

U.S. Department of Labor
Occupational Safety and Health Administration
1141 Montlimar Drive
Suite 1006
Mobile, AL 36609
Phone: 251-441-6131 Fax: 251-441-6396



Citation and Notification of Penalty

To:
Keystone Foods, dba Equity Group Eufaula Division,
LLC
57 Melvin Clark Rd.
Bakerhill, AL 36027

Inspection Number: 1131939
Inspection Date(s): 03/09/2016 - 03/11/2016
Issuance Date: 09/01/2016

Inspection Site:
57 Melvin Clark Rd.
Bakerhill, AL 36027

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. 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. 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 09/01/2016. The conference will be held by telephone or at the OSHA office located at 1141 Montlimar Drive, Suite 1006, Mobile, AL 36609 on _____ at _____.

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

CERTIFICATION OF CORRECTIVE ACTION WORKSHEET

Inspection Number: 1131939

Company Name: Keystone Foods, dba Equity Group Eufaula Division, LLC
Inspection Site: 57 Melvin Clark Rd., Bakerhill, AL 36027
Issuance Date: 09/01/2016

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, 1141 Montlimar Drive, Suite 1006, Mobile, AL 36609**

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

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

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Citation and Notification of Penalty

Company Name: Keystone Foods, dba Equity Group Eufaula Division, LLC
Inspection Site: 57 Melvin Clark Rd., Bakerhill, AL 36027

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

29 CFR 1910.23(a)(2): Ladderway floor opening(s) or platform(s) were not guarded by a standard railing with standard toeboard(s) on all exposed sides (except at the entrance to opening) with passage through the railing either provided with a swinging gate or so offset that a person could walk directly into the opening:

a) Stunner stand area: On or about March 9, 20146 and at times prior; the employer exposed employees to a 58" (4'-10") fall hazard in that employees were allowed to walk and/or work on a platform with an unguarded portion in front of the access ladder.

Date By Which Violation Must be Abated:
Proposed Penalty:

Quick Fix Applied
\$3862.00

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
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Company Name: Keystone Foods, dba Equity Group Eufaula Division, LLC
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Citation 1 Item 2 Type of Violation: **Serious**

29 CFR 1910.23(a)(5): Every pit and floor opening was not adequately guarded by standard railing or any other effected means:

a) Waste water pit floor opening: On or about March 9, 2016 and at times prior; the employer exposed employees to a 132" (11') fall hazard in that employees were allowed to walk and/or work next to an unguarded pit floor opening when performing task such as cleaning the area.

Date By Which Violation Must be Abated:
Proposed Penalty:

Quick Fix Applied
\$3862.00

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Company Name: Keystone Foods, dba Equity Group Eufaula Division, LLC
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Citation 1 Item 3 Type of Violation: **Serious**

29 CFR 1910.24(h): Standard railings were not provided on the open sides of all exposed stairways and stair platforms:

a) Water treatment plant area: On or about March 9, 2016 and at times prior to; the employer exposed employees to fall hazards of up to 126" (10'-6") in that employees were allowed to ascend/descend stairs leading to the upper area of the electrical room that were not equipped with a intermediate rail in one side.

Date By Which Violation Must be Abated:
Proposed Penalty:

Quick Fix Applied
\$3862.00

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Company Name: Keystone Foods, dba Equity Group Eufaula Division, LLC
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Citation 1 Item 4 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) Engine Room (Processing Plant); On or about March 9, 2016 and at times prior, the employer did not ensure that the exit doors opening to the outside of the engine room were tight fitting doors as specified in IIAR 2-2008 Standard Section 13 (Machinery Room Design) which states each refrigerating machinery room shall have a tight-fitting door or doors opening outward.

Date By Which Violation Must be Abated:
Proposed Penalty:

Quick Fix Applied
\$6436.00

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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Company Name: Keystone Foods, dba Equity Group Eufaula Division, LLC
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Citation 1 Item 5 Type of Violation: **Serious**

29 CFR 1910.119(e)(3)(v): The process hazard analysis did not address the hazards related to facility siting:

a) On or about March 9, 2016 and at times prior; the employer did not ensure the Process Hazards Analysis (PHA) addressed facility siting regarding any hazards related to the propane tanks (approx. 18,000 gallons) which might affect a release of ammonia from the PSM-covered process.

Date By Which Violation Must be Abated:
Proposed Penalty:

09/21/2016
\$4543.00

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: Keystone Foods, dba Equity Group Eufaula Division, LLC
Inspection Site: 57 Melvin Clark Rd., Bakerhill, AL 36027

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

29 CFR 1910.119(j)(4)(iii): The frequency of inspections and tests of process equipment shall be consistent with applicable manufacturers' recommendations and good engineering practices, and more frequently if determined to be necessary by prior operating experience.

a) Engine Room (Processing Plant): On or About March 9, 2016 and at times prior; the employer did not ensure that the ammonia detectors in the engine room were calibrated following the manufacturer's recommendations.

a) Engine Room (Cook Plant): On or About March 9, 2016 and at times prior; the employer did not ensure that the ammonia detectors in the engine room were calibrated following the manufacturer's recommendations.

Date By Which Violation Must be Abated:
Proposed Penalty:

Quick Fix Applied
\$6436.00

U.S. Department of Labor
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Company Name: Keystone Foods, dba Equity Group Eufaula Division, LLC
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Citation 1 Item 7 Type of Violation: **Serious**

29 CFR 1910.119(n): The employer shall 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 shall include procedures for handling small releases.

a) On or about March 9, 2016 and at times prior; the employer's emergency action plan did not include procedures for handling small ammonia releases.

Date By Which Violation Must be Abated:
Proposed Penalty:

Quick Fix Applied
\$6436.00

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
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Citation and Notification of Penalty

Company Name: Keystone Foods, dba Equity Group Eufaula Division, LLC
Inspection Site: 57 Melvin Clark Rd., Bakerhill, AL 36027

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

29 CFR 1910.133(a)(1): Protective eye equipment was not required where there was a reasonable probability of injury that could be prevented by such equipment

a) Sanitation: On or about March 9, 2016 and at times prior, the employer failed to enforce the use of eye protection where employees were exposed to hazards from foreign objects and/or chemicals such as but not limited to CHEM 3390 used during the sanitation process.

Date By Which Violation Must be Abated:
Proposed Penalty:

09/21/2016
\$6057.00

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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Issuance Date: 09/01/2016



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Company Name: Keystone Foods, dba Equity Group Eufaula Division, LLC
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Citation 1 Item 9 Type of Violation: **Serious**

29 CFR 1910.147(d)(2): The machine or equipment was not turned off or shut down using the procedures established for the machine or equipment:

a) Flour breader (pre-duster); On or about March 9, 2016 and at times prior, the employer exposed his employees to potential hazardous energies in that employees were allowed to perform cleaning and sanitation procedures on the flour breader (pre-duster) without locking it out to prevent the accidental start-up of the machine.

Date By Which Violation Must be Abated:
Proposed Penalty:

Quick Fix Applied
\$12471.00

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
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Citation and Notification of Penalty

Company Name: Keystone Foods, dba Equity Group Eufaula Division, LLC
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Citation 1 Item 10 Type of Violation: **Serious**

29 CFR 1910.151(c): Where employees were exposed to injurious corrosive materials, suitable facilities for quick drenching or flushing of the eyes and body were not provided within the work area for immediate emergency use:

a) Fresh plant (back dock): On or about March 9, 2016 and at times prior; employees handling, walking by and/or working next to the Sodium hypochlorite tank (corrosive chemical) were not provided with a functional eye and body wash station.

Date By Which Violation Must be Abated:
Proposed Penalty:

Quick Fix Applied
\$5149.00

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: Keystone Foods, dba Equity Group Eufaula Division, LLC
Inspection Site: 57 Melvin Clark Rd., Bakerhill, AL 36027

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

29 CFR 1910.212(a)(3)(ii): Point(s) of operation of machinery were not guarded to prevent employee(s) from having any part of their body in the danger zone(s) during operating cycle(s):

- a) Processing Plant: On or About March 9, 2016 and at times prior; the employer exposed employees to amputation hazards due to being allowed to walk and/or work next to an unprotected saw.

- b) Strapper machine: On or about March 9, 2016 and at times prior; the employer failed to ensure the strapper machine was guarded to protect employees from caught-in and crushing hazards.

Date By Which Violation Must be Abated:
Proposed Penalty:

Quick Fix Applied
\$12471.00

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

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Issuance Date: 09/01/2016



Citation and Notification of Penalty

Company Name: Keystone Foods, dba Equity Group Eufaula Division, LLC
Inspection Site: 57 Melvin Clark Rd., Bakerhill, AL 36027

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

29 CFR 1910.303(b)(1): Electrical equipment was not free from recognized hazards that were likely to cause death or serious physical harm to employees:

a) Engine Room (Processing Plant) On or about March 9, 2016 and at times prior; the employer exposed employees to electrical hazards in that employees were allowed to walk and work next to an electrical outlet with live parts exposed.

Date By Which Violation Must be Abated:
Proposed Penalty:

Quick Fix Applied
\$5149.00

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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Citation and Notification of Penalty

Company Name: Keystone Foods, dba Equity Group Eufaula Division, LLC
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Citation 2 Item 1 Type of Violation: **Other-than-Serious**

29 CFR 1910.1030(d)(2)(i): Engineering and work practice controls shall be used to eliminate or minimize employee exposure. Where occupational exposure remains after institution of these controls, personal protective equipment shall also be used.

a) On March 9, 2016 and at times prior; the employer exposed employee(s) to bloodborne pathogen hazards that could cause diseases by not providing and requiring that employees use safety engineered needles.

Date By Which Violation Must be Abated:
Proposed Penalty:

Quick Fix Applied
\$0.00



Joseph Roesler
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
1141 Montlimar Drive
Suite 1006
Mobile, AL 36609
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INVOICE / DEBT COLLECTION NOTICE

Company Name: Keystone Foods, dba Equity Group Eufaula Division, LLC
Inspection Site: 57 Melvin Clark Rd., Bakerhill, AL 36027
Issuance Date: 09/01/2016

Summary of Penalties for Inspection Number	1131939
Citation 1, Serious	\$76734.00
Citation 2, Other-than-Serious	\$0.00
TOTAL PROPOSED PENALTIES	\$76734.00

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. 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

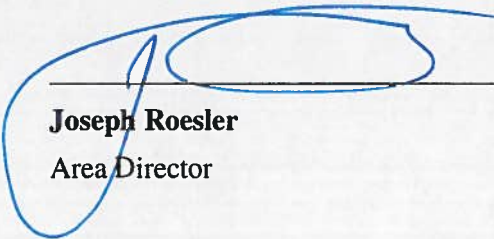
account, the bank will attempt to make the transfer up to 2 times.

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.



Joseph Roesler
Area Director

9/1/2016

Date