



Citation and Notification of Penalty

To:
Vforge, Inc.
and its successors
5567 W. 6th Avenue
Lakewood, CO 80214

Inspection Number: 1304388
Inspection Date(s): 03/23/2018 - 09/13/2018
Issuance Date: 09/20/2018

Inspection Site:
5567 W. 6th Avenue
Lakewood, CO 80214

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 by calling 303-843-4500. 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 09/20/2018. The conference will be held by telephone or at the OSHA office located at 7935 East Prentice Avenue, Suite 209, Greenwood Village, CO 80111 on _____ at _____.

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

CERTIFICATION OF CORRECTIVE ACTION WORKSHEET

Inspection Number: 1304388

Company Name: Vforge, Inc.
Inspection Site: 5567 W. 6th Avenue, Lakewood, CO 80214
Issuance Date: 09/20/2018

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, 7935 East Prentice Avenue, Suite 209, Greenwood Village, CO 80111**

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: Vforge, Inc.
Inspection Site: 5567 W. 6th Avenue, Lakewood, CO 80214

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 1 a Type of Violation: **Serious**

29 CFR 1910.147(c)(4)(ii): Procedures did not clearly and specifically outline the scope, purpose, authorization, rules, and techniques to be utilized for the control of hazardous energy, and the means to enforce compliance including, but not limited to, (c)(4)(ii)[A], (c)(4)(ii)[B], (c)(4)(ii)[C] and (c)(4)(ii)[D]:

a) On or about March 23, 2018, and at times prior, press operators and helpers were exposed to crushing hazards while performing die change, maintenance and set up while utilizing the "SSM Lockout/Tag-out" procedure which was inadequate to inform and protect workers in that its scope, purpose, rules, and means to enforce compliance were not clear, it did not achieve a locked-out condition, and the procedure did not include the following:

1. The intended use, such as including if it should be used for die change and/or other hazardous tasks.
2. Specific procedural steps for electrical isolation of control switches and the hydraulic pump.
3. Specific procedural steps for isolation and lockout of compressed air hazards.
4. Specific procedural steps for the application, removal and transfer of locks.
5. A means to verify or test the effectiveness of the isolation and lockout methods.

b) On or about March 23, 2018, and at times prior, the Lockout Safety Procedure for VFE/SSM (Press 1) did not specifically address transfer of locks and verifying hazardous air pressure was effectively isolated.

Abatement Note: Abatement certification and documentation are required for this item (see enclosed Certification of Corrective Action Worksheet).

ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM

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: 1304388
Inspection Date(s): 03/23/2018 - 09/13/2018
Issuance Date: 09/20/2018



Citation and Notification of Penalty

Company Name: Vforge, Inc.
Inspection Site: 5567 W. 6th Avenue, Lakewood, CO 80214

Date By Which Violation Must be Abated: 09/28/2018
Proposed Penalty: \$9054.00

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: Vforge, Inc.
Inspection Site: 5567 W. 6th Avenue, Lakewood, CO 80214

Citation 1 Item 1 b 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 (see substeps [A], [B], and [C]):

- a) On or about March 23, 2018, and at times prior, managers did not ensure that a periodic inspection was conducted in a timely manner in that the program titled, SSM Lockout / Tag-out had not received an annual review since April 30, 2008.
- b) On or about March 23, 2018, and at times prior, managers did not ensure that the Lockout Safety Procedures, including, but not limited to VFE/SSM (Press 1) for engineering personnel received a timely, annual review in that the binder containing these procedures was most recently inspected on January 10, 2017.
- c) On or about March 23, 2018, and at times prior, managers did not ensure the most recent review of LOTO procedures was performed by a person who does not utilize the specific LOTO procedure, did not identify and correct deficiencies, and did not include a review between the inspector and each authorized employee (see substeps [A], [B], and [C]).

Abatement Note: Abatement certification and documentation are required for this item (see enclosed Certification of Corrective Action Worksheet).

ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM

Date By Which Violation Must be Abated:

10/10/2018



Citation and Notification of Penalty

Company Name: Vforge, Inc.
Inspection Site: 5567 W. 6th Avenue, Lakewood, CO 80214

Citation 1 Item 2 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:

a) SSM presses: On or about March 28, 2018, and at times prior, workers were exposed to severe crushing injuries while routinely entering the area beyond the protective enclosure doors of the IDRA and IDRA Prince presses, including Model OL/320 I PRP; Ser. No.: 7110, during operation in the full automatic mode for tasks including part retrieval and die-cleaning while the presses were fully operational and could cycle unexpectedly due to operator's panel input and/or equipment malfunction.

Abatement Note: Abatement certification and documentation are required for this item (see enclosed Certification of Corrective Action Worksheet).

ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM

Date By Which Violation Must be Abated:	09/28/2018
Proposed Penalty:	\$9054.00



Citation and Notification of Penalty

Company Name: Vforge, Inc.
Inspection Site: 5567 W. 6th Avenue, Lakewood, CO 80214

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 1 a Type of Violation: **Willful**

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 are understood by employees and that the knowledge and skills required for the safe application, usage, and removal of the energy controls are acquired by employees and did not include all the training elements listed under Items A-C of 29 CFR 1910.147(c)(7)(i):

a) SSM Presses: On or about March 23, 2018, and at times prior, workers without the ability to speak, read and/or comprehend the English language were exposed to severe crushing hazards while being untrained or effectively untrained respective to roles, responsibilities and hazards during machine servicing and maintenance due to the employer's Lockout/Tagout training being presented only in English. A worker with almost no ability to communicate in the English language was exposed to crushing injuries while assigned to perform servicing and maintenance on SSM Press 1 prior to receiving any Lockout/Tagout training. The worker sustained fatal injuries.

Abatement Note: Abatement certification and documentation are required for this item (see enclosed Certification of Corrective Action Worksheet).

ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM

Date By Which Violation Must be Abated:	09/28/2018
Proposed Penalty:	\$103469.00



Citation and Notification of Penalty

Company Name: Vforge, Inc.
Inspection Site: 5567 W. 6th Avenue, Lakewood, CO 80214

Citation 2 Item 1 b Type of Violation: **Willful**

29 CFR 1910.147(d)(1): The authorized employees did not have knowledge of the type and magnitude of the energy, the hazards of the energy to be controlled, and the method or means to control the energy before the authorized or affected employees turned off the machine or equipment:

a) SSM Presses: On or about March 23, 2018, and at times prior, workers were not provided with specific information regarding the types and magnitude of hazardous energy, potential hazards and the means to perform a full and effective removal of hazardous energy present in the IDRA and IDRA Prince presses, including Model OL/320 I PRP; Serial No. 7110, such as electrical, mechanical, hydraulic, and pressurized air.

Abatement Note: Abatement certification and documentation are required for this item (see enclosed Certification of Corrective Action Worksheet).

ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM

Date By Which Violation Must be Abated: 09/28/2018



Citation and Notification of Penalty

Company Name: Vforge, Inc.
Inspection Site: 5567 W. 6th Avenue, Lakewood, CO 80214

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 2 a Type of Violation: **Willful**

29 CFR 1910.218(f)(2)(i): Electrical power apparatus to hydraulic forging presses was not locked out when dies were being changed or maintenance was being performed on the presses:

a) SSM presses: On or about March 23, 2018, and at times prior, press operators and trimmers were exposed to severe crushing injuries when they performed die changes on IDRA and IDRA Prince presses, including Model OL/320 I PRP; Serial No 7110, without shutting off and locking out power using the electrical apparatus for the presses. A fatal injury resulted from this condition.

Abatement Note: Abatement certification and documentation are required for this item (see enclosed Certification of Corrective Action Worksheet).

ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM

Date By Which Violation Must be Abated:	09/28/2018
Proposed Penalty:	\$103469.00



Citation and Notification of Penalty

Company Name: Vforge, Inc.
Inspection Site: 5567 W. 6th Avenue, Lakewood, CO 80214

Citation 2 Item 2 b Type of Violation: **Willful**

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 sources:

a) SSM presses: On or about March 23, 2018, and at times prior, press operators and trimmers were exposed to severe crushing injuries while performing die changes on IDRA and IDRA Prince presses, including Model OL/320 I PRP; Serial No. 7110, when the air supply line providing more than 100 p.s.i. air pressure to enclosure door pneumatic actuators was not locked in the closed position and residual pressure bled off.

Abatement Note: Abatement certification and documentation are required for this item (see enclosed Certification of Corrective Action Worksheet).

ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM

Date By Which Violation Must be Abated:

09/28/2018

A handwritten signature in blue ink, appearing to read "David Nelson", is written over a horizontal line.

David Nelson
Area Director

U.S. Department of Labor
Occupational Safety and Health Administration
7935 East Prentice Avenue, Suite 209
Greenwood Village, CO 80111



INVOICE / DEBT COLLECTION NOTICE

Company Name: Vforge, Inc.
Inspection Site: 5567 W. 6th Avenue, Lakewood, CO 80214
Issuance Date: 09/20/2018

Summary of Penalties for Inspection Number	1304388
Citation 1, Serious	\$18108.00
Citation 2, Willful	\$206938.00
TOTAL PROPOSED PENALTIES	\$225046.00

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.



David Nelson

Area Director

9/20/18

Date