

Location: TriOak Foods - Oakville, IA

Confined Space Program For TriOak Foods Oakville, IA

Purpose

TriOak Foods recognizes the need to protect their employees from potential safety hazards that may be encountered during entry into a confined space, and has developed this written Confined Space Entry Program. This program is intended to assure that:

- | All workers who are required to enter into a permit required confined space are properly trained and supervised.
- | Procedures are in-place to prevent employee injuries.
- | If an emergency occurs, the rescue procedures are in place to minimize injuries.

This program includes provisions for, hazard identification and control, an entry permit system, a site-specific entry program, employee training and rescue procedures.

Background

A confined space is a space that is:

1. Large enough for an employee to enter and perform assigned work; and
2. Has limited or restricted means for entry or exit; and
3. Is not designed for continuous employee occupancy.

A permit-required confined space means a confined space that has one or more of the following characteristics:

1. Contains or has the potential to contain a hazardous atmosphere.
2. Contains materials that have the potential for engulfing an entrant.
3. Has an internal configuration such that an entrant could be trapped or asphyxiated by inwardly converging walls or by a floor that slopes downward and tapers to a smaller cross-section.
4. Contains any other recognized serious safety or health hazard (such as noise, electricity, or moving parts of machinery).

Introduction to the Confined Space Entry Program

The principal objective of this Confined Space Entry Program is to implement practices and procedures that will protect employees from hazards that may exist in permit-required confined spaces. This objective is met by:

1. Surveying, inventorying and evaluating the workplace to determine if any spaces are permit-required

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confined spaces.

2. Posting appropriate signs and providing training to individuals so that they recognize and will not enter permit-required confined spaces unless authorized.
3. Training individuals who will enter permit-required confined spaces.
4. Developing written entry practices and procedures
5. Implementing a permit system to control and monitor entry into permit-required confined spaces.
6. This program has been designed to comply with Occupational Safety and Health Administration (OSHA) standard 29 CFR 1910.146.

Participants:

1. The "Entrants" are workers who enter a permit-required confined space.
2. The "Attendants" are workers who attends to the safety of entrants.
3. The Supervisor is the person who issues the permit and oversees the safe conduct of entry.
4. Rescue units are people that will participate in case of an emergency.

Identification of Permit Required Spaces

The inventory of the confined spaces for TriOak Foods facility at Oakville, IA is listed on the following page.

1. Tom Parchert will maintain and updated this list as needed. The inventory shall include an assessment of the hazard(s) associated with each permit-required space.
2. Tom Parchert will assure that all permit-required spaces are labeled as such.

The labels shall read as follows:

**DANGER
PERMIT-REQUIRED CONFINED SPACE
DO NOT ENTER**

Confined Spaces

Confined Space	Hazard #1	Hazard #2	Hazard #3	Hazard #4	Hazard #5
East B., West B. NE, SE. NW, SW.	Engulfment	Entrapment	Bridging	Electrical	Mechanical
Fat Tank Inside	Electrical	Entrapment	Engulfment		
Feed Mill - #101 & 102 Whole Grain Storage Silos	Engulfment	Entrapment	Mechanical Hazards	Bridged Grain	Crusted Grain
Feed Mill - Counter Flow Cooler	Entrapment	Hazardous Atmospher	Engulfment		
Feed Mill - Finished Product Bins #27-48	Engulfment	Entrapment	Crusted Product	Bridged Product	Mechanical Hazards
Feed Mill - Horizontal Cooler	Entrapment	Hazardous Atmosphere	Engulfment		
Feed Mill - Main Supply Distributor	Entrapment	Mechanical Hazards	Engulfment		
Feed Mill - Meal Distributor	Entrapment	Machanical Hazards	Engulfment		
Feed Mill - Mixer	Mechanical Hazards	Entrapment	Engulfment		
Feed Mill - Pellet Distributor	Entrapment	Machanical Hazards	Engulfment		
Feed Mill - Recieving Pit	Engulfment	Machanical Hazards	Entrapment		
Feed Mill - Scale Hopper	Engulfment	Entrapment	Mechanical Hazards		
Feed Mill - Scalper	Engulfment	Entrapment	Mechanical Hazards		
Feed Mill - Truck Scale Pit	Entrapment	Hazardous Atmospher	Mechanical Hazards		

Entry Permits & Person in Charge

1. Prior to entry into a permit-required confined space, Tom Parchert or his/her assigned designate will complete an entry permit. Tom Parchert or his/her assigned designate will be in charge of the entry.
2. Tom Parchert or his/her assigned designate will ensure that the permit specifies the location, type of work, personal protective measures, authorized entrants and attendants, safety and monitoring equipment, hazards of the permit space, and control measures. The procedure for contacting rescue services will also be included on the permit.
3. The permit will be dated and carry an expiration time limiting the work to one shift. The permit will be updated for each shift, and may be extended to each shift if entry conditions are still acceptable.
4. Tom Parchert or his/her assigned designate shall sign the permit prior to allowing entry and ensure that entry operations remain consistent with the terms on the permit. The entry will be terminated if a potential hazardous situation occurs which exceeds the conditions authorized on the permit.
5. The permit will be available at the work site outside the confined space.
6. Hot work (potential ignition sources) must be authorized on a separate TriOak Foods hot work permit and attached and noted on the entry permit.
7. After the work has been completed, the permit will be canceled by Tom Parchert or his/her assigned designate. Cancellation of the permit indicates that the space is ready to be returned to its normal operation.
8. All confined space entry permits will be kept for a minimum of three years.
9. A copy of a permit is available as an uploaded document with this policy.

Training and Duties of Program Participants:

1. All personnel involved in confined space work shall receive appropriate training in hazard recognition, personal protective equipment, safety equipment, communications equipment, procedures for calling rescue services, and proper use of rescue equipment.
2. Training shall be performed before the employee is assigned duties in permit-required confined spaces.
3. Retraining will be performed at least annually.
4. Training records will be maintained. These records shall include the date of the training program, the name of instructor, a copy of the written material presented, and the names of the employee to whom the training was given.
5. Tom Parchert is responsible to assure that all affected employees at this facility receive training.

Training and Duties of the Entrant

All personnel involved in entry into permit-required confined spaces shall receive appropriate training, which shall include, at a minimum:

1. The requirements of this program and the conditions that must be met for entry into a permit-required confined space.
2. Hazard recognition and use of atmospheric testing devices, including information on the mode, signs or symptoms, and consequences of exposure.

3. The use of personal protective equipment including rescue harnesses, respiratory protection, and so forth.
4. Entry procedures and precautions are to include
 - A. Establishing a communication system with the attendant
 - B. Maintaining communication with the attendant as necessary to enable the attendant to monitor entrant status and to enable the attendant to alert entrants of the need to evacuate the space;
 - C. Alerting the attendant whenever:
 - a. The entrant recognizes any warning sign or symptoms of exposure to a dangerous situation, or
 - b. The entrant detects a prohibited condition.
5. The entrant is required to evacuate whenever ordered by the entry supervisor or attendant, whenever the entrant recognizes any warning sign or symptom of exposure to a dangerous situation, if the entrant detects a prohibited condition, or whenever an evacuation alarm is activated.
6. Emergency and non-entry rescue methods, and procedures for calling rescue services.

Training and Duties of the Attendant

The attendant shall receive the training above also receive training on the following:

1. Hazards that may be faced during entry, including information on the mode, signs or symptoms, and consequences of the exposure;
2. Possible behavioral effects of hazard exposure in authorized entrants.

The attendant shall:

1. Continuously maintain an accurate count of authorized entrants in the permit space and ensure that the means used to identify authorized entrants accurately identifies who is in the permit space;
2. Remain outside the permit space during entry operations until relieved by another attendant;
3. Communicate with authorized entrants as necessary to monitor entrant status and to alert entrants of the need to evacuate the space;
4. Monitor activities inside and outside the space to determine if it is safe for entrants to remain in the space and order the authorized entrants to evacuate the permit space immediately under any of the following conditions:
 - A. If the attendant detects a prohibited condition;
 - B. If the attendant detects behavioral effects of hazard exposure in the authorized entrants;
 - C. If the attendant detects a situation outside the space that could endanger the entrant.
 - D. If the attendant can not effectively and safely perform the requirements of their duties.
5. Summon rescue and other emergency services as soon as the attendant determines that authorized entrants may need assistance to escape from permit space hazards.
6. Performs non-entry rescues as specified.
7. Performs no duties that might interfere with the attendant's primary duty to monitor and protect the authorized entrants.

Training and Duties of the Entry Supervisor

The entry supervisor shall receive training as for attendant, above, and additional training as

required to evaluate confined space hazards. The entry supervisor shall:

1. Know the hazards that may be faced during entry, including signs or symptoms, and consequences of the exposure.
2. Verify, by checking that the appropriate entries have been made on the permit, that all tests specified by the permit have been conducted and that all procedures and equipment specified by the permit are in place before endorsing the permit and allowing entry to begin.
3. Terminate the entry and cancel the permit when either the entry operations covered by the entry permit have been completed or a condition that is not allowed under the entry permit arises in or near the permit space.
4. Verify that rescue services are available and that the means for summoning them are operable.

Training and Duties of Rescue and Emergency Services

Rescues will be provided by the Oakville Fire Department and Company Staff . Tom Parchert will be responsible to for arranging an annual facility visit by the Oakville Fire Department and Company Staff in which all hazards of confined spaces will be covered.

Contractor Awareness, Duties and Responsibilities

1. Tom Parchert or his/her assigned designate will inform the contractor in writing that the workplace contains permit spaces and that permit space entry is allowed only through compliance with a permit space program meeting the requirements set forth by OSHA (e.g. 29 CFR 1910.146). A signed copy of this notification must be kept on file for one year.
2. Tom Parchert or his/her assigned designate will inform the contractor of the elements, including the hazard(s) identified with the space, that make the space in question a permit-required confined space.
3. Tom Parchert or his/her assigned designate will inform the contractor of any precautions or procedures that TriOak Foods has implemented for the protection of its workers in or near the permit space where contractor personnel will be working.
4. Tom Parchert or his/her assigned designate will coordinate entry operations with the contractor when both TriOak Foods personnel and contractor personnel will be working in or near permit spaces.

Rescue Procedures

1. If it is necessary to rescue workers from a permit-required confined space, the attendant will immediately notify Tom Parchert, who will contact the Oakville Fire Department and Company Staff .
2. After notifying Tom Parchert, the attendant will attempt to retrieve the worker using the retrieval line. **Under no circumstance will the attendant enter the confined space until help has arrived, and then only with the proper rescue equipment.** Attendants participating in the rescue effort must have received specialized training in confined space rescue techniques.
3. Rescuers will, where practical, be connected to a safety line attached to a point outside the confined space. An attendant will remain outside the confined space during rescue efforts. Rescuers will wear appropriate protective clothing.

ENTRY-RELATED WORK ACTIVITIES AND DUTIES:

Entry Procedures:

NOTE: Specific procedures for confined spaces at this location can be found with the policy.

All permit-required confined spaces:

1. Tom Parchert will properly complete an entry permit prior to entry into the permit-required confined space.
2. All mechanical, electrical, hydraulic and pneumatic equipment which present a danger to employees inside must be disconnected, locked-out and tagged, blocked-off, or otherwise prevented from operating.
3. If Tom Parchert has reason to believe that gases, vapors or toxic agents may be present, then the atmosphere within the confined space must be tested for their presence. Additionally, the atmosphere within must be tested for oxygen content, unless there is continuous natural air movement or continuous forced-air ventilation before and during the period employees are inside. If the oxygen level is less than 19.5%, or if combustible gas or vapor is detected, or if toxic agents are present in excess or in concentrations that will cause health effects which prevent employees from rescuing themselves or communicating to obtain assistance, the following provisions apply:
4. Ventilation must be provided until the unsafe condition or conditions are eliminated, and the ventilation must be continued as long as there is a possibility of recurrence of the unsafe condition while the bin or tank is occupied by employees.
5. Only properly trained individuals will be allowed to enter a permit-required confined space. Entrants will maintain contact with the attendant, utilizing the selected communication system.
6. Each individual entering a permit required confined space will have a safety or retrieval line attached to a chest, or body harness. The other end of the line will be secured to an anchor point or lifting device outside the entry portal. The anchor point will not be secured to a motor vehicle in a manner that would pull the line out of the space if the vehicle moved.
7. When entering bins, silos or tanks from the top, employees must wear a body harness with lifeline, or use a boatswain's chair.
8. An attendant, equipped to provide assistance, must be stationed outside the bin, silo or tank being entered. Communications (visual, voice or signal line) must be maintained between the attendant and the entering employee. The employee acting as attendant must be trained in rescue procedures, including notification methods for obtaining additional assistance, and the employer must provide equipment for rescue operations specifically suited for the bin, silo or tank being entered.
9. Employees must not enter bins or tanks underneath a bridging condition, or where a buildup of grain products on the sides could fall and bury them.
10. During any confined space entry, all safety rules and procedures will be followed. Metal ladders will not be used when working around electrical equipment. There will be no smoking in a confined space. Any use of chemicals, welding, soldering or cutting must be pre-approved. Adequate lighting will be provided.
11. Personal protective equipment, including respirators, will be provided to workers as necessary for safe entry into the permit-required confined space.

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Supporting Files

 [Confined Space Permit](#)

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