

U.S. Department of Labor

Occupational Safety and Health Administration
701 Lee Street
Suite 950
Des Plaines, IL 60016
Phone: 847-803-4800 Fax: 847-390-8220



Citation and Notification of Penalty

To:

Hi Temp Northlake LLC, dba Bluewater Thermal
Solutions
and its successors
75 E. Lake Street
Northlake, IL 60164

Inspection Number: 994383**Inspection Date(s):** 09/09/2014 - 02/23/2015**Issuance Date:** 03/06/2015**Inspection Site:**

75 E. Lake Street
Northlake, IL 60164

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 \$50,000 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 03/06/2015. The conference will be held by telephone or at the OSHA office located at 701 Lee Street, Suite 950, Des Plaines, IL 60016 on _____ at _____.

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

CERTIFICATION OF CORRECTIVE ACTION WORKSHEET

Company Name: Hi Temp Northlake LLC, dba Bluewater Thermal Solutions
Inspection Site: 75 E. Lake Street, Northlake, IL 60164
Issuance Date: 03/06/2015

Inspection Number: 994383

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, 701 Lee Street, Suite 950, Des Plaines, IL 60016**

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: Hi Temp Northlake LLC, dba Bluewater Thermal Solutions

Inspection Site: 75 E. Lake Street, Northlake, IL 60164

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

29 CFR 1910.119(c)(1): Employers did not develop a written plan of action regarding the implementation of the employee participation required by this paragraph.

a) Hi Temp Northlake LLC. dba Bluewater Thermal Solutions - The employer did not develop a written plan of action regarding the implementation of employee participation for the covered process at the facility.

In accordance with 29 CFR 1903.19(c), abatement certification is required for this violation (using the CERTIFICATION OF CORRECTIVE ACTION WORKSHEET).

Date By Which Violation Must be Abated:
Proposed Penalty:

05/13/2015
\$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: Hi Temp Northlake LLC, dba Bluewater Thermal Solutions

Inspection Site: 75 E. Lake Street, Northlake, IL 60164

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 2 a Type of Violation: **Serious**

29 CFR 1910.119(d)(2)(i)(D): The employer did not ensure that information concerning the technology of the process included safe upper and lower limits for such items as temperature, pressure, flows or compositions.

a) Hi Temp LLC. dba Bluewater Thermal Solutions - The employer did not ensure that the information regarding the technology of the covered process at the facility such as ammonia dissociation included safe upper and lower limits for items as temperatures, pressures, flows or compositions.

In Accordance with 29 CFR 1903.19(c), abatement certification is required for this violation (using the CERTIFICATION OF CORRECTIVE ACTION WORKSHEET).

Date By Which Violation Must be Abated:

05/13/2015

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.



Citation and Notification of Penalty

Company Name: Hi Temp Northlake LLC, dba Bluewater Thermal Solutions

Inspection Site: 75 E. Lake Street, Northlake, IL 60164

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

29 CFR 1910.119(d)(2)(i)(E): The employer did not ensure that the information concerning the technology of the process included an evaluation of the consequences of deviations, including those affecting the safety and health of employees.

a) Hi Temp Northlake LLC. dba Bluewater Thermal Solutions -The employer did not ensure that the information concerning the technology of the covered processes at the facility included an evaluation of the consequences of deviation, including those affecting the safety and health of employees.

In accordance with 29 CFR 1903.19(d) abatement certification is required for this violation (using the CERTIFICATION OF CORRECTIVE ACTION WORKSHEET).

Date By Which Violation Must be Abated:

05/13/2015



Citation and Notification of Penalty

Company Name: Hi Temp Northlake LLC, dba Bluewater Thermal Solutions

Inspection Site: 75 E. Lake Street, Northlake, IL 60164

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 3 a Type of Violation: **Serious**

29 CFR 1910.119(e)(3)(iii): The process hazard analysis did not address the engineering and administrative controls applicable to the hazards and their interrelationship, such as, appropriate application of detection methodologies to provide early warning of releases: (Acceptable detection methods might include process monitoring and control instrumentation with alarms, and detection hardware such as hydrocarbon sensors.):

- a) Hi Temp Northlake LLC. dba Bluewater Thermal Solutions - The employer's January 13, 2011 and April 30, 2014 process hazard analyses (PHA) did not identify the appropriate safeguards to control high consequences hazards for the ammonia dissociators. The employer used administrative controls such as procedures to safeguard against catastrophic hazards where engineering controls such as automatic shutoffs should have been used.
- b) Hi Temp Northlake LLC. dba Bluewater Thermal Solutions - The employer's January 13, 2011 and April 30, 2014 process hazard analyses (PHA) did not identify the appropriate safeguards to control high consequences hazards such as
- an ammonia leak from the process piping located inside the facility and at ammonia dissociators.
 - an ammonia pipe located inside the facility getting damaged.
 - a power failures, including total, brief, partial, or brownout on the ammonia dissociators.
 - a failure of the hydrogen fueled furnaces and the resulting levels hydrogen, below the upper explosive limit, on the upstream ammonia dissociators.
 - a loss of pressure in the ammonia system including the ammonia dissociators.

In accordance with 29 CFR 1903.19(c), abatement certification is required for this violation (using the CERTIFICATION OF CORRECTIVE ACTION WORKSHEET).

Date By Which Violation Must be Abated:

05/13/2015

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.



Citation and Notification of Penalty

Company Name: Hi Temp Northlake LLC, dba Bluewater Thermal Solutions
Inspection Site: 75 E. Lake Street, Northlake, IL 60164

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

29 CFR 1910.119(e)(3)(v): The process safety hazard analyses did not address facility siting.

a) Hi Temp Northlake LLC. dba Bluewater Thermal Solutions - The employer's January 13, 2011 and April 30, 2014 process hazard analyses (PHA) did not address for the process of ammonia dissociation, the facility siting, which included, but are not limited to:

- 1) The spacing between components in the furnace area.
- 2) The location of large inventories of ammonia in the outside and inside storage area.
- 3) The location of furnaces, weld shops, forklift traffic and other likely sources of ignition.
- 4) The location of the truck dock in relation to the ammonia storage tanks.
- 5) The electrical classification of the facility.

In accordance with 29 CFR 1903.19(c), abatement certification is required for this (using the CERTIFICATION OF CORRECTIVE ACTION WORKSHEET).

Date By Which Violation Must be Abated:

05/13/2015



Citation and Notification of Penalty

Company Name: Hi Temp Northlake LLC, dba Bluewater Thermal Solutions
Inspection Site: 75 E. Lake Street, Northlake, IL 60164

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

29 CFR 1910.119(e)(3)(vi): The process hazard analyses did not address human factors.

a) Hi Temp Northlake LLC. dba Bluewater Thermal Solutions - The employer's January 13, 2011 and April 30, 2014 process hazard analyses (PHA) did not address human factors affecting the process of ammonia dissociators such as but not limited to, the following:

- 1) Lack of trained maintenance personnel or lead supervisors;
- 2) Coverage when trained employees are on leave;
- 3) Operator overload during normal operations, emergency operations and emergency shutdown.

In accordance with 29 CFR 1903.19(c), abatement certification is required for this violation (using the CERTIFICATION OF CORRECTIVE ACTION WORKSHEET).

Date By Which Violation Must be Abated:

05/13/2015



Citation and Notification of Penalty

Company Name: Hi Temp Northlake LLC, dba Bluewater Thermal Solutions
Inspection Site: 75 E. Lake Street, Northlake, IL 60164

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

29 CFR 1910.119(e)(3)(vii): The process hazard analyses did not address a qualitative evaluation of a range of the possible safety and health effects of failure of controls on employees in the workplace.

a) Hi Temp Northlake LLC. dba Bluewater Thermal Solutions - The employer's January 13, 2011 and April 30, 2014 Process Hazard Analyses (PHA) did not address an evaluation of possible safety and health effects due to failure of each control on employees such as employee exposures to inhalation hazards in case of a chemical release.

In accordance with 29 CFR 1903.19(c), abatement certification is required for this violation (using the CERTIFICATION OF CORRECTIVE ACTION WORKSHEET).

Date By Which Violation Must be Abated:

05/13/2015



Citation and Notification of Penalty

Company Name: Hi Temp Northlake LLC, dba Bluewater Thermal Solutions

Inspection Site: 75 E. Lake Street, Northlake, IL 60164

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

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

a.) Hi Temp Northlake LLC. dba Bluewater Thermal Solutions - The operating procedures for #224, 226, and 228 Dissociators Start Up and Shut down, did not adequately address safety systems such as specific alarms levels and the lack of automatic shutdown for the dissociators.

In accordance with 29 CFR 1903.19(c), abatement certification is required for this violation (using the CERTIFICATION OF CORRECTIVE ACTION WORKSHEET).

Date By Which Violation Must be Abated:
Proposed Penalty:

05/13/2015
\$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: Hi Temp Northlake LLC, dba Bluewater Thermal Solutions
Inspection Site: 75 E. Lake Street, Northlake, IL 60164

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

29 CFR 1910.119(g)(1)(i): The employer did not ensure each employee presently involved in operating a process, and each employee before being involved in operating a newly assigned process, were trained in an overview of the process and in the operating procedures as specified in paragraph (f) of this section.

a) Hi Temp Northlake LLC. dba Bluewater Thermal Solutions - The maintenance personnel and lead supervisors for the ammonia dissociators did not receive process overview training prior to being required to operate the process. The employees did not receive overview training on the hazards of the process, standard operating procedures, chemicals in the process and protective measures in place.

In accordance with 29 CFR 1903.19(c), abatement certification is required for this violation (using the CERTIFICATION OF CORRECTIVE ACTION WORKSHEET).

Date By Which Violation Must be Abated:
Proposed Penalty:

05/13/2015
\$7000.00



Citation and Notification of Penalty

Company Name: Hi Temp Northlake LLC, dba Bluewater Thermal Solutions
Inspection Site: 75 E. Lake Street, Northlake, IL 60164

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

29 CFR 1910.119(j)(3): The employer did not train each employee involved in maintaining the on-going integrity of process equipment in an overview of that process and its hazards and in the procedures applicable to the employee's job tasks to assure that the employee could perform the job tasks in a safe manner.

a) Hi Temp Northlake LLC. dba Bluewater Thermal Solutions - The employer did not train employees involved in maintaining the on-going integrity of process equipment in the inspection process and procedures required to perform the job tasks for the covered process at the facility.

In accordance with 29 CFR 1903.19(d) abatement certification is required for this violation (using the CERTIFICATION OF CORRECTIVE ACTION WORKSHEET).

Date By Which Violation Must be Abated:
Proposed Penalty:

05/13/2015
\$7000.00



Citation and Notification of Penalty

Company Name: Hi Temp Northlake LLC, dba Bluewater Thermal Solutions
Inspection Site: 75 E. Lake Street, Northlake, IL 60164

Citation 2 Item 1 Type of Violation: **Other-than-Serious**

29 CFR 1910.119(n): The employer did not establish and implement an emergency action plan for the entire plant in accordance with the provisions of 29 CFR 1910.38. In addition, the emergency action plan shall include procedures for handling small releases.

a) Hi Temp Northlake LLC. dba Bluewater Thermal Solutions -The employer did not establish or implement an emergency action plan that included procedures for handling small releases.

In accordance with 29 CFR 1903.19(c), abatement certification is required for this violation (using the CERTIFICATION OF CORRECTIVE ACTION WORKSHEET).

Date By Which Violation Must be Abated:
Proposed Penalty:

05/13/2015
\$0.00


Angeline Loftus
Area Director

U.S. Department of Labor
Occupational Safety and Health Administration
701 Lee Street
Suite 950
Des Plaines, IL 60016
Phone: 847-803-4800 Fax: 847-390-8220



INVOICE / DEBT COLLECTION NOTICE

Company Name: Hi Temp Northlake LLC, dba Bluewater Thermal Solutions
Inspection Site: 75 E. Lake Street, Northlake, IL 60164
Issuance Date: 03/06/2015

Summary of Penalties for Inspection Number	994383
Citation 1, Serious	\$42000.00
Citation 2, Other-than-Serious	\$0.00
TOTAL PROPOSED PENALTIES	\$42000.00

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 \$50,000 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

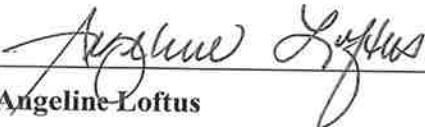
account, the bank will attempt to make the transfer up to 2 times.

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.



Angeline Loftus

Area Director



Date