

OSC 12
Ohio Safety Congress & Expo

**WELL AT HOME.
SAFE AT WORK.**

275 Industrial and Pedestrian/Vehicle Safety

Aaron Stolpe

Thursday, March 29, 2:30 to 3:30 p.m.

Ohio Bureau of Workers' Compensation

Powered Industrial Vehicle & Pedestrian Safety

Aaron Stolpe
Safety Manager
A-B InBev
Columbus, Ohio Brewery




Objectives ABInBev

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- Facility Background
- Injury Examples
- Facility Rules and Regulations
- Facility Training
- Facility Improvements

Company & Facility Background ABInBev

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- Brewery 5th built and started up in 1968 at 1.9 hL (1.7MM bbls)
- Four expansion in brewery history
- Located on 221 acres
- 2011 released 11.9 hL (10.5 MM bbls)
- Employ approximately 748 salaried and hourly employees



Company & Facility Background ABInBev

-
- Powered Industrial Vehicle
 - Yale Fork Trucks
 - Single 1,800 pounds capacity
 - Double/Single 4,450 pounds capacity
 - Double Wide 4,550 pounds capacity
 - Electric
 - Battery powered due to closed buildings
 - Product integrity





Injuries ABInBev

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- The following were the top 10 most frequently cited standards in fiscal year 2011 (October 1, 2010 through September 30, 2011):
 1. Scaffolding, general requirements, construction
 2. Fall protection, construction
 3. Hazard communication standard, general industry
 4. Respiratory protection, general industry
 5. Control of hazardous energy (lockout/tagout), general industry
 6. Electrical, wiring methods, components and equipment, general industry
- 7. Powered industrial trucks, general industry**
- 8. Ladders, construction
- 9. Electrical systems design, general requirements, general industry
- 10. Machines, general requirements, general industry

Injuries 

The following are the standards for which OSHA assessed the highest penalties in fiscal year 2011 (October 1, 2010 through September 30, 2011):

1. Fall protection, construction
2. Scaffolding, general requirements, construction
3. Control of hazardous energy (lockout/tagout), general industry
4. Machines, general requirements, general industry
5. Ladders, construction
6. Excavations, requirements for protective systems

7. Powered industrial trucks, general industry

8. General duty clause
9. Electrical, wiring methods, components and equipment, general industry
10. Electrical systems design, general requirements, general industry

Injuries 

- **Death by forklift truck in break warehouse accident**
 - Employee was trapped under the vehicle
 - Crushed to death by forklift truck
 - December, 2011
- **Company fined after fork-lift truck accident**
 - Employee practices allowed climbing on top of fork truck lift
 - Employee fell, became unconscious and missed a month of work
 - October, 2011
- **South Florida construction worker killed in workplace forklift accident**
 - A roofing tile delivery went all wrong, ending in the death of a Bonita Springs construction worker.
 - The worker was walking between the delivery truck and a forklift when the forklift driver reversed and backed over him.
 - September, 2011

Fork Truck Accidents Are Life Altering, If Not Deadly!

Federal Regulations 

- Initial Certification
- 3 Year Recertification
- Operator Review
- OSHA Regulation 1910.178(a)

Facility Rules & Regulations 

- Columbus, Ohio Brewery Mission:
 - Continual Improvement Providing A SAFE and Healthy Working Environment
 - Comply with Company Policies
 - Comply with Federal Regulations

Facility Rules & Regulations 

Anheuser-Busch, Inc.
Powered Industrial Trucks
Operating Rules

1. Only drivers authorized by the company and trained in the safe operation of industrial trucks shall be permitted to operate such vehicles.
2. The use of seat belts on Fork Trucks is mandatory.
3. Street driving and handley are prohibited.
4. No riders shall be permitted on vehicles unless the truck was provided for that purpose by the manufacturer.
5. Employees shall not ride on the forks of the lift trucks.
6. Employees shall not place any part of their bodies outside the running lines of an industrial truck or between the uprights or other parts of the truck where shear or crushing hazards exist.
7. Employees shall not be allowed to stand, pass, or work under the elevated portion of any industrial truck, loaded or empty, unless it is effectively blocked to prevent it from falling.
8. Drivers shall check the vehicle before being placed in service at least once per shift, and if it is found to be unsafe, the matter shall be reported to a supervisor or mechanic, and the vehicle shall not be put in service again until it has been made safe. Attention shall be given to the proper functioning of tires, horns, lights, backing, controls, brakes, steering mechanism, cooling system and the lift system of forklifts (forks, chains, cable and limit switches).
9. No truck shall be operated with a leak in the fuel system.
10. Vehicles shall not exceed the authorized or safe speed, always maintaining a safe distance from other vehicles, keeping the truck under positive control at all times and all established traffic regulations shall be observed. For trucks traveling in the same direction, a safe distance may be considered to approximately three truck lengths or preferably a time lapse - three seconds - passing the same point.
11. Trucks traveling in the same direction shall not be passed at intersections, blind spots, or dangerous locations.
12. The driver shall slow down and sound the horn at cross angles and other locations where vision is obstructed. Operators must travel in reverse with any load on the forks. A spotter, or spotters may be used if it is necessary to drive forward while under load.
13. Operators shall look in the direction of travel and shall not move a vehicle until certain all persons are in the clear.
14. Trucks shall not be driven up to anyone standing in front of a bench or other object of such size that the person could be caught between the truck and the object.

Facility Rules & Regulations 

Anheuser-Busch, Inc.
Powered Industrial Trucks
Operating Rules

15. Grades shall be ascended or descended slowly. When ascending or descending grades in excess of 10 %, loaded trucks shall be driven with the load upgrade. On all grades, the load and load engaging means shall be tilted back if applicable and raised only as far as necessary to clear the road surface. Motorized hand and hand/ride trucks shall be operated on all grades with the load engaging means downgrade.
16. The forks shall always be carried as low as possible, consistent with safe operation.
17. When leaving a vehicle unattended, the power shall be shut off, brakes set, the mast brought to the vertical position, and forks left in the down position. When left on an incline, the wheels shall be blocked front and rear. Note: When the operator is over 25' from or out of sight of the industrial truck, the vehicle is left "unattended".
18. When the operator of an industrial truck is dismounted and within 20' of the truck which remains in the operators view, the load engaging means shall be fully lowered, controls retracted, and the brakes set to prevent movement.
19. Vehicles shall not be run onto an elevator unless the driver is specifically authorized to do so. Before entering an elevator, the driver shall determine the capacity of the elevator will not be exceeded. Once on an elevator, the power shall be shut off and the brakes set.
20. All powered industrial trucks shall enter elevators or other confined areas with the load end forward.
21. Vehicles shall not be operated on floors, sidewalks, or platforms that will not safely support the loaded vehicle.
22. Prior to driving onto trucks, trailers, and railroad cars, their floor shall be checked for breaks and other structural weaknesses.
23. Vehicles shall not be driven in and out of highway trucks and trailers at loading docks until such trucks or trailers are securely blocked by placing chocks under the rear wheels and the brakes set. Trailer wheels are to be chocked on both sides of the hubs between the wheels with the chocks placed snugly against and in front of the rear most set of tires. All air ride suspension trailers, at A-B facility docks where forklifts enter, must have the air released on the trailer prior to forklift entry.
24. Trailers that are not coupled to a tractor shall not be driven in and out of until fixed jacks are placed under a supporting member (plate) of the trailer and the jack adjusted so the top of the jack is approximately two inches below the supporting rib of the trailer.
25. To prevent railroad cars from moving during loading or unloading operations, the car brakes shall be set, and wheel chocks shall be used. In the case of the coupled railroad car, the cars at each end will be chocked.

Facility Rules & Regulations 

Anheuser-Busch, Inc.
Powered Industrial Trucks

Operating Rules

26. The width of use line on the power of industrial truck shall be the minimum distance maintained from the edge by the truck while it is on any elevated dock, platform, freight car or truck.
27. Railroad tracks shall be crossed diagonally, wherever possible. Parking closer than 6-1/2' from the center line of railroad tracks is prohibited.
28. Trucks shall not be loaded in excess of their rated capacity.
29. A loaded vehicle shall not be moved until the load is set and secure.
30. Extreme caution shall be taken when tilting loads. Elevated loads shall not be tilted forward except when the load is being deposited or into a storage rack or the equivalent. When stacking or lifting, backward tilt shall be limited to that necessary to stabilize the load.
31. The load engaging device shall be placed in such a manner that the load will be securely held or supported.
32. Powered industrial trucks will not be used to open and close freight doors.
33. If loads are lifted by two or more trucks working in unison, the total weight of the load shall not exceed the combined rated capacity of all trucks involved.
34. If adjustable rear wheels of the trailer are positioned forward, jacks shall be placed at the rear of both trailer rear corners, or have the wheels moved towards the end of the trailer before loading.

Facility Rules & Regulations 

Anheuser-Busch, Inc.
Powered Industrial Trucks

Operating Rules

8. Drivers shall check the vehicle before being placed in service at least once per shift, and if it is found to be unsafe, the matter shall be reported to a supervisor or mechanic, and the vehicle shall not be put in service again until it has been made safe. Attention shall be given to the proper functioning of tires, horn, lights, battery, controller, brakes, steering mechanism, cooling system and the lift system of forklifts (forks, chains, cable and limit switches).



Facility Rules & Regulations 

Anheuser-Busch, Inc.
Powered Industrial Trucks

Operating Rules

8. Drivers shall check the vehicle before being placed in service at least once per shift, and if it is found to be unsafe, the matter shall be reported to a supervisor or mechanic, and the vehicle shall not be put in service again until it has been made safe. Attention shall be given to the proper functioning of tires, horn, lights, battery, controller, brakes, steering mechanism, cooling system and the lift system of forklifts (forks, chains, cable and limit switches).

- Response
 - If truck is determined to be unsafe then:
 - Taken out of service immediately
 - Transported to on site repair shop
 - Abandoned in place and employees notified
 - Spare truck used if needed
 - Columbus Brewery has an on site truck shop open on day shift

Facility Rules & Regulations 

Anheuser-Busch, Inc.
Powered Industrial Trucks

Operating Rules

10. Vehicles shall not exceed the authorized or safe speed, always maintaining a safe distance from other vehicles, keeping the truck under positive control at all times and all established traffic regulations shall be observed. For trucks traveling in the same direction, a safe distance may be considered to approximately three truck lengths or preferably a time lapse – three seconds – passing the same point.

- Fork trucks purchased to operate in brewery environment
 - Smooth surfaced floors
 - Water common in virtually all brewery environments
 - Have evaluated speeds multiple times
 - Have limited speeds as much as possible
- Constant focus
 - Reinforcement with employees
 - Signage to remind
 - Safety Monitoring process by managers
 - Safety Observations by employees



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- "Safety Zone" is 3 foot radius surrounding a fork truck
 - Developed & implemented in 2008
 - Applies to
 - Moving vehicles
 - Approaching pedestrians
 - Stationary objects

Facility Rules & Regulations 

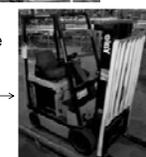
Anheuser-Busch, Inc.
Powered Industrial Trucks

Operating Rules

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- A lot of obstructed intersections
 - Installed(ing) mirrors to help vision
 - Currently a big focus on using horns
 - Constantly evaluating and improving
- Reversing with a load
 - Constant request by employees to reevaluate
 - All loads must be carried in reverse

If this truck is traveling forward with a load on the forks and has to stop suddenly, where will the load go? →



Facility Rules & Regulations

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Powered Industrial Trucks

Operating Rules

21. Prior to driving onto trucks, trailers, and railroad cars, their floor shall be checked for breaks and other structural weaknesses.
22. Vehicles shall not be driven in and out of highway trucks and trailers at loading docks until such trucks or trailers are securely blocked by placing chocks under the rear wheels and the brakes set. Trailer wheels are to be chocked on both sides of the trailer between the wheels with the chocks placed snugly against and in front of the rear most set of tires. All air ride suspension trailers, at A-R facility docks where forklifts enter, must have the air released on the trailer prior to forklift entry.
24. Trucks that are not coupled to a tractor shall not be driven in and out of until fixed jacks are placed under a supporting member (dolly) of the trailer and the jack adjusted so the top of the jack is approximately two inches below the supporting rib of the trailer.

- The Columbus Brewery ships 300 trucks of package & draft beer daily



Facility Training

- Excellent training process
 - Every new employee trained BEFORE performing work
 - Salaried
 - Full Time Hourly
 - Seasonal Hourly
 - Weekend Hourly
 - Tracked in our electronic training management system
 - Every employee's training records available
 - Classroom training consists of
 - Lecture
 - Video
 - Plant experience
 - Testing

Facility Training

- Post training testing
 - Classroom test of rules and regulations
 - Driving test
 - Practical use of fork truck
 - Validate ability and execution of training
- Recertification
 - Performed every 3 years (required by OSHA)
 - Performing annual driving reviews
- Trainers
 - Our employees deliver the training
 - Train to practical / real experiences!

*Great People
Are the Most
Valuable
Assets of
Our
Company!*

Facility Improvements

- Segregation
 - Physically separating trucks and employees!



Facility Improvements

- Segregation
 - Physically separating trucks and employees!



**SEATBELTS
ARE
MANDATORY**



**THE USE OF
ELECTRONIC
DEVICES IS
PROHIBITED
WHEN DRIVING**

Summary

- Injuries from fork trucks are severe, if not deadly!
- Established fork truck and pedestrian rules
 - Some company driven
 - Most OSHA regulation driven
- Training
 - Initial fork truck training process
 - Recertification fork truck process
 - Pedestrian training process
- Separate!
 - Define areas for only fork trucks!
 - Define areas for only pedestrians!
- **Ultimate Goal: Maintain and Improve the Safest Working Environment for Your Employees!**

Things YOU Can Do

ABInBev

- - Training
 - Requires a resource
 - Establish your rules
 - Train to the rules
 - Certification
 - Recertification
 - Implement operator safety inspection process
 - Signage to reinforce rules
 - Reinforce rules
 - Communicate (rules, changes, etc)
 - Separate!

ABInBev

Q & A

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