



Citation and Notification of Penalty

Company Name: Kraft Foods Global, Inc.
Inspection Site: 910 Mayer Avenue, Madison, WI 53704

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

29 CFR 1910.23(b)(3): Window wall opening(s), from which there was a drop of more than 4 feet, and where the bottom of the opening(s) was less than 3 feet above the platform(s) or landing(s), were not guarded by standard slats, standard grill work or standard railings:

Employees closing the wall opening door on the upper level of the Power House by leaning over the top railing were not protected by a mid-railing or its equivalent from a fall hazard of over 9 feet above the lower level.

Date By Which Violation Must be Abated:	Corrected During Inspection
Proposed Penalty:	\$ 5500.00

See pages 1 through 5 of this Citation and Notification of Penalty for information on employer and employee rights and responsibilities.



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Company Name: Kraft Foods Global, Inc.
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Citation 1 Item 2 Type of Violation: **Serious**

29 CFR 1910.119(d)(3)(i)(B): Process safety information pertaining to the equipment in the process did not include the piping and instrument diagrams (P&ID'S):

The employer did not develop P&IDs which accurately represent current equipment for the ammonia refrigeration system. Deficiencies include, but are not limited to:

- a) Gauge valve between Transfer Drum tank and 3 way valve (TD FV 01) is not depicted
- b) Three way isolation valve on top of Transfer Drum (TD EV 02) is not depicted;
- c) Three way valve on Transfer Drum (TD 3WV-01) is not depicted;
- d) Solenoid valve on 3 way valve on Transfer Drum (TD 3WSV-01) is not depicted;
- e) Outlet pressure regulator on Transfer Drum (TD PR-01) is not depicted;
- f) Piping associated with the relief system for the Transfer Drum is not depicted;
- g) Hand valve located on the liquid line to the Transfer Drum (unlabeled) is not depicted;
- h) Valve tags for the plate & frame heat exchanger in Snap Cell do not match the labels on the P&IDs;
- i) Strainers are not depicted for Dumper area and Pi²;
- j) Relief system for Chester Jensen's in CLSP is incorrectly depicted as attached to the back suction line;
- k) Relief system piping for CLSP booster compressor is not depicted;
- l) Relief system piping for the Accumulator and DeSuperheater above the CLSP is not depicted;

ABATEMENT CERTIFICATION REQUIRED PER 29 CFR 1903.19(c).

Date By Which Violation Must be Abated:	10/06/2011
Proposed Penalty:	\$ 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 resulting from an accident.

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

29 CFR 1910.119(f)(4): The employer did not develop and implement safe work practices for employees and contractor employees to provide for the control of hazards during operations such as lockout/tagout; confined space entry; opening process equipment or piping; and control over entrance into a facility by maintenance, contractor, laboratory, or other support personnel:

The employer did not implement safe work practices when they did not conduct periodic inspections of the energy control procedures at least annually including, but not limited to, the following procedures:

- a) Lockout/Tagout Procedure for Cooling Unit 526.
- b) Lockout/Tagout Procedure for Cooling Unit 562.
- c) Lockout/Tagout Procedure for JCON II Ice Maker.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:	10/06/2011
Proposed Penalty:	\$ 7000.00

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Citation and Notification of Penalty

Company Name: Kraft Foods Global, Inc.
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Citation 1 Item 3b Type of Violation: **Serious**

29 CFR 1910.147(c)(6)(i): The employer did not conduct a periodic inspection of the energy control procedure at least annually to ensure that the procedure and the requirement of this standard were being followed:

The employer did not conduct periodic inspections of the energy control procedures at least annually including, but not limited to, the following procedures,

- a) Lockout/Tagout Procedure for Cooling Unit 526.
- b) Lockout/Tagout Procedure for Cooling Unit 562.
- c) Lockout/Tagout Procedure for JCON II Ice Maker.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated: 10/06/2011

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

29 CFR 1910.119(i)(2)(iv): The pre-startup safety review did not confirm that prior to the introduction of highly hazardous chemicals to the process, the training of each employee involved in operating a process had been completed:

The employer did not train affected employees prior to the start-up of the plate and frame heat exchanger in the Snap Cell Accumulator room.

Date By Which Violation Must be Abated: Corrected During Inspection
Proposed Penalty: \$ 7000.00



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Company Name: Kraft Foods Global, Inc.
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Citation 1 Item 5 Type of Violation: **Serious**

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

The employer did not implement written procedures during the installation of a back pressure control valve on a flange-bolt assembly.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:	10/06/2011
Proposed Penalty:	\$ 7000.00

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

29 CFR 1910.119(j)(4)(iii): The frequency of inspections and tests of process equipment to maintain its mechanical integrity, was not consistent with applicable manufacturers' recommendations and good engineering practices, or more frequently determined to be necessary by prior operating experience:

The employer failed to inspect and test emergency shutdown systems and controls per the applicable manufacturer's recommendations and recognized and generally accepted good engineering practices.

- a) Ammonia sensors were not calibrated per the manufacturer's recommendations.
- b) The emergency ventilation system for Engine Room #2 was not tested per recognized and generally accepted good engineering practices.
- c) The emergency ventilation system for the CLSP Booster Compressor Room was not tested per recognized and generally accepted good engineering practices.

Date By Which Violation Must be Abated:	Corrected During Inspection
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Company Name: Kraft Foods Global, Inc.
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Citation 1 Item 7 Type of Violation: **Serious**

29 CFR 1910.119(j)(5): The employer did not correct deficiencies in equipment that were outside acceptable limits (as defined by process information in 29 CFR 1910.119(d) before further use or in a safe and timely manner:

The employer did not correct deficiencies in equipment that were outside acceptable limits before further use or in a safe and timely manner.

- a) Pressure relief valve on the CLSP Accumulator was past the 5 year replacement date.
- b) Pressure relief valve on the CLSP Desuperheater was past the 5 year replacement date.

ABATEMENT CERTIFICATION REQUIRED PER 29 CFR 1903.19(c)

Date By Which Violation Must be Abated:	10/06/2011
Proposed Penalty:	\$ 5500.00

Citation 1 Item 8 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:

The employer did not train affected employees prior to the start-up of the AMU-118 in the Jeep Patio.

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Company Name: Kraft Foods Global, Inc.
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Citation 1 Item 9 Type of Violation: **Serious**

29 CFR 1910.119(l)(4): A change covered by 29 CFR 1910.119(l) resulted in a change in the process safety information required by 29 CFR 1910.119(d) and the process information was not updated:

The employer did not update the piping and instrument diagrams (P&IDs) when the installation of Air Make-Up Unit (AMU) 118 was installed which resulted in a change in the process safety information.

- a) AMU 118 oil pot assembly not depicted;
- b) Relief valve #2 RV(2) not depicted;
- c) Unlabeled valve located under AMU 118 not depicted;
- d) Pump-out Valve (POV-AMU 118) not depicted;
- e) Oil Pot Equalization Valve (OPEV-AMU 118) not depicted;
- f) Oil Drain Isolation Valve (ODIV-AMU 118) not depicted;
- g) Oil Drain Valve (ODV-AMU 118) not depicted.

ABATEMENT CERTIFICATION REQUIRED PER 29 CFR 1903.19(c)

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Company Name: Kraft Foods Global, Inc.
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Citation 1 Item 10 Type of Violation: **Serious**

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

The employer did not develop an energy control procedure that clearly and specifically outline the steps for locking out/tagging out machines to control hazardous energy including, but not limited to, the following procedures,

- a) Lockout/Tagout Procedure for Cooling Unit 526.
- b) Lockout/Tagout Procedure for Cooling Unit 562.
- c) Lockout/Tagout Procedure for JCON II Ice Maker.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:	10/06/2011
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Company Name: Kraft Foods Global, Inc.
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Citation 1 Item 11 Type of Violation: **Serious**

29 CFR 1910.212(a)(1): Machine guarding was not provided to protect operators and other employees from hazard(s) created by points of operation, ingoing nip points, and rotating parts and/or flying chips or sparks.

Machines not guarded included the following:

- a) The Alkar packaging department palletizer envelope of movement
- b) IQ 2 machine conveyor belt
- c) Log Curve conveyor belt

ABATEMENT CERTIFICATION REQUIRED PER 29 CFR 1903.19(c).

Date By Which Violation Must be Abated:	10/05/2011
Proposed Penalty:	\$ 5500.00



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Company Name: Kraft Foods Global, Inc.
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Citation 1 Item 12 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):

Points of operation were not guarded on the following equipment:

- a) Ironworker punch end- the plexiglass shield was disconnected on the right side piece, and the punch opening was wider than 1/4".
- b) Combi Packaging System- the opening to the box folding area was not adjustable to the smaller size box being processed and would allow an arm to enter the hazard zone at the point of operation.
- c) Deli Meat Packager- a pinch point was present on each side arm at the inturning roller for the sliced meat.
- d) J Con II Links, Barre-Wiehmilller Thile Technologies packager-Opening at conveyor line as it enters the packaging section is not guarded to prevent reaching into the point of operation.

ABATEMENT CERTIFICATION REQUIRED PER 29 CFR 1903.19(c).

Date By Which Violation Must be Abated:	10/05/2011
Proposed Penalty:	\$ 5500.00

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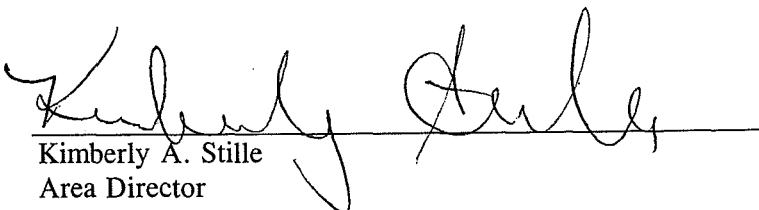
Citation 2 Item 1 Type of Violation: **Other**

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

The employer did not implement procedures to manage changes to the management personnel prior to the change.

- a) Changes to the Facility Manager
- b) Changes to the Powerhouse Supervisor
- c) Changes to the PSM Coordinator

Date By Which Violation Must be Abated:	Corrected During Inspection
Proposed Penalty:	\$ 0.00


Kimberly A. Stille
Area Director

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