



LOCKOUT/TAGOUT PROGRAM

A comprehensive approach to critical safety procedures

ENGINEERED
TO OUTFIT



From October 2023 through September 2024, OSHA rendered 2,620 lockout/tagout citations across all industries, accounting for more than \$19 million in penalties. ABB can help you improve your lockout/tagout safety program and avoid violations of OSHA standards.

LOCKOUT/TAGOUT PROGRAM

The risk of unexpected asset energization is real

Whether the energy source is electrical, chemical, pneumatic, hydraulic or mechanical, overlooking critical steps in de-energizing, releasing stored energy or re-energizing assets during servicing and maintenance can lead to severe consequences. A comprehensive energy-control program, commonly known as lockout/tagout (LOTO), is essential for:

- Protecting employees from accidental energization (e.g., hazardous shock)
- Complying with federal, state, local and internal requirements and policies
- Meeting insurance requirements
- Enhancing the life, operability and maintainability of energized equipment
- Reducing waste, rework and unplanned downtime

Key components of an effective lockout/tagout program include:

- A documented LOTO program 1910.147(c)(1)
- Written energy-control procedures 1910.147(c)(4)
- Periodic inspections 1910.147(c)(6)
- Employee training 1910.147(c)(7)



This standard covers the servicing and maintenance of machines and equipment in which the unexpected energization or start-up of the machines or equipment or release of stored energy could cause injury to employees. This standard establishes minimum performance requirements for the control of such hazardous energy.

– OSHA 1910.147 — Control of Hazardous Energy

LOCKOUT/TAGOUT PROGRAM

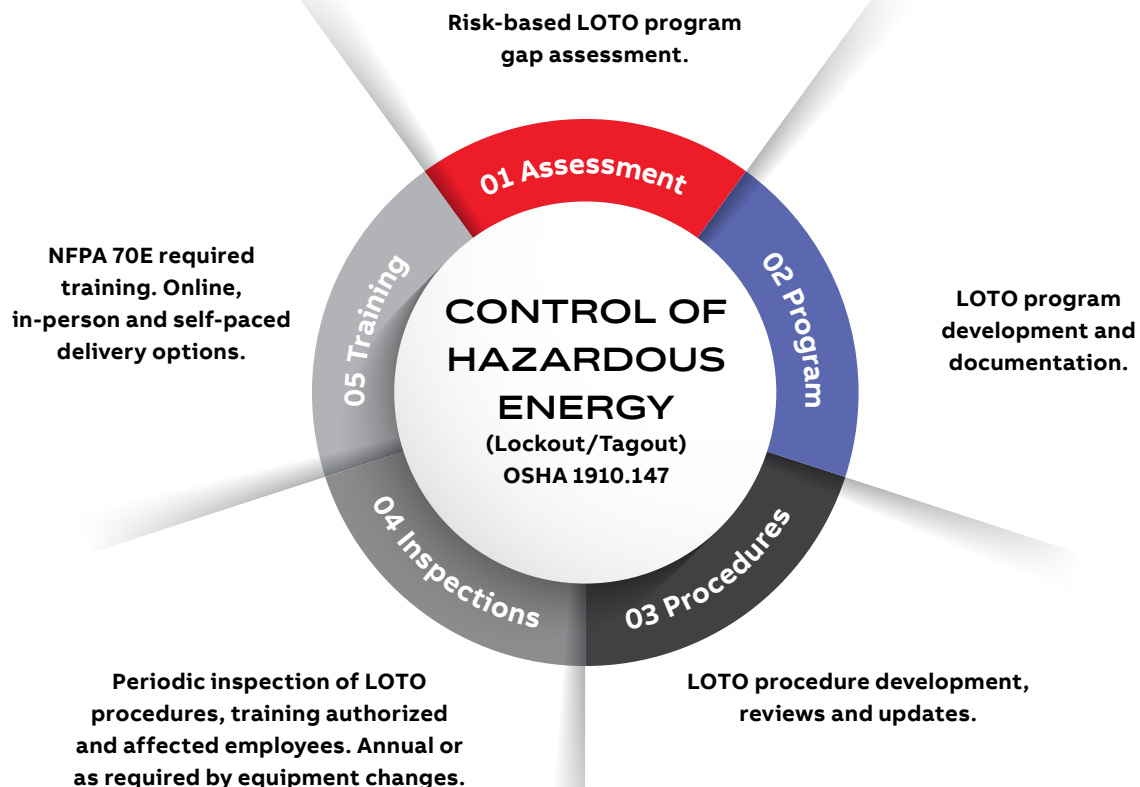
01 Risk-based LOTO gap assessment

Our comprehensive LOTO assessment follows best practices and requirements defined by OSHA 1910.147, EU Directive & Guidelines 2009/104/EC and applicable federal, state, local and internal requirements and policies.

During an on-site visit, your ABB safety advisor will review your facility's assets and its current LOTO program and procedures with your team. This gap assessment covers:

- Current LOTO program and documentation
- Accuracy, availability, accessibility, documentation and spot checking LOTO procedures
- Use of LOTO procedures in work preparation and execution
- Change and obsolescence management of LOTO procedures
- LOTO program communication and safety culture
- LOTO training system, availability, compliance and tracking

Following the visit, your ABB safety advisor will provide a gap report that details findings, recommendations and corrective actions. This written program is customized to meet your preferences and can include a follow-up workshop to develop an action and implementation plan.





02 LOTO program and policy development

Whether you need to develop a brand new LOTO program or revamp your existing one, the process begins with acquiring and reviewing your asset list, policies and documents. A safety advisor will perform a site verification and develop a written program to meet your internal requirements and applicable standards such as OSHA 1910.147, ANSI Z244.1 or EU Directive & Guidelines 2009/104/EC.

03 LOTO procedure development

ABB's comprehensive approach to developing and implementing energy-control procedures follows these steps:

- 1 Review your asset list, or determine a set number of procedures to be developed
- 2 Field-verify assets and identify energy isolation points (EIP) of each asset:
 - Locate energy control points and apply tags
 - Identify energy sources
 - Capture pictures of the isolation point for reference
 - Develop procedures to meet OSHA standards
 - Produce the final customized electronic procedures in PDF format*
- 3 Quality check by a senior safety expert to ensure information and procedures match field verification

* If you signed up for our digital delivery program, your interactive procedures will be available via mobile device for use at the point of work and through our web portal for management.

04 Periodic inspection of LOTO procedures

When ABB creates or revamps your lockout/tagout procedures, you can receive them in print and/or digital format.

According to OSHA 1910.147(c)(6), employers must conduct a periodic inspection of the energy-control procedures at least once a year. This inspection is necessary to identify deviations or inadequacies and ensure the procedures and requirements are followed.

That's why ABB offers tools and guidance to help address any gaps found during inspections and to ensure compliance. Contact us to have one of our technical professionals assist you with inspections and documentation.

05 NFPA 70E required training

With effective and timely training from ABB, you can turn your lockout/tagout program investment into a driver of mission-critical safety, compliance and reliability outcomes.

We offer in-person, live webinar and self-paced options to meet your onboarding and scheduling needs. Our training solutions include:

- Authorized employee training
- Affected employee training
- Guidance for retraining needs
- Custom training program development

UNDERSTANDING THE COST OF WORKPLACE INJURIES

The cost and effects of a workplace injury go beyond claims and fines. A serious OSHA violation penalty can be up to \$16,550. The penalty for a willful or repeated violation can be up to 10 times higher, reaching \$165,514 ¹.

The average cost of a workplace injury claim is \$44,179². For every dollar spent on workers' compensation, it is estimated that \$2.12 is spent on indirect costs³, including legal fees, administrative time, recovery of lost production, quality and morale. This means the actual average cost of a workplace injury can be \$137,838.

If your company operates at a 10% profit margin, you will need an additional \$1,378,380 in revenue to cover the cost of the injury.

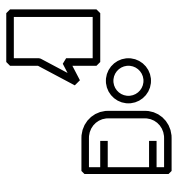
- 1 www.osha.gov/penalties
- 2 <https://injuryfacts.nsc.org/work/costs/workers-compensation-costs/>
- 3 www.amerisafegroup.com/the-real-cost-of-a-workplace-injury



CONTROLLING HAZARDOUS ENERGY REQUIRES CONTINUOUS IMPROVEMENT

Developing and leveraging a comprehensive lockout/tagout program is critical to the safety and success of your people and operations. However, controlling hazardous energy at your facility is an ongoing journey, not a destination. Changes in regulations, equipment, processes, business demands and workforce often require you to revisit one or more critical program components.

Whether you need a safety advisor or a boots-on-the-ground partner for any of the critical components of your LOTO program, you can rely on the expertise of the ABB team.



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