

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

Inspection Number: 551899
Inspection Date(s): 08/01/2012 - 01/31/2013
Issuance Date: 02/01/2013



Citation and Notification of Penalty

Company Name: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

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

29 CFR 1910.22(a)(1): All places of employment, passageways, storerooms or service rooms were not kept clean and orderly or in a sanitary condition.

Employees were exposed to slip hazards created by sand accumulations in the basement sand reclamation area.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:
Proposed Penalty:

02/15/2013
\$5500.00

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

29 CFR 1910.23(a)(5): Every pit and trapdoor floor opening infrequently used was not guarded by a floor opening cover of standard strength and construction. While the cover was not in place, the pit or trap opening was not constantly attended by someone or was not protected on all exposed sides by removable standard railings.

The floor opening near the bucket elevator was not guarded by a standard railing.

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

29 CFR 1910.24(f): All treads were not reasonably slip-resistant and the nosings were not of nonslip finish. Rise height and tread width were not uniform throughout any flight of stairs including any foundation structure used as one or more treads of the stairs.

- a) Where employees were using concrete stairs to enter the basement, in 3 areas, the stair treads and nosings were not slip resistant due to a layer of sand on the concrete.
- b) Where employees were using metal stairs to access the QJS pour deck, the stair rise height was not uniform.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

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03/04/2013
\$5500.00

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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 4 a Type of Violation: **Serious**

29 CFR 1910.27(b)(1)(iii): The minimum clear length of rungs or cleats was not 16 inches.

The ladder accessing the Sinto Autopour platform was less than 16 inches wide.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:
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02/25/2013
\$7000.00

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

29 CFR 1910.36(g)(1): The ceiling of an exit route was not at least seven feet six inches (2.3 m) high. Any projection from the ceiling did reach a point less than six feet eight inches (2.0 m) from the floor.

The pipe projection from the ceiling above the Sinto Autopour platform was less than six feet eight inches from the floor of the platform.

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

29 CFR 1910.37(a)(3): Exit routes were not free and unobstructed.

The exit route for the Sinto Autopour operator included climbing a ladder, ducking under a low hanging pipe, and weaving through raw materials and equipment that obstructed the exit.

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

29 CFR 1910.28(a)(1): Scaffolds were not furnished and erected in accordance with this standard for persons engaged in work that cannot be done safely from the ground or from solid construction.

On or about November 23, 2012, employees performing lancing and chipping in the cupola while standing on tuyeres were exposed to fall hazards of approximately 15 feet.

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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 6 a Type of Violation: **Serious**

29 CFR 1910.94(a)(3)(i)(a): All air inlets and access openings were not baffled or so arranged that by the combination of inward air flow and baffling the escape of abrasive or dust particles into an adjacent work area would be minimized and visible spurts of dust would not be observed.

Employees working near the continuous blast were exposed to leaking shot.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

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

29 CFR 1910.94(a)(7): Aisles and walkways were not kept clear of steel shot or similar abrasive which may create a slipping hazard:

Employees working near continuous blast were exposed to slip hazards due to the accumulation of steel shot on the floor.

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

29 CFR 1910.132(c): All personal protective equipment was not of safe design and construction for the work to be performed:

Where employees were working with molten metal, the employer provided spats and face shields that were not rated for molten metal splash hazards.

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Company Name: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

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

29 CFR 1910.133(a)(1): The employer did not ensure that each affected employee used appropriate eye or face protection when exposed to eye or face hazards from flying particles, molten metal, liquid chemicals, acids or caustic liquids, chemical gases or vapors, or potentially injurious light radiation:

- a) Where employees working in the core rooms were using chemicals including, but not limited to: dimethylethylamine (DMEA), the employer did not ensure that employees used face protection.
- b) Where employees working in the melt department were exposed to molten metal, the face shields provided were not rated for molten metal and were damaged.

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Company Name: Grede Wisconsin Subsidiaries, LLC
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Citation 1 Item 7 c Type of Violation: **Serious**

29 CFR 1910.138(a): The employer did not select and require employees' to use appropriate hand protection when employees' hands were exposed to hazards such as those from skin absorption of harmful substances; severe cuts or lacerations; severe abrasion; punctures; chemical burns; thermal burns; and harmful temperature extremes:

On or about October 4, 2012, an employee entering the space below the QJS pour deck was not wearing gloves.

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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 8 a Type of Violation: **Serious**

29 CFR 1910.134(d)(1)(i): Selection of appropriate respirators was not based on the respiratory hazard(s) to which the worker was exposed and user factors that affect respirator performance and reliability:

Half mask filtering facepiece respirators were allowed to be used in conditions that exceeded the MUC (maximum use concentration) for exposures to respirable crystalline silica. Employees performed cleaning activities in the basement sand reclamation area where exposures to respirable crystalline silica were measured to exceed the APF (assigned protection factor) for half mask filtering facepiece respirators. Working conditions required employees to frequently replace respirators due to excess loading of the filters.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

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

29 CFR 1910.134(d)(3)(i)(B)(1): The employer did not select a respirator for employee use that maintained the employee's exposure to the hazardous substance, when measured outside the respirator, at or below the maximum use concentration:

Half mask filtering facepiece respirators were allowed to be used in conditions that exceeded the MUC (maximum use concentration) for exposures to respirable crystalline silica. Employee's performed cleaning activities in the basement sand reclamation area where exposures to respirable crystalline silica were measured to exceed to the APF (assigned protection factor) for half mask filtering facepiece respirators.

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

29 CFR 1910.134(d)(1)(iii): The employer did not identify and evaluate the respiratory hazard(s) in the workplace; including a reasonable estimate of employee exposures to respiratory hazard(s) and identification of the contaminant's chemical state and physical form:

- a) Where employees enter the basement sand reclamation area for cleaning purposes, the employer did not estimate the employee's exposure to crystalline silica hazards.
- b) Where employees in core room 2 and core room 3 were working with dimethylethylamine (DMEA), the employer did not estimate the employee's exposure to respiratory hazards.
- c) Where employees were performing lancing and chipping in the cupola, the employer did not estimate the employee's exposure to respiratory hazards including, but not limited to: crystalline silica and metal fumes.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

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Company Name: Grede Wisconsin Subsidiaries, LLC
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Citation 1 Item 10 Type of Violation: **Serious**

29 CFR 1910.134(e)(1): The employer did not provide a medical evaluation to determine the employee's ability to use a respirator, before the employee was fit tested or required to use the respirator in the workplace:

The employer did not provide a medical evaluation prior to respirator usage where a melt utility employee was required to wear a full face respirator while working in the basement sand reclamation area.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

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Company Name: Grede Wisconsin Subsidiaries, LLC
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Citation 1 Item 11 Type of Violation: **Serious**

29 CFR 1910.134(f)(2): Employee(s) using tight-fitting facepiece respirators were not fit tested whenever a different respirator facepiece (size, style, model or make) was used:

A melt utility employee using a half mask filtering face piece N95 respirator was not fit tested.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

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

29 CFR 1910.134(f)(5): The fit test was not administered using an OSHA-accepted qualitative fit test or quantitative fit test protocol:

Employees required to wear half mask filtering face piece N95 respirators and full face air purifying respirators were fit tested with facial hair.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

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Company Name: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

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

29 CFR 1910.134(g)(1)(i)(A): Respirators with tight-fitting facepieces were worn by employees who had facial hair that came between the sealing surface of the facepiece and the face or that interfered with valve function:

On or about October 12, 2012, employees required to wear half mask filtering face piece N95 respirators while cleaning the basement sand reclamation area wore respirators with facial hair that came between the sealing surface of the facepiece and face.

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Company Name: Grede Wisconsin Subsidiaries, LLC
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Citation 1 Item 13 Type of Violation: **Serious**

29 CFR 1910.134(k)(1)(ii): The employer did not ensure that each employee could demonstrate knowledge of what the limitations and capabilities of the respirator were:

Where employees were required to wear respiratory protection while cleaning the basement sand reclamation area, the employer did not ensure each employee knew how to use the respirators required to be worn and the limitations and capabilities of wearing respirators with facial hair.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

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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 14 a Type of Violation: **Serious**

29 CFR 1910.146(c)(1): The employer did not evaluate the workplace to determine if any spaces were permit-required confined spaces:

- a) Where employees were entering the basement sand reclamation area for clean-up and maintenance, the employer did not evaluate the space to determine if it was a permit-required confined space.
- b) Where employees were crawling under the QJS pour deck for clean-up and maintenance, the employer did not evaluate the space to determine if it was a permit-required confined space.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

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Company Name: Grede Wisconsin Subsidiaries, LLC
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Citation 1 Item 14 b Type of Violation: **Serious**

29 CFR 1910.146(c)(2): The employer did not inform exposed employees, by posting danger signs or by any other equally effective means, of the existence and location of and the danger posed by the permit spaces:

Where employees were crawling under the QJS pour deck for clean-up and maintenance, the employer did not post a danger sign or inform employees using other means of the existence and location of the permit spaces.

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

29 CFR 1910.146(d)(1): Under the permit-required confined space program required by 29 CFR 1910.146(c)(4), the employer did not implement the measures necessary to prevent unauthorized entry:

Where employees entered the tilt pan pit/skip charge bucket for cleaning purposes, the employer did not implement measures to prevent unauthorized entry of other employees.

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

29 CFR 1910.146(d)(4)(vi): Under the permit-required confined space program required by 29 CFR 1910.146(c)(4), the employer did not provide, at no cost to the employees, barriers and shields as required by 29 CFR 1910.146(d)(3)(iv):

Where employees were entering the tilt pan pit/skip charge bucket, the employer did not provide pedestrian barriers to protect entrants from external hazards.

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Citation 1 Item 16 a Type of Violation: **Serious**

29 CFR 1910.146(d)(3): Under the permit-required confined space program required by 29 CFR 1910.146(c)(4), the employer did not develop and implement the means, procedures, and practices necessary for safe permit space entry operations:

- a) Where employees enter the space under the QJS pour deck for cleaning and maintenance, the employer did not develop and implement procedures for safe entry operations including, but not limited to: specifying acceptable entry conditions, use of lighting equipment, use of personal protective equipment, isolation of mechanical hazards, and verifying conditions in the space are acceptable for entry and throughout the duration of the entry.
- b) Where employees are entering the tilt pan pit for cleanup, the employer did not implement procedures for safe entry operations including, but not limited to: specifying acceptable entry conditions, prevention of unauthorized entry, isolation of mechanical hazards and verifying conditions in the space are acceptable for entry and throughout the duration of the entry.
- c) Where employees are entering the cupola for maintenance, the employer did not implement procedures for safe entry operations including, but not limited to: specifying acceptable entry conditions, the use of personal protective equipment, atmospheric testing equipment, the use of rescue equipment, isolation of mechanical hazards, and verifying conditions in the space are acceptable for entry and throughout the duration of the entry.

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Citation 1 Item 16 b Type of Violation: **Serious**

29 CFR 1910.146(d)(4)(i): Under the permit-required confined space program required by 29 CFR 1910.146(c)(4), the employer did not provide, at no cost to the employees, testing and monitoring equipment needed to comply with 29 CFR 1910.146(d)(5):

- a) On or about October 19, 2012, employees entering the cupola were not provided air monitoring equipment.
- b) On or about November 23, 2012, employees entering the cupola were not provided air monitoring equipment.

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Citation 1 Item 16 c Type of Violation: **Serious**

29 CFR 1910.146(d)(4)(v): Under the permit-required confined space program required by 29 CFR 1910.146(c)(4), the employer did not ensure that lighting equipment needed to enable employees to see well enough to work safely and to exit the space quickly in an emergency:

Where employees are entering the space below the QJS pour deck for clean-up and maintenance, the employer did not provide lighting equipment.

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Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

Citation 1 Item 16 d Type of Violation: **Serious**

29 CFR 1910.146(d)(4)(viii): Under the permit-required confined space program required by 29 CFR 1910.146(c)(4), the employer did not provide rescue and emergency equipment needed to comply with 29 CFR 1910.146(d)(9):

Where employees are entering permit required confined spaces including, but not limited to: the cupola and tilt pan pit, the employer did not provide rescue equipment to facilitate non entry rescue.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:

02/15/2013

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: 551899
Inspection Date(s): 08/01/2012 - 01/31/2013
Issuance Date: 02/01/2013



Citation and Notification of Penalty

Company Name: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

Citation 1 Item 16 e Type of Violation: **Serious**

29 CFR 1910.146(d)(5)(i): Under the permit-required confined space program required by 29 CFR 1910.146(c)(4), the employer did not evaluate permit space conditions when entry operations were conducted by testing conditions in the permit space to determine if acceptable entry conditions existed before entry was authorized to begin:

On or about November 23, 2012, the employer did not test conditions via air monitoring inside the cupola before employees were authorized to enter the space.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:

02/15/2013

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: 551899
Inspection Date(s): 08/01/2012 - 01/31/2013
Issuance Date: 02/01/2013



Citation and Notification of Penalty

Company Name: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

Citation 1 Item 16 f Type of Violation: **Serious**

29 CFR 1910.146(d)(6): Under the permit-required confined space program required by 29 CFR 1910.146(c)(4), the employer did not provide at least one attendant outside the permit space into which entry was authorized for the duration of entry operations:

Where employees are entering permit required confined spaces including, but not limited to: the tilt pan pit/skip charge bucket and the space under the QJS pour deck, the employer did not provide an attendant.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:

02/15/2013

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: 551899
Inspection Date(s): 08/01/2012 - 01/31/2013
Issuance Date: 02/01/2013



Citation and Notification of Penalty

Company Name: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

Citation 1 Item 17 Type of Violation: **Serious**

29 CFR 1910.146(e)(1): Before entry was authorized, the employer did not document the completion of measures required by 29 CFR 1910.146(d)(3) by preparing an entry permit:

- a) On or about October 4, 2012, prior to employee(s) entering the space under the QJS pour deck for cleanup and maintenance purposes, the employer did not prepare an entry permit.
- b) On or about November 7, 2012, prior to employee(s) entering the tilt pan pit/skip charge bucket, the employer did not prepare an entry permit.
- c) On or about November 9, 2012, prior to employee(s) entering the tilt pan pit/skip charge bucket, the employer did not prepare an entry permit.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:
Proposed Penalty:

02/25/2013
\$7000.00

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

Inspection Number: 551899
Inspection Date(s): 08/01/2012 - 01/31/2013
Issuance Date: 02/01/2013



Citation and Notification of Penalty

Company Name: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

Citation 1 Item 18 Type of Violation: **Serious**

29 CFR 1910.146(g)(1): The employer did not provide training so that all employees whose work was regulated by 29 CFR 1910.146 (permit required confined spaces) acquired the understanding, knowledge, and skills necessary for the safe performance of the duties assigned under 29 CFR 1910.146:

Where a melt utility employee entered the tilt pan pit/skip charge bucket and cupola for clean-up and maintenance, the employer did not provide training on permit required confined spaces.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:
Proposed Penalty:

02/15/2013
\$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: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

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 19 a Type of Violation: **Serious**

29 CFR 1910.147(c)(4)(ii)(B): The energy control procedures did not clearly and specifically outline the specific procedural steps for shutting down, isolating, blocking and securing machines or equipment to control hazardous energy:

- a) Hazardous energy control procedures did not address steps for locating and activating energy isolating devices for equipment such as a molding machine and the tilt pan.
- b) Energy control procedures for the tilt pan and the charge bucket did not address the need to isolate gravity hazards.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:
Proposed Penalty:

02/15/2013
\$7000.00

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

Inspection Number: 551899
Inspection Date(s): 08/01/2012 - 01/31/2013
Issuance Date: 02/01/2013



Citation and Notification of Penalty

Company Name: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

Citation 1 Item 19 b Type of Violation: **Serious**

29 CFR 1910.147(c)(4)(ii)(C): The energy control procedure did not clearly and specifically outline the specific procedural steps for placement, removal and transfer of lockout devices or tagout devices and the responsibility for them:

Hazardous energy control procedures did not address steps for the placement of locks on energy isolating devices for equipment such as but not limited to: a molding machine and tilt pan.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:

02/25/2013

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: 551899
Inspection Date(s): 08/01/2012 - 01/31/2013
Issuance Date: 02/01/2013



Citation and Notification of Penalty

Company Name: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

Citation 1 Item 20 Type of Violation: **Serious**

29 CFR 1910.147(c)(7)(i): The employer did not provide training to ensure that the purpose and function of the energy control program was understood by employees and that the knowledge and skills required for the safe application, usage, and removal of the energy controls were acquired by employees:

Where employees were performing servicing and maintenance activities such as cleaning and set-up work, the employer did not provide training on the energy control program including, but not limited to the usage of energy isolating devices.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:
Proposed Penalty:

02/15/2013
\$7000.00

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

Inspection Number: 551899
Inspection Date(s): 08/01/2012 - 01/31/2013
Issuance Date: 02/01/2013



Citation and Notification of Penalty

Company Name: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

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 21 a Type of Violation: **Serious**

29 CFR 1910.147(d)(3): All energy isolating devices that were needed to control the energy to the machine or equipment were not physically located and operated in such a manner as to isolate the machine or equipment from the energy source(s):

Energy isolating devices were not operated during servicing and maintenance activities on equipment such as but not limited to: the tilt pan, a molding machine, and mold cart lifts.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:
Proposed Penalty:

02/15/2013
\$7000.00

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

Inspection Number: 551899
Inspection Date(s): 08/01/2012 - 01/31/2013
Issuance Date: 02/01/2013



Citation and Notification of Penalty

Company Name: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

Citation 1 Item 21 b Type of Violation: **Serious**

29 CFR 1910.147(d)(5)(i): All potentially hazardous stored or residual energy was not relieved, disconnected, restrained or otherwise rendered safe following the application of lockout or tagout devices to energy isolating devices:

The charge bucket and tilt pan were not secured by isolating means during servicing and maintenance.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:

02/15/2013

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: 551899
Inspection Date(s): 08/01/2012 - 01/31/2013
Issuance Date: 02/01/2013



Citation and Notification of Penalty

Company Name: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

Citation 1 Item 22 Type of Violation: **Serious**

29 CFR 1910.178(l)(4)(ii)(B): Refresher training in relevant topics was not provided to the operator when the operator had been involved in an accident or near-miss incident:

On or about September 17, 2012 a forklift operator was involved in a driving incident resulting in property damage to a doorway and the operator was not provided refresher training.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:
Proposed Penalty:

02/25/2013
\$5500.00

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

Inspection Number: 551899
Inspection Date(s): 08/01/2012 - 01/31/2013
Issuance Date: 02/01/2013



Citation and Notification of Penalty

Company Name: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

Citation 1 Item 23 Type of Violation: **Serious**

29 CFR 1910.212(a)(1): One or more methods of machine guarding was not provided to protect the operator and other employees in the machine area from hazards such as those created by point of operation, ingoing nip points, rotating parts, flying chips and sparks:

Employees walking through the QJS pour deck area were exposed to sparks created during the pouring of molten metal.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:
Proposed Penalty:

03/04/2013
\$4400.00

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

Inspection Number: 551899
Inspection Date(s): 08/01/2012 - 01/31/2013
Issuance Date: 02/01/2013



Citation and Notification of Penalty

Company Name: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

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 24 a Type of Violation: **Serious**

29 CFR 1910.1020(e)(1)(i): Whenever an employee or designated representative requested access to a record, the employer did not assure that access was provided in a reasonable time, place, and manner:

On or about September 16, 2012, the employer did not provide records within a reasonable time frame.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:
Proposed Penalty:

02/15/2013
\$7000.00

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

Inspection Number: 551899
Inspection Date(s): 08/01/2012 - 01/31/2013
Issuance Date: 02/01/2013



Citation and Notification of Penalty

Company Name: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

Citation 1 Item 24 b Type of Violation: **Serious**

29 CFR 1910.1020(g)(1): The employer did not inform current employees upon their first entering in to employment and at least annually thereafter, of the existence, location, and availability of any records covered by 29 CFR 1910.1020:

The employer was in possession of exposure monitoring records for silica, noise, among other hazardous substances, and current employees had not been informed on at least an annual basis of the existence, location, or availability of these records.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:

02/15/2013

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: 551899
Inspection Date(s): 08/01/2012 - 01/31/2013
Issuance Date: 02/01/2013



Citation and Notification of Penalty

Company Name: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

Citation 1 Item 24 c Type of Violation: **Serious**

29 CFR 1910.1200(h)(1): Employees were not provided effective information and training on hazardous chemicals in their work area at the time of their initial assignment and whenever a new hazard that the employees had not been previously trained about was introduced into their work area:

Employees working with chemicals including, but not limited to: crystalline silica, dimethylethylamine and toluene, were not provided effective information and training.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:

02/15/2013

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: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

Citation 2 Item 1 Type of Violation: **Repeat**

29 CFR 1910.147(d)(4)(i): Lockout or tagout devices were not affixed to each energy isolating device by authorized employees:

- a) Where employees were performing work on a core molding machine, Redford Carver #26, energy isolating devices were not used to isolate electrical energy sources.
- b) Where employees were performing servicing and maintenance activities in the tilt pan pit/skip charge bucket, energy isolating devices were not used to isolate electrical energy sources for the tilt pan and skip charge bucket.
- c) Where employees were performing servicing and maintenance activities under the QJS deck, energy isolating devices were not used to isolate electrical energy sources for the mold cart lifts.

Grede Wisconsin Subsidiaries LLC was previously cited for a violation of this Occupational Safety and Health Standard 29 CFR 1910.147(d)(4)(i), which was contained in OSHA Inspection 312557911, Citation Number 01, Item 7b and was affirmed as a final order on December 8, 2010, with respect to a workplace located at 242 S. Pearl St., Berlin, WI 54923-0071.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:
Proposed Penalty:

02/15/2013
\$38500.00

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

Inspection Number: 551899
Inspection Date(s): 08/01/2012 - 01/31/2013
Issuance Date: 02/01/2013



Citation and Notification of Penalty

Company Name: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

Citation 2 Item 2 Type of Violation: **Repeat**

29 CFR 1910.212(a)(1): One or more methods of machine guarding was not provided to protect the operator and other employees in the machine area from hazards such as those created by point of operation, ingoing nip points, rotating parts, flying chips and sparks:

Employees working in the basement sand reclamation area were exposed to unguarded tail pulleys on the conveyer lines.

Grede Wisconsin Subsidiaries LLC. was previously cited for a violation of this Occupational Safety and Health standard 29 CFR 1910.212(a)(1), which was contained in OSHA Inspection Number 312557911, Citation Number 01, Item number 09, and was affirmed as a final order on December 8, 2010, with respect to a workplace located at 242 S. Pearl St., Berlin, WI 54923-0071.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:	02/15/2013
Proposed Penalty:	\$38500.00

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: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

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

Citation 2 Item 3 a Type of Violation: **Repeat**

29 CFR 1910.1000(c): Employee(s) were exposed to an airborne concentration of crystalline quartz silica listed in Table Z-3 in excess of the 8 hour Time Weighted Average concentration of $(10/(\%Si)+2)$:

a) On or about October 12, 2012, an employee cleaning the basement was exposed to respirable dust containing crystalline silica at an 8-hour time weighted average of 11.1 milligrams per cubic meter, approximately 8.1 times the calculated permissible exposure limit of 1.37 milligrams per cubic meter for a sampling containing 5.3% of respirable crystalline silica; this limit is established prevent silicosis. The sample was collected for 330 minutes; exposure calculations include a zero increment for the 150 minutes not sampled.

b) On or about October 12, 2012, an employee cleaning the basement was exposed to respirable dust containing crystalline silica at an 8-hour time weighted average of 9.4 milligrams per cubic meter, approximately 6.8 times the calculated permissible exposure limit of 1.39 milligrams per cubic meter for a sampling containing 5.2% of respirable crystalline silica; this limit is established prevent silicosis. The sample was collected for 290 minutes; exposure calculations include a zero increment for the 190 minutes not sampled.

c) On or about October 12, 2012, an employee cleaning the basement was exposed to respirable dust containing crystalline silica at an 8-hour time weighted average of 3.48 milligrams per cubic meter, approximately 2.12 times the calculated permissible exposure limit of 1.64 milligrams per cubic meter for a sampling containing 4.1% of respirable crystalline silica; this limit is established prevent silicosis. The sample was collected for 288 minutes; exposure calculations include a zero increment for the 192 minutes not sampled.

d) On or about October 12, 2012, an employee cleaning the basement was exposed to respirable dust containing crystalline silica at an 8-hour time weighted average of 8.56 milligrams per cubic meter, approximately 6.16 times the calculated permissible exposure limit of 1.39 milligrams per cubic meter

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: 551899
Inspection Date(s): 08/01/2012 - 01/31/2013
Issuance Date: 02/01/2013



Citation and Notification of Penalty

Company Name: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

for a sampling containing 5.2% of respirable crystalline silica; this limit is established prevent silicosis. The sample was collected for 337 minutes; exposure calculations include a zero increment for the 143 minutes not sampled.

The Grede Wisconsin Subsidiaries LLC was previously cited for a violation of this Occupational Safety and Health Standard 29 CFR 1910.1000(c), which was contained in OSHA Inspection 310769112, Citation Number 01, Item 5a and was affirmed as a final order on May 11, 2009, with respect to a workplace located at N2480 City Hwy M in Browntown, WI 53522.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:
Proposed Penalty:

02/11/2013
\$38500.00

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: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

Citation 2 Item 3 b Type of Violation: **Repeat**

29 CFR 1910.1000(e): Feasible administrative or engineering controls were not determined and implemented to achieve compliance with the limits prescribed in 29 CFR 1910.1000(a) through (d):

- a) On or about October 12, 2012, an employee cleaning the basement was exposed to crystalline silica at an 8-hour time weighted average of 11.1 milligrams per cubic meter, approximately 8.1 times the calculated permissible exposure limit of 1.37 milligrams per cubic meter; this limit is established prevent silicosis. The sample was collected for 330 minutes; exposure calculations include a zero increment for the 150 minutes not sampled.
- b) On or about October 12, 2012, an employee cleaning the basement was exposed to crystalline silica at an 8-hour time weighted average of 9.4 milligrams per cubic meter, approximately 6.8 times the calculated permissible exposure limit of 1.39 milligrams per cubic meter; this limit is established prevent silicosis. The sample was collected for 290 minutes; exposure calculations include a zero increment for the 190 minutes not sampled.
- c) On or about October 12, 2012, an employee cleaning the basement was exposed to crystalline silica at an 8-hour time weighted average of 3.48 milligrams per cubic meter, approximately 2.12 times the calculated permissible exposure limit of 1.64 milligrams per cubic meter; this limit is established prevent silicosis. The sample was collected for 288 minutes; exposure calculations include a zero increment for the 192 minutes not sampled.
- d) On or about October 12, 2012, an employee cleaning the basement was exposed to crystalline silica at an 8-hour time weighted average of 8.56 milligrams per cubic meter, approximately 6.16 times the calculated permissible exposure limit of 1.39 milligrams per cubic meter; this limit is established prevent silicosis. The sample was collected for 337 minutes; exposure calculations include a zero increment for the 143 minutes not sampled.

The Grede Wisconsin Subsidiaries LLC was previously cited for a violation of this Occupational Safety and Health Standard 29 CFR 1910.1000(e), which was contained in OSHA Inspection 310769112, Citation Number 01, Item 5b and was affirmed as a final order on May 11, 2009, with respect to a workplace located at N2480 City Hwy M in Browntown, WI 53522.

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: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

Abatement normally will be multistep as follows:

STEP 1: Effective respiratory protection shall be provide and used by exposed employees as an interim protective measure until feasible engineering and/or administrative controls can be implemented, or whenever such controls fail to reduce employee exposure to within exposure limits.

Abatement due 30 days from issuance date: **March 6, 2013**

STEP 2: Submit to the Area Director a written detailed plan of abatement outlining a schedule for the implementation of engineering and /or administrative measures to control employee exposure to hazardous substance as referenced in this Citation. This plan shall include, at a minimum, target dates for the following actions which must be consistent with the abatement dates required by this Citation:

1. Evaluation of engineering/administrative control options;
2. Selection of optimum control methods and completion of design;
3. Procurement, installation, and operation of selected control measures; and
4. Testing and acceptable or modification/redesign of controls.

All proposed control measures shall be approved for each particular use by a competent industrial hygienist or other technically qualified person.

Abatement due 60 days from issuance date: **April 5, 2013**

Step 3: Abatement shall have been completed by the implementation of feasible engineering and/or administrative controls upon verification of their effectiveness in achieving compliance.

Abatement due 90 days from issuance date: **May 6, 2013**

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: 551899
Inspection Date(s): 08/01/2012 - 01/31/2013
Issuance Date: 02/01/2013



Citation and Notification of Penalty

Company Name: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:

05/06/2013

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: 551899
Inspection Date(s): 08/01/2012 - 01/31/2013
Issuance Date: 02/01/2013



Citation and Notification of Penalty

Company Name: Grede Wisconsin Subsidiaries, LLC
Inspection Site: N2480 Cty Hwy M, Browntown, WI 53522

Citation 3 Item 1 Type of Violation: **Other-than-Serious**

29 CFR 1910.1020(e)(3)(i): The employer did not ensure, upon request, and without derogation of any rights under the Constitution or the Occupational Safety and Health Act of 1970 that the employer chose to exercise, the prompt access of representatives to employee exposure and medical records and/or to analyses using exposure or medical records:

On or about September 18, 2012, prompt access to employee exposure and medical records and analyses of the records were not provided in a reasonable time frame when requested by OSHA representatives.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:
Proposed Penalty:

02/15/2013
\$.00

A handwritten signature in black ink, appearing to read "Kimberly A. Stille", written over a horizontal line.

Kimberly A. Stille
Area Director

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