

5205.1400 INSPECTION OF HOPPERS.

Subpart 1. **Definitions.** The terms used in this part have the meanings given them in this subpart.

A. "Aggregate" means the natural sands, gravels, and crushed stones used for mixing with cementing material in making mortars and cements.

B. "Corrosive agent or substance" means any agent or substance with a pH factor of ten or greater or four or less.

C. "Hopper" means a metal structure designed for storing and dispensing materials, with a capacity of one ton or greater, that is shaped to allow stored materials to flow from it.

D. "Nondestructive testing" means a testing method that does not damage or destroy the test sample. Nondestructive testing includes, but is not limited to, the use of X-rays, ultrasonics, radiography, and magnetic flux.

E. "Visual inspection" means a thorough physical examination of all interior and exterior surface areas, and support members and their component parts.

Subp. 2. **Inspection.** Hoppers used to hold aggregate shall be inspected according to the schedule in subpart 3 if employees have access to the area beneath the hopper or the area surrounding the hopper, equal to the height of the hopper measured from the ground or floor to the hopper's highest point. The inspection shall be conducted by a person qualified to conduct the inspection under subpart 7.

Subp. 3. **Inspection schedule.**

A. Hoppers that must be inspected under subpart 2 shall be visually inspected every 12 months.

B. Hoppers that must be inspected under subpart 2, that have had corrosive agents or substances used within the system, shall be nondestructively tested every five years.

C. Hoppers that must be inspected under subpart 2, that have not had any corrosive agents or substances used within the system, shall be nondestructively tested every ten years.

D. Hoppers that have been modified, altered, or repaired shall be inspected under subpart 2 before returning the hopper to service when the modifications, alterations, or repairs affect the designed load capacity of the hopper. This includes, but is not limited to, relining of the hopper.

Subp. 4. **Documentation.** Inspections required by this part shall be documented and the required documentation shall be retained for the life of the hopper at the facility where the hopper is located. The documentation shall be made available upon request to

representatives of the Occupational Safety and Health Division. The documentation of the inspections shall include:

- A. the dates on which inspections were conducted;
- B. the names, addresses, and employers of persons conducting the inspections;
- C. the means used to inspect the hoppers;
- D. the findings of the inspections;
- E. the deficiencies noted as a result of the inspections; and
- F. the dates on which recommended repairs were completed.

Subp. 5. **Repairs.** If deficiencies found during an inspection do not compromise the designed load capacity of the hopper, all repairs shall be made within the minimum amount of time necessary to complete repairs. If deficiencies found during an inspection do compromise the designed load capacity, the hopper shall be emptied and removed from service until all repairs are completed.

Subp. 6. **Means of inspection.** All inspections conducted under this part shall include visual inspections and nondestructive testing that is capable of determining that erosion, corrosion, stress, fatigue, damage, repairs, or alterations have not compromised the designed load capacity.

Subp. 7. **Qualified person.** A person is qualified to conduct inspections under this part if, through education, training, or experience, the person is capable of determining through visual inspections and nondestructive testing that erosion, corrosion, stress, fatigue, damage, repairs, or alterations have not compromised the designed load capacity.

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