

108年 職業傷病防治年報





內容

摘要 1

壹、前言

第一章、我國職業傷病服務體系歷史演進 2

第二章、我國職業傷病服務網絡建構歷程 8

貳、臺灣職業傷病防治服務現況

第一章、職業傷病勞工診治服務成果 28

第二章、職災勞工個案管理服務及個案管理師人才培育 33

第三章、辦理過勞專案及職業疾病鑑定案成果 37

參、臺灣職業傷病通報成果

第一章、97 至 108 年職業傷病通報分布情形 48

第二章、防治中心 108 年群聚調查成果：非破壞性檢測游離輻射作業 56

肆、未來展望

伍、附錄一防治中心群聚調查成果 73



圖目錄

| | | |
|------|---|----|
| 圖 1 | 92 年 ILO/WHO/ICOH 推行之基本健康服務系統 (BOHS) 架構之流程圖 | 3 |
| 圖 2 | 職業疾病三段五級預防策略圖 | 4 |
| 圖 3 | 職業傷病防治服務分工架構 | 5 |
| 圖 4 | 職業傷病防治中心成立時間軸 | 10 |
| 圖 5 | 108 年北榮防治中心執行成果 | 12 |
| 圖 6 | 108 年臺大防治中心執行成果 | 13 |
| 圖 7 | 108 年長庚防治中心執行成果 | 14 |
| 圖 8 | 108 年中國醫防治中心執行成果 | 15 |
| 圖 9 | 108 年中山防治中心執行成果 | 16 |
| 圖 10 | 108 年彰基防治中心執行成果 | 17 |
| 圖 11 | 108 年雲分防治中心執行成果 | 18 |
| 圖 12 | 108 年成大防治中心執行成果 | 19 |
| 圖 13 | 108 年高醫防治中心執行成果 | 20 |
| 圖 14 | 108 年慈濟防治中心執行成果量 | 21 |
| 圖 15 | 防治中心分布及特色疾病發展 | 23 |
| 圖 16 | 職業傷病防治服務醫療院所建構家數圖 | 28 |
| 圖 17 | 職業傷病防治服務各區醫療院所開設診次數量圖 | 29 |
| 圖 18 | 職業傷病診治網絡醫院建構家數與開設診次數量圖 | 29 |
| 圖 19 | 歷年職業傷病防治服務醫療院所開設診次 | 30 |
| 圖 20 | 歷年職業傷病防治服務醫療院所開設診次 | 30 |
| 圖 21 | 職業傷病防治服務醫療院所開設診次歷年數量圖 | 31 |
| 圖 22 | 職業傷病防治重建與復工服務歷年個案量 | 32 |
| 圖 23 | 職業傷病防治成功復工之歷年個案量 | 32 |
| 圖 24 | 歷年職業傷病防治個案管理服務數量 | 33 |
| 圖 25 | 職業傷病防治諮詢與轉介服務歷年個案量 | 34 |
| 圖 26 | 職業安全衛生署長官與個案管理師於教育訓練課程前大合照 | 36 |
| 圖 27 | 個案管理師在職教育訓練 | 36 |
| 圖 28 | 100 年至 108 年過勞專案個案基本資料分布情形 | 38 |
| 圖 29 | 108 年過勞專案評估個案行業別分布情形 | 39 |

| | |
|--------------------------------|----|
| 圖 30 職業病鑑定流程圖 | 40 |
| 圖 31 歷年職業疾病勞保給付申請情形 | 45 |
| 圖 32 歷年勞保職業病給付勾稽職業傷病通報系統資料結果 | 45 |
| 圖 33 手臂肩頸疾病勞保職業病給付與通報系統案件數比對結果 | 46 |
| 圖 34 塵肺症勞保職業病給付與通報系統案件數比對結果 | 46 |
| 圖 35 矽肺症勞保職業病給付與通報系統案件數比對結果 | 46 |
| 圖 36 職業性下背痛勞保職業病給付與通報系統案件數比對結果 | 47 |
| 圖 37 歷年職業疾病通報數量 | 48 |
| 圖 38 歷年職業病通報率 | 48 |
| 圖 39 修正聽力通報後之歷年職業病通報率 | 49 |
| 圖 40 歷年平均年齡與男性比 | 49 |
| 圖 41 職業病通報量排名前 10 位之診斷 | 50 |
| 圖 42 歷年石綿暴露促發之職業病通報數 | 54 |
| 圖 43 108 年職業傷病通報系統內之職業傷害通報資料 | 55 |
| 圖 44 職業疾病群聚事件調查流程圖 | 56 |
| 圖 45 中國附醫群聚調查個案歷年健檢紀錄 | 59 |
| 圖 46 RT 作業檢測設備介紹 | 59 |
| 圖 47 放射線檢測作業管制區設置圖 | 60 |
| 圖 48 游離輻射檢測師實際拍攝作業圖 | 61 |
| 圖 49 高醫群聚調查個案放射照相作業 | 65 |
| 圖 50 高醫群聚調查個案沖洗底片作業 | 66 |
| 圖 51 職災勞工保護服務網絡 | 72 |
| 圖 52 中山群聚調查工作現場訪視 | 74 |
| 圖 53 中山群聚調查工作現場訪視 | 75 |
| 圖 54 中山群聚調查工作現場訪視 | 76 |
| 圖 55 中山群聚調查工作現場訪視 | 76 |
| 圖 56 彰基群聚調查工作現場訪視 | 80 |
| 圖 57 美髮勞工工作流程 | 80 |
| 圖 58 彰基群聚調查美髮勞工個案基本資料 | 81 |
| 圖 59 彰基群聚調查美髮從業人員常見罹患疾病 | 82 |
| 圖 60 正中神經滑動運動教學示意圖 | 83 |
| 圖 61 肌腱滑動運動教學示意圖 | 83 |



| | |
|---------------------------------|-----|
| 圖 62 彰基與美髮工會合作進行職業傷病防治宣導 | 84 |
| 圖 63 雲分群聚調查蜆收成作業流程圖 | 86 |
| 圖 64 以 EAWS 風險評估工具評估蜆收成作業測量結果 | 89 |
| 圖 65 雲分群聚調查抬舉作業流程圖 | 90 |
| 圖 66 以 EAWS 風險評估工具評估蜆上岸作業測量結果 | 91 |
| 圖 67 雲分群聚調查蜆篩選及清洗作業流程圖 | 92 |
| 圖 68 以 EAWS 風險評估工具評估請喜及篩選作業測量結果 | 94 |
| 圖 69 蜆上岸篩選作業工作改善建議 | 95 |
| 圖 70 成大群聚調查手工製鞋作業流程說明 | 97 |
| 圖 71 成大群聚調查現場衛教宣導情形 | 102 |
| 圖 72 臺大群聚調查工作現場空氣採樣情形 | 105 |
| 圖 73 長庚群聚調查甲公司工作現場訪視圖 | 109 |
| 圖 74 長庚群聚調查乙公司工作現場訪視圖 | 110 |
| 圖 75 北榮群聚調查工作現場訪視圖 | 123 |

表目錄

| | |
|--|-----|
| 表 1 106-108 年防治中心增（修）訂職業病認定參考指引清單 | 6 |
| 表 2 職業傷病管理服務中心年表 | 8 |
| 表 3 防治中心特色疾病及優勢資源 | 24 |
| 表 4 108 個案管理師訓練課程表 | 35 |
| 表 5 100 年至 108 年過勞專案評估結果 | 38 |
| 表 6 108 年職業疾病鑑定個案情形 | 41 |
| 表 7 92 年至 108 年勞保職業病給付種類及案件數 | 43 |
| 表 8 常見職業病診斷歷年通報人次 | 53 |
| 表 9 常見職業病診斷年齡、性別及行業分佈 | 53 |
| 表 10 常見職業病門診來源及常見通報區域比例 | 54 |
| 表 11 108 年管理服務中心與 10 家防治中心群聚調查成果 | 57 |
| 表 12 中國附醫群聚調查個案基本資料 | 58 |
| 表 13 高醫群聚調查游離輻射作業個案基本資料 | 64 |
| 表 14 高醫群聚調查發病員工與 104 年全國男性罹患白血病的標準化發病比 | 67 |
| 表 15 中山群聚調查個案基本資料 | 73 |
| 表 16 中山群聚調查個案疾病檢查結果 | 73 |
| 表 17 中山群聚調查個案工作暴露分析 | 77 |
| 表 18 彰基群聚調查個案基本資料及罹病情形 | 79 |
| 表 19 雲分群聚調查評估蜆收成手部施力測量結果 | 86 |
| 表 20 KIM-MHO 風險評估工具評估蜆收成手部作業結果 | 87 |
| 表 21 以 KIM-MHO 風險評估工具評估篩選及清洗作業作業結果 | 93 |
| 表 22 成大群聚調查手工製鞋業家庭代工廠作業員之基本資料分析 | 99 |
| 表 23 成大群聚調查手工製鞋業家庭代工廠作業員之年資與工作內容分析 | 100 |
| 表 24 成大群聚調查手工製鞋業家庭代工廠作業員之肌肉骨骼症狀分析 | 100 |



| | |
|--|-----|
| 表 25 成大群聚調查手工製鞋業家庭代工廠作業員肌肉骨骼疾病分析 | 100 |
| 表 26 成大群聚調查手工製鞋業家庭代工廠作業員肌肉骨骼理學檢查結果 | 101 |
| 表 27 臺大群聚調查個案基本資料 | 103 |
| 表 28 長庚群聚個案基本資料 | 107 |
| 表 29 長庚群聚調查個案疾病診斷結果 | 111 |
| 表 30 104-107 年接受健康檢查實驗室人員基本資料與過去健康檢查結果 | 114 |
| 表 31 從事小鼠實驗者過敏性鼻炎與過敏性皮膚炎病史與症狀的勝算比 | 115 |
| 表 32 常做小鼠實驗與有做小鼠實驗者過敏性鼻炎病史與症狀勝算比 | 116 |
| 表 33 常做小鼠實驗與有做小鼠實驗者過敏性皮膚炎病史與症狀勝算比 | 117 |
| 表 34 從事小鼠實驗者氣喘病史、症狀與肺功能異常的勝算比 | 118 |
| 表 35 做小鼠實驗與有做小鼠實驗者氣喘病史與症狀勝算比 | 118 |
| 表 36 健康檢查肺功能異常個案的基本資料及各項健康檢測結果 | 119 |
| 表 37 一氧化碳中毒之 COHb 濃度與臨床症狀對照表 | 121 |
| 表 38 北榮群聚調查個案症狀及血紅素濃度檢測結果 | 122 |
| 表 39 慈濟群聚調查個案基本資料 | 126 |
| 表 40 慈濟群聚調查個案肌肉骨骼症狀發生情形 | 127 |
| 表 41 慈濟群聚調查個案自覺症狀調查結果 | 128 |
| 表 42 慈濟群聚調查個案噪音作業經歷調查結果 | 128 |
| 表 43 慈濟群聚調查個案粉塵作業經歷調查結果 | 129 |
| 表 44 慈濟群聚調查個案聽力及肺功能檢查結果 | 130 |
| 表 45 慈濟群聚調查個案聽力篩檢數值分布情形 | 131 |

摘要

為保障勞工健康與勞動力，勞動部職業安全衛生署於 92 年開始逐年規劃於全國北、中、南、東區醫學中心設置職業傷病防治中心，結合區域網絡醫院，提供勞工友善便利之職業傷病防治服務，服務內容包含：(1) 預防：與相關單位合作宣導職業傷病預防觀念、針對可能出現職業疾病群聚事件之事業單位進行調查與提出改善建議；(2) 診治：提供職業傷病勞工門診及個案管理服務、針對疑似職業疾病罹病勞工進行工作現場訪視調查；(3) 職災重建：與工作強化中心或相關職能復健單位合作，提供職業傷病勞工工作能力評估、復健與復工服務，協助其早日回到職場。

除前述診治服務外，職業傷病防治中心與地區內之事業單位、政府機關及職業工會合作推廣職業傷病防治服務，辦理宣導活動推廣防治觀念、建立轉介服務管道等，提供多面向服務。近年因應國際間重視石綿危害議題，各防治中心積極與院內洽商建立合作轉介機制，發掘罹病個案；另方面透過政府各權責單位建立合作機制，發掘潛在暴露勞工，提供事前預防與保護。

108 年度職業傷病管理服務中心與臺大附醫、臺北榮總、林口長庚、中國附醫、中山附醫、彰基、臺大雲林分院、成大附醫、高醫附醫與花蓮慈濟等 10 家職業傷病防治中心及轄區 83 家網絡醫院，每週提供 280 診次之職業傷病診治服務；職業傷病診治門診服務人次達 26,896 人次；職業疾病通報個案量計 2,204 例；職業傷害通報個案量計 5,000 例；開立 696 份職業疾病評估報告；完成 11 件職業疾病群聚事件調查報告；職業傷病個案管理人數達 3,079 例；提供職業傷病諮詢與轉介個案服務共 10,466 人；轉介個案至相關單位人數計 778 人；院內跨專科合作轉介個案計 6,743 人；協助復工總人數計 1,087 人。

在職業傷病防治中心共同努力之下，職業傷病勞工服務量與職業疾病發現率已有逐年提升，職業傷病管理服務中心與 10 家職業傷病防治中心，將持續推廣職業傷病診治相關服務與提升效能，促進我國勞工健康福祉。



壹、前言

第一章、我國產業發展歷程與勞工健康型態

臺灣日治初期產業以農業與礦石開採業為主，西元 1917 年左右日本財團開始積極投資礦業，使礦產量大增，但煤礦災難意外頻傳，每年死於礦災勞工超過百人，重傷者更超過五百人；戰後的仍以農業為主，但礦業依然是主力產業，惟每年礦區崩塌及爆炸事件時有所聞，直至民國 70 年代後期礦業才逐漸步入夕陽。

民國 50 年代，歐美日等國積極投入戰後重建，環境公害與職業傷病問題也逐漸浮出，引起該國民眾對於環境保護及勞動意識的重視，許多企業紛紛外移至工資低廉且法規管制寬鬆的國家。我國政府於民國 49 年頒布《獎勵投資條例》，積極推展出口導向的經濟政策，透過設置加工出口區，提供土地、廠房、公共設施、租稅減免等優惠措施吸引外商投資，民國 55 年高雄前鎮成立第一座加工出口區，隨後成立高雄楠梓與臺中潭子加工出口區亦陸續營運。

60 年代，伴隨著勞力密集工業的蓬勃發展，重大職業災病事件頻傳，民國 61 至 62 年以「飛歌事件」為首，外商電子廠陸續發生數起有機溶劑集體中毒的死傷事件，經媒體曝光後引發社會關注，並催生了 63 年通過的《勞工安全衛生法》（於 102 年更名為職業安全衛生法），陸續訂頒數項環境與職業衛生相關的法規。

70 年代解嚴前後，國內環保及勞動等社會運動蓬勃發展，臺灣產業結構快速轉型，傳統勞力密集產業外移，工業轉朝資本與技術密集產業發展，服務業就業人口逐漸上升，惟職業傷病議題仍不受社會關注，國內勞工對職業性危害的知識較為薄弱，工業衛生防護未落實，缺乏職前和定期性的健康監測措施，導致許多勞工發生嚴重的職業傷害和疾病。

70 年代以前，因醫師對職業疾病認定的因果關係訓練不足，可利用的職業醫學相關服務資源相對貧乏，在勞工和雇主對職業健康相關知識皆不足的情況下，職業疾病的診斷和認定率相對偏低；民國 71 年自美返國的王榮德教授率先於臺大醫院創設「職業病與環境病門診」，推動臺灣職業醫學的發展。73 年土城海山及瑞芳煤山發生礦災事故，造成三百多人慘遭活埋，核發職災保險死亡給付逾 1.2 億元，為勞保開辦以來最大礦災，敲響煤礦業的喪鐘。同年，《勞動基準法》頒佈施行，規範最低勞動條件標準。77 年，我國服務業就業人口超越工業部門，80 年至 82 年，政府逐步開放外籍移工進入我國勞動市場。

80年代，儘管勞工發生職業災害死亡率有下降的趨勢，但被診斷確診的職業疾病案例卻仍然有限，為改善我國勞工發生職業傷病的問題，提高職業傷病的通報率，當時行政院勞工委員會與行政院衛生署（後改制為勞動部與衛生福利部）分別建立不同體系的通報系統，84年行政院衛生署建立的職業傷病通報系統未具強制性，只有部份職業醫學科專科醫師會通報，與其他先進國家相較仍有不足。

為改善通報問題，提升職業傷病勞工獲得勞保給付的比例，給予更妥善的協助，當時行政院勞工委員會（後改制勞動部，本項業務移由勞動部職業安全衛生署辦理，以下簡稱職業安全衛生署）於92年起逐年規劃於臺灣各區的醫學中心設置職業傷病診治中心（自98年起更名為職業傷病防治中心，以下簡稱防治中心），並結合鄰近區域醫院，就近提供職業傷病診治相關服務。

98年起，參考ILO/WHO/ICOH（國際勞工組織 / 世界衛生組織 / 國際職業衛生委員會）所建議之基本職業健康服務（Basic Occupational Health Service，圖1）原則，各區防治中心試行提供中小型企業（係指雇員少於300名員工之事業單位）職場健康服務，服務內容包括風險及危害評估、健康促進的教育課程、健康檢查管理和後續追蹤、教導個人防護裝備的使用、協助返回職場工作，以及人體工學上的預防諮詢等。

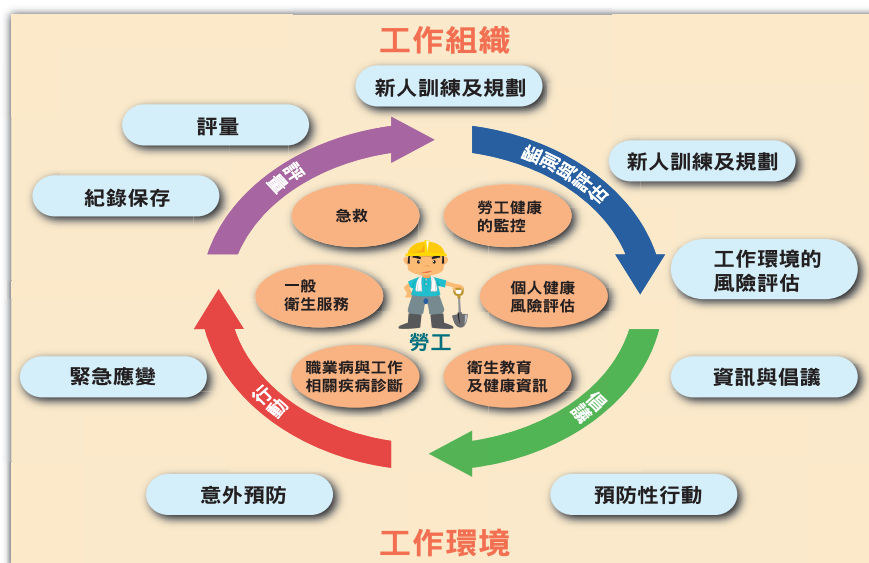


圖 1 92 年 ILO/WHO/ICOH 推行之基本健康服務系統 (BOHS) 架構之流程圖



104 年，職業安全衛生署於我國北、中、南區成立勞工健康服務中心，辦理 300 人以下規模之事業單位職場健康服務係，防治中心追蹤職災勞工個案時如遇有事業單位對於改善勞工的工作環境危害風險控制的需求，則轉介勞工健康服務中心協助評估；或是勞工健康服務中心服務的事業單位，如有勞工個案復工之後狀況仍然不佳，希望能繼續申請醫療期間不能工作的要求，也會將該個案轉介至防治中心進行評估。

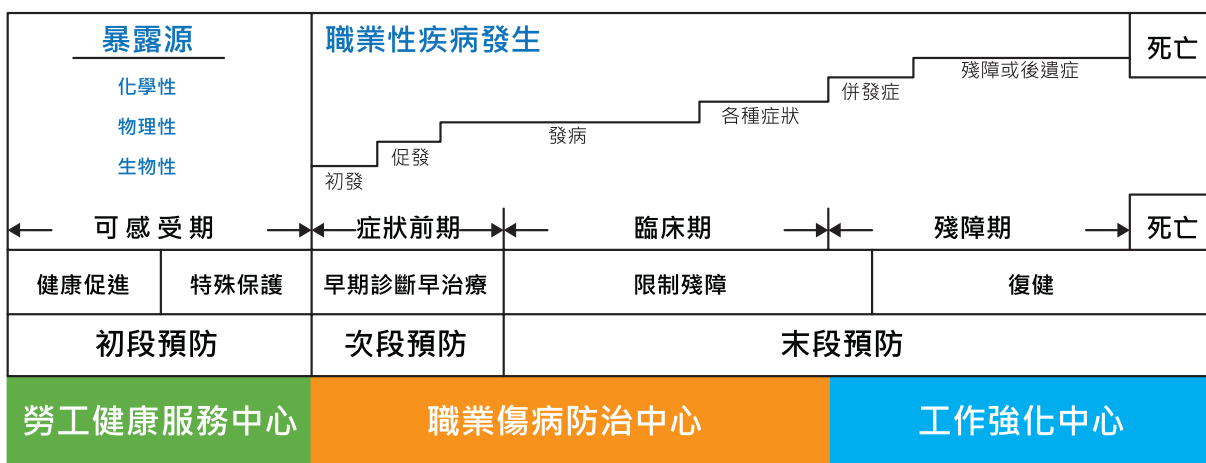


圖 2 職業疾病三段五級預防策略圖

如圖 2 所示，將職業疾病發生與病程搭配公共衛生三段五級預防概念，勞工健康服務中心主責職場健康促進、給予特別危害健康作業從業勞工保護措施；勞工若發生職災或因工作導致身體上不適症狀，便由防治中心協助勞工進行職業傷病評估與診治，協助勞工申請勞保給付並依個案需求轉介至相關單位服務；如遇個案有職能復健需求，則由工作強化中心提供服務，擬定並執行個案需要的重建協助計畫。

為提升我國職業疾病發現率，推廣全國職業傷病防治暨重建網絡，齊一職業傷病服務品質，職業安全衛生署於 96 年起委託辦理「職業傷病管理服務中心計畫」（即職業傷病管理服務中心，以下簡稱管理服務中心），97 年建置完成「職業傷病通報系統」，將各區防治中心之醫療機構納入通報範圍，完成各區防治中心「治療、調查、診斷、通報等服務項目之作業標準」、「服務品質之監督管理」、「擴充發展各區職業傷病防治中心之轄區網絡醫院開設職業疾病門診數」與「修訂常見職業疾病調查作業指引」（表 1）等政策措施，101 年為因應「勞工安全衛生法」、「職業災害勞工保護法」之修正規劃，新增建構職業重建服務網絡、加強職業傷病通報之資安管控措施，期望提供勞工朋友更好的職業傷病診治協助。



圖 3 職業傷病防治服務分工架構





表 1 106-108 年防治中心增(修)訂職業病認定參考指引清單

| 年份 | 職業病認定參考指引 | 負責之防治中心 |
|-------|---|---------|
| 106 年 | 豬丹毒、炭疽病、類鼻疽等疾病認定參考指引 外因性過敏性肺泡炎及其併發症之認定參考指引 職業性過敏性肺炎認定參考指引 煤焦油中毒之認定參考指引 | 臺大 |
| | 鹽酸、硝酸、硫酸引起的職業病之認定參考指引 職業性矽肺症及煤礦工作塵肺症認定參考指引 銻及銻化合物中毒之認定參考指引 | 長庚 |
| | 鎘及其化合物中毒診斷認定參考指引 磷及磷化合物中毒之認定之參考指引 低溫引起之職業病認定參考指引 | 北榮 |
| | 從事醫療業務，由患者之病原體因接觸而引起之法定傳染病以外之傳染性疾病認定參考指引 肺結核之認定參考指引 退伍軍人症之認定參考指引 | 中國 |
| | 恙蟲病之認定參考指引 職業性人類免疫缺乏病毒感染之認定參考指引 職業性病毒性肝炎感染之認定參考指引 | 中山 |
| | 職業性聽力損失診斷認定參考指引 漢他病毒出血熱之認定參考指引 外爾氏病之認定參考指引 | 彰基 |
| | 結膜炎之認定參考指引 游離輻射的職業病認定參考指引 各種非游離輻射引起之疾病認定參考指引 | 成大 |
| | 錳及其化合物中毒診斷認定參考指引 雷諾氏症候群之認定參考指引 溴化甲烷中毒之認定參考指引 | 高醫 |

| 年份 | 職業病認定參考指引 | 負責之防治中心 |
|---------------------|---|---------|
| 107 年 | 木粉引起的鼻腔癌、鼻竇癌認定基準 | 臺大 |
| | 錫及其化合物引起之中毒及其續發症認定參考指引 | 長庚 |
| | 氯乙烯中毒之認定參考指引 | 北榮 |
| | 熱危害引起之職業疾病認定參考指引 | 中國 |
| | 高溫作業之健康影響的認定參考指引 | |
| | 全身垂直振動引起的腰椎椎間盤突出職業疾病認定參考指引 | 中山 |
| | 肘隧道症候群及橈隧道症候群 | 彰基 |
| | 甲醇、丁醇、異丙醇、環己醇、甲基環己醇引起的職業病之認定參考指引 | 成大 |
| 正己烷中毒診斷認定參考指引 | 高醫 | |
| 108 年 | 石綿（包括含石綿的滑石）引起之職業性癌症診斷認定參考指引 - 3 肺癌 | 臺大 |
| | 石綿（包括含石綿的滑石）引起之職業性癌症診斷認定參考指引 - 1 惡性間皮細胞瘤 | |
| | 石綿（包括含石綿的滑石）引起之職業性癌症診斷認定參考指引 - 1 喉癌 | |
| | 笑氣 (Nitrous oxide) 與其他麻醉性氣體引起之中毒及其續發症認定參考指引 | 長庚 |
| | 四烷基鉛引起的職業性疾病認定參考指引 | 北榮 |
| | 四烷基鉛中毒之認定參考指引 | |
| | 鎢及其化合物引起之中毒及其續發症認定參考指引 | 中國 |
| | 鈹及其化合物中毒診斷認定參考指引 | 中山 |
| | 異常氣壓（含潛水伏病）作業引起之職業疾病認定參考指引 | 彰基 |
| | 異常氣壓作業意外事件認定參考指引 | |
| 職業相關之創傷後壓力症候群認定參考指引 | 成大 | |
| 銻及其化合物之中毒職業病認定參考指引 | 高醫 | |



第二章、我國職業傷病服務網絡建構歷程

一、管理服務中心執行成果

(一) 管理服務中心成立緣起與目標：

為提升我國職業病發現率及職業傷病診治服務品質，職業安全衛生署於 96 年度起委託國立臺灣大學醫學院附設醫院辦理「職業傷病管理服務中心計畫」並建置「職業傷病通報系統」，將各區防治中心與其轄區網絡醫院納入職業傷病通報，草擬並完成各防治中心服務項目作業標準程序書，強化職業傷病診治服務品質與協助防治中心拓展網絡醫院，提升民眾就醫近便性、建立常見職業病調查作業指引等，配合職業安全衛生署法規修訂或重要政策方向，分階段完成工作目標，期望能持續提供職業傷病勞工更高品質的服務。(表 2)

表 2 職業傷病管理服務中心年表

| 計畫年度 | 職業傷病管理服務中心工作成果 |
|-------|--|
| 97 年 | 建置網路視窗版本職業傷病通報系統，經與各中心溝通與修正改進，陸續新增通報系統內通報資料統計、分析、查詢、列印及後端資料管理功能，有助於瞭解我國職業傷病通報分布情形。 |
| 98 年 | <ol style="list-style-type: none">1. 辦理職業傷病診治服務之文宣、媒體或資訊推廣行銷工作，並建置特定職業病通報監控機制。2. 參考世界衛生組織 (WHO) 「職業衛生全球行動 10 年計畫」內容，引進職業衛生基礎健康照護服務，邀請國際勞工組織 (ILO) 與 WHO 專家或標竿國家的職業衛生相關領域專家學者來台交流與指導。 |
| 99 年 | <ol style="list-style-type: none">1. 為加強職業病防治服務效能與擴大推動全國職業傷病通報，辦理「我國職業健康推動方案」與「規劃及開發全國職業傷病通報機制之工具」。2. 編製常見職業疾病介紹與預防宣導手冊，透過管理服務中心，整合服務資源、提昇服務品質與民眾使用率，促使我國職業傷病預防、診治、通報等服務內容與國際接軌。3. 協助職安署辦理職業病鑑定個案危害暴露調查。 |
| 100 年 | <ol style="list-style-type: none">1. 因應職業災害勞工保護法修訂之規劃，配合職安署加強職業病防治、擴大推動全國職業傷病通報與建構職災醫療體系規劃，擴充原職業傷病通報系統功能，建立職業病群聚事件調查及預防模式。2. 分析職業病鑑定案例並編製案例彙編，提供各醫療機構與相關單位參考。3. 提供修訂職災補助專業意見，辦理與國外勞災醫療體系交流事宜。 |

| 計畫年度 | 職業傷病管理服務中心工作成果 |
|---------------------|--|
| 101 年 | <ol style="list-style-type: none"> 1. 強化職業傷病通報系統資安管控功能，擴增通報管理功能，並擴充職災勞工個案管理轉介平台。 2. 為協助「勞工安全衛生法」修正，蒐集國內外相關文獻，提供研擬女性健康保護及身心健康保護的相關附屬法規專業意見，參與國際會議及考察國外職業健康相關制度，藉助國際交流與經驗分享國外相關制度規劃，健全我國職業健康服務體系。 |
| 102 年 | <ol style="list-style-type: none"> 1. 接續前兩年「勞工安全衛生法」修正的相關作業，協助職安署進行我國雇用 200 至 300 人的事業單位勞工施行健康服務制度的可行性調查評估。 2. 分享參與國際勞工健康相關會議經驗，提供職安署職業健康政策建議。 |
| 103 年 | <ol style="list-style-type: none"> 1. 因應 103 年起「職業安全衛生法」施行，管理服務中心持續編製職業健康或傷病相關案例與資訊電子報，強化職業傷病服務推廣行銷。 2. 舉辦職業健康國際研討會，邀請國外相關領域的學者專家分享勞工身心健康保護措施實務作法，期望藉由國際交流，提供我國職業健康服務實務推動與政策規劃參考。 |
| 104 年 | <ol style="list-style-type: none"> 1. 規劃全國醫療機構職業傷病登錄通報機制及資訊系統維護與更新，將通報資訊系統及管理服務中心網頁移轉至職安署的伺服器與程式碼修改，確保通報系統及網頁能正常服務。 2. 修正更新各式職業傷病診治服務標準作業程序書，提供相關服務實務參考。 3. 舉辦各區職業傷病防治中心交流觀摩會議，邀請各防治中心進行實務交流，分享績效優良中心的特色服務與施行細節。 |
| 105 年 至 106 年 | <ol style="list-style-type: none"> 1. 為提升職業傷病防治服務的可見度，辦理職業傷病相關資源的推廣行銷工作，管理服務中心與 2 家以上全國性勞工或雇主等相關團體或行政機關建立合作機制，辦理三場以上的職業傷病防治宣導會。 2. 因應行動時代來臨，建置行動版管理服務中心的網站，以利民眾可隨時以智慧型裝置搜尋、瀏覽相關資訊。 3. 為整合各區職業傷病防治中心特色服務，邀集相關領域專家與各區中心討論特色服務發展推廣、資源分享與規劃，彙製特色服務資源手冊。 4. 持續強化職業傷病防治服務推廣行銷工作，結合相關資源規劃推廣方式，以提升全國職業傷病服務量能。 5. 因應資訊安全的需求，評估並執行資安防護措施。 |
| 107 年 | <ol style="list-style-type: none"> 1. 辦理職業傷病十年成果國際研討會議，邀集英國、日本、韓國的職業醫學與職業衛生的專家學者、防治中心交流分享執行成果與策略。 2. 持續進行職業傷病通報系統資料分析，了解高風險產業與盛行率較高的職業傷病資訊，提供規劃職業傷病防治政策參據。 3. 規劃提升通報誘因與落實通報保護，宣導與加強職業疾病的診斷與通報；協助提供職災保險制度單獨立法專業意見。 |
| 108 年 | <ol style="list-style-type: none"> 1. 持續辦理職業傷病相關資源的工作與推廣行銷，藉由職業傷病通報系統資料分析，了解高風險產業與盛行率較高的職業傷病資訊，提供規劃職業傷病防治政策參據。 2. 提升職業傷病通報誘因與落實通報個人資料保護措施，加強宣導職業疾病的診治與通報，強化跨醫療專科的轉介與照會，持續擴展及健全職業傷病防治網絡服務。 |



二、防治中心特色發展簡介

(一) 防治中心的起始：

勞動部（當時為行政院勞工委員會）為提供職業傷病勞工在地化之健康照護服務，自 92 年起，陸續委託全國各大型醫療院所成立「職業傷病診治中心」，其後為擴大提供勞工職業傷病預防、工作與疾病間因果關係判斷、復工評估、復健轉介、勞動法令諮詢及健康促進等職業健康照護服務，進一步於 98 年推動臨廠職業健康服務，爰將「職業傷病診治中心」配合更名為「職業傷病防治中心」（以下簡稱防治中心）。

103 年行政院勞工委員會更名為勞動部，同時成立職業安全衛生署，管理服務中心與防治中心的計畫與相關業務亦一併移轉交由職業安全衛生署負責。從計畫開始發展至今，全國已有 10 家防治中心，分別為：國立臺灣大學醫學院附設醫院、臺北榮民總醫院、長庚醫療財團法人林口長庚紀念醫院、中國醫藥大學附設醫院、中山醫學大學附設醫院、彰化基督教醫療財團法人彰化基督教醫院、臺大醫學院附設醫院雲林分院、國立成功大學醫學院附設醫院、高雄醫學大學附設中和紀念醫院、佛教慈濟醫療財團法人花蓮慈濟醫院，分佈於全臺之北、中、南及東區等四區（圖 4）：

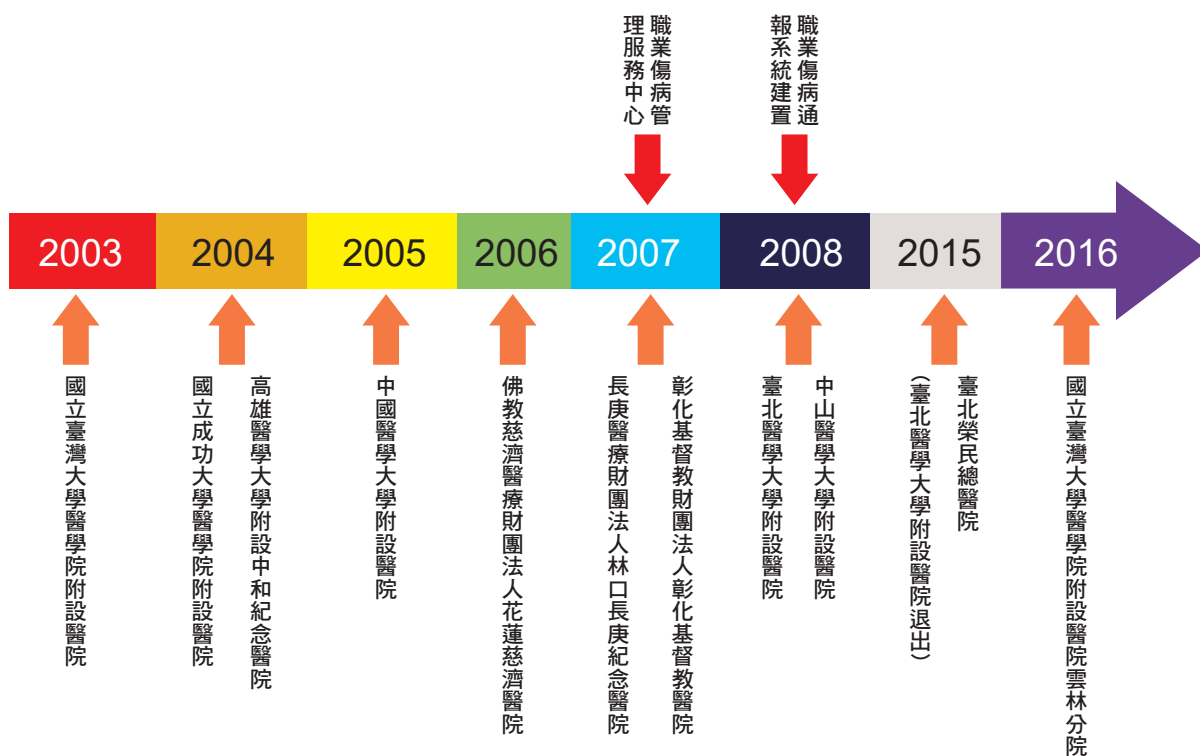


圖 4 職業傷病防治中心成立時間軸

各防治中心負責業務廣泛，大致可整理為下五點：

1. 職業傷病診斷、防治及轉介等服務：由專業醫療團隊提供職業傷病之工作因果關係診斷、職業病防治、職場母性諮詢、過勞評估等，視個案需求，提供個案管理或復工評估、復健轉介等服務。
2. 職業暴露與職業疾病個案調查：藉由個案提供之資訊進行職業疾病之調查，並提供工作現場訪視、危害評估等職業暴露調查之服務。
3. 健康管理及健康促進服務：提供勞工特別危害健康作業健康檢查三級管理以上之複診服務；提供勞工職業疾病健康管理及健康教育宣導。
4. 職業傷病諮詢服務：提供職業傷病認定、勞保補償、相關法律問題、職業傷病預防及健康諮詢等服務。
5. 職業疾病個案研討：辦理職業疾病個案研討，提供職業疾病相關進階課程訓練之管道。

(二) 防治中心的工作內容

各防治中心具有醫學院之學術支援、完整醫療設備與醫療團隊、充分結合各專科的轉介資源，以進行職業疾病調查與職業傷病個案通報；結合工作強化中心與社區及工廠健康服務，就近提供勞工職業傷病預防、診斷、評估及重建與諮詢轉介服務，建置區域職業傷病服務網絡，發展職業傷病預防與重建機制；培育職業傷病防治專業人才等業務內容，永續我國職業傷病協助服務發展。



三、各防治中心簡介

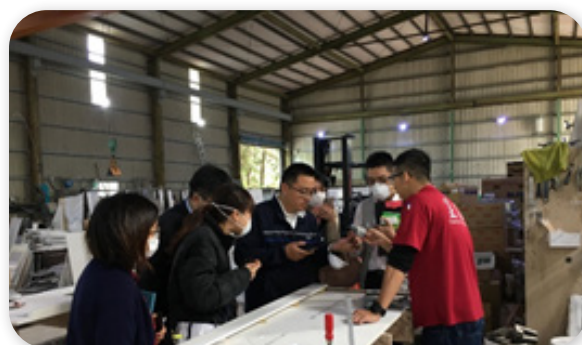
臺北榮民總醫院

臺北榮民總醫院為勞動部於 104 年委託成立之職業傷病防治中心（以下簡稱北榮防治中心）。為衛生福利部評鑑合格之醫學中心，病床約 3,000 餘張，醫師約 1,100 多位。科內除提供職業醫學門診服務外，亦設有毒藥物諮詢中心及毒藥物檢驗實驗室組成專業醫師團隊等優勢資源，職業傷病服務之發展特色係以毒化物職業暴露疾病為主。

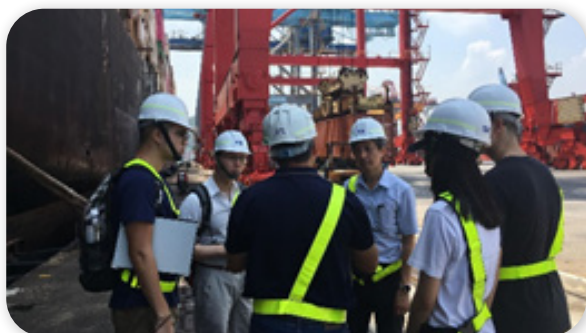
北榮防治中心自 104 年起至 108 年止，共計已分別與臺北市立萬芳醫院、衛生福利部雙和醫院、天主教仁慈醫療財團法人仁慈醫院、臺北榮民總醫院桃園分院、臺北榮民總醫院蘇澳分院、新竹科學工業園區員工診所及衛生福利部桃園醫院等 7 家職業傷病診治服務網絡合作，提供北部地區職災勞工職業傷病服務。



吳明玲醫師帶領北榮防治中心團隊與臺北市 FAP 個管員及院內社工室同仁交流與討論



北榮防治中心團隊進行職業病工作現場訪視



蔡維禎醫師帶領北榮防治中心團隊到個案工作現場進行復工評估



北榮防治中心辦理教育訓練宣導職業傷病防治

圖 5 108 年北榮防治中心執行成果

國立臺灣大學醫學院附設醫院

國立臺灣大學醫學院附設醫院為勞動部於全國第一家委託成立之職業傷病防治中心（以下簡稱臺大防治中心）。其係因「職業災害勞工保護法」於 91 年施行，亟需具職業傷病專業之醫療院所提供職業傷病診斷、補償、與職能重建之服務，並建立職災預防－補償－重建之整合服務模式，爰由勞工保險局職災專款補助，於 92 年 4 月正式成立。為衛生福利部醫院評鑑特優之醫學中心，其病床約有 2,400 床，醫師約 740 位。因院內有胸腔內科、腫瘤醫學部、心臟內科及神經內科等優勢資源，職業傷病服務之發展特色係以工作壓力相關疾病（職業促發腦血管及心臟疾病）及職業性肺部疾病為主。

臺大防治中心自 97 年起至 108 年止，已分別與臺北市立聯合醫院忠孝院區、新光醫療財團法人新光吳火獅紀念醫院、國立臺灣大學醫學院附設醫院新竹分院、佛教慈濟醫療財團法人臺北慈濟醫院、三軍總醫院附設民眾診療服務處、亞東綜合醫院、基督復臨安息日會醫療財團法人臺安醫院、輔仁大學學校財團法人天主教輔仁大學附設醫院以及天成醫療社團法人天晟醫院等 9 家職業傷病診治服務網絡合作，就近提供北部地區職災勞工職業傷病服務。



臺大防治中心團隊進行求診個案評估、討論與後續追蹤



臺大防治中心醫師到個案工作現場收集暴露資料



臺大防治中心個案管理師提供個案職業傷病諮詢服務



臺大防治中心醫師進行工作現場訪視

圖 6 108 年臺大防治中心執行成果



長庚醫療財團法人林口長庚紀念醫院

長庚醫療財團法人林口長庚紀念醫院為勞動部於 96 年委託成立之職業傷病防治中心（以下簡稱長庚防治中心）。為衛生福利部評鑑合格之醫學中心，其病床約有 3,700 餘張病床，醫師約 1,100 位，因鄰近桃竹地區，桃園市係屬工業重鎮，共有七大工業區，大園、中壢、平鎮、幼獅、龜山、觀音、林口工業區；五大科學園區，龍潭渴望、龍潭科技、桃園、華亞、秀才科學園區，由於該院之地理位置及具有完善之檢驗儀器，肝膽腸胃科、急診醫學科、毒物科、高壓氧中心及多位相關科別專任主治醫師等優勢資源，職業傷病服務之發展特色係以化學與金屬等有機溶劑中毒診治為主，尤其是二甲基甲醯胺暴露造成肝功能異常之相關服務。

長庚防治中心自 97 年起至 108 年止，已分別與財團法人天主教聖保祿醫院、壠新醫院、敏盛綜合醫院（經國院區）、長庚醫療財團法人桃園長庚醫院、長庚醫療財團法人臺北長庚醫院、臺灣基督長老教會馬偕醫療財團法人馬偕紀念醫院、臺灣基督長老教會馬偕醫療財團法人新竹馬偕紀念醫院、衛生福利部樂生療養院、聯心診所、日康診所、臺北醫學大學附設醫院等 11 家職業傷病診治服務網絡合作，就近提供桃竹地區及北部地區職災勞工職業傷病服務。



羅錦泉醫師協助罹病勞工診斷職業病



長庚防治中心辦理職業傷病研討會



長庚防治中心專業團隊與鶯歌陶瓷工會合作宣導



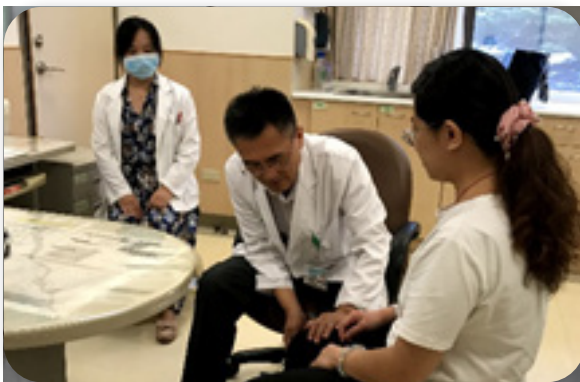
長庚防治中心與新竹市勞工局合作辦理職業傷病防治教育訓練課程

圖 7 108 年長庚防治中心執行成果

中國醫藥大學附設醫院

中國醫藥大學附設醫院為勞動部於 94 年委託成立之職業傷病防治中心（以下簡稱中國醫防治中心）。為衛生福利部評鑑合格之醫學中心，病床約 2,076 張，醫師約 884 位。因鄰近臺中、南崗、彰濱等工業區、潭子加工出口區及中部科學園區，加上院內心臟科的心臟血管中心等優勢資源，職業傷病服務之發展特色係以職業性腦心血管疾病為主。

中國醫防治中心自民國 97 年起至 108 年止，共計已分別與中國醫藥大學附設醫院豐原分院、中國醫藥大學附設醫院臺中東區分院、里澄診所、瑞斌診所、中部科學工業園區員工診所、仁愛醫療財團法人大里仁愛醫院及光田醫療社團法人光田綜合醫院等 7 家職業傷病診治服務網絡合作，提供中部地區職災勞工職業傷病服務。



中國醫防治中心劉秋松醫師進行復工評估



中國醫防治中心團隊到疑似職業病個案工作現場收集暴露資料



中國醫防治中心進行職業傷病個案工作現場訪視



中國醫防治中心辦理職業傷病防治教育訓練活動

圖 8 106 年中國醫防治中心執行成果



中山醫學大學附設醫院

中山醫學大學附設醫院為勞動部於 97 年委託成立之職業傷病防治中心（以下簡稱中山防治中心）。為衛生福利部評鑑合格之醫學中心，病床約 950 張，醫師約 200 位。中部地區的產業除勞力密集、勞工技術的傳統產業為主外，因鄰近中部科學園區，高科技產業帶來的人因工程危害亦不少，加上該院具有完善之特殊診斷儀器和技術、多位專任主治醫師及設有復健中心及輔具中心，與中山醫學大學職能治療學系等優勢資源，職業傷病服務之發展特色係以職業性肌肉骨骼疾病為主。

中山防治中心自民國 97 年起至 108 年止，共計已分別與臺中榮民總醫院、佛教慈濟醫療財團法人臺中慈濟醫院、童綜合醫療社團法人童綜合醫院、中港澄清醫院、衛生福利部臺中醫院、衛生福利部苗栗醫院以及員林郭醫院大村分院等 7 家職業傷病診治服務網絡合作，就近提供中部地區職災勞工職業傷病服務。



中山防治中心陳俊傑醫師協助求診個案進行復工評估



中山防治中心團隊辦理教育訓練活動



中山防治中心專業團隊協助個案進行工作暴露評估



中山防治中心專業團隊進行職業病工作現場訪視

圖 9 108 年中山防治中心執行成果

彰化基督教醫療財團法人彰化基督教醫院

彰化基督教醫療財團法人彰化基督教醫院為勞動部於 96 年委託成立之職業傷病防治中心（以下簡稱彰基防治中心）。為衛生福利部評鑑合格之醫學中心，病床約 1,700 餘張，醫師約 670 位。因鄰近彰濱工業區，院內除設有工作強化中心，亦有復健科、神經內科、骨科等專科醫師及物理治療師，並結合朝陽科技大學人因工程學者專家及長榮大學工業衛生專家等優勢資源，職業傷病服務之發展特色係以職業性肌肉骨骼疾病為主。

彰基防治中心自民國 97 年起至 108 年止，共計已分別與彰化基督教醫療財團法人彰化基督教醫院雲林分院、秀傳醫療社團法人秀傳紀念醫院、衛生福利部彰化醫院、埔基醫療財團法人埔里基督教醫院、佛教慈濟醫療財團法人大林慈濟醫院、國立成功大學醫學院附設醫院斗六分院及國軍臺中總醫院中清分院等 7 家職業傷病診治服務網絡合作，就近提供彰雲投三縣市職災勞工職業傷病服務。



彰基防治中心湯豐誠醫師與在地工會合作辦理職業傷病防治宣導



彰基防治中心進行疑似職業傷病個案工作現場訪視



彰基防治中心團隊與彰化市政府 FAP 辦理工作聯繫會議交流



彰基防治中心與彰化縣勞工處共同辦理勞動節職業傷病宣導活動

圖 10 108 年彰基防治中心執行成果



國立臺灣大學醫學院附設醫院雲林分院

國立臺灣大學醫學院附設醫院雲林分院為勞動部於 105 年委託成立之職業傷病防治中心（以下簡稱雲分防治中心）。為衛生福利部評鑑合格之醫學中心，病床約 940 餘張。雲林縣為臺灣農業大縣，中央與雲林縣政府均衡產業發展，該縣境內設斗六、豐田、大將、麻園、元長等工業區，另設有雲林科技工業區與中部科學工業園區虎尾園區，以及佔全國石化業產值超過七成之麥寮工業區。雲分防治中心位處農業大縣，發展農業相關職業危害為主之職業傷病服務特色發展，以照護在地勞工健康並免除勞工發生職災卻要跨區就醫之困擾，補全雲嘉地區職業傷病防護網。

雲分防治中心自民國 105 年起至 108 年止，共計已分別與大千綜合醫院、為恭紀念醫院、臺中榮民總醫院嘉義分院及臺塑關係企業麥寮廠區醫務室等 4 家職業傷病診治服務網絡合作，提供中部地區職災勞工職業傷病服務。



雲分防治中心團隊辦理教育訓練活動



雲分防治中心李念偉醫師宣導職災勞工相關權益



雲分防治中心與當地工會合作辦理職業病防治宣導



雲分防治中心協助個案進行疑似職業病工作現場訪視

圖 11 108 年雲分防治中心執行成果

國立成功大學醫學院附設醫院

國立成功大學醫學院附設醫院為勞動部於 93 年委託成立之職業傷病防治中心（以下簡稱成大防治中心）。為衛生福利部評鑑合格之醫學中心，病床約 1,200 張，醫師約 530 位。因鄰近南部科學園區，及嘉義民雄、朴子、頭橋、義竹、嘉太等工業區，與臺南安平、臺南科技、官田、新營、永康等工業區，加上該院具有完善之特殊診斷儀器和技術、多位胸腔重症專任醫師等優勢資源，職業傷病服務之發展特色係以職業性肺部疾病與職業性皮膚病為主。

成大防治中心自民國 97 年起至 108 年止，已與高雄榮民總醫院、奇美醫療財團法人奇美醫院、財團法人天主教聖馬爾定醫院、臺南科學工業園區聯合診所、王伯智皮膚科診所、臺南市立醫院、奇美醫療財團法人奇美醫院柳營分院、奇美醫療財團法人奇美醫院佳里分院、郭綜合醫院、新樓醫療財團法人臺南新樓醫院、新樓醫療財團法人麻豆新樓醫院、臺南市立安南醫院、衛生福利部臺南醫院及戴德森醫療財團法人嘉義基督教醫院等 14 家職業傷病診治服務網絡合作，就近提供南嘉義與臺南地區勞工職業傷病服務。



成大防治中心與社區服務人員工會合作辦理職業傷病宣導講座



成大防治中心吳政龍醫師協助職災個案進行復工評估



成大防治中心與當地工會合作辦理職業傷病防治宣導



成大防治中心的醫生到病房與護理師宣導個案轉介

圖 12 108 年成大防治中心執行成果



財團法人高雄醫學大學附設醫院

財團法人高雄醫學大學附設醫院為勞動部於 93 年委託成立之職業傷病防治中心（以下簡稱高醫防治中心）。為衛生福利部評鑑合格之醫學中心，病床約 1,600 張，醫師約 330 位。因鄰近南部臨海、大發、林園石化、鳳山、永安、岡山本洲、大社等工業區，另有楠梓加工區、高雄加工區、臨廣加工區及新興的高雄軟體科技園區，加上該院具備完善之多種重金屬檢驗儀器且為南臺灣最多解毒劑儲備中心，及院內胸腔科、血液腫瘤科、癌症中心等專任醫師優勢資源，職業傷病服務之發展特色係以職業性重金屬中毒與職業性胸腔疾病診治為主。

高醫防治中心自 97 年起至 108 年止，共計已分別與高雄市立小港醫院、義大醫療財團法人義大醫院、健丞診所、祥全診所、大興骨科診所、馮文璋皮膚專科診所、馬敘強診所、長庚醫療財團法人高雄長庚紀念醫院、屏基醫療財團法人屏東基督教醫院、衛生福利部屏東醫院、國軍高雄總醫院岡山分院及高雄市立大同醫院等 12 家職業傷病診治服務網絡合作，就近提供大高雄與屏東地區職災勞工職業傷病服務。



高醫防治中心協助職業傷病個案進行復工評估



高醫防治中心偕同轄區網絡醫院辦理聯繫會議



高醫防治中心配合高雄市勞工局辦理工會宣導



高醫防治中心進行工作現場訪視收集工作暴露資料

圖 13 108 年高醫防治中心執行成果

佛教慈濟醫療財團法人花蓮慈濟醫院

佛教慈濟醫療財團法人花蓮慈濟醫院為勞動部於 95 年委託成立之職業傷病防治中心（以下簡稱慈濟防治中心）。為衛生福利部評鑑合格之醫學中心，病床約 960 餘張，醫師約 320 位。因東部地區以傳統產業為主，尤其多為石材雕刻等產業，加上該院具有完善之特殊診斷儀器或技術及多位相關科別專任醫師等優勢資源，職業傷病服務之發展特色係以職業性聽力損失疾病診治為主。

慈濟防治中心自民國 97 年起至 108 年止，已與天主教靈醫會醫療財團法人羅東聖母醫院、國立陽明大學附設醫院及醫療財團法人羅許基金會羅東博愛醫院等 3 家職業傷病診治服務網絡合作，就近提供宜花東地區職災勞工職業傷病服務。



慈濟防治中心劉鴻文醫師協助求診個案認定職業病



慈濟防治中心辦理東區職業傷病研習會活動



慈濟防治中心劉鴻文主持職災勞工配復工案例討論



慈濟防治中心團隊進行原住民職業傷病預防宣導活動

圖 14 108 年慈濟防治中心執行成果



四、防治中心的現有發展與特色服務

全臺目前已有 10 家防治中心，多數為醫學院之附設醫學中心，學術能口充沛且各有所長，為使勞工能獲得「特殊」且更為「細緻」之職業傷病協助服務，各防治中心於 100 年起發展建構具區域特性之職業傷病防治、照護及研究之服務特色，期望能藉此強化各防治中心針對特定職業疾病之診治技能，進而提升職業疾病之發現率與罹患職業疾病勞工之復工率。

在特色發展上，各防治中心可藉由統計轄區內之常見職業疾病，並考口鄰近產業特性、勞動環境條件與疾病診治需求等因素，分析有關該職業疾病之症狀、危害、預防與治療等議題，發展評估與鑑定、臨廠訪視等，並作為特色職業病之選定依據，研擬針對常見職業疾病之職業安全衛生管理計畫。依據各中心統計診治與通報常見之職業疾病，主要以肌肉骨骼、化學性危害物質所引起之中毒、腦心血管疾病、聽力損失，以及皮膚疾病等問題，職業疾病種類與中心所在區域之產業型態具有相當關聯。



四、防治中心選定之特色與優勢

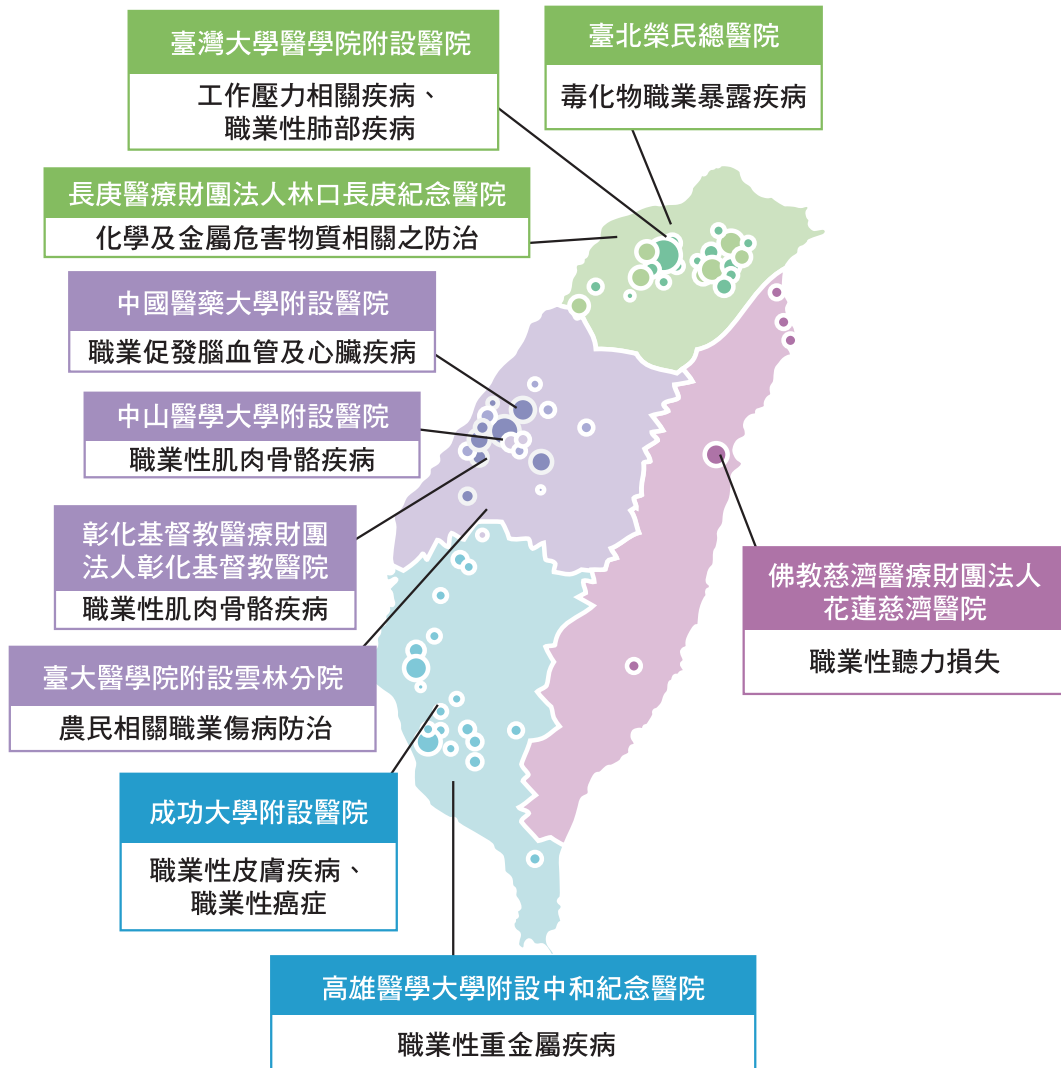


圖 15 防治中心分布及特色疾病發展



表 3 防治中心特色疾病及優勢資源

| 防治中心 | 選定之特色 | 優勢資源與分布 |
|------------------|------------------------|---|
| 臺北榮民總醫院 | 毒化物職業暴露疾病 | <ol style="list-style-type: none"> 1. 結合北榮毒藥物諮詢中心及科內毒藥物檢驗實驗室，具有專任主治醫師、顧問醫師及兼任主治醫師專業團隊，以工作相關之化學物質所引起的職業疾病為特色研究發展主軸，提供職災勞工服務。 2. 與國立陽明大學環境與職業衛生研究所密切合作，研究專長包括環境毒理學、環境毒物之健康風險評估與監測、環境流行病學、空氣品質評估與汙染控制、作業環境測定與分析。 |
| 國立臺灣大學醫學院附設醫院 | 工作壓力相關疾病（職業促發腦血管及心臟疾病） | <ol style="list-style-type: none"> 1. 結合臺大醫院院內與院外其他單位資源，提供腦心血管和職業性肺病之個案各種階段不同需求服務。如臺大醫院具特色之各專科醫師可協助疾病診治及建議預防疾病策略。另設有物理治療中心、臨床心理中心及工作強化中心。 2. 與北部地區各實驗室有密切合作。 |
| | 職業性肺部疾病 | |
| 長庚醫療財團法人林口長庚紀念醫院 | 化學及金屬危害物質相關之防治 | <ol style="list-style-type: none"> 1. 結合院內醫療資源與轄下網絡醫院，另結合鄰近開設職業傷病門診之醫療機構或特別危害作業指定健康檢查之醫療機構，透過職業傷病服務轉介，提高發現職場傷病個案人數。合作期間定期辦理網絡醫院教育訓練並定期督導服務品質。 2. 透過歷年職業傷病報告案例，主動發現群聚案件，組成專業團隊進行現場調查，了解職業傷病發生原因及過程、工作流程與傷病之因果關係，提供改善建議，積極介入職場進行工作場所改善，保障勞工健康與安全。 |

| 防治中心 | 選定之特色 | 優勢資源與分布 |
|------------|--------------|---|
| 中國醫學大學附設醫院 | 職業促發腦血管及心臟疾病 | <ol style="list-style-type: none"> 1. 設有心臟血管中心。 2. 預防醫學中心有完善之社區及工廠健康服務。 3. 預防醫學中心與社區暨家庭醫學部已在國際期刊上發表多篇社區代謝症候群之研究論文。 |
| 中山醫學大學附設醫院 | 職業性肌肉骨骼疾病 | <ol style="list-style-type: none"> 1. 設有復建床位，住院患者主要以脊髓損傷、創傷性腦損傷以及腦中風為主，為中南部頗具規模的復健教學、研究及臨床照護單位。中山醫學大學設有中部地區唯一職能治療學系，並執行職業安全衛生署委託「中區職災勞工工作強化中心」計畫，與復健科、骨科、神經內科、神經外科等專科醫師合作，互相轉介個案。 2. 中山醫學大學職業安全衛生系與職能治療系有多位人因工程專業領域的教師。針對疑似職業病個案，進行勞工工作場所訪視、調查與危害評估等工作，以及後續工作環境改善建議等，將提供勞工職場安全與職業衛生之建議，提供事業單位職業健康照護服務，達到預防職業傷害與職業病的目的。 3. 針對所有認定職業性腰椎椎間盤突出症等個案與校內人因工程專家合作，利用人因工程套裝軟體或以德國之腰椎終生累積受力模式，來模擬計算個案作業時可能的腰椎受力情形，以提高職業病診斷之品質。 |



| 防治中心 | 選定之特色 | 優勢資源與分布 |
|--------------------|-----------------------------|---|
| 彰化基督教醫療財團法人彰化基督教醫院 | 職業性肌肉骨骼疾病（四肢） | <ol style="list-style-type: none"> 1. 為臺中以南至雲林唯一醫學中心。 2. 防治中心與院內神經內科、復健科、骨科等專科醫師、物理治療師等成立以四肢骨骼肌肉疾病為重點服務方向之職業醫學團隊，院外與朝陽科技大學人因工程學者專家、中山醫學大學人因工程專家及長榮大學工業衛生專家已建立合作關係。 3. 100年4月起彰基復健科承接「彰雲投工作強化中心」計畫，本中心與該工作強化中心在業務上多方相輔相成，並依照個案需求，結合輔具中心，提供個案相關輔具選用及使用說明。 4. 已成立人因醫學研究中心，目前已有使用扭力計、拉力計、EMG、IOSH 抬舉評估程式及肌肉骨骼量表（OCRA Index 與 HALTLV）來輔助職業性骨骼肌肉疾病鑑定。 |
| 國立臺灣大學附設醫院雲林分院 | 職業性肌肉骨骼疾病 | <ol style="list-style-type: none"> 1. 雲林為農業大縣，農業為此區域之特色產業。 2. 藉由整合與臺大醫院醫學中心完整資源，並連結數個縣市之勞政、社福等行政資源，提供職業傷病勞工治療、復健或復工等整合式診療服務。 |
| 國立成功大學醫學院附設醫院 | 職業性皮膚疾病 職業性癌症（包括職業性肺部疾病） | <ol style="list-style-type: none"> 1. 有國立成功大學醫學院之學術資源。 2. 與嘉義、臺南及高雄之「職業災害勞工個案主動服務」計畫（FAP）密切結合。 3. 與院內其他科部（含神經部、復健部、骨科部、皮膚部及急診部）協同診治職業傷病病患。 |
| 高雄醫學大學附設中和紀念醫院 | 職業性重金屬疾病 職業性胸腔疾病 | <ol style="list-style-type: none"> 1. 職業醫學專科醫師之醫療團隊陣容完整。 2. 設有專屬之勞工健康檢查部門。 3. 具備豐富之職業醫學相關計畫推廣經驗。 |

| 防治中心 | 選定之特色 | 優勢資源與分布 |
|------------------------------|-------------|--|
| 佛教慈濟 醫療財團 法人花蓮 慈濟醫院 | 職業性 聽力損失 | <ol style="list-style-type: none"> 1. 中心以在地產業特色，積極發展職業性聽力損失為中心職業傷病防治特色，自 89 年起逐步籌備，訂定「標準化聽力損失個案轉介流程」、「職業性聽力損失調查作業指引」、「噪音作業訪視行動檢核表」、「高噪音工作危害現場訪視機制」、「噪音防治及危害作業現場臨廠服務模式」、「職業性聽力損傷之診斷工具指引」等評估工具。 2. 透過臨廠預防篩檢服務模式，可採前述工具篩檢初期異常個案，增加勞工參與改善意願，進行健康管理，安排勞工至醫院接受進一步檢查與安排適當治療。 3. 中心對於東區產業特性與勞工職業危害具豐富之經驗。 |





貳、臺灣職業傷病防治服務現況

第一章、職業傷病勞工診治服務成果

108 年 10 家防治中心轄下共計有 83 家區域網絡醫院，以全臺分區而言，北、中、南區其所分佈之資源較為平均，亦與全臺勞工人數分佈情形相似，另東部方面所設立職業傷病服務網絡服務，雖仍有待努力之處，但該區勞工人數也相對較其他區少。各區職業傷病防治中心轄下網絡醫院建構家數以及開設門診診次如圖 16 所示：

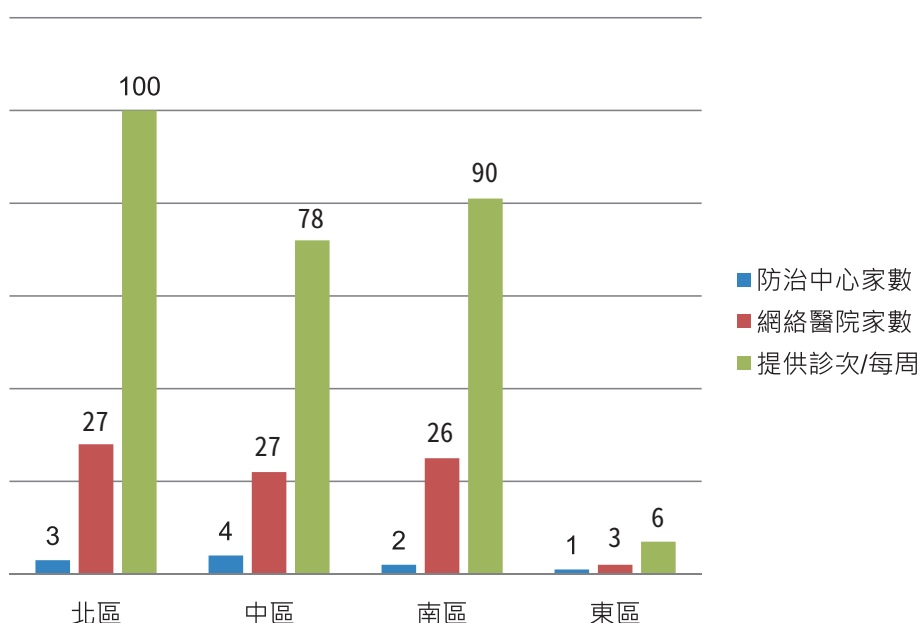


圖 16 職業傷病防治服務醫療院所建構家數圖



全國 10 家防治中心分別所建置之網絡醫院家數與網絡醫院門診診次如圖 17 所示，轄區網絡醫院建置最多家數為成大防治中心，每周開設門診診次以成大最多：

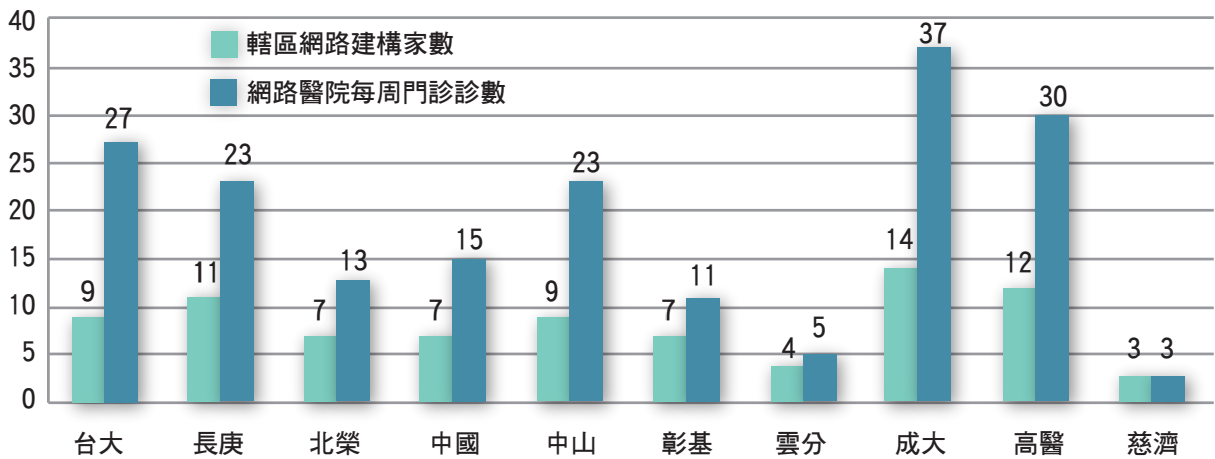


圖 17 職業傷病防治服務各區醫療院所開設診次數量圖

網絡醫院係為提升職業傷病勞工之就醫可近性而建置，自 97 年建置職業傷病防治網絡醫院以來，每年網絡醫院家數與開設門診診次皆穩定增加。歷年網絡醫院數量與開設門診診次如圖 18 所示，大致呈現穩定成長趨勢。107 年開設門診診次略有下降，主要在於網絡醫院醫師更迭，減少開設門診診次所致。

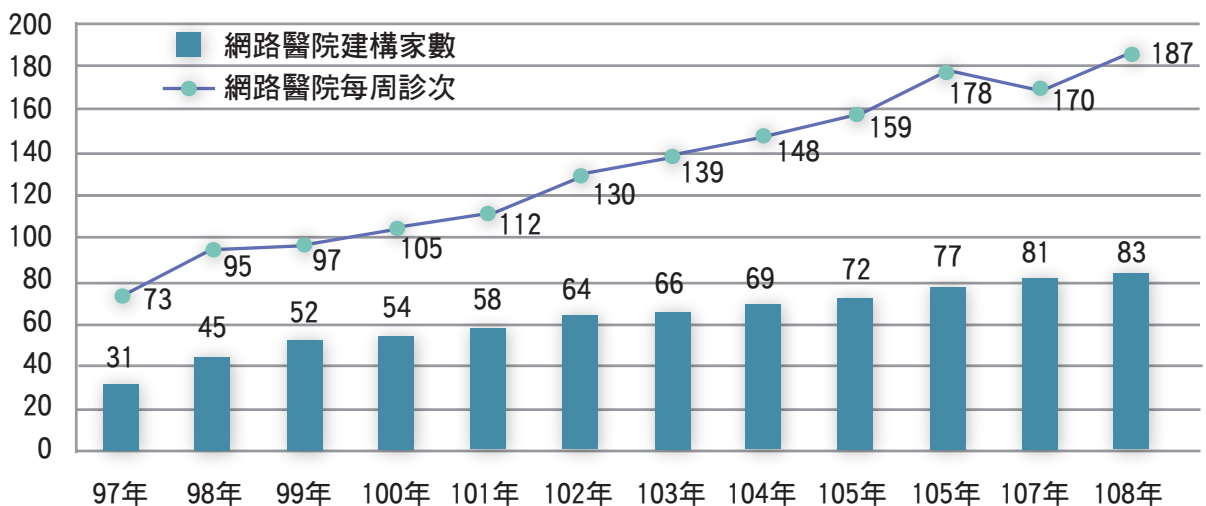


圖 18 職業傷病診治網絡醫院建構家數與開設診次數量圖



圖 19 為 97 至 108 年 10 家防治中心開設門診次與轄區 83 家網絡醫院開設門診診次加總之數量，逐年穩定提升。

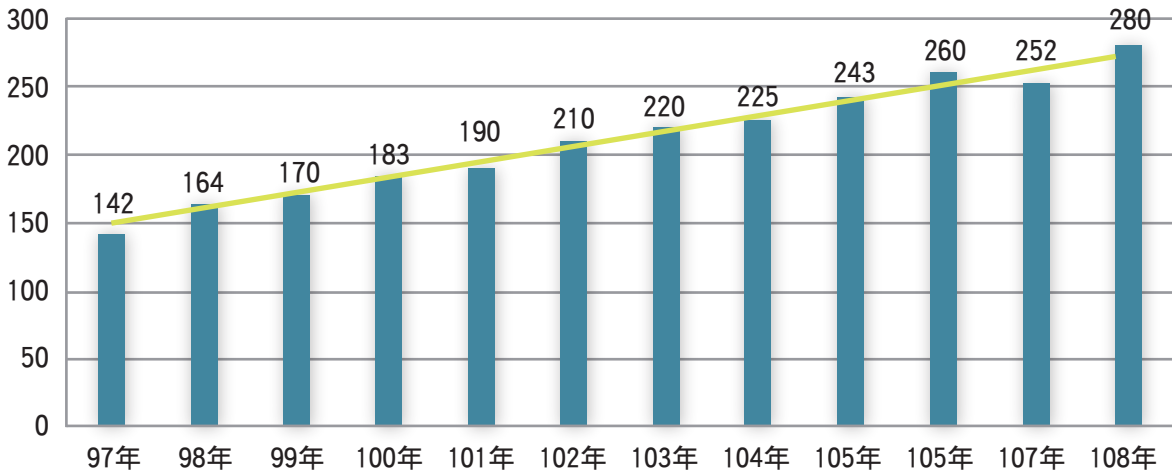


圖 19 歷年職業傷病防治服務醫療院所開設診次

圖 20 將診次分為防治中心及網絡醫院分層分析，可知防治中心的門診量維持穩定服務量，網絡醫院的門診開設量上升度極多，以期能提供勞工就醫可近性更便利之職業傷病照護服務。

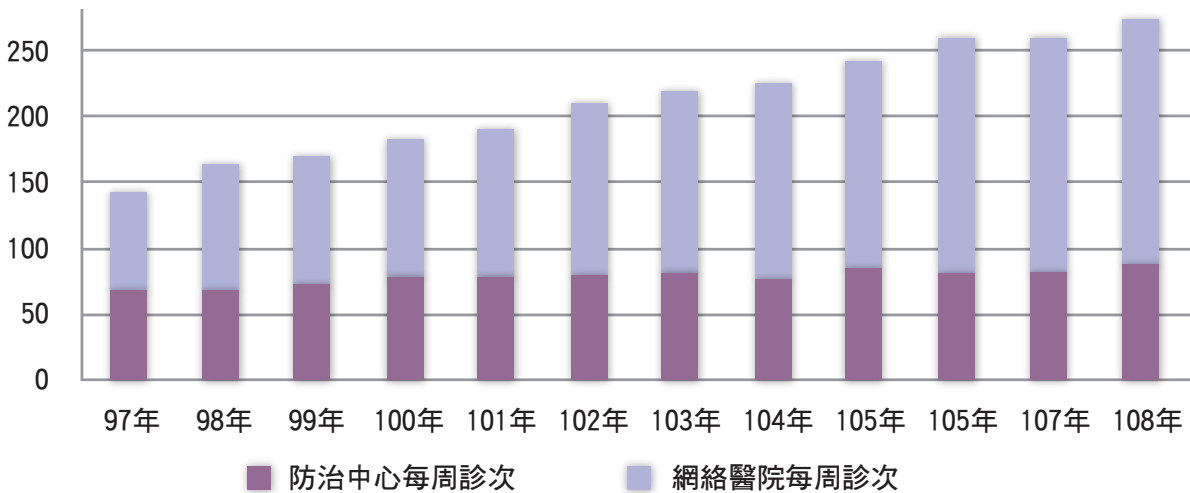


圖 20 歷年職業傷病防治服務醫療院所開設診次（依層級區分）

97 至 108 年職業傷病防治網絡服務之職業傷病初診人次與總求診人次如圖 21 所示，歷年服務之初診及求診人次均有穩定上升。105 年後加入 1 家防治中心與 9 家網絡醫院，明顯提升職業傷病醫療服務網絡效能。

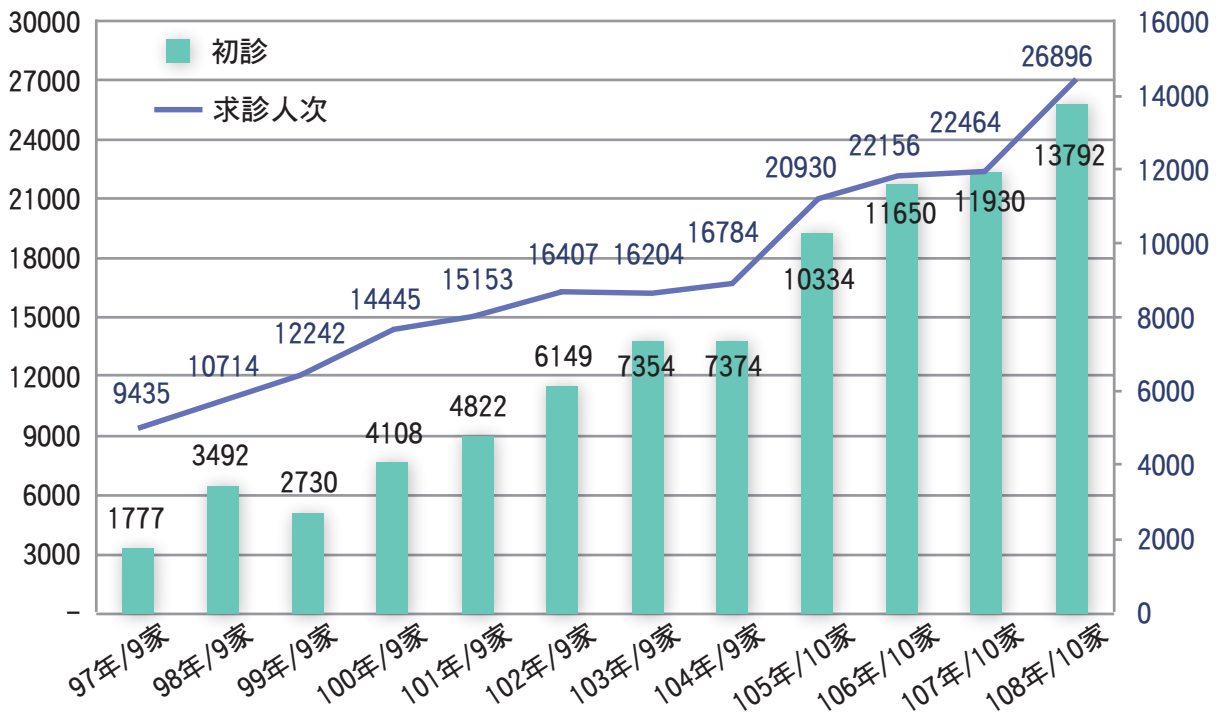


圖 21 職業傷病防治服務醫療院所開設診次歷年數量圖

防治中心除了由職業醫學專科醫師與個案管理師協助職災勞工進行職業病認定外，亦協助職災勞工能盡快恢復工作能力回到工作崗位，以減輕罹病的身心痛苦及生活負擔，也會與專責職災勞工復工協助服務的工作強化中心或院內復健科合作，提供復工評估及復健服務。





圖 22 為 97 至 108 年 10 大中心重建與復工服務之總人次，108 年成大推動職災勞工復工協助服務 369 人最多，臺大 348 人居次：

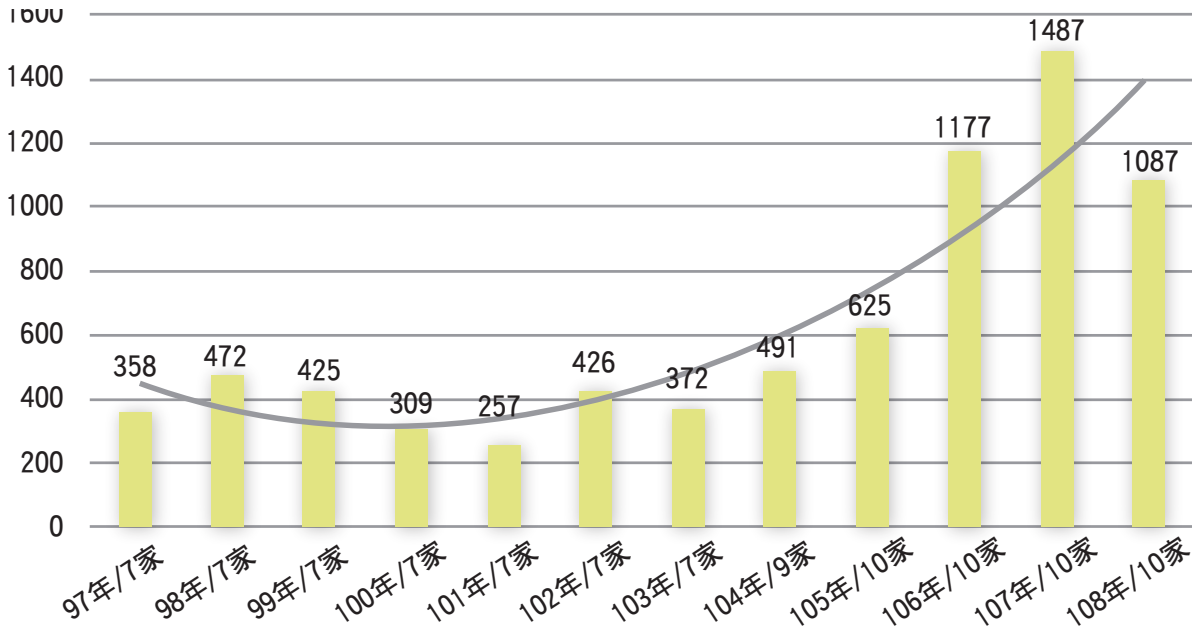


圖 22 職業傷病防治重建與復工服務歷年個案量

圖 23 為 97-108 年成功復工之總人數，108 年成功服務個案量較前一年度成長許多。職災勞工的復工端視受災的嚴重程度而定，部分遭遇重大職災的勞工，醫療協助身體機能慢慢痊癒後，為協助個案能重回職場，從個案評估、設計適合的介入計畫到完成復工，可能花費一年以上的時間完成，期間亦需要個案及其家屬與醫療團隊持續努力不懈的合作才能達成復工目標，故職災個案成功復工與提供職災勞工復工服務的比例平均約為五成左右，108 年成功復工的比例提升至六成。108 年成功復工的 836 人當中，以成大協助個案成功復工 265 人最多。

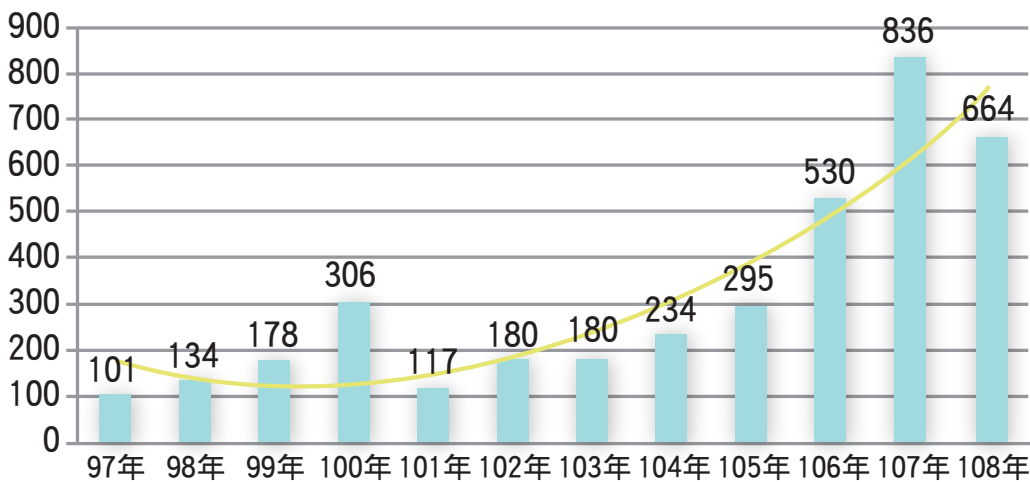


圖 23 職業傷病防治協助個案成功復工之歷年個案量

第二章、職災勞工個案管理服務及個案管理師 人才培育

防治中心提供職業傷病勞工個案管理服務流程，包含復健復工網絡、心理網絡、社工網絡及醫療網絡，以發展個案管理模式提供職業傷病勞工全面且專業的職業傷病諮詢、診療、評估及後續服務。個案收案標準符合勞動部訂定之職業傷病防治中心暨網絡醫院個案管理及轉介協助程序書個案管理收案標準之定義。在預防方面，職業醫學專科醫師與個案管理師針對求診個案進行工作暴露詢問相關調查時，確認勞工罹病是否有出現群聚現象，並給予該事業單位改善建議。對於個案診治服務之過程詳實記錄，並主動定期檢討個案所受之服務，是否獲得資源上之協助或問題解決。

個案管理人數於近 3 年內服務人數趨向平穩，105 年加入雲分防治中心運作，個案管理服務量顯著提升後趨於穩定，107 年開始職業安全衛生署鼓勵防治中心及網絡醫院通報噪音性聽力損失以外的職業疾病個案，故個案管理人數又成長許多，如圖 24 所示：

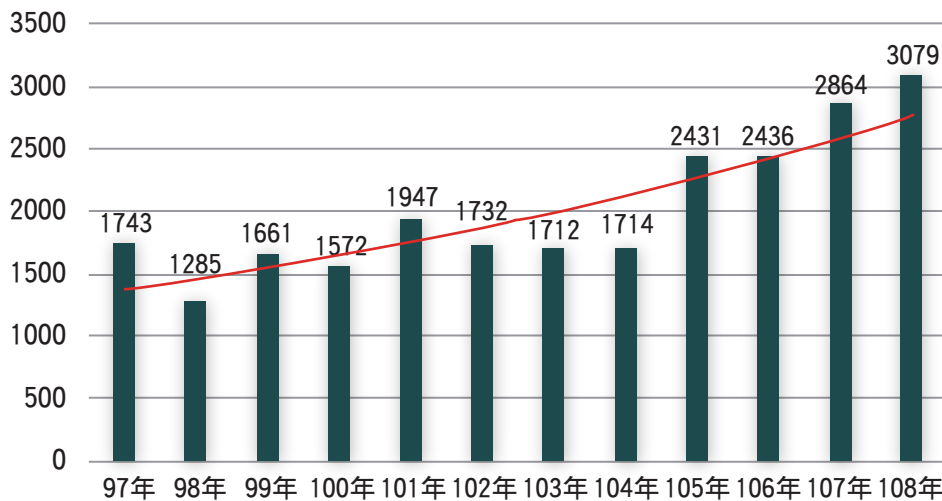


圖 24 歷年職業傷病防治個案管理服務數量



除因 105 年雲分防治中心加入運作，臺大防治中心 105 年諮詢轉介服務量成長 375%，故 105 年諮詢與轉介人數大幅提升，106 年至 108 年諮詢與轉介人數皆超過 10,000 人（圖 25）。

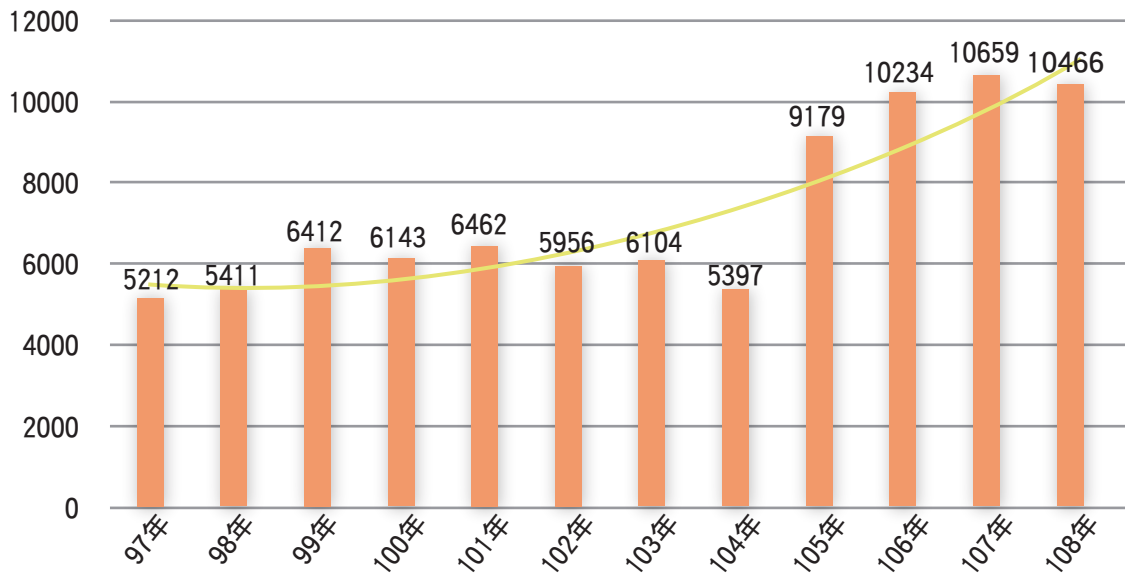


圖 25 職業傷病防治諮詢與轉介服務歷年個案量

個案管理師工作內容

許多勞工在罹災後，對於勞動權益相關法規保障與勞保相關給付資料填寫不甚了解或甚至根本不知道該如何填寫資料，此時職業傷病防治中心的個案管理師扮演著職災勞工、雇主、醫師、護理人員、及各網絡專業人員之間的重要溝通橋樑，協助職業傷病勞工就醫、進行職業傷病認定及勞保給付申請等，以減少勞工奔波之苦。

大部份來中心尋求職業病診斷協助的個案，經常是病情嚴重影響工作必須停工休養、或是勞工因職業傷病跟雇主發生勞資糾紛，需要申請職業傷病給付或失能給付等，以填補因病造成的薪資減少或減輕醫療負擔。

個案尋求職業病診斷協助時，個案管理師須先詳細詢問個案的基本資料及工作暴露相關資料、跟個案解釋職業傷病勞工相關權益、協助安排轉介其他所需要的服務，例如：縣市政府的 FAP、院內其他專科檢查、工作強化中心等；轉介後仍須繼續追蹤職業病認定個案的各項檢查結果、確認是否符合目標疾病、收集個案工作暴露相關資料、彙整個案的工作及醫療報告後，供醫師判斷是否屬於職業病；有時候會遇到不易判讀是否為目標疾病的影像檢查結果，很難釐清是否為目標疾病，必須尋求其他專科醫師的協助判斷。

無法排除非屬於職業病時，個案管理師需要與個案、雇主約定時間，與醫師一同進行工作現場訪視，以便釐清。此外，個案管理師在門診開設時間外也會接受民眾直接到中心詢問，或透過電話、電子郵件、Line、臉書等方式諮詢職災相關問題。

個案管理師在職教育訓練課程

因為職業傷病門診服務的求診人數連年增加，反映社會大眾對於勞動權益日漸重視，對於職業傷病也有更多了解，然防治中心採計畫逐年招標，專業人才難以久任，為提升全體個案管理師的專業知能並應用到實務工作上，提供求診勞工更高品質的服務，管理服務中心於108年9月5、6日假國立臺灣大學公共衛生學院大樓進行職業傷病個案管理師訓練，課程規劃先以問卷方式詢問職業傷病個案管理師們在職災勞工協助實務上容易遇到的問題，彙總後與邀請授課的講師們溝通討論，以期能規畫能有效解決個管師們處理在協助職災勞工時經常遇到的問題，切合個管師們的需求以期提升職業傷病門診服務的品質，提供職災勞工完整且妥適的職業傷病診治服務。

訓練課程規劃合計8小時，以課程教學形式進行，參與人員以防治中心與轄區網絡醫院相關人員為主，亦開放中心及網絡醫院的職業安全衛生人員參加，108年邀請各縣市之「職災勞工個案主動服務計畫」的個案管理員共同參與，課程內容包含：勞保職業災害保險制度介紹、勞保職業病給付審查實務及案例討論、職災勞工法律協助實務及案例分享、個案管理服務實務討論（包含診治、補償、復健復工等）、職業疾病認定之實務作業與案例分享、職業衛生相關法規介紹等相關服務知能。

表 4 108 個案管理師訓練課程表

| 日期/時間 | 課程名稱 | 主講人 |
|-----------------|---------------------|---------------------------------|
| 9月5日 星期四 | | |
| 08:45-09:00 | 報到 | |
| 09:00-10:30 | 職災勞工法律協助實務及案例分享 | 宇恆法律事務所 律師 沈以軒 |
| 10:40-12:20 | 職災勞工權益相關法規介紹 | 勞動部職業安全衛生署 |
| 午膳 | | |
| 13:45-15:15 | 勞保職業傷病給付審查實務與案例研討 | 勞動部勞工保險局 |
| 茶敘及聯誼交流 | | |
| 15:30-17:00 | 勞保職業傷病失能給付審查實務與案例研討 | 勞動部勞工保險局 |
| 9月6日 星期五 | | |
| 09:15-10:45 | 職業病診斷實務與案例研討 | 臺北市立萬芳醫院 勞保局特約審查醫師 醫師 黃百黎 |
| 10:50-12:20 | 職災勞工諮商技巧與案例分享 | 華人心理治療研究 發展基金會 臨床心理師 廖怡玲 |
| 12:30 | 賦歸 | |



圖 26 職業安全衛生署長官與個案管理師於教育訓練課程前大合照



圖 27 個案管理師在職教育訓練

第三章、辦理過勞專案及職業疾病鑑定案成果

一、過勞專案專業意見提供情形

99年發生科技產業年輕工程師猝死事件，引發社會高度關注責任制工作時間、加班工時過長可能導致勞工過勞的問題。勞動部為改善過勞的問題，於同年10月針對30家大型高科技公司進行專案勞動檢查，發現高達8成的業者違反勞基法關於工時的規定，可能係因全球化經濟產業競爭壓力下，雇主為了維持產業競爭力，期望能盡量減少人事費用支出以降低成本，彈性利用變動工時排班便成為事業單位人資部門的首要選擇，大幅增加勞工的工作負荷。然不僅只有臺灣，工作壓力與職場疲勞也係許多亞洲國家重要的勞動政策議題，亞洲國家普遍而言工時較長，鄰近國家如日本與韓國等，自70年代以來，過勞猝死案例亦層出不窮。

管理服務中心自100年起依據過勞專案研商會議決議，協助職業安全衛生署過勞防治專案之認定評估作業。於接獲職業安全衛生署函送之個案後，依照地域性分派各區防治中心協助評估並撰寫評估報告書後，由管理服務中心函覆職業安全衛生署，對於具有勞保身分者，職業安全衛生署再函轉至勞工保險局作為保險相關給付之參考。因勞工或其家屬多半不熟悉勞保給付申請程序及申請給付所需具備的文書資料，管理服務中心會協助向個案或其家屬說明評估結果及相關權益事項，期能減低公文往返的時間，讓個案或其家屬能盡快獲得勞保給付。

108年過勞專案評估案件共38件，評估結果如表5所示。個案平均年齡約48.9歲，年齡最大為64歲，最小僅34歲，過勞專案中男性達35件，佔總案件數92%，統計結果如圖28所示。外籍勞工共4名，佔總案件數11%。38件個案進入過勞專案評估之案件中，15位製造業的作業員(39.5%)，8名個案為從事支援服務業(21.1%)的個案中有6名個案任職保全，4名個案從事運輸及倉儲業的駕駛員(10.5%)，營建工程業4名(10.5%)，3名個案為農、林、漁、牧業人員(7.9%)，住宿及餐飲業2名(5.3%)，教育業、用水工業及汙染整治業各1名個案(各2.6%)。(圖29)

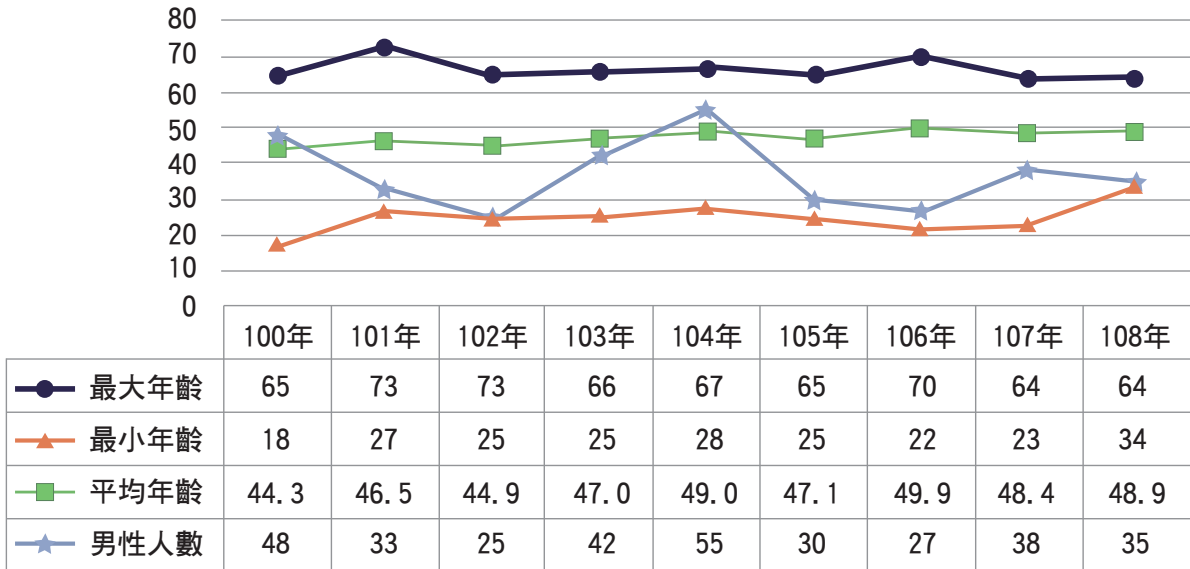


圖 28 100 年至 108 年過勞專案個案基本資料分布情形

表 5 100 年至 108 年過勞專案評估結果

| 年度 | 評估結果 | | 總個案數 |
|-------|---------|----------|------|
| | 職業促發個案數 | 非職業促發個案數 | |
| 100 年 | 27 | 27 | 54 |
| 101 年 | 24 | 15 | 39 |
| 102 年 | 16 | 11 | 27 |
| 103 年 | 19 | 25 | 44 |
| 104 年 | 25 | 35 | 60 |
| 105 年 | 16 | 16 | 32 |
| 106 年 | 15 | 17 | 32 |
| 107 年 | 18 | 24 | 42 |
| 108 年 | 19 | 19 | 38 |
| 共計 | 160 | 170 | 330 |

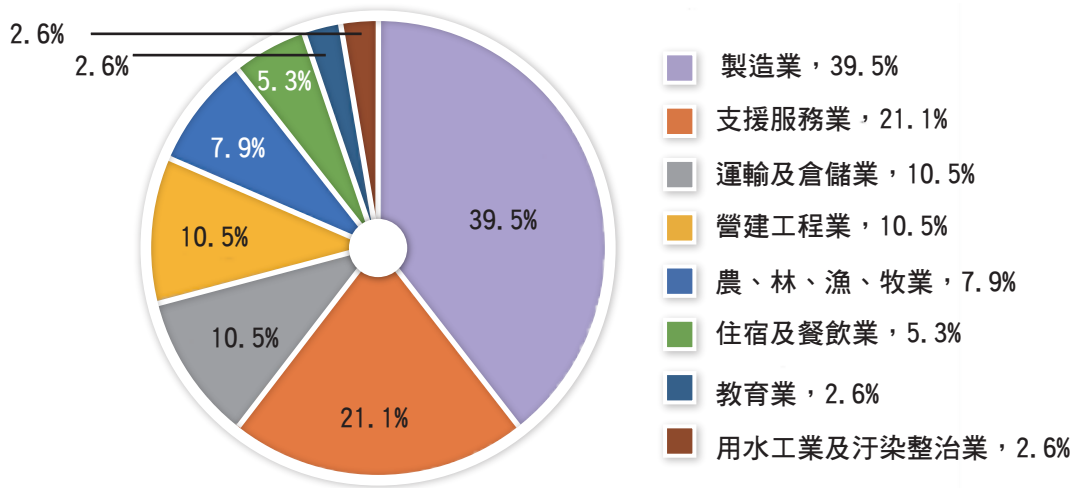


圖 29 108 年過勞專案評估個案行業別分布情形

自個案工作時間可知，長工時容易引發非外傷所致之腦心血管疾病，保全業為適用勞基法第 84 條之一變形工時之行業，工時不受勞基法有關工時之限制，工時較長，相關事業單位進行員工健康管理時，應審慎評估勞工排班對於勞工健康負荷之影響，減少過勞所致疾病發生，以達企業永續經營之目的。完成過勞專案評估報告共 38 件：19 件為非職業促發疾病、19 件為職業促發疾病。





二、職業疾病鑑定專業意見提供情形

有關職業疾病之鑑定，應先確認某一疾病之存在，再認定該疾病與職業之因果關係。職業疾病鑑定的證據，需考量暴露的證據、時序性、一致性（醫學及流行病學文獻之考量）及合理地排除其他致病因素後，始能確定是否為職業疾病。依據職業災害勞工保護法第 11 條與職業災害勞工保護法施行細則第 18 條規定，職業疾病鑑定委員會受理案件來自勞雇雙方對地方政府之認定有異議或地方政府無能力認定，以及勞工保險局審查有疑義或應勞動部訴願委員會之要求移送者，故每件申請職業疾病鑑定之個案均極具爭議與難度。現行職業疾病鑑定程序如圖 30 所示。

由於職業疾病認定所需之相關職業暴露證據，勞工不易取得，在暴露證據不足之情況下，如僅以一次多數決定，雖然能加快鑑定流程，但可能因事證不足而犧牲職災勞工應有的權益，因此，透過鑑定委員會多數之專業審查意見，逐步補齊相關事證，於事證充分下做成決定較具公信力，並保障勞工權益。

管理服務中心依職業安全衛生署交付之職業疾病鑑定案需求，委託各區防治中心與專家組成調查團隊，協同具有入廠權之各區勞動檢查單位進入個案工作現場訪視調查，調查過程中視調查個案需求，如需職業安全衛生專家進行相關工作環境暴露檢測與採樣、或需精神科專科醫師進行工作壓力導致心理疾病相關評估，將共同進行工作現場調查訪視及評估工作，確保讓調查結果盡可能周延，以維護勞工權益。

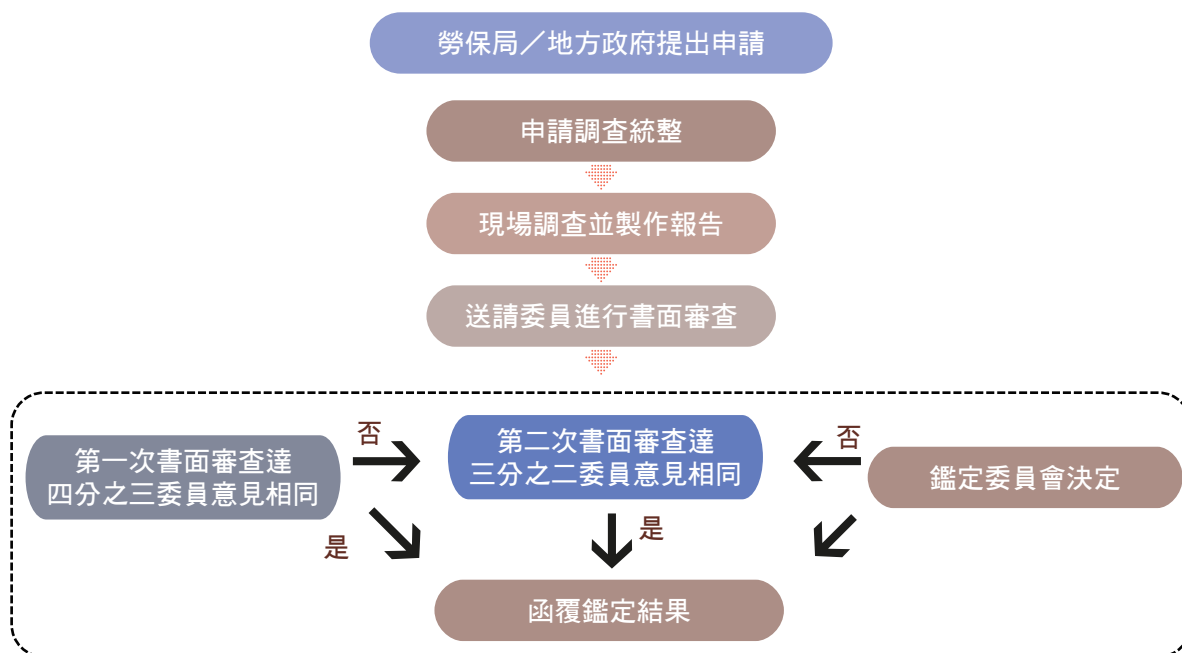


圖 30 職業病鑑定流程圖

調查團隊最後依據個案之職場危害暴露、職業醫學、流行病學及相關職業疾病認定參考指引等相關資料，提出職業醫學證據、環境暴露調查報告。108年共有19件職業疾病鑑定案，7件為疑似職業性肌肉骨骼疾病，7件為疑似職業性異常壓力疾病，3件為疑似職業促發精神疾病，2件為疑似職業促發腦心血管疾病。鑑定案之摘要內容請見表6：

表6 108年職業疾病鑑定個案情形

| 編號 | 職業疾病鑑定案個案類別 | 職業疾病個案摘要 | 現場訪視與調查 |
|---------|--------------|--------------------------------|------------------------|
| 案件一 | 疑似職業性肌肉骨骼疾病 | 臺中市卓姓個案板模工人（腰椎椎間盤突出）是否屬職業疾病 | 本中心委請中山醫團隊前往工作現場進行訪視調查 |
| 案件二 | 疑似職業性肌肉骨骼疾病 | 臺北市王姓勤務員（左側膝部內側半月板後角撕裂）是否屬職業疾病 | 本中心委請長庚團隊前往工作現場進行訪視調查 |
| 案件三 | 疑似職業促發精神疾病 | 臺南市吳姓個案廚師（創傷後壓力症候群、憂鬱症）是否屬職業疾病 | 本中心委請高醫團隊前往工作現場進行訪視調查 |
| 案件四 | 疑似職業性肌肉骨骼疾病 | 新北市王姓個案攤販（右手腕廣泛性關節炎併僵直）是否屬職業疾病 | 本中心委請北榮團隊前往工作現場進行訪視調查 |
| 案件五 | 疑似職業促發精神疾病 | 新北市余姓個案業務員（焦慮症、失眠）是否屬職業疾病 | 本中心委請台大團隊前往工作現場進行訪視調查 |
| 案件六 | 疑似職業性肌肉骨骼疾病 | 高雄市蔡姓個案作業員（深部靜脈屈張）是否屬職業疾病 | 本中心委請成大團隊前往工作現場進行訪視調查 |
| 案件七 | 疑似職業促發腦心血管疾病 | 嘉義市陳姓個案漁業養殖工（腦血管疾病）是否屬職業疾病 | 本中心委請彰基團隊前往工作現場進行訪視調查 |
| 案件八 | 疑似職業性肌肉骨骼疾病 | 臺北市朱姓個案照護服務員（TFCC損傷）是否屬職業疾病 | 本中心委請北榮團隊前往工作現場進行訪視調查 |
| 案件九 | 疑似職業促發腦心血管疾病 | 臺中市鄭姓個案勞安主管（腦血管疾病）是否屬職業疾病 | 本中心委請中國醫團隊與家屬進行訪談調查 |
| 案件十 | 疑似職業促發精神疾病 | 苗栗縣陳姓個案房務員（憂鬱症）是否屬職業疾病 | 本中心委請中國醫團隊與家屬進行訪談調查 |
| 案件十一 | 疑似職業性肌肉骨骼疾病 | 臺南市林姓個案機械工人（腰椎椎間盤突出）是否屬職業疾病 | 本中心委請高醫團隊前往工作現場進行訪視調查 |
| 案件十二 | 疑似職業性肌肉骨骼疾病 | 臺中市莊姓個案水電工人（關節炎）是否屬職業疾病 | 本中心委請彰基團隊前往工作現場進行訪視調查 |
| 案件十三至十九 | 疑似職業性異常壓力疾病 | 陳姓個案等地下工程工人（潛水夫病）是否屬職業疾病（共7件） | 本中心委請台大團隊協助 |



參、臺灣職業傷病通報成果

我國職業疾病之監測與通報機制係由勞動部與衛生福利部分別建立完成，包括「勞工血中鉛值通報與監控系統」、「噪音作業勞工聽力閾值監視系統」、「衛生署之職業傷病通報系統」、「職業性針扎危害通報系統」、勞工健康檢查之異常個案資料，以及勞工保險局之職業疾病現金給付資料等。84 年衛生福利部建立職業傷病通報系統，醫師可主動地去通報職業疾病，但未具強制性，因此只有部份職業醫學科專科醫師會通報，且此時期的主要通報目的在於流行病學的調查，無實際連結至職業傷病的預防與補償。在 96 年以前，勞工因職業疾病而接受到勞工保險局職業病給付的人數，扣除 88 年開放塵肺症患者勞工之勞保給付申請個案後，平均每年約為 200 至 300 人，這與其他先進國家相比是偏低的。

為提升我國職業病發現率、推廣全國職業傷病防治及重建網絡並齊一服務品質，勞動部於 96 年起委託辦理「職業傷病管理服務中心計畫」，訂定「治療、調查、診斷、通報等服務項目之作業標準」，並於 97 年建置「職業傷病通報系統」，且將各區防治中心及轄下醫療機構納入通報範圍。

由表 7 可知，92 年至 94 年扣除罹患塵肺症的退休礦工申請的給付案件量後，職業病給付申請案件分別為 161 件、224 件及 177 件。至 95 年，職業傷病防治服務已有臺大、成大、高醫、中國醫及慈濟等 5 家防治中心運作，此時職業性肌肉骨骼疾病、氣喘及腦心血管疾病等給付量皆有提升。104 年職業性癌症給付量劇增，主要來自於 RCA 訴訟罹癌勞工的給付。



表 7 92 年至 108 年勞保職業病給付種類及案件數

| 年份 | 總計 | 噪音引起之聽力損失 | 職業下背痛 | 振動引起之疾病 | 手臂肩頸疾病 | 化學性危害 | 生物性危害及職業性氣喘 | 塵肺症與矽肺症 | 石綿肺症 | 職業性皮膚病 | 職業相關癌症 | 腦心血管疾病 | 精神疾病 | 其他 |
|-----|-------|-----------|-------|---------|--------|-------|-------------|---------|------|--------|--------|--------|------|----|
| 92 | 1139* | 4 | 44 | 0 | 61 | 4 | 5 | 978* | 0 | 3 | 4 | 0 | 0 | 36 |
| 93 | 1184* | 6 | 53 | 1 | 85 | 6 | 2 | 960* | 2 | 5 | 6 | 0 | 0 | 58 |
| 94 | 393 | 6 | 47 | 5 | 64 | 4 | 3 | 216 | 0 | 6 | 4 | 0 | 0 | 38 |
| 95 | 298 | 0 | 61 | 2 | 87 | 5 | 20 | 53 | 4 | 12 | 2 | 13 | 0 | 39 |
| 96 | 326 | 5 | 86 | 0 | 98 | 2 | 10 | 71 | 2 | 5 | 2 | 37 | 0 | 8 |
| 97 | 426 | 3 | 109 | 1 | 182 | 1 | 12 | 56 | 7 | 3 | 1 | 34 | 0 | 17 |
| 98 | 532 | 6 | 138 | 1 | 239 | 3 | 13 | 72 | 2 | 11 | 1 | 26 | 0 | 20 |
| 99 | 607 | 5 | 127 | 5 | 303 | 2 | 22 | 75 | 4 | 9 | 7 | 33 | 3 | 12 |
| 100 | 893 | 1 | 170 | 1 | 417 | 6 | 15 | 157 | 2 | 10 | 13 | 88 | 0 | 13 |
| 101 | 908 | 1 | 144 | 0 | 393 | 1 | 25 | 213 | 1 | 9 | 6 | 92 | 3 | 20 |
| 102 | 808 | 1 | 122 | 1 | 381 | 1 | 20 | 180 | 4 | 12 | 4 | 68 | 3 | 11 |
| 103 | 757 | 1 | 121 | 0 | 352 | 7 | 16 | 164 | 3 | 3 | 11 | 67 | 1 | 11 |
| 104 | 975 | 2 | 161 | 2 | 393 | 8 | 6 | 137 | 1 | 7 | 146 | 83 | 3 | 26 |
| 105 | 706 | 1 | 119 | 2 | 345 | 5 | 11 | 118 | 0 | 8 | 11 | 68 | 6 | 12 |
| 106 | 630 | 1 | 102 | 0 | 298 | 2 | 12 | 92 | 12 | 2 | 4 | 84 | 6 | 15 |
| 107 | 757 | 2 | 102 | 3 | 363 | 0 | 17 | 106 | 18 | 1 | 55 | 69 | 3 | 18 |
| 108 | 744 | 0 | 120 | 2 | 353 | 4 | 13 | 144 | 16 | 1 | 4 | 60 | 2 | 19 |

- 註： 1. 本表含被保險人離職退保後，經診斷確定罹患職業病者。
 2. 本表含 98 年 1 月 1 日勞工保險條例修正施行後勞保年金之職業傷病失能補償一次金及職業災害死亡補償一次金人數。
 3. 92 年、93 年的高給付量來自於退休礦工的塵肺症給付。



圖 31、圖 32 為歷年勞保職業病給付結果，與職業傷病通報系統勾稽比後，申請通過案件中約有半數來自於防治中心協助之申請案件。進一步將 108 年勞工保險職業病給付案件數前三高的職業病，如：手臂肩頸疾病、塵肺症與矽肺症、職業下背痛等，與通報系統的職業病通報案件數比較後發現，手臂肩頸疾病、塵肺症與矽肺症的職業病通報案件數低於勞工保險職業病給付案件數，推測可能的原因為罹病與工作間的因果關係較為明確，且相關職業病認定指引的範圍較廣，勞保局的核定率較高，罹病勞工不必然只能尋求職業醫學科醫師協助，亦可以獲得給付。

職業下背痛在通報系統中，通報案件數歷年通常都略高於勞工保險給付案件數一些，自 105 年開始案件數量差距逐漸拉大，108 年差異的案件數最多，原因除近年鼓勵通報多元的職業病類型，整體通報件數均逐年提升外，另因通報系統建置的主要目的係為從醫療端監測職業疾病，凡醫師認符合職業病者均會被納入通報的範圍，相較於勞保為給付之審查會較為寬鬆，兩者的目的不同，故呈現的數量也差異較多。

職業下背痛的通報系統職業病通報案件數歷年通常都略高於勞工保險給付案件數一些，自 105 年開始案件數量差距逐漸拉大，108 年差異的案件數最多，差異數量提升的原因除因政府單位鼓勵醫療機構通報多元類型的職業病，致通報系統的案件數量提升外，且將塵肺症與矽肺症的勞保給付統計與職業傷病通報統計區分並比較之後，可以發現塵肺症的勞保給付件數皆高於職業傷病通報件數，可能係塵肺症放寬離職退休後職業病給付的認定標準，且罹患塵肺症的勞工在工作暴露與罹病的因果關係較容易判定，故個案不必要尋求職業醫學科專業團隊的協助，也能獲得勞保職業病給付。值得注意的是矽肺症的個案雖然勞保職業病給付數量偏低，但近年內職業病通報數連年提升，除與通報政策調整有關外，進一步分析職業傷病通報系統個案發生疾病的工作場所主要位於新北市（原臺北縣），以鄉鎮區做分群則以鶯歌區和瑞芳區為最多，個案分布有明顯聚集之現象；或可對照勞保預防職業病健康檢查資料，應可得更全面之全國性估計值。個案工作內容以陶瓷工、磁磚工、鑄造廠作業員、噴砂作業員、礦工、隧道工等為主。（圖 33、圖 34、圖 35、圖 36）

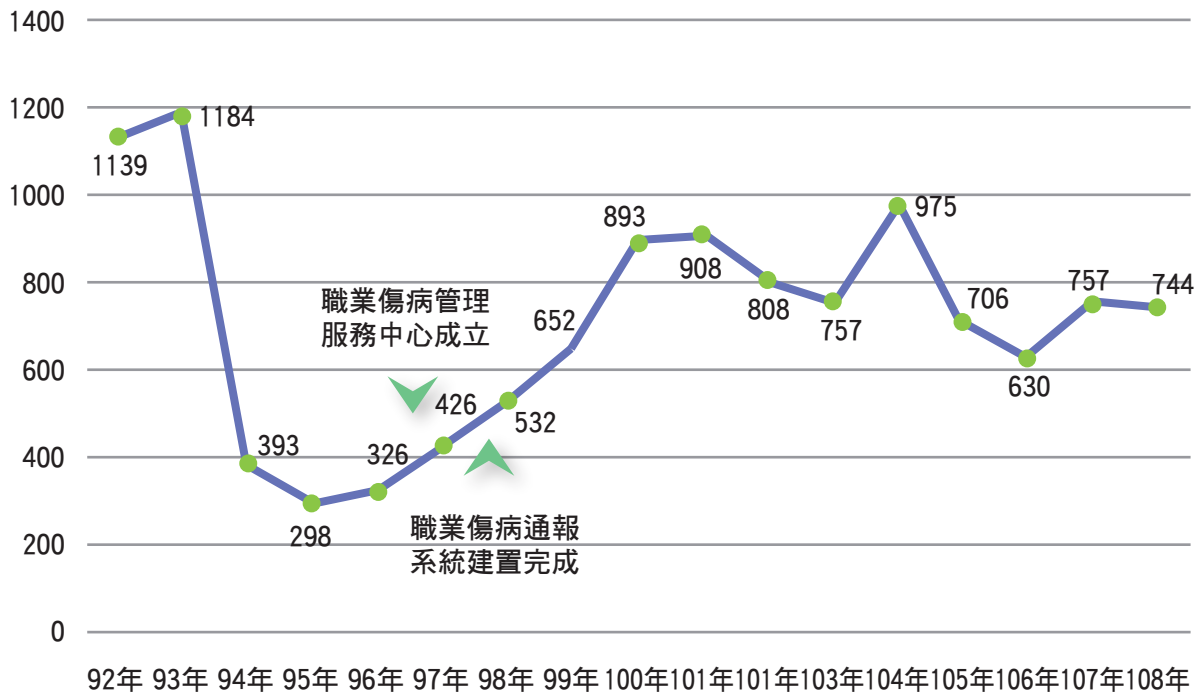


圖 31 歷年職業疾病勞保給付申請情形

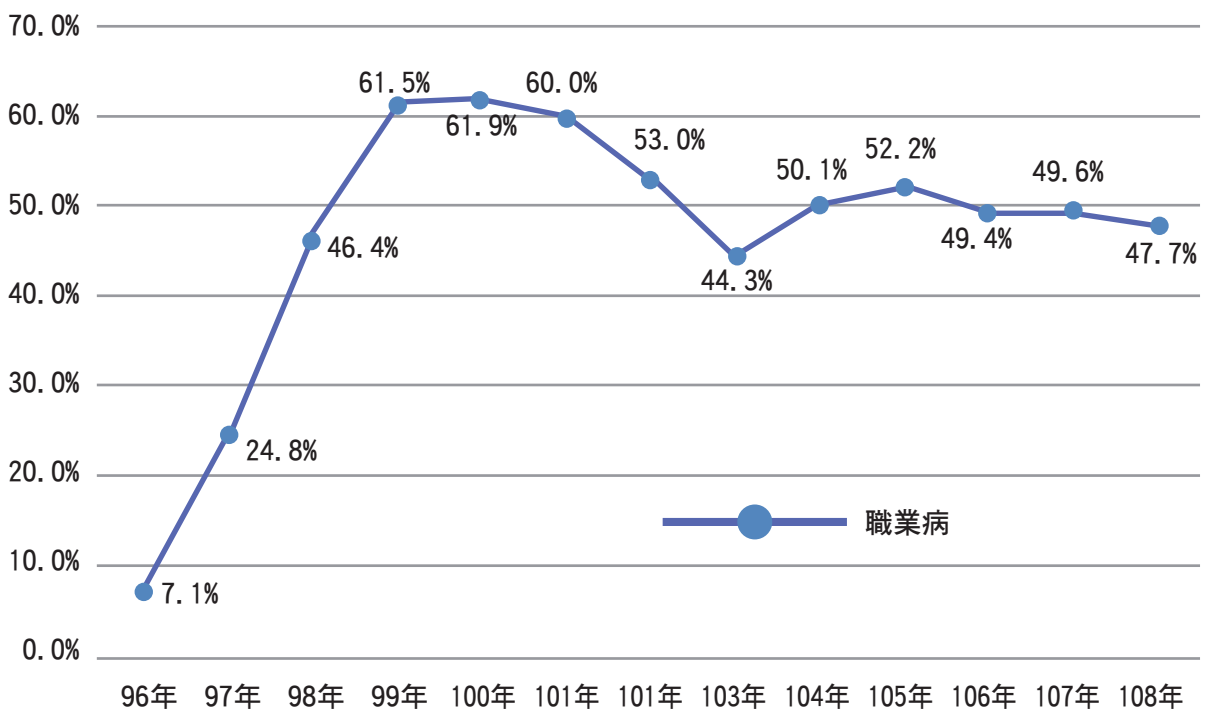


圖 32 歷年勞保職業病給付勾稽職業傷病通報系統資料結果

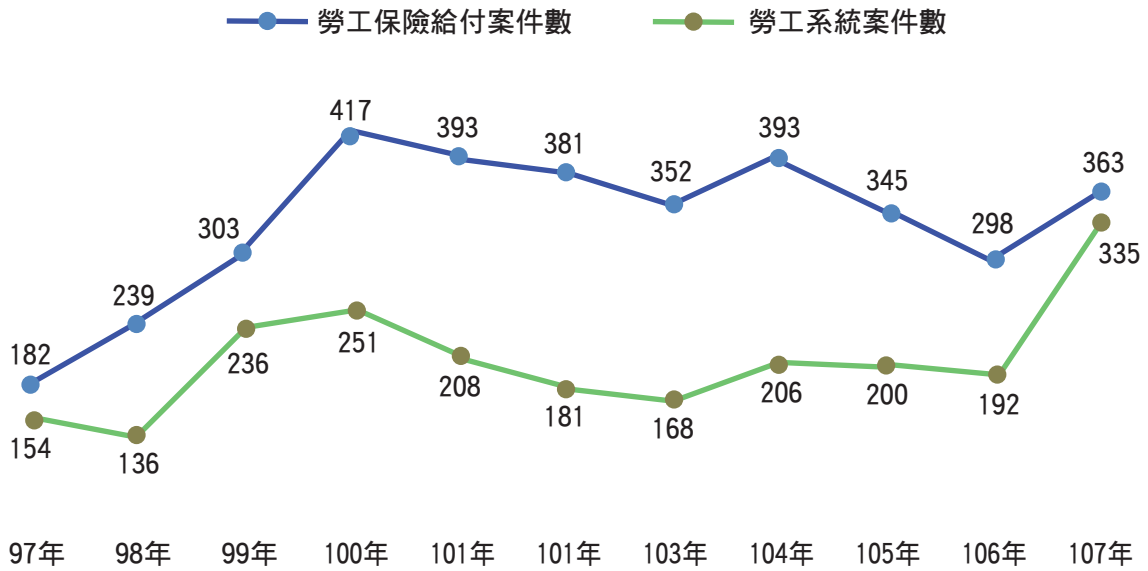


圖 33 手臂肩頸疾病勞保職業病給付與通報系統案件數比對結果

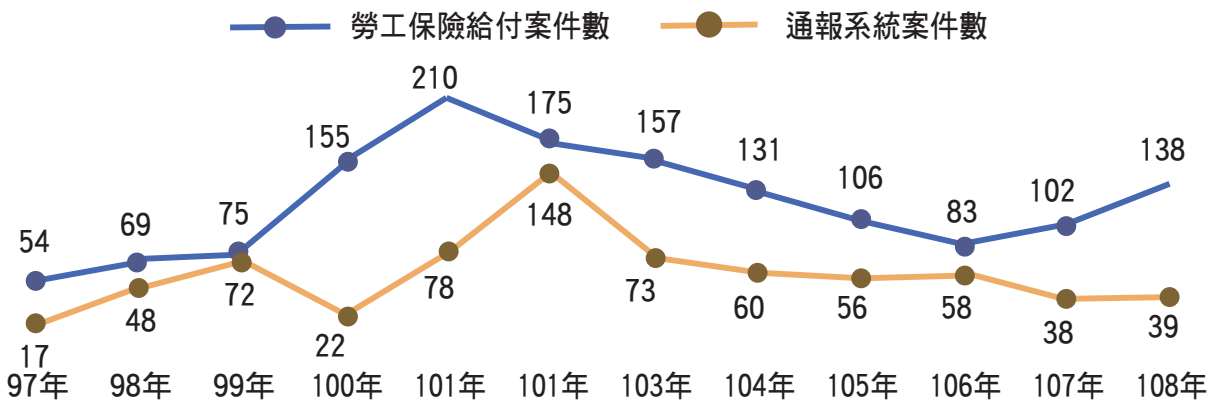


圖 34 塵肺症勞保職業病給付與通報系統案件數比對結果

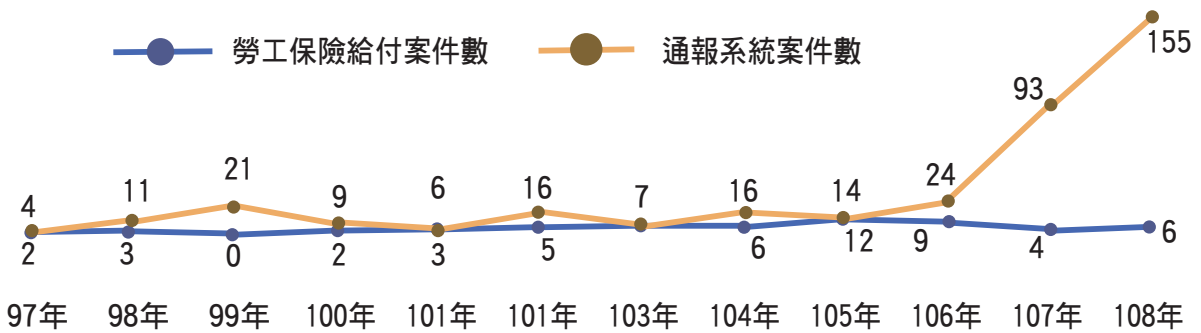


圖 35 矽肺症勞保職業病給付與通報系統案件數比對結果

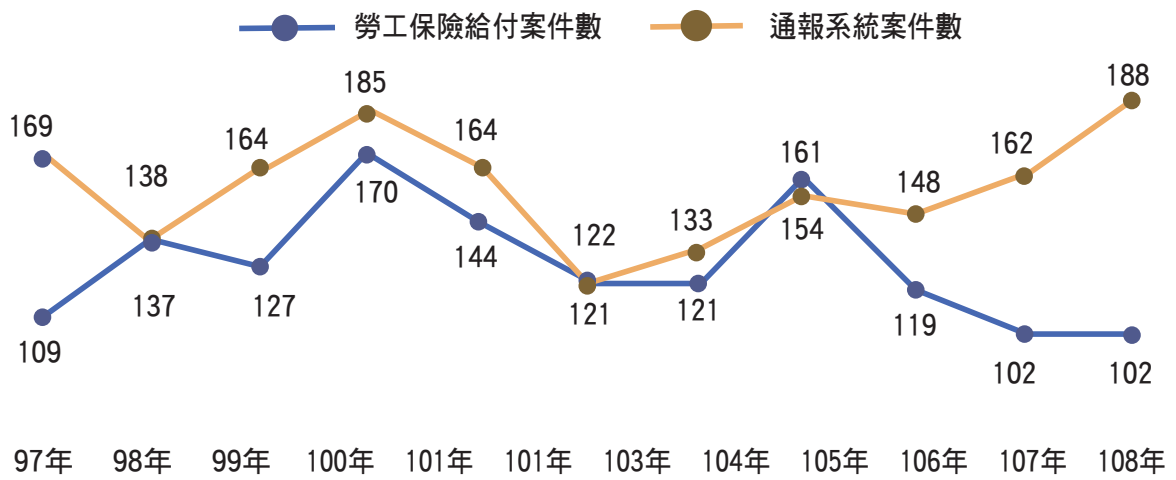


圖 36 職業性下背痛勞保職業病給付與通報系統案件數比對結果





第一章、97 至 108 年職業傷病通報分布情形

自 97 年職業傷病通報系統建置以來，由圖 37 的趨勢可得知職業疾病通報量穩定逐年提升，此為各家防治中心努力推廣職業傷病醫療服務之成果。97 年因通報系統初建立完成，屬第一年測試執行期，通報系統內包含 96 年所通報之職業傷病個案與部分職業傷害之個案，故 97 年通報之職業傷病個案量遠高於 98 年。待 97 年防治中心與網絡醫院熟悉職業傷病通報系統操作模式後，職業疾病與職業傷害通報已無通報系統操作不熟悉的問題，自 99 年起，每年職業疾病通報之個案量皆有穩定提升。

108 年共通報 2,290 件職業病個案，通過品質審查案件數共 2,204 件，職業病品質審查的通過率約為 96%。107 年開始，職業安全衛生署鼓勵防治中心及轄區內網絡醫院通報噪音性聽力損失以外的其他類型職業病（如職業性肌肉骨骼疾病、石棉引發之工作相關疾病等），並提升職業病通報品質，修正職業引發之噪音性聽力損失的審查標準，故噪音性聽力損失的通報數量減少；且因其他類型的職業病做出診斷時，尚須取得完整工作暴露資料後才能確定是否屬於職業病，期間所需花費時間較長，故自 107 年開始職業病通報案件數略有減少，待防治中心與網絡醫院熟悉調整後的通報流程後，108 年職業病通報案件數小幅提升。（圖 37）

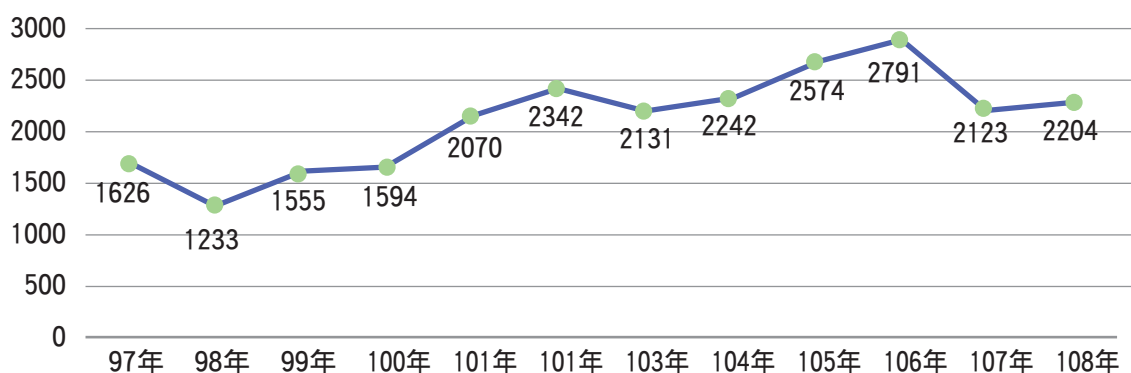


圖 37 歷年職業疾病通報數量（職業疾病 ICD-9 診斷確診且通過品質審查之通報個案）

職業病通報系統於 97 年設置完成並開始運作，該年防治網絡服務的職業病通報率為每十萬就業人口 15.5 人次，逐年穩定提升，往後隨著防治網絡服務之醫療院所數量增加，通報率也逐步穩定提升，108 年職業病通報率已提升至每十萬就業人口 19.2 人次（圖 38）。但若將噪音性聽力損失個案排除再予以統計，職業病通報率由 97 年的每十萬就業人口 11.6 人次至 103 年降低至每十萬就業人口 8.1 人次，至 107 年大幅提高至每十萬就業人口 12.9 人次，108 年為每十萬就業人口 12.7 人次，大致持平（圖 39），由此可推知 107 年鼓勵防治中心及網絡醫院醫師通報噪音性聽力損失以外之其他類型職業病的策略有成。

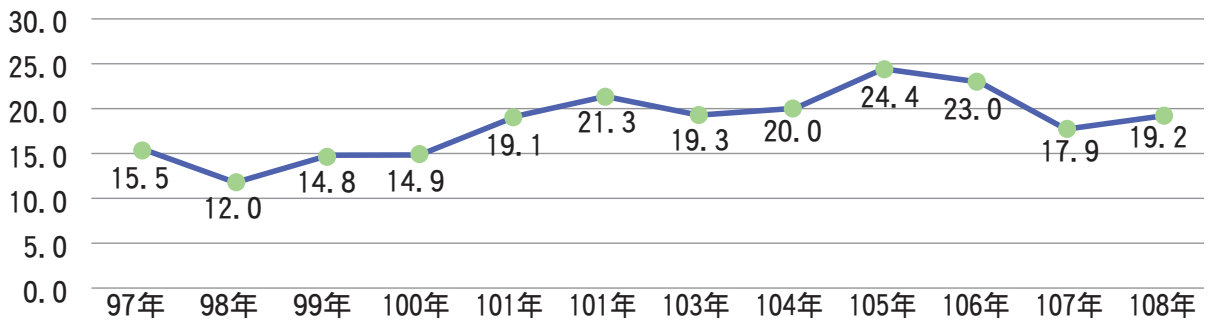


圖 38 歷年職業病通報率 (單位：每十萬就業人口)

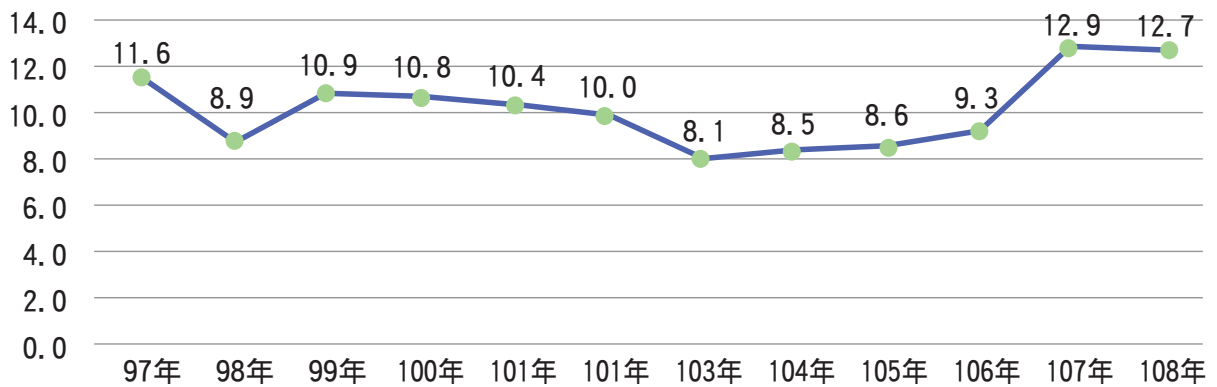


圖 39 修正聽力通報後之歷年職業病通報率 (單位：每十萬就業人口)

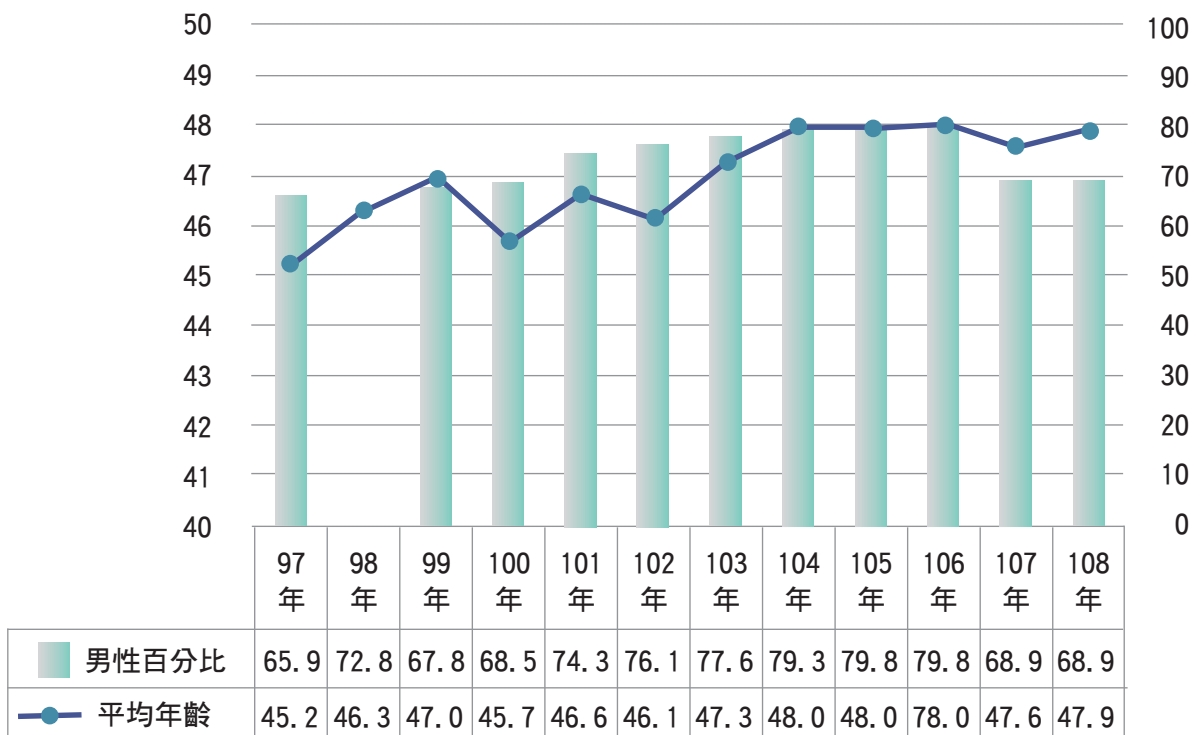


圖 40 歷年平均年齡與男性比



依圖 40 所示，歷年通報個案之個案平均年齡漸增，97 年被通報者平均年齡 45.2 歲，至 108 年 47.9 歲。歷年通報個案超過六成皆為男性。

常見通報職業病診斷及其對應之職業危害種類，依年度通報總人次排序，97 至 108 年之更迭差異如圖 41 所示。

97 年通報量居首位診斷為噪音性聽力損失，通報量為 404 人次；其次為腕隧道症候群，通報 230 人次；第三為腰椎椎間盤突出，通報 169 人次。108 年通報量最多仍為噪音性聽力損失，通報量為 738 人次；第二及第三常見通報診斷，為上肢肌肉骨骼疾病及接觸性皮膚炎，通報量分別為 339 及 304 人次。若以職業危害種類區分，97 年之前 10 大通報職業病中，主要為人因性危害佔最多數，化學性及物理性危害則各佔三項。至 108 年人因性危害仍佔最多數，而社會心理性危害（例如超時加班等工作過負荷因素）所致急性腦心血管疾病，通報量則上升至第七位，108 年度合計達 42 人次。除了急性腦心血管疾病及噪音性聽力損失，接觸性皮膚炎、上肢肌肉骨骼疾病、塵肺症及職業性癌症等通報量也呈現增加的趨勢。

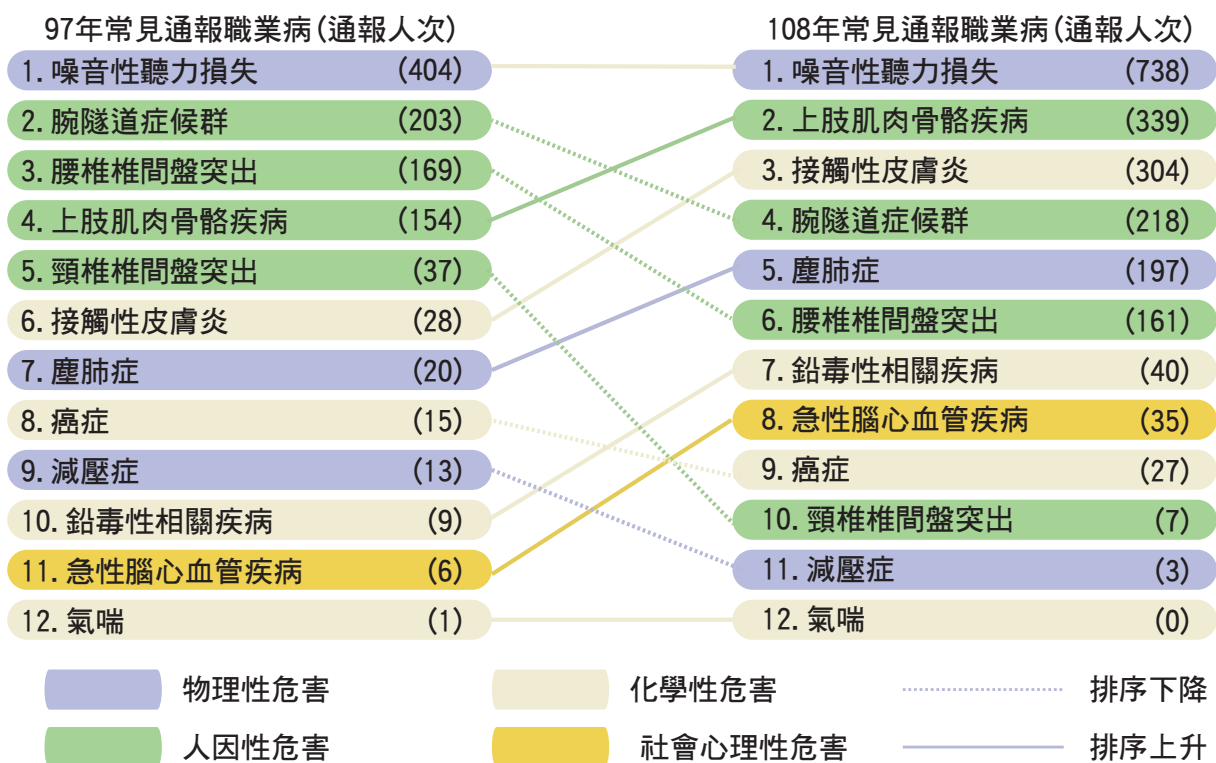


圖 41 職業病通報量排名前 10 位之診斷

表 8 為常見職業病診斷歷年通報人次。通報系統 12 年累計總通報量為 24,485 人次，其中噪音性聽力損失佔最多，97 至 108 年合計 10,953 人次，佔總通報量之 44.7%；其次為上肢肌肉骨骼疾病，共通報 2,658 人次，佔 10.9%；第三為腕隧道症候群，2,539 人次，佔 10.4%。噪音性聽力損失通報量顯著多於其他類型的職業疾病，推究其主要原因為工作場所中暴露噪音係《勞工健康保護規則》中所規範 40 項特別危害健康作業之一，相關勞工依法需每年至合格醫療院所接受特殊健康檢查及健康分級管理。防治網絡之職業醫學科醫師，定期為噪音勞工進行特殊健康檢查時，便能依據其純音聽力檢查結果及作業場所環境噪音測量值，評估個案聽力損失是否為工作噪音所致，即可認定通報為職業病。

除了上述職業安全衛生相關法規之推廣實行，會增加特定診斷職業病通報率外，若有重大職業災害新聞被報導關注，或是職業安全衛生署增修職業病認定參考指引時，也可能影響第一線職業醫學科醫師認定及通報職業病情形。以急性腦心血管疾病為例，99 年時新聞媒體大幅報導某科技公司員工因超時加班導致過勞猝死，同年底職業安全衛生署修訂《職業促發腦血管及心臟疾病之認定參考指引》，新修訂之指引具體描述超時加班、工作過負荷等因素為職業病認定要件，由表 6 急性腦心血管疾病之歷年通報量中，99 年以前僅 10 人次以下，100 年修定認定指引公告後，通報量便達 21 人次。

此外，跨醫療專科之諮詢照會及轉介認定機制也影響職業病通報率。由於臺灣整體醫療體系仍以全民健保為主，無論是否為職業病，絕大多數勞工罹病時，第一時間會先至職業醫學科以外之醫療專科尋求診療協助。若觀察接觸性皮炎之歷年通報量，97 年時僅 28 人，至 108 年時通報達 304 人，通報個案數顯著增加。分析通報來源後推測，可能原因便是防治網絡內之特定皮膚科專科醫師，有經過完整職業醫學專科訓練，能於門診治療病患皮膚疾患的同時，蒐集職業暴露相關資訊，並協助認定職業病通報。相較之下，職業性癌症累計通報量僅 168 人，通報率遠低於其他已開發國家。除癌症本身誘導期長、職業暴露證據蒐集困難等因素外，癌症病患所就診之專科分布相當多且廣，防治網絡內之醫療院所，要針對職業性癌症，建構完備之轉介認定機制並不容易。

依據不同職業病診斷，統計通報個案之平均年齡、性別比及常見行業別如表 9 所示。多數職業病診斷之平均年齡介於 40 至 50 歲之間，接觸性皮炎個案年齡分布較低，平均 36.0 歲；塵肺症及癌症個案通報時平均年齡較高，分別為 64.6 及 63.3 歲，主要因為此二種疾病，一般



於中壯年甚至老年後病程才會進展至症狀發生。於大部分職業病診斷中，男性個案比例皆達半數以上，減壓症、噪音性聽力損失及癌症，男性比例更高達九成以上。僅腕隧道症候群及上肢肌肉骨骼疾病，累計通報個案數女性多於男性，男性分別佔 32.5% 及 49.4%，推測可能係因工作場所中女性較常從事上肢動作重複性高的工作，因此發病比例高於男性。

製造業是最頻繁被通報發生職業病之行業，包括噪音性聽力損失、腕隧道症候群、上肢肌肉骨骼疾病、腰椎椎間盤突出等多項通報診斷。主要因為製造業工作環境，現場常有機械運轉而充斥著噪音，且大部分仍屬勞力密集作業，勞工潛在暴露手部高重複性動作、手臂高舉過肩施力、長時間彎腰搬重等各式人因性危害。急性腦心血管疾病 98-108 年累計共 233 人次，通報所佔比例最多為製造業、運輸倉儲業及其他服務業（包含保全）等，其勞工經常暴露之危險因子，包括長工時、需長期輪班或夜班工作等，醫學文獻已證明上述因素會顯著增加急性腦心血管疾病發生風險。

表 10 為常見職業病來源門診比例、因病停止工作比例及常見通報區域，癌症、氣喘及塵肺症的個案來源大多來自院內其他科部轉介，而噪音性聽力損失及鉛毒性相關疾病則大多源自勞工特殊健檢需複檢請職業醫學專科醫師重新分級的個案。

因罹患職業疾病而曾經停止工作的個案比例中，以急性腦心血管疾病最高（70.0%），腰椎椎間盤突出居次（48.1%），職業性癌症第三（46.9%）。罹患工作引發之急性腦心血管疾病的個案，需要花費較長的時間進行復健，甚至可能會有身體癱瘓的後遺症發生導致無法繼續工作，故因病停止工作的比例遠高於其他類型的職業疾病。罹患腰椎椎間盤突出的勞工在工作上經常需要負重或搬運動作，求診個案大多等到突出症狀明顯引發疼痛、痠麻等嚴重不適症狀，可能影響到工作時才就診，因此疾病的嚴重度以及因病停止工作的比例也較高。癌症因為治療過程繁複且療程相較其他疾病需要花費更多時間，停止工作比例也較高。除了因病停止工作的情形之外，死亡個案的比例也是評估疾病嚴重度的指標之一，罹患急性腦心血管疾病與職業性癌症死亡的個案比例分別為 29.4% 以及 22.2%，遠高於其他類型的職業病。

新北市及臺中市是常發生通報職業病的縣市。新北市為我國勞動人口最多的縣市，臺中市的勞動人口為勞動人口排名第三的縣市，勞動產業型態以勞力密集的傳統產業為主，故勞工發生職業疾病比例較高。另因大臺北都會區跟臺中都會區分別設有兩家防治中心（北部為臺大、北榮，中部為中國附醫、中山附醫），區域內可乘載的職業傷病服務量較高，故完成職業傷病通報的比例也較高。

石綿因耐磨、抗高溫等特性，且表面經濟利益高，早期在建材及造船等工業被廣泛應用。在石綿被國際癌症研究署 (International Agency for Research on Cancer, 簡稱 IARC) 列為一級致癌物後，歐盟已於西元 94 年全面禁用石綿，我國環保署也規劃將在 108 年 7 月全面禁用石綿。

表 8 常見職業病診斷歷年通報人次

| 職業病診斷 | 合計 | 97年 | 98年 | 99年 | 100年 | 101年 | 102年 | 103年 | 104年 | 105年 | 106年 | 107年 | 108年 |
|----------|--------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 噪音性聽力損失 | 10,953 | 404 | 323 | 406 | 437 | 935 | 1,248 | 1,239 | 1,294 | 1,635 | 1,695 | 599 | 738 |
| 上肢肌肉骨骼疾病 | 2,658 | 154 | 136 | 236 | 251 | 208 | 181 | 168 | 206 | 200 | 192 | 387 | 339 |
| 腕隧道症候群 | 2,539 | 230 | 166 | 216 | 253 | 231 | 202 | 184 | 212 | 184 | 196 | 247 | 218 |
| 腰椎椎間盤突出 | 1,891 | 169 | 137 | 164 | 185 | 164 | 121 | 133 | 154 | 148 | 162 | 193 | 161 |
| 接觸性皮炎 | 2,016 | 28 | 60 | 72 | 155 | 184 | 215 | 99 | 108 | 196 | 267 | 328 | 304 |
| 塵肺症 | 1,090 | 20 | 56 | 88 | 36 | 94 | 153 | 80 | 78 | 70 | 81 | 137 | 197 |
| 減壓症 | 318 | 12 | 70 | 45 | 49 | 69 | 26 | 19 | 18 | 2 | 4 | 1 | 3 |
| 鉛毒性相關疾病 | 316 | 9 | 38 | 22 | 9 | 21 | 48 | 36 | 17 | 21 | 31 | 24 | 40 |
| 急性腦心血管疾病 | 233 | 6 | 10 | 10 | 21 | 19 | 15 | 15 | 17 | 19 | 24 | 42 | 35 |
| 頸椎椎間盤突出 | 181 | 37 | 14 | 12 | 17 | 17 | 14 | 11 | 16 | 10 | 8 | 18 | 7 |
| 氣喘 | 146 | 1 | 9 | 90 | 31 | 1 | 3 | 3 | 1 | 0 | 3 | 4 | 0 |
| 癌症 | 168 | 15 | 13 | 15 | 18 | 12 | 5 | 8 | 5 | 4 | 16 | 30 | 27 |
| 其他 | 1,976 | 541 | 201 | 179 | 132 | 115 | 111 | 136 | 116 | 85 | 112 | 113 | 135 |
| 總計 | 24,485 | 1,626 | 1,233 | 1,555 | 1,594 | 2,070 | 2,342 | 2,131 | 2,242 | 2,574 | 2,791 | 2,123 | 2,204 |

表 9 常見職業病診斷年齡、性別及行業分佈

| 職業病診斷 | 合計 | 平均年齡 | 男性比 | 常見通報行業別 |
|----------|--------|------|------|--------------------------|
| 噪音性聽力損失 | 10,953 | 47.5 | 92.7 | 製造業、營造業、運輸及倉儲業 |
| 上肢肌肉骨骼疾病 | 2,658 | 48.7 | 49.4 | 製造業、營造業、住宿及餐飲業 |
| 腕隧道症候群 | 2,539 | 48.5 | 32.5 | 製造業、住宿及餐飲業、其他服務業 * |
| 腰椎椎間盤突出 | 1,891 | 49.6 | 83.1 | 營造業、製造業、運輸及倉儲業 |
| 接觸性皮炎 | 2,016 | 36.0 | 57.3 | 住宿及餐飲業、專業科學及技術服務業、製造業 |
| 塵肺症 | 1,090 | 64.6 | 66.2 | 製造業、礦業及土石採取業、營造業 |
| 減壓症 | 318 | 43.6 | 99.9 | 農林漁牧業、用水供應及污染整治業、其他服務業 * |
| 鉛毒性相關疾病 | 316 | 40.2 | 79.0 | 製造業、營造業 |
| 急性腦心血管疾病 | 233 | 50.4 | 87.8 | 製造業、運輸及倉儲業、其他服務業 * |
| 頸椎椎間盤突出 | 181 | 50.7 | 92.4 | 營造業、製造業、運輸及倉儲業 |
| 氣喘 | 146 | 47.1 | 61.0 | 製造業、營造業、住宿及餐飲業 |
| 癌症 | 168 | 63.3 | 96.2 | 營造業、製造業、專業、科學及技術服務業 |

* 註：其他服務業包含理髮美容、汽車維修、保全等。



表 10 常見職業病門診來源及常見通報區域比例

| 職業病診斷 | 合計 門診比例 | 因病停止工作比例 | 常見通報區域 | |
|----------|---------|----------|--------|-------------|
| 噪音性聽力損失 | 10,953 | 56.4 | 0.1 | 桃園市、臺中市、新北市 |
| 上肢肌肉骨骼疾病 | 2,658 | 72.5 | 34.7 | 臺中市、高雄市、臺南市 |
| 腕隧道症候群 | 2,539 | 66.2 | 27.1 | 臺中市、臺北市、新北市 |
| 腰椎椎間盤突出 | 1,891 | 70.0 | 48.1 | 臺中市、新北市、彰化縣 |
| 接觸性皮炎 | 2,016 | 90.1 | 2.1 | 高雄市 |
| 塵肺症 | 1,090 | 34.0 | 11.1 | 新北市 |
| 減壓症 | 318 | 95.9 | 0.5 | 屏東縣、臺東縣 |
| 鉛毒性相關疾病 | 316 | 38.7 | 0.2 | 宜蘭縣 |
| 急性腦心血管疾病 | 233 | 66.1 | 70.0 | 臺北市、臺中市、新北市 |
| 頸椎椎間盤突出 | 181 | 70.8 | 41.1 | 臺中市、新北市、臺北市 |
| 氣喘 | 146 | 19.3 | 8.2 | 高雄市、新北市、屏東縣 |
| 癌症 | 168 | 49.2 | 46.9 | 新北市、高雄市、桃園市 |

近年來日本、英國等國家皆發生數起大規模石綿暴露相關職業病的求償案件，國內亦有學者指出，臺灣即將進入石綿暴露相關疾病的發病高峰期，為因應石綿引發之相關職業疾病議題，防治中心積極挖掘因工作暴露石綿罹患相關職業病個案，108 年防治中心及網絡醫院共通報 22 例個案，其中有 16 例個案被確診為間皮細胞瘤，被診斷為間皮細胞瘤的個案皆為男性（圖 42）。22 例石綿引發相關之職業疾病個案中，除個案已死亡、個案放棄認定或仍在申請程序中之個案，已有 2 例個案獲得勞保相關給付。

圖 43 為防治中心及網絡醫院 108 年職業傷害通報資料，有別於職業安全衛生法規發生一死三傷一住院職災事件必須強制通報之系統，屬於醫療端的職業傷害通報，為防治中心與院內急診部門建立合作轉介機制，其傷害原因符合職業傷害意外事件者才予以通報。故通報最多者為上下班通勤職災，佔 29.0%。108 年共通報 5,000 件職業傷害個案。

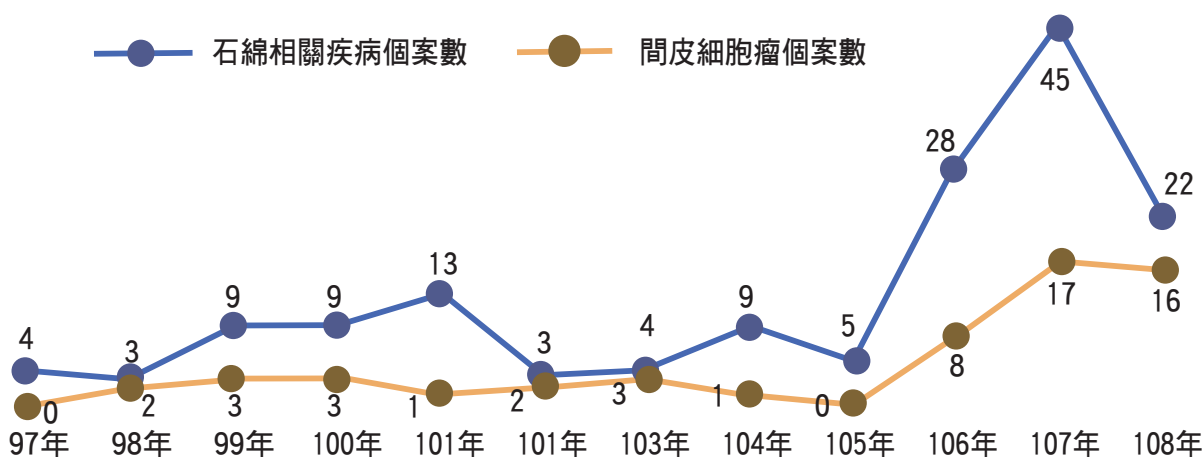


圖 42 歷年石綿暴露促發之職業病通報數

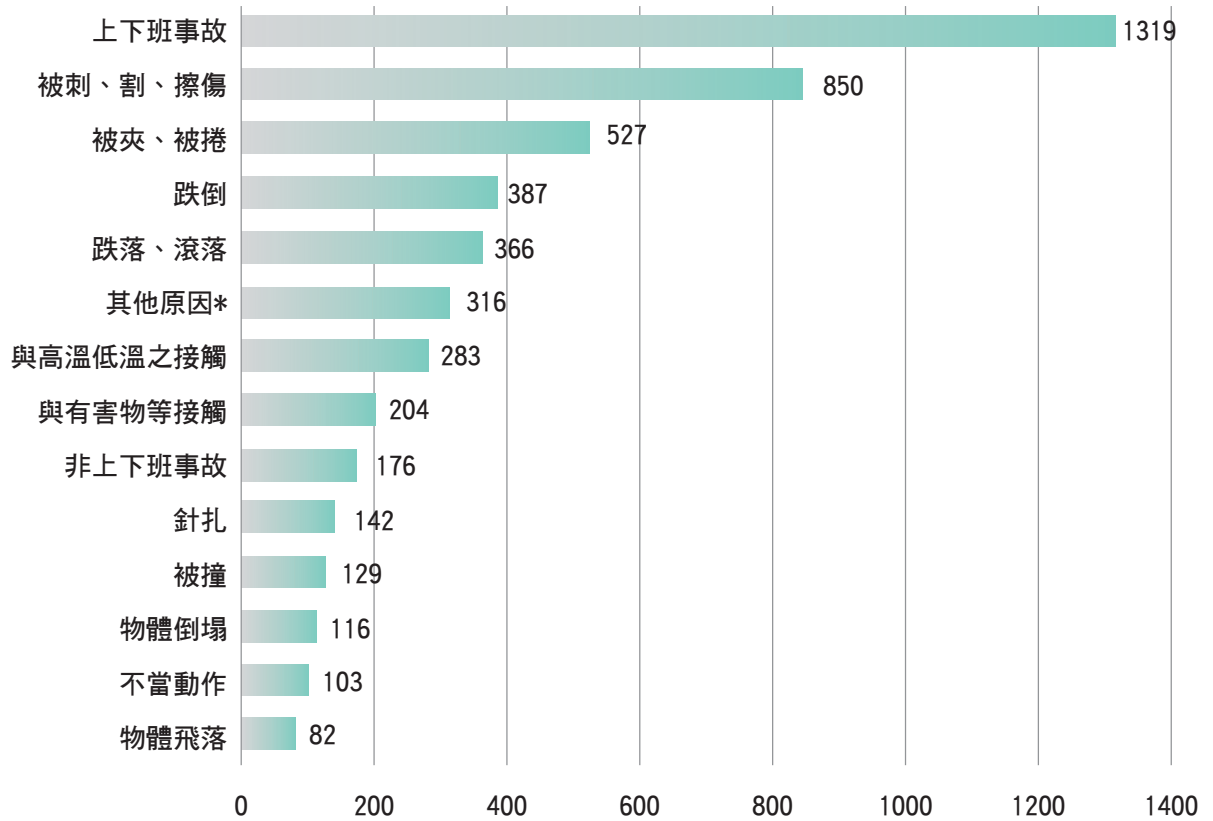


圖 43 108 年職業傷病通報系統內之職業傷害通報資料

* 註：其他原因 (*) 包含無法分類之職業災害類型 (即通報系統職業災害分類為「其他」的職業傷害通報個案) 共 193 例，以及通報系統內占總職業傷害通報數百分比低於 2.0% 之職業災害類型，包含：爆炸 (32 例)、感電 (31 例)、物體破裂 (22 例)、衝撞 (15 例)、血液污染 (14 例)、火災 (5 例)、踩踏 (4 例) 等。



第二章、防治中心 108 年群聚調查成果：非破壞性檢測游離輻射作業

防治中心可藉由職業疾病門診個案，進一步挖掘該個案服務之事業單位是否有其他勞工也罹患相似的疾病，並根據工作現場實地訪視，確認該種疾病發生是否與工作相關，並針對職業疾病發生之原因，向該事業單位提出預防性保護建議，以達成防治中心預防功能。(圖 44)

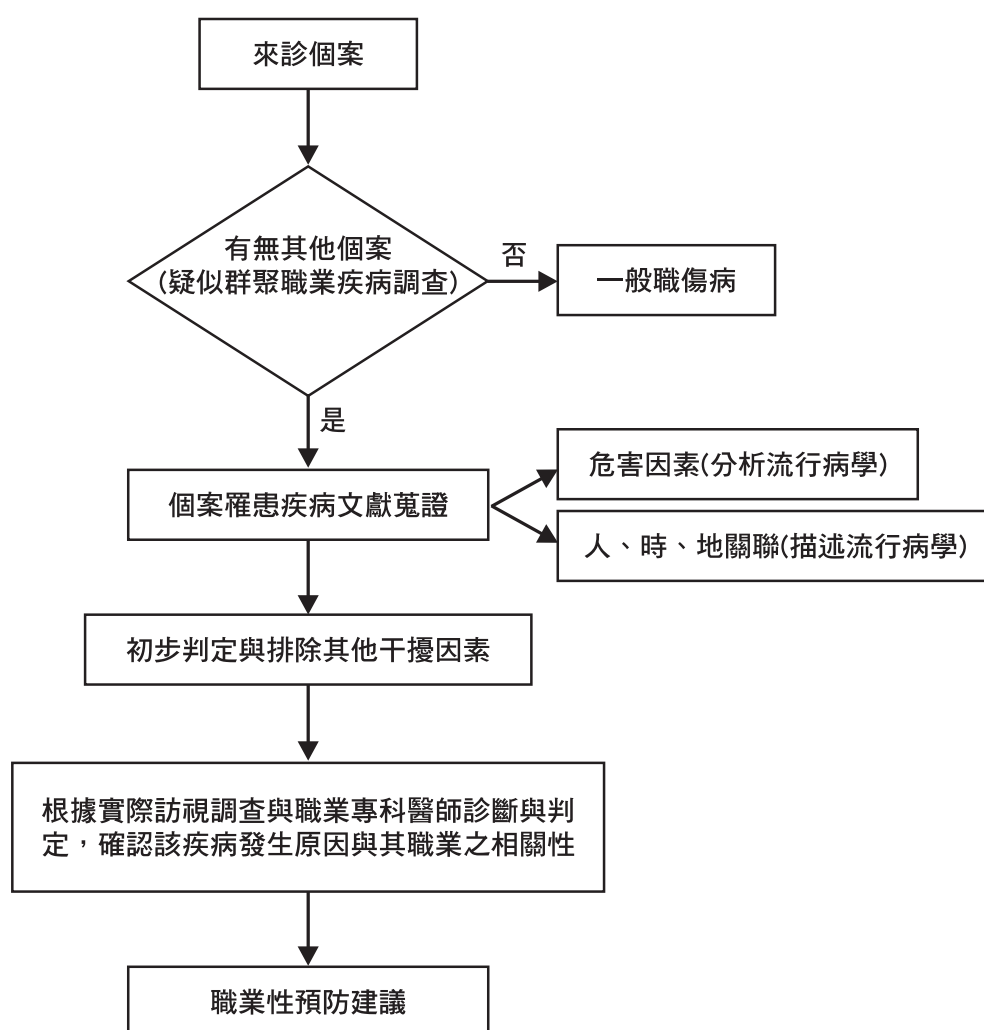


圖 44 職業疾病群聚事件調查流程圖

表 11 摘要整理 108 年管理服務中心與 10 家防治中心群聚調查成果。108 年發生從事非破壞性檢測游離輻射作業的勞工群聚罹患白血病的事件，引發社會關注，為釐清罹災的勞工危害暴露因子與患病因果關係，職業安全衛生署偕同中國附醫防治中心與高醫防治中心專業團隊進行調查，期望能獲得更多資訊，做為未來相關作業勞工健康保護政策的借鏡，故本節的群聚報告主要呈現非破壞性檢測游離輻射作業的群聚調查成果。其他防治中心的群聚報告成果以職業傷病通報系統內通報書較高的職業性肌肉骨骼疾病、職業性肺病、職業性聽力損失為主，將於附錄的章節中呈現。未來希望能透過改善現行的職業傷病通報系統，優化系統功能擴大疑似職業病的個案通報，並藉由串連特殊健康檢查的資料庫收集暴露資料，設計群聚或高風險個案調查的專案研究，以期發現更多潛在的職業病個案。

表 11 108 年管理服務中心與 10 家防治中心群聚調查成果

| 職業病類型 | 單位 | 群聚調查主題 | 行業別 | 工作性質 | 危害類別 | 暴露物質 |
|-----------|-----|-----------------------|-----------|----------------|----------|---------------|
| 職業性癌症 | 中國醫 | 非破壞性檢測游離輻射作業群聚調查 | 專業、科學及技術業 | 放射線檢測工作 | 物理 | 放射線（游離輻射） |
| | 高醫 | 非破壞性檢測游離輻射作業群聚調查 | 專業、科學及技術業 | 放射線檢測工作 | 物理 | 放射線（游離輻射） |
| 職業性肌肉骨骼疾病 | 中山 | 室內裝潢業木工罹患旋轉肌袖症之群聚調查 | 營造業 | 室內裝潢業木工 | 人因 | 重覆性關節肌肉動作、搬重 |
| | 彰基 | 美髮業工作者肌肉骨骼危害之群聚調查 | 其他服務業 | 美髮業 | 人因 | 重複性關節肌肉動作 |
| | 雲分 | 蠅養殖業工作者肌肉骨骼危害風險評估 | 農林漁牧業 | 蠅養殖業工作者 | 人因 | 重複性關節肌肉動作 |
| | 成大 | 手工製鞋業工作者肌肉骨骼危害調查 | 製造業 | 手工製鞋業 | 物理 | 重複性關節肌肉動作 |
| 職業性肺病 | 台大 | 石綿曝露工作者環境採樣分析調查 | 營造業、製造業 | 工作環境中有暴露石綿的工作者 | 化學 | 石綿、玻璃纖維 |
| | 長庚 | 重金屬（鋁）曝露之群聚調查 | 製造業 | 研磨及噴漆作業 | 化學 | 重金屬 |
| 其他 | 管服 | 實驗室工作者過敏疾病危害調查 | 專業、科學及技術業 | 實驗室研究人員 | 生物、化學、物理 | 小鼠過敏原等 |
| | 北榮 | 一氧化碳中毒群聚調查 | 住宿及餐飲業 | 廚房工作者 | 物理 | 一氧化碳 |
| | 慈濟 | 石作業工作者健康狀況及工作環境危害因子調查 | 製造業 | 石作業 | 物理、人因、化學 | 噪音、粉塵、重覆性關節動作 |



非破壞性檢測游離輻射作業群聚調查－中國附醫防治中心

群聚調查職業疾病類型：急性骨髓性白血病

個案工作性質與背景介紹：

個案 A、B、C (表 12) 從事非破壞性檢測 - 放射線檢測 (RT)，分屬同行業不同公司，歷年健檢紀錄呈現如下 (圖 45)，皆診斷同為急性骨髓性白血病。

表 12 中國附醫群聚調查個案基本資料

| 個案 | A | B | C |
|------|------------------------|-------------------|------------------------|
| 性別 | 男 | 男 | 男 |
| 年齡 | 31 | 44 | 48 |
| 工作內容 | RT 檢測師 | RT 檢測師 | RT 檢測師 / 助理 |
| 年資 | 7 年 6 個月 | 9 年 8 個月 | 斷續共約 16 年 |
| 疾病診斷 | 骨髓分化不良 症候群 | 急性髓母細胞性 白血病 | 骨髓分化不良 症候群 |
| 病程狀況 | 107/08 確診 107/10 逝世 | 107/08 確診 化療治療 | 107/08 確診 108/05 逝世 |

| 個案 | 日期 | WBC (4000- 11000) | RBC (4.5- 5.5*10 ⁶) | Hb (13-17) | PH | Eosinphil (<5%) | Lymphocyte (20-55%) | Monocyte (<12%) | Neutrophil (35-75%) | Basophile (~1.6%) |
|----|-----------|-------------------------|---------------------------------------|---------------|-----|--------------------|------------------------|--------------------|------------------------|----------------------|
| A | 101/04/20 | 8100 | 5.07 | 15.3 | 254 | 4.1 | 33.6 | 6.2 | 55.6 | 0.5 |
| | 102/05/20 | 6900 | 5.18 | 15.3 | 221 | 3.8 | 27 | 3.2 | 65.7 | 0.3 |
| | 103/04/14 | 7800 | 5.02 | 15.0 | 234 | 3.6 | 32.4 | 4.2 | 59.5 | 0.3 |
| | 104/05/05 | 6500 | 4.90 | 14.9 | 251 | 2.9 | 31.1 | 4 | 61.7 | 0.3 |
| | 105/04/25 | 7300 | 4.71 | 14.8 | 219 | 3.5 | 27.1 | 5.2 | 63.7 | 0.5 |
| | 106/05/04 | 4500 | 4.21 | 13.8 | 225 | 3.1 | 38.7 | 408 | 53.2 | 0.2 |
| | 107/04/30 | 2400 | 3.72 | 12.3 | 244 | 1.0 | 60.8 | 1.9 | 36.3 | 0.0 |

| 個案 | 日期 | WBC (4000- 11000) | RBC (4.5- 5.5*10 ⁶) | Hb (13-17) | PH | Eosinphil (0-7%) | Lymphocyte (19-49%) | Monocyte (3-9%) | Neutrophil (55-75%) | Basophile (~1.5%) |
|----|-----------|---------------------------|---------------------------------------|---------------|---|---|------------------------|--------------------|------------------------|----------------------|
| B | 96/06/04 | *4740 | 5.19 | 15.5 | 201 | 3.8 | 39.7 | 5.9 | *49.8 | 0.8 |
| | 97/10 | *3990 | 4.80 | 15 | 153 | 4.3 | 39.8 | 7.3 | *47.8 | 0.8 |
| | 98/09/28 | *2350 | *3.91 | *13.1 | *89 | 2.1 | 43.8 | 8.5 | *45.2 | 0.4 |
| | 99/09/01 | *2910 | *4.13 | *13.6 | *115 | 1 | 44.3 | 6.9 | *47.5 | 0.3 |
| | 100/08/26 | *3060 | *4.43 | 14.7 | *125 | 0.7 | 35.3 | 7.5 | 56.2 | 0.3 |
| | 101/09/08 | 5040 | *4.43 | 14.7 | *138 | 0.6 | 30.4 | 6.3 | 62.3 | 0.4 |
| | 102/08/24 | *4090 | 4.77 | 15.2 | *134 | 1.2 | 35.5 | 6.4 | 56.7 | 0.2 |
| | 103/09 | *4220 | *4.67 | 15.2 | 145 | 1.9 | 35.1 | 7.8 | *54.7 | 0.5 |
| | 104/09 | *4170 | *4.60 | 15.1 | 150 | 1.0 | 40.3 | 6.5 | *51.7 | 0.5 |
| | 105/08 | *4790 | *4.74 | 15.3 | 155 | 1.3 | 32.4 | 7.5 | 58.2 | 1.3 |
| | 106/10/27 | *2900 (3500- 10000) | *4.04 | *13.2 | *81 (150- 450 *10 ³) | *81 (150- 450 *10 ³) | 1.0 (1-7%) | 39.0 (*22-53%) | 8.3 (3-12%) | 51.4 (34-70%) |

| 個案 | 日期 | WBC (4000-11000) | RBC (4.5-5.5*10 ⁶) | Hb (13-17) | PH | Eosinphil (0-7%) | Lymphocyte (19-49%) | Monocyte (3-9%) | Neutrophil (55-75%) | Basophile (~1.5%) |
|----|----------|---------------------|-----------------------------------|---------------|-----|---------------------|------------------------|--------------------|------------------------|----------------------|
| C | 101/2/21 | 9700 | 4.75 | 15.9 | 306 | 1.4 | 37.2 | 6.2 | 55 | 0.2 |
| | 103/2/20 | 9000 | 4.82 | 15.1 | 282 | 3.1 | 29 | 4 | 62.9 | 1 |
| | 106/1/24 | *12390 | 4.96 | 16.1 | 290 | 1.4 | 20.2 | 7.1 | 71 | 0.3 |
| | 107/1/23 | 7060 | 4 | *13.3 | 139 | 3 | 33.7 | 7.3 | 55.8 | 0.2 |
| | 107/8/11 | *3200 | *2.36 | *7.1 | *35 | 0 | 40 | 0.9 | 34.8 | 0.9 |

圖 45 中國附醫群聚調查個案歷年健檢紀錄

非破壞性檢測是工業上常見的檢測作業，旨在不破壞構造、特性、形狀、功能的情況下，對物品做內部缺陷及瑕疵的檢測技術，檢測方法有許多種，常見如目測 (VT)、磁力檢測 (MT)、渦電流檢測 (ET)、液滲檢測 (PT)、超音波檢測 (UT)、放射線檢測 (RT)。工業上對於壓力容器、儲槽、管線結構等品質檢測較普遍使用放射線檢測法 (Radiography Testing, RT)，其原理為使用高穿透力的放射線 (X 射線、 γ 射線) 照射檢測物，藉由底片上生成影像判讀檢測物的瑕疵及缺陷。RT 作業需使用放射性設備 (圖 46)，在台灣使用之射源以 Ir-192 為主，公司接受業主委託後派 RT 檢測師至業主指定地點進行檢測作業，按照法規，RT 作業需設置管制區 (圖 47)，為免影響工廠正常運作，RT 檢測師工作時間落於 PM3:00-AM1-6:00，每日工時約 10-14 小時，每周平均工作 6 天，工作時間包含現場拍攝及沖洗底片，據個案保守估計每日拍攝約 150-200 張底片。



γ -ray 設備，由前導管、射源屏體、推送搖把組成，操作方法為轉動推送搖把將屏體中的射源 (Ir-192) 沿著前導管推送至導管最前端，利用放射線照射檢測物。

圖 46 RT 作業檢測設備介紹

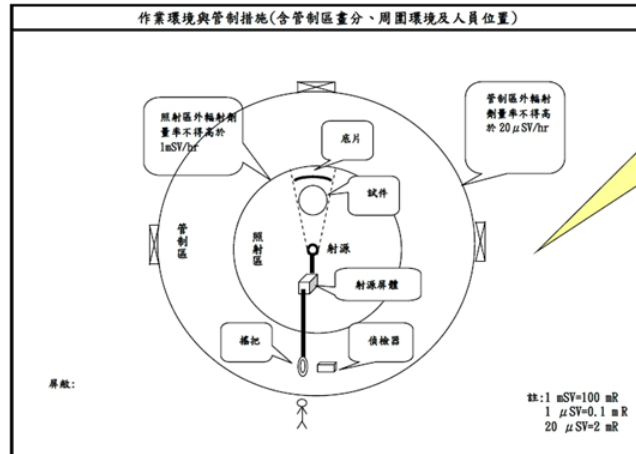


圖 47 放射線檢測作業管制區設置圖

訪視目的：

防治中心於 107 年底相繼收到 3 位從事 RT 作業之個案及個案家屬尋求職業病評估。急性骨髓性白血病為我國職業病種類表列疾病，又 RT 作業屬游離輻射作業，為游離輻射職業病認定參考指引所示相關行業，且白血病於一般族群發生率相對低，防治中心所收個案數顯示此行業中白血病發生率異常高，為釐清該作業與個案所患疾病之相關性，遂會同主管機關及檢測公司進行職業暴露調查。

調查結果：

RT 作業主要為 2 人一組，由檢測師以及助理配合進行操作，先在待測務上放置底片，依現場地形、檢測物位置，尋找適合地點固定好設備，釋出射源 (Ir-192) 拍攝 (圖 48)。



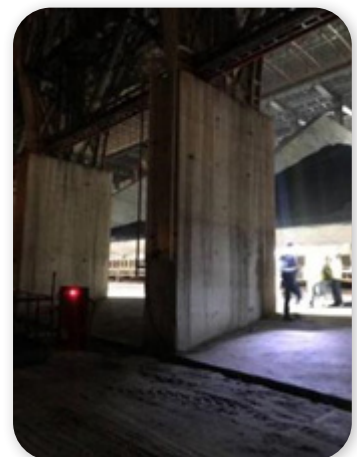
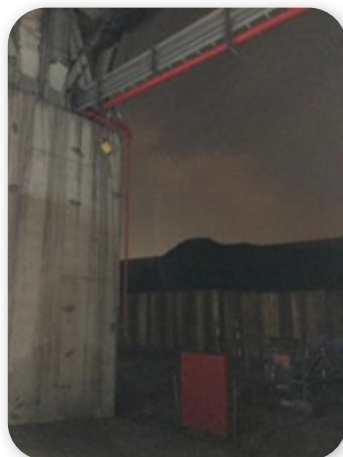
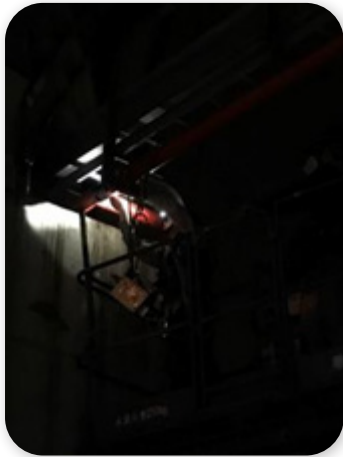
訪視當日使用之射源屏體及檢測師裝備配置 (含偵檢器、劑量徽章)



射源屏體位於人員腳邊時，
個人偵檢器計測值 $0.7 \mu\text{Sv}$



使用高空作業車載升檢測師至檢測管線所在高度



於待測物（紅色管線）貼底片、調整照射方向（左圖）、固定完成之射源屏體（中圖），
推送搖把則拉至於屏蔽物（水泥牆）後操作（右圖）



釋出射源前，搖把位置輻射
計測值（屏蔽物：1 道水泥牆）



拍攝時人員位置輻射計測值
（屏蔽物：2 道水泥牆）

圖 48 游離輻射檢測師實際拍攝作業圖



射源釋出為檢測師主要輻射曝露來源，曝露劑量應以法規要求游離輻射作業人員所配戴之劑量佩章數值計算，中心 3 位個案歷年曝露劑量佩章累計曝露劑量分別為 9.9 毫西弗、19.7 毫西弗、3.55 毫西弗，並未超過法規每年 50 毫西弗之劑量限度，然而個案自述為避免曝露劑量超過標準，實際工作時未將劑量佩章確實配掛於身上，可能導致劑量佩章讀值不準確，考量工業廠房、鍋爐內部確有高空作業車不便深入、施工架搭設條件不盡理想及現場難尋屏蔽的可能，進而對個案自述之檢測業務曝露量進行理論上的模擬試算，以不同管線設備檢測的環境條件為參數時，單日曝露量為 2.22-37.27 毫西弗。

曝露劑量高低可能造成的危害程度，隨著研究發展還有許多討論空間，國際放射防護委員會 (ICRP) 多年來持續發表及修改建議書，目前仍可將輻射危害分為高劑量曝露導致的確定效應和低劑量輻射曝露可能引起的機率效應，依照 ICRP 建議，輻射相關工作人員每年曝露劑量建議 1 年不超過 20 毫西弗，我國法規上限則為一年 50 毫西弗或五年 100 毫西弗以內。急性骨髓性白血病及骨髓增生不良症候群發病在 50 歲以前是較罕見的，研究統計白血病於亞洲男性 30-34 歲發生率每 10 萬人約 3.55 人 (取至 ICRP, 2007, The 2007 Recommendations of the International Commission on Radiological Protection, Table A.4.15)。而 Health Risks from Exposure to Low Levels of Ionizing Radiation: BEIR VII Phase 2，預估每 100000 個男性曝露於 0.1Gy 後約有 100 位產生白血病，其他國外期刊個案報告 (case report) 非破壞性檢測員工因輻射曝露產生血液相關癌症 (Two Case of Erythroleukemia and Myelodysplastic Syndrome in a Non-Destructive Inspector.)，本次調查的 3 位個案發病年齡為 31、43 歲及 47 歲，分屬的 2 家公司執行放射線檢測業務總人數約 40 人，已出現至少 3 位員工罹病，綜合各項資料顯示該行業發病率及輻射曝露量高於各項研究報告。

建議：

基於此檢測法所使用的射源屏體相當容易攜帶和操作，使其成為最需注意使用安全和操作人員健康危害的行業，尤其檢測師處於完成業務的時效性壓力以及靠拍攝底片數量提升薪水績效的推動下，檢測師每日拍攝的底片數量甚至可能遠超過理論推算所設的參數，同時也不會尋找較遠的屏蔽或保持相對安全的距離。若按照標準作業流程並遵照輻射防護法規，該行業輻射曝露造成的健康風險危害應當極低，機率效應產生的健康危害更低，也因發病率不高，輻射作業引起健康危害案例常以零星個案呈現，加上 RT 檢測行業多為師徒制，口耳相傳的經驗法則易忽略健康危害風險意識的傳承，1999 年台灣南部發生的放射線檢測意外事件當時所記載的「無攜帶任何個人劑量佩章」情形，仍見存於 20 年後的檢測行業，不準確的曝露劑量通常難

以作職業病聯想和評估，且本次調查過程中亦發現檢測公司其他員工罹患相似疾病，卻由於發病至逝世時間相當短暫，又公司與勞工家屬迅速達成協議，致使該行業中相關疾病案例並不會在職業病通報系統及勞保職災給付系統中留下紀錄，難以產生警惕效果，因此提出 6 項建議：

- 1、事業單位應確保檢測作業人員皆具有專業證書並遵守法規要求。
- 2、事業單位應落實職業安全衛生教育，確保勞工具有健康危害風險意識，執行作業時注意自我保護。
- 3、檢測人員應確實配戴劑量佩章，配合查核及記錄。
- 4、事業單位應盡量給予合適防護設備，檢測人員執行作業前可作環境勘查，制定作業計劃，確保作業時有足夠的屏蔽，當承接案量較大時，事業單位應協調人力輪替，降低檢測人員曝露量。
- 5、檢測人員應確實填寫工作紀錄，交由事業單位管理保存，甚至電子化或待檢方與檢測方做線上申報系統，以利長久保存紀錄，便於查核與管控人員曝露量。
- 6、調查過程中發現個案病程發展快速，特別危害健康作業人員健康檢查異常資料回報後雖有公文提醒調配職務，但實際執行速度難敵病程發展速度，且個案歷年健檢紀錄有異常趨勢，建議加強輻射作業查核健檢紀錄，或優化申報及反應機制，加速警示危害風險較高的事業單位及勞工。





非破壞性檢測游離輻射作業群聚調查－高醫防治中心

群聚調查職業疾病類型：

疑似職業引發之白血病

個案工作性質與背景介紹：

4 位個案先後皆確診白血病，均為放射線檢測現場操作的作業員，其中三位已過世。罹病的員工約 20、30 多歲進入業界服務，估計的工作暴露時間在 7~12 年之間，其中 3 位個案曾於 106 年參與大量的放射照相作業。(表 13)

表 13 高醫群聚調查游離輻射作業個案基本資料

| | 個案 A | 個案 B | 個案 C | 個案 D |
|--------|--------------|-------------|--------------|-------------|
| 出生年份 | 76 年 | 64 年 | 70 年 | 61 年 |
| 入行年份 | 100 年 (24 歲) | 96 年 (32 歲) | 95 年 (25 歲) | 97 年 (36 歲) |
| 罹患疾病 | 白血病 (31 歲) | 白血病 (43 歲) | 淋巴性血癌 (37 歲) | AML (47 歲) |
| 預估暴露時間 | 7 年 | 10 年 | 12 年 | 11 年 |
| 目前狀況 | 已過世 | 離職 | 已過世 | 已過世 |

訪視目的：

透過事業單位工作現場訪視個案的工作內容與防護設備，評估 4 位罹患白血病個案的疾病與工作內容是否有相關性及群聚情形發生，並檢視其作業環境是否有其他可能的健康危害因子。

調查結果：

高醫防治中心群聚事件調查的 4 位個案，皆為放射線照像檢測員，主要過程為使用游離輻射對待測物結構進行量測，以及拍攝底片沖洗與判讀。因該作業須進行輻射管制且有時間急迫性，故作業時間主要以夜間為主，並須於隔日早上交出將讀片報告。據公司員工所述，工作量視訂單及產量而定，平均每天每人需拍攝 300~500 張，但於民國 105~107 年，曾接下發電廠之大量訂單，以致在民國 106 年曾有兩次連續三個月每日須拍攝超過 1000 張之情形，但在此兩年間該公司未有收到原能會提出輻射劑量超標警告，也未有員工反應出現過急性輻射暴露症狀情形。同時因員工作業會攜帶警報器與輻射測量儀二合一機，可即時監測自身暴露的輻射劑量，據先前經驗，主要在局限空間作業內才會出現警報器異常偵測而撤離情形。(圖 49、圖 50)。

| | | |
|---|--|---|
| <p>模擬現場施工照片</p> | <p>該公司所採用之輻射警報器與輻射測量儀二合一機型</p> | <p>公司提供測量人員穿戴輕便型半身鉛衣</p> |
|  |  |  |

圖 49 高醫群聚調查個案放射照相作業

| | | |
|---|--|---|
| <p>沖洗作業區</p> | <p>烘片區</p> | |
|  |  | |
| <p>沖洗相關化學品(大蘇打、赤血鹽)</p> | <p>顯影液 G128</p> | <p>定影液 G328</p> |
|  |  |  |

圖 50 高醫群聚調查個案沖洗底片作業



根據事業單位提供的 105 年至 108 年體外輻射劑量測試報告，環境暴露數值均未有高於法規的情形發生，且背景值佩章（熱發光劑量 thermoluminescent dosimeter, TLD）讀值也未有異常情形。高醫防治中心團隊進行現場訪視時，該公司的員工確實知悉正確的穿戴佩章方式，且自述於測量操作時有確實佩戴，故以下就員工於執行作業時穿戴佩章方式確實之情形下討論。102 年~106 年的五年全身累計劑量為 B~7.57mSv（平均 4.63 mSv，標準差 2.83mSv），而罹病的 4 位個案分別為 7.31、7.57、6.25 mSv；第 2 位個案因已離職，暴露時間只統計至 106 年 1 月 31 日，累計量為 4.96mSv（同期的 5 年全身累計劑量為 B~5.95mSv，平均 3.32 mSv，標準差 2.03mSv）。顯示罹病個案與未罹病員工的暴露量相比，雖未有統計顯著上的差異，但有暴露量較多之趨勢。

而沖洗底片的作業所需要接觸的物質（如：大蘇打、赤血鹽、顯影液 G128、定影液 G328 等）目前尚未有研究證實會致癌。

依據職業起因之游離輻射的職業病認定參考指引，非破壞性檢測員工屬於游離輻射高危險作業。且游離輻射在 IARC 被列為一級致癌物，致癌效應為機率效應。該事業單位 18 位從事非破壞性檢測員工中，有 4 人自 107 年至 108 年間先後罹患白血病，估算其粗發生率約為 0.1667。104 年我國白血病的發生率約為 0.00009708，且據 104 年衛生福利部的白血病及惡性淋巴瘤申報人數統計資料、100-104 年台灣癌症登記中心的白血病年齡別發生率資料及內政部的人口統計資料估算，並以 104 年全國男性人口做為標準加權值，估算得到標準化發病比 SMR 為 3531.3001（表 14）。根據前述的暴露資料，發現罹病員工的輻射暴露劑量較未罹病者高，時序性上也符合白血病 2~10 年之潛伏期。雖然本調查的樣本數少且無相同時期的對照案例，且存在健康勞工效應（入行年齡主要青、中年，24~36 歲），並有家族史及工作以外可能的化學物質暴露等干擾因子，也須考量員工在工作場所中是否全程正確佩戴輻射背章，但藉由標準化發病比調整偏差後在研究統計上仍然達到顯著，雖然本研究個案未有足夠證據證實自身的輻射暴露劑量超過法定許可範圍，但此 4 位個案的疾病與職業暴露可能有相當因果關係。（表 14）

表 14 高醫群聚調查發病員工與 104 年全國男性罹患白血病的標準化發病比

| 某 NDT 公司員工 | | | | 2011~2015 發生年代年 齡別發生率 | 2015 年全國男性 | | |
|------------------|--|-----------|------------|-----------------------------|-------------------------|-----------|------------------------|
| 年齡 | 發病數 | 族群 人口數 | 年齡別 發病率 | 年齡別發 病率 | 發病數 | 族群 人口數 | 年齡別 發病率 |
| 25~29 | 0 | 2 | 0 | 3.37×10^{-5} | 32 | 818,133 | 3.911×10^{-5} |
| 30~34 | 1 | 6 | 0.1667 | 4.05×10^{-5} | 32 | 948,459 | 3.373×10^{-5} |
| 35~39 | 1 | 5 | 0.2 | 4.70×10^{-5} | 47 | 1,004,245 | 4.680×10^{-5} |
| 40~44 | 1 | 8 | 0.125 | 5.26×10^{-5} | 45 | 877836 | 5.126×10^{-5} |
| 45~49 | 1 | 2 | 0.5 | 6.58×10^{-5} | 56 | 913,117 | 6.133×10^{-5} |
| 50~54 | 0 | 1 | 0 | 9.29×10^{-5} | 79 | 926,100 | 8.530×10^{-5} |
| 25~54 | 4 | 24 | 0.1667 | - | 291 | 5487890 | 5.303×10^{-5} |
| 累積發 病率 | 0.6290 | | | 3.3245×10^{-4} | 3.1750×10^{-4} | | |
| 年齡標 準化發 病率 | 0.1686 | | | 5.5664×10^{-5} | 5.3026×10^{-5} | | |
| 標準化 發病比 | 3531.3001 (95%CI: 962.1604~9041.5307) | | | - | 1 | | |

建議：

國內放射性檢測常以銥 (Ir192) 作為放射源，其產生的伽瑪射線游離輻射範圍在 206~612KeV 之間，用以檢驗 19~70mm 厚度的鋼材，確認待測物的結構是否有瑕疵的情形，例如：以放射性檢驗壓力容器的焊道確保產品是否符合壓力容器安全檢查的標準。伽瑪射線的穿透力強，檢測過程可能使勞工暴露在游離輻射的相關危害，且在輻射暴露後，白血病的發生有較長的潛伏期，可能長達 30 年，即使員工不再從事放射線相關作業，建議仍應持續追蹤是否有癌症發生。建議事業單位可藉由訂游離輻射作業安全計畫，短中長期計畫，並考慮採行以下方式，降低可能的危害暴露：

- 1、工程控制：預防危害暴露最有效方法是工程改善，藉由工程設備的改良或者製程的調整改變目前的作業內容與方式，進行工程控制：
 - (1) 因游離輻射致癌效應為機率效應，可以權衡其他非破壞性檢測取代此項檢查，並制定相對應之檢查標準規範，將暴露減至最少。
 - (2) 在可接受的檢驗，可考慮使用其他放射能量或活度之放射線物質（如銻 75）取代銥 (Ir192)。
 - (3) 加長導管長度能使工作人員操作照相業務時遠離放射線，屬於輻射防護的增加距離技巧（例如由原本的 15 英尺增加為 30 英尺），減少受到輻射暴露的計量。



2、行政管理

- (1) 建議定期進行游離輻射工作教育，宣導安全的工作流程，增加員工（特別是新進員工）的危害認知。
- (2) 確實填寫工作日誌須，並不定期稽查員工是否有正確使用防護具。
- (3) 訂定每人每天放射線照相張數的上限，避免造成過多的游離輻射暴露。
- (4) 確實佩戴並定期監測輻射佩章讀數，更積極安排特別危害健康作業勞工健康檢查，尤其血液學、甲狀腺功能等須特別留意。新進員工可安排職前健檢，確認基礎數值以備未來與工作後的數值比較差異，並期望達到早期診斷早期治療的目標。
- (5) 員工若罹患下列不適合從事游離輻射作業之疾病，如：血液疾病、內分泌疾病、精神與神經異常、眼睛疾病、惡性腫瘤等，可視情況調整職務或工作內容。
- (6) 施行母性健康保護計畫：雖然該事業單位的放射線檢驗工作區無女性員工，但公司內有存放放射性核種，仍建議主管於得知女性勞工妊娠之日起至分娩後一年期間，應對於女性勞工從事上述有母性健康危害之虞的工作採取相關措施，包括危害評估與控制、醫師面談指導、風險分級管理、工作適性安排及其他相關措施，例如：存放放射線核種處應設管制區、於管制區設置實體圍籬，進出口處及區內適當位置設明顯之放射示警標誌及警語等，以免暴露游離輻射造成流產或畸胎。

3、個人防護具

- (1) 輻射防護主要以阻絕、稀釋、分散、除污防止體內暴露；同時以時間、距離、屏蔽、衰減技巧預防外來暴露。
- (2) 由於游離輻射暴露無法由人體感官感知，需藉由佩戴臂章或監測儀器測得暴露資料，故正確的佩戴佩章或監測相當重要，並且需定期繳回原能會作校正，確保提供勞工保護。
- (3) 當發生輻射外洩時，需以鉛布、鉛毯等阻絕放射線的洩漏。
- (4) 鉛衣對於伽瑪射線之防護功能可能有限，因此需注意勿穿著過重或不合適等影響員工行動的鉛衣，反而增加暴露游離輻射的時間，造成反效果。
- (5) 鉛衣使用時須注意規格是否合適，檢視外觀完整性並定期檢測，保存時盡量攤開平放、以專用衣架吊掛，必要時可輕捲成鬆散的圓桶狀，避免彎角折疊鉛衣。
- (6) 由於非破壞性檢測可能會在桶槽或管線處進行作業，需注意可能遇到作業區域有存放或運輸有害物質的情形，應配戴相對應的防護具，並注意可能會遇到密閉空間作業問題。

於底片沖洗作業時，雖然使用的物質不具致癌性或腐蝕性，但仍建議使用化學防護手套、護目鏡及普通口罩，以避免接觸藥劑產生刺激或過敏傷害。

肆、未來展望

據勞工保險局提供之勞工保險職業災害給付統計資料（含：傷病給付、失能給付與死亡給付），101年申請勞工保險職業傷害及職業病給付案件數共計67,747件，102年64,509件，103年62,066件，104年59,352件，105年56,704件，106年55,011件，107年54,263件，108年50,004件，雖然每年的給付申請件數有緩降的趨勢，但我國每年平均近6萬餘人發生職業災害申請職災給付，因應少子化、高齡化時代來臨，產業缺工漸成常態，為使每位勞工能在安全健康職場環境工作，實有必要整合職災保險相關法令以擴大職災勞工保障、建置永續的預防與重建服務機制。

一、預防、補償與重建為職業災害保護核心

德國（1884）、日本（1947）、韓國（1964）國家之共同特色為職業災害保險單獨立法，將職災保險總支出一定額度用於職災預防與重建工作，並成立預防、醫療及重建公法人機構專責辦理。民國95年國際勞工組織（International Labor Organization, ILO）C187「職業安全衛生促進架構公約」及其建議書提出，國家應以法律明定職災保險投入職災預防；依國際社會安全保障協會（International Social Security Association, ISSA）調查結果，世界上大部分國家均建立了社會保險系統，然而，許多國家仍僅限於提供職業災受害者補償，而非致力於預防。

民國97年世界職業安全衛生大會首爾宣言，呼籲社會保險組織必須扮演職災預防之關鍵角色，以社會保險基金促進工作環境改善，強調職業安全衛生是社會安全的核心工作，社會保險的「預防投資」可以顯著減少職業災害與疾病發生並增進勞工健康與生產力，有利於企業及整體社會發展。勞工發生職業災害或是罹患職業傷病後，如何照顧職業傷病勞工，使其最終能回到職場，才是健全並永續國家整體勞動力的首要目標，職災保險機構應與職業安全衛生主管機關、社會夥伴合作，減少給付或補助。

德、日、韓等國執行職災保險之預防、醫療照顧、重建等相關業務，係由每年職災保險收入提撥一定比例（例如韓國職災保險法明定8%以上）作為經費，並成立一個或多個既非政府機關、也非營利組織的獨立法人機構辦理。我國目前每年由職災保險收支節餘提撥40%至60%的經費作為職災保護專款，惟因現行的職災保險費率與其他國家相比之下偏低致收支結餘有限，預防重建業務較易受到節制，為改善此一問題，勞動部108年擬具《勞工職業災害保險及保護法》草案，規定於年度應收保費最高20%範圍內編列經費支應辦理職災預防與重建業務，



強化職災預防與職業重建，提供職災勞工更周延的保護。

二、改進疑似職業病調查與審（鑑）定制度

現行疑似職業病調查與（審）鑑定制度主要問題為：(1) 診斷醫師無現場訪視權，不易蒐集完整工作暴露資料；(2) 勞工或雇主疑似罹患職業病，可向隸屬地方政府的勞工職業疾病認定委員會申請職業病認定，亦可向勞動部勞工保險局作申請，形成疑似職業病審定雙軌制，若兩個管道作出不一致的審查結果，容易衍生爭議，增加行政上的困難；(3) 缺乏專業職業病調查組織與人力。

為解決現行疑似職業病調查與審（鑑）定制度產生之問題，提高我國職業病發現率，已於《勞工職業災害保險及保護法》草案規劃由中央主管機關透過認可職業傷病診治醫療機構方式辦理，認可醫療機構除開設職業傷病門診，設置專責服務窗口，強化院內職業傷病通報轉介機制外，協助建構區域網絡之職業傷病通報、診治及職能復健服務、提供個案管理服務，並得辦理疑似職業病及群聚事件之調查研究（含實地訪視、監測）等職業病防治工作。

對於職業病鑑定案件，未來亦規劃委由預防及重建法人，協助辦理鑑定調查並提供專業評估意見。另考量立法後強制納保對象已涵蓋多數勞工（即便雇主未完成加保手續，仍給予保險給付；針對受僱自然人雇主，屬自願加保對象之勞工，亦提供簡便加保措施），將刪除現行縣市政府辦理職業病認定機制，調整鑑定會之組成規模，簡化作業程序，僅受理保險人於審核職業病給付案件時認有必要者，以縮短辦理期程，協助職災勞工盡快獲得職災保險給付。

三、提高職業病發現率

我國 108 年職業病發現率為每 10 萬名勞工中有 7.1 人，較諸日、韓、德、英等工業化國家為低。提高職業病發現率，挖掘潛在暴露職業危害族群，積極落實勞工保護，係進步國家的表徵，有必要建置更完善之職業傷病通報系統、調查、診斷及認定機制及相關資料庫，方能有成。在《勞工職業災害保險及保護法》草案已定明中央主管機關應捐助成立預防及重建財團法人，承接中央主管機關所規劃之職業災害預防及重建政策，統籌辦理相關業務外，亦明定建置通報系統、疑似職業病與群聚案件調查、認定機制、潛伏期長之職業病離退勞工長期健檢追蹤、各項資料庫勾稽分析等，均為提高職業病發現率之重要工作。

- (一) 建立職業傷病通報系統，明定職業傷病通報制度，將依服務量能逐步推動多元通報體系，可包括醫療機構、勞動檢查機構、職災勞工本人及其家屬、雇主、勞工保險投保之保險單位（如：職業工會）或相關人員均得主動通報。
- (二) 對於如粉塵作業、致癌物質作業或經指定有害作業工作一定期間之離職或退休勞工，得申請健檢補助。
- (三) 辦理職業病群聚調查與特定職業病之勾稽清查（如石綿症、矽肺症、職業癌症）及通報篩檢。
- (四) 建立長期暴露資料庫，作為分析與指引修訂、制定職病預防政策的參據，並可與勞工健康檢查資料庫、化學品資料庫等互相串聯勾稽，以便覆蓋與蒐集更完整的勞工健康資料。

四、健全職災勞工照護體系

每位職災勞工從受傷醫療以至重返職場，經歷傷病診治、醫療復健、職能復健等轉銜過程，本人、家屬及生活上之衝擊與痛苦，不僅需要職災保險金錢給付補償，更需要健全完整的照護服務，以彰顯社會保險的真正核心價值。

我國近 10 年來以計畫標案方式委託各地區醫學中心成立 10 家職業傷病防治中心並建置 80 餘家網絡醫療院所，提供勞工職業傷病診斷、職能復健評估等服務；補助 22 家醫療院所辦理職能復健、工作能力評估及工作強化訓練；輔以各縣市職災重建個案管理員，按勞工需要就近結合相關各類轉介協助資源，已漸具職災勞工重建服務體系雛型。

協助職災勞工重返工作過程中，需考量個人需求、工作環境、企業需求以及法律責任等面向，避免因工作能力降低而提早結束職業生涯。因所涉層面廣泛，如何有效整合各類需求即為一大問題，如在醫療面，爭取院方高層支持，推動院內專科的整合等，更高層次如整合醫療、職能復健、職業重建等專業面向均有相當困難與阻力。

為解決前述問題，我國借鑒日本與南韓的勞災醫院經驗，建立以醫學中心為基礎之職災醫院體系，勞工罹災開始，即指派個案管理員提供協助服務，醫療體系、職能復健體系、社會復建體系配合個案高度整合。參酌國際社會安全組織 (International Society Security Association, ISSA) 提供各國社會保險機構推動重返工作 (Return To Work, RTW) 之指引，幫



助因職業與非職業疾病或傷害導致工作能力降低的當事人重新融入職場、重返工作 (RTW)，相關規劃均可見於《勞工職業災害保險及保護法》草案，將持續推動整合職災勞工相關需求，以提供勞工個案適切服務，幫助順利重返工作，重拾人生正軌。

結論

我國目前因產業結構、勞動環境之變遷，職業安全衛生法新增職業傷害通報義務，人因工程、工作壓力等健康危害導致職業性肌肉骨骼疾病、工作促發腦心血管疾病、工作壓力導致相關精神疾病等新興職業疾病的出現；另因民國 60 年代工業起飛時期使用石綿、粉塵或致癌化學物，已有職業醫學專家提出警示相關職業疾病可能將進入發病高峰期，雖然當前由管理服務中心、各職業傷病防治中心及網絡醫院所組成之職業傷病醫療體系，仍持續提供勞工職業疾病診治、通報、健康服務、職能復健等服務，致力提升職災勞工發現率及復工率。惟為落實完整的職災勞工保護政策，預防、補償、重建三個維度的服務缺一不可，目前配合本部積極推動《勞工職業災害保險及保護法》立法工作，相關職災勞工保護服務網絡如圖 51，將整合相關服務資源與走出現行機制的困境，永續發展我國職災勞工保護工作。



圖 51 職災勞工保護服務網絡

伍、附錄－防治中心群聚調查成果

室內裝潢業木工罹患旋轉肌袖症之群聚調查－中山防治中心

群聚調查職業疾病類型：

旋轉肌袖症

個案工作性質與背景介紹：

表 15 為 4 位個案的基本資料，皆為室內裝潢木工，工作年資超過 30 年，每日工作時間為 8-10 小時。大部分的工作時間，雙手皆有施力性及抬舉過肩的人因工程危害暴露情形，顯著增加勞工罹患旋轉肌袖症候群風險。從案例資料分析中可以發現，勞工的病灶皆在慣用手（右手）。（表 16）

表 15 中山群聚調查個案基本資料

| 個案 | 性別 | 年齡 | 年資 | 廠訪 | 慣用手 | 外傷病史 |
|----|----|----|------|----|-----|------|
| A | 男 | 60 | 40 年 | 有 | 右手 | 無 |
| B | 男 | 56 | 33 年 | 有 | 右手 | 無 |
| C | 男 | 56 | 40 年 | 有 | 右手 | 無 |
| D | 男 | 53 | 30 年 | 有 | 右手 | 無 |

表 16 中山群聚調查個案疾病檢查結果

| 個案 | 自覺症狀 | 理學檢查 | 影像學檢查 | 手術 |
|----|---------------|-----------------------------|-------|----|
| A | 雙側肩膀疼痛、關節活動受限 | 右肩活動受限、右手 Empty can test(+) | 有 | 無 |
| B | 右側肩膀疼痛、關節活動受限 | 右肩活動受限、右手 Empty can test(+) | 有 | 無 |
| C | 右側肩膀疼痛、關節活動受限 | 右肩活動受限、右手 Empty can test(+) | 有 | 無 |
| D | 雙側肩膀疼痛、關節活動受限 | 右肩活動受限、右手 Empty can test(+) | 有 | 無 |



訪視目的：

營造從業人員為旋轉肌袖症候群的高危險群，故針對確診為旋轉肌袖症候群的室內裝潢木工，透過病歷記錄及工作史調查且到某室內裝潢木工工作現場作業流程進行訪視，確認勞工的暴露風險與防護具使用情形，於其工作現場進行暴露量評估，了解現場勞工的危害暴露情形並加強宣導相關改善建議，以期減少職業傷病發生。

調查結果：

個案 A

個案 A 每天工作 8 小時，每月工作 22 天，工作內容為天花板裝訂 (40%) 及室內施工 (60%)，室內施工的工作內容包含隔間裝訂、櫥櫃施工。依其工作比例，天花板施工每月約 9 天、室內施工每月約 13 天。天花板裝訂流程為：架角料、釘槍固定、架矽酸鈣板、釘槍固定。每天至少可完成 4-5 坪空間的裝修，每坪需要 2 片矽酸鈣板，若加上造型施工，所需天數會更多。

隔間裝訂工作需以右手緊握釘槍，不斷重複移動，使角料與角料、角料與木板牆及木板等固定。櫥櫃施工則需要先將角料裁切、黏合後再持釘槍重複裝訂動作，期間若有角料釘歪，需以右手持鐵鎚重複敲打調整動作，以小刷子清潔木板面，最後沾木頭保養液重複來回刷上。裝訂好的櫥櫃還需鎖上活動門片，工作流程為：以電鑽機鑽孔、鎖門片、鎖螺絲。(圖 52)

近幾年多為 1 人工作，慣用手為右手。依工作現場訪視的工作量分析，室內施工時至少有 1/2-1/3 的時間，雙手有施力性及平舉至抬舉過肩動作，每天工作 8 小時，工作中有大部分時間重複動作，工作中雙手暴露施力及抬舉過肩的人因工程危害因子中。



天花板裝訂



一手固定、一手持電鑽鎖門片



持電鑽鎖櫥櫃

圖 52 中山群聚調查工作現場訪視 (個案 A)



個案 B

每天工作 8 小時，每月工作 22 天，工作內容為拆除工程佔工作內容比例約 30%、木作加工約佔 70%。木作加工包含：天花板施工 (35%)、隔間施工 (35%)、櫥櫃施工 (10%)、木地板施工 (20%)。拆除工程需使用鐵鍬、鐵鎚、電鋸等工具。木工加工需將木材裁切、組裝、成型及固定，慣用手為右手。(圖 53)

個案自述依施工高度的不同，會使用工作梯或以雙手高舉方式進行施工，約有 5-6 成時間需進行雙手高舉過肩姿勢作業、抬舉過肩動作與重複性動作，例如：進行櫥櫃施工中的補土作業時，個案需左手握土盤，右手持刮板進行補土，右手多數時間有抬舉過肩動作與重複性動作。進行工作現場訪視當天的天花板施工為木板非矽酸鈣板，架角材後釘上木板後，需再持研磨機進行研磨，多數時間皆有雙手抬舉過肩動作、施力性與重複性動作等人因工程危害。



天花板施工



櫥櫃施工

圖 53 中山群聚調查工作現場訪視 (個案 B)



個案 C

工作內容為天花板裝訂 (40%) 及室內施工 (60%)，室內施工包含隔間裝訂、櫥櫃施工，以民宅裝潢為主，每次工作約有 3 位師傅合作施工，以坪數為 15-16 坪的室內空間裝修工作為例，約需工作 20 天，個案慣用手為右手。天花板裝訂的流程為：架角料、釘槍固定、架矽酸鈣板、釘槍固定。室內施工依高度不同而選擇使用工作梯或以雙手抬舉方式進行施工，腰部以下則採蹲姿作業。依現場訪視的動作分析，室內施工時至少有 1/2-1/3 時間雙手有施力性及平舉至抬舉過肩動作，個案每天工作 8-10 小時，工作中雙手有施力性及抬舉過肩的人因工程危害。(圖 54)



裝訂角材：釘槍重約 2 公斤



裝訂天花板

圖 54 中山群聚調查工作現場訪視 (個案 C)



個案 D

工作內容包含天花板裝訂 (70%)、牆壁施工及櫥櫃施工 (30%) 等作業，每組施工作業約 2-4 人合作，施工地點以民宅為主。以室內施工坪數 15 坪為例，約需工作 18-20 天，個案慣用手為右手。依據個案工作內容所佔比例以及現場訪視動作分析，天花板施工每個月約需 14-15 天、牆壁施工及櫥櫃施工每月約 6-7 天，天花板施工時，使用重約 2 公斤的釘槍施工，每次裝訂動作皆需以左手固定矽酸鈣板或角料、右手重複抓握釘槍，天花板施工時其雙手持續有施力性及抬舉過肩動作。(圖 55)

室內施工包含牆壁施工、櫥櫃施工，動作以左手固定、右手緊握釘槍，不斷重複移動，使角料與角料間、角料與木板牆及木板之間能固定，裝訂則依高度不同斟酌使用工作梯或以雙手高舉方式，腰部以下高度的施工則採蹲姿作業。依現場訪視動作分析，室內施工時至少有 1/2-1/3 時間雙手有施力性及平舉、抬舉過肩動作，個案每天工作 8 小時，工作中雙手有施力性及抬舉過肩的人因工程危害。



天花板裝訂



裝訂矽酸鈣板



隔間施工

圖 55 中山群聚調查工作現場訪視 (個案 D)

本調查的主要調查對象為室內裝潢木工，透過病例回顧及工作量分析可以發現，4位勞工皆為男性(100%)，年齡在50-59歲有3人(75%)，60-69歲有1人(25%)，服務年資介於30年至40年。(表17)

4位勞工均有自覺症狀，包含：患部疼痛與關節活動受限(100%)，理學檢查均發現有患部肩膀活動受限及Empty can test陽性(100%)，4位勞工的病灶皆為右側肩膀(100%)。影像學檢查與手術方面，其中3位經超音波檢查確診(75%)，1位經磁共振造影檢查確診(25%)。(表16)

由個案工作現場訪視以及表17的工作暴露分析可知，3位勞工進行天花板裝訂工作比例佔40%，室內施工及拆解工作佔60%；1位勞工進行天花板裝訂的工作比例佔60%，室內施工佔40%。每日工作時間3位為8小時(75%)，1位為8-10小時(25%)。4位勞工每天至少有1/2-1/3時間雙手有施力性及平舉至抬舉過肩動作(100%)。

表17 中山群聚調查個案工作暴露分析

| 個案 | 作業類型 | 年資 | 每日工時 | 抬舉過肩時數/日 | 高施力 | 職業病認定 | 勞保局審核 |
|----|--------|-----|------|----------|-----|-------|-------|
| A | 室內裝潢木工 | 40年 | 8 | 4 | 有 | 通過 | 通過 |
| B | 室內裝潢木工 | 33年 | 8 | 4 | 有 | 通過 | 通過 |
| C | 室內裝潢木工 | 40年 | 8-10 | 4-5 | 有 | 通過 | 通過 |
| D | 室內裝潢木工 | 30年 | 8 | 4 | 有 | 通過 | 通過 |

建議：

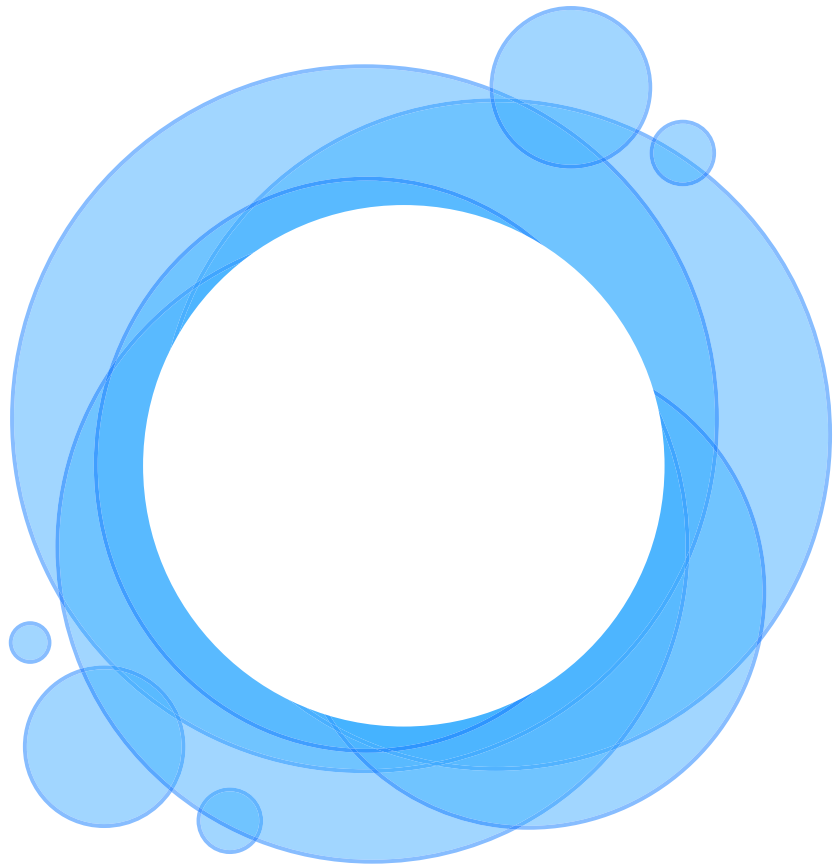
本調查中被診斷為旋轉肌袖症候群的勞工共4位，主要病灶為右肩(慣用手)，自覺症狀為患部疼痛與關節活動受限，理學檢查均有患部活動受限、Empty can test陽性等發現。本調查針對事業單位，提出3項防治建議：

- 1、給予室內裝潢木工勞工肩膀疼痛時相關衛教及指導肌肉骨骼放鬆技巧，以期早期發現早期治療。對於已經出現症狀的勞工，宜加強宣導正確就醫及復健觀念，並應避免長時間施力性抬舉過肩的動作。如遇到需長時間抬舉過肩之工作(如天花板裝訂)，建議進行職務調整，以免症狀加重或復發。
- 2、室內裝潢木工的主要危害以不良的工作姿勢(如抬舉過肩)為主，同時可能合併有高施力動作。建議事業單位可降低不良工作姿勢(抬舉過肩)時間比例，適度安排天花板裝訂等需抬舉過肩的作業與其他毋須抬舉過肩的作業輪替進行，例如每半天輪替一次工作站，俾使局部肌肉可以得到充分休息；或是同時安排多人進行天花板裝訂作業以減少個人不良工



作姿勢的作業時間。進行其他室內裝潢工作時，勞工可選擇高度合適的梯子，減少抬舉肩膀工作時間，以自然且省力的姿勢工作。

- 3、建議事業單位主動進行人因性危害預防，調查肌肉骨骼傷病現況，並利用肌肉骨骼症狀調查表 (Nordic musculoskeletal questionnaire, NMQ) 對全體員工實施自覺症狀調查，進而針對有肌肉骨骼危害暴露的勞工進行作業分析及危害評估。之後亦可依據評估結果做危害風險排序及優先改善順序評估，考慮人因工程改善、健康促進、管理改善與個人防護具等改善方案，降低事業單位員工發生職業傷病的風險。



美髮業勞工肌肉骨骼危害之群聚調查－彰基防治中心

群聚調查職業疾病類型：

腕隧道症候群

個案工作性質與背景介紹：

調查對象為職業醫學科門診個案中美髮勞工共 12 人，接受調查者以女性為主，平均年齡約 49 歲，平均工作年資約 34 年。(表 18)

表 18 彰基群聚調查個案基本資料及罹病情形

| 個案 | 工作年資 | 年齡 | 性別 | 疾病診斷 | 罹病史 |
|----|------|----|----|---------|------|
| A | 21 年 | 58 | 男 | 旋轉肌袖症候群 | 6 年 |
| B | 34 年 | 49 | 女 | 腕隧道症候群 | 3 年 |
| C | 36 年 | 52 | 女 | 腕隧道症候群 | 14 年 |
| D | 22 年 | 36 | 女 | 腕隧道症候群 | 7 年 |
| E | 23 年 | 39 | 女 | 腕隧道症候群 | 6 年 |
| F | 34 年 | 46 | 女 | 腕隧道症候群 | 16 年 |
| G | 41 年 | 63 | 女 | 腕隧道症候群 | 10 年 |
| I | 34 年 | 52 | 女 | 扳機指 | 1 年 |
| J | 38 年 | 63 | 女 | 旋轉肌袖症候群 | 1 年 |
| K | 36 年 | 54 | 女 | 扳機指 | 1 年 |
| L | 35 年 | 54 | 女 | 旋轉肌袖症候群 | 5 年 |
| M | 45 年 | 40 | 女 | 旋轉肌袖症候群 | 1 年 |

經作業現場訪視確認後，個案自民國 74 年從事美髮師的工作，前後約 34 年。平均每週工作 5.5 天，一天工作 8 小時。主要工作內容包含洗髮（抓、沖、吹整），剪髮（剪刀、電剪、吹整），染髮（沖、吹整、上染劑、蒸氣），冷燙（沖、修剪、上捲子、上藥水、加溫、拆捲子、吹整），熱燙（沖、吹整、修剪、上捲子、上藥水、加溫、拆捲子），護髮（沖、吹整），清潔（擦桌椅、洗毛巾、清洗用具、掃地、拖地）等。評估其工作情形，她每日約有四成五的工作時間需反覆手腕動作。(圖 56)



洗髮



剪髮



染髮



燙髮



護髮



清潔整理

圖 56 彰基群聚調查工作現場訪視

經現場工作模擬後可發現，美髮勞工常見職務內容主要為洗髮、剪髮、染髮、燙髮、護髮，
工作流程請見圖 57：

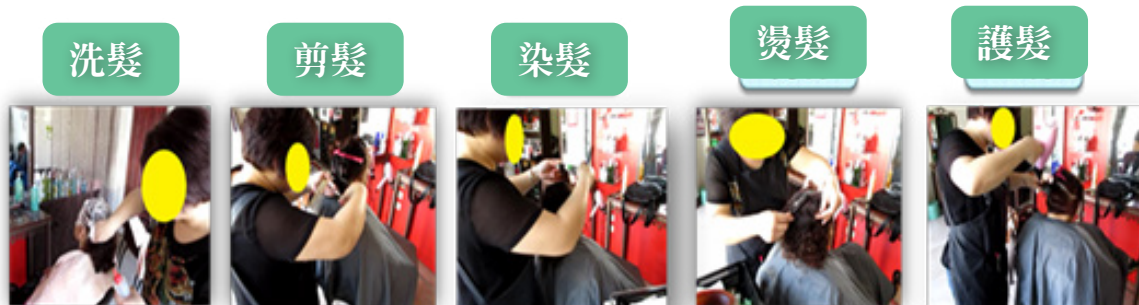


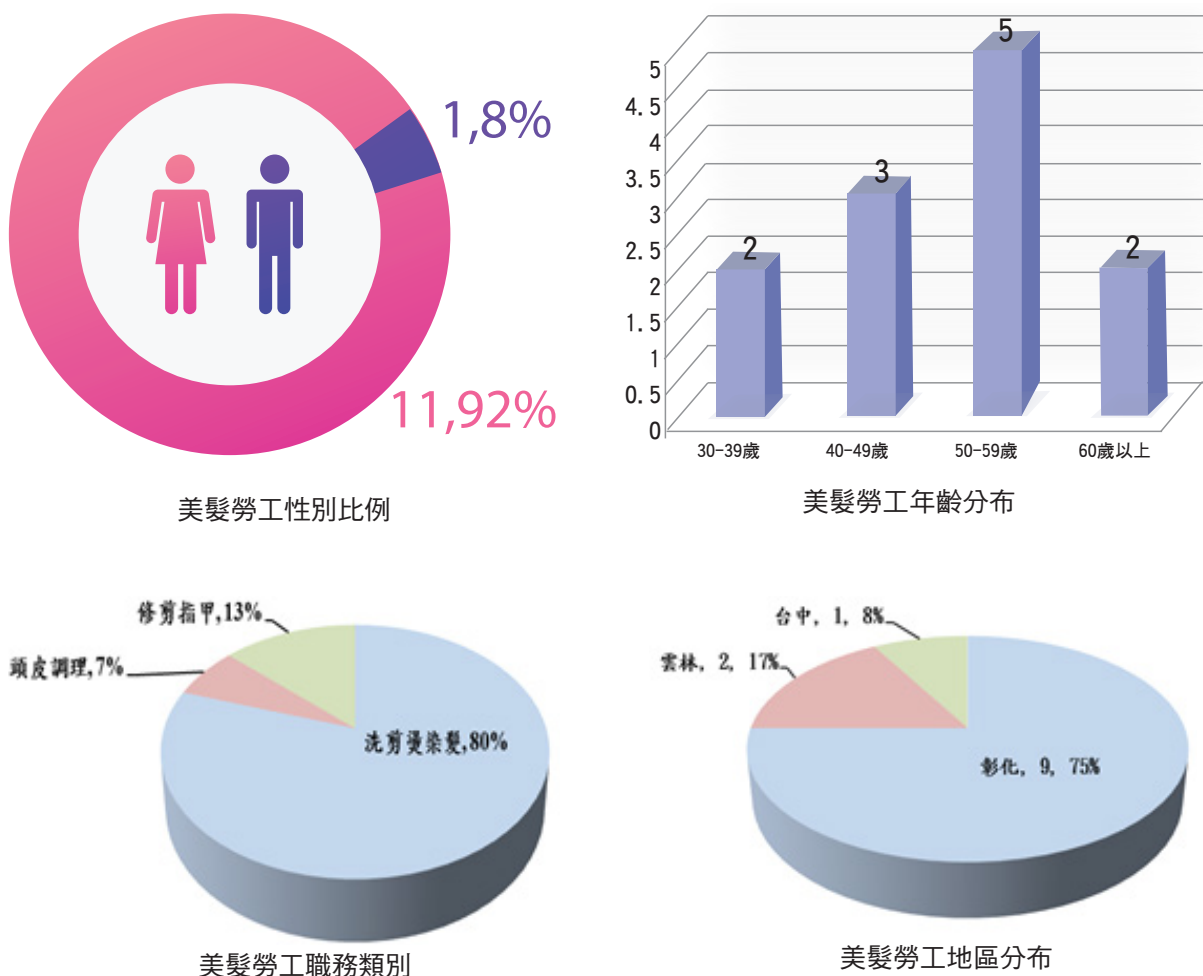
圖 57 美髮勞工工作流程

訪視目的：

美髮勞工的工作內容包含洗髮、剪髮、染髮、燙髮、護髮、頭皮調理、修剪指甲等，每日約有一半的工作時間手部需用力抓握、手腕重複前彎及側彎、重複手指動作等作業情形。彰基的職業醫學團隊自職業醫學科門診個案中，發覺 12 位因平均工作年資為 33 年的美髮勞工因發生手部症狀前來就醫，故調查美髮業勞工腕隧道症候群發生的情形，評估職業暴露的危險性，並提供改善建議。

調查結果：

本群聚調查對象為職業醫學科門診個案中美髮勞工共 12 人，接受調查者以女性為主，平均年齡約 49 歲，平均工作年資約 34 年，個案基本資料請見圖 58：



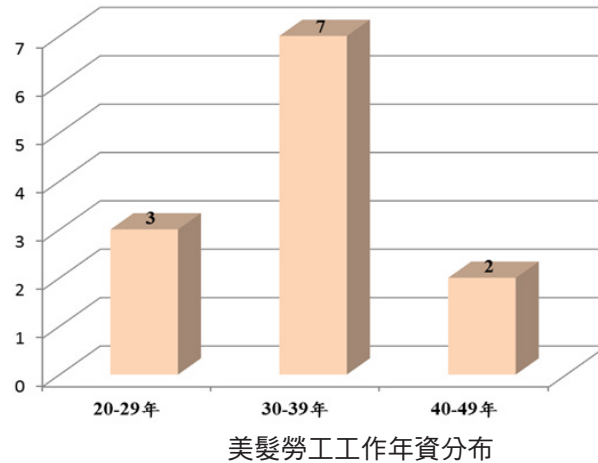


圖 58 彰基群聚調查美髮勞工個案基本資料

調查結果發現，其中 8 人有手部症狀，其中 6 位已經職業醫學科門診確診為職業性腕隧道症候群。(圖 59)

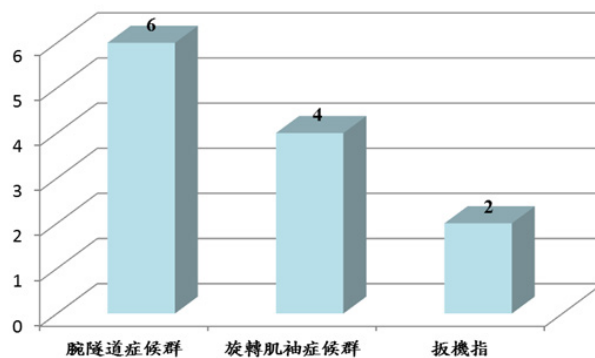


圖 59 彰基群聚調查美髮從業人員常見罹患疾病

建議：

腕隧道症候群常見的職業性促發原因包含手腕部反覆性動作作業（尤其是高頻率的反覆性手腕部動作）、用力握緊或抓緊工具或物品作業、經常或長時間壓迫腕部或手掌底部者。建議輔導美髮從業人員進行工作模式改善，高重複性手部工作改以工具及其他服務方式代替人力，以減少人因工程方面的危害。針對美髮勞工工會，除專業課程外，建議安排衛教保健等相關課程，加強勞工自我保護的觀念。另針對事業單位，提出 4 項防治建議：

- 1、若無法以機器取代人工，可考慮減少勞工的連續工作時間。
- 2、工作時坐於可調整高度之工作椅或適當高度工作檯面，減少彎腰或高抬手等不當姿勢。於久站處（洗髮、剪髮區等）鋪設適當硬度的地墊（如木製或橡膠墊子），減緩下肢負擔。

3、預防方式首重於改善引起或加重腕隧道症候群的原因，減少手腕的速度和力量，注意定時讓休息，加強勞工衛生教育，配戴護腕避免腕部的活動也有效果。

4、教導勞工學習正中神經滑動運動或是肌腱滑動運動以改善腕隧道症候群症狀。正中神經滑動運動：手臂平放在桌面上，以握拳姿勢開始，掌心向下（大拇指靠近身體方向）→手指伸直（圖 A）→手腕背屈（圖 B）→大拇指張開（圖 C）→手心翻轉過來朝上（圖 D）→再用另一隻手扳開大拇指（圖 E），每個動作維持 10 秒，重複 6-10 次，每日做 3 回。（圖 60）



圖 60 正中神經滑動運動教學示意圖



肌腱滑動運動：A 伸直手，B 勾（爪）狀拳，C 握拳，D 手指七型，E 直拳。每個動作維持 10 秒，重複 6-10 次，每日做 3 回。（圖 61）

圖 61 肌腱滑動運動教學示意圖

完成本調查後，彰基防治中心持續向工會宣導職業傷病就醫相關資訊，拜訪彰化縣、雲林縣女子燙髮職業工會以及理燙髮美容業職業工會後給予相關宣導品，請工會代為發送給工會會員，並舉辦職業病相關講座，宣導職業傷病資訊。（圖 62）



彰基製作腕隧道症候群宣導摺頁並請工會發送



彰基進行工會訪視與職業病防治宣導

圖 62 彰基與美髮工會合作進行職業傷病防治宣導



蜆養殖業勞工肌肉骨骼危害風險評估－雲分防治中心

群聚調查職業疾病類型：

職業性肌肉骨骼疾病

個案工作性質與背景介紹：

蜆養殖作業屬於複合型作業，每位人員的作業內容不固定，仰賴彼此互相支援，且蜆養殖作業的工作地點並非固定於單一場所每日作業，依循當日訂單多寡及互助成員接單狀況而定。

訪視目的：

蜆養殖作業的員工經常暴露於搬抬重物、不良姿勢、重複動作等人因性危害因子，故進行工作場所健康風險評估。

調查結果：



蜆收成作業

收成作業時工作人員魚塭中以站姿及行走交替進行作業，負責收成的勞工左手握持漁網輔以自動收成機，約 10 秒鐘後彎腰將漁網內沉於池底的蜆拉至漁網中，此動作重複三次後，再用雙手將靠近漁網口的蜆抬起後置放於不鏽鋼的圓盆內並裝滿，上述動作重複循環三次。魚網內蜆的重量約為 15 公斤，蜆收成作業的工作週期為 58 秒。以裝滿一個圓盆為單位計算，每天約需處理 3,000 公斤的蜆，約為 40 個大圓盆。每天工作 4 小時。(圖 63)



自動收成機器作業中



收網



拉起漁網

將蜆置於不鏽鋼圓盆內

圖 63 雲分群聚調查蜆收成作業流程圖

蜆養殖勞工收成蜆需使力拉起沉在水中漁網內的蜆，此動作暴露於可能罹患上肢肌肉骨骼疾病的風險；此外蜆養殖勞工抬舉約 15 公斤的蜆置放於不鏽鋼圓盆時，亦可能導致下背部的肌肉骨骼疾病風險。因此上肢以 KIM-MHO 評估其作業的風險，下背的部分則以 EAWS 評估。

上肢針對左右手之施力進行風險評估，蜆收成需以左手握持魚網（力量低），另以右手拉起魚網時，因為水的阻力及蜆本身重量，使用的力量達到峰值（超過五公斤），分析計算後，左手施力評級分數為 4 分，右手為 4 分（如表 19）。收成的主要施力以右手為主，後續上肢的風險評估以右手估算。

表 19 雲分群聚調查評估蜆收成手部施力測量結果

| 手 - 手指部位的施力方式 | | 握持 | | | | 移動 | | | | | |
|---|---|--------------|-------|------|-----|--------------|-----|------|-------|-------|-----|
| | | 平均握持時間 [秒/分] | | | | 平均移動頻率 [次/分] | | | | | |
| | | 60-31 | 30-16 | 15-4 | <4 | <1 | 1-4 | 5-15 | 16-30 | 31-60 | >60 |
| | | 評級點數 | | | | | | | | | |
| 等級 | 說明, 典型的例子 | 2 | 1 | 0.5 | 0 | 0 | 0.5 | 1 | 2 | 3 | |
| 低 | 力量極低 例如：按鈕啟動 / 換檔 / 整理 | 3 | 1.5 | 1 | 0 | 0 | 1 | 1.5 | 3 | 5 | |
| | 力量低 例如：物料引導 / 插入 | 5 | 2 | 1 | 0 | 0.5 | 1 | 2 | 5 | 8 | |
| | 力量中等 例如：抓握 / 用手或小工具組裝小工件 | 8 | 4 | 2 | 0.5 | 1 | 2 | 4 | 8 | 13 | |
| | 力量高 例如：旋轉 / 纏繞 / 包裝 / 抓取 / 握持或組裝零件 / 壓入 / 切割 / 使用小動力手工工具作業 | 12 | 6 | 3 | 1 | 1 | 3 | 6 | 12 | 21 | |
| | 力量極高 例如：涉及以施力進行的切割 / 以小釘槍工作 / 移動或固定零件或工具 | 19 | 9 | 4 | 1 | 2 | 4 | 9 | 19 | 33 | |
| 高 | 力量達到峰值 例如：鎖緊或鬆動螺絲 / 分離 / 壓入 | - | - | - | 1 | 1 | 3 | 6 | 12 | 21 | |
| 揮打：以拇指球、手掌或拳頭 | | | | | | | | | | | |
| 必須觀察工作週期並分別標註相關施力等級的評級點數，再將所標註的評級點數（左右手分別）加總算出施力的評級點數，後續以其中較高者來計算總評級點數。 | | | | | | | 左手： | | 右手： | | |
| 施力的評級點數： | | | | | | | 4 | | 4 | | |

漁網濕滑，不易抓握，抓握條件的評級點數為 3，手與手臂位置的評級點數為 1，工作協調的評級點數為 1。工作姿勢以站姿為主，軀幹會嚴重扭曲並前傾、經常彎腰，分數為 5。工作時間每天 4 小時，評級點數為 2.5。經計算後，風險值為 37.5，風險等級為 3，屬中高負載，建議需要進行人因改善。(表 20)

表 20 KIM-NHO 風險評估工具評估蠅收成手部作業結果

| 算式 項目 | 各項評估 | 評級點數 | 說明 |
|----------|-------------|------|-------------------|
| | 施力的評級點數 | 4 | 如表 |
| + | 抓握條件 | 3 | 介於受限及明顯受阻 |
| + | 手臂位置 | 1 | 關節位置或活動不定期地達到活動極限 |
| + | 工作協調 | 1 | 少數的工作操作 |
| + | 工作條件 | 1 | 潮濕、噪音 |
| + | 姿勢 | 5 | 軀幹嚴重扭曲和前傾 / 經常彎腰 |
| = | 總計 | 15 | |
| × | 總時間評級點數 | 2.5 | 總工時為 4 小時 |
| = | 風險分數 | | 37.5 |

| 風險等級 ***) | 風險分數 | 說明 |
|-----------|-----------|---|
| 1 | <10 | 低負荷，不易產生身體過載的健康危害。 |
| 2 | 10 to <25 | 中等負載，身體過載的情形可能發生於恢復能力較弱者。針對此族群進行工作再設計是有幫助的。 |
| 3 | 25 to <50 | 中高負載，身體過載的情形可能發生於一般作業人員。應檢討工作場所的重新設計。 |
| 4 | ≥50 | 高負載，生理過載的情形極可能發生。必須進行工作改善。 |



蜆養殖勞工在蜆收成作業時約有 67% 的時間行走移動，背部彎曲角度均未超過 20 度，風險值為 11。其餘時間為全身施力及抬舉作業。在全身施力部分，蜆養殖勞工在將池底的蜆拉往網口時，右手需要以 A+ 姿勢拉高魚網，每次將蜆收於圓型鋼盆時，共重複三次，整天作業須完成 120 次動作，經計算後每天每分鐘動作約為 0.5 次；而在施力部分，每次約需出力 150 N，而 A+ 身體彎曲時 P40 的建議值為 285 N，因此力量約為 53% 的力值；經計算後全身施力的風險值約為 8.4。蜆養殖勞工需要以抬舉的方式將蜆置放於圓形不鏽鋼盆中，重量為 15 公斤，評級點數為 2，彎腰姿勢的評級點數為 4。在頻率部分，每天須完成 40 次，評級點數為 2.3，風險值為 13.8。經過計算後總風險值為 33.2，EAWS 等級在黃燈區，可能導致下背肌肉骨骼傷病的風險，建議進行工作再設計。(圖 64)

| Basic Positions / Postures and movements of trunk and arms (per shift) | | | | | | | | | | | Postures | | | | | | | | | | |
|--|-----------|--|--|--------------|-------------------------|-----------|-----|-------|-------|--------|---------------|-------------------|--------------------|----------------------|----------------------|----------------------|-----|-----|-----|--|--|
| (incl. loads of <3 kg, forces onto fingers of <30 N and whole body forces of <40 N) | | | Evaluation of static postures and/or high frequent movements of trunk/arms/legs | | | | | | | | Sum of lines | Asymmetry effects | | | | | | | | | |
| | | | Duration [sec/min] = $\frac{\text{duration of posture(s)} \times 60}{\text{cycle time}}$ | | | | | | | | | Trunk Rotation 1) | Lateral Bending 1) | Far Reach 2) | | | | | | | |
| Static postures: ≥ 4 sec | | | | | | | | | | | | | | | | | | | | | |
| High frequency movements: Trunk bendings ($> 60^\circ$) ≥ 2 /min Kneeling/crouching ≥ 2 /min Arm liftings ($> 60^\circ$) ≥ 10 /min | | | [%] | 5 | 7.5 | 10 | 15 | 20 | 27 | 33 | 50 | 67 | 83 | int | dur | int | dur | int | dur | | |
| | [sec/min] | 3 | 4.5 | 6 | 9 | 12 | 16 | 20 | 30 | 40 | 50 | | | 0-5 | 0-3 | 0-5 | 0-3 | 0-5 | 0-2 | | |
| | [min/8h] | 24 | 36 | 48 | 72 | 96 | 130 | 160 | 240 | 320 | 400 | | | Intensity x Duration | Intensity x Duration | Intensity x Duration | | | | | |
| Standing (and walking) | | | | | | | | | | | | | | | | | | | | | |
| 1 | | Standing & walking in alteration, standing with support | 0 | 0 | 0 | 0 | 0.5 | 1 | 1 | 1 | 1.5 | 2 | | | | | | | | | |
| 2 | | Standing, no body support (for other restrict. see Extra Points) | 0.7 | 1 | 1.5 | 2 | 3 | 4 | 6 | 8 | 11 | 13 | 11 | | | | | | | | |
| 3 | | Bent forward (20-60°) with suitable support | 2 | 3 | 5 | 7 | 9.5 | 12 | 18 | 23 | 32 | 40 | | | | | | | | | |
| 4 | | Strongly bent forward (>60°) with suitable support | 3.3 | 5 | 8.5 | 12 | 17 | 21 | 30 | 38 | 51 | 63 | | | | | | | | | |
| 5 | | Upright with elbow at / above shoulder level | 3.3 | 5 | 8.5 | 12 | 17 | 21 | 30 | 38 | 51 | 63 | | | | | | | | | |
| 6 | | Upright with hands above head level | 5.3 | 8 | 14 | 19 | 26 | 33 | 47 | 60 | 80 | 100 | | | | | | | | | |
| 1) | | 0 | 1 | 3 | 5 | 2) | | 0 | 1 | 3 | 5 | Σ | | Σ | Σ | Σ | | | | | |
| Trunk | | slightly $\leq 10^\circ$ | medium 15° | strongly 25° | extreme $\geq 30^\circ$ | Far Reach | | close | 60% | 80% | arm stretched | 11 | | Σ (max.=15) | Σ (max.=15) | Σ (max.=10) | | | | | |
| dur | | never | 4 sec | 10 sec | 13 sec | dur | | never | 4 sec | 10 sec | 13 sec | (a) | | Σ (max. = 40) | | | | | | | |
| | | 0% | 6% | 15% | 20% | | | 0% | 6% | 15% | 20% | (b) | | | | | | | | | |
| Attention: Max. duration of evaluation = duration of task or 100%! | | | | | | | | | | | | | | | | | | | | | |
| Attention: correct evaluation, if duration of evaluation ≠ 60s | | | | | | | | | | | | | | | | | | | | | |
| Postures = Σ lines 1 - 16 | | | 11 | (a) | + | (b) | = | 11 | | | | | | | | | | | | | |

| Action forces (per minute / shift) | | | | | | | | | | Forces | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| 17 | | Forces onto fingers (e.g. clips, plugs) | 0 | 7 | 15 | 25 | 50 | Intensity x time | Σ | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| <p>Forces F_{max} onto arms / whole body forces (neutral to gender)</p> <p>P15 for planning & P40 for analysis</p> <table border="1"> <thead> <tr> <th>ST Upright</th> <th>P15</th> <th>P40</th> <th>ST Bent</th> <th>P15</th> <th>P40</th> <th>ST Above head</th> <th>P15</th> <th>P40</th> <th>Finger forces F_{max} (neutral to gender)</th> </tr> </thead> <tbody> <tr> <td></td> <td>A 245</td> <td>315</td> <td></td> <td>A 210</td> <td>285</td> <td></td> <td>A 230</td> <td>280</td> <td>Posture A1 (power grip, pliers: see 70%)</td> </tr> <tr> <td></td> <td>B 280</td> <td>325</td> <td></td> <td>B 200</td> <td>240</td> <td></td> <td>A 285</td> <td>320</td> <td>F_{max}</td> </tr> <tr> <td></td> <td>C 170</td> <td>210</td> <td></td> <td>B 205</td> <td>260</td> <td></td> <td>B 180</td> <td>200</td> <td>Posture A2 (ball of the thumb)</td> </tr> <tr> <td></td> <td>A 245</td> <td>315</td> <td></td> <td>B 285</td> <td>300</td> <td></td> <td>C 255</td> <td>310</td> <td>F_{max}</td> </tr> <tr> <td></td> <td>B 130</td> <td>185</td> <td></td> <td>C 145</td> <td>200</td> <td></td> <td>A 105</td> <td>140</td> <td>Posture B1 (thumb or thumb to 4 fingers)</td> </tr> <tr> <td></td> <td>C 110</td> <td>165</td> <td></td> <td>C 90</td> <td>135</td> <td></td> <td>B 100</td> <td>140</td> <td>F_{max}</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>C 130</td> <td>180</td> <td>Posture B2 (index or wide pinch)</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>A 225</td> <td>275</td> <td>F_{max}</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>B 210</td> <td>270</td> <td>Posture C (hook, palmar, strong pinch)</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>C 130</td> <td>180</td> <td>F_{max}</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>A 205</td> <td>265</td> <td>Posture A1 (power grip, pliers: 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<td></td> <td></td> <td></td> <td>B 210</td> <td>270</td> <td>F_{max}</td> </tr> <tr> <td></td> <td></td></tr></tbody></table> | | | | | | | | | | | ST Upright | P15 | P40 | ST Bent | P15 | P40 | ST Above head | P15 | P40 | Finger forces F _{max} (neutral to gender) | | A 245 | 315 | | A 210 | 285 | | A 230 | 280 | Posture A1 (power grip, pliers: see 70%) | | B 280 | 325 | | B 200 | 240 | | A 285 | 320 | F _{max} | | C 170 | 210 | | B 205 | 260 | | B 180 | 200 | Posture A2 (ball of the thumb) | | A 245 | 315 | | B 285 | 300 | | C 255 | 310 | F _{max} | | B 130 | 185 | | C 145 | 200 | | A 105 | 140 | Posture B1 (thumb or thumb to 4 fingers) | | C 110 | 165 | | C 90 | 135 | | B 100 | 140 | F _{max} | | | | | | | | C 130 | 180 | Posture B2 (index or wide pinch) | | | | | | | | A 225 | 275 | F _{max} | | | | | | | | B 210 | 270 | Posture C (hook, palmar, strong pinch) | | | | | | | | C 130 | 180 | F _{max} | | | | | | | | A 205 | 265 | Posture A1 (power grip, pliers: see 70%) | | | | | | | | B 215 | 260 | F _{max} | | | | | | | | C 120 | 165 | Posture A2 (ball of the thumb) | | | | | | | | A 190 | 245 | F _{max} | | | | | | | | B 220 | 290 | Posture B1 (thumb or thumb to 4 fingers) | | | | | | | | C 105 | 135 | F _{max} | | | | | | | | A 225 | 275 | Posture B2 (index or wide pinch) | | | | | | | | B 210 | 270 | F _{max} | | | | | | | | C 130 | 180 | Posture C (hook, palmar, strong pinch) | | | | | | | | A 205 | 265 | F _{max} | | | | | | | | B 215 | 260 | F _{max} | | | | | | | | C 120 | 165 | F _{max} | | | | | | | | A 190 | 245 | F _{max} | | | | | | | | B 220 | 290 | F _{max} | | | | | | | | C 105 | 135 | F _{max} | | | | | | | | A 225 | 275 | F _{max} | | | | | | | | B 210 | 270 | F _{max} | | | | | | | | C 130 | 180 | F _{max} | | | | | | | | A 205 | 265 | F _{max} | | | | | | | | B 215 | 260 | F _{max} | | | | | | | | C 120 | 165 | F _{max} | | | | | | | | A 190 | 245 | F _{max} | | | | | | | | B 220 | 290 | F _{max} | | | | | | | | C 105 | 135 | F _{max} | | | | | | | | A 225 | 275 | F _{max} | | | | | | | | B 210 | 270 | F _{max} | | | | | | | | C 130 | 180 | F _{max} | | | | | | | | A 205 | 265 | F _{max} | | | | | | | | B 215 | 260 | F _{max} | | | | | | | | C 120 | 165 | F _{max} | | | | | | | | A 190 | 245 | F _{max} | | | | | | | | B 220 | 290 | F _{max} | | | | | | | | C 105 | 135 | F _{max} | | | | | | | | A 225 | 275 | F _{max} | | | | | | | | B 210 | 270 | F _{max} | | | | | | | | C 130 | 180 | F _{max} | | | | | | | | A 205 | 265 | F _{max} | | | | | | | | B 215 | 260 | F _{max} | | | | | | | | C 120 | 165 | F _{max} | | | | | | | | A 190 | 245 | F _{max} | | | | | | | | B 220 | 290 | F _{max} | | | | | | | | C 105 | 135 | F _{max} | | | | | | | | A 225 | 275 | F _{max} | | | | | | | | B 210 | 270 | F _{max} | | | | | | | | C 130 | 180 | F _{max} | | | | | | | | A 205 | 265 | F _{max} | | | | | | | | B 215 | 260 | F _{max} | | | | | | | | C 120 | 165 | F _{max} | | | | | | | | A 190 | 245 | F _{max} | | | | | | | | B 220 | 290 | F _{max} | | | | | | | | C 105 | 135 | F _{max} | | | | | | | | A 225 | 275 | F _{max} | | | | | | | | B 210 | 270 | F _{max} | | | | | | | | C 130 | 180 | F _{max} | | | | | | | | A 205 | 265 | F _{max} | | | | | | | | B 215 | 260 | F _{max} | | | | | | | | C 120 | 165 | F _{max} | | | | | | | | A 190 | 245 | F _{max} | | | | | | | | B 220 | 290 | F _{max} | | | | | | | | C 105 | 135 | F _{max} | | | | | | | | A 225 | 275 | F _{max} | | | | | | | | B 210 | 270 | F _{max} | | | | | | | | C 130 | 180 | F _{max} | | | | | | | | A 205 | 265 | F _{max} | | | | | | | | B 215 | 260 | F _{max} | | | | | | | | C 120 | 165 | F _{max} | | | | | | | | A 190 | 245 | F _{max} | | | | | | | | B 220 | 290 | F _{max} | | | | | | | | C 105 | 135 | F _{max} | | | | | | | | A 225 | 275 | F _{max} | | | | | | | | B 210 | 270 | F _{max} | | | | | | | | C 130 | 180 | F _{max} | | | | | | | | A 205 | 265 | F _{max} | | | | | | | | B 215 | 260 | F _{max} | | | | | | | | C 120 | 165 | F _{max} | | | | | | | | A 190 | 245 | F _{max} | | | | | | | | B 220 | 290 | F _{max} | | | | | | | | C 105 | 135 | F _{max} | | | | | | | | A 225 | 275 | F _{max} | | | | | | | | B 210 | 270 | F _{max} | | | | | | | | C 130 | 180 | F _{max} | | | | | | | | A 205 | 265 | F _{max} | | | | | | | | B 215 | 260 | F _{max} | | | | | | | | C 120 | 165 | F _{max} | | | | | | | | A 190 | 245 | F _{max} | | | | | | | | B 220 | 290 | F _{max} | | | | | | | | C 105 | 135 | F _{max} | | | | | | | | A 225 | 275 | F _{max} | | | | | | | | B 210 | 270 | F _{max} | | | | | | | | C 130 | 180 | F _{max} | | | | | | | | A 205 | 265 | F _{max} | | | | | | | | B 215 | 260 | F _{max} | | | | | | | | C 120 | 165 | F _{max} | | | | | | | | A 190 | 245 | F _{max} | | | | | | | | B 220 | 290 | F _{max} | | | | | | | | C 105 | 135 | F _{max} | | | | | | | | A 225 | 275 | F _{max} | | | | | | | | B 210 | 270 | F _{max} | | | | | | | | C 130 | 180 | F _{max} | | | | | | | | A 205 | 265 | F _{max} | | | | | | | | B 215 | 260 | F _{max} | | | | | | | | C 120 | 165 | F _{max} | | | | | | | | A 190 | 245 | F _{max} | | | | | | | | B 220 | 290 | F _{max} | | | | | | | | C 105 | 135 | F _{max} | | | | | | | | A 225 | 275 | F _{max} | | | | | | | | B 210 | 270 | F _{max} | | | | | | | | C 130 | 180 | F _{max} | | | | | | | | A 205 | 265 | F _{max} | | | | | | | | B 215 | 260 | F _{max} | | | | | | | | C 120 | 165 | F _{max} | | | | | | | | A 190 | 245 | F _{max} | | | | | | | | B 220 | 290 | F _{max} | | | | | | | | C 105 | 135 | F _{max} | | | | | | | | A 225 | 275 | F _{max} | | | | | | | | B 210 | 270 | F _{max} | | | | | | | | C 130 | 180 | F _{max} | | | | | | | | A 205 | 265 | F _{max} | | | | | | | | B 215 | 260 | F _{max} | | | | | | | | C 120 | 165 | F _{max} | | | | | | | | A 190 | 245 | F _{max} | | | | | | | | B 220 | 290 | F _{max} | | | | | | | | C 105 | 135 | F _{max} | | | | | | | | A 225 | 275 | F _{max} | | | | | | | | B 210 | 270 | F _{max} | | | | | | | | C 130 | 180 | F _{max} | | | | | | | | A 205 | 265 | F _{max} | | | | | | | | B 215 | 260 | F _{max} | | | | | | | | C 120 | 165 | F _{max} | | | | | | | | A 190 | 245 | F _{max} | | | | | | | | B 220 | 290 | F _{max} | | | | | | | | C 105 | 135 | F _{max} | | | | | | | | A 225 | 275 | F _{max} | | | | | | | | B 210 | 270 | F _{max} | | | | | | | | C 130 | 180 | F _{max} | | | | | | | | A 205 | 265 | F _{max} | | | | | | | | B 215 | 260 | F _{max} | | | | | | | | C 120 | 165 | F _{max} | | | | | | | | A 190 | 245 | F _{max} | | | | | | | | B 220 | 290 | F _{max} | | | | | | | | C 105 | 135 | F _{max} | | | | | | | | A 225 | 275 | F _{max} | | | | | | | | B 210 | 270 | F _{max} | | |
| ST Upright | P15 | P40 | ST Bent | P15 | P40 | ST Above head | P15 | P40 | Finger forces F _{max} (neutral to gender) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | A 245 | 315 | | A 210 | 285 | | A 230 | 280 | Posture A1 (power grip, pliers: see 70%) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | B 280 | 325 | | B 200 | 240 | | A 285 | 320 | F _{max} | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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蜆上岸篩選作業

兩位蜆養殖勞工偕同先將圓形不鏽鋼盆抬離保麗龍浮板後，再抬舉至岸邊置放，等待後續進行清洗及篩選作業。每個裝滿蜆的不鏽鋼圓盆重量約為 45 公斤，每天約需處理 3,000 公斤的蜆（約 67 個大圓盆），每天工作 4 小時。（圖 65）



將不鏽鋼盆抬離保麗龍浮板



再將圓盆抬至岸上板

圖 65 雲分群聚調查抬舉作業流程圖

蜆養殖勞工需要以抬舉的姿勢將裝滿蜆的圓形不鏽鋼盆抬至岸邊，圓盆重量為 45 公斤，兩位蜆養殖勞工平均施力，因此一位需抬 22.5 公斤，評級點數為 3.5，姿勢為低彎腰，評級點數為 4；在頻率部分，每次作業需抬舉兩次，每日共須處理 3000 公斤的蜆，總計每天需完成 134 次的抬舉動作，評級點數為 4.1，風險值為 30.8，EAWS 等級在黃燈區，可能有罹患下背肌肉骨骼傷病的風險，建議進行工作再設計。（圖 66）

| Manual Material Handling (per shift) | | | | | | | | | | Loads | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|--|--|---|---|---|--|------------------------------|--|------|--------------|--------------------|------|------|------|--|--------------------------------|-------------------|---|-----------------|---|---------------|---|--------------|---|--------------|--------------------|---------------------------------|------|---|--|---|--|---|------|---|--|--|------------------------------|--|--|--|--|--|--|--|--|--|--|
| Weights of loads [kg] for repositioning (lifting / lowering), carrying and holding as well as pushing and pulling | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Reposition, carrying & holding | Males | 3 | 10 | 15 | 20 | 22.5 | 25 | 30 | 35 | 40 | >40 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | Females | 2 | 5 | 7 | 10 | 3.5 | 5 | 15 | 20 | 25 | >25 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Load points | | 1 | 1.5 | 2 | 3 | 4 | 5 | 5.5 | 7 | 8.5 | 25 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| + Pushing and pulling | Males | Barrows | | | <50 | 75 | 100 | 150 | 200 | 250 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | Females | Barrows | | | <40 | 60 | 80 | 115 | 155 | 195 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | Males | Carriage, roller, trolleys | | | <50 | 75 | 100 | 150 | 250 | 350 | 550 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | Females | Carriage, roller, trolleys | | | <40 | 60 | 80 | 115 | 195 | 270 | 425 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | Males | Carts, roller tables, carriages, Fixed rollers | | | <50 | 75 | 150 | 250 | 350 | 500 | 600 | 800 | 1250 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | Females | Carts, roller tables, carriages, Fixed rollers | | | <40 | 60 | 115 | 195 | 270 | 385 | 480 | 615 | 980 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Load points | | Means of transport | | | 0.5 | 1 | 1.5 | 2 | 3 | 4 | 5 | 6 | 8 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Posture, position of load (select characteristic posture) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| + trunk upright and / or not twisted load at the body | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | little trunk bending or twisting; load at or close to the body | | | bending trunk deep or far forward; little trunk bending forward and trunk twisting simultaneously; load far from body or above shoulder level | | | bending trunk far forward and twisting; load far from the body; limited postural stability while standing; crouching or kneeling | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Posture points | 1 | | | 2 | | | 4 | | | 8 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Working Conditions (pushing and pulling only) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| (+) | very low rolling resistance | trolley pushing / pulling on (very) slick floor | rough floor and above small gaps / edges | on structured sheet metal, into / out of a track | trolleys have to be torn off when starting, strongly damaged floor | very high rolling resistance | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Conditions points | 0 | 1 | 3 | 5 | 6 | 8 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Frequency of load manipulations [# / shift], holding time [min] or travel distance [meter / shift] | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| x | Frequency of repositionings / pushing & pulling short | 5 | 25 | 120 | 134 | 350 | 750 | 1000 | 1500 | 2000 | 2500 | 3000 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | Duration (holding time) [min] | 2.5 | 10 | 37 | 90 | 180 | 240 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | Distance (carrying, pushing & pulling long) [m] | 300 | 650 | 2500 | 6000 | 12000 | ≥16000 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| # duration or distance points | 1 | 2 | 4 | 4.1 | 6 | 8 | 10 | 11 | 13 | 14 | 15 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Manual Material Handling (result) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 19 | (Load + posture + (condition points)) x (#, duration or distance points) | Repositioning (3.5) | + | 4 | + | 4.1 | + | 30.8 | + | 30.8 | + | 30.8 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Handling = Σ line 19 = 30.8 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 1) Maximal cumulative time points for all tasks of repositioning, holding, carrying as well as pushing & pulling all together = 15 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| <table border="1"> <tr> <td><input type="checkbox"/> Green</td> <td>Whole Body</td> <td>=</td> <td>Postures</td> <td>+</td> <td>Forces</td> <td>+</td> <td>Loads</td> <td>+</td> <td>Extra</td> <td>Upper Limbs</td> </tr> <tr> <td><input type="checkbox"/> Yellow</td> <td>30.8</td> <td>=</td> <td></td> <td>+</td> <td></td> <td>+</td> <td>30.8</td> <td>+</td> <td></td> <td></td> </tr> <tr> <td><input type="checkbox"/> Red</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table> | | | | | | | | | | | | | | | <input type="checkbox"/> Green | Whole Body | = | Postures | + | Forces | + | Loads | + | Extra | Upper Limbs | <input type="checkbox"/> Yellow | 30.8 | = | | + | | + | 30.8 | + | | | <input type="checkbox"/> Red | | | | | | | | | | |
| <input type="checkbox"/> Green | Whole Body | = | Postures | + | Forces | + | Loads | + | Extra | Upper Limbs | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| <input type="checkbox"/> Yellow | 30.8 | = | | + | | + | 30.8 | + | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| <input type="checkbox"/> Red | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| EAWs evaluation | 0-25 Points | Green | Low risk: recommended; no action is needed | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | >25-50 Points | Yellow | Possible risk: not recommended; redesign if possible, otherwise take other measures to control the risk | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | >50 Points | Red | High risk: to be avoided; action to lower the risk is necessary | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

圖 66 以 EAWS 風險評估工具評估蜆上岸作業測量結果



篩選及清洗作業

進行篩選及清洗蜆作業時，蜆養殖勞工以左手拿紅篩網、以右手拿紅勺子撥蜆，接著以雙手拿篩網過水清洗後，再以右手挑出品質不良的蜆並置於左手，左手將不良品丟棄後，再以雙手甩篩網及清洗。最後將篩選後的蜆倒於暫存區的待裝袋內，每個勺子內的蜆重量約為 3 公斤，此作業的動作週期為 37 秒，每天工作 4 小時。(圖 67)



取出蜆



清洗



篩選



將蜆置於暫存區

圖 67 雲分群聚調查蜆篩選及清洗作業流程圖

針對左、右手的施力進行評估，作業過程中以左手拿篩網、以右手拿勺子撥蜆（力量中等），接著以雙手拿篩網過水清洗（力量中等），之後以右手進行篩選作業，挑出品質不良的蜆置於左手，然後左手將不良品丟棄後（力量極低），最後將篩選後的蜆倒於暫存區等待裝袋（力量中等），分析計算後，左手的施力評級分數為 3 分，右手為 4 分。

抓握時戴手套，不易抓握，因此抓握條件之評級點數為 1，手及手臂位置的評級點數為 1，工作協調的評級點數為 2；姿勢以坐姿為主，偶爾行走，軀幹會明顯前傾和扭轉，分數為 3。工作時間每天 4 小時，評級點數為 2.5，經計算後，風險值為 30，風險等級為 3，屬中高負載，建議需要進行人因改善。(表 21)

表 21 以 KIM-MHO 風險評估工具評估篩選及清洗作業作業結果

| 手 - 手指部位的施力方式 | | 握持 | | | | 移動 | | | | | |
|--|--|--------------|-------|------|-----|--------------|----------|------|----------|----------|-----|
| | | 平均握持時間 [秒/分] | | | | 平均移動頻率 [次/分] | | | | | |
| | | 60-31 | 30-16 | 15-4 | <4 | <1 | 1-4 | 5-15 | 16-30 | 31-60 | >60 |
| 等級 | | 評級點數 | | | | | | | | | |
| 低  | 力量極低 例如：按鈕啟動 / 換檔 / 整理 | 2 | 1 | 0.5 | 0 | 0 | 0.5 | 1 | 2 | 3 | |
| | 力量低 例如：物料引導 / 插入 | 3 | 1.5 | 1 | 0 | 0 | 1 | 1.5 | 3 | 5 | |
| | 力量中等 例如：抓握 / 用手或小工具組裝小工件 | 5 | 2 | 1 | 0 | 0.5 | 1 | 2 | 5 | 8 | |
| | 力量高 例如：旋轉 / 纏繞 / 包裝 / 抓取 / 握持或組裝零件 / 壓入 / 切割 / 使用小動力手工具作業 | 8 | 4 | 2 | 0.5 | 1 | 2 | 4 | 8 | 13 | |
| | 力量極高 例如：涉及以施力進行的切割 / 以小釘槍工作 / 移動或固定零件或工具 | 12 | 6 | 3 | 1 | 1 | 3 | 6 | 12 | 21 | |
| | 力量達到峰值 例如：鎖緊或鬆動螺絲 / 分離 / 壓入 | 19 | 9 | 4 | 1 | 2 | 4 | 9 | 19 | 33 | |
| 高 | 捶打：以拇指球、手掌或拳頭 | - | - | - | 1 | 1 | 3 | 6 | 12 | 21 | |
| 必須觀察工作週期並分別標註相關施力等級的評級點數，再將所標註的評級點數（左右手分開）加總算出施力的評級點數，後續以其比較高者來計算總評級點數。 | | | | | | | 施力的評級點數： | | 左手： 3 | 右手： 4 | |

| 算式 | 各項評估 | 評級點數 | 說明 |
|----|-------------|-----------|-------------------|
| 項目 | 施力的評級點數 | 4 | 如表 |
| + | 抓握條件 | 1 | 戴手套，濕滑介於良好及受限 |
| + | 手臂位置 | 1 | 關節位置或活動不定期地達到活動極限 |
| + | 工作協調 | 2 | 負荷狀況幾乎沒有變化 |
| + | 工作條件 | 1 | 潮濕、噪音 |
| + | 姿勢 | 3 | 軀幹明顯前傾和扭轉 |
| = | 總計 | 12 | |
| × | 總時間評級點數 | 2.5 | 總工時為 4 小時 |
| = | 風險分數 | 30 | |

| 風險等級 ***) | 風險分數 | 說明 |
|-----------|-----------|---|
| 1 | <10 | 低負荷，不易產生身體過載的健康危害。 |
| 2 | 10 to <25 | 中等負載，身體過載的情形可能發生於恢復能力較弱者。針對此族群進行工作再設計是有幫助的。 |
| 3 | 25 to <50 | 中高負載，身體過載的情形可能發生於一般作業人員。應檢討工作場所的重新設計。 |
| 4 | ≥50 | 高負載，生理過載的情形極可能發生。必須進行工作改善。 |



篩選及清洗作業主要以坐姿進行，幾乎所有工作時間都有背部彎曲的情形，風險值為 13。而約有 4 秒的時間蠅養殖勞工軀幹為中度扭轉及側彎，因此因不當姿勢可能導致下背不適的風險值 3。經過計算後總風險值為 16，EAWS 等級在綠燈區，導致下背肌肉骨骼傷病之風險極低，不需要進行後續之改善。(圖 68)

| Basic Positions / Postures and movements of trunk and arms (per shift) | | | | | | | | | | | Postures | | | | | | | | | | | | |
|--|---------------|--|---|----------|---------|---------------|-----|-------|-------|--------|--|----------------------|----------------------|-----|-----|-----|-------------|-------------|-------------|--|-------------------|-------------------|--|
| (incl. loads of <3 kg, forces onto fingers of <30 N and whole body forces of <40 N) Static postures: ≥ 4sec High frequency movements: Trunk bendings (> 60°) ≥ 2/min Kneeling/crouching ≥ 2/min Arm liftings (> 60°) ≥ 10/min | | | | | | | | | | | Evaluation of static postures and/or high frequent movements of trunk/arms/legs | | | | | | | | | | Asymmetry effects | | |
| | | | | | | | | | | | Duration (sec/min) = $\frac{\text{duration of posture(s)} \times 60}{\text{cycle time}}$ | | | | | | | | | | Sum of lines | Trunk Rotation 1) | |
| [%] | 5 | 7,5 | 10 | 15 | 20 | 27 | 33 | 50 | 67 | 83 | int | dur | int | dur | int | dur | | | | | | | |
| [sec/min] | 3 | 4,5 | 6 | 9 | 12 | 16 | 20 | 30 | 40 | 50 | 0-5 | 0-3 | 0-5 | 0-3 | 0-5 | 0-2 | | | | | | | |
| [min/8h] | 24 | 36 | 48 | 72 | 96 | 130 | 180 | 240 | 320 | 400 | Intensity x Duration | Intensity x Duration | Intensity x Duration | | | | | | | | | | |
| Sitting | | | | | | | | | | | | | | | | | | | | | | | |
| 7 | | Upright with back support slightly bent forward or backward | 0 | 0 | 0 | 0 | 0 | 0,5 | 1 | 1,5 | 2 | | | | | | | | | | | | |
| 8 | | Upright no back support (for other restrict. see Extra Points) | 0 | 0 | 0,5 | 1 | 1,5 | 2 | 3 | 4 | 5,5 | 7 | | | | | | | | | | | |
| 9 | | Bent forward | 0,7 | 1 | 1,5 | 2 | 3 | 4 | 6 | 8 | 11 | 13 | 13 | 1 | 1,5 | 1 | 1,5 | | | | | | |
| 10 | | Elbow at / above shoulder level | 2,7 | 4 | 7 | 10 | 13 | 16 | 23 | 30 | 40 | 50 | | | | | | | | | | | |
| 11 | | Hands above head level | 4 | 6 | 10 | 14 | 20 | 25 | 35 | 45 | 60 | 75 | | | | | | | | | | | |
| 1) | | 0 | 1 | 3 | 5 | 2) | | 0 | 1 | 3 | 5 | Σ | 13 | 1,5 | 1,5 | Σ | | | | | | | |
| Trunk int | | slightly | medium | strongly | extreme | Far Reach int | | close | 60% | 80% | arm stretched | | | | | | Σ (max.=15) | Σ (max.=15) | Σ (max.=10) | | | | |
| | | ≤10° | 15° | 25° | ≥30° | | | never | 4 sec | 10 sec | 13 sec | | | | | | | | | | | | |
| dur | | 0 | 1,5 | 2,5 | 3 | dur | | never | 4 sec | 10 sec | 13 sec | | | | | | Σ (max.=40) | | | | | | |
| | | 0% | 6% | 15% | 20% | | | 0% | 6% | 15% | 20% | (b) | | | | | | | | | | | |
| Attention: Max. duration of evaluation = duration of task or 100%! | | | | | | | | | | | Attention: correct evaluation, if duration of evaluation ≠ 60s | | | | | | | | | | | | |
| Postures = Σ lines 1 - 16 | | | 13 | | | 3 | | | = | | | 16 | | | | | | | | | | | |
| <input checked="" type="checkbox"/> Green <input type="checkbox"/> Yellow <input type="checkbox"/> Red | | Whole Body | = | Postures | + | Forces | + | Loads | + | Extra | Upper Limbs | | | | | | | | | | | | |
| | | 16 | = | 16 | + | | + | | + | | | | | | | | | | | | | | |
| EAWS evaluation | 0-25 Points | Green | Low risk: recommended; no action is needed | | | | | | | | | | | | | | | | | | | | |
| | >25-50 Points | Yellow | Possible risk: not recommended; redesign if possible, otherwise take other measures to control the risk | | | | | | | | | | | | | | | | | | | | |
| | >50 Points | Red | High risk: to be avoided; action to lower the risk is necessary | | | | | | | | | | | | | | | | | | | | |

圖 68 以 EAWS 風險評估工具評估請喜及篩選作業測量結果

建議：

針對蜆養殖勞工的工作現場訪視測量結果，依據工作內容提出改善建議如下：

1、蜆收成作業

建議使用可以有效改善不當姿勢、重複性施力的自走式文蛤收穫機進行作業，作業過程中漁民不需要再握持並拉起魚網施力，僅需操作機器，亦可以降低罹患下肢肌肉骨骼疾病的風險。

2、蜆上岸篩選作業

為改善蜆養殖勞工在濕滑環境以高強度的施力進行抬舉作業，建議在岸邊設置省力裝置（圖 69），以減少高度施力及不當姿勢的發生。



圖 69 蜆上岸篩選作業工作改善建議

3、篩選及清洗作業

建議使用篩選用平面輸送機，以改善蜆養殖勞工在清洗及篩選蜆作業時需進行高度重複性上肢動作的問題。



手工製鞋業勞工肌肉骨骼危害調查－成大防治中心

群聚調查職業疾病類型：

職業性肌肉骨骼疾病

個案工作性質與背景介紹：

個案從事手工製鞋業約 35 年，大月 (31 天) 每日工作約 15 小時，小月 (30 天) 每日工作 8 小時，週休一日。個案的主要工作是將皮革縫製成各類鞋款。在操作針車縫合皮革的過程中，須使用雙手將皮革固定於縫紉檯面，雙手須施力壓住皮革往前滑動，確保縫合位置正確。縫合一件皮革耗時約 10 秒鐘。

工作時須雙手反覆、用力，且不自然的姿勢操作，其中又以針車縫合的製程危害最高，單一製程中同時包含三種易導致腕隧道症候群之人因危害因子。操作針車時，勞工須雙手施力，且以不自然的姿勢握持皮革，反覆使用雙手操作針車將皮革縫製成鞋面。(圖 70)

削皮：雙手持皮革使用機器削皮。



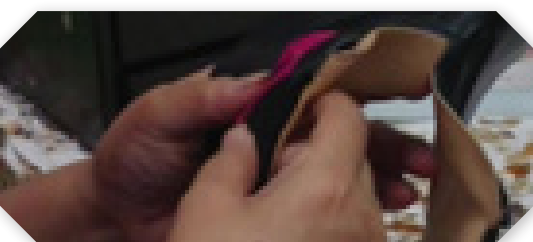
反覆：60 次 /min

抹糊：手持刷子沾膠水塗革內側



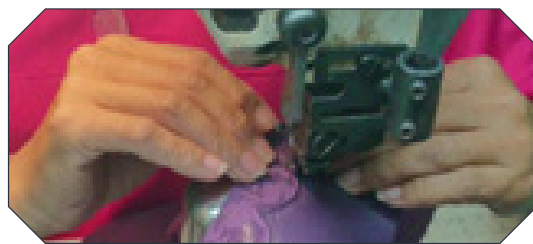
反覆：43 次 /min

塞泡棉：雙手將泡綿塞入皮革摺痕



反覆：40 次 /min；用力

針車縫合：雙手握皮革以針車縫製組合。



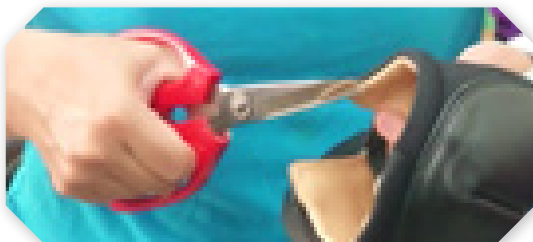
反覆：22 次 /min；用力；不自然姿勢

折邊：手持鐵鎚反覆敲打皮革製造摺痕。



反覆：104 次 /min；用力

修內裡：單手持剪刀修去皮革多餘的內裡



用力

製鞋眼：雙手各持鐵鎚及釘打洞



反覆：27 次 /min；用力

手動上鉚釘：將金屬鉚釘放入鞋眼中



反覆：>20 個 /min



機器上鉚釘：雙手握持皮革將鞋眼對準機器後
打上鉚釘

反覆性：22 個 /min

圖 70 成大群聚調查手工製鞋作業流程說明

訪視目的：

成大職業醫學門診的求診個案自述工作中腕部經常進行反覆性單調動作且須維持不自然姿勢，因此安排現場訪視以評估個案所罹患腕隧道症候群與其工作的相關性，並提出職業傷病相關的健康保護建議。

調查結果：

本調查共訪問 13 位從事手工製鞋業、平均年齡為 48 歲的受訪者，皆為女性。當中有 38.5% 的人 BMI 屬於過重或肥胖，61.5% 的人體位在標準範圍，多數教育程度落於國中（33.3%）與高中職（33.3%）之間。所有受訪者從未抽菸，僅 1 位受訪者有飲酒習慣。受訪者每週的運動天數介於 0 至 7 天之間，平均天數為 3 ± 3 天。受訪者中多數人（69.2%）於工作後有伸展舒緩的習慣，23.1% 的人每兩三天一次，23.1% 的人每天一次，23.1% 的人每天多次伸展。（表 22）



受訪者的年資介於 1 至 35 年之間，平均 (± 標準差) 年資 18 (±10) 年，任職於目前公司的年資平均 (± 標準差) 為 10 (±10) 年；每月最常工作天數的平均值 (± 標準差) 為 22 (±6) 天，每天最常工作時數的平均值 (± 標準差) 為 9 (±1) 小時，每天工作中手部頻繁操作或用力最常時數 (± 標準差) 為 8 (±1) 小時。受訪者於最近半年內的工作內容以操作針車 (69.2%) 佔最大宗，其次是摺邊 (30.8%)、抹糊 (23.1%)、修內裡 (23.1%)、敲鞋眼 (15.4%)、固定鉚釘 (15.4%)、削皮 (7.7%)、塞泡棉 (7.7%)。(表 23)

手工製鞋業需大量使用手部動作、反覆操作，工作時多為坐姿且大量使用針車，長期工作易造成肩、頸、手部、腰背肌肉骨骼的傷害。經本次群聚調查的問卷分析，發現有 92.4% 的手工製鞋業人員在最近三個月每天出現肌肉骨骼的不適症狀，症狀又以腰背 (76.9%) 不適占比最多，肩膀 (61.5%) 次之，頸部 (53.8%) 與手指 (53.8%) 並列第三。雖然受訪者中有骨骼肌肉症狀的占比極高，但僅有 53.8% 的受訪者表示最近三個月曾因肌肉骨骼不適就醫，僅 23.1% 的受訪者於近三個月內因肌肉骨骼不適請假。造成不適需要就醫的肌肉骨骼症狀以手腕 (30.8%) 與腰背 (30.8%) 最多，其次是手指 (23.1%)。而最近三個月因為不適需要請假休養的骨骼肌肉症狀則是以手指 (23.1%)、手腕 (23.1%)、腰背 (23.1%) 並列第一，頸部以外之其他部位之症狀則沒有請假的需求。(表 24)

最近一年內有 38.5% 的受訪個案曾被醫師診斷骨骼肌肉疾病，腕隧道症候群 (23.1%) 為首，板機指 (7.7%) 與媽媽手 (7.7%) 次之 (表 23)。依據現場訪視時由醫師執行的理學檢查結果，發現肱骨溝觸痛檢查 (bicipital groove palpation) 陽性 (30.8%) 的比率最高，Tinel' s test (30.8% 陽性)、脊下肌觸痛檢查 (infraspinatus muscle palpation) (23.1% 陽性) 次之，接續是 Finkelstein' s test (15.4% 陽性)、小圓肌觸痛檢查 (Teres minor muscle palpation) (15.4% 陽性)、Cozen' s test- lateral (7.7% 陽性)、Cozen' s test-medial (7.7% 陽性)，其餘菱形肌觸痛檢查 (Rhomboid muscle palpation)、click signs 所有受訪者皆為陰性 (0%)。(表 26)。

根據本次的問卷調查，92.4% 受訪者在過去三個月有肌肉骨骼的症狀，症狀以腰背 (76.9%)、肩 (61.5%)、頸 (53.8%)、手指 (53.8%)、手腕 (46.2%) 為主，但是因為症狀有請假需求的則是手指 (23.1%)、手腕 (23.1%)、腰背 (23.1%) 為首，近一年內勞工曾被醫師診斷的骨骼肌肉疾病，以腕隧道症候群 (23.1%) 為首，板機指 (7.7%) 與媽媽手 (7.7%) 次之。(表 25)

有鑑於該事業單位有極高比例的勞工發生肌肉骨骼不適的症狀，因此成大偕同工作能力強化中心的職能治療師前往工作場所，先由職業醫學科醫師進行職場肌肉骨骼傷害預防衛教宣導，再由職能治療師進行各部位肌肉伸展操教學。

表 22 成大群聚調查手工製鞋業家庭代工廠作業員之基本資料分析

| 項目 | N | 總個案數 = 13 | |
|-------------|----|-------------------------|--|
| | | 平均值 ± 標準差 (範圍) / 百分比 | |
| 年齡 | 13 | 48±12 (24-64) | |
| 性別 | | | |
| 男性 | 0 | 0% | |
| 女性 | 13 | 100% | |
| BMI | | | |
| 過輕 | 0 | 0% | |
| 標準 | 8 | 61.5% | |
| 過重或肥胖 | 5 | 38.5% | |
| 教育程度 | | | |
| 小學 | 3 | 25.0% | |
| 國中 | 4 | 33.3% | |
| 高中職 | 4 | 33.3% | |
| 大專 | 1 | 8.4% | |
| 研究所以上 | 0 | 0% | |
| 抽菸習慣 | | | |
| 從未抽過 | 13 | 100% | |
| 已戒菸 | 0 | 0% | |
| 有抽菸 | 0 | 0% | |
| 喝酒習慣 | | | |
| 從未喝過 | 12 | 92.3% | |
| 已戒酒 | 0 | 0% | |
| 有喝酒 | 1 | 7.7% | |
| 每週運動天數 | 12 | 3±3 (0-7) | |

| 項目 | N | 總個案數 = 13 | |
|------------------|---|-------------------------|--|
| | | 平均值 ± 標準差 (範圍) / 百分比 | |
| 工作後伸展舒緩習慣 | | | |
| 沒有 | 4 | 30.7% | |
| 兩三天一次 | 3 | 23.1% | |
| 每天一次 | 3 | 23.1% | |
| 每天多次 | 3 | 23.1% | |
| 勞保投保單位 | | | |
| 工會 | 4 | 30.7% | |
| 公司或事業單位 | 1 | 7.7% | |
| 其他 | 3 | 23.1% | |
| 未投保 | 5 | 38.5% | |



表 23 成大群聚調查手工製鞋業家庭代工廠作業員之年資與工作內容分析

| 項目 | N | 總個案數 = 13 |
|------------------------|----|----------------------|
| | | 平均值 ± 標準差 (範圍) / 百分比 |
| 從事製鞋業年資 | 13 | 18±10 (1-35) |
| 任職目前公司年資 | 13 | 10±10 (0.3-35) |
| 每月最常工作天數 | 13 | 22±6 (4-26) |
| 每天最常工作時數 | 13 | 9±1 (8-12) |
| 每天工作中手部頻繁操作 / 用力最常時數 | 12 | 8±1 (6-8) |
| 最近半年內的工作內容 (複選) | | |
| 削皮 | 1 | 7.7% |
| 操作針車 | 9 | 69.2% |
| 抹糊 | 3 | 23.1% |
| 折邊 | 4 | 30.8% |
| 塞泡棉 | 1 | 7.7% |
| 修內裡 | 3 | 23.1% |
| 敲斜眼 | 2 | 15.4% |
| 固定鉚釘 | 2 | 15.4% |

表 24 成大群聚調查手工製鞋業家庭代工廠作業員之肌肉骨骼症狀分析

| 項次 | 最近三個月內是否每天出現肌肉骨骼不適 | | | | | |
|-----------|--------------------|-------|----|-------|----|-------|
| | 症狀 | | 就醫 | | 請假 | |
| 總個案數 = 13 | | | | | | |
| | N | 百分比 | N | 百分比 | N | 百分比 |
| 否 | 1 | 7.6% | 6 | 46.2% | 10 | 76.9% |
| 是, 不舒服部位: | 12 | 92.4% | 7 | 53.8% | 3 | 23.1% |
| 手指 | 7 | 53.8% | 3 | 23.1% | 3 | 23.1% |
| 手腕 | 6 | 46.2% | 4 | 30.8% | 3 | 23.1% |
| 手肘 | 3 | 23.1% | 2 | 15.4% | 0 | 0% |
| 肩膀 | 8 | 61.5% | 1 | 7.7% | 0 | 0% |
| 脖子 | 7 | 53.8% | 1 | 7.7% | 2 | 15.4% |
| 腰背 | 10 | 76.9% | 4 | 30.8% | 3 | 23.1% |
| 大腿 | 2 | 15.4% | 1 | 7.7% | 0 | 0% |

表 25 成大群聚調查手工製鞋業家庭代工廠作業員肌肉骨骼疾病分析

| 最近一年內是否曾被醫師診斷肌肉骨骼疾病 (複選) | | |
|--------------------------|---|-------|
| 否 | 8 | 61.5% |
| 是, 疾病名稱: | 5 | 38.5% |
| 扳機指 | 1 | 7.7% |
| 媽媽手 | 1 | 7.7% |
| 腕隧道症候群 | 3 | 23.1% |
| 網球肘 | 0 | 0% |
| 高爾夫球肘 | 0 | 0% |
| 旋轉肌袖症候群 | 0 | 0% |



表 26 成大群聚調查手工製鞋業家庭代工廠作業員肌肉骨骼理學檢查結果

| 項目 | N | 總個案數 = 13 | |
|------------------------------|----|-------------------------|--|
| | | 平均值 ± 標準差 (範圍) / 百分比 | |
| 理學檢查 | | | |
| Finkelstein's test | | | |
| 陽性 * | 2 | 15.4% | |
| 不典型 | 0 | 0% | |
| 陰性 | 11 | 84.6% | |
| Tinel's test | | | |
| 陽性 * | 4 | 30.8% | |
| 不典型 | 0 | 0% | |
| 陰性 | 9 | 69.2% | |
| Cozen's test- lateral | | | |
| 陽性 * | 1 | 7.7% | |
| 不典型 | 0 | 0% | |
| 陰性 | 12 | 92.3% | |
| Cozen's test- medial | | | |
| 陽性 * | 1 | 7.7% | |
| 不典型 | 0 | 0% | |
| 陰性 | 12 | 92.3% | |
| Rhomboid mm. | | | |
| 陽性 * | 0 | 0% | |
| 不典型 | 0 | 0% | |
| 陰性 | 13 | 100% | |
| Infra-spinatus mm. | | | |
| 陽性 * | 3 | 23.1% | |
| 不典型 | 1 | 7.7% | |
| 陰性 | 9 | 69.2% | |

| 項目 | N | 總個案數 = 13 | |
|-------------------------|----|-------------------------|--|
| | | 平均值 ± 標準差 (範圍) / 百分比 | |
| Teres minor mm. | | | |
| 陽性 * | 2 | 15.4% | |
| 不典型 | 0 | 0% | |
| 陰性 | 11 | 84.6% | |
| Bicipital groove | | | |
| 陽性 * | 4 | 30.8% | |
| 不典型 | 1 | 7.7% | |
| 陰性 | 8 | 61.5% | |
| Click signs | | | |
| 陽性 * | 0 | 0% | |
| 不典型 | 0 | 0% | |
| 陰性 | 13 | 100% | |





由職業醫學科醫師現場訪視，
進行問卷訪問。



由醫師於現場進行
理學檢查。



由職業醫學科醫師進行
衛教，講題為職場肌肉
骨骼傷害預防。



現場衛教情況。



職能治療師教學正中
神經滑動練習。



現場勞工參與之狀況。



正中神經滑動練習之教材。



職能治療師教學肩頸舒展
及放鬆運動。



勞工於現場參與
伸展操之實況。



會後合影。

圖 71 成大群聚調查現場衛教宣導情形

建議：

針對手工製鞋業勞工及其雇主，提供 6 項改善建議：

- 1、手工製鞋從業人員需大量操作針車，過程中除了手部須反覆、用力、以不良姿勢操作外，頸部也會反覆前曲。在雙手反覆操作、久坐且姿勢不良的情況下，極易產生肩、頸、下背疼痛、雙手麻痛等不適。因此，此行業的勞工較易發生肌肉骨骼症狀，而其中會影響工作能力的則是腕隧道症候群為首要。
- 2、現場工作訪視觀察的 8 個作業內容中，每個製程皆有會造成腕隧道症候群的危險因子，其中以針車操作的危害因子最多，包含：手部反覆性、用力性與不自然姿勢的操作等。建議透過班表輪替的方式，盡量減低重複使用勞工的特定肌肉群，讓勞工於工作中有固定的休息時間，讓肌肉群能適當休息。
- 3、建議本身患有類風溼性關節炎、甲狀腺低下的人工製鞋業勞工定期接受治療，以免加重腕隧道症候群的症狀。
- 4、建議手工製鞋從業人員，能於工作前、後或是休息時間，定期伸展肩、頸、手部的肌肉群，並可搭配正中神經滑動練習，降低肌肉骨骼危害。
- 5、若發生職業性骨骼肌肉疾病，建議善用我國勞工保險的職業病給付，減免醫療費用負擔。
- 6、參考美國職業安全衛生署預防職場肌肉骨骼疾病的建議策略，包含：(1) 提供管理階層的支持、(2) 結合勞工參與、(3) 提供訓練、(4) 辨識危害、(5) 鼓勵早期通報肌肉骨骼症狀、(5) 危害應對，及 (7) 追蹤成效等。

本調查介入雖然未提供反覆、用力及不當工作姿勢等人因工程危害的改善建議，但已結合雇主支持、員工參與、人因危害辨識、衛生教育訓練、早期篩檢職業病症狀、個人體能訓練、及復配工諮詢等多重策略，推行三段五級各階段的預防措施，期望能有效協助手工製鞋業勞雇雙方因應肌肉骨骼職業病的危害。



石綿暴露勞工環境採樣分析調查－臺大防治中心

群聚調查職業疾病類型：

職業性肺部疾病（職業性石綿暴露所致間皮細胞瘤、職業性石綿肺症、職業性氣喘）

個案工作性質與背景介紹：

108 年臺大防治中心接到 6 位疑似石綿癌症通報，其中 4 位已完成調查、並開立職病報告書協助申請職業病認定。（表 27）

表 27 臺大群聚調查個案基本資料

| 個案 | 年齡 | 性別 | 疾病診斷 | 行業別 | 工作內容 |
|----|------|----|--|-------|------------------------------------|
| A | 57 歲 | 男 | Sarcomatoid mesothelioma of RUL | 營造業 | 泥水工 |
| B | 61 歲 | 男 | Malignant neoplasm of lower lobe, right bronchus or lung | 製造業 | 齒輪師傅（把上游廠商做好的 " 石綿 " 鍍到齒輪上，並用螺絲鎖緊） |
| C | 65 歲 | 男 | Malignant pleural effusion, etiology to be determined, suspect metastatic adenocarcinoma related | 支援服務業 | 製作屋頂鐵架及鋪設屋頂 |
| D | 62 歲 | 男 | right middle lobe lung adenocarcinoma r/o occupation-related | 製造業 | 金飾加工 |
| E | 38 歲 | 男 | Lung cancer, right | 製造業 | 熱氣球工廠印製 |
| F | 76 歲 | 男 | r/o Atypical and fibrous, mesenchymal mesothelioma | 製造業 | 造船廠電銲工 |

訪視目的：

臺大於 105 年開始推動院內主動發現職業性肺病個案並推廣職業傷病防治中心業務，除維持胸腔內科、胸腔外科及心臟內科的門診轉介及住院照會的機制外，同時積極向院內其他科部宣導石綿暴露的疾病診斷資訊與通報。為釐清 108 年臺大列管追蹤的 6 位個案之一罹患肺癌是否係因工作場所暴露石綿所引發，故進行工作場所訪視。

調查結果：

工作現場訪視個案為 61 歲男性，過去病史有 C 型肝炎、缺血性心臟病、消化性潰瘍，菸齡 40 年，每天約莫會抽一包菸。自 108 年起有慢性乾咳與右側肋膜疼痛症狀，經電腦斷層診斷為右下肺葉肺癌合併同側中膈淋巴結腫大與肋膜轉移，個案於臺大醫院住院治療時，因工作史有石綿職業暴露史，病房照會臺大防治中心評估工作相關性。

個案於石綿墊片組裝工廠服務，廠內無特別安裝通風換氣的設備，為半開放式的非密閉空間。其石綿墊片組裝工作主要是把石綿墊片裝在新齒輪箱內，或是把舊齒輪箱內破損的石綿墊片刮除後，再把裁切完成的石綿墊片裝在舊齒輪箱內，一個月大約有 10 天會進行石綿墊片的裁切。

勞工裁切對應尺寸的石綿墊片及移除舊齒輪箱內破損的石綿墊片時，現場會有較明顯的石綿粉塵飄逸，推測為主要石綿暴露來源，但現場採樣時，以肉眼觀察發現粉塵量並不多，故臺大針對粉塵量較多的「石綿墊片切裁」與「破損石綿墊片移除」兩項作業，進行個人採樣與環境測量。

雖然石綿墊片組裝工作過程確實有石綿暴露，但與現場訪視所見的粉塵量並不多，空氣中濃度遠低於容許濃度標準，即使以測量到的的空氣中濃度最高值 $0.016 \text{ fibers} / \text{c.c}$ 進行估算，個案從事石綿墊片組裝工作 27 年，其累積工作石綿職業暴露為 $0.432 \text{ fibers} / \text{毫升} \cdot \text{年}$ ，仍然遠低於我國「石綿（包括含石綿的滑石）引起之職業性癌症認定參考指引」中的 $25 \text{ fibers} / \text{毫升} \cdot \text{年}$ 標準。相較之下，個案吸菸 40 年每天一包（40 包 / 年），已超過我國「石綿（包括含石綿的滑石）引起之職業性癌症認定參考指引 - 3 肺癌」中吸菸導致低度致癌風險的 15 包 / 年（15 包 / 年）標準，雖然石綿暴露與吸菸對肺癌發生有協同效應，但以個案的實際石綿暴露與吸菸情形而言，推測主要風險仍來自於吸菸。



圖 72 臺大群聚調查工作現場空氣採樣情形



建議：

依據本群聚調查結果，提出 3 項防治建議：

- 1、建議政府部門及相關研究單位提供早期相似作業場所的環測數據、照片、專家建議等，以俾釐清工作現場概況。
- 2、建議可以請勞保局針對職業性癌症勞工放寬失能給付的條件，以對於生活自理能力進行評估相關失能代替較為嚴格的器官檢測結果。
- 3、粉塵作業勞工肺功能異常的原因通常為多因性因素，建議可與國民健康署合作，共同推廣勞工呼吸道健康，並加強粉塵作業勞工的呼吸防護具使用衛教宣導，除了提醒正確的選擇呼吸防護具的知識外，亦需宣導正確的佩戴方式與相關知識。



重金屬（錫）暴露之群聚調查－長庚防治中心

群聚調查職業疾病類型：

職業性肺部疾病

個案工作性質與背景介紹：

個案 A 與個案 B 兩位噴砂作業員工作時使用氧化鋁細砂進行濺鍍靶材擋板、零件清潔，靶材濺鍍比例為 ITO 46%、矽 18%、銻 18%、鋁 13%、鉬 5%，雖然無法實際測得作業環境空氣中錫及其化合物濃度，但依據「錫及其化合物之中毒職業病認定參考指引」，2 位個案的胸部 X 光及電腦斷層檢查結果，發現肺部有纖維化病變情形發生，生物暴露指標血清中的錫為 149 $\mu\text{g}/\text{L}$ 及 79 $\mu\text{g}/\text{L}$ ，且臨床症狀出現呼吸系統症狀包含呼吸困難、喘等，符合職業疾病診斷基準。2 位個案皆由長庚協助向勞保局獲得職災傷病及醫療給付，工作內容亦進行調整。（表 28）

表 28 長庚群聚調查個案基本資料

| 公司 | 甲公司 | | | | | 乙公司 |
|------|----------|----|----------|----|-----------|----------|
| 個案 | A | B | C | D | E | F |
| 性別 | 男 | 男 | 男 | 男 | 男 | 男 |
| 年齡 | 37 | 39 | 46 | 54 | 44 | 52 |
| 作業內容 | ITO 擋板清潔 | | ITO 靶材研磨 | | 設備維修保養 | ITO 靶材研磨 |
| 工作年資 | 17 | 10 | 9 | 11 | 8 | 14 |
| 是否在职 | 是 | 否 | 是 | 否 | 是 | 是 |
| 是否抽菸 | 20 包 / 年 | 否 | 否 | 否 | >10 包 / 年 | 偶爾 |

訪視目的：

近年來因顯示器產業蓬勃發展，氧化錫錫（透明導電鍍膜 Indium tin oxide，簡稱 ITO）的使用量大幅增加，100 年全世界使用量約 1400 噸，其中超過 80 % 用於顯示器製造，而台灣使用氧化錫錫的量即佔約全世界的三分之一。氧化錫錫的可能暴露工作場所為氧化錫錫濺鍍靶製造廠、錫回收工廠、平板顯示器製造廠等。

本群聚共有 6 位作業環境暴露錫的勞工至長庚求診，為了解勞工工作暴露危害，長庚的職業醫學專業團隊至從事氧化錫錫作業的 2 家公司現場訪視調查工作環境及作業流程。



調查結果：

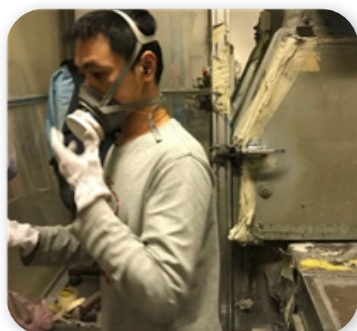
甲公司 ITO 擋板清潔作業工作現場 訪視結果



噴砂物件：左圖為待噴砂之擋板，右圖為已完成之擋板。



噴砂物件：左圖為待噴砂之零件，右圖為已完成之零件。



防護具使用情形：
病患進行噴砂作業時配戴手套及半面體單罐式呼吸防護具。



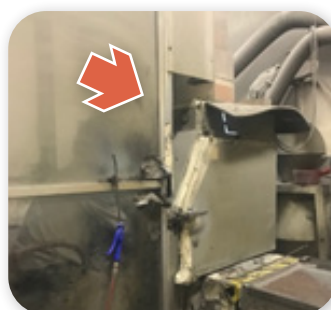
完成噴砂後取出擋板 / 零件。



噴砂作業情形：
雙手套進噴砂區內作業，眼睛透過壓克力板操作。



噴砂作業情形：
噴砂雙手伸入手套內進行噴砂作業。且機台無有效密閉。壓克力窗週邊可見膠帶黏貼。

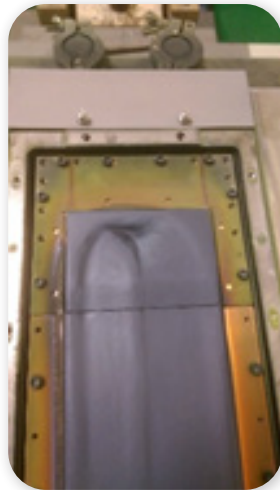


噴砂作業情形：
噴砂作業時於單獨 hood 內操作。作業區及手套作業區無密閉，作業現場粉塵逸散。



進行噴砂作業時，持續有粉塵溢散出。

甲公司（個案 C、個案 D – ITO 靶材研磨作業）



工作時配戴半面體單罐式呼吸防護具。持砂輪機研磨靶材，作業環境前方有局部排氣裝置。

圖 73 長庚群聚調查甲公司工作現場訪視圖

乙公司 ITO 靶材研磨工作現場訪視結果



靶材加工，將台車上之大型靶材吊掛至噴砂機（紅框）內。作業區除配戴防護具。



噴砂機內部機械手臂清潔靶材情況。



濕式研磨，過程為機台自動化密閉操作。



人工清潔細部，雙手持砂紙來回研磨，紅箭頭處為兩座局部排氣裝置設備。



進入作業區需配戴電動防塵面罩、作業服（下班須洗澡及脫掉工作服），下班後面罩放入抽氣櫃清潔。

圖 74 長庚群聚調查乙公司工作現場訪視圖

根據現場訪視結果可知，個案接觸的氧化銻錫粉塵為引起肺部疾病的主因，個案 A 及個案 B 工作內容為協助靶材濺鍍 (sputtering) 時所需的擋板 (Shutter) 及零件清潔需使用氧化鋁細砂將擋板、零件殘留的靶材金屬表面清潔，以俾重複使用。濺鍍時使用的擋板需每週更換一次並進行清潔，每塊擋板約使用一個月後汰換。零件噴砂每籃約需噴砂 30 分鐘，每日約需清理零件約 2-3 籃；擋板噴砂每次 2-4 條，每次約噴砂時間 30 分鐘，每日約 10 次。(圖 73、74)

噴砂作業中使用氧化鋁細砂作為擋板、零件清潔原料，擋板成份為中碳鋼、白鐵、鋁、銅、鈦，而靶材濺鍍包含：鉬靶、氧化鈮靶、氧化銻錫靶、矽靶、鋁合金靶，靶材濺鍍比例為氧化銻錫 46%、矽 18%、鈮 18%、鋁 13%、鉬 5%。個案進行噴砂作業時，需將擋板及零件沉積去除，其中靶材濺鍍又以 IT0 為主，且噴砂作業空間未完全密閉，工作中雖然有配戴拋棄式防塵口罩，但未著工作服。在噴砂作業時取放待噴砂物件時皆會暴露於粉塵環境，且個案提及其工作間隔壁為從事靶材研磨工作。

長庚安排 6 位勞工進行血中錮、胸部 X 光及肺功能等檢查後，發現個案 A、個案 B 的血中錮遠高於標準值 25 至 50 倍，且有肺功能降低及肺部纖維化情形發生，疾病診斷為錮中毒造成肺纖維化病變。其他 4 位個案因檢查結果皆無明顯異常，作為對照組資料以進行比較，另針對事業單位勞工進行衛教宣導，並建議定期回診追蹤健康狀況。(表 29)

表 29 長庚群聚調查個案疾病診斷結果

| 公司 | | 甲公司 | | | | | 乙公司 | 標準值 |
|----------------|---|-------|-------|-------|-------|-------|--------|-----|
| 姓名 | 個案 A | 個案 B | 個案 C | 個案 D | 個案 E | 個案 F | | |
| 年齡 | 37 | 39 | 46 | 54 | 44 | 52 | - | |
| 年資 | 17 | 10 | 9 | 11 | 8 | 14 | - | |
| 自覺症狀 | 喘、咳嗽 | 胸悶、胸痛 | 無 | 喘 | 喘 | 咳嗽 | - | |
| In(S), ug/L | (107-9-21): 149 (107-11-23): 129 (108-1-9): 113 (108-2-14): 113 (108-2-22): 123 | 79.6 | 1.1 | 1 | 1.7 | 0.7 | ≤ 3 | |
| 肺功能 | FVC | 70 % | 72 % | 108 % | 120 % | 90 % | 87 % | - |
| | FEV1 | 62 % | 62 % | 115 % | 126 % | 92 % | 96 % | - |
| | Ratio | 74 % | 71 % | 106 % | 87 % | 102 % | 89.8 % | - |
| | DlCo | 29 % | 67 % | - | 118 % | - | - | - |
| CT | 雙側瀰漫性肺氣腫 | 肺部纖維化 | - | - | - | - | - | |
| 診斷 | 錮中毒造成肺纖維化病變 | | 無明顯異常 | 無明顯異常 | 無明顯異常 | 無明顯異常 | - | |

建議：

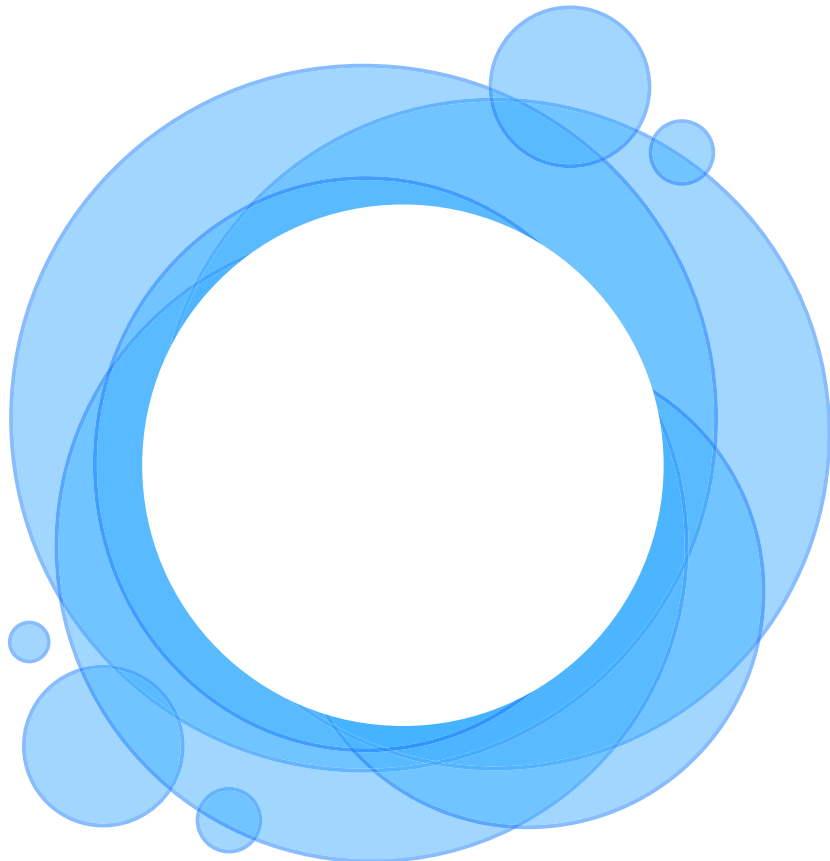
本群聚個案從事噴砂作業時需去除擋板及零件沉積，其中靶材濺鍍又以 IT0 為主，且噴砂作業空間未完全密閉，工作中僅配戴拋棄式防塵口罩 (3M 8812)，但未著工作服。依據「錮及其化合物之中毒職業病認定參考指引」，可知經由呼吸道接觸到各種含錮的化合物會造成肺部發炎及增生，且依據目前研究指出，暴露氧化錮錫 4 年後易發生肺纖維化疾病的情況。

依據勞動部勞動及職業安全衛生研究所研究日本病例及調查報告，推論我國可能有錮暴露的工作場所為氧化錮錫濺鍍靶製造廠、氧化錮錫回收廠和廢棄物回收廠 (CRT 和 TFT-LCD 螢幕含有氧化錮錫)，即使勞工暴露在極低濃度的 IT0 粉塵下，若未使用適當防護具或有良好的標



準工作流程，由於 IT0 粉塵溶解度不佳且可在肺部累積，容易導致作業人員血清中銻濃度無法下降，且隨工作年資增加，氧化壓力有增加趨勢。為有效防範勞工因暴露銻之作業引起職業性健康危害，提出 4 項改善建議：

- 1、執行現場督導與缺失改善，加強危害物物質教育訓練。
- 2、確實執行特別危害健康作業之特殊體格 / 健康檢查，並建立健康管理資料；將定期實施之特殊健康檢查，分級實施健康管理，作為選配工及健康管理。
- 3、有效隔離作業環境，建議以工程改善的方式，避免勞工直接暴露粉塵，作業場所並加裝局部排氣設備以降低相關作業勞工之暴露危害與健康風險。
- 4、提供防護效能足夠之呼吸防護具給勞工佩戴。上班穿著之工作服下班應立即沐浴換下；提供適當之防護具，並使勞工確實佩戴，以減少勞工有害物之暴露。



實驗室工作人員過敏疾病危害調查－職業傷病管理服務中心

群聚調查職業疾病類型：

過敏疾病危害

個案工作性質與背景介紹：

個本調查針對某研究單位 104-107 年實驗室人員健康檢查時的健康評估問卷、工作暴露評估問卷和健康檢查結果進行分析，相同實驗室人員不同年度的健康檢查結果視為不同樣本，問卷內容和健康檢查結果包含：基本資料（性別、年齡、單位、職稱、抽菸史）、過去病史（肺結核、過敏性鼻炎、過敏性皮膚炎、氣喘等）、健康調查（最近 6 個月內，鼻子過敏等耳鼻喉症狀、皮膚過敏或紅疹等皮膚症狀和會喘且呼吸咻咻聲等呼吸系統症狀）、職業暴露（最近 6 個月內，小鼠等實驗動物在內的生物性暴露、化學性暴露和物理性暴露）、健康檢查（身高與體重等理學檢查、IgE 等抽血檢查）、肺功能檢查（用力呼氣肺活量 (FVC) 與用力呼氣一秒量 (FEV1) 等肺功能檢查結果，計算 FEV1 對 FVC 比值，並參考 Min-Chien Wu 所提出的肺功能常模，計算預測 FVC 值 (predicted FVC value) 與預測 FEV1 值 (predicted FEV1 value) 等。

訪視目的：

在職業性過敏疾病中，實驗動物過敏 (Laboratory animal allergy, 簡稱 LAA) 為重要的議題之一，而所有實驗動物中，對大鼠 (Rat) 與小鼠 (Mice) 過敏是最常見的臨床問題，主要是因為這些動物被廣泛用於醫學研究中，過去有研究指出對大鼠過敏的盛行率約 12% 到 31%，而對小鼠過敏的盛行率約 10% 到 32%。

綜上可知，實驗動物過敏對於從事動物實驗的研究單位而言常見的職場危害，其中又以小鼠和大鼠過敏為最主要的過敏原，故進行本群聚調查研究，期望能提供研究單位的從業人員妥善使用工程控制與個人防護用具，有效降低職業暴露，進而預防實驗動物過敏的發生。

調查結果：

某研究單位的實驗室人員在 104-107 年，共有 2,564 人次接受年度健康檢查，扣除較不會親自從事動物實驗 141 人次後，共計有 2,423 人次接受年度健康檢查（表 30），平均年齡為 35.5 歲，47.3% 為女性，91.6% 的人未曾抽菸，0.4% 有確定或疑似肺結核病史、23.2% 有過敏性鼻炎病史、10.6% 有過敏性皮膚炎病史、4.6% 有氣喘病史，近 6 個月有 20.6% 鼻子過敏、17.1% 皮膚過敏或紅疹、1.2% 會喘且呼吸咻咻聲，IgE 有 36.7% 大於 100、26.9% 大於 150、14.9% 大於 300，肺功能 5.6% 預測 FEV1 值 <80%、1.8% 預測 FVC 值 <80%、20.1% FEV1 對 FVC 比值 <80%、2.8% 為阻塞性肺病。



其中，638 人次有從事小鼠實驗、1,772 人次未從事小鼠實驗，以 T 檢定或卡方檢定分析，從事小鼠實驗者較多為女性 (OR: 1.25, 1.04-1.51)、較多有過敏性鼻炎 (1.44, 1.16-1.78)、較多有過敏性皮膚炎 (1.50, 1.13-2.00)、較多有氣喘 (2.07, 1.37-3.12)、近 6 個月會喘且呼吸咻咻聲者較多 (3.48, 1.56-7.90)，其餘則無顯著差異，不過從事小鼠實驗者的 IgE 過高比例，少於未從事小鼠實驗者。

表 30 104-107 年接受健康檢查實驗室人員 (排除非親自從事動物實驗者) 基本資料與過去健康檢查結果

| 項目 | 小鼠實驗 (n=638) | 無小鼠實驗 (n=1,772) | 總計 (N=2,410) |
|------------------------|-----------------|--------------------|-----------------|
| 平均年齡 | 35.8±7.5 | 35.4±9.0 | 35.5±8.6 |
| 性別為女性 * | 328 (51.4) | 812 (45.8) | 1140 (47.3) |
| 平均身高 | 167.0±8.5 | 166.8±8.8 | 166.8±8.7 |
| 平均體重 | 66.6±14.0 | 65.6±14.4 | 65.9±14.3 |
| 未曾抽菸 | 578 (90.6) | 1629 (91.9) | 2207 (91.6) |
| 病史有確定或疑似肺結核 | 1 (0.2) | 9 (0.5) | 10 (0.4) |
| 病史有過敏性鼻炎 * | 179 (28.1) | 380 (21.4) | 559 (23.2) |
| 病史有過敏性皮膚炎 * | 87 (13.6) | 169 (9.5) | 256 (10.6) |
| 病史有氣喘 * | 46 (7.2) | 64 (3.6) | 110 (4.6) |
| 近 6 個月鼻子過敏 | 144 (22.6) | 352 (19.9) | 496 (20.6) |
| 近 6 個月皮膚過敏或紅疹 | 113 (17.7) | 298 (16.8) | 411 (17.1) |
| 近 6 個月會喘且呼吸咻咻聲 * | 16 (2.5) | 13 (0.7) | 29 (1.2) |
| IgE>100 | 223 (35.0) | 662 (37.4) | 885 (36.7) |
| IgE>150 | 162 (25.4) | 484 (27.3) | 649 (26.9) |
| IgE>300 | 84 (13.2) | 274 (15.5) | 358 (14.9) |
| 肺功能預測 FEV1 值 <80% | 32 (5.0) | 103 (5.8) | 135 (5.6) |
| 肺功能預測 FVC 值 <80% | 8 (1.3) | 36 (2.0) | 44 (1.8) |
| 肺功能 FEV1 對 FVC 比值 <80% | 135 (21.2) | 350 (19.8) | 485 (20.1) |
| 肺功能為阻塞性肺病 | 18 (2.8) | 50 (2.8) | 68 (2.8) |

註：表中所載為「平均值 ± 標準差」或「人數 (百分比)」，T 檢定或卡方檢定達統計顯著差異 (p 值 <0.05) 之變項以 * 標記。

管服中心依據 IgE 數值進行過敏性鼻炎與過敏性皮膚炎分層分析 (表 31)，可知在 IgE 大於 100、150 和 300 的情況下，從事小鼠實驗者，病史有過敏性鼻炎的勝算比為 1.94、2.29 和 3.50，病史有過敏性皮膚炎的勝算比則為 1.69、1.88 和 1.94，而近 6 個月鼻子過敏和皮膚過敏或紅疹的症狀雖未達統計顯著，但也有類似的趨勢。整體來說，隨著 IgE 數值升高，從事小鼠實驗者敏性鼻炎與過敏性皮膚炎病史與症狀的勝算比也隨之升高。

表 31 從事小鼠實驗者過敏性鼻炎與過敏性皮膚炎病史與症狀的勝算比

| 項目 | 小鼠實驗 (n=638) | 無小鼠實驗 (n=1,772) | 勝算比 | 95% 信賴區間 |
|---------------|-----------------|--------------------|------|-----------|
| 近 6 個月鼻子過敏 | 144 (22.6) | 352 (19.9) | 1.18 | 0.94-1.47 |
| IgE>100 | 69 (30.9) | 184 (27.8) | 1.16 | 0.82-1.64 |
| IgE>150 | 57 (34.5) | 140 (28.9) | 1.29 | 0.87-1.92 |
| IgE>300 | 31 (36.9) | 73 (26.6) | 1.61 | 0.92-2.78 |
| 病史有過敏性鼻炎 | 179 (28.5) | 380 (21.7) | 1.44 | 1.16-1.78 |
| IgE>100 | 103 (47.0) | 205 (31.3) | 1.94 | 1.40-2.69 |
| IgE>150 | 87 (53.0) | 158 (33.0) | 2.29 | 1.57-3.35 |
| IgE>300 | 51 (61.4) | 84 (31.2) | 3.50 | 2.04-6.06 |
| 近 6 個月皮膚過敏或紅疹 | 113 (17.7) | 298 (16.8) | 1.06 | 0.83-1.36 |
| IgE>100 | 55 (24.7) | 143 (21.6) | 1.19 | 0.81-1.72 |
| IgE>150 | 44 (26.7) | 111 (22.9) | 1.22 | 0.79-1.86 |
| IgE>300 | 29 (34.5) | 67 (24.5) | 1.63 | 0.92-2.84 |
| 病史有過敏性皮膚炎 | 87 (13.7) | 169 (9.6) | 1.50 | 1.13-2.00 |
| IgE>100 | 49 (22.2) | 95 (14.4) | 1.69 | 1.12-2.52 |
| IgE>150 | 42 (25.5) | 74 (15.4) | 1.88 | 1.19-2.94 |
| IgE>300 | 26 (31.0) | 51 (18.8) | 1.94 | 1.07-3.48 |



若進一步以從事小鼠實驗的頻率進行分層分析 (表 32) , 相較於未從事小鼠實驗者 , 常做 (Often) 小鼠實驗者與有做 (Ever) 小鼠實驗者過敏性鼻炎病史與症狀的勝算比皆較高 , 其中前者的勝算比又大致比後者高 , 可見劑量反應效應的關係 , 而前者過敏性鼻炎病史的勝算比也皆達統計上顯著性。另外 , 隨著 IgE 數值升高 , 過敏性鼻炎病史與症狀的勝算比大致上也隨之升高。

表 32 常做小鼠實驗與有做小鼠實驗者過敏性鼻炎病史與症狀勝算比

| 項目 | 常做小鼠實驗 (n=352) | 有做小鼠實驗 (n=286) | 無小鼠實驗 (n=1,772) |
|------------|-------------------------------|-------------------------------|--------------------|
| 近 6 個月鼻子過敏 | 82 (23.3) 1.22, 0.92-1.62 | 62 (21.7) 1.12, 0.81-1.52 | 352 (19.9) 1.0 |
| IgE>100 | 43 (32.6) 1.25, 0.82-1.90 | 26 (28.6) 1.04, 0.61-1.72 | 184 (27.8) 1.0 |
| IgE>150 | 37 (35.9) 1.38, 0.85-2.20 | 20 (32.3) 1.17, 0.63-2.12 | 140 (28.9) 1.0 |
| IgE>300 | 22 (36.1) 1.55, 0.82-2.89 | 9 (39.1) 1.77, 0.65-4.60 | 73 (26.6) 1.0 |
| 病史有過敏性鼻炎 | 110 (31.8) 1.62, 1.24-2.09 | 69 (24.5) 1.17, 0.86-1.58 | 380 (21.7) 1.0 |
| IgE>100 | 66 (50.8) 2.26, 1.51-3.37 | 37 (41.6) 1.56, 0.96-2.51 | 205 (31.3) 1.0 |
| IgE>150 | 57 (55.9) 2.57, 1.63-4.08 | 30 (48.4) 1.90, 1.07-3.36 | 158 (33.0) 1.0 |
| IgE>300 | 35 (58.3) 3.07, 1.67-5.73 | 16 (69.6) 5.00, 1.86-14.95 | 84 (31.2) 1.0 |

若進一步以從事小鼠實驗的頻率進行分層分析 (表 33) , 在過敏性皮膚炎病史的勝算比上 , 常做小鼠實驗者的勝算比大於有做小鼠實驗者又大於未做小鼠實驗者 , 有類似前述劑量反應效應的關係 , 而常做小鼠實驗者過敏性皮膚炎病史的勝算比也皆達統計上顯著性。另外 , 隨著 IgE 數值升高 , 過敏性鼻炎病史與症狀的勝算比大致上也隨之升高。

表 33 常做小鼠實驗與有做小鼠實驗者過敏性皮膚炎病史與症狀勝算比

| 項目 | 常做小鼠實驗 (n=352) | 有做小鼠實驗 (n=286) | 無小鼠實驗 (n=1,772) |
|-------------------|------------------------------|------------------------------|--------------------|
| 近 6 個月皮膚過敏 或紅疹 | 69 (24.4) 1.21, 0.89-1.62 | 44 (15.4) 0.90, 0.62-1.28 | 298 (16.8) 1.0 |
| IgE>100 | 36 (27.3) 1.36, 0.86-2.11 | 19 (20.9) 0.96, 0.53-1.6 | 143 (21.6) 1.0 |
| IgE>150 | 28 (27.2) 1.25, 0.74-2.07 | 16 (25.8) 1.17, 0.59-2.20 | 111 (22.9) 1.0 |
| IgE>300 | 21 (34.4) 1.62, 0.84-3.04 | 8 (34.8) 1.64, 0.58-4.35 | 67 (24.5) 1.0 |
| 病史有過敏性皮膚炎 | 48 (13.7) 1.50, 1.04-2.1 | 39 (13.7) 1.49, 1.00-2.19 | 169 (3.9) 1.0 |
| IgE>100 | 32 (24.2) 1.90, 1.16-3.04 | 17 (19.1) 1.40, 0.74-2.53 | 95 (14.4) 1.0 |
| IgE>150 | 27 (26.2) 1.96, 1.13-3.31 | 15 (24.2) 1.76, 0.87-3.40 | 74 (15.4) 1.0 |
| IgE>300 | 18 (29.5) 1.81, 0.91-3.52 | 8 (34.8) 2.30, 0.80-6.17 | 51 (18.8) 1.0 |

在剔除曾經抽菸與肺結核病史者後，依 IgE 數值進行氣喘的分層分析 (表 34)，可見在 IgE 大於 100、150 和 300 的情況下，從事小鼠實驗者，病史有氣喘的勝算比為 2.02、1.83 和 2.66，肺功能為阻塞性肺病的勝算比則為 2.14、2.37 和 2.08，雖未如過敏性鼻炎與過敏性皮膚炎，看到隨著 IgE 數值升高、勝算比也隨之升高的明顯趨勢，但 IgE 數值較高者的勝算比也確實較高，惟近 6 個月會喘且呼吸咻咻聲的症狀無此趨勢，但可能與分層分析後個案數量不足有關。



表 34 從事小鼠實驗者（排除抽菸與肺結核病史）氣喘病史、症狀與肺功能異常的勝算比

| 項目 | 有做小鼠實驗 (n=578) | 無小鼠實驗 (n=1,621) | 勝算比 | 95% 信賴區間 |
|----------------|-------------------|--------------------|------|------------|
| 近 6 個月會喘且呼吸咻咻聲 | 11 | 11 | 2.84 | 1.11-7.26 |
| IgE>100 | 4 | 9 | 1.40 | 0.31-5.10 |
| IgE>150 | 3 | 9 | 1.03 | 0.17-4.21 |
| IgE>300 | 2 | 4 | 1.68 | 0.15-12.01 |
| 病史有氣喘 | 37 | 61 | 1.75 | 1.12-2.72 |
| IgE>100 | 27 | 45 | 2.02 | 1.16-3.44 |
| IgE>150 | 22 | 40 | 1.83 | 0.99-3.28 |
| IgE>300 | 16 | 23 | 2.66 | 1.23-5.63 |
| 肺功能為阻塞性肺病 | 16 | 40 | 1.13 | 0.58-2.08 |
| IgE>100 | 8 | 12 | 2.14 | 0.75-5.78 |
| IgE>150 | 6 | 8 | 2.37 | 0.67-7.96 |
| IgE>300 | 3 | 5 | 2.08 | 0.31-10.76 |

考量肺功能為阻塞性肺病與近 6 個月會喘且呼吸咻咻聲的個案數相較不足，故僅針對病史有氣喘的個案，進一步以從事小鼠實驗的頻率進行分層分析（表 35），常做小鼠實驗者的勝算比大於有做小鼠實驗者又大於未做小鼠實驗者，有類似前述劑量反應效應的關係，而常做小鼠實驗者過敏性皮膚炎病史的勝算比也皆達統計上顯著性。另外，隨著 IgE 數值升高，過敏性鼻炎病史與症狀的勝算比大致上也隨之升高。

表 35 做小鼠實驗與有做小鼠實驗者氣喘病史與症狀勝算比

| 項目 | 常做小鼠實驗 (n=352) | 有做小鼠實驗 (n=286) | 無小鼠實驗 (n=1,772) |
|---------|------------------------------|-----------------------------|--------------------|
| 病史有氣喘 | 22 (6.9) 1.89, 1.09-3.17 | 15 (5.9) 1.59, 0.83-2.89 | 61 (3.8) 1.0 |
| IgE>100 | 19 (16.1) 2.43, 1.28-4.44 | 8 (10.3) 1.45, 0.57-3.27 | 45 (7.3) 1.0 |
| IgE>150 | 16 (17.2) 2.14, 1.06-4.14 | 6 (11.3) 1.31, 0.43-3.35 | 40 (8.8) 1.0 |
| IgE>300 | 12 (21.4) 2.76, 1.16-6.30 | 4 (19.0) 2.38, 0.54-8.20 | 23 (8.9) 1.0 |

最後，針對未曾抽菸、無肺結核病史、肺功能為阻塞性肺病、IgE 大於 150 的個案，追蹤其歷年健檢結果與就醫紀錄，其中有 4 名個案僅接受單次健檢、3 名個案為單次健檢異常、3 名個案為反覆健檢異常，針對 3 名反覆健檢異常的個案，整理其健檢結果與就醫紀錄（表 36）。

由表 36 可見，反覆健檢異常的個案未必都會接受門診追蹤，往往第二次健檢異常後才會接受門診追蹤，此與 4 名僅接受單次健檢異常個案都未接受門診追蹤的情況相仿，反覆健檢異常的個案 B 與個案 C 在門診追蹤後，確實都找到明確的過敏原，分別為小鼠過敏原與混合動物毛皮（個案 B）、屋塵蹣與粉塵蹣（個案 C），其中個案 B 也確實常做 (Often) 小鼠實驗工作，其 IgE 數值不僅最高，肺功能檢查的預測 FEV1 值、預測 FVC 值、FEV1 對 FVC 比值、預測 PEF 值也都較糟，顯示其氣喘情形確實因工作暴露而較差，不過值得注意的是，個案 B 近 6 個月都沒有會喘且呼吸咻咻聲的症狀，與前述分層分析的結果相仿，顯示此問題未必與氣喘相關。

表 36 健康檢查肺功能異常個案的基本資料及各項健康檢測結果

| | 個案 A | 個案 B | 個案 C |
|-------------------|---------|-----------|----------|
| 性別 | M | M | F |
| 年齡 | 33/34 | 35/36 | 27/28 |
| 健檢年度 | 105/106 | 106/107 | 106/107 |
| 小鼠實驗 | 有做 / 有做 | 常做 / 常做 | 未做 / 常做 |
| 病史有過敏性鼻炎 | X | X | X/V |
| 病史有過敏性皮膚炎 | V | X | X |
| 病史有氣喘 | V | V | V |
| 近 6 個月鼻子過敏 | X/X | V/V | X/X |
| 近 6 個月皮膚過敏或紅疹 | X/X | X/X | X/X |
| 近 6 個月會喘且呼吸咻咻聲 | X/X | X/X | X/X |
| 肺功能預測 FEV1 值 | 75%/79% | 72%/73% | 75%/69% |
| 肺功能預測 FVC 值 | 91%/95% | 101%/99% | 92%/97% |
| 肺功能 FEV1 對 FVC 比值 | 77%/78% | 65%/67% | 71%/66% |
| 肺功能預測 PEF 值 | 75%/79% | 72%/73% | 75%/69% |
| IgE | 197/230 | 1800/1860 | 633/516 |
| 門診追蹤 | X | 2018 | 2019 |
| 小鼠過敏原 | - | >100/6 級 | 0.00/0 級 |
| 混合動物毛皮 | - | 21.1/4 級 | 0.28/0 級 |
| 屋塵蹣 | - | 11.1/3 級 | >100/6 級 |
| 粉塵蹣 | - | 7.94/3 級 | 92.8/5 級 |
| 蝦 | - | 0.16/0 級 | 0.76/2 級 |



建議：

小鼠實驗為實驗室工作人員重要的過敏原，從事小鼠實驗者，其 IgE 過高比例並未較高，但病史有過敏性鼻炎、過敏性皮膚炎和氣喘的勝算比都顯著較高，且隨著 IgE 數值和小鼠實驗的從事頻率升高，勝算比也隨之升高；另外，從事小鼠實驗者，其近 6 個月鼻子過敏、近 6 個月皮膚過敏或紅疹和肺功能為阻塞性肺病的勝算比也偏高，且有類似前述劑量反應效應的關係。

然而，異常個案的追蹤情形顯示，IgE 過高且肺功能為阻塞性肺病者，目前並不會在第一次健檢異常就安排門診追蹤，而反覆健檢異常者若接受門診追蹤，確實都能有效找出過敏原，其中職業暴露小鼠導致過敏的個案，其過敏情形與肺功能數值都較糟，顯示此類個案確實需要盡早安排門診追蹤並提早介入，而小鼠過敏的職業健康問題也需要更多重視，提出 4 項防治建議如下：

- 1、**工程控制**：分層分析顯示過敏疾病危害的勝算比，與小鼠實驗工作的頻率有關，顯示過敏原的暴露量與風險有關，建議應安排工作現場訪視測定環境中過敏原的暴露量，並以工程控制方式降低暴露風險。
- 2、**行政管理**：考量小鼠實驗為實驗室工作人員重要的過敏原，建議相關人員在從事小鼠實驗前，於體格檢查中詢問過去病史並加驗 IgE，若有過敏疾病病史或 IgE 過高者，應安排過敏原檢測確認是否對小鼠過敏，而從事小鼠實驗的工作人員，在年度健康檢查若發現 IgE 過高，且合併過敏疾病症狀，應納入個案管理並安排門診追蹤。
- 3、**個人防護用具**：針對嚴重過敏個案，若無法移離目前工作，除應以工程控制方式降低暴露風險外，亦應穿戴個人防護用具。
- 4、**緊急應變**：從事小鼠實驗的工作單位，應擬定緊急應變計畫處理過敏性休克的緊急情況，作業人員應接受相關的安全衛生教育訓練。

一氧化碳中毒群聚調查－北榮防治中心

群聚調查職業疾病類型：

一氧化碳中毒症候群

個案工作性質與背景介紹：

個案為 55 歲女性職員，自 92 年起於某集團中央廚房擔任鍋爐室作業員，工作內容主要係調配集團旗下全臺各餐廳所需的蔬果、醬料等。個案過去無吸菸史及任何系統性疾病，每日上班時間為 07:00-16:00，中午休息 1 小時，平時休假採月排休方式。

訪視目的：

釐清個案罹患的神經學症候群是否與其工作有關，並了解一氧化碳危害，以提供事業單位環境改善及疾病預防建議。

調查結果：

本調查個案工作內容係於鍋爐室中看顧烹煮醬料流程，事發當日一早進入作業場所後不久，便開始感到悶熱、頭暈，後續因全因無力且暈眩故被同事扶出作業場所，當下雖意識清醒但難以說話及移動肢體，休息一個多小時後雖小有改善，但仍感到頭暈和頭痛，後續同一作業場所也有多位同仁發生頭暈不適等類似症狀，單位主管遂建議所有作業人員前往醫院就醫。

有關一氧化碳中毒症係因血液中一氧化碳血紅素 (COHb) 濃度過高導致 (相關濃度對應症狀可參考下表)，經檢測同一作業場所之員工，可發現 COHb 濃度皆大於 5% (6.3%-17.2%)，始確定係一氧化碳群聚中毒事件。(表 38)

表 37 一氧化碳中毒之 COHb 濃度與臨床症狀對照表

| COHb 濃度 (%) | 臨床症狀 |
|-------------|---------------------------------|
| 0-5 | 無症狀 |
| 5-10 | 無症狀；少數人可能會有輕微頭痛、運動不耐；冠心病者可能有心絞痛 |
| 10-20 | 輕微運動性氣促、頭痛 |
| 20-30 | 抽動式頭痛、噁心 |
| 30-40 | 劇烈頭痛、頭昏、噁心、嘔吐、判斷力降低、動作笨拙 |
| 40-50 | 意識混亂、昏厥 |
| 50-60 | 昏迷、抽搐 |
| 60-70 | 昏迷、抽搐、心肺功能喪失、死亡 |

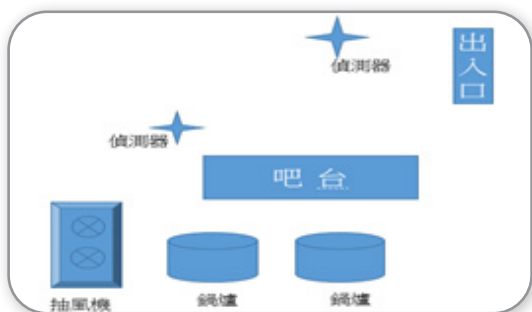


表 38 北榮群聚調查個案症狀及血紅素濃度檢測結果

| 個案 | 性別 | 年齡 | 就醫症狀 | CO 血紅素濃度 (檢查時間) | 年資 |
|----|----|----|----------------|----------------------------|----------|
| A | 男 | 25 | 頭暈 | 7.8%(17:48) | 1 年 |
| B | 女 | 53 | 暈眩、頭暈、噁心想吐 | 17.2%(11:08) | 13 年 |
| C | 女 | 29 | 暈眩、頭暈、噁心想吐 | 7.6%(14:38) | - |
| D | 女 | 44 | 頭暈想吐 | 13.5%(14:11) 、 2.2%(17:18) | - |
| E | 男 | 38 | 頭暈 | 13.4%(14:27) 、 3.3%(17:09) | - |
| F | 男 | 48 | 頭暈、臉麻 | 15.0%(14:20) 、 4.0%(17:18) | 4 年 |
| G | 女 | 33 | 頭脹 | 6.3%(15:10) 、 2.1%(17:09) | 9 年 3 個月 |
| H | 女 | 55 | 頭暈、頭痛、無力、暈倒、失語 | 8.3%(15:03) | 16 年 |



北榮職業醫學團隊至工作場所向主管及罹災勞工進行一氧化碳中毒宣導。



鍋爐室示意圖



抽風機 (抽風設備)

現場作業環境訪視。一氧化碳濃度介於 5-8 ppm (容許濃度 \leq 35 ppm)



偵測器之 APP



一氧化碳偵測器

改善方式：加裝一氧化碳偵測器。偵測到異常數值便會通知保全公司與各管理者。

圖 75 北榮群聚調查工作現場訪視圖

建議：

針對廚房勞工，提出 3 項預防及改善建議：

由於一氧化碳為無色無味之氣體，很容易讓人忽略其存在及毒性，當密閉空間一氧化碳濃度過高時容易發生一氧化碳中毒。由於本調查工作場所鍋爐室屬於封閉空間，且事件發生當日抽風機故障，導致沒有足夠的通風換氣，才造成員工發生頭暈、全身無力等症狀。綜合上述分析，分別針對人員及環境提供 3 項建議：

- 1、可針對鍋爐作業環境可能遭遇之危害加強員工教育訓練（如熱危害、一氧化碳中毒、爆炸等），建立正確的健康危害知能。
- 2、建立一套鍋爐標準作業流程，以應變緊急危害措施。
- 3、針對環境部分可加強通風改善，並於入口張貼危害告示，另可加裝監測警報器等。



石作業勞工健康狀況及工作環境危害因子調查－慈濟防治中心

群聚調查職業疾病類型：

職業性聽力損失、職業性肌肉骨骼疾病、職業性肺病

個案工作性質與背景介紹：

石作業勞工。

訪視目的：

為了解花蓮地區石作業勞工的健康狀況、工作環境危害因子以及職業因素造成聽力損失情形及對肺功能的影響，慈濟進行石作業勞工的健康狀況及職業暴露問卷、肌肉骨骼症狀調查、聽力篩檢、肺功能篩檢、手腕理學檢查、腰椎理學檢查、探討防音防護具、呼吸防護具、眼睛防護具的使用情形等調查，以俾未來慈濟調整並推廣職業傷病衛教宣導的內容，也期望藉由篩檢活動提供篩檢勞工預防職業傷病衛教、職業傷病諮詢服務，以提高花蓮地區勞工對於職業衛生危害認知以及危害預防的觀念。

調查結果：

本次群聚事件共調查 48 人，排除資料不全及行業別不符者，有效問卷共 42 人。本次調查主要為男性 (73.8%)，主要工作內容為操作機台、搬石材，女性 (26.2%) 主要工作內容為廠務，綜觀工作性質，故男性比率較高。

石作業勞工族群主要為外籍人士 (40.5%)、閩南人 (40.5%) 居多；年齡計算方式以個案出示健保卡上的出生日期，計算至健康篩檢當日的歲數為準，年齡分布結果顯示主要為 31-50 歲 (54.8%)、其次為小於 30 歲 (28.6%)；工作年資以個案陳述資料進行分析，結果顯示小於 5 年 (50%) 居多、其次為 6-20 年者 (35.7%)。本次調查結果發現，參與篩檢的石作業勞工，多數為外籍人士、閩南人，年齡以中年者居多、工作年資較低。篩檢過程中，外籍員工自述為了照顧長輩、老婆、小孩，趁年輕離鄉至台灣工作，賺取較高的薪資；但也因外籍員工輪替率高，簽證到期可能就必須返國或更換工作、語言不通等因素，故本次調查結果的平均工作年資也較低。(表 39)

肌肉骨骼症狀調查結果，有身體不適 7 個月至 1 年者占 14.3 居多，主要酸痛部位有下背 (34.2%)、其次為右肩 (18.4%)、左肩 (18.4%)。石作業主要工作性質為經常腰部負重從事搬抬工作、重複性雙手施力從事搬抬工作造成下背及肩頸痠痛等症狀；若工作年資達 8-10 年，男性每日搬抬重量至少 2 噸、女性則至少 1.5 噸。(表 40)

勞工噪音作業經歷調查結果顯示，自覺工作屬噪音環境者 (83.3%) 居多，但調查工作中是否配戴聽力保護具的結果顯示有配戴聽力保護具者僅占 28.6%。粉塵作業經歷調查結果可知，自覺工作屬粉塵環境者達 71.4%，有配戴呼吸防護具者占 66.7%、有配戴眼睛防護具者占 28.6%；調查結果顯示勞工進行呼吸防護的比例高於眼睛防護，進行防音防護的勞工比例為最低。

初步排除可能影響檢查結果的因素後，勞工肺功能檢查結果顯示仍為異常者有 1 人；勞工年齡層較低、工作年資少、作業方式為濕式作業、配戴呼吸防護具的比例高，皆可能為造成異常比例較低的原因。(表 41、表 42)

依勞工健康保護規則進行聽力健康風險管理分級，勞工聽力檢查結果顯示第三級管理者有 13 人 (31%)、第四級管理者有 6 人 (14.3%)。調查結果發現工作環境曾作過粉塵環境監測者 1 人、噪音環境監測者 2 人，但受訪個案皆表示不清楚過去的監測結果。因本次參與篩檢的事業單位皆為 20 人以下，多數為自營業者，對相關法令不甚了解，故事業單位執行環境監測的比例較低。

篩檢過程中，曾有石作業勞工自述工作使用的工具，常發出巨大噪音，例如：水磨機、磨台等，依據過去流行病學已知的證據，長期暴露於高噪音環境中，勞工最易於 3000~6000Hz 發生聽力損失，且伴隨 4000Hz 或 6000Hz 處有明顯聽力損失大於 40 分貝。由表 7 可看出，本調查之勞工左耳低音頻三分法為 18 分貝、右耳低音頻三分法為 18 分貝，且於雙耳 6000Hz 之平均數有明顯高於其他頻率。進一步比較各年齡層之右耳聽力檢查數值，除小於 30 歲之勞工外，其他年齡層勞工於 4000Hz、6000Hz 僅皆有明顯凹陷；比較各年齡層之左耳聽力檢查數值，31-50 歲勞工、65 歲以上勞工皆於 4000Hz、6000Hz 僅有明顯凹陷 (表 43、表 44、表 45)



表 39 慈濟群聚調查個案基本資料

| 變項 | N=42(%) | 平均數 ± 標準差 |
|--------------|-----------|-------------|
| 性別 | | |
| 男 | 31(73.8%) | |
| 女 | 11(26.2%) | |
| 年齡 | | |
| 小於 30 歲 | 12(28.6%) | 38.6 ± 11.2 |
| 31-50 歲 | 23(54.8%) | |
| 50-65 歲 | 5(11.9%) | |
| 65 歲以上 | 2(4.8%) | |
| BMI | | 24.4 ± 3.9 |
| 石作業年資 | | 8.9 ± 11.5 |
| 教育程度 | | |
| 小學畢業 | 1(2.4%) | |
| 國中畢業 | 1(2.4%) | |
| 高中 / 職畢業 | 22(52.4%) | |
| 大學 (專) 以上 | 17(40.5%) | |
| 資料不全 | 1(2.4%) | |
| 婚姻狀況 | | |
| 未婚 | 12(28.6%) | |
| 已婚 | 27(64.3%) | |
| 離婚 | 2(4.8%) | |
| 資料不全 | 1(2.4%) | |
| 族群 | | |
| 閩南 | 17(40.5%) | |
| 客家 | 3(7.1%) | |
| 外省 | 2(4.8%) | |
| 原住民 | 3(7.1%) | |
| 其他 | 17(40.5%) | |

| 變項 | N=42(%) | 平均數 ± 標準差 |
|-------------|-----------|-----------|
| 原住民 | 3 | |
| 太魯閣 | 1 | |
| 阿美族 | 2 | |
| 其他 | 17 | |
| 泰國 | 2 | |
| 烏克蘭 | 1 | |
| 菲律賓 | 7 | |
| 越南 | 7 | |
| 抽菸習慣 | | |
| 從未抽菸 | 23(54.8%) | |
| 每天吸 | 13(31.0%) | |
| 已戒菸 | 6(14.3%) | |
| 嚼食檳榔 | | |
| 從未嚼檳榔 | 37(88.1%) | |
| 偶爾嚼 | 2(4.8%) | |
| 每天嚼 | 3(7.1%) | |
| 飲酒習慣 | | |
| 從未飲酒 | 20(47.6%) | |
| 偶爾喝 | 16(38.1%) | |
| 每天喝 | 4(9.5%) | |
| 已戒酒 | 2(4.8%) | |

表 40 慈濟群聚調查個案肌肉骨骼症狀發生情形

| 變項 | N=55(%) | 不痛 N(%) | 有疼痛 N(%) | | 症狀程度調查 | | | | | | | | | | |
|----------------------|-----------|---------|----------|----|--------|--------|------|--------|--------|----|-------|----|-------|---|------|
| | | | | | 可以忽略 | 可能影響工作 | 影響工作 | 影響活動能力 | 完全無法活動 | | | | | | |
| | | | | | N(%) | N(%) | N(%) | N(%) | N(%) | | | | | | |
| 身體不適持續時間 N(%) | | | | | | | | | | | | | | | |
| 無 | 24(57.1%) | | | | | | | | | | | | | | |
| 1-6 個月 | 4(9.5%) | | | | | | | | | | | | | | |
| 7 個月 -1 年 | 6(14.3%) | | | | | | | | | | | | | | |
| 1-2 年 | 5(11.9%) | | | | | | | | | | | | | | |
| 3 年以上 | 3(7.1%) | | | | | | | | | | | | | | |
| 身體部位調查 | | | | | | | | | | | | | | | |
| 頸 | 42(100%) | 410 | 6.8% | 2 | 5.3% | 0 | 0% | 1 | 6.3% | 0 | 0.0% | 1 | 9.1% | 0 | 0.0% |
| 上背 | 42(100%) | 41 | 6.9% | 1 | 2.6% | 0 | 0% | 1 | 6.3% | 0 | 0.0% | 0 | 0.0% | 0 | 0.0% |
| 左肩 | 42(100%) | 35 | 5.9% | 7 | 18.4% | 0 | 0% | 4 | 25.0% | 2 | 20.0% | 1 | 9.1% | 0 | 0.0% |
| 左手肘 / 左前 | 42(100%) | 40 | 6.8% | 2 | 5.3% | 0 | 0% | 1 | 6.3% | 1 | 10.0% | 0 | 0.0% | 0 | 0.0% |
| 左手 / 左手腕 | 42(100%) | 41 | 6.9% | 1 | 2.6% | 0 | 0% | 0 | 0.0% | 1 | 10.0% | 0 | 0.0% | 0 | 0.0% |
| 左臀 / 左大腿 | 42(100%) | 42 | 7.1% | 0 | 0.0% | 0 | 0% | 0 | 0.0% | 0 | 0.0% | 0 | 0.0% | 0 | 0.0% |
| 左膝 | 42(100%) | 41 | 6.9% | 1 | 2.6% | 0 | 0% | 0 | 0.0% | 0 | 0.0% | 1 | 9.1% | 0 | 0.0% |
| 左腳踝 / 左腳 | 42(100%) | 42 | 7.1% | 0 | 0.0% | 0 | 0% | 0 | 0.0% | 0 | 0.0% | 0 | 0.0% | 0 | 0.0% |
| 右肩 | 42(100%) | 34 | 5.8% | 7 | 18.4% | 0 | 0% | 4 | 25.0% | 1 | 10.0% | 3 | 27.3% | 0 | 0.0% |
| 右手肘 / 右前 | 42(100%) | 41 | 6.9% | 1 | 2.6% | 0 | 0% | 1 | 6.3% | 0 | 0.0% | 0 | 0.0% | 0 | 0.0% |
| 下背 | 42(100%) | 29 | 4.9% | 13 | 34.2% | 0 | 0% | 4 | 25.0% | 5 | 50.0% | 3 | 27.3% | 1 | 100% |
| 右手 / 右手腕 | 42(100%) | 41 | 6.9% | 1 | 2.6% | 0 | 0% | 0 | 0.0% | 0 | 0.0% | 1 | 9.1% | 0 | 0.0% |
| 右臀 / 右大腿 | 42(100%) | 42 | 7.1% | 0 | 0.0% | 0 | 0% | 0 | 0.0% | 0 | 0.0% | 0 | 0.0% | 0 | 0.0% |
| 右膝 | 42(100%) | 40 | 6.8% | 2 | 5.3% | 1 | 100% | 0 | 0.0% | 0 | 0.0% | 1 | 9.1% | 0 | 0.0% |
| 右腳踝 / 右腳 | 42(100%) | 42 | 7.1% | 0 | 0.0% | 0 | 0.0% | 0 | 0.0% | 0 | 0.0% | 0 | 0.0% | 0 | 0.0% |
| 小計 | | 591 | 100% | 38 | 100% | 1 | 100% | 16 | 100% | 10 | 100% | 11 | 100% | 1 | 100% |

註：本表身體部位調查表之百分比為各症狀程度之比率



表 41 慈濟群聚調查個案自覺症狀調查結果

| 變項 | N=42(%) |
|---------------|-----------|
| 聽力困難現象 | |
| 無 | 35(83.3%) |
| 有 | 7(16.7%) |
| 耳鳴 | |
| 無 | 33(78.6%) |
| 有 | 9(21.4%) |
| 暈眩 | |
| 無 | 38(90.5%) |
| 有 | 4(9.5%) |
| 聽力改變 | |
| 沒改變 | 37(88.1%) |
| 更差 | 5(11.9%) |
| 肺功能改變 | |
| 沒改變 | 39(92.9%) |
| 更差 | 3(7.1%) |
| 心臟血管不適 | |
| 無 | 33(78.6%) |
| 有 | 9(21.4%) |
| 呼吸系統不適 | |
| 無 | 40(95.2%) |
| 有 | 2(4.8%) |

表 42 慈濟群聚調查個案噪音作業經歷調查結果

| 變項 | N=42(%) |
|----------------------|-----------|
| 曾暴露於巨大聲音 | |
| 無 | 38(90.5%) |
| 有 | 4(9.5%) |
| 曾暴露於爆炸狀況 | |
| 無 | 42(100%) |
| 有 | 0(0%) |
| 經常暴露於槍聲 | |
| 無 | 40(95.2%) |
| 有 | 2(4.8%) |
| 工作屬噪音環境 | |
| 否 | 7(16.7%) |
| 是 | 35(83.3%) |
| 工作時噪音存在時間 | |
| 無 | 6(14.3%) |
| 偶爾 | 16(38.1%) |
| 一半時間 | 5(11.9%) |
| 所有工作時間 | 15(35.7%) |
| 聽力保護措施 | |
| 無配戴 | 30(71.4%) |
| 有配戴 | 12(28.6%) |
| 聽力保護設備類型 (人次) | |
| 無 | 30 |
| 耳塞 | 12 |
| 聽力保護具配戴時間 | |
| 都不戴 | 32(76.2%) |
| 偶爾戴 | 3(2.4%) |
| 一半時間配戴 | 2(4.8%) |
| 全時間配戴 | 6(14.3%) |
| 資料不全 | 1(2.4%) |

| 配戴聽力保護具原因 (人次) | |
|----------------|-----------|
| 環境很吵 | 8 |
| 擔心聽力受損 | 8 |
| 公司規定 | 6 |
| 同事建議 | 1 |
| 是否曾做過聽力檢查 | |
| 無 | 35(83.3%) |
| 有 | 7(16.7%) |
| 是否曾做過噪音環境監測 | |
| 無 | 40(95.2%) |
| 有 | 2(4.8%) |
| 常使用的工具 (人次) | |
| 堆高機 | 5 |
| 天車 | 4 |
| 電動手剪 | 4 |
| 鐵鎚 | 4 |
| 水磨機 | 3 |
| 砂輪機 | 3 |
| 磨台 | 3 |
| 水沖機 | 2 |
| 橋剪機 | 2 |
| 電鋸 | 2 |
| 線鋸機 | 1 |

表 43 慈濟群聚調查個案粉塵作業經歷調查結果

| 變項 | N=42 (%) |
|----------------|-----------|
| 工作屬粉塵環境 | |
| 否 | 12(28.6%) |
| 是 | 30(71.4%) |
| 呼吸防護措施 | |
| 無配戴 | 14(33.3%) |
| 有配戴 | 28(66.7%) |
| 呼吸防護類型 | |
| 無 | 14 |
| 一般外科口罩 | 26 |
| 棉布口罩 | 1 |
| 活性炭口罩 | 2 |
| 配戴呼吸防護具原因 (人次) | |
| 吸入不舒服 | 20 |
| 擔心肺功能受損 | 10 |
| 公司規定 | 13 |
| 眼睛防護措施 | |
| 無配戴 | 30(71.4%) |
| 有配戴 | 12(28.6%) |
| 眼睛防護類型 | |
| 無 | 30 |
| 護目鏡 | 12 |
| 面罩 | 1 |
| 其他 | 1 |
| 配戴眼睛防護具原因 (人次) | |
| 眼睛不舒服 | 10 |
| 擔心眼睛受損 | 8 |
| 公司規定 | 6 |



表 44 慈濟群聚調查個案聽力及肺功能檢查結果

| 是否曾做過肺功能檢查 | |
|-------------|-----------|
| 無 | 27(64.3%) |
| 有 | 15(35.7%) |
| 作業方式 | |
| 濕式 | 40(95.3%) |
| 不知道 | 2(4.8%) |
| 是否曾做過粉塵環境監測 | |
| 無 | 41(97.6%) |
| 有 | 1(2.4%) |
| 常使用的材料 (人次) | |
| 花崗岩 | 39 |
| 大理石 | 29 |
| 玉石 | 15 |
| 人造石材 | 9 |
| 其他 | 2 |

| 變項 | N=42(%) |
|--------------------|-----------|
| 聽力檢查結果 (人數) | |
| 正常 | 18(42.9%) |
| 異常 (二級以上) | 24(57.1%) |
| 聽力健康風險管理 (人數) | |
| 第一級管理 | 18(42.9%) |
| 第二級管理 | 5(11.9%) |
| 第三級管理 | 13(31%) |
| 第四級管理 | 6(14.3%) |
| 肺功能檢查結果 (人數) | |
| 正常 | 36(85.7%) |
| 異常 | 6(14.3%) |
| 肺功能異常伴隨其他症狀 (人數) 6 | |
| 每天吸菸 10 年以上 | 3 |
| 每天吸菸 10 年以下 | 1 |
| 抽 10 年，已戒菸 2 年 | 1 |
| 以上皆無 | 1 |
| SLRT 陽性 | |
| 右側 | 2(4.8%) |
| 左側 | 4(9.5%) |
| reverse SLRT 陽性 | |
| 右側 | 2(4.8%) |
| 左側 | 1(2.4%) |
| Tinel's Test 陽性 | |
| 右側 | 1(2.4%) |
| 左側 | 2(4.8%) |
| Phalen's Test 陽性 | |
| 右側 | 1(2.4%) |
| 左側 | 2(4.8%) |

- * 本表之聽力異常包含：噪音外原因造成異常、疑似噪音聽力損失、噪音性聽力損失
- * 聽力健康風險管理三級以上排除，耳朵受傷、耳朵手術、使用耳毒性藥物、家族遺傳疾病

表 45 慈濟群聚調查個案聽力篩檢數值分布情形

| 變項 | 左耳 | 右耳 |
|--------|---------------|---------------|
| | 平均數 ± 標準差 | |
| 250 | 19.76 ± 6.61 | 18.9 ± 7.12 |
| 500 | 20.24 ± 7.07 | 21.1 ± 7.37 |
| 1000 | 19.51 ± 7.65 | 19.51 ± 8.93 |
| 2000 | 16.83 ± 13.64 | 14.51 ± 11.28 |
| 3000 | 23.17 ± 17.28 | 18.05 ± 11.77 |
| 4000 | 29.02 ± 20.22 | 22.2 ± 15.09 |
| 6000 | 30.61 ± 20.29 | 29.76 ± 19.33 |
| 8000 | 22.2 ± 25.93 | 21.1 ± 22.54 |
| 低音頻三分法 | 18.85 ± 8.23 | 18.34 ± 8.32 |
| 高音頻三分法 | 27.51 ± 17.62 | 23.44 ± 13.88 |

* 低音頻三分法計算方式為，(500Hz+1000Hz+2000Hz)/3

* 高音頻三分法計算方式為，(3000Hz+4000Hz+6000Hz)/3

* 共 41 人，排除一位個案右耳 6K8K 資料不全

建議：

石作業工作經常需要腰部負重從事搬抬工作、重複性雙手施力從事搬抬工作，長時間暴露下有累積性肌肉骨骼傷病發生的風險。工作時亦需操作水磨機、砂輪機、磨台等設備工具，機具發出的噪音極大，作業環境現場經常有粉塵飄散，作業環境暴露於高噪音及粉塵危害之下。綜合以上，石作業為職業性肌肉骨骼疾病、噪音性聽力損失及暴露於粉塵危害的高危險群。

本調查結果顯示，石作業勞工有下背酸痛、雙肩酸痛、部分手腕理學檢查結果異常、部分腰椎理學檢查結果異常、噪音性聽力損失、肺功能異常的情形。綜合以上，裝潢木工業為職業性肌肉骨骼疾病、噪音性聽力損失及暴露於粉塵危害的高危險群。本調查針對裝潢業木工，提出 2 項建議：

- 1、有一定比例的勞工會配戴呼吸防護具、眼睛防護具，未來希望政府機關能多加宣導防護具的正確配戴時機、密合度測試資訊等，使相關從業人員可以落實工作中的防護措施，持續提高勞工作業時配戴呼吸防護具、眼睛防護具的比例。



2、本調查結果發現勞工落實呼吸防護的比例高於眼睛防護，進行噪音防護的比例為最低。初步推測原因為呼吸防護具（如一般外科口罩）為常用的生活用品，一般民眾習慣配戴，故接受度較高；而眼睛防護具可以明顯降低眼睛不適感，勞工在作業時能有立即性感受，在使用上的警覺性也較高。但聽力保護具極易造成勞工於工作中與同事溝通阻礙，且多數勞工已習慣暴露於噪音環境中，故配戴比例跟意願也較低。期望事業單位辦理員工教育訓練時能增強勞工主動進行聽力保護的觀念，慈濟也將持續製作簡易式聽力損失認知危害的宣導海報、衛教單張等，加強勞工的危害認知及危害預防觀念。

根據流行病學已知的證據以及職業醫學科門診看診統計，每年製造業勞工發生被捲、被夾、切割傷等職業傷害的比例較其他行業別勞工高，故篩檢完畢後，慈濟發放職業傷病預防宣導摺頁、職業醫學科就診資訊、勞保職災權益等衛教單張，鼓勵篩檢勞工若不慎遭遇職業傷害，可由慈濟協助進行申請勞保職災給付。



108年 職業傷病防治年報





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