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UNITED STATES ENVIRONMENTAL PROTECTION AGENCY  
REGION 7  
11201 RENNER BOULEVARD  
LENEXA, KANSAS 66219

**EXPEDITED SETTLEMENT AGREEMENT (ESA)**

**DOCKET NO.:** CAA-07-2013-0004

**This ESA is issued to:** BHJ USA, Inc.

**At:** 2472 170<sup>th</sup> Street, Fort Dodge, Iowa 50501

**for violating Section 112(r)(7) of the Clean Air Act.**

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The United States Environmental Protection Agency, Region 7 (EPA) and BHJ USA, Inc. (Respondent), have agreed to a settlement of this action before filing of a complaint, and thus this action is simultaneously commenced and concluded pursuant to Rules 22.13(b) and 22.18(B)(2) of the Consolidated Rules of Practice Governing the Administrative Assessment of Civil Penalties, Issuance of Compliance or Corrective Action Orders, and the Revocation, Termination or Suspension of Permits (Consolidated Rules), 40 C.F.R. §§ 22.13(b), 22.18(b)(2).

The Complainant, by delegation of the Administrator of the EPA, is the Director of the Air and Waste Management Division. The Respondent is BHJ USA, Inc., 2472 170<sup>th</sup> Street, Fort Dodge, Iowa 50501.

This is an administrative action for the assessment of civil penalties instituted pursuant to Section 113(d) of the Clean Air Act (CAA). Pursuant to Section 113(d) of the CAA, 42 U.S.C. § 7413(d), the Administrator and the Attorney General jointly determined that cases which meet the criteria set forth in EPA's policy entitled "Use of Expedited Settlements in Addressing Violations of the Clean Air Act Chemical Accident Prevention Provision, 40 C.F.R. Part 68," dated January 5, 2004, are appropriate for administrative penalty action.

**ALLEGED VIOLATIONS**

On May 16 and 17, 2012, an authorized representative of the EPA conducted a compliance inspection of the Respondent's facility located at 2472 170<sup>th</sup> Street, Fort Dodge, Iowa, to determine compliance with the Risk Management Plan (RMP) regulations promulgated at 40 C.F.R. Part 68 under Section 112(r) of the CAA. The EPA found that the Respondent had violated regulations implementing Section 112(r) of the CAA by failing to comply with the regulations as noted on the enclosed Risk Management Program Inspection Findings (RMP Findings), which is hereby incorporated by reference.

**SETTLEMENT**

In consideration of Respondent's size of business, its full compliance history, its good faith effort to comply, and other factors as justice may require, and upon consideration of the

entire record, the parties enter into the ESA in order to settle the violations, described in the enclosed RMP Findings, for the total penalty amount of **\$4,020**.

This settlement is subject to the following terms and conditions:

The Respondent by signing below waives any objections that it may have regarding jurisdiction, neither admits nor denies the specific factual allegations contained herein and in the RMP Findings, and consents to the assessment of the penalty as stated above. Respondent waives its rights to a hearing afforded by Section 113(d)(2)(A) of the CAA, 42 U.S.C. § 7413(d)(2)(A), and to appeal this ESA. Each party to this action shall bear its own costs and fees, if any. Respondent also certifies, subject to civil and criminal penalties for making a false submission to the United States Government, that the Respondent has corrected the violations listed in the enclosed RMP Findings and has sent a cashier's check or certified check (payable to the "United States Treasury") in the amount of **\$4,020** in payment of the full penalty amount to the following address:

U.S. Environmental Protection Agency  
Fines and Penalties  
Cincinnati Finance Center  
P.O. Box 979077  
St. Louis, Missouri 63197-9000

The Docket Number of this ESA is CAA-07-2013-0004, and must be included on the check.

This original ESA, a copy of the completed RMP Findings, and a copy of the check must be sent by certified mail to:

Deanna Smith  
Office of Regional Counsel  
U.S. Environmental Protection Agency, Region 7  
11201 Renner Boulevard  
Lenexa, Kansas 66219.

A copy of the check must also be sent to:

Kathy M. Robinson  
Regional Hearing Clerk  
U.S. Environmental Protection Agency, Region 7  
11201 Renner Boulevard  
Lenexa, Kansas 66219.

Upon Respondent's submission of the signed original ESA, EPA will take no further civil action against Respondent for the alleged violations of the CAA referenced in the RMP Findings.

In the Matter of BHJ USA, Inc.  
Docket No. CAA-07-2013-0004  
Page 3 of 6

The EPA does not waive any other enforcement action for any other violations of the CAA or any other statute.

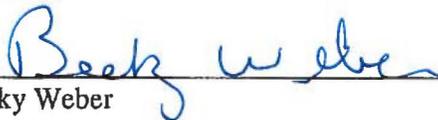
If the signed original ESA with an attached copy of the check is not returned to the EPA Region 7 office at the above address in correct form by the Respondent within 45 days of the date of Respondent's receipt of it (90 days if an extension is granted), the proposed ESA is withdrawn, without prejudice to EPA's ability to file an enforcement action for the violations identified herein and in the RMP Findings.

This ESA is binding on the parties signing below.

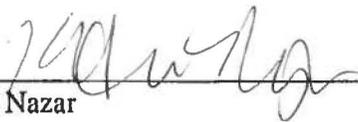
This ESA is effective upon filing with the Regional Hearing Clerk.



FOR COMPLAINANT:

  
\_\_\_\_\_  
Becky Weber  
Director  
Air and Waste Management Division  
EPA Region 7

Date: 2-15-13

  
\_\_\_\_\_  
Kristen Nazar  
Assistant Regional Counsel  
Office of Regional Counsel  
EPA Region 7

Date: 2/12/12

I hereby ratify the ESA and incorporate it herein by reference. It is so ORDERED.

Karina Borromeo  
Karina Borromeo  
Regional Judicial Officer

Date: Feb. 21, 2013

Risk Management Program Inspection Findings  
CAA § 112(r) Violations

BHJ USA, Inc.  
2472 170<sup>th</sup> Street  
Fort Dodge, Iowa 50501  
Docket No. CAA-07-2013-0004

**COMPLETE THIS FORM AND RETURN IT WITH THE ESA.**

**VIOLATIONS**

**PENALTY AMOUNT**

Prevention Program

**Safety Information [§ 68.65(d)(2)]**

**\$1,500**

The owner or operator fail to document that equipment complies with recognized and generally accepted good engineering practices.

*How was this addressed:*

PSI DOCUMENT HAS BEEN DEVELOPED PER ATTACHMENT (A) REGARDING  
"DESIGN CODES, STANDARDS AND GOOD ENGINEERING PRACTICES" PRESENTED AT EPA  
REVIEW ON 5/16/12. BHJ USA, INC IS IN COMPLIANCE WITH ALL CODES,  
STANDARDS AND PRACTICES AS REFERENCED IN ATTACHMENT (A).

Prevention Program

**Process Hazard Analysis [68.67(e)]**

**\$1,500**

The owner or operator failed to establish a system to promptly address the team's findings and recommendations; assured that the recommendations are resolved in a timely manner and documented; document what actions are to be taken; complete actions as soon as possible; develop a written schedule of when these actions are to be completed; and communicate the actions to operating, maintenance, and other employees whose work assignments are in the process and who may be affected by the recommendations or actions.

*How was this addressed:*

PHA FINDINGS TRACKING SYSTEM HAS BEEN DEVELOPED AS PER ATTACHMENT (B),  
"SUMMARY OF PHA RECOMMENDATIONS." INCLUDED WITH THIS ARE DATES OF  
COMPLETION, PRIORITY LIST, PERSON RESPONSIBLE FOR CHANGES, ETC. BHJ USA, INC.  
HAS IMPLEMENTED A POLICY TO NOTIFY AFFECTED EMPLOYEES OF CHANGES DUE  
TO PHA FINDINGS DURING PHA STUDY REVIEW MEETING PER ATTACHMENT (B).

Prevention Program

**Process Hazard Analysis [68.67(f)]**

**\$2,500**

The owner or operator failed to insure that the PHA has been updated and revalidated by a team every five years after the completion of the initial PHA to assure that the PHA is consistent with the current process.

*How was this addressed:*

PHA WAS NOT UPDATED OR REVALIDATED EVERY FIVE YEARS BECAUSE THE PHA(S) UNDER THE "FORT DODGE ICE & COLD" NAME WERE NOT FOUND OR PASSED ON TO BHD USA, INC. SEE ATTACHMENT (C) FOR BHD USA, INC'S STATEMENT REGARDING PREVIOUS "PHA DOCUMENTATION."

**Operating procedures [68.69(c)]**

**\$1,200**

The owner or operator failed to certify annually that the operating procedures are current and accurate and that procedures have been reviewed as often as necessary.

*How was this addressed:*

PROCEDURES HAVE BEEN IMPLEMENTED TO CERTIFY THAT OPERATING PROCEDURES ARE CURRENT AND ACCURATE AS REQUIRED ANNUALLY. SEE ATTACHMENT (D) FOR CURRENT "OPERATING PROCEDURES REVIEW SUMMARY AND CERTIFICATION FORM."

**Emergency response program § 68.180**

**No Penalty Assessed**

The owner or operator failed to include a written emergency response plan that included specific actions to be taken in response to an accidental release of a regulated substance in the RMP.

*How was this addressed:*

PER OUR RMP FILING ON 5/14/12 OUR "EMERGENCY RESPONSE PROGRAM" HAS BEEN CHANGED TO REFLECT AN "EMERGENCY ACTION PROGRAM" RATHER THAN AN "EMERGENCY RESPONSE PROGRAM." SEE ATTACHMENT (E) "EXECUTIVE SUMMARY" FROM RMP SUBMITTAL.

**Total Unadjusted Penalty**

**\$6,700**

**Calculation of Adjusted Penalty**

- 1<sup>st</sup> Reference the multipliers for calculating proposed penalties for violations found during RMP inspection matrix. Finding the column for number of employees of 10 to 100 employees and the row for less than 1 to 5 times the threshold quantity of 10,000 pounds of anhydrous ammonia as listed in 40 C.F.R. Part 68.130 for the amount in a process gives a multiplier factor of 0.6. Therefore, the multiplier for BHD USA, Inc., is 0.6.
- 2<sup>nd</sup> Adjusted Penalty: \$6,700 (Unadjusted Penalty) X 0.6 (Size-Threshold Multiplier) = \$4,020 (Adjusted Penalty)
- 3<sup>rd</sup> A Penalty of \$4,020 would be assessed to BHD USA, Inc., for violations found during the RMP Compliance Inspection.

**Total Penalty**

**\$4,020**

**This section must be also be completed and signed by BHJ USA, Inc.:**

The approximate cost to correct the above items: \$ 3000.00

Compliance staff name: JAMES O'CONNOR

Signed: [Signature] Date: 2/4/13

BHJ USA, Inc.  
Ft. Dodge, IA  
Document Date: 5/16/12  
Revision Date:

(A)

## DESIGN CODES, STANDARDS, AND GOOD ENGINEERING PRACTICES

At the time of RM Program regulations in 1999, BHJ USA, Inc. in Fort Dodge, IA was owned and operated by Omaha Industries. BHJ USA, Inc. gained ownership of the facility on August 29, 2011. BHJ USA, Inc. is unaware of the original design codes, standards and the good engineering practices regarding the facility's ammonia refrigeration system installed. There have also been a number of presidents involved with the company previous to BHJ USA, Inc's ownership which resulted in deficiencies in documentation. These documents may have been misplaced, erased or accidentally destroyed. From this day forward, it is the intention of BHJ USA, Inc to follow the below standards and codes:

- (1) ANSI/IIAR 2-2008 (Addendum A), American National Standard for Equipment, Design, and Installation of Ammonia Mechanical Refrigerating Systems.
- (2) ANSI/ASHRAE 15-2010, Safety Code for Mechanical Refrigeration, American National Standards Institute/American Society of Heating, Refrigerating and Air-Conditioning Engineers, Inc.
- (3) ASME Boiler and Vessel Code: Section IX, "Welding and Brazing Qualifications"
- (4) ASME B31.5-2010, "Refrigeration Piping and Heat Transfer Components"
- (5) Uniform Mechanical Code

BHJ USA, Inc also uses the following methods to document that the equipment in the ammonia refrigeration system complies with recognized and generally accepted good engineering practices:

- (1) Start-up test reports are prepared during the design, installation and commissioning of the ammonia refrigeration system;
- (2) The equipment is compared with good engineering practices during the documentation of the process safety information;
- (3) The equipment is compared with good engineering practices when a process hazard analysis is conducted for the refrigeration system;
- (4) The Pre-Startup Safety Review Procedures are designed to ensure that all changes to the ammonia refrigeration system are reviewed to ensure that these changes comply with good engineering practices;

(B)

PROCESS SAFETY MANAGEMENT PROGRAM

SUMMARY OF PHA RECOMMENDATIONS

Facility: Fort Dodge Ice & Cold  
Date: 08/25/2009  
Facilitator: John Lingelbach (ARESCO Inc.)

Reference: Updated PHA  
System: Main  
Process: Refrigeration

DUE DATE	PERSON RESPONSIBLE	ITEM #	PRIORITY #	DATE OF COMPLETION
01/01/2010	TRENT RICHARDSON	1.16	3	11-4-09 Completed
01/01/2010	DALE HUDSON	4.18	3	11-4-09 Completed
08/25/2009	TRENT RICHARDSON	5.18	3	9/25/09 COMPLETED
01/01/2010	DALE HUDSON	5.19	2	11-19-09 Completed
06/29/2006	JIMMY PATTERSON	5.28	2	5/11/06 COMPLETED
01/01/2010	TRENT RICHARDSON	6.3	3	7-20-10 completed
-----	-----	6.4	----	NOT NECESSARY
-----	-----	6.7	-----	NOT NECESSARY
09/29/2006	DALE HUDSON	6.12	3	8/25/09 COMPLETED
09/29/2006	DALE HUDSON	6.13	3	8/25/09 COMPLETED
01/01/2010	TRENT RICHARDSON	6.15	3	11-4-09 completed
01/01/2010	TRENT RICHARDSON	6.20	3	11-4-09 Completed
-----	-----	7.1	-----	DOES NOT APPLY
05/29/2006	TRENT RICHARDSON	8.1	1	6/20/06 COMPLETED
01/01/2010	TRENT RICHARDSON	8.6	3	11-4-09 Completed
09/29/2006	DALE HUDSON	9.6	3	8/25/09 COMPLETED
11/01/2009	ARESCO	11.08	- 3	9-1-12 Completed
12/01/2009	DALE HUDSON	11.10	3	7-25-11 Completed
12/01/2009	DALE HUDSON	11.11	3	11-9-09 Completed
12/01/2009	DALE HUDSON	11.12	3	10/1/09 COMPLETED
12/01/2009	DALE HUDSON	11.14	3	11-5-09 Completed
12/01/2009	DALE HUDSON	12.2	4	8/25/09 COMPLETED
1/01/2010	DALE HUDSON	12.3	4	8/25/09 COMPLETED
3/29/2007	DALE HUDSON	12.9	4	8/25/09 COMPLETED
12/01/2009	TRENT RICHARDSON	14.2	3	11-19-09 Completed
12/01/2009	DALE HUDSON	14.10	3	8/25/09 COMPLETED
6/29/2006	JIMMY PATTERSON	14.15	2	5/21/06 COMPLETED
6/29/2006	TRENT RICHARDSON	14.23	2	7/15/06 COMPLETED
9/29/2006	DALE HUDSON	14.26	3	8/25/09 COMPLETED
01/01/2010	DALE HUDSON	15.3	- 2	9-1-12 Completed
01/01/2010	DALE HUDSON	15.38	2	10/29/10 Completed
6/29/2006	JIMMY PATTERSON	15.49	2	5/07/06 COMPLETED
9/29/2006	DALE HUDSON	15.56	3	8/25/09 COMPLETED
6/29/2006	JIMMY PATTERSON	15.65	2	5/02/06 COMPLETED
6/29/2006	JIMMY PATTERSON	15.67	2	5/04/06 COMPLETED
9/29/2006	DALE HUDSON	15.70	3	8/25/09 COMPLETED
5/29/2006	JIMMY PATTERSON	15.73	1	6/08/06 COMPLETED
1/01/2010	DALE HUDSON	15.75	2	11-3-09 Completed
6/29/2006	JIMMY PATTERSON	15.77	2	5/15/06 COMPLETED
6/29/2006	JIMMY PATTERSON	15.87	2	5/28/06 COMPLETED



BHJ USA, Inc.  
Ft. Dodge, IA  
Document Date: 5/16/12  
Revision Date:

(C)

## PHA Documentation

At the time of RM Program regulations in 1999, BHJ USA, Inc. in Fort Dodge, IA was owned and operated by Omaha Industries. BHJ USA, Inc. gained ownership of the facility on August 29, 2011. Besides the 2006 and 2009 PHAs, BHJ USA, Inc. is unaware if any other PHA's have been conducted. There have been a number of presidents involved with the company previous to BHJ USA, Inc's ownership which resulted in deficiencies in documentation. These documents may have been misplaced, erased or accidentally destroyed. From this day forward, it is the intention of BHJ USA, Inc to retain all copies of the PHAs regarding this facility.

(D)

**Operating Procedures  
Review Summary and Certification Form**

**Facility Name:** BHJ USA, Inc. Fort Dodge

**Facility Location:** 2472 170<sup>th</sup> St.  
Fort Dodge, IA 50501

**System / Equipment List:**

**SOP 1 – West Overall Refrigeration System**

- a. 1.1: W - System page 1.1.1

**SOP 2 – West Evaporative Condensers**

- a. 2.1: EC -1 roof page 2.1.1

**SOP 3 – West Compressor operation**

- a. 3.1: HSC-1; Engine Room page 3.1.1
- b. 3.2: LSC-1; Engine Room page 3.2.1
- c. 3.3: LSC- 2; Engine Room page 3.3.1
- d. 3.4: SWC-2; Engine Room (High Side Operation) page 3.4.1
- e. 3.5: SWC-2; Engine Room (Low Side Operation) page 3.5.1

**SOP 4 – West Liquid Accumulators, Pumps, and Vessels:**

- a. 4.1: LTA-1, AP-1, AP-2 Engine Room page 4.1.1
- b. 4.2: IC-1; Engine Room page 4.2.1
- c. 4.3: HPR-1; Out Side Engine Room page 4.3.1

**Operating Procedure Review:**

I have reviewed the SOP's and certify that to the best of my knowledge they are correct and accurate.

Reviewed By _____	Date: ___/___/___

- |  |   |
|--|---|
| <input type="checkbox"/> All procedures found current and accurate | <input type="checkbox"/> Additional procedures are needed |
| <input type="checkbox"/> Some procedures to be updated             | <input type="checkbox"/> Some procedures no longer needed |

**Affected SOP's:**

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

(D)

**Operating Procedures  
Review Summary and Certification Form**

**Facility Name:** BHJ USA, Inc. Fort Dodge

**Facility Location:** 2472 170<sup>th</sup> St.  
Fort Dodge, IA 50501

**System / Equipment List:**

**SOP 5 – West Evaporators & Plate Freezers:**

- a. 5.1: PF – 1; Plate freezer Room page 5.1.1
- b. 5.2: PF – 1; Plate freezer Room page 5.2.1
- c. 5.3: PF – 1; Plate freezer Room page 5.3.1
- d. 5.4 PF – 1; Plate freezer Room page 5.4.1
- e. 5.5 PF – 1; Plate freezer Room page 5.5.1
- f. 5.6 PF – 1; Plate freezer Room page 5.6.1
- g. 5.7 PF – 1; Plate freezer Room page 5.7.1
- h. 5.8 PF – 1; Plate freezer Room page 5.8.1
- i. 5.9 PF – 1; Plate freezer Room page 5.9.1
- j. 5.10 PF – 1; Plate freezer Room page 5.10.1

**SOP 6 – West Miscellaneous**

- a. 6.1: P – 1; Purger Engine Room page 6.1.1

**SOP 7 – West Line & Equipment Opening Procedures: page 7.1.1**

**SOP 8 – West Ammonia Unloading Procedures: 8.1.1**

**SOP 9 – West Quality Control of Ammonia: 9.1.1**

**SOP 10 – West Oil Draining Procedure: 10.1.1**

**SOP 11 – West Equipment Commissioning Procedures: 11.1.1**

**Operating Procedure Review:**

I have reviewed the SOP's and certify that to the best of my knowledge they are correct and accurate.

Reviewed By _____	Date: ___/___/___

- |  |   |
|--|---|
| <input type="checkbox"/> All procedures found current and accurate | <input type="checkbox"/> Additional procedures are needed |
| <input type="checkbox"/> Some procedures to be updated             | <input type="checkbox"/> Some procedures no longer needed |

**Affected SOP's:**

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(D)

**Operating Procedures  
Review Summary and Certification Form**

**Facility Name:** BHJ USA, Inc. Fort Dodge

**Facility Location:** 2472 170<sup>th</sup> St.  
Fort Dodge, IA 50501

**System / Equipment List:**

**SOP 1 – East System charging**

- a. 1.1: System Charging Engine Room (Out Side) pages 1.1.5

**SOP 2; C-1**

- a. Compressor C-1: East Engine Room; pages 2.1.19

**SOP 3; C-2**

- a. Compressor C-2: East Engine Room; pages 3.1.20

**SOP 4; C-3**

- a. Compressor C-3: East Engine Room; pages 4.1.20

**SOP 5; C-4**

- a. Compressor C-4: East Engine Room; pages 5.1.20

**SOP 6; EC-1**

- a. Evaporative Condenser EC-1 East Engine Room (Out Side) pages 6.1.13

**SOP 7; V - 1 LTR**

- a. Low Temp Recirculator V-1: East Engine Room (out Side) pages 7. 1. 23

**SOP 8; V – 2**

- a. Intermediate Recirculator V-2: East Engine Room (Out Side) pages 8. 1. 23

**SOP 9; V – 3**

- a. Controlled Pressure Receiver V-3: East Engine Room (Out Side) 9. 1. 10

**Operating Procedure Review:**

I have reviewed the SOP's and certify that to the best of my knowledge they are correct and accurate.

Reviewed By \_\_\_\_\_ Date: \_\_\_/\_\_\_/\_\_\_

All procedures found current and accurate

Additional procedures are needed

Some procedures to be updated

Some procedures no longer needed

**Affected SOP's:**

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

(D)

**Operating Procedures  
Review Summary and Certification Form**

**Facility Name:** BHJ USA, Inc. Fort Dodge

**Facility Location:** 2472 170<sup>th</sup> St.  
Fort Dodge, IA 50501

**System / Equipment List:**

**SOP 10; PR V - 4**

- a. Pilot Receiver V-4 East Engine Room; (Out Side) pages 10.1 .11

**SOP 11; TD V - 5**

- a. Transfer Drum V-5: East Engine Room; (Out Side) pages 11.1.9

**SOP 12; KD V - 6**

- a. Knockout Drum V-6: East Engine Room; (Out Side) pages 12.1.9

**SOP 13; Freezer CS - 1**

- a. Control Station CS-1: Evaporator 1; (Freezer 2) pages 13.1.16

**SOP 14; Freezer CS - 2**

- a. Control Station CS-2: Evaporator 2; (Freezer 2) pages 14.1.17

**SOP 15; Freezer CS - 4**

- a. Control Station CS-4: Evaporator 4; (Freezer 2) pages 15.1.15

**SOP 16; Freezer CS - 5**

- a. Control Station CS-5: Evaporator 5; (Freezer 2) pages 16.1.15

**SOP 17; Glycol System CS - 6**

- a. Control Station CS-6: Glycol Heat Exchanger Room; pages 17.1.10

**Operating Procedure Review:**

I have reviewed the SOP's and certify that to the best of my knowledge they are correct and accurate.

Reviewed By _____	Date: ___/___/___

- |  |   |
|--|---|
| <input type="checkbox"/> All procedures found current and accurate | <input type="checkbox"/> Additional procedures are needed |
| <input type="checkbox"/> Some procedures to be updated             | <input type="checkbox"/> Some procedures no longer needed |

**Affected SOP's:**

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

(D)

**Operating Procedures  
Review Summary and Certification Form**

**Facility Name:** BHJ USA, Inc. Fort Dodge

**Facility Location:** 2472 170<sup>th</sup> St.  
Fort Dodge, IA 50501

**System / Equipment List:**

**SOP 27; Freezer CS - 7**

- a. Control Station CS-7: Evaporator 7; (Freezer 1) pages 18.1.15

**SOP 19; Freezer CS - 8**

- a. Control Station CS-8: Evaporator 8; (Freezer 1) pages 19.1.15

**SOP 20; Freezer CS - 9**

- a. Control Station CS-9: Evaporator 9; (Freezer 3) pages 20.1.15

**SOP 21; Freezer CS - 10**

- a. Control Station CS-10: Evaporator 10; (Freezer 3) pages 21.1.15

**SOP 22; Freezer CS - 11**

- a. Control Station CS-11: Evaporator 11; (Freezer 4) pages 22.1.15

**SOP 23; Freezer CS - 12**

- a. Control Station CS-12: Evaporator 12; (Freezer 4) pages 23.1.15

**SOP 24; Freezer CS - 19**

- a. Control Station CS-19: Evaporator 19; (Blast Freezer) pages 24.1.15

**SOP 25; Freezer CS - 20**

- a. Control Station CS-20: Evaporator 20; (Blast Freezer) pages 25.1.15

**SOP 26; Freezer CS - 22**

- a. Control Station CS-22: Evaporator 22; (South Dock) pages 26.1.15

**Operating Procedure Review:**

I have reviewed the SOP's and certify that to the best of my knowledge they are correct and accurate.

Reviewed By _____	Date: ___/___/___

- |  |   |
|--|---|
| <input type="checkbox"/> All procedures found current and accurate | <input type="checkbox"/> Additional procedures are needed |
| <input type="checkbox"/> Some procedures to be updated             | <input type="checkbox"/> Some procedures no longer needed |

**Affected SOP's:**  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

(D)

**Operating Procedures  
Review Summary and Certification Form**

**Facility Name:** BHJ USA, Inc. Fort Dodge

**Facility Location:** 2472 170<sup>th</sup> St.  
Fort Dodge, IA 50501

**System / Equipment List:**

**SOP 27; Cooler CS – 23**

- a. Control Station CS-23: Evaporator 23; (Cooler ) pages 27.1.15

**SOP 28; Cooler CS – 24**

- a. Control Station CS-24: Evaporator 24; (Cooler ) pages 28.1.15

**SOP 29; Auto Purger - AP**

- a. Auto Purger; East Engine Room: pages 29.1.8

**SOP 30; SRV**

- a. Safety Relief Replacement; East Engine Room: pages 30.1.9

**SOP 31; Line Break**

- a. Line Break; All Of Plant refrigeration Systems (East & West) Pages 31.1.7

**Operating Procedure Review:**

I have reviewed the SOP's and certify that to the best of my knowledge they are correct and accurate.

Reviewed By _____	Date: ____/____/____

- |  |   |
|--|---|
| <input type="checkbox"/> All procedures found current and accurate | <input type="checkbox"/> Additional procedures are needed |
| <input type="checkbox"/> Some procedures to be updated             | <input type="checkbox"/> Some procedures no longer needed |

**Affected SOP's:**

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_



## (E) Executive Summary

BHI USA, Inc. utilizes anhydrous ammonia as a refrigerant in its cold storage process. The facility has an ammonia storage capacity of approximately 12,000 pounds. Ammonia is stored in pressure vessels, piping, evaporators and miscellaneous equipment. The maximum amount of ammonia stored in any one vessel is 1,637 pounds.

The BHI USA, Inc. facility meets Program 3 eligibility requirements of the RMP Rule because the facility is subject to the OSHA PSM standard.

The prevention program implemented at the BHI USA, Inc. facility was developed to meet OSHA PSM 29 CFR 1910.119 requirements. In accordance with 40 CFR 68.175 the following is a summary of the prevention program in place at the Fort Dodge facility.

Most recent process hazard analysis: Completed July 2011

Operating procedures: Last reviewed April 2012

Training programs: Last reviewed January 2012

Maintenance procedures: Last reviewed July 2009

Management of change procedures: Last reviewed March 2012

No new or modified stationary sources have been introduced since the initial prestartup review was conducted

Compliance audit: Last conducted July 2009

Incident investigation: Last completed February 2012

Employee participation plans: Last reviewed May 2012

Hot work permit procedures: Last reviewed March 2012

Contractor safety procedures: Last reviewed April 2012

Contractor safety performance: Last evaluated April 2012

The BHI USA, Inc. facility has an emergency action program in place which outlines the actions to be taken for a facility evacuation, ammonia release, or natural disaster. A training schedule has also been established to train employees on the emergency action program. The Fort Dodge Fire Department, Rescue Squad, HAZMAT team, and Police Department have been designated as the first responding agencies. Evacuation procedures are in place for an ammonia release with primary and secondary meeting locations.

Within the last 5 years, no accidental releases of ammonia, which resulted in deaths, injuries, or significant property damage has occurred on site, or known deaths, injuries, evacuations, sheltering in place, property damage, or environmental damage, have occurred offsite from the BHI USA, Inc. facility.

IN THE MATTER OF BHJ USA, Inc., Respondent  
Docket No. CAA-07-2013-0004

CERTIFICATE OF SERVICE

I certify that a true and correct copy of the foregoing Order was sent this day in the following manner to the addressees:

Copy hand delivered to  
Attorney for Complainant:

Kristen Nazar  
Assistant Regional Counsel  
Region 7  
United States Environmental Protection Agency  
11201 Renner Blvd.  
Lenexa, Kansas 66219

Copy by First Class Mail to:

Thomas B Christensen, President  
BHJ USA, Inc.  
2472 170<sup>th</sup> Street  
Fort Dodge, Iowa 50501

Dated: 2/28/13



Kathy Robinson  
Hearing Clerk, Region 7