



**UNITED STATES ENVIRONMENTAL PROTECTION AGENCY
REGION 10**

1200 Sixth Avenue, Suite 155
Seattle, WA 98101

ENFORCEMENT &
COMPLIANCE ASSURANCE
DIVISION

**Clean Air Act - Section 112(r)
Risk Management Program
and EPCRA 312 – Tier II
Facility Inspection Report**

FACILITY INFORMATION:

Name: Evans Fruit Company, Inc.
Physical Address: 5002 Tieton Drive, Yakima, WA 98908
Phone Number: 509-830-7367
Latitude/Longitude: 46.591722 / -120.576167
RMP Facility ID#: 100000211031
FRS ID#: 110005390601
EJ Concerns: No (Below 80%)

CONTACT INFORMATION (RMP Implementation):

Name: Barb Evans
Phone Number: 509-830-7367
E-mail: barbielevans@gmail.com

EMERGENCY CONTACT INFORMATION:

Name: Joseph Evans
Phone (24-hr): 509-830-1225
E-mail: joe@evansfruitco.com

TRIP DETAILS:

Inspection Date: 4/27/2022
Inspection Time: 0900 hours through 1345 hours
Inspectors: Edward Johannes, US EPA Region 10 SEE Grantee, Lead RMP Inspector and EPCRA Inspector
Bob Hales, US EPA Region 10 SEE Grantee, RMP Inspector
Peter Phillips, US EPA Region 10 SEE Grantee, RMP Inspector
Lisa Graves, Weston Solutions, Inc., EPA START Contractor

DATE AND PROGRAM LEVELS OF SUBMITTED RMP:

Initial Submission Date: April 1, 2010

Date of Latest Update: July 13, 2020

Process (Program 1, 2, 3) as reported in RMP:

Process ID	Description	Process Chemical ID	NAICS Code	Program Level	Chemical Name CAS Number	Quantity (lbs)
1000110369	Machine Room 2	1000110369	49312	3	Ammonia, Anhydrous (7664-41-7)	13,690
1000110370	Machine Room 1	1000110370	49312	3	Ammonia, Anhydrous (7664-41-7)	11,925
(none)	*Machine Room 3	(none)	49312	-	Ammonia, Anhydrous (7664-41-7)	1,795

*Not reported in the RMP because ammonia inventory is below threshold reporting quantity of 10,000 lbs.

PURPOSE:

The purpose of this inspection was to determine whether this facility is in compliance with Section 112(r) of the Clean Air Act and Title 40 Code of Federal Regulations (CFR) Part 68, Chemical Accident Prevention Provisions.

- The facility has been previously inspected in the past 5 years: No ☐ Yes ☒
If Yes, Date of Last Inspection: 7/17/2013
- The facility is High Risk: No ☐ Yes ☒
- Joint EPCRA inspection: No ☐ Yes ☒

CAA Title V Air Permit:

Does the facility have a CAA Title V Permit?

No ☒ Yes ☐*If Yes, Permit Number:***RELEASE/ACCIDENT HISTORY:**

Did the facility have a reportable release in the past 5 years?

No ☒ Yes ☐*If Yes, Date and Description of the Release:***EPCRA TIER II REPORTING:**

Did the facility submit the 2022 Tier II report to the SERC?

No ☐ Yes ☒*If Yes, Date the Tier II was submitted: 2/8/2022**If No, calendar year of the most recent Tier II:*Did the facility submit a Tier II to the LEPC and local fire department? No ☐ Yes ☒*If Yes, Date the Tier II was submitted: 2/8/2022 to LEPC and 2/22/2022 to Yakima Fire Department.*

INSPECTION ENTRY:

Edward Johannes led the inspection entry. The inspection team met with Barb Evans at the Evans Fruit Company facility in Yakima, Washington. The team arrived at the facility at 0900 hours and was joined by the following facility personnel:

Name	Title
Barb Evans	Reg Manager
Jon Hammermeister	Plant Manager
Joseph Evans	Manager
Edgar Gurman	Refrigeration Operator

Was a state/county/or local emergency representative present? No ☒ Yes ☐

If Yes, Name and Title of Representative:

The facility is a first responder: No ☒ Yes ☐

If No, Responding Agency: Yakima Fire Department

The inspection team was escorted to an office located in the facility's office building. Introductions were made by Edward Johannes, who provided a summary of the risk management program (RMP) and explained the purpose of the visit. Each team member presented his/her credentials.

EPA then requested an explanation of the facility's operations and any additional safety measures that should be taken during the site tour. Barb Evans and Jon Hammermeister gave a brief description of the facility, operations, and personal protective equipment required for the tour.

Prior to the inspection, EPA sent a certified notice of inspection letter to the facility informing them of the CAA Section 112(r)(6)(L) requirement that facility employees and employee representatives (such as a union representative) have the right to participate in the RMP inspection, and that a copy of the letter must be provided to the employee representative(s) and the letter posted in a manner accessible to employees in the facility.

The facility is unionized: No ☒ Yes ☐

If Yes, Name of Union:

An employee representative present during the facility visit: No ☒ Yes ☐

If Yes, Name/Title:

GENERAL INFORMATION:

The facility is regulated under the Risk Management Program as a Program Level 3 facility and is owned and operated by Evans Fruit Company, Inc. The facility operates an apple packing and refrigeration warehouse throughout the year. Ammonia is used as the refrigerant in the system, and three refrigeration systems are located on site. There are 120 full-time employees on site including one operator who is responsible for refrigeration operations. The facility also has an on-call refrigeration technician available to cover the operator role, as needed.

Evans Fruit packages and stores primarily apples in refrigerated rooms until shipment. The refrigeration operator checks the ammonia system every workday and all refrigerated areas are continuously monitored by an ammonia detection system. In addition, the computer system will remotely notify a refrigeration technician when an alarm is triggered, or refrigeration parameters are out-of-range. There

are no process modifications that impact the facility's ammonia refrigeration system. The facility has an emergency action plan in the event of an ammonia release and all employees participate in an annual evacuation drill for the emergency action plan.

ON-SITE OBSERVATIONS:

The facility tour was conducted from approximately 0915 hours to 1015 hours. The inspection team was escorted by Barb Evans, Joe Evans, Jon Hammermeister, and Edgar Gurman. The inspection team observed the ammonia engine rooms, and controlled atmosphere rooms.

The ammonia refrigeration system has three engine rooms, Machine Room 1, Machine Room 2, and Machine Room 3. Each machine room contains the main equipment for the ammonia refrigeration system. The primary equipment observed in the machine rooms were the compressors, valves, high pressure receiver (HPR) tanks and associated king valve, exhausts fans, intakes vents, and the ammonia leak detection device. The condensers were located on the building rooftop for each machine room. Adjacent to Machine Room 1 was an office used to monitor all facility refrigeration equipment parameters through the computer terminal and ammonia sensor network panel.

Three controlled atmosphere rooms (CA 7, CA 18, and CA 28) were inspected. The primary equipment observed were the evaporator, ammonia sensor intake, and the ammonia leak detection device.

The facility ammonia refrigeration equipment was clearly labeled and tagged. In addition, safety features were observed. Photographs were taken of the ammonia system process. The photographs that were taken at the facility are included in Attachment A to this report.

After touring the RMP-covered process areas at the Evans Fruit Company, Inc., the inspection team returned to the conference room to review the RMP documentation. Upon completion of the document review, EPA provided a debriefing to Barb Evans, Joe Evans, and Jon Hammermeister.

INFORMATION COLLECTED FROM FACILITY:

No documents were collected from the inspection.

AREAS OF CONCERNS ADDRESSED IN CLOSING CONFERENCE:

1. The most recent Hazard Assessment review and update completed on April 15, 2022, exceeded the 5-year review cycle since the previous Hazard Assessment review and update from May 11, 2016. [68.36(a)].
2. Four pressure relief valves were identified as past due for replacement. [68.73(d)(3)]. Two pressure relief valves in Machine Room 3 had a replacement date of September, 2020, and two others in Machine Room 2 had replacement dates of November, 2020, and April, 2021.

DOCUMENTS REQUESTED NOT INCLUDED IN REPORT:

The following documents were requested during the inspection but are not included in this report. These documents will still be reviewed to determine compliance with Section 112(r) of the Clean Air Act.

No follow-up documents were requested from the inspection for review.

INSPECTION REPORT CERTIFICATION:

This is to certify that I, Edward Johannes was the lead inspector at this facility and that I have verified the accuracy of the observations in this inspection report:

EDWARD JOHANNES Digitally signed by EDWARD
(Affiliate) JOHANNES (Affiliate)
Date: 2022.08.30 11:48:25 -07'00'

Inspector Signature

JAVIER MORALES Digitally signed by JAVIER
MORALES
Date: 2022.08.30 12:05:12 -07'00'

RMP Coordinator/Approval

ERIN WILLIAMS Digitally signed by ERIN WILLIAMS
Date: 2022.08.30 13:09:13 -07'00'

EPCRA Coordinator/Approval

Jennifer A Sullivan Digitally signed by Jennifer A Sullivan
Date: 2022.08.31 14:42:48 -07'00'

Land Enforcement Section Chief/Approval

Attachment A – Photo Log

Site Name: Evans Fruit Company, Inc.

City, State: Yakima, Washington

Photographer: Lisa Graves

File	Photo Layout ID	Date	Time	Description
DSCN2345	1	4/27/2022	9:24 AM	Machine Room 1 - Condensers
DSCN2346		4/27/2022	9:27 AM	Machine Room 1 - Compressors
DSCN2347	2	4/27/2022	9:28 AM	Machine Room 1 - Entry/Exit
DSCN2348	4	4/27/2022	9:29 AM	Machine Room 1 - Regulator Valve Tags
DSCN2349	3	4/27/2022	9:30 AM	Machine Room 1 - King Valve
DSCN2350		4/27/2022	9:31 AM	Machine Room 1 - King Valve and Regulator Valves
DSCN2351	5	4/27/2022	9:33 AM	Machine Room 1 - Exhaust
DSCN2352	7	4/27/2022	9:34 AM	Machine Room 1 - Ammonia Leak Detector
DSCN2353	8	4/27/2022	9:34 AM	Machine Room 1 - Daily Log
DSCN2354	6	4/27/2022	9:36 AM	Machine Room 1 - Compressor
DSCN2355	10	4/27/2022	9:39 AM	Machine Room 3 - Entry/Exit and Condenser
DSCN2356	13	4/27/2022	9:40 AM	Machine Room 3 - Ammonia Leak Detector
DSCN2357	12	4/27/2022	9:42 AM	Machine Room 3 - Regulator Valve Tags
DSCN2358	11	4/27/2022	9:43 AM	Machine Room 3 - High Pressure Receiver and King Valve
DSCN2359	14	4/27/2022	9:45 AM	CA 18 - Entry/Exit
DSCN2360	15	4/27/2022	9:45 AM	CA 18 - Evaporators
DSCN2361		4/27/2022	9:46 AM	CA 18 - Storage
DSCN2362	16	4/27/2022	9:46 AM	CA 18 - Evaporator and Ammonia Sensor Tube
DSCN2363		4/27/2022	9:47 AM	Machine Room 2 - Condenser
DSCN2364	17	4/27/2022	9:49 AM	CA 7 - Entry/Exit
DSCN2365		4/27/2022	9:49 AM	CA 7 - Storage
DSCN2366		4/27/2022	9:52 AM	CA 7 - Mezzanine Electrical Panels
DSCN2367		4/27/2022	9:52 AM	CA 7 - Mezzanine Electrical Panels
DSCN2368	18	4/27/2022	9:53 AM	CA 7 - Mezzanine Walkway
DSCN2369	19	4/27/2022	9:53 AM	CA 7 - Mezzanine Surge Drum System
DSCN2370		4/27/2022	9:57 AM	Machine Room 1 - Ammonia Sensor Network Panel
DSCN2371		4/27/2022	9:57 AM	Machine Room 1 - Ammonia Sensor Network Panel
DSCN2372	9	4/27/2022	9:58 AM	Ammonia Sensor Network Panel Adjacent to Machine Room 1

File	Photo Layout ID	Date	Time	Description
DSCN2373	20	4/27/2022	10:03 AM	Machine Room 2 - Entry/Exit
DSCN2374		4/27/2022	10:03 AM	Machine Room 2 - Condenser
DSCN2375		4/27/2022	10:04 AM	Machine Room 2 - Ammonia Leak Detector
DSCN2376		4/27/2022	10:04 AM	Machine Room 2 - Ammonia Sensor Network Panel
DSCN2377		4/27/2022	10:05 AM	Machine Room 2 - Dual Gas Analyser Component
DSCN2378	21	4/27/2022	10:07 AM	Machine Room 2 - King Valve
DSCN2379	22	4/27/2022	10:07 AM	Machine Room 2 - Regulator Valve Tags
DSCN2380	23	4/27/2022	10:08 AM	Machine Room 2 - Ammonia Leak Detector
DSCN2381	27	4/27/2022	10:13 AM	CA 28 - Entry/Exit
DSCN2382	28	4/27/2022	10:13 AM	CA 28 - Evaporators
DSCN2383		4/27/2022	10:14 AM	CA 28 - Entry/Exit
DSCN2384		4/27/2022	10:16 AM	Machine Room 2A - Entry/Exit
DSCN2385	26	4/27/2022	10:16 AM	Machine Room 2A - Ammonia Leak Detector
DSCN2386	25	4/27/2022	10:17 AM	Machine Room 2A - Regulator Valve Tag
DSCN2387		4/27/2022	10:18 AM	Machine Room 2A - Compressor
DSCN2388	24	4/27/2022	10:19 AM	Machine Room 2A - Condenser and Entry/Exit