

U.S. Department of Labor

Occupational Safety and Health Administration
138 River Road
Suite 102, Shattuck Office Center
Andover, MA 01810
Phone: 978-837-4460 Fax: 978-837-4455



Citation and Notification of Penalty

To:
NEW ENGLAND CONFECTIONERY COMPANY,
Inc.
135 AMERICAN LEGION HIGHWAY
Revere, MA 02151

Inspection Number: 686158
Inspection Date(s): 10/15/2012 - 10/15/2012
Issuance Date: 04/02/2013

Inspection Site:
135 AMERICAN LEGION HIGHWAY
Revere, MA 02151

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 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.

OSHA does not agree to any restrictions or conditions or endorsements put on any check or money order for less than the full amount due, and will cash the check or money order as if these restrictions, conditions, or endorsements 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 04/02/2013. The conference will be held at the OSHA office located at 138 River Road, Suite 102, Shattuck Office Center, Andover, MA 01810 on _____ at _____.

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

CERTIFICATION OF CORRECTIVE ACTION WORKSHEET

Inspection Number: 686158

Company Name: NEW ENGLAND CONFECTIONERY COMPANY, Inc.
Inspection Site: 135 AMERICAN LEGION HIGHWAY, Revere, MA 02151
Issuance Date: 04/02/2013

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, 138 River Road, Suite 102, Shattuck Office Center, Andover, MA 01810**

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: NEW ENGLAND CONFECTIONERY COMPANY, Inc.
Inspection Site: 135 AMERICAN LEGION HIGHWAY, Revere, MA 02151

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

29 CFR 1910.119(d)(3)(i)(B): The employer's piping and instrument diagrams were not accurate and did not represent equipment that was existing and was part of the process.

(a) Location - Facility:

On or about 10/5/12, the supporting valves and piping for a pump out compressor added in 2007 were not represented in the employer's piping and instrument diagrams. The valves and piping were added to equipment including but not limited to the high pressure receiver, the heat exchangers and compressors.

ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM

Date By Which Violation Must be Abated:
Proposed Penalty:

05/17/2013
\$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

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Company Name: NEW ENGLAND CONFECTIONERY COMPANY, Inc.
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Citation 1 Item 2 Type of Violation: **Serious**

29 CFR 1910.119(d)(3)(i)(D): Information pertaining to the equipment in the process did not include a relief system design and design basis.

(a) Location - Facility:

On or about 10/5/12, the information pertaining to the equipment in the process did not include a relief system design and design basis.

ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM

Date By Which Violation Must be Abated:
Proposed Penalty:

05/17/2013
\$7000.00

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U.S. Department of Labor
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Company Name: NEW ENGLAND CONFECTIONERY COMPANY, Inc.
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Citation 1 Item 3 Type of Violation: **Serious**

29 CFR 1910.119(d)(3)(i)(E): Information pertaining to the equipment in the process did not include a ventilation system design.

(a) Location - Ammonia Room:

On or about 10/5/12, the information pertaining to the equipment in the process did not include a ventilation system design.

ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM

Date By Which Violation Must be Abated:
Proposed Penalty:

05/17/2013
\$7000.00

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U.S. Department of Labor
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Company Name: NEW ENGLAND CONFECTIONERY COMPANY, Inc.
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Citation 1 Item 4 Type of Violation: **Serious**

29 CFR 1910.119(e)(3)(ii): The process hazard analysis did not identify any previous incident which had a likely potential for catastrophic consequences in the workplace.

(a) Location - Facility:

The process hazard analysis did not identify a situation where the ammonia coils in the concentrator corroded at a rapid rate and had to be replaced prematurely.

ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM

Date By Which Violation Must be Abated:
Proposed Penalty:

05/17/2013
\$7000.00

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Citation and Notification of Penalty

Company Name: NEW ENGLAND CONFECTIONERY COMPANY, Inc.

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

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

29 CFR 1910.119(f)(1)(i):

The employer did not develop and implement written operating procedures that provided clear instructions for safely conducting activities involved in each covered process consistent with the process safety information that addressed steps for each operating phase.

(a) Location - Facility:

On or about 10/5/12, the employer did not develop and implement written operating procedures that provided clear instructions addressing normal operations for equipment including but not limited to compressors.

(b) Location - Facility:

On or about 10/5/12, the employer did not develop and implement written operating procedures that provided clear instructions addressing temporary operations for equipment including but not limited to pumps, compressors, condensers, air handling units, and heat exchangers.

(c) Location - Facility:

On or about 10/5/12, the employer did not develop and implement written operating procedures that provided clear instructions addressing the assignment of shutdown responsibility to qualified operators to ensure that emergency shutdown is executed in a safe and timely manner for equipment including but not limited to pumps, compressors, condensers, air handling units, and heat exchangers.

(d) Location - Facility:

On or about 10/5/12, the employer did not develop and implement written operating procedures that provided clear instructions addressing normal shutdown for equipment including but not limited to heat exchangers.

(e) Location - Facility:

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On or about 10/5/12, the employer did not develop and implement written operating procedures that provided clear instructions addressing startup following a turnaround, or after an emergency shutdown for equipment including but not limited to pumps, compressors, condensers, air handling units, and heat exchangers.

ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM

Date By Which Violation Must be Abated:	05/17/2013
Proposed Penalty:	\$7000.00

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

U.S. Department of Labor
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Company Name: NEW ENGLAND CONFECTIONERY COMPANY, Inc.
Inspection Site: 135 AMERICAN LEGION HIGHWAY, Revere, MA 02151

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

29 CFR 1910.119(f)(1)(i)(E): The employer did not develop and implement written operating procedures that provided clear instructions for safely conducting activities involved in each covered process consistent with the process safety information that addressed emergency operations.

(a) Location - Facility:

On or about 10/5/12, the employer did not develop written operating procedures that provided clear instructions for safely conducting emergency operations with the ammonia coils in the concentrator.

ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM

Date By Which Violation Must be Abated:

05/17/2013

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

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Company Name: NEW ENGLAND CONFECTIONERY COMPANY, Inc.
Inspection Site: 135 AMERICAN LEGION HIGHWAY, Revere, MA 02151

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

29 CFR 1910.119(f)(1)(ii): The employer did not develop and implement written operating procedures that provided clear instructions for safely conducting activities involved in each covered process consistent with the process safety information that addressed operating limits.

(a) Location - Facility:

On or about 10/5/12, the employer did not develop and implement written operating procedures that provided clear instructions addressing operating limits for equipment including but not limited to all pumps and compressors.

ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM

Date By Which Violation Must be Abated:
Proposed Penalty:

05/17/2013
\$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: NEW ENGLAND CONFECTIONERY COMPANY, Inc.
Inspection Site: 135 AMERICAN LEGION HIGHWAY, Revere, MA 02151

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

29 CFR 1910.119(f)(1)(iii)(B):

The employer did not develop and implement written operating procedures that provided clear instructions for safely conducting activities involved in each covered process consistent with the process safety information which addressed precautions necessary to prevent exposure, including engineering controls, administrative controls, and personal protective equipment.

(a) Location - Facility:

The employer did not develop and implement written operating procedures that provided clear instructions addressing precautions necessary to prevent exposure to employees operating equipment including but not limited to pumps and compressors.

ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM

Date By Which Violation Must be Abated:
Proposed Penalty:

05/17/2013
\$7000.00

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

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Citation and Notification of Penalty

Company Name: NEW ENGLAND CONFECTIONERY COMPANY, Inc.
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Citation 1 Item 8 Type of Violation: **Serious**

29 CFR 1910.119(f)(1)(iv): The employer failed to ensure that the Process Safety Management Standard Operating Procedures included safety systems and their functions.

(a) Location - Facility:

On or about 10/5/12, the employer did not develop and implement written operating procedures that provided clear instructions addressing safety systems and their functions for equipment such as alarms, detection systems, and visual indicators.

ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM

Date By Which Violation Must be Abated:
Proposed Penalty:

05/17/2013
\$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: NEW ENGLAND CONFECTIONERY COMPANY, Inc.
Inspection Site: 135 AMERICAN LEGION HIGHWAY, Revere, MA 02151

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

29 CFR 1910.119(f)(3): Operating procedures were not reviewed as often as necessary to assure that they reflected current operating practices, and the employer did not certify annually that the operating procedures were current and accurate.

(a) Location - Facility:

On or about 10/5/12, the employer did not review and annually certify that written operating procedures were current and accurate for equipment including but not limited to pumps, compressors, condensers, air handling units, and heat exchangers.

ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM

Date By Which Violation Must be Abated:	05/17/2013
Proposed Penalty:	\$7000.00



Citation and Notification of Penalty

Company Name: NEW ENGLAND CONFECTIONERY COMPANY, Inc.
Inspection Site: 135 AMERICAN LEGION HIGHWAY, Revere, MA 02151

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

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

(a) Location - Facility:

On or about 10/5/12, the employer did not establish written procedures detailing how to maintain the on-going integrity of process equipment for equipment including but not limited to pumps and compressors.

An example of a recognized and generally acceptable good engineering practice (RAGAGEP) for inspection, testing and preventative maintenance (ITPM) procedures for pumps and compressors would be IIAR Bulletin #110-1993, Guidelines for Start-up, Inspection and Maintenance of Ammonia Mechanical Refrigeration Systems (6.3 for compressors and 6.5 for pumps).

ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM

Date By Which Violation Must be Abated:	05/17/2013
Proposed Penalty:	\$7000.00

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

Inspection Number: 686158
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Citation and Notification of Penalty

Company Name: NEW ENGLAND CONFECTIONERY COMPANY, Inc.
Inspection Site: 135 AMERICAN LEGION HIGHWAY, Revere, MA 02151

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

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

(a) Location - Facility:

On or about 10/5/12, the frequency of inspections and tests had not been established for the ammonia coils in the concentrator.

ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM

Date By Which Violation Must be Abated:
Proposed Penalty:

05/17/2013
\$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: NEW ENGLAND CONFECTIONERY COMPANY, Inc.
Inspection Site: 135 AMERICAN LEGION HIGHWAY, Revere, MA 02151

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 12 a Type of Violation: **Serious**

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

(a) Location - Facility:

The employer did not implement management of change procedures when adding 10,000 additional pounds of ammonia to a system that was originally intended to hold 20,000 pounds of ammonia.

(b) Location - Concentrator:

The employer did not implement management of change procedures when the ammonia coils in the concentrator were replaced by coils constructed of a different material (stainless steel).

(c) Location - Facility:

The employer did not implement procedures to manage changes in organizational structure.

ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM

Date By Which Violation Must be Abated:
Proposed Penalty:

05/17/2013
\$7000.00



Citation and Notification of Penalty

Company Name: NEW ENGLAND CONFECTIONERY COMPANY, Inc.
Inspection Site: 135 AMERICAN LEGION HIGHWAY, Revere, MA 02151

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

29 CFR 1910.119(l)(3):

Employees involved in operating a process and maintenance and contract employees whose job tasks would be affected by a change in the process were not informed of and trained in the change prior to start-up of the process or affected part of the process.

(a) Location - Facility:

The employer did not inform of and/or train employees in changes to the organizational structure when it affected the safe operation and emergency response duties of the ammonia refrigeration system.

ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM

Date By Which Violation Must be Abated:

05/17/2013

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

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Company Name: NEW ENGLAND CONFECTIONERY COMPANY, Inc.
Inspection Site: 135 AMERICAN LEGION HIGHWAY, Revere, MA 02151

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

29 CFR 1910.119(l)(2)(ii): The management of change procedures did not assure that the impact of changes on safety and health were addressed prior to any change.

(a) Location - Facility:

The written operating procedures for management of change that were used by the company did not assure that thefor the impact of the changes on safety and health were addressed.

ABATEMENT DOCUMENTATION REQUIRED FOR THIS ITEM

Date By Which Violation Must be Abated:
Proposed Penalty:

05/17/2013
\$7000.00


Jeffrey Erskine
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
138 River Road
Suite 102, Shattuck Office Center
Andover, MA 01810
Phone: 978-837-4460 Fax: 978-837-4455



INVOICE / DEBT COLLECTION NOTICE

Company Name: NEW ENGLAND CONFECTIONERY COMPANY, Inc.
Inspection Site: 135 AMERICAN LEGION HIGHWAY, Revere, MA 02151
Issuance Date: 04/02/2013

Summary of Penalties for Inspection Number	686158
Citation 1, Serious	\$91000.00
TOTAL PROPOSED PENALTIES	\$91000.00

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.

OSHA does not agree to any restrictions or conditions or endorsements put on any check or money order 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

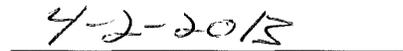
becomes due and payable (penalty due date). The current interest rate is one percent (1%). Interest will accrue from the date on which the penalty amounts (as proposed or adjusted) become a final order of the Occupational Safety and Health Review Commission (that is, 15 working days from your receipt 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.



Jeffrey Erskine
Area Director



Date