

**U.S. Department of Labor**  
Occupational Safety and Health Administration  
1387 S. Vinnell Way  
Suite 218  
Boise, ID 83709  
Phone: 208-321-2960 Fax: 208-321-2966



## Citation and Notification of Penalty

**To:**  
Dickinson Frozen Foods, Inc.  
and its successors  
903 E. 3000 North  
Sugar City, ID 83448

**Inspection Number:** 1117009  
**Inspection Date(s):** 01/05/2016 - 01/06/2016  
**Issuance Date:** 05/25/2016

**Inspection Site:**  
903 E. 3000 North  
Sugar City, ID 83448

*The violation(s) described in this Citation and Notification of Penalty is (are) alleged to have occurred on or about the day(s) the inspection was made unless otherwise indicated within the description given below.*

This Citation and Notification of Penalty (this Citation) describes violations of the Occupational Safety and Health Act of 1970. The penalty(ies) listed herein is (are) based on these violations. You must abate the violations referred to in this Citation by the dates listed and pay the penalties proposed, unless within 15 working days (excluding weekends and Federal holidays) from your receipt of this Citation and Notification of Penalty **you either call to schedule an informal conference (see paragraph below) or** you mail a notice of contest to the U.S. Department of Labor Area Office at the address shown above. Please refer to the enclosed booklet (OSHA 3000) which outlines your rights and responsibilities and which should be read in conjunction with this form. Issuance of this Citation does not constitute a finding that a violation of the Act has occurred unless there is a failure to contest as provided for in the Act or, if contested, unless this Citation is affirmed by the Review Commission or a court.

**Posting** - The law requires that a copy of this Citation and Notification of Penalty be posted immediately in a prominent place at or near the location of the violation(s) cited herein, or, if it is not practicable because of the nature of the employer's operations, where it will be readily observable by all affected employees. This Citation must remain posted until the violation(s) cited herein has (have) been abated, or for 3 working days (excluding weekends and Federal holidays), whichever is longer.

**Informal Conference** - An informal conference is not required. However, if you wish to have such a conference you may request one with the Area Director during the 15 working day contest period. During such an informal conference you may present any evidence or views which you believe would support an adjustment to the citation(s) and/or penalty(ies).

If you are considering a request for an informal conference to discuss any issues related to this Citation and Notification of Penalty, you must take care to schedule it early enough to allow time to contest after the informal conference, should you decide to do so. Please keep in mind that a written letter of intent to contest must be submitted to the Area Director within 15 working days of your receipt of this Citation. The running of this contest period is not interrupted by an informal conference.

If you decide to request an informal conference, please complete, remove and post the Notice to Employees next to this Citation and Notification of Penalty as soon as the time, date, and place of the informal conference have been determined. Be sure to bring to the conference any and all supporting documentation of existing conditions as well as any abatement steps taken thus far. If conditions warrant, we can enter into an informal settlement agreement which amicably resolves this matter without litigation or contest.

**Right to Contest** – You have the right to contest this Citation and Notification of Penalty. You may contest all citation items or only individual items. You may also contest proposed penalties and/or abatement dates without contesting the underlying violations. Unless you inform the Area Director in writing that you intend to contest the citation(s) and/or proposed penalty(ies) within 15 working days after receipt, the citation(s) and the proposed penalty(ies) will become a final order of the Occupational Safety and Health Review Commission and may not be reviewed by any court or agency.

**Penalty Payment** – Penalties are due within 15 working days of receipt of this notification unless contested. (See the enclosed booklet and the additional information provided related to the Debt Collection Act of 1982.) Make your check or money order payable to “DOL-OSHA”. Please indicate the Inspection Number on the remittance. You can also make your payment electronically on [www.pay.gov](http://www.pay.gov). On the left side of the pay.gov homepage, you will see an option to Search Public Forms. Type "OSHA" and click Go. From the results, click on OSHA Penalty Payment Form. The direct link is:

<https://www.pay.gov/paygov/forms/formInstance.html?agencyFormId=53090334>.

You will be required to enter your inspection number when making the payment. Payments can be made by credit card or Automated Clearing House (ACH) using your banking information. Payments of \$25,000 or more require a Transaction ID, and also must be paid using ACH. If you require a Transaction ID, please contact the OSHA Debt Collection Team at (202) 693-2170.

OSHA does not agree to any restrictions or conditions or endorsements put on any check, money order, or electronic payment for less than the full amount due, and will process the payments as if these restrictions or conditions do not exist.

**Notification of Corrective Action** – For each violation which you do not contest, you must provide *abatement certification* to the Area Director of the OSHA office issuing the citation and identified above. This abatement certification is to be provided by letter within 10 calendar days after each abatement date. Abatement certification includes the date and method of abatement. If the citation indicates that the violation was corrected during the inspection, no abatement certification is required for that item. The abatement certification letter must be posted at the location where the violation appeared and the corrective action took place or employees must otherwise be effectively informed about abatement activities. A sample abatement certification letter is enclosed with this Citation. In addition, where the citation indicates that *abatement documentation* is necessary, evidence of the purchase or repair of equipment, photographs or video, receipts, training records, etc., verifying that abatement has occurred is required to be provided to the Area Director.

**Employer Discrimination Unlawful** – The law prohibits discrimination by an employer against an

employee for filing a complaint or for exercising any rights under this Act. An employee who believes that he/she has been discriminated against may file a complaint no later than 30 days after the discrimination occurred with the U.S. Department of Labor Area Office at the address shown above.

**Employer Rights and Responsibilities** – The enclosed booklet (OSHA 3000) outlines additional employer rights and responsibilities and should be read in conjunction with this notification.

**Notice to Employees** – The law gives an employee or his/her representative the opportunity to object to any abatement date set for a violation if he/she believes the date to be unreasonable. The contest must be mailed to the U.S. Department of Labor Area Office at the address shown above and postmarked within 15 working days (excluding weekends and Federal holidays) of the receipt by the employer of this Citation and Notification of Penalty.

**Inspection Activity Data** – You should be aware that OSHA publishes information on its inspection and citation activity on the Internet under the provisions of the Electronic Freedom of Information Act. The information related to these alleged violations will be posted when our system indicates that you have received this citation. You are encouraged to review the information concerning your establishment at [www.osha.gov](http://www.osha.gov). If you have any dispute with the accuracy of the information displayed, please contact this office.



## NOTICE TO EMPLOYEES OF INFORMAL CONFERENCE

An informal conference has been scheduled with OSHA to discuss the citation(s) issued on 05/25/2016. The conference will be held by telephone or at the OSHA office located at 1387 S. Vinnell Way, Suite 218, Boise, ID 83709 on \_\_\_\_\_ at \_\_\_\_\_.

Employees and/or representatives of employees have a right to attend an informal conference.

**CERTIFICATION OF CORRECTIVE ACTION WORKSHEET**

**Inspection Number: 1117009**

Company Name: Dickinson Frozen Foods, Inc.  
Inspection Site: 903 E. 3000 North, Sugar City, ID 83448  
Issuance Date: 05/25/2016

List the specific method of correction for each item on this citation in this package that does not read "Corrected During Inspection" and return to: **U.S. Department of Labor – Occupational Safety and Health Administration, 1387 S. Vinnell Way, Suite 218, Boise, ID 83709**

Citation Number \_\_\_\_\_ and Item Number \_\_\_\_\_ was corrected on \_\_\_\_\_  
By (Method of Abatement): \_\_\_\_\_  
\_\_\_\_\_

Citation Number \_\_\_\_\_ and Item Number \_\_\_\_\_ was corrected on \_\_\_\_\_  
By (Method of Abatement): \_\_\_\_\_  
\_\_\_\_\_

Citation Number \_\_\_\_\_ and Item Number \_\_\_\_\_ was corrected on \_\_\_\_\_  
By (Method of Abatement): \_\_\_\_\_  
\_\_\_\_\_

Citation Number \_\_\_\_\_ and Item Number \_\_\_\_\_ was corrected on \_\_\_\_\_  
By (Method of Abatement): \_\_\_\_\_  
\_\_\_\_\_

Citation Number \_\_\_\_\_ and Item Number \_\_\_\_\_ was corrected on \_\_\_\_\_  
By (Method of Abatement): \_\_\_\_\_  
\_\_\_\_\_

Citation Number \_\_\_\_\_ and Item Number \_\_\_\_\_ was corrected on \_\_\_\_\_  
By (Method of Abatement): \_\_\_\_\_  
\_\_\_\_\_

I certify that the information contained in this document is accurate and that the affected employees and their representatives have been informed of the abatement.

\_\_\_\_\_  
Signature

\_\_\_\_\_  
Date

\_\_\_\_\_  
Typed or Printed Name

\_\_\_\_\_  
Title

**NOTE: 29 USC 666(g)** whoever knowingly makes any false statements, representation or certification in any application, record, plan or other documents filed or required to be maintained pursuant to the Act shall, upon conviction, be punished by a fine of not more than \$10,000 or by imprisonment of not more than 6 months or both.

**POSTING:** A copy of completed Corrective Action Worksheet should be posted for employee review



**Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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**Citation 1 Item 1** Type of Violation: **Serious**

29 CFR 1910.119(c)(1): Employers did not develop a written plan of action regarding the implementation of the employee participation required by this paragraph.

a) On or about January 5, 2016 and at times prior thereto: Employees were not involved in a process of analyzing the hazards of ammonia and the Process Safety Management of the facility.

OR IN THE ALTERNATIVE:

OSH ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazard of anhydrous ammonia because the employer had not included employee participation in a process safety management analysis.

NOTE: Abatement certification and documentation are required for this item.

Abatement Note: Recommended abatement measures for this item shall include compliance with the following consensus standards and accepted industry practice. A link to a related OSHA pamphlet is also provided.

- 1) ASHRAE 15 2007, Safety Standard for Refrigeration Systems.
- 2) ANSI/IIAR-2-2008, Equipment, Design, and Installation of Closed-Circuit Ammonia Mechanical Refrigeration Systems.
- 3) Industrial Refrigeration Course IV, Plant Operation and Safety, Refrigerating Engineers and Technicians Association, 2002.
- 4) OSHA pamphlet 3133 Process Safety Management Guidelines for Compliance, [www.osha.gov](http://www.osha.gov).

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.

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**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

Date By Which Violation Must be Abated: 10/06/2016  
Proposed Penalty: \$7000.00

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.



### Citation and Notification of Penalty

**Company Name:** Dickinson Frozen Foods, Inc.  
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The alleged violations below have been grouped because they involve similar or related hazards that may increase the potential for injury or illness.

#### Citation 1 Item 2 a Type of Violation: **Serious**

29 CFR 1910.119(d)(2)(i)(E): The process safety information did not include an evaluation of the consequences of deviations, including those affecting the safety and health of employees.

a) On or about January 5, 2016, and at times prior thereto, An analysis of the consequences of deviation was not developed for ammonia releases including but was not limited to the following equipment: heat exchange failure, piping leaks, strainer failure, and potential pressure relief valve failure.

OR IN THE ALTERNATIVE:

OSH ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer had not compiled written process safety information for hazards, technology, and equipment.

NOTE: Abatement certification and documentation are required for this item.

Abatement Note: Recommended abatement measures for this item shall include compliance with the following consensus standards and accepted industry practice. A link to a related OSHA pamphlet is also provided.

- 1) ASHRAE 15 2007, Safety Standard for Refrigeration Systems.
- 2) ANSI/IIAR-2-2008, Equipment, Design, and Installation of Closed-Circuit Ammonia Mechanical Refrigeration Systems.
- 3) Industrial Refrigeration Course IV, Plant Operation and Safety, Refrigerating Engineers and Technicians Association, 2002.

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4) OSHA pamphlet 3133 Process Safety Management Guidelines for Compliance, [www.osha.gov](http://www.osha.gov).

**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

Date By Which Violation Must be Abated:	10/06/2016
Proposed Penalty:	\$7000.00

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### **Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
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#### **Citation 1 Item 2 b** Type of Violation: **Serious**

29 CFR 1910.119(d)(3)(i)(B): The process safety information did not include information pertaining to the equipment in the process:

a) On or about January 5, 2016, and at times prior thereto, Process & Instrumentation Diagram (P&ID) for Line B: The P&ID for Line B did not include the Kemper Northwest December 3, 2015 modification of the refrigeration line that circumvented the heat exchanger that failed on December 1, 2015.

b) On or about January 5, 2016, and at times prior thereto, Process & Instrumentation Diagrams (P&ID) for Line A: The print out of the P&ID for the Line A refrigeration line did not include modifications to the refrigeration pressure vessels.

OR IN THE ALTERNATIVE:

OSH ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer had not compiled written process safety information for hazards, technology, and equipment.

NOTE: Abatement certification and documentation are required for this item.

Abatement Note: Recommended abatement measures for this item shall include compliance with the following consensus standards and accepted industry practice. A link to a related OSHA pamphlet is also provided.

- 1) ASHRAE 15 2007, Safety Standard for Refrigeration Systems.
- 2) ANSI/IIAR-2-2008, Equipment, Design, and Installation of Closed-Circuit Ammonia Mechanical Refrigeration Systems.

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- 3) Industrial Refrigeration Course IV, Plant Operation and Safety, Refrigerating Engineers and Technicians Association, 2002.
- 4) OSHA pamphlet 3133 Process Safety Management Guidelines for Compliance, [www.osha.gov](http://www.osha.gov).

**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

Date By Which Violation Must be Abated:

10/06/2016

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**Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
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**Citation 1 Item 2 c** Type of Violation: **Serious**

29 CFR 1910.119(d)(3)(i)(C): The process safety information did not include information pertaining to electrical classification.

a) On or about January 5, 2016, and at times prior thereto, Electrical classification of compressor rooms A and B were not maintained.

OR IN THE ALTERNATIVE:

OSH ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer had not compiled written process safety information for hazards, technology, and equipment.

NOTE: Abatement certification and documentation are required for this item.

Abatement Note: Recommended abatement measures for this item shall include compliance with the following consensus standards and accepted industry practice. A link to a related OSHA pamphlet is also provided.

- 1) ASHRAE 15 2007, Safety Standard for Refrigeration Systems.
- 2) ANSI/IIAR-2-2008, Equipment, Design, and Installation of Closed-Circuit Ammonia Mechanical Refrigeration Systems.
- 3) Industrial Refrigeration Course IV, Plant Operation and Safety, Refrigerating Engineers and Technicians Association, 2002.
- 4) OSHA pamphlet 3133 Process Safety Management Guidelines for Compliance, [www.osha.gov](http://www.osha.gov).

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**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

Date By Which Violation Must be Abated:

10/06/2016

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.



### **Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
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#### **Citation 1 Item 2 d** Type of Violation: **Serious**

29 CFR 1910.119(d)(3)(i)(E): The process safety information did not include information pertaining to ventilation system design.

a) On or about January 5, 2016, and at times prior thereto, process safety information did not address ventilation system design to handle the quantity of ammonia in the refrigeration system.

OR IN THE ALTERNATIVE:

OSH ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer had not compiled written process safety information for hazards, technology, and equipment.

NOTE: Abatement certification and documentation are required for this item.

Abatement Note: Recommended abatement measures for this item shall include compliance with the following consensus standards and accepted industry practice. A link to a related OSHA pamphlet is also provided.

- 1) ASHRAE 15 2007, Safety Standard for Refrigeration Systems.
- 2) ANSI/IIAR-2-2008, Equipment, Design, and Installation of Closed-Circuit Ammonia Mechanical Refrigeration Systems.
- 3) Industrial Refrigeration Course IV, Plant Operation and Safety, Refrigerating Engineers and Technicians Association, 2002.
- 4) OSHA pamphlet 3133 Process Safety Management Guidelines for Compliance, [www.osha.gov](http://www.osha.gov).

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### Citation and Notification of Penalty

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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#### Citation 1 Item 2 e Type of Violation: **Serious**

29 CFR 1910.119(d)(3)(i)(F): The process safety information did not include information pertaining to the design codes and standards employed.

a) On or about January 5, 2016, and at times prior thereto, process safety information did not include design codes and standards utilized for construction of the B-Line Cloudy Britton Refrigeration System.

OR IN THE ALTERNATIVE:

OSH ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer had not compiled written process safety information for hazards, technology, and equipment.

NOTE: Abatement certification and documentation are required for this item.

Abatement Note: Recommended abatement measures for this item shall include compliance with the following consensus standards and accepted industry practice. A link to a related OSHA pamphlet is also provided.

- 1) ASHRAE 15 2007, Safety Standard for Refrigeration Systems.
- 2) ANSI/IIAR-2-2008, Equipment, Design, and Installation of Closed-Circuit Ammonia Mechanical Refrigeration Systems.
- 3) Industrial Refrigeration Course IV, Plant Operation and Safety, Refrigerating Engineers and Technicians Association, 2002.
- 4) OSHA pamphlet 3133 Process Safety Management Guidelines for Compliance, [www.osha.gov](http://www.osha.gov).

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**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

Date By Which Violation Must be Abated:

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### Citation and Notification of Penalty

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The alleged violations below have been grouped because they involve similar or related hazards that may increase the potential for injury or illness.

#### Citation 1 Item 3 a Type of Violation: **Serious**

29 CFR 1910.119(d)(3)(ii): The employer did not document that equipment complies with recognized and generally accepted good engineering practices (RAGAGEP).

- a) Line A Compressor Room, On or about January 5, 2016, and at times prior thereto, the employer did not document that in the Line A Compressor Room, that the structural components of the Line A compressor room were constructed of non-combustible materials.
- b) Line A Compressor Room, On or about January 5, 2016, and at times prior thereto, the employer did not document that tight fitting doors were installed.
- c) Line B Compressor Room, On or about January 5, 2016, and at times prior thereto, the employer did not document that the structural components of the Line B compressor room were constructed of non-combustible materials.
- d) Line B Compressor Room, On or about January 5, 2016, and at times prior thereto, the employer did not document that tight fitting doors were installed.
- e) Line B Compressor Room, On or about January 5, 2016, and at times prior thereto, the employer did not document that in the Line B Compressor Room, that all electrical equipment in the Line B Compressor Room conformed to requirements for a Class 1 Group D Division 2 location. Two open 110 V Junction boxes and extension cords were observed on January 5, 2016.
- f) Line B Compressor Room, On or about January 5, 2016, and at times prior thereto, the employer did not document that the ammonia alarm was unplugged. It was not hard wired.
- g) Line B Refrigeration Line, On or about January 5, 2016, and at times prior thereto, the employer did not document that the room containing the Low Pressure Receiver met protective requirements of a "machinery room."

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.



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**OR IN THE ALTERNATIVE:**

OSH ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer had not documented that equipment complies with recognized and generally accepted good engineering practices (RAGAGEP).

NOTE: Abatement certification and documentation are required for this item.

Abatement Note: Among other methods to comply with recognized and generally accepted good engineering practices, the employer may consider the following:

- a) Ensure structural components are in accordance with Equipment, Design, and Installation of Ammonia Mechanical Refrigerating Systems, ANSI/IIAR-2-2008, Section 13.3.1.
- b) Ensure structural components are in accordance with Equipment, Design, and Installation of Ammonia Mechanical Refrigerating Systems, ANSI/IIAR-2-2008, Section 13.3.3.1, 13.3.3.2.
- c) Ensure structural components are in accordance with Equipment, Design, and Installation of Ammonia Mechanical Refrigerating Systems, ANSI/IIAR-2-2008, Section 13.3.1.
- d) Ensure structural components are in accordance with Equipment, Design, and Installation of Ammonia Mechanical Refrigerating Systems, ANSI/IIAR-2-2008, Section 13.3.3.1, 13.3.3.2.
- e) Ensure electrical equipment is in accordance with Equipment, Design, and Installation of Ammonia Mechanical Refrigerating Systems, ANSI/IIAR-2-2008, Section 13.2.1.2, 13.3.2.5.
- f) Ensure monitoring equipment is in accordance with Equipment, Design, and Installation of Ammonia Mechanical Refrigerating Systems, ANSI/IIAR-2-2008, Section 13.2.1.3, 13.2.3.1.
- g) See ANSI/IIAR 2-2008, Definitions: Machinery Room and Section 13. And see ASHRAE 15-2007, Definitions Machinery Room and Pressure Vessel; and Sections 8.11 and 8.12.

**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

Date By Which Violation Must be Abated:	10/06/2016
Proposed Penalty:	\$7000.00

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**Company Name:** Dickinson Frozen Foods, Inc.  
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#### Citation 1 Item 3 b Type of Violation: **Serious**

29 CFR 1910.119(d)(3)(iii): For existing equipment designed and constructed in accordance with codes, standards, or practices that are no longer in general use, the employer did not determine and document that the equipment was designed, maintained, inspected, tested, and operating in a safe manner.

- a) Line A Compressor Room, On or about January 5, 2016, and at times prior thereto, the employer did not document that in the Line A Compressor Room, that the structural components of the Line A compressor room were constructed of non-combustible materials.
- b) Line A Compressor Room, On or about January 5, 2016, and at times prior thereto, the employer did not document that tight fitting doors were installed.
- c) Line B Compressor Room, On or about January 5, 2016, and at times prior thereto, the employer did not document that the structural components of the Line B compressor room were constructed of non-combustible materials.
- d) Line B Compressor Room, On or about January 5, 2016, and at times prior thereto, the employer did not document that tight fitting doors were installed.
- e) Line B Compressor Room, On or about January 5, 2016, and at times prior thereto, the employer did not document that in the Line B Compressor Room, that all electrical equipment in the Line B Compressor Room conformed to requirements for a Class 1 Group D Division 2 location. Two open 110 V Junction boxes and extension cords were observed on January 5, 2016.
- f) Line B Compressor Room, On or about January 5, 2016, and at times prior thereto, the employer did not document that the ammonia alarm was unplugged. It was not hard wired.
- g) Line B Refrigeration Line, On or about January 5, 2016, and at times prior thereto, the employer did not document that the room containing the Low Pressure Receiver met protective requirements of a "machinery room."

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**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

**OR IN THE ALTERNATIVE:**

OSH ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer had not documented that equipment complies with recognized and generally accepted good engineering practices (RAGAGEP).

NOTE: Abatement certification and documentation are required for this item.

Abatement Note: Among other methods to comply with recognized and generally accepted good engineering practices, the employer may consider the following:

- a) Ensure structural components are in accordance with Equipment, Design, and Installation of Ammonia Mechanical Refrigerating Systems, ANSI/IIAR-2-2008, Section 13.3.1.
- b) Ensure structural components are in accordance with Equipment, Design, and Installation of Ammonia Mechanical Refrigerating Systems, ANSI/IIAR-2-2008, Section 13.3.3.1, 13.3.3.2.
- c) Ensure structural components are in accordance with Equipment, Design, and Installation of Ammonia Mechanical Refrigerating Systems, ANSI/IIAR-2-2008, Section 13.3.1.
- d) Ensure structural components are in accordance with Equipment, Design, and Installation of Ammonia Mechanical Refrigerating Systems, ANSI/IIAR-2-2008, Section 13.3.3.1, 13.3.3.2.
- e) Ensure electrical equipment is in accordance with Equipment, Design, and Installation of Ammonia Mechanical Refrigerating Systems, ANSI/IIAR-2-2008, Section 13.2.1.2, 13.3.2.5.
- f) Ensure monitoring equipment is in accordance with Equipment, Design, and Installation of Ammonia Mechanical Refrigerating Systems, ANSI/IIAR-2-2008, Section 13.2.1.3, 13.2.3.1.
- g) See ANSI/IIAR 2-2008, Definitions: Machinery Room and Section 13. And see ASHRAE 15-2007, Definitions Machinery Room and Pressure Vessel; and Sections 8.11 and 8.12.

**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

**Date By Which Violation Must be Abated:**

**10/06/2016**



**Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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**Citation 1 Item 4** Type of Violation: **Serious**

29 CFR 1910.119(e)(1): The employer did not perform an initial process hazard analysis (hazard evaluation) on processes covered by this standard.

a) Line A and Line B ammonia refrigeration systems; On or about January 5, 2016, and at times prior thereto: The employer did not perform a process hazard analysis of the Line A and Line B ammonia refrigeration systems.

OR IN THE ALTERNATIVE:

OSHA ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer had not conducted a process hazard analysis.

NOTE: Abatement certification and documentation are required for this item.

Abatement Note: Recommended abatement measures for this item shall include compliance with the following consensus standards and accepted industry practice. A link to a related OSHA pamphlet is also provided.

- 1) ASHRAE 15 2007, Safety Standard for Refrigeration Systems.
- 2) ANSI/IIAR-2-2008, Equipment, Design, and Installation of Closed-Circuit Ammonia Mechanical Refrigeration Systems.
- 3) Industrial Refrigeration Course IV, Plant Operation and Safety, Refrigerating Engineers and Technicians Association, 2002.
- 4) OSHA pamphlet 3133 Process Safety Management Guidelines for Compliance, [www.osha.gov](http://www.osha.gov).

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.

**U.S. Department of Labor**  
Occupational Safety and Health Administration

**Inspection Number:** 1117009  
**Inspection Date(s):** 01/05/2016 - 01/06/2016  
**Issuance Date:** 05/25/2016



**Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

Date By Which Violation Must be Abated: 10/06/2016  
Proposed Penalty: \$7000.00

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.



### Citation and Notification of Penalty

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

The alleged violations below have been grouped because they involve similar or related hazards that may increase the potential for injury or illness.

#### Citation 1 Item 5 a Type of Violation: **Serious**

29 CFR 1910.119(f)(1)(i)(D): The employer did not develop and implement emergency shutdown including the conditions under which emergency shutdown is required, and the assignment of shutdown responsibility to qualified operators to ensure that emergency shutdown is executed in a safe and timely manner.

a) On or about January 5, 2016, and at times or prior thereto: The employer did not implement written operating procedures for Maintenance employees involved in emergency operations including shutdown procedures addressed in the Dickinson Frozen Foods Ammonia SOP's.

OR IN THE ALTERNATIVE:

OSHA ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer had not implemented emergency shutdown procedures.

NOTE: Abatement certification and documentation are required for this item.

Abatement Note: Recommended abatement measures for this item shall include compliance with the following consensus standards and accepted industry practice. A link to a related OSHA pamphlet is also provided.

- 1) ASHRAE 15 2007, Safety Standard for Refrigeration Systems.
- 2) ANSI/IIAR-2-2008, Equipment, Design, and Installation of Closed-Circuit Ammonia Mechanical Refrigeration Systems.
- 3) Industrial Refrigeration Course IV, Plant Operation and Safety, Refrigerating Engineers and

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.

**U.S. Department of Labor**  
Occupational Safety and Health Administration

**Inspection Number:** 1117009  
**Inspection Date(s):** 01/05/2016 - 01/06/2016  
**Issuance Date:** 05/25/2016



**Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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Technicians Association, 2002.

4) OSHA pamphlet 3133 Process Safety Management Guidelines for Compliance,  
[www.osha.gov](http://www.osha.gov).

**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

Date By Which Violation Must be Abated:	10/06/2016
Proposed Penalty:	\$7000.00

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.



### **Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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#### **Citation 1 Item 5 b Type of Violation: **Serious****

29 CFR 1910.119(f)(2): Operating procedures were not readily accessible to employees who work in or maintain a process.

a) On or about January 5, 2016, and at times or prior thereto: The employer did not make written operating procedures for Maintenance employees involved in ammonia refrigeration activity readily accessible.

OR IN THE ALTERNATIVE:

OSHA ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer did not make operating procedures accessible.

NOTE: Abatement certification and documentation are required under this item.

Abatement Note: Recommended abatement measures for this item shall include compliance with the following consensus standards and accepted industry practice. A link to a related OSHA pamphlet is also provided.

- 1) ASHRAE 15 2007, Safety Standard for Refrigeration Systems.
- 2) ANSI/IIAR-2-2008, Equipment, Design, and Installation of Closed-Circuit Ammonia Mechanical Refrigeration Systems.
- 3) Industrial Refrigeration Course IV, Plant Operation and Safety, Refrigerating Engineers and Technicians Association, 2002.
- 4) OSHA pamphlet 3133 Process Safety Management Guidelines for Compliance, [www.osha.gov](http://www.osha.gov).

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.

**U.S. Department of Labor**  
Occupational Safety and Health Administration

**Inspection Number:** 1117009  
**Inspection Date(s):** 01/05/2016 - 01/06/2016  
**Issuance Date:** 05/25/2016



**Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

Date By Which Violation Must be Abated:

10/06/2016

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.



### Citation and Notification of Penalty

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

The alleged violations below have been grouped because they involve similar or related hazards that may increase the potential for injury or illness.

#### Citation 1 Item 6 a Type of Violation: **Serious**

29 CFR 1910.119(g)(1)(i): Each employee presently involved in operating a process, and each employee before being involved in operating a newly assigned process, was not trained in an overview of the process and in the operating procedures as specified in paragraph (f) of this section. The training did not include emphasis on the specific safety and health hazards, emergency operations including shutdown, and safe work practices applicable to the employee's job tasks.

a) On or about January 5, 2016, and at times or prior thereto: Maintenance employees involved in ammonia refrigeration activity were not trained in the Line A and B ammonia refrigeration system.

OR IN THE ALTERNATIVE:

OSHA ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer had not conducted training for employees operating a related process.

NOTE: Abatement certification and documentation are required for this item.

Abatement Note: Recommended abatement measures for this item shall include compliance with the following consensus standards and accepted industry practice. A link to a related OSHA pamphlet is also provided.

- 1) ASHRAE 15 2007, Safety Standard for Refrigeration Systems.
- 2) ANSI/IIAR-2-2008, Equipment, Design, and Installation of Closed-Circuit Ammonia Mechanical Refrigeration Systems.

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.

**U.S. Department of Labor**  
Occupational Safety and Health Administration

**Inspection Number:** 1117009  
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**Issuance Date:** 05/25/2016



**Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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3) Industrial Refrigeration Course IV, Plant Operation and Safety, Refrigerating Engineers and Technicians Association, 2002.

4) OSHA pamphlet 3133 Process Safety Management Guidelines for Compliance, [www.osha.gov](http://www.osha.gov).

**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

Date By Which Violation Must be Abated:	10/06/2016
Proposed Penalty:	\$7000.00

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.



### Citation and Notification of Penalty

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

#### Citation 1 Item 6 b Type of Violation: **Serious**

29 CFR 1910.119(g)(3): The employer did not ascertain that each employee involved in operating a process has received and understood the training required by this paragraph. The employer did not prepare a record which contains the identity of the employee, the date of training, and the means used to verify that the employee understood the training.

a) On or about January 5, 2016 and at times prior thereto: Employees did not have adequate knowledge of company refrigeration processes, the written emergency action plan, and of routine responses to ammonia refrigeration system leaks and releases. In addition, the employer did not have documentation of employee training in the Emergency Action Plan, Emergency Respirator Procedures, Ammonia Standard Operating Procedures, and Respirator Training.

OR IN THE ALTERNATIVE:

OSHA ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer had not training for employees operating a related process.

NOTE: Abatement certification and documentation are required for this item.

Abatement Note: Recommended abatement measures for this item shall include compliance with the following consensus standards and accepted industry practice. A link to a related OSHA pamphlet is also provided.

- 1) ASHRAE 15 2007, Safety Standard for Refrigeration Systems.
- 2) ANSI/IIAR-2-2008, Equipment, Design, and Installation of Closed-Circuit Ammonia Mechanical Refrigeration Systems.
- 3) Industrial Refrigeration Course IV, Plant Operation and Safety, Refrigerating Engineers and Technicians Association, 2002.

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.

**U.S. Department of Labor**  
Occupational Safety and Health Administration

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**Inspection Date(s):** 01/05/2016 - 01/06/2016  
**Issuance Date:** 05/25/2016



**Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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4) OSHA pamphlet 3133 Process Safety Management Guidelines for Compliance,  
[www.osha.gov](http://www.osha.gov).

**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

Date By Which Violation Must be Abated:

07/13/2016

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.



**Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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**Citation 1 Item 7** Type of Violation: **Serious**

29 CFR 1910.119(h)(2)(iii): The employer did not explain to contract employers the applicable provisions of the emergency action plan required by paragraph (n) of this section.

a) Line B Compressor Room, On or about December 3, 2015 or at times prior thereto: The employer did not review the company emergency action plan with Kemper Northwest prior to repair work to circumvent the heat exchanger in the Line B compressor room.

OR IN THE ALTERNATIVE:

OSHA ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer had not reviewed the emergency action plan with contract employers.

NOTE: Abatement certification and documentation are required for this item.

Abatement Note: Recommended abatement measures for this item shall include compliance with the following consensus standards and accepted industry practice. A link to a related OSHA pamphlet is also provided.

- 1) ASHRAE 15 2007, Safety Standard for Refrigeration Systems.
- 2) ANSI/IIAR-2-2008, Equipment, Design, and Installation of Closed-Circuit Ammonia Mechanical Refrigeration Systems.
- 3) Industrial Refrigeration Course IV, Plant Operation and Safety, Refrigerating Engineers and Technicians Association, 2002.
- 4) OSHA pamphlet 3133 Process Safety Management Guidelines for Compliance, [www.osha.gov](http://www.osha.gov).

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.

**U.S. Department of Labor**  
Occupational Safety and Health Administration

**Inspection Number:** 1117009  
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**Issuance Date:** 05/25/2016



**Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

Date By Which Violation Must be Abated:	10/06/2016
Proposed Penalty:	\$7000.00

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.



### Citation and Notification of Penalty

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

#### Citation 1 Item 8 Type of Violation: **Serious**

29 CFR 1910.119(i)(1): The employer did not perform a pre-startup safety review for new facilities and for modified facilities when the modification is significant enough to require a change in the process safety information.

a) Line B Compressor Room; On or about December 3, 2015, The employer did not perform a pre-startup safety review after the Heat Exchanger was circumvented by Kemper Northwest on Line B.

OR IN THE ALTERNATIVE:

OSHA ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer had not conducted a pre-startup safety review.

NOTE: Abatement certification and documentation are required for this item.

Abatement Note: Recommended abatement measures for this item shall include compliance with the following consensus standards and accepted industry practice. A link to a related OSHA pamphlet is also provided.

- 1) ASHRAE 15 2007, Safety Standard for Refrigeration Systems.
- 2) ANSI/IIAR-2-2008, Equipment, Design, and Installation of Closed-Circuit Ammonia Mechanical Refrigeration Systems.
- 3) Industrial Refrigeration Course IV, Plant Operation and Safety, Refrigerating Engineers and Technicians Association, 2002.
- 4) OSHA pamphlet 3133 Process Safety Management Guidelines for Compliance, [www.osha.gov](http://www.osha.gov).

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.

**U.S. Department of Labor**  
Occupational Safety and Health Administration

**Inspection Number:** 1117009  
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**Issuance Date:** 05/25/2016



**Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

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Proposed Penalty:	\$7000.00

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.



### Citation and Notification of Penalty

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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The alleged violations below have been grouped because they involve similar or related hazards that may increase the potential for injury or illness.

#### Citation 1 Item 9 a Type of Violation: **Serious**

29 CFR 1910.119(j)(2): The employer did not establish and implement written procedures to maintain the on-going integrity of process equipment.

a) On or about January 5, 2016, and at times prior thereto: Procedures were not in place to maintain the process equipment on Line A and B including but are not limited to the following equipment: Low Pressure Receivers, High Pressure Receivers, Compressors, Evaporators, Condensers, Pressure Relief Valves, Piping, Controls and Pumps.

OR IN THE ALTERNATIVE:

OSHA ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer had not implemented written procedures to maintain the on-going integrity of process equipment.

NOTE: Abatement certification and documentation are required for this item.

Abatement Note: Recommended abatement measures for this item shall include compliance with the following consensus standards and accepted industry practice. A link to a related OSHA pamphlet is also provided.

- 1) ASHRAE 15 2007, Safety Standard for Refrigeration Systems.
- 2) ANSI/IIAR-2-2008, Equipment, Design, and Installation of Closed-Circuit Ammonia Mechanical Refrigeration Systems.
- 3) Industrial Refrigeration Course IV, Plant Operation and Safety, Refrigerating Engineers and

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**U.S. Department of Labor**  
Occupational Safety and Health Administration

**Inspection Number:** 1117009  
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**Issuance Date:** 05/25/2016



**Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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Technicians Association, 2002.

4) OSHA pamphlet 3133 Process Safety Management Guidelines for Compliance, [www.osha.gov](http://www.osha.gov).

**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

Date By Which Violation Must be Abated:	10/06/2016
Proposed Penalty:	\$7000.00

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.



### Citation and Notification of Penalty

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

#### Citation 1 Item 9 b Type of Violation: **Serious**

29 CFR 1910.119(j)(3): The employer did not train each employee involved in maintaining the on-going integrity of process equipment in an overview of that process and its hazards and in the procedures applicable to the employee's job tasks to assure that the employee can perform the job tasks in a safe manner.

a) On or about January 5, 2016, and at times prior thereto: Employees were not trained on maintenance of process equipment on Line A and B including but are not limited to the following equipment on Line A and B refrigeration lines: Low Pressure Receivers, High Pressure Receivers, Compressors, Evaporators, Condensers, Pressure Relief Valves, Piping, Controls and Pumps.

OR IN THE ALTERNATIVE:

OSHA ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer had not implemented written procedures and training to maintain the on-going integrity of process equipment.

NOTE: Abatement certification and documentation are required for this item.

Abatement Note: Recommended abatement measures for this item shall include compliance with the following consensus standards and accepted industry practice. A link to a related OSHA pamphlet is also provided.

- 1) ASHRAE 15 2007, Safety Standard for Refrigeration Systems.
- 2) ANSI/IIAR-2-2008, Equipment, Design, and Installation of Closed-Circuit Ammonia Mechanical Refrigeration Systems.
- 3) Industrial Refrigeration Course IV, Plant Operation and Safety, Refrigerating Engineers and Technicians Association, 2002.

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.

**U.S. Department of Labor**  
Occupational Safety and Health Administration

**Inspection Number:** 1117009  
**Inspection Date(s):** 01/05/2016 - 01/06/2016  
**Issuance Date:** 05/25/2016



**Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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4) OSHA pamphlet 3133 Process Safety Management Guidelines for Compliance, [www.osha.gov](http://www.osha.gov).

**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

Date By Which Violation Must be Abated:

10/06/2016

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.



### Citation and Notification of Penalty

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

#### Citation 1 Item 10 Type of Violation: **Serious**

29 CFR 1910.119(j)(4)(i): Inspections and tests were not performed on process equipment.

- a) On or about January 27, 2016, and at times prior thereto: High Pressure Receiver Line A - pressure relief valve had an expiration date of 2014.
- b) On or about January 27, 2016, and at times prior thereto: Low Pressure Receiver Line A - pressure relief valve had an expiration date of 2014.
- c) On or about January 27, 2016, and at times prior thereto: Low Pressure Receiver Line A - pressure relief valve had an illegible tag.

#### OR IN THE ALTERNATIVE:

OSHA ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer had not implemented written procedures to maintain the on-going integrity of process equipment.

NOTE: Abatement certification and documentation are required for this item.

Abatement Note: Recommended abatement measures for this item shall include compliance with the following consensus standards and accepted industry practice. A link to a related OSHA pamphlet is also provided.

- 1) ASHRAE 15 2007, Safety Standard for Refrigeration Systems.
- 2) ANSI/IIAR-2-2008, Equipment, Design, and Installation of Closed-Circuit Ammonia Mechanical Refrigeration Systems.

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.

**U.S. Department of Labor**  
Occupational Safety and Health Administration

**Inspection Number:** 1117009  
**Inspection Date(s):** 01/05/2016 - 01/06/2016  
**Issuance Date:** 05/25/2016



**Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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- 3) Industrial Refrigeration Course IV, Plant Operation and Safety, Refrigerating Engineers and Technicians Association, 2002.
- 4) OSHA pamphlet 3133 Process Safety Management Guidelines for Compliance, [www.osha.gov](http://www.osha.gov).

**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

Date By Which Violation Must be Abated:	10/06/2016
Proposed Penalty:	\$7000.00

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.



### Citation and Notification of Penalty

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

#### Citation 1 Item 11 Type of Violation: **Serious**

29 CFR 1910.119(j)(5): The employer did not correct deficiencies in equipment that are outside acceptable limits (defined by the process safety information in paragraph (d) of this section) before further use or in a safe and timely manner when necessary means are taken to assure safe operation.

- a) Compressor Rooms A and B; On or about December 4, 2015 and at times prior thereto, employees were exposed to the hazard of using a Goodall N2000 Anhydrous Ammonia hose beyond its service life. The hose had an end of service life date of 2009. The hose was used to transfer approximately 1,300 pounds of anhydrous ammonia from a nurse tank in Compressor Room A to the High Pressure Receiver in Compressor Room B. From 2003 to 2015, the hose had periodically been utilized to transfer anhydrous ammonia from the High Pressure Receiver in Compressor Room B, to the High Pressure Receiver on Line A. This operation was conducted to prevent line shutdowns of the ammonia refrigeration system.
- b) On or about January 27, 2016, and at times prior thereto: High Pressure Receiver Line A - pressure relief valve had an expiration date of 2014.
- c) On or about January 27, 2016, and at times prior thereto: Low Pressure Receiver Line A - pressure relief valve had an expiration date of 2014.
- d) On or about January 27, 2016, and at times prior thereto: Low Pressure Receiver Line A - pressure relief valve had an illegible tag.

#### OR IN THE ALTERNATIVE:

OSHA ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer had not implemented procedures to maintain the on-going integrity of process equipment.

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.



**Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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NOTE: Abatement certification and documentation is required for this item.

Recommended abatement measures for this item shall include compliance with the following consensus standards for anhydrous ammonia hose:

- 1) RMA IP-14 Specifications for Anhydrous Ammonia Hose.
- 2) ANSI/IIAR 2-2008, Section 15 Testing and Charging. Specifically, ensure that all ammonia handling and storage on site be in accordance with Section 15.2 Ammonia Handling and Storage.
- 3) Industrial Refrigeration Course IV, Plant Operation and Safety, Refrigerating Engineers and Technicians Association, 2002.
- 4) Develop a Process Safety Management program that includes a Process Hazard Analysis (PHA), Pre-Startup Safety Reviews, Operating Procedures, Process Safety Information, Mechanical Integrity and Employee Training as described in OSHA pamphlet 3133 Process Safety Management Guidelines for Compliance, available at OSHA's website [www.osha.gov](http://www.osha.gov).

**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

Date By Which Violation Must be Abated:	07/13/2016
Proposed Penalty:	\$7000.00



**Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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Citation 1 Item 12 Type of Violation: **Serious**

29 CFR 1910.119(k)(1): The employer did not issue a hot work permit for hot work operations conducted on or near a covered process.

a) Line B Compressor Room; On or about December 3, 2015, and at times prior thereto: The employer did not issue a hot work permit for hot work operations conducted on the Line B Heat Exchanger that was circumvented by Kemper Northwest.

OR IN THE ALTERNATIVE:

OSHA ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer did not issue permits and procedures for hot work operations.

NOTE: Abatement certification and documentation are required under this item.

Abatement Note: Recommended abatement measures for this item shall include compliance with the following consensus standards and accepted industry practice. A link to a related OSHA pamphlet is also provided.

- 1) ASHRAE 15 2007, Safety Standard for Refrigeration Systems.
- 2) ANSI/IIAR-2-2008, Equipment, Design, and Installation of Closed-Circuit Ammonia Mechanical Refrigeration Systems.
- 3) Industrial Refrigeration Course IV, Plant Operation and Safety, Refrigerating Engineers and Technicians Association, 2002.
- 4) OSHA pamphlet 3133 Process Safety Management Guidelines for Compliance, [www.osha.gov](http://www.osha.gov).

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.

**U.S. Department of Labor**  
Occupational Safety and Health Administration

**Inspection Number:** 1117009  
**Inspection Date(s):** 01/05/2016 - 01/06/2016  
**Issuance Date:** 05/25/2016



**Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

Date By Which Violation Must be Abated: 10/06/2016  
Proposed Penalty: \$7000.00

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.



### Citation and Notification of Penalty

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

The alleged violations below have been grouped because they involve similar or related hazards that may increase the potential for injury or illness.

Citation 1 Item 13 a      Type of Violation: **Serious**

29 CFR 1910.119(l)(1): The employer did not establish and implement written procedures to manage changes (except for "replacements in kind") to process chemicals, technology, equipment, and procedures; and, changes to facilities that affect a covered process.

a) Line B Compressor Room, On or about December 3, 2015, and at times prior thereto: The employer did not implement management of change procedures for the modification and circumvention of the Line B Heat Exchanger by Kemper Northwest.

OR IN THE ALTERNATIVE:

OSHA ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer had not implemented written procedures to manage changes to process chemicals, technology, equipment, procedures and facilities that affect a covered process.

NOTE: Abatement certification and documentation are required for this item.

Abatement Note: Recommended abatement measures for this item shall include compliance with the following consensus standards and accepted industry practice. A link to a related OSHA pamphlet is also provided.

- 1) ASHRAE 15 2007, Safety Standard for Refrigeration Systems.
- 2) ANSI/IIAR-2-2008, Equipment, Design, and Installation of Closed-Circuit Ammonia Mechanical Refrigeration Systems.

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.

**U.S. Department of Labor**  
Occupational Safety and Health Administration

**Inspection Number:** 1117009  
**Inspection Date(s):** 01/05/2016 - 01/06/2016  
**Issuance Date:** 05/25/2016



**Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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- 3) Industrial Refrigeration Course IV, Plant Operation and Safety, Refrigerating Engineers and Technicians Association, 2002.
- 4) OSHA pamphlet 3133 Process Safety Management Guidelines for Compliance, [www.osha.gov](http://www.osha.gov).

**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

Date By Which Violation Must be Abated:	10/06/2016
Proposed Penalty:	\$7000.00

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.



### Citation and Notification of Penalty

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

Citation 1 Item 13 b      Type of Violation: **Serious**

29 CFR 1910.119(l)(3): Employees involved in operating a process and maintenance and contract employees whose job tasks will be affected by a change in the process were not informed of, and trained in, the change prior to start-up of the process or affected part of the process.

a) Line B Compressor Room: On or about December 3, 2015, and at times prior thereto: The employer did not inform employees of the change, nor train employees affected by modification and circumvention of the Line B Heat Exchanger by Kemper Northwest.

OR IN THE ALTERNATIVE:

OSHA ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer had not implemented written procedures and related training to manage changes to process chemicals, technology, equipment, procedures and facilities that affect a covered process.

NOTE: Abatement certification and documentation are required for this item.

Abatement Note: Recommended abatement measures for this item shall include compliance with the following consensus standards and accepted industry practice. A link to a related OSHA pamphlet is also provided.

- 1) ASHRAE 15 2007, Safety Standard for Refrigeration Systems.
- 2) ANSI/IIAR-2-2008, Equipment, Design, and Installation of Closed-Circuit Ammonia Mechanical Refrigeration Systems.
- 3) Industrial Refrigeration Course IV, Plant Operation and Safety, Refrigerating Engineers and

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.

**U.S. Department of Labor**  
Occupational Safety and Health Administration

**Inspection Number:** 1117009  
**Inspection Date(s):** 01/05/2016 - 01/06/2016  
**Issuance Date:** 05/25/2016



**Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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Technicians Association, 2002.

4) OSHA pamphlet 3133 Process Safety Management Guidelines for Compliance, [www.osha.gov](http://www.osha.gov).

**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

Date By Which Violation Must be Abated:

10/06/2016

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.



### Citation and Notification of Penalty

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

The alleged violations below have been grouped because they involve similar or related hazards that may increase the potential for injury or illness.

Citation 1 Item 14 a      Type of Violation: **Serious**

29 CFR 1910.119(m)(3): An incident investigation team was not established and consisted of at least one person knowledgeable in the process involved, including a contract employee if the incident involved work of the contractor, and other persons with appropriate knowledge and experience to thoroughly investigate and analyze the incident.

a) Line B Compressor Room: On or about December 1, 2015, and at times prior thereto: An ammonia release incident related to the release of 1,300 pounds of ammonia from the Heat Exchanger in the Line B Compressor Room led to potential IDLH (Immediately Dangerous to Life and Health) conditions in an employer led emergency response. After the incident, the investigation team of Dickinson Frozen Foods did not include the ammonia systems expert of the company, nor their ammonia refrigeration contractor, Kemper Northwest.

OR IN THE ALTERNATIVE:

OSHA ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer had not established an incident investigation team with at least one person knowledgeable in the process involved, including a contract employee if the incident involved work of the contractor, and other persons with appropriate knowledge and experience to thoroughly investigate and analyze the incident.

NOTE: Abatement certification and documentation are required for this item.

Abatement Note: Recommended abatement measures for this item shall include compliance with the following consensus standards and accepted industry practice. A link to a related OSHA pamphlet is also provided.



**Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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- 1) ASHRAE 15 2007, Safety Standard for Refrigeration Systems.
- 2) ANSI/IIAR-2-2008, Equipment, Design, and Installation of Closed-Circuit Ammonia Mechanical Refrigeration Systems.
- 3) Industrial Refrigeration Course IV, Plant Operation and Safety, Refrigerating Engineers and Technicians Association, 2002.
- 4) OSHA pamphlet 3133 Process Safety Management Guidelines for Compliance, [www.osha.gov](http://www.osha.gov).

**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

Date By Which Violation Must be Abated:	10/06/2016
Proposed Penalty:	\$7000.00



### Citation and Notification of Penalty

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

Citation 1 Item 14 b      Type of Violation: **Serious**

29 CFR 1910.119(m)(5): The employer did not establish a system to promptly address and resolve the incident report findings and recommendations.

a) Line B Compressor Room: On or about December 1, 2015, and at times prior thereto: An ammonia release incident related to the release of 1,300 pounds of ammonia from the Heat Exchanger in the Line B Compressor Room led to potential IDLH (Immediately Dangerous to Life and Health) conditions in an employer led emergency response. The employer did not establish a system or methodology to address the cause of the release and prevent future occurrences.

OR IN THE ALTERNATIVE:

OSHA ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer had not established a system to promptly address and resolve the incident report findings and recommendations.

NOTE: Abatement certification and documentation are required for this item.

Abatement Note: Recommended abatement measures for this item shall include compliance with the following consensus standards and accepted industry practice. A link to a related OSHA pamphlet is also provided.

- 1) ASHRAE 15 2007, Safety Standard for Refrigeration Systems.
- 2) ANSI/IIAR-2-2008, Equipment, Design, and Installation of Closed-Circuit Ammonia Mechanical Refrigeration Systems.
- 3) Industrial Refrigeration Course IV, Plant Operation and Safety, Refrigerating Engineers and Technicians Association, 2002.

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.

**U.S. Department of Labor**  
Occupational Safety and Health Administration

**Inspection Number:** 1117009  
**Inspection Date(s):** 01/05/2016 - 01/06/2016  
**Issuance Date:** 05/25/2016



**Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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4) OSHA pamphlet 3133 Process Safety Management Guidelines for Compliance, [www.osha.gov](http://www.osha.gov).

**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

Date By Which Violation Must be Abated:

10/06/2016

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.



**Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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**Citation 1 Item 15** Type of Violation: **Serious**

29 CFR 1910.119(n): The employer did not establish and implement an emergency action plan for the entire plant in accordance with the provisions of 29 CFR 1910.38. In addition, the emergency action plan did not include procedures for handling small releases. The employer was also subject to the hazardous waste and emergency response provisions contained in 29 CFR 1910.120(q).

a) On or about December 1, 2015, and at times prior thereto, the employers emergency plan was not adequately implemented in that maintenance employees had not been fully trained prior to responding to an ammonia release and were exposed to unknown concentrations.

OR IN THE ALTERNATIVE:

OSHA ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to the hazards of anhydrous ammonia because the employer had not implemented an emergency action plan.

NOTE: Abatement certification and documentation are required for this item.

Abatement Note: Recommended abatement measures for this item shall include compliance with the following consensus standards and accepted industry practice. A link to a related OSHA pamphlet is also provided.

- 1) ASHRAE 15 2007, Safety Standard for Refrigeration Systems.
- 2) ANSI/IIAR-2-2008, Equipment, Design, and Installation of Closed-Circuit Ammonia Mechanical Refrigeration Systems.
- 3) Industrial Refrigeration Course IV, Plant Operation and Safety, Refrigerating Engineers and Technicians Association, 2002.
- 4) OSHA pamphlet 3133 Process Safety Management Guidelines for Compliance,

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**U.S. Department of Labor**  
Occupational Safety and Health Administration

**Inspection Number:** 1117009  
**Inspection Date(s):** 01/05/2016 - 01/06/2016  
**Issuance Date:** 05/25/2016



**Citation and Notification of Penalty**

**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448

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[www.osha.gov](http://www.osha.gov).

**ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM**

Date By Which Violation Must be Abated:  
Proposed Penalty:

10/06/2016  
\$7000.00

A handwritten signature in blue ink, appearing to read "D. Kearns", written over a horizontal line.

**David G. Kearns**  
Area Director

See pages 1 through 4 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.

**U.S. Department of Labor**  
Occupational Safety and Health Administration  
1387 S. Vinnell Way  
Suite 218  
Boise, ID 83709  
Phone: 208-321-2960 Fax: 208-321-2966



## INVOICE / DEBT COLLECTION NOTICE

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**Company Name:** Dickinson Frozen Foods, Inc.  
**Inspection Site:** 903 E. 3000 North, Sugar City, ID 83448  
**Issuance Date:** 05/25/2016

<b>Summary of Penalties for Inspection Number</b>	<b>1117009</b>
<b>Citation 1, Serious</b>	<b>\$105000.00</b>
<b>TOTAL PROPOSED PENALTIES</b>	<b>\$105000.00</b>

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To avoid additional charges, please remit payment promptly to this Area Office for the total amount of the uncontested penalties summarized above. Make your check or money order payable to: "DOL-OSHA". Please indicate OSHA's Inspection Number (indicated above) on the remittance. You can also make your payment electronically on [www.pay.gov](http://www.pay.gov). On the left side of the pay.gov homepage, you will see an option to Search Public Forms. Type "OSHA" and click Go. From the results, click on **OSHA Penalty Payment Form**. The direct link is <https://www.pay.gov/paygov/forms/formInstance.html?agencyFormId=53090334>. You will be required to enter your inspection number when making the payment. Payments can be made by credit card or Automated Clearing House (ACH) using your banking information. Payments of \$25,000 or more require a Transaction ID, and also must be paid using ACH. If you require a Transaction ID, please contact the OSHA Debt Collection Team at (202) 693-2170.

OSHA does not agree to any restrictions or conditions or endorsements put on any check, money order, or electronic payment for less than the full amount due, and will cash the check or money order as if these restrictions or conditions do not exist.

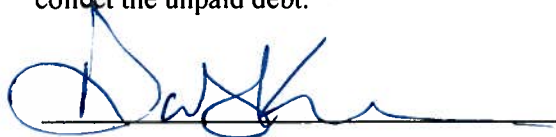
If a personal check is issued, it will be converted into an electronic fund transfer (EFT). This means that our bank will copy your check and use the account information on it to electronically debit your account for the amount of the check. The debit from your account will then usually occur within 24 hours and will be shown on your regular account statement. You will not receive your original check back. The bank will destroy your original check, but will keep a copy of it. If the EFT cannot be completed because of insufficient funds or closed account, the bank will attempt to make the transfer up to 2 times.

Pursuant to the Debt Collection Act of 1982 (Public Law 97-365) and regulations of the U.S. Department of Labor (29 CFR Part 20), the Occupational Safety and Health Administration is required to assess interest, delinquent charges, and administrative costs for the collection of delinquent penalty debts for violations of the Occupational Safety and Health Act.

**Interest:** Interest charges will be assessed at an annual rate determined by the Secretary of the Treasury on all penalty debt amounts not paid within one month (30 calendar days) of the date on which the debt amount becomes due and payable (penalty due date). The current interest rate is one percent (1%). Interest will accrue from the date on which the penalty amounts (as proposed or adjusted) become a final order of the Occupational Safety and Health Review Commission (that is, 15 working days from your receipt of the Citation and Notification of Penalty), unless you file a notice of contest. Interest charges will be waived if the full amount owed is paid within 30 calendar days of the final order.

**Delinquent Charges:** A debt is considered delinquent if it has not been paid within one month (30 calendar days) of the penalty due date or if a satisfactory payment arrangement has not been made. If the debt remains delinquent for more than 90 calendar days, a delinquent charge of six percent (6%) per annum will be assessed accruing from the date that the debt became delinquent.

**Administrative Costs:** Agencies of the Department of Labor are required to assess additional charges for the recovery of delinquent debts. These additional charges are administrative costs incurred by the Agency in its attempt to collect an unpaid debt. Administrative costs will be assessed for demand letters sent in an attempt to collect the unpaid debt.



**David G. Kearns**

Area Director

May 25, 2016

Date