

U.S. Department of Labor

Occupational Safety and Health Administration
4802 E. Broadway
Madison, WI 53716
Phone: 608-441-5388 Fax: 608-441-5400



Citation and Notification of Penalty

To:

Didion Milling, Inc.
and its successors
P.O. Box 495
Cambria, WI 53923

Inspection Number: 1236533

Inspection Date(s): 06/01/2017 - 11/15/2017

Issuance Date: 11/17/2017

Inspection Site:

501 S. Williams Street
Cambria, WI 53923

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. 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 11/17/2017. The conference will be held by telephone or at the OSHA office located at 4802 E. Broadway, Madison, WI 53716 on _____ at _____. Employees and/or representatives of employees have a right to attend an informal conference.

CERTIFICATION OF CORRECTIVE ACTION WORKSHEET

Inspection Number: 1236533

Company Name: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923
Issuance Date: 11/17/2017

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, 4802 E. Broadway, Madison, WI 53716**

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: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

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

OSH ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that caused or were likely to cause death or serious physical harm in that employees were exposed to grain product fire hazards associated with an indoor fluid bed dryer processing dry corn products which was not equipped with a means of fire protection:

On or about May 17, 2017 through May 29, 2017, the employer operated the expander #5 fluid bed dryer located on the 1st floor of the C mill without an automatic fire protection system. The employer relied on employees to manually extinguish a fire that occurred on May 29, 2017 within this dryer.

Among other methods, one feasible and acceptable method to abate this hazard is to follow the provisions of the National Fire Protection Association's (NFPA) Standard 61 "Standard for the Prevention of Fires and Dust Explosions in Agricultural and Food Processing Facilities, 2017 ed." to ensure that dryers have a means for detecting abnormal conditions that indicate the presence or potential of a fire and ensure that the detection system activates an alarm system and automatic fire extinguishing system. See NFPA 61 (2017) - Sections 8.3.9.4.3 (dryer fire detection, alarm, and interlocking systems) and 8.3.9.4.4 (dryer suppression and extinguishing systems).

Pursuant to 29 CFR 1903.19, abatement certification and documentation are required for this item. The employers certification that abatement is complete must include [in addition to the requirements in 1903.19(h)], the date and method of abatement and a statement that affected employees have been informed of the abatement. The employer must also submit documents demonstrating that abatement is complete to include, but not limited to, evidence of the purchase or repair of equipment, photographic or video evidence of abatement, or other written records.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:	01/09/2018
Proposed Penalty:	\$12675.00

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: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

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

29 CFR 1910.272(e)(1): The employer did not provide training to employees at least annually and when changes in job assignment exposed them to new hazards on the general safety precautions and specific procedures and safety practices listed in 29 CFR 1910.272(e)(1)(i) and (e)(1)(ii):

On or about May 17, 2017 through May 31, 2017, the employer had not provided annual training on the following:

- a) Employees were not trained at least annually on common ignition sources, such as but not limited to, inappropriate electrical equipment and wiring methods; static electricity including bonding of equipment to ground; mechanical sparks and friction; foreign materials capable of igniting combustibles (ferrous materials); heated surfaces and heating systems; properly rated powered industrial trucks; and improper preventative maintenance.
- b) Employees were not trained at least annually on specific procedures and safety practices, such as but not limited to, specific housekeeping procedures, cleaning procedures for grinding equipment, preventative maintenance procedures, equipment safety systems (monitors, sensors, alarms, interlocks), and the safety practice prohibiting use of compressed air to clean in the presence of potential ignition sources.

Pursuant to 29 CFR 1903.19, abatement certification and documentation are required for this item. The employer's certification that abatement is complete must include [in addition to the requirements in 1903.19(h)], the date and method of abatement and a statement that affected employees have been informed of the abatement. The employer must also submit documents demonstrating that abatement is complete to include, but not limited to, evidence of the purchase or repair of equipment, photographic or video evidence of abatement, or other written records.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:	01/09/2018
Proposed Penalty:	\$12675.00

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Citation and Notification of Penalty

Company Name: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

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

29 CFR 1910.272(l)(2): Filter collectors installed after March 30, 1988 were not: (i) located outside of the facility; or (ii) located in an area inside the facility protected by an explosion suppression system; or (iii) located in an area inside the facility that is separated from other areas of the facility by construction having at least one hour fire-resistance rating, and which is adjacent to an exterior wall and vented to the outside:

On or about May 17, 2017 and through May 31, 2017, multiple filter media dust collectors such as, but not limited to, the following were located inside of the facility without means of explosion protection:

- a) 3rd floor mezzanine of F mill: Kice filter dust collector
- b) 2nd floor of F mill: Torit filter dust collector
- c) 4th floor of D mill: Flex-Kleen / Bran filter dust collector
- d) 2nd floor of D mill: Bran filter dust collector
- e) Packaging room mezzanine: Pack line #1 filter dust collector
- f) 4th floor of B mill: Clean corn filter dust collector
- g) 4th floor of B mill: BGM filter dust collector
- h) 4th floor of B mill: Expander #3 fine grinder filter dust collector
- i) 4th floor of B mill: 4-B Expander & Extruder / Expander #s 3 & 4 dryer / Pre-gel filter dust collector
- j) 6th floor of A mill: NW filter dust collector

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: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

- k) 6th floor of A mill: NC filter dust collector
- l) 6th floor of A mill: NE filter dust collector
- m) 6th floor of A mill: SW filter dust collector
- n) 6th floor of A mill: SC filter dust collector
- o) 6th floor of A mill: SE filter dust collector
- p) 2nd floor of Bulk Loadout: Bulk loadout filter dust collector

Pursuant to 29 CFR 1903.19, abatement certification and documentation are required for this item. The employer's certification that abatement is complete must include [in addition to the requirements in 1903.19(h)], the date and method of abatement and a statement that affected employees have been informed of the abatement. The employer must also submit documents demonstrating that abatement is complete to include, but not limited to, evidence of the purchase or repair of equipment, photographic or video evidence of abatement, or other written records.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:	01/09/2018
Proposed Penalty:	\$12675.00



Citation and Notification of Penalty

Company Name: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

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

29 CFR 1910.272(m)(1)(i): Regularly scheduled inspections of at least the mechanical and safety control equipment associated with dryers, grain stream processing equipment, dust collection equipment including filter collectors, and bucket elevators were not accomplished:

On or about May 17, 2017 through May 29, 2017, the employer did not develop preventative maintenance procedures pertaining to mechanical equipment for the Expander #5 fluid bed dryer (employer ID #M16012) located on the 1st floor of C mill.

Pursuant to 29 CFR 1903.19, abatement certification and documentation are required for this item. The employer's certification that abatement is complete must include [in addition to the requirements in 1903.19(h)], the date and method of abatement and a statement that affected employees have been informed of the abatement. The employer must also submit documents demonstrating that abatement is complete to include, but not limited to, evidence of the purchase or repair of equipment, photographic or video evidence of abatement, or other written records.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:	12/08/2017
Proposed Penalty:	\$12675.00



Citation and Notification of Penalty

Company Name: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

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

29 CFR 1910.272(n): The employer did not equip grain stream processing equipment (such as hammer mills, grinders, and pulverizers) with an effective means of removing ferrous material from the incoming grain stream:

On or about May 17, 2017 through May 31, 2017, effective means of removing ferrous material was not provided to remove ferrous material from the incoming grain stream of size reduction equipment such as, but not limited to, the following:

- a) 2nd floor of B mill: the Roll stand East Main Rolls #1 and Roll stand South Main Rolls #1 unit
- b) 2nd floor of B mill: the Roll stand East Main Rolls #2 and Roll stand South Main Rolls #2 unit
- c) 2nd floor of B mill: the Roll stand East Main Rolls #3 and Roll stand South Main Rolls #3 unit
- d) 2nd floor of B mill: the Roll stand East Main Rolls #4 and Roll stand South Main Rolls #4 unit
- e) 2nd floor of B mill: the Roll Stand East Main Rolls #5 and Roll stand South Main Rolls #5 unit
- f) 2nd floor of B mill: the Roll Stand East Main Rolls #6 and Roll stand South Main Rolls #6 unit
- g) 1st floor of B mill: the South Bran Grinder Bauermeister
- h) 4th floor of D mill: the Coarse Roller Mill Main Rolls unit
- i) 4th floor of D mill: the Fines Roller Mill Main Rolls unit

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Citation and Notification of Penalty

Company Name: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Pursuant to 29 CFR 1903.19, abatement certification and documentation are required for this item. The employer's certification that abatement is complete must include [in addition to the requirements in 1903.19(h)], the date and method of abatement and a statement that affected employees have been informed of the abatement. The employer must also submit documents demonstrating that abatement is complete to include, but not limited to, evidence of the purchase or repair of equipment, photographic or video evidence of abatement, or other written records.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:	01/09/2018
Proposed Penalty:	\$12675.00

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: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

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

OSH ACT of 1970 Section (5)(a)(1): The employer did not furnish employment and a place of employment which were free from recognized hazards that caused or were likely to cause death or serious physical harm in that employees were exposed to hazards associated with combustible grain dust explosion, deflagration or other fire hazards resulting from the failure to ensure that switch station flex hoses (part of a grain pneumatic conveying system) on the 5th floor of A mill were conductive, bonded and grounded:

The employer does not ensure that pneumatic conveying systems handling combustible grain dusts are conductive, bonded, and grounded. This violation was most recently documented as occurring as outlined below:

On or about May 17, 2017 through May 31, 2017, recognized conductivity and bonding/ grounding deficiencies associated with the non-metallic, non-conductive flexible hose utilized at the switch station on the 5th floor of A-mill had not been resolved. Non-conductive flexible ducting was utilized at the transfer switch stations on the 5th floor of the A-mill.

Among other methods, one feasible and acceptable method to abate this hazard is to follow the provisions of the National Fire Protection Association's (NFPA) Standard 61 "Standard for the Prevention of Fires and Dust Explosions in Agricultural and Food Processing Facilities, 2017 ed." to ensure that pneumatic conveyance system ducting is made of conductive materials and is also bonded and grounded. See NFPA 61 (2017) - Sections 8.3.3.2.1 (system components to be electrically conductive), 8.3.3.2.2 (bonding and grounding for all system components), 8.5.2.2 (bonding and grounding as static ignition source control), and A.3.3.3.2.1 (NFPA 77 for guidance on static electricity) and NFPA 77 "Recommended Practice on Static Electricity, 2014 ed." - Sections 15.7.2 (pipes and ducts to be metal and be grounded) and 15.8.1 (prohibited use of non-conductive flexible hoses).

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Citation and Notification of Penalty

Company Name: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Pursuant to 29 CFR 1903.19, abatement certification and documentation are required for this item. The employer's certification that abatement is complete must include [in addition to the requirements in 1903.19(h)], the date and method of abatement and a statement that affected employees have been informed of the abatement. The employer must also submit documents demonstrating that abatement is complete to include, but not limited to, evidence of the purchase or repair of equipment, photographic or video evidence of abatement, or other written records.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:	01/09/2018
Proposed Penalty:	\$126749.00

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: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

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

29 CFR 1910.132(a): Protective equipment, including personal protective equipment for the eyes, face, head and extremities, protective clothing, respiratory devices, and protective shields and barriers, were not provided, used, and maintained in a sanitary and reliable condition whenever it was necessary by reason of hazards of processes or environment, chemical hazards, radiological hazards, or mechanical irritants encountered in a manner capable of causing injury or impairment in the function of any part of the body through absorption, inhalation, or physical contact:

The employer does not provide and ensure the use of flame-resistant clothing (FRC) to protect employees from burns due to potential flash fires. This violation was most recently documented as occurring as outlined below:

On or about May 17, 2017 through May 31, 2017, the employer failed to provide and ensure the use of flame-resistant clothing (FRC) necessary to protect employees from burns due to potential flash fires associated with combustible grain dust(s)/particulates in the milling, packaging, and bulk load out areas. Employee uniforms for mill operators, packaging employees, and bulk load-out employees were made of 100% spun polyester fabric.

To abate this violation, the employer must provide and ensure the use of FRC clothing where there is potential for exposure flash fires associated with combustible grain dust(s)/particulates. Appropriate guidance on FRC can be found in the National Fire Protection Association's (NFPA) Standard 2113 "Standard on Selection, Care, Use, and Maintenance of Flame-Resistant Garments for Protection of Industrial Personnel Against Short-Duration Thermal Exposures from Fire, 2015 ed."

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Occupational Safety and Health Administration

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Issuance Date: 11/17/2017



Citation and Notification of Penalty

Company Name: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Pursuant to 29 CFR 1903.19, abatement certification and documentation are required for this item. The employer's certification that abatement is complete must include [in addition to the requirements in 1903.19(h)], the date and method of abatement and a statement that affected employees have been informed of the abatement. The employer must also submit documents demonstrating that abatement is complete to include, but not limited to, evidence of the purchase or repair of equipment, photographic or video evidence of abatement, or other written records.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:	01/09/2018
Proposed Penalty:	\$126749.00

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: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

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 3a Type of Violation: **Willful**

29 CFR 1910.272(d): The employer did not develop and implement an emergency action plan meeting the requirements contained in 29 CFR 1910.38:

The employer does not establish and maintain an approved employee alarm system compliant with the requirements of 1910.272(d), 1910.38(d), and 1910.165. This violation was most recently documented as occurring as outlined below:

On or about May 17, 2017 through May 31, 2017, the employer had not established an employee alarm system compliant with the requirements of 29 CFR 1910.165 as required by 29 CFR 1910.38(d) and 29 CFR 1910.272(d), respectively.

To abate this violation, the employer must establish an approved employee alarm system having a distinctive signal for each emergency purpose and that also:

- Provides warning for necessary emergency action as called for in the emergency action plan, or for reaction time for safe escape of employees from the workplace or the immediate work area, or both;
- Is capable of being perceived above ambient noise or light levels by all employees in the affected portion of the workplace;
- Is distinctive and recognizable as a signal to evacuate the work area or to perform actions designated under the emergency action plan.

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ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:

01/09/2018

Proposed Penalty:

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Citation and Notification of Penalty

Company Name: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

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

29 CFR 1910.38(d): The employer did not have and maintain an employee alarm system using a distinctive signal for each purpose and complying with the requirements in 29 CFR 1910.165:

The employer does not establish and maintain an approved employee alarm system compliant with the requirements of 1910.272(d), 1910.38(d), and 1910.165. This violation was most recently documented as occurring as outlined below:

On or about May 17, 2017 through May 31, 2017, the employer had not established an employee alarm system compliant with the requirements of 29 CFR 1910.165 as required by 29 CFR 1910.38(d) and 29 CFR 1910.272(d), respectively.

To abate this violation, the employer must establish an approved employee alarm system having a distinctive signal for each emergency purpose and that also:

- Provides warning for necessary emergency action as called for in the emergency action plan, or for reaction time for safe escape of employees from the workplace or the immediate work area, or both;
- Is capable of being perceived above ambient noise or light levels by all employees in the affected portion of the workplace;
- Is distinctive and recognizable as a signal to evacuate the work area or to perform actions designated under the emergency action plan.

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Pursuant to 29 CFR 1903.19, abatement certification and documentation are required for this item. The employer's certification that abatement is complete must include [in addition to the requirements in 1903.19(h)], the date and method of abatement and a statement that affected employees have been informed of the abatement. The employer must also submit documents demonstrating that abatement is complete to include, but not limited to, evidence of the purchase or repair of equipment, photographic or video evidence of abatement, or other written records.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:

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Citation and Notification of Penalty

Company Name: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Citation 2 Item 4 Type of Violation: **Willful**

29 CFR 1910.272(j)(1): The employer did not develop and implement a written housekeeping program that established the frequency and the method(s) determined best to reduce accumulations of fugitive grain dust on ledges, floors, equipment, and other exposed surfaces:

The employer does not develop and implement a written housekeeping program that establishes the frequency and method(s) determined best to reduce accumulations of fugitive grain dust on ledges, floors, equipment, and other exposed surfaces:

a) The frequencies of housekeeping established in the written programs do not best reduce accumulations of fugitive grain dust emissions that are allowed to accumulate on elevated surfaces of the 1st floor, A Mill (A1). This violation most recently existed from May 17, 2017 through May 31, 2017 at the Cambria, WI dry corn milling facility.

b) The employer's methods of housekeeping do not best reduce accumulations of fugitive grain dust emissions that are allowed to accumulate on elevated surfaces of the 1st floor, A mill (A1) as demonstrated by the following deficiencies: lack of specific cleaning methods or training on cleaning methods; compressed air usage as a cleaning method is tolerated; methods of accessing and cleaning overhead areas are not provided; lack of management oversight and verification of housekeeping; and fugitive dust emissions from numerous pieces of process equipment and transfer points are not accounted for where they are a source for dust accumulation. This violation most recently existed from May 17, 2017 through May 31, 2017 at the Cambria, WI dry corn milling facility.

To abate this violation, the employer must develop and implement a written housekeeping program that establishes the frequency and method(s) determined to best reduce accumulations of fugitive grain dusts on elevated surfaces. Consistent with Appendix A of 1910.272, the housekeeping program is to be designed to keep dust accumulations and emissions under control inside grain facilities. See Appendix A for additional guidance on the prevention of dust accumulations and the prevention and control dust emissions.

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Occupational Safety and Health Administration

Inspection Number: 1236533
Inspection Date(s): 06/01/2017 - 11/15/2017
Issuance Date: 11/17/2017



Citation and Notification of Penalty

Company Name: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Pursuant to 29 CFR 1903.19, abatement certification and documentation are required for this item. The employer's certification that abatement is complete must include [in addition to the requirements in 1903.19(h)], the date and method of abatement and a statement that affected employees have been informed of the abatement. The employer must also submit documents demonstrating that abatement is complete to include, but not limited to, evidence of the purchase or repair of equipment, photographic or video evidence of abatement, or other written records.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:	01/09/2018
Proposed Penalty:	\$126749.00

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: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Citation 2 Item 5 Type of Violation: **Willful**

29 CFR 1910.272(j)(1): The employer did not develop and implement a written housekeeping program that established the frequency and the method(s) determined best to reduce accumulations of fugitive grain dust on ledges, floors, equipment, and other exposed surfaces:

The employer does not develop and implement a written housekeeping program that establishes the frequency and method(s) determined best to reduce accumulations of fugitive grain dust on ledges, floors, equipment, and other exposed surfaces:

- a) The frequencies of housekeeping established in the written programs do not best reduce accumulations of fugitive grain dust emissions that are allowed to accumulate on elevated surfaces of the 1st floor, B Mill (B1). This violation most recently existed from May 17, 2017 through May 31, 2017 at the Cambria, WI dry corn milling facility.
- b) The employer's methods of housekeeping do not best reduce accumulations of fugitive grain dust emissions that are allowed to accumulate on elevated surfaces of the 1st floor, B mill (B1) as demonstrated by the following deficiencies: lack of specific cleaning methods or training on cleaning methods; compressed air usage as a cleaning method is tolerated; methods of accessing and cleaning overhead areas are not provided; lack of management oversight and verification of housekeeping; and fugitive dust emissions from numerous pieces of process equipment and transfer points are not accounted for where they are a source for dust accumulation. This violation most recently existed from May 17, 2017 through May 31, 2017 at the Cambria, WI dry corn milling facility.

To abate this violation, the employer must develop and implement a written housekeeping program that establishes the frequency and method(s) determined to best reduce accumulations of fugitive grain dusts on elevated surfaces. Consistent with Appendix A of 1910.272, the housekeeping program is to be designed to keep dust accumulations and emissions under control inside grain facilities. See Appendix A for additional guidance on the prevention of dust accumulations and the prevention and control dust emissions.

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

Inspection Number: 1236533
Inspection Date(s): 06/01/2017 - 11/15/2017
Issuance Date: 11/17/2017



Citation and Notification of Penalty

Company Name: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Pursuant to 29 CFR 1903.19, abatement certification and documentation are required for this item. The employer's certification that abatement is complete must include [in addition to the requirements in 1903.19(h)], the date and method of abatement and a statement that affected employees have been informed of the abatement. The employer must also submit documents demonstrating that abatement is complete to include, but not limited to, evidence of the purchase or repair of equipment, photographic or video evidence of abatement, or other written records.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:
Proposed Penalty:

01/09/2018
\$126749.00

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: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Citation 2 Item 6 Type of Violation: **Willful**

29 CFR 1910.272(j)(1): The employer did not develop and implement a written housekeeping program that established the frequency and the method(s) determined best to reduce accumulations of fugitive grain dust on ledges, floors, equipment, and other exposed surfaces:

The employer does not develop and implement a written housekeeping program that establishes the frequency and method(s) determined best to reduce accumulations of fugitive grain dust on ledges, floors, equipment, and other exposed surfaces:

- a) The frequencies of housekeeping established in the written programs do not best reduce accumulations of fugitive grain dust emissions that are allowed to accumulate on elevated surfaces of the 4th floor, B Mill (B4). This violation most recently existed from May 17, 2017 through May 31, 2017 at the Cambria, WI dry corn milling facility.
- b) The employer's methods of housekeeping do not best reduce accumulations of fugitive grain dust emissions that are allowed to accumulate on elevated surfaces of the 4th floor, B mill (B4) as demonstrated by the following deficiencies: lack of specific cleaning methods or training on cleaning methods; compressed air usage as a cleaning method is tolerated; methods of accessing and cleaning overhead areas are not provided; lack of management oversight and verification of housekeeping; and fugitive dust emissions from numerous pieces of process equipment and transfer points are not accounted for where they are a source for dust accumulation. This violation most recently existed from May 17, 2017 through May 31, 2017 at the Cambria, WI dry corn milling facility.

To abate this violation, the employer must develop and implement a written housekeeping program that establishes the frequency and method(s) determined to best reduce accumulations of fugitive grain dusts on elevated surfaces. Consistent with Appendix A of 1910.272, the housekeeping program is to be designed to keep dust accumulations and emissions under control inside grain facilities. See Appendix A for additional guidance on the prevention of dust accumulations and the prevention and control dust emissions.

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

Inspection Number: 1236533
Inspection Date(s): 06/01/2017 - 11/15/2017
Issuance Date: 11/17/2017



Citation and Notification of Penalty

Company Name: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Pursuant to 29 CFR 1903.19, abatement certification and documentation are required for this item. The employer's certification that abatement is complete must include [in addition to the requirements in 1903.19(h)], the date and method of abatement and a statement that affected employees have been informed of the abatement. The employer must also submit documents demonstrating that abatement is complete to include, but not limited to, evidence of the purchase or repair of equipment, photographic or video evidence of abatement, or other written records.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:	01/09/2018
Proposed Penalty:	\$126749.00

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: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Citation 2 Item 7 Type of Violation: **Willful**

29 CFR 1910.272(j)(1): The employer did not develop and implement a written housekeeping program that established the frequency and the method(s) determined best to reduce accumulations of fugitive grain dust on ledges, floors, equipment, and other exposed surfaces:

The employer does not develop and implement a written housekeeping program that establishes the frequency and method(s) determined best to reduce accumulations of fugitive grain dust on ledges, floors, equipment, and other exposed surfaces:

- a) The frequencies of housekeeping established in the written programs do not best reduce accumulations of fugitive grain dust emissions that are allowed to accumulate on elevated surfaces of the 3rd floor, F Mill (F3). This violation most recently existed from May 17, 2017 through May 31, 2017 at the Cambria, WI dry corn milling facility.
- b) The employer's methods of housekeeping do not best reduce accumulations of fugitive grain dust emissions that are allowed to accumulate on elevated surfaces of the 3rd floor, F mill (F3) as demonstrated by the following deficiencies: lack of specific cleaning methods or training on cleaning methods; compressed air usage as a cleaning method is tolerated; methods of accessing and cleaning overhead areas are not provided; lack of management oversight and verification of housekeeping; and fugitive dust emissions from numerous pieces of process equipment and transfer points are not accounted for where they are a source for dust accumulation. This violation most recently existed from May 17, 2017 through May 31, 2017 at the Cambria, WI dry corn milling facility.

To abate this violation, the employer must develop and implement a written housekeeping program that establishes the frequency and method(s) determined to best reduce accumulations of fugitive grain dusts on elevated surfaces. Consistent with Appendix A of 1910.272, the housekeeping program is to be designed to keep dust accumulations and emissions under control inside grain facilities. See Appendix A for additional guidance on the prevention of dust accumulations and the prevention and control dust emissions.

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

Inspection Number: 1236533
Inspection Date(s): 06/01/2017 - 11/15/2017
Issuance Date: 11/17/2017



Citation and Notification of Penalty

Company Name: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Pursuant to 29 CFR 1903.19, abatement certification and documentation are required for this item. The employer's certification that abatement is complete must include [in addition to the requirements in 1903.19(h)], the date and method of abatement and a statement that affected employees have been informed of the abatement. The employer must also submit documents demonstrating that abatement is complete to include, but not limited to, evidence of the purchase or repair of equipment, photographic or video evidence of abatement, or other written records.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:	01/09/2018
Proposed Penalty:	\$126749.00

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: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Citation 2 Item 8 Type of Violation: **Willful**

29 CFR 1910.272(j)(1): The employer did not develop and implement a written housekeeping program that established the frequency and the method(s) determined best to reduce accumulations of fugitive grain dust on ledges, floors, equipment, and other exposed surfaces:

The employer does not develop and implement a written housekeeping program that establishes the frequency and method(s) determined best to reduce accumulations of fugitive grain dust on ledges, floors, equipment, and other exposed surfaces:

- a) The frequencies of housekeeping established in the written programs do not best reduce accumulations of fugitive grain dust emissions that are allowed to accumulate on elevated surfaces of the Pack area. This violation most recently existed from May 17, 2017 through May 31, 2017 at the Cambria, WI dry corn milling facility.
- b) The employer's methods of housekeeping do not best reduce accumulations of fugitive grain dust emissions that are allowed to accumulate on elevated surfaces of the Pack area as demonstrated by the following deficiencies: lack of specific cleaning methods or training on cleaning methods; compressed air usage as a cleaning method is tolerated; methods of accessing and cleaning overhead areas are not provided; lack of management oversight and verification of housekeeping; and fugitive dust emissions from numerous pieces of process equipment and transfer points are not accounted for where they are a source for dust accumulation. This violation most recently existed from May 17, 2017 through May 31, 2017 at the Cambria, WI dry corn milling facility.

To abate this violation, the employer must develop and implement a written housekeeping program that establishes the frequency and method(s) determined to best reduce accumulations of fugitive grain dusts on elevated surfaces. Consistent with Appendix A of 1910.272, the housekeeping program is to be designed to keep dust accumulations and emissions under control inside grain facilities. See Appendix A for additional guidance on the prevention of dust accumulations and the prevention and control dust emissions.

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

Inspection Number: 1236533
Inspection Date(s): 06/01/2017 - 11/15/2017
Issuance Date: 11/17/2017



Citation and Notification of Penalty

Company Name: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Pursuant to 29 CFR 1903.19, abatement certification and documentation are required for this item. The employer's certification that abatement is complete must include [in addition to the requirements in 1903.19(h)], the date and method of abatement and a statement that affected employees have been informed of the abatement. The employer must also submit documents demonstrating that abatement is complete to include, but not limited to, evidence of the purchase or repair of equipment, photographic or video evidence of abatement, or other written records.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:	01/09/2018
Proposed Penalty:	\$126749.00

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: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Citation 2 Item 9 Type of Violation: **Willful**

29 CFR 1910.272(j)(3): Compressed air was used to blow dust from ledges, walls, and other areas in grain handling facilities when machinery presenting an ignition source was not shut down, and when all other known potential ignition sources in the area were not removed or controlled:

Compressed air is permitted to be used to blow dust from ledges, walls and other areas when all machinery in the area that presents an ignition source is not shut down and when other known potential ignition sources in the area are not removed or controlled. This violation most recently existed from May 17, 2017 through May 31, 2017 at the Cambria, WI dry corn milling facility.

To abate this violation, the employer must not permit compressed air to be used to blow dust from ledges, walls, and other areas in grain handling facilities unless machinery presenting an ignition source is shut down, and all other known potential ignition sources in the areas are removed or controlled. Further guidance on this topic can be found in National Fire Protection Association (NFPA) Standard 61 "Standard for the Prevention of Fires and Dust Explosions in Agricultural and Food Processing Facilities, 2017 ed."

Pursuant to 29 CFR 1903.19, abatement certification and documentation are required for this item. The employer's certification that abatement is complete must include [in addition to the requirements in 1903.19(h)], the date and method of abatement and a statement that affected employees have been informed of the abatement. The employer must also submit documents demonstrating that abatement is complete to include, but not limited to, evidence of the purchase or repair of equipment, photographic or video evidence of abatement, or other written records.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:	01/09/2018
Proposed Penalty:	\$126749.00



Citation and Notification of Penalty

Company Name: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

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 10a Type of Violation: **Willful**

29 CFR 1910.272(m)(1)(i): Regularly scheduled inspections of at least the mechanical and safety control equipment associated with dryers, grain stream processing equipment, dust collection equipment including filter collectors, and bucket elevators were not accomplished:

The employer does not implement regularly scheduled inspections pertaining to mechanical equipment on the North Bauermeister GM-120 gap mill (Employer ID# M13031) within the employer's established preventative maintenance procedures, as follows:

- a) Quarterly and semi-annual inspections are not getting completed within the employer's established time frame. This violation most recently existed from May 17, 2017 through May 31, 2017 at the Cambria, WI dry corn milling facility.
- b) Critical steps as outlined in the employer's preventative maintenance procedures within weekly, monthly, and quarterly inspections that required the equipment to be shut down are not being performed. This violation most recently existed from May 17, 2017 through May 31, 2017 at the Cambria, WI dry corn milling facility.

To abate this violation, the employer must implement preventative maintenance procedures consisting of performance of regularly scheduled inspections of the mechanical equipment associated with covered equipment such as dryers, grain stream processing equipment, dust collection equipment including filter collectors, and bucket elevators.

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

Inspection Number: 1236533
Inspection Date(s): 06/01/2017 - 11/15/2017
Issuance Date: 11/17/2017



Citation and Notification of Penalty

Company Name: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Pursuant to 29 CFR 1903.19, abatement certification and documentation are required for this item. The employer's certification that abatement is complete must include [in addition to the requirements in 1903.19(h)], the date and method of abatement and a statement that affected employees have been informed of the abatement. The employer must also submit documents demonstrating that abatement is complete to include, but not limited to, evidence of the purchase or repair of equipment, photographic or video evidence of abatement, or other written records.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:	12/08/2017
Proposed Penalty:	\$126749.00

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: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Citation 2 Item 10b Type of Violation: **Willful**

29 CFR 1910.272(m)(1)(ii): Lubrication and other appropriate maintenance in accordance with manufacturers' recommendations, or as determined necessary by prior operating records were not accomplished:

The employer does not ensure that preventative maintenance procedures incorporate appropriate maintenance steps communicated by the equipment manufacturer for the North Bauermeister GM-120 gap mill, (employer ID # M13031) located on the 1st floor of B mill, such as, but not limited to:

- a) The employer does not perform complete lubrication system oil changes of the mill shaft bearing oil as outlined per the manufacturer's operations manual. This violation most recently existed from May 17, 2017 through May 31, 2017 at the Cambria, WI dry corn milling facility.
- b) The employer is not shutting down the equipment on a weekly basis to remove product build-up from the inside of the gap mill, to include the grinding baffle, rotor, and mill housing. This violation most recently existed from May 17, 2017 through May 31, 2017 at the Cambria, WI dry corn milling facility.

To abate this violation, the employer must develop and implement preventative maintenance procedures including lubrication and other appropriate maintenance in accordance with manufacturer recommendations, or as otherwise determined necessary by prior operating records, for covered equipment such as dryers, grain stream processing equipment, dust collection equipment including filter collectors, and bucket elevators.

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

Inspection Number: 1236533
Inspection Date(s): 06/01/2017 - 11/15/2017
Issuance Date: 11/17/2017



Citation and Notification of Penalty

Company Name: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Pursuant to 29 CFR 1903.19, abatement certification and documentation are required for this item. The employer's certification that abatement is complete must include [in addition to the requirements in 1903.19(h)], the date and method of abatement and a statement that affected employees have been informed of the abatement. The employer must also submit documents demonstrating that abatement is complete to include, but not limited to, evidence of the purchase or repair of equipment, photographic or video evidence of abatement, or other written records.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated: 12/08/2017

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: Didion Milling, Inc.

Inspection Site: 501 S. Williams Street, Cambria, WI 53923

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 11a Type of Violation: **Willful**

29 CFR 1910.272(m)(1)(i): Regularly scheduled inspections of at least the mechanical and safety control equipment associated with dryers, grain stream processing equipment, dust collection equipment including filter collectors, and bucket elevators were not accomplished:

The employer does not implement regularly scheduled inspections pertaining to mechanical equipment on the South Bauermeister GM-120 gap mill (Employer ID# M13030) within the employer's established preventative maintenance procedures, as follows:

- a) Quarterly inspections are not getting completed within the employer's established time frame. This violation most recently existed from May 17, 2017 through May 31, 2017 at the Cambria, WI dry corn milling facility.
- b) Critical steps as outlined in the employer's preventative maintenance procedures within weekly, monthly, and quarterly inspections that required the equipment to be shut down are not being performed. This violation most recently existed from May 17, 2017 through May 31, 2017 at the Cambria, WI dry corn milling facility.

To abate this violation, the employer must implement preventative maintenance procedures consisting of performance of regularly scheduled inspections of the mechanical equipment associated with covered equipment such as dryers, grain stream processing equipment, dust collection equipment including filter collectors, and bucket elevators.

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

Inspection Number: 1236533
Inspection Date(s): 06/01/2017 - 11/15/2017
Issuance Date: 11/17/2017



Citation and Notification of Penalty

Company Name: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Pursuant to 29 CFR 1903.19, abatement certification and documentation are required for this item. The employer's certification that abatement is complete must include [in addition to the requirements in 1903.19(h)], the date and method of abatement and a statement that affected employees have been informed of the abatement. The employer must also submit documents demonstrating that abatement is complete to include, but not limited to, evidence of the purchase or repair of equipment, photographic or video evidence of abatement, or other written records.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:	12/08/2017
Proposed Penalty:	\$126749.00

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: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Citation 2 Item 11b Type of Violation: **Willful**

29 CFR 1910.272(m)(1)(ii): Lubrication and other appropriate maintenance in accordance with manufacturers' recommendations, or as determined necessary by prior operating records were not accomplished:

The employer does not ensure that preventative maintenance procedures incorporate appropriate maintenance steps communicated by the equipment manufacturer for the South Bauermeister GM-120 gap mill, (employer ID # M13030) located on the 1st floor of B mill, such as, but not limited to:

- a) The employer does not perform complete lubrication system oil changes of the mill shaft bearing oil as outlined per the manufacturer's operations manual. This violation most recently existed from May 17, 2017 through May 31, 2017 at the Cambria, WI dry corn milling facility.
- b) The employer is not shutting down the equipment on a weekly basis to remove product build-up from the inside of the gap mill, to include the grinding baffle, rotor, and mill housing. This violation most recently existed from May 17, 2017 through May 31, 2017 at the Cambria, WI dry corn milling facility.

To abate this violation, the employer must develop and implement preventative maintenance procedures including lubrication and other appropriate maintenance in accordance with manufacturer recommendations, or as otherwise determined necessary by prior operating records, for covered equipment such as dryers, grain stream processing equipment, dust collection equipment including filter collectors, and bucket elevators.

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

Inspection Number: 1236533
Inspection Date(s): 06/01/2017 - 11/15/2017
Issuance Date: 11/17/2017



Citation and Notification of Penalty

Company Name: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Pursuant to 29 CFR 1903.19, abatement certification and documentation are required for this item. The employer's certification that abatement is complete must include [in addition to the requirements in 1903.19(h)], the date and method of abatement and a statement that affected employees have been informed of the abatement. The employer must also submit documents demonstrating that abatement is complete to include, but not limited to, evidence of the purchase or repair of equipment, photographic or video evidence of abatement, or other written records.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated: 12/08/2017

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: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Citation 2 Item 12 Type of Violation: **Willful**

29 CFR 1910.272(m)(1)(i): Regularly scheduled inspections of at least the mechanical and safety control equipment associated with dryers, grain stream processing equipment, dust collection equipment including filter collectors, and bucket elevators were not accomplished:

The employer does not perform regularly scheduled inspections of safety control equipment such as monitors, sensors, alarms, and associated interlocks on equipment such as size reduction equipment (hammermills, gap mills, roller mills), fluid bed dryers, filter dust collectors, and bucket elevator legs. This violation most recently existed from May 17, 2017 through May 31, 2017 at the Cambria, WI dry corn milling facility.

To abate this violation, the employer must develop and implement preventative maintenance procedures consisting of the performance of regularly scheduled inspections of the safety control equipment associated with covered equipment such as dryers, grain stream processing equipment, dust collection equipment including filter collectors, and bucket elevators.

Pursuant to 29 CFR 1903.19, abatement certification and documentation are required for this item. The employer's certification that abatement is complete must include [in addition to the requirements in 1903.19(h)], the date and method of abatement and a statement that affected employees have been informed of the abatement. The employer must also submit documents demonstrating that abatement is complete to include, but not limited to, evidence of the purchase or repair of equipment, photographic or video evidence of abatement, or other written records.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:	12/08/2017
Proposed Penalty:	\$126749.00



Citation and Notification of Penalty

Company Name: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Citation 2 Item 13 Type of Violation: **Willful**

29 CFR 1910.272(m)(1)(ii): Lubrication and other appropriate maintenance in accordance with manufacturers' recommendations, or as determined necessary by prior operating records were not accomplished:

The employer does not ensure that preventative maintenance procedures incorporate appropriate maintenance steps communicated by the equipment manufacturer for the Pregel Bauermeister GM-80 gap mill (employer ID #M12227) located on the 1st floor of B Mill as follows:

- a) The employer does not complete repacking of GM-80 mill shaft bearing with new grease every 2,000 hours as outlined per the manufacturer's operations manual. This violation most recently existed from May 17, 2017 through May 31, 2017 at the Cambria, WI dry corn milling facility.
- b) The employer is not shutting down the equipment on a weekly basis to remove product build-up from the inside of the gap mill, to include the grinding baffle, rotor, and mill housing. This violation most recently existed from May 17, 2017 through May 31, 2017 at the Cambria, WI dry corn milling facility.

To abate this violation, the employer must develop and implement preventative maintenance procedures including lubrication and other appropriate maintenance in accordance with manufacturer recommendations, or as otherwise determined necessary by prior operating records, for covered equipment such as dryers, grain stream processing equipment, dust collection equipment including filter collectors, and bucket elevators.

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

Inspection Number: 1236533
Inspection Date(s): 06/01/2017 - 11/15/2017
Issuance Date: 11/17/2017



Citation and Notification of Penalty

Company Name: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Pursuant to 29 CFR 1903.19, abatement certification and documentation are required for this item. The employer's certification that abatement is complete must include [in addition to the requirements in 1903.19(h)], the date and method of abatement and a statement that affected employees have been informed of the abatement. The employer must also submit documents demonstrating that abatement is complete to include, but not limited to, evidence of the purchase or repair of equipment, photographic or video evidence of abatement, or other written records.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:	12/08/2017
Proposed Penalty:	\$126749.00

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: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923

Citation 2 Item 14 Type of Violation: **Willful**

29 CFR 1910.272(m)(2): The employer did not promptly correct dust collection systems which were malfunctioning or which were operating below designed efficiency:

The employer does not ensure that dust collection systems that are malfunctioning or operating below designed efficiency are promptly corrected. This violation was most recently documented as occurring as outlined below:

On or about May 17, 2017 through May 31, 2017, the employer had not ensured that documented capture deficiencies associated with the Pack Line #1 filter dust collector had been promptly corrected.

To abate this violation, the employer must ensure that documented deficiencies with dust collection systems (such as low capture velocities, duct velocities, etc.) are promptly corrected.

Pursuant to 29 CFR 1903.19, abatement certification and documentation are required for this item. The employer's certification that abatement is complete must include [in addition to the requirements in 1903.19(h)], the date and method of abatement and a statement that affected employees have been informed of the abatement. The employer must also submit documents demonstrating that abatement is complete to include, but not limited to, evidence of the purchase or repair of equipment, photographic or video evidence of abatement, or other written records.

ABATEMENT DOCUMENTATION REQUIRED PER 29 CFR 1903.19(d)

Date By Which Violation Must be Abated:
Proposed Penalty:

01/09/2018
\$126749.00

A handwritten signature in blue ink, reading "Chad Greenwood", written over a horizontal line.

Chad Greenwood
Acting Area Director

U.S. Department of Labor
Occupational Safety and Health Administration
4802 E. Broadway
Madison, WI 53716
Phone: 608-441-5388 Fax: 608-441-5400



INVOICE / DEBT COLLECTION NOTICE

Company Name: Didion Milling, Inc.
Inspection Site: 501 S. Williams Street, Cambria, WI 53923
Issuance Date: 11/17/2017

Summary of Penalties for Inspection Number	1236533
Citation 1, Serious	\$63,375.00
Citation 2, Willful	\$1,774,486.00
TAL PROPOSED PENALTIES	\$1,837,861.00

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.



Chad Greenwood

Acting Area Director



Date