terminal screws in terminal boxes integral with, or secured to, the motor frames.

4.12.4 *Ignition System:*

4.12.4.1 When automatic electric ignition is provided, it shall be accomplished by means of either a high-voltage electric spark, a high-energy electric spark, or a glow coil.

4.12.4.2 Ignition transformers shall conform to requirements of the UL Standard 506.

4.12.4.3 Ignition cable shall conform to requirements of the UL Standard 814.

4.12.5 *Wiring:*

4.12.5.1 All wiring for incinerators shall be rated for the maximum operating temperature to which it may be exposed. Such wiring shall be in accordance with National Electrical Code, NFPA No. 70. All wiring between components shall have copper conductors not less than size No. 18 AWG and constructed in accordance with the National Electrical Code, NFPA No. 70.

4.12.5.2 All electrical wiring shall have a voltage rating commensurate with the voltage of the power supply.

4.12.5.3 Conductors shall be protected from physical damage where appropriate.

4.12.5.4 Conductors shall be sized on the basis of the rated current of the load they supply.

4.12.6 *Bonding and Grounding:*

4.12.6.1 Means shall be provided for grounding the major metallic frame or assembly of the incinerators.

4.12.6.2 Noncurrent carrying enclosures, frames, and similar parts of all electrical components and devices shall be bonded to the main frame or assembly of the boiler. Electrical components that are bonded by their installation do not require a separate bonding conductor.

4.12.6.3 When an insulated conductor is used to bond electrical components and devices, it shall show a continuous green color, with or without a yellow stripe.

5. Operating Requirements

5.1 The incinerator system shall be designed and constructed for operation with the following conditions:

Maximum combustion chamber temperature	2190°F (1200°C)
Minimum combustion chamber temperature	1560°F (850°C)
Preheat temperature of combustion chamber	1200°F (650°C)

For batch loaded incinerators, there are no preheating requirements. However, the incinerator shall be so designed that the temperature in the actual combustion space shall reach 1110°F (600°C) within 5 min after start.

Prepurge, before ignition	at least four air changes in the chamber(s) and stack, but not less than 15 s
Time between restarts	at least four air changes in the chamber(s) and stack, but not less than 15 s
Postpurge, after shutoff of fuel oil	not less than 15 s after the closing of the fuel oil valve
Incinerator discharge gases	min 6 % O ₂ (measured in dry flue gas)

5.2 Outside surface of combustion chamber(s) shall be shielded from contact such that people would not be exposed to extreme heat (maximum 68°F (20°C) above ambient temperature) or direct contact of surface temperatures exceeding 140°F (60°C). Examples for alternatives to accomplish this are a double jacket with an air flow in between or an expanded metal jacket.

5.3 Incinerating systems are to be operated with underpressure (negative pressure) in the combustion chamber such that no gases or smoke can leak out to the surrounding areas.

5.4 The incinerator shall have warning plates attached in a

prominent location on the unit, warning against unauthorized opening of doors to combustion chamber(s) during operation and against overloading the incinerator with garbage.

5.5 The incinerator shall have instruction plate(s) attached in a prominent location on the unit that clearly addresses the following:

5.5.1 Cleaning ashes and slag from the combustion chamber(s) and cleaning of combustion air openings before starting the incinerator (where applicable).

5.5.2 Operating procedures and instructions.

5.6 To avoid the buildup of dioxins, the flue gas should be shock-cooled to a maximum 660°F (350°C) within 2.5 m from the combustion chamber flue gas outlet.

6. Operating Controls

6.1 The entire unit shall be disconnected from all sources of electricity by means of one disconnect switch located near the incinerator (see 4.12.1.1).

6.2 There shall be an emergency stop switch located outside the compartment which stops all power to the equipment. The emergency stop switch shall also be able to stop all power to the fuel pumps. If the incinerator is equipped with an induced draft fan, the fan shall be capable of being restarted independently of the other equipment on the incinerator.

6.3 The control equipment shall be so designed that any failure of the following equipment will prevent continued operations and cause the fuel supply to be cut off.

6.3.1 Safety Thermostat/Draft Failure:

6.3.1.1 A flue gas temperature controller, with a sensor placed in the flue gas duct, shall be provided that will shut down the burner if the flue gas temperature exceeds the temperature set by the manufacturer for the specific design.

6.3.1.2 A combustion temperature controller, with a sensor placed in the combustion chamber, shall be provided that will shut down the burner if the combustion chamber temperature exceeds the maximum temperature.

6.3.1.3 A negative pressure switch shall be provided to monitor the draft and the negative pressure in the combustion chamber. The purpose of this negative pressure switch is to ensure that there is sufficient draft in the incinerator during operations. The circuit to the program relay for the burner shall be opened and an alarm activated before the negative pressure rises to atmospheric pressure. This is applicable to incinerators fitted with induced draft fans.

6.3.2 Flame Failure/Fuel Oil Pressure:

6.3.2.1 The incinerator shall have a flame safeguard control consisting of a flame-sensing element and associated equipment for shut down of the unit in the event of ignition failure and flame failure during the firing cycle. The flame safeguard control shall be so designed that the failure of any component will cause a safety shutdown and prevent automatic restarting.

6.3.2.2 The flame safeguard control shall be capable of closing the fuel valves in not more than 4 s after a flame failure.

6.3.2.3 The flame safeguard control shall provide a trial-for-ignition period of not more than 10 s during which fuel may be supplied to establish flame. If flame is not established within 10 s, the fuel supply to the burners shall be immediately shut off automatically. Where a light oil pilot is used, the flame safeguard control shall provide a trial-for-ignition period for

the pilot of not more than 10 s. If flame is not established within 10 s, the fuel supply to the pilot shall be immediately shut off automatically.

6.3.2.4 Whenever the flame safeguard control has operated because of failure of ignition, flame failure, or failure of any component, manual reset of the flame safeguard control shall be required for restart.

6.3.2.5 Flame safeguard controls of the thermostatic type, such as stack switches and pyrostats operated by means of an open bimetallic helix, are prohibited.

6.3.2.6 If fuel oil pressure drops below that set by the manufacturer, a failure and lock out of the program relay shall result. This also applies to a sludge oil burner. (Applies where pressure is important for the combustion process or where a pump is not an integral part of the burner.)

6.3.3 *Motor Overload*—All motors shall be protected in all phases by a thermal overload relay or circuit breaker with thermal overload protection which must be reset manually (see 4.12.3.3).

6.3.4 If there is a loss of power to the incinerator control/ alarm panel (not remote alarm panel), the system shall shut down.

6.4 *Fuel Supply*—Two fuel control solenoid valves shall be provided in series in the fuel supply line to each burner. On multiple burner units, a valve on the main fuel supply line and a valve at each burner will satisfy this requirement. The valves shall be connected electrically in parallel so that both operate simultaneously.

6.5 Alarms:

6.5.1 When a failure occurs, an audible alarm shall be automatically sounded. A visible indicator shall show what caused the failure. (Alarm may be provided by the user and indicator may cover more than one fault condition.)

6.5.2 Means shall be provided to silence the audible alarm. The visible indicators shall be designed so that, where failure is a safety related shutdown, manual reset is required.

6.6 After shutdown of the oil burner, the exhaust fan or ejector must continue to run until the fire box has cooled sufficiently. This does not apply in the case of an emergency manual trip.

7. Other Requirements

7.1 *Documentation*—A complete instruction and maintenance manual with drawings, electric diagrams, spare parts list, and so forth shall be furnished with each incinerator.

7.2 *Installation*—All devices and components shall, as fitted in the ship, be designed to operate when the ship is upright and when inclined at any angle of list up to and including 15° either way under static conditions and 22.5° under dynamic conditions (rolling) either way and simultaneously inclined dynamically (pitching) 7.5° by bow or stern.

7.3 Incinerator:

7.3.1 Incinerators are to be fitted with a pilot burner with sufficient energy to ensure a safe ignition and combustion. The combustion is to take place at sufficient negative pressure in the combustion chamber(s) to ensure no gases or smoke leaking out to the surrounding areas (see 6.3.1.3).

7.3.2 A drip tray is to be fitted under each burner and under

any pumps, strainers, and so forth that require occasional examination.

8. Tests

8.1 *Prototype Tests*—An operating test for the prototype of each design shall be conducted, with a test report completed indicating results of all tests. The tests shall be conducted to ensure that all of the control components have been properly installed and that all parts of the incinerator, including controls and safety devices, are in satisfactory operating condition. Tests shall include those described in 8.3.

8.2 *Factory Tests*—For each unit, if preassembled, an operating test shall be conducted to ensure that all of the control components have been properly installed and that all parts of the incinerator, including controls and safety devices, are in satisfactory operating condition. Tests shall include those described in 8.3.

8.3 *Installation Tests*—An operating test after installation shall be conducted to ensure that all of the control components have been properly installed and that all parts of the incinerator, including controls and safety devices, are in satisfactory operating condition. The requirements for prepurge and time between restarts referred to in 5.1 shall be verified at the time of the installation test.

8.3.1 *Flame Safeguard*—The operation of the flame safeguard system shall be verified by causing flame and ignition failures. Operation of the audible alarm and visible indicator shall be verified. The shutdown times shall be verified.

8.3.2 *Limit Controls*—Shutdown as a result of the operation of the limit controls shall be verified.

8.3.2.1 *Oil Pressure Limit Control*—The lowering of the fuel oil pressure below the value required for safe combustion shall initiate a safety shutdown.

8.3.2.2 *Other Interlocks*—Other interlocks provided shall be tested for proper operation as specified by the unit manufacturer.

8.3.3 *Combustion Controls*—The combustion control shall be stable and operate smoothly.

8.3.4 *Programming Controls*—Programming controls shall be verified as controlling and cycling the unit in the intended manner. Proper prepurge, ignition, postpurge, and modulation shall be verified. A stopwatch shall be used for verifying intervals of time.

8.3.5 *Fuel Supply Controls*—The satisfactory operation of the two fuel control solenoid valves for all conditions of operation and shutdown shall be verified.

8.3.6 *Low-Voltage Test*—A low-voltage test shall be conducted on the incinerator unit to demonstrate satisfactorily that the fuel supply to the burners will be automatically shut off before an incinerator malfunction results from the reduced voltage.

8.3.7 *Switches*—All switches shall be tested to verify proper operation.

9. Inspections

9.1 The manufacturer shall afford the purchaser's inspector all reasonable facilities necessary to satisfy him that the material is being furnished in accordance with this specification. Inspection by the purchaser shall not interfere unnecessarily with the manufacturer's operations. All examinations and inspections shall be made at the place of manufacture, unless otherwise agreed upon.

10. Certification

10.1 Manufacturer's certification that an incinerator has been constructed in accordance with this specification shall be provided (by letter, certificate, or in the instruction manual).

11. Product Marking

11.1 Each incinerator shall be permanently marked indicating:

11.1.1 Manufacturer's name or trademark.

11.1.2 Style, type, model, or other manufacturer's designation for the incinerator.

11.1.3 Capacity to be indicated by net designed heat release of the incinerator in heat units per timed period; for example, British Thermal Units per hour, megajoules per hour, kilocalories per hour.

11.1.4 ASTM designation of this specification (F 1323).

12. Quality Assurance

12.1 Incinerators shall be designed, manufactured, and tested in a manner that ensures they meet the requirements of this specification.

12.2 The incinerator manufacturer shall maintain the production quality of the incinerators that are designed, tested, and marked in accordance with this specification. At no time shall an incinerator be sold with this standard designation that does not meet the requirements herein (see Certification).

APPENDIXES**(Nonmandatory Information)****X1. LOCATION REQUIREMENTS FOR INCINERATORS**

X1.1 Incinerators for sludge oil may be installed in the engine room or in a separate room. Incinerators for garbage installed in the engine room should receive due attention to size and location of the incinerator. If the incinerator is installed in a separate room outside the engine room, bulkheads and decks of this room are to be A-class boundaries insulated in accordance with the requirements for Category A machinery spaces, as defined by SOLAS 1974, as amended in Chapter II-2, Regulation 3. This requirement shall apply regardless of the type of vessel construction used (that is, Methods IC, IIC, IIIC as defined in SOLAS II-2, Regulation 42) and regardless of whether the vessel is required to meet SOLAS or to be approved or certified by the cognizant government authority.

X1.2 On certified vessels or those meeting SOLAS, both fire detection and extinguishing systems must be approved by the cognizant government authority. Ventilation ducts shall be capable of being closed by means of fire dampers, controlled from outside the incinerator room, of sufficient construction to

maintain the A-class boundary. Emergency stop of oil burner and oil-booster pumps shall also be arranged outside the room.

X1.3 Flue gas uptakes and surfaces of incinerators are not to be less than 500 mm from fuel, oil tanks, or accommodation bulkheads. Flue gas uptake and exhaust pipe are to be insulated and located well away from electrical installations and inflammable items. Exhaust pipes in the casing are to be led to the top of the funnel. Exhaust uptakes from incinerators, which are installed in separate rooms outside the engine room, are to be approved in each case.

X1.4 Incinerators and flue gas uptakes are to be located outside of hazardous areas as defined by the applicable rules.

X1.5 The flue lines of incinerating systems shall not open into the flues or exhaust lines of other equipment but must be arranged separately to the point of discharge.

X1.6 Garbage chutes shall comply with the same fire standards as incinerator rooms outside engine rooms.

X2. INCINERATORS INTEGRATED WITH HEAT RECOVERY UNITS

X2.1 The flue gas system, for incinerators in which the flue gas is led through a heat recovery unit (economizer), should be designed so that the incinerator can continue operation with the economizer coils dry. This may be accomplished with bypass dampers if needed.

X2.2 The incinerator unit should be equipped with a visual

and audible alarm in case of loss of feed water.

X2.3 The gas side of the economizer should have equipment for proper cleaning. Sufficient access should be provided for adequate inspection of external heating surfaces.

X3. FLUE GAS TEMPERATURE

X3.1 When deciding upon the type of incinerator, consideration should be given as to what the flue gas temperature will be. The flue gas temperature can be a determining factor in the

selection of materials for fabricating the stack. Special high-temperature material may be required for use in fabricating the stack when the flue gas temperatures exceed 775°F (413°C).

X4. DESIGN FOR FUTURE RETROFITS OF AIR EMISSION CONTROL EQUIPMENT

X4.1 Though not a requirement, it is recommended that incinerators be designed with an ability for future retrofits of air emission control equipment to accommodate emission standards for shipboard incinerators as they are developed.

indicated it intends to publish emission standards eventually. In addition, emission standards for state and local jurisdictions vary.

X4.2 The Environmental Protection Agency (EPA) does not currently have emission standards for small shipboard incinerators as described in this specification. However, the EPA has

X4.3 Note that emission control equipment is unnecessary if the incinerator is only operated at sea, not in port or in coastal waters.

X5. SPARK ARRESTORS

X5.1 The incinerator should be so constructed or so equipped as not to permit from the exhaust the passage of spheres having a diameter larger than $\frac{1}{2}$ in. (13.7 mm) nor block the passage of spheres having a diameter of less than $\frac{3}{8}$ in. (9.5 mm).

X5.2 Means should be provided for securely attaching the spark arrestors to chimneys to provide adequate support and prevent movement of the arrestor.

X5.3 Means should be provided to replace spark screens.

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