



Health Department
health@westalliswi.gov
414.302.8600

September 13, 2022

Ronnie K. Janzen, P.E.
President & General Manager
Unit Forgings
1903 South 62nd St.
West Allis, WI 53219

Dear Mr. Janzen,

Regarding the 15-year variance approved by the City of West Allis Common Council on September 6, 2022, you were informed that the terms of the Modified Amended Variance dated August 26, 2011* remain in effect throughout the newly approved 15-year variance. Via email, on September 13, 2022, you responded as President and General Manager of Unit Forgings to be in agreement with continuance of terms of the variance dated August 26, 2011. The amended variance expiration date is September 6, 2037.

*2011 Modified Amended Variance for reference.

Attached to this correspondence are the terms with the amended renewal date.

Sincerely,

Robert Leischow, MPH
Health Commissioner
West Allis Health Department

There is hereby granted to the Unit Drop Forge Co., Inc., together with its successors and assigns, a variance to expire November 22, 2023, during which time the plant will not be cited for violation of Section 7.035 of the Revised Municipal Code of the City of West Allis, and any amendments thereto, subject to the following conditions.

- (1) Except as permitted in this variance, no new or additional forge hammers or other equipment which can reasonably be expected to result in vibration levels exceeding the limits set forth in Chapter 7.035 of the Revised Municipal Code of the City of West Allis relating to noise and vibration shall be installed or utilized, nor shall any modifications be made to existing forge hammers, without prior written approval by the Health Commissioner.
- (2) Operations involving production with, or die-to-die contact of, any or all of the steam-driven drop forge hammers before 7:00 a.m. and after 11:00 p.m., Monday through Saturday, or anytime on Sunday, shall require advance, written approval by the Health Commissioner.
- (3) The Unit Drop Forge Co., Inc., plant shall be subject, upon 48 hours notice, to inspection by the Health Commissioner or his/her agent for compliance with this Modified Amended Variance.
- (4) Unit Drop Forge may install hammers up to 18,000 lb. in size, provided Unit Drop Forge does so within the following parameters:
 - (a.) The West Allis Health Department shall allow the installation of an 18,000 lb. hammer at the site of its current #8006 hammer utilizing a vibration control system designed by GERB Vibration Control Systems Inc.

If independent tests on the above referenced 18,000 lb. hammer installation conducted per (4) (d) satisfy the emission limits for ground-borne vibration set forth in Section 7.035 (3) of the Revised Municipal Code of the City of West Allis, Unit Drop Forge Co., Inc. will be permitted to install additional or replacement hammers larger than 12,000 lbs. and up to 18,000 lbs. hammers utilizing a GERB system, or other vibration control system engineered to yield equivalent/better vibration reduction results.

Independent testing referenced in (4) (d) will be required after all subsequent installations of hammers 12,000 lbs. or larger. Should subsequent installations produce vibration levels that exceed the noise and vibration limitations set forth in Section 7.035 (3) of the Revised Municipal Code of the City of West Allis, written approval must be obtained from the Health Commissioner prior to the installation of all future hammers 12,000 lb. or larger.

- (b) Unit Drop Forge may install additional or replacement 12,000 lb. hammers using foundation design concepts similar to those utilized in the existing 12,000 lb. hammer that it installed at its #8004 site in 1988-89.
 - (c) Fabreeka, Korfund, or similar vibration damping padding materials shall be installed under the new 18,000 lb. hammer and any additional, replacement or relocated hammers in a manner that will maximize the vibration attenuation effect.
 - (d) Tests to determine the magnitude of vibration transmitted from any larger additional or replacement hammer site shall be conducted before and after the installation of the hammer. Test data shall include measurements of frequency and displacement amplitude (in inches). Every effort must be made to minimize the number of variables by producing identical or similar parts under the same manufacturing conditions. The Health Commissioner and management of Unit Drop Forge Co., Inc., shall mutually agree on the selection of the individuals or firm contracted to perform the tests. All costs of this testing shall be the responsibility of Unit Drop Forge Co., Inc.
- (5) Unit Drop Forge Co., Inc., shall not produce forgings larger than the size range currently produced, without prior written approval by the Health Commissioner.
- (6) Unit Drop Forge Co., Inc., shall review and advise the Health Commissioner of advances in the technology of hammer-created ground-borne vibration control and report on said advances, in writing at two-year intervals, with the first report due two years from the date of this modified amended variance.

- (7) It is understood that Unit Drop Forge Co., Inc., retains the right of appeal to the Common Council of the City of West Allis at any time and for any reason during the course of the proceedings as outlined above.
- (8) This Modified Amended Variance may be revoked for material and continuing or intentional violation of, or non-compliance with, any of the terms stated herein.
- (9) This Modified Amended Variance is binding upon Unit Drop Forge Co., Inc. its successors, and assigns.
- (10) This Modified Amended Variance supersedes all prior variances granted for the Unit Drop Forge Co., Inc. production facility at 1903 South 62nd Street, West Allis, Wisconsin.

Issued this 26th day of August, 2011