



Grain Storage Structure Entry Procedures

Train, Plan, Prepare – Act!

Grain Handling Safety Coalition

1. Train, Plan, Prepare - then Act!

- A. Train - workers on hazards, LOTO, entry, and responsibilities.
- B. Plan - Bin entry plan, LOTO, Emergency Action plan
- C. Prepare – policy, procedures
 - i. Who is responsible for the permit/checklist
 - ii. Who can enter bins & how it will be done
 - iii. Emergency action plan
- D. Act – **Rushing into a bin is NEVER the right answer!**

2. Determine need for entry.

- A. Reason – routine (ex. temp monitoring) vs. Problem (ex. out of condition grain)
- B. Task to perform – PPE, equipment, tools
- C. Trained workers – entrant and observer
- D. Explore alternatives to entry

3. Determine if safe entry can be made. Evaluate the conditions of the storage structure.

4. Complete an entry permit or checklist. A permit/checklist addresses critical safety issues.

- A. Trained workers - **Untrained workers should never enter bins!**
- B. Atmospheric Hazard Potential
- C. Grain Conditions
- D. Equipment & Other Hazard Potential - **LOTO**
- E. Personal Protective Equipment Needs – Harness & Lifeline
- F. Rescue Equipment Available

5. Double Check. Hazard mitigation in place for all identified hazards.

- A. **LOTO**
- B. Prepare sump gates/guards. Install immediately upon entry.
- C. Rescue equipment available.

6. Pre-Entry Meeting – entrant, observer, supervisor (if different).

- A. Top, Side, Bottom entry
- B. Review tasks to complete and how to perform
- C. Review present & potential hazards; how to eliminate or mitigate.
- D. Review PPE needed, tools, equipment

7. Entrant – completes tasks. Continually reassess hazards, constantly communicate with observer.

8. Observer – Must NOT leave! If the observer has to step away, the entrant must exit.

- A. Maintains constant communication – visual is best.
- B. Controls the lifeline.
- C. Knows how to call for help & initiate rescue from outside the bin.

No one should enter a bin without an observer present!

9. If a new hazard arises during entry, discontinue entry until the hazard is mitigated correctly.

10. Complete work, clean up tools, discuss any problems. Clean & Store PPE properly!

NO ONE

**Should enter a bin if
they cannot be protected
against the hazards
present!**



**Failure to LOTO is leading
cause of entry fatalities!**