

GRAIN STANDARD COMPLIANCE CHECKLIST
1910.272

- _____ 1. Emergency Action Plan (must be written if employer has 11 or more employees report to the location, including clerical sales, drivers, etc.). Otherwise, OSHA considers oral communication to be adequate.
- _____ 2. Post emergency phone numbers next to all phones: office, elevator, warehouse, etc.
- _____ 3. Training – annually and when changes in job assignment expose employees to new hazards.

A. General Safety

- _____ 1. Hand tools
- _____ 2. Lifting
- _____ 3. Lift truck operation
- _____ 4. Fire extinguisher
- _____ 5. Ladders at proper angle
- _____ 6. Manlift operation
- _____ 7. Equipment overload
- _____ 8. Dust filter
- _____ 9. Keep walkways clear of tools, debris, spilled grain, etc.
- _____ 10. Machine guards in place
- _____ 11. Grinder (bench/angle)
- _____ 12. Shop safety
- _____ 13. Compressed gas cylinders
- _____ 14. _____
- _____ 15. _____
- _____ 16. _____
- _____ 17. _____

B. Recognition and preventive measures for hazards related to dust accumulation and common ignition sources such as smoking

C. Specific procedures and safety practices related to employee job tasks

- _____ 1. Cleaning procedures for grinding equipment
- _____ 2. Clearing procedures for choked legs
- _____ 3. Housekeeping procedure
- _____ 4. Hot Work procedures (permit where required)

- _____ 5. Preventive maintenance
- _____ 6. Lockout/Tagout procedure
- _____ 7. Entry into bins, silos and tanks (permits when required)
 - _____ a. Determine if presence of combustible or toxic gases exists
 - _____ b. Determine if oxygen level is below 19.5%
 - _____ c. Entry from top – employee wears a body harness with a lifeline or boatswain’s chair
 - _____ d. Observer outside (stay in communication), trained in rescue procedures including notification methods for obtaining additional assistance
 - _____ e. Do not enter under a bridging condition or where hung-up grain on sides may fall
 - _____ f. Provide rescue equipment specifically suited for the bin, silo, or tank entered

D. Contractors – informed of hazards of dust explosions

- _____ 1. Explain emergency action plan
- _____ 2. Type of alarm, meeting place, smoking policy

E. Housekeeping

- _____ Written program for each location

F. Receiving pit grate openings 2½” maximum one way (not a grid)

- _____ Grate openings measured center-to-center 2½” maximum

G. Filter collectors

- _____ Monitor (magnahelic gauge) to determine pressure drop

H. Preventive maintenance regular inspections

- _____ 1. Maintain a written log of inspections and maintenance on grain dryers, grain stream processing equipment, dust collectors, bucket elevators, bearings associated with gallery and tunnel areas
- _____ 2. Grain dryers
- _____ 3. Promptly correct or remove from service overheated bearings associated with inside legs
- _____ 4. Promptly correct or remove from service slipping or misaligned belts associated with inside legs

I. Lock-out/Tag-out

- _____ 1. Written procedures for each piece of equipment
- _____ 2. Training (Authorized and Affected)

J. Grain stream processing equipment must be provided with an effective means to remove ferrous material from incoming grain stream

K. Emergency escape

- _____ 1. Two means – from galleries (bin decks)
- _____ 2. One means – from tunnels of elevators built before March 30, 1988 Two means – from tunnels of elevators built after March 30, 1988

L. Grain dryers

- _____ 1. Automatic controls to shut off fuel supply in case of power or flame failure or interruption of air movement through exhaust fan
- _____ 2. Automatic controls to stop grain from being fed into dryer if excessive temperature occurs in the exhaust of drying section

M. Inside bucket elevators (not outside leg)

- _____ 1. Shall not be jogged
- _____ 2. Belts and lagging shall be conductive
- _____ 3. Access to head and tail section for inspection, clean out
- _____ 4. As of April 1, 1991, mount bearings external to leg casing
- _____ 5. Provide monitoring (temperature) to monitor condition of bearings mounted or making contact with interior of leg casing, including inner dust seals
- _____ 6. As of April 1, 1991, motion detection monitoring of leg belt
- _____ 7. As of April 1, 1991, belt alignment monitoring of leg belt
- _____ 8. Provide daily visual and written inspection and monitoring of inside bucket elevator belts by verifying the methodology being used to ascertain proper belt speed and alignment by actual visual observation. This must be a part of training and preventive maintenance and be properly documented. This may only be used in lieu of monitors for those elevators with less than 1 million bushels of permanent storage capacity.