

High-Speed Bottling & Packaging Line Safety Checklist

Site / Project	_____	Address	_____
Inspector name	_____	Company	_____
Date	_____	Time	_____

Documentation aid only. Adapt this resource to the site, manufacturer instructions, and applicable local requirements. It does not replace a competent person, professional judgment, legal advice, or a required statutory form.

Inspection checklist

Machine Guarding & Nip Point Protection

☐ Are all conveyor nip points (belt-roller interfaces, chain-sprocket interfaces) fully guarded to prevent access? (ANSI B155.1)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐ Are E-stop pull cords accessible along the entire length of the line and tested for functionality before each shift? (OSHA 1910.212)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐ Do interlock switches on access doors and panels function correctly, immediately stopping machinery when opened? (ANSI B11.19)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐ Are light curtains or area scanners properly positioned and functioning to prevent access to hazardous areas? (IEC 61496)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐ Are all emergency stop buttons clearly labeled, easily accessible, and tested weekly? (OSHA 1910.145)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐ Are all machine guards free from damage (dents, cracks, missing fasteners) that could compromise their effectiveness? (OSHA 1910.212)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐ Are fixed barrier guards securely mounted and of sufficient height and construction to prevent reaching over, under, or around the hazard? (BS EN ISO 14120)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐ If two-hand controls are used, do they require simultaneous actuation and prevent bypassing? (OSHA 1910.212)	☐ Pass	☐ Fail	☐ N/A	Notes: _____

☐	Are presence-sensing devices (PSD) properly calibrated and maintained to prevent unintended machine startup? (ANSI B11.19)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐	Is perimeter fencing in place to prevent unauthorized access to the bottling line area? (OSHA 1910.22)	☐ Pass	☐ Fail	☐ N/A	Notes: _____

Glass Breakage Prevention & Control

☐	Are documented procedures in place for handling broken glass, including proper PPE and disposal methods? (Company Policy)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐	Are cut-resistant gloves, safety glasses with side shields, and appropriate footwear readily available and used by personnel handling glass? (OSHA 1910.132)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐	Are designated, clearly labeled containers available for the safe collection and disposal of broken glass? (Company Policy)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐	Is there a documented and practiced protocol for clearing line jams, emphasizing safe methods to prevent glass breakage and nip point injuries? (Company Policy)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐	Is there a system in place to inspect bottles for defects (cracks, chips) before they enter the filling line? (Company Policy)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐	Are air pressure regulators on pneumatic systems properly set to prevent excessive force that could cause bottle breakage? (Manufacturer Specifications)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐	Is the conveyor speed optimized to minimize bottle-to-bottle contact and reduce the risk of breakage? (Company Policy)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐	Are lighting levels adequate to allow for clear visibility and identification of potential glass hazards? (ANSI/IES RP-7)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐	Are spill containment measures in place to manage liquid spills from broken bottles and prevent slip hazards? (29 CFR 1910.22)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐	Are training records available to verify that all employees handling glass have been trained on safe handling procedures? (OSHA 1910.132)	☐ Pass	☐ Fail	☐ N/A	Notes: _____

Noise Exposure Control

☐	Has a recent noise survey been conducted to identify areas where noise levels exceed 85 dBA? (29 CFR 1910.95)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
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☐	Is appropriate hearing protection (earplugs or earmuffs) readily available and worn by personnel in areas exceeding 85 dBA? (29 CFR 1910.95)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐	Are warning signs posted in areas where noise levels exceed 85 dBA, indicating the requirement for hearing protection? (29 CFR 1910.95)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐	Have engineering controls (e.g., sound dampening materials, machine enclosures) been implemented to reduce noise levels at the source? (29 CFR 1910.95)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐	Are audiometric testing programs in place for employees exposed to noise levels exceeding 85 dBA? (29 CFR 1910.95)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐	Are employees trained on the proper fitting and use of hearing protection? (29 CFR 1910.95)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐	Is equipment regularly maintained to prevent excessive noise generation due to worn or loose parts? (Company Policy)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐	Is there a documented plan and schedule for implementing noise reduction measures? (29 CFR 1910.95)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐	Are designated "quiet zones" available for employees to take breaks from noisy environments? (Best Practice)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐	Are personal noise dosimeters used to monitor individual employee noise exposure levels? (29 CFR 1910.95)	☐ Pass	☐ Fail	☐ N/A	Notes: _____

General Safety & Housekeeping

☐	Are walkways and aisles clear of obstructions (e.g., pallets, tools, debris) to prevent trips and falls? (29 CFR 1910.22)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐	Are floors clean, dry, and free from slip hazards (e.g., spills, grease)? (29 CFR 1910.22)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐	Is lighting adequate in all areas of the bottling line to ensure safe visibility? (ANSI/IES RP-7)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐	Are emergency exits clearly marked, unobstructed, and easily accessible? (29 CFR 1910.36)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐	Are fire extinguishers readily available, fully charged, and inspected monthly? (29 CFR 1910.157)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐	Is a well-stocked first-aid kit readily available and accessible? (ANSI Z308.1)	☐ Pass	☐ Fail	☐ N/A	Notes: _____

☐ Are chemicals properly stored and labeled according to SDS requirements? (29 CFR 1910.1200)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐ Are Safety Data Sheets (SDS) readily available for all chemicals used in the bottling line area? (29 CFR 1910.1200)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐ Is ventilation adequate to remove fumes or dust generated during the bottling process? (29 CFR 1910.94)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐ Are waste materials properly segregated and disposed of in designated containers? (Company Policy)	☐ Pass	☐ Fail	☐ N/A	Notes: _____
☐ Are compressed air lines free from leaks and properly supported? (OSHA 1910.242)	☐ Pass	☐ Fail	☐ N/A	Notes: _____

Findings

#	Item	Location	Severity	Action required
1				
2				
3				
4				
5				
6				
7				
8				

Signature

Inspector signature _____

Name _____

Date _____