
2017

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Mine Inspector
St. Louis County
307 South First Street
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218-742-9840

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Safety & Risk Mgmt. Director
St. Louis County
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Duluth, MN 55811
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The ANNUAL REPORT of the INSPECTOR OF MINES St. Louis County, Minnesota

2017

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THE ST. LOUIS COUNTY BOARD OF COMMISSIONERS
District 1 .............................................................. Frank Jewell, Duluth, Minnesota
District 2 ..................................................................... Patrick Boyle, Duluth, Minnesota
District 3 .................................................................... Beth Olson, Duluth, Minnesota
District 4 ..................................................................... Tom Rukavina, Ely, Minnesota
District 5 ................................................... Pete Stauber, Hermantown, Minnesota
District 6 ...................................................... Mike Jugovich, Chisholm, Minnesota
District 7 .................................................................... Keith Nelson, Virginia, Minnesota

THE ITASCA COUNTY BOARD OF COMMISSIONERS
District 1 .............................................................. Davin Tinquist
District 2 ..................................................................... Terry Snyder
District 3 ..................................................................... Leo Trunt
District 4 ..................................................................... Burl Ives
District 5 ..................................................................... Mark Mandich

Jeff Walker ......................................................... Itasca County Auditor
Vic Williams ........................................... Itasca County Sheriff, Itasca County Mine Inspector
February 27, 2018

THE HONORABLE BOARDS OF COMMISSIONERS

ST. LOUIS COUNTY
COURT HOUSE
DULUTH, MN 55802-1202

ITASCA COUNTY
COURT HOUSE
GRAND RAPIDS, MN 55744

Dear Chairs Nelson, Trunt and Commissioners:


Mining activity for 2017 showed an increased production schedule for both St. Louis and Itasca counties. A total of 39,485,849 tons of natural ore and taconite were shipped from area operations compared to 27,841,630 in 2016. Mining related employment also increased and was reported at 3,944, which was an increase of 323 individuals compared to 2016. These positive numbers mark a significant improvement compared to the two previous years of reduced production and mining related employment in the area reported for 2015 and 2016. The total work hours reported for area mining operations was 8,054,252 for the year.

Keetac re-opened in February of 2017, bringing the total number of active mining operations in the area up to six. These include: ArcelorMittal Minorca, Hibbing Taconite, Minntac, Northshore and United Taconite. Several of these increased production during 2017 in comparison to their 2016 numbers.

Progress was made by several area operations toward the objective of growth during the coming years. PolyMet has now completed and submitted the mine permits associated with the NorthMet project (copper/nickel/precious metal mining) and Twin Metals continues to move forward with efforts directed at their semi-precious metal mining project near Ely.

On the transportation front, MnDOT completed the Highway 53 reroute and new bridge across the Rouchleau Pit in Virginia (see cover).

During 2017, area mining operations reported a total of 18 lost time or serious accidents. This is a decrease in comparison to the 22 experienced in 2016 and noteworthy considering the increases seen in both total em-

(Continued on page 3)
ployee number and production during the year. Zero fatalities were reported in 2017. The continued commitment to the safety of all those who work in the mining industry is our shared goal.

St. Louis County Mine Inspectors successfully completed all required inspections of area operations mandated by Minnesota State Law Chapter 180, Section 180.03 during 2017.

Acknowledgement and appreciation is extended to both Labor and Management for their continued interest, efforts and cooperation in the field of Safety and Health throughout the mines and plants in St. Louis and Itasca counties.

Respectfully submitted,

Steven K. Manninen
Inspector of Mines
St. Louis County

Joseph J. Austin MS, MIS, CHMM
Director, Safety and Risk Management
St. Louis County
INSPECTOR, POWERS; OWNER, DUTIES

It shall be lawful for the inspector of mines or assistant inspector to enter, examine, and inspect any and all mining operations and machinery belonging to the mine owner, operator, or agent at all reasonable times by day or by night, but so as not to obstruct or hinder the necessary workings of the facility. At the request of the inspector of mines, the owner, operator, or agent of a mining operation shall furnish for inspection:

(1) all maps, drawings, and plans of the mining facility, together with the plans of all contemplated changes:

(2) a suitable person, who shall be chosen by the inspector from a list containing at least three candidates, submitted by a majority of employees of the mine, to accompany the inspector through the mining operation;

(3) any necessary equipment to make a proper inspection; and

(4) all necessary facilities for such entry, examination, and inspection.

Upon receipt of a written request made by the inspector of mines, refusal to permit the inspection, or to furnish the necessary facilities for entry, examination, and inspection, shall be deemed a gross misdemeanor.
SUMMARY OF STATISTICS

2017

Number of Mining Companies .................................................. 7
Number of Mines in Operation .................................................. 6
Number of Plants in Operation .................................................. 6
Number of Wash Plants ............................................................... 0
Number of Mines Inactive .......................................................... 285
Number of Abandoned Mine Shafts Inspected ............................... 66
Total Number of Mines and Plants .............................................. 294
Total Taconite Products Shipped .............................................. 39,485,849
Total Ore Shipped ................................................................. 0
Taconite Mined ................................................................. 131,905,934
Stripping and Waste Removal, Tons ........................................ 125,926,472
Total Material Moved, Tons Estimate ........................................ 257,832,406
Total People Employed ............................................................ 3,944
Number of Fatal Accidents, Open Pit ......................................... 0
Number of Fatal Accidents, Plant ............................................... 0
Total Number of Fatal Accidents ................................................ 0
Fatalities per 1,000 People Employed ........................................ 0
Number of Lost-time and Time Charged Accidents ......................... 18
Total Number of Man-hours Worked ......................................... 8,054,252
Number of Investigations and Inspections ................................... 428

2017 WAGE RATES INCENTIVE INCLUDED

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<th>Wage Rate</th>
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Due to contractual changes the wage structure from mine to mine has changed significantly in recent years resulting in differing methods of payment. This results in different pay scales and different average daily wages from mine to mine. This is an example of what the rates are for the mines in St. Louis and Itasca counties.
<table>
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<th>YEAR</th>
<th>MINES</th>
<th>TONS SHIPPED</th>
<th>EMPLOYED</th>
<th>INJURED</th>
<th>FATALS</th>
<th>FAT/1000</th>
<th>WAGES</th>
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<td>(Average per year)</td>
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<td>WAGES</td>
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## Operational Summary

**Year Ending December 31, 2017**

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<tr>
<th>Mines</th>
<th>Tons of Taconite Products Shipped</th>
<th>Tons Taconite Mined</th>
<th>Tons Taconite Stripping Waste (Rock &amp; Overburden)</th>
<th>Average Number People Employed Plants / Pits</th>
<th>Man Hours</th>
<th>Months Worked</th>
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### REPORT OF THE COUNTY INSPECTOR OF MINES — PER MS 180.11

**OPERATIONAL SUMMARY**

**YEAR ENDING DECEMBER 31, 2017**

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<tr>
<th>MINES</th>
<th>TONS OF TACONITE PRODUCTS SHIPPED</th>
<th>TOTAL TACONITE MINED</th>
<th>TONS STRIPPING WASTE (ROCK &amp; OVERBURDEN)</th>
<th>AVERAGE NUMBER PEOPLE EMPLOYED PLANTS / PITS</th>
<th>MAN HOURS</th>
<th>MONTHS WORKED</th>
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MINING COMPANIES, MINE OPERATIONS, SAFETY PERSONNEL AND OTHER AGENCIES

UNITED STATES STEEL CORPORATION  
Minnesota Ore Operations  
KEEWATIN TACONITE  
P.O. Box 217  
Keewatin, Minnesota  55753  
Phone: 218-778-8798

Lawrence Sutherland ........................................ General Manager
Travis Kolari .......................................................... Plant Manager
Cory Hertling ...................... Area Manager - Electrical & Mine Maintenance
John Kingston ................. Area Manager - Mine Operations & Crusher
Kraig Raiber .......... Area Manager - Plant Operations & Maintenance
Susan Wiire ................. Interim Manager - Employee Relations
Kent Swanson ................. Manager - Safety & Industrial Hygiene
Jerry Orrell ......................... Safety & Industrial Hygiene Specialist

* * * * *

UNITED STATES STEEL CORPORATION  
Minnesota Ore Operations  
MINNTAC  
P.O. Box 417  
Mt. Iron, MN  55768  
Phone: 218-749-7299

Lawrence Sutherland ........................................ General Manager
Tim Kalisch .............. Division Manager - Plant & Plant Maintenance
Susan Wiire .................. Coordinator - Human Resources
Kent Swanson ................ Manager - Safety & Industrial Hygiene
Robert Youngman ............ Safety & IH Specialist
Mike Levar .................. Safety & IH Specialist
Jerry Orrell .................. Safety & IH Specialist
ARCELMITTAL MINORCA MINE, INC.
Company Officers and Staff

Minnesota Address
5950 Old U.S. Highway 53 North
P.O. Box 1
Virginia, MN  55792

Main Telephone
(218) 749-5910
(218) 749-3420 Fax
E-mail: jonathan.holmes@arcelormittal.com

Officers
John Brett ........................................ President and CEO
Keith Howell ..................................... Chief Operating Officer
Daniel Mull ................................. Executive Vice President, Sales & Marketing
Paul Liebenson .............................. General Counsel & Assistant Secretary
Marc Jeske ...................................... Secretary
Neil Kohlberg ............................... Vice President, Finance & Procurement
Richard Campoli ............................ Controller
Pat Parker ...................................... Vice President, Labor Relations
Wendell Carter ............................... Vice President, General Manager
Jonathan Holmes ............................ Vice President, Mining
Laurent Koenig ................................ Treasurer
Ken E. Walker .............................. Assistant Treasurer
Christine F. Fleps ........................... Assistant Treasurer
Joseph P. Wallace ........................... Assistant Treasurer
William R. Martin ........................... Assistant Treasurer

Managers
Jonathan H. Holmes ............... Vice President/Operations Manager - ArcelorMittal Minorca Mine
William M. Bond ......................... Manager - Operating Technology
Scott W. Harrison .......................... Manager - Pit
Robb A. Peterson .......................... Manager - Plant
Daniel G. Vidmar .......... Manager - Human Resources/Labor Relations
Karla L. Heritage-McKenzie ........ Manager - Safety
Thomas R. Cossalter ...................... Manager - Purchasing
Ross A. Phensalting ........................ Manager - Electrical/Systems

* * * * * *
HIBBING TACONITE COMPANY
P.O. Box 589
Hibbing, Minnesota 55746
Phone: 218-262-5950

Jack T. Croswell .................................................. General Manager
Joe Marturano .................................................. Manager - Asset Management
Todd Nelson .................................................. Manager - Financial Control
Jared Lubben .................................................. Manager - Mining
Rally Hess .................................................. Manager - Plants
Michael P. Kern .................................................. Manager - Human Resources
Andrea J. Bakk .................................................. Manager - Safety & Loss Control
Julie C. Lucas .................................................. Manager - Environmental
Tim Angelo .................................................. Manager - Procurement

★★★★★

UNITED TACONITE LLC
P.O. Box 180
Eveleth, MN 55734
Phone: 218-744-7800

Chad Asgaard .................................................. General Manager
Ryan Korpela .................................................. Area Manager - Plant
Jared Lubben .................................................. Area Manager - Mine
Nick Beukema .................................................. Area Manager - Maintenance
Todd Nelson .................................................. Area Manager - Finance
John Baxter .................................................. Area Manager - Human Resources
Bryan Baird .................................................. Area Manager - Safety
Candice Maxwell .................................................. Section Manager - Environmental
Jon Lamusga .................................................. Section Manager - Materials
Paul Carlson .................................................. General Manager
Ron Holm .................................................. Plant Manager
Connor McCue ......................................... Mine Manager
Bryon Rusco .............................................. Railroad Manager
Scott Blood ............................................. Safety Manager
Andrea Hayden ..................................... Environmental Manager
Bill Bundschuh ........................................ Silver Bay Power Manager
Ken Stocco ............................................. Reliability Manager
Carl Kerschen ....................................... Human Resource Manager
Chris Tokvam .......................................... Purchasing Manager
Nolan Koskela ......................................... Finance Manager
Luke Thun ............................................. Plant Safety Representative
Jake Baxter ............................................. Plant Safety Representative
Maria Strand ......................................... Plant Safety Associate
Rod Lampton .......................................... Mine Safety Representative
ERP INTERNATIONAL
28754 County Highway 61
Grand Rapids, MN 55744

Rob Bigelow ................................................. Managing Director

* * * * * *

POLYMET MINING
P.O. Box 475
6500 County Road 666
Hoyt Lakes, MN 55750
Phone: 218-471-2150

Jon Cherry ......................... President and Chief Executive Officer
LaTisha Gietzen ........ Director of Public and Community Relations
James Tieberg ......................... Division Manager - Mining
Kevin Pylka ..... Manager of Environmental Permitting & Compliance
Christine Kearney ..................... Environmental Site Director

* * * * * *
PIONEER FOUNDERS, LLC
306 W. Superior Street, Suite 1605
Duluth, Minnesota 55802-1816
Phone: 218-722-0816

Nicholas B. Alworth .................................................. Managing Director

* * * * *

CONGDON MINERAL MANAGEMENT INC.
1035 7th Ave. E.
Hibbing, Minnesota 55746-3675
Phone: 218-262-0799
Fax: 206-203-0098

David C. Adams .......................................................... President
David G. Meineke ....................................................... Vice President
Ann L. Albrecht ......................................................... Assistant Secretary and Treasurer

* * * * *

EVELETH FEE OFFICE, INC.
301 McKinley Avenue
P.O. Box 521
Eveleth, Minnesota 55734-0521
Phone: 218-744-4646
Fax: 218-744-2149

Daniel L. England ...................................................... President
Thomas J. Malkovich ......................... Vice President/Manager of Mines
Lisa A. Williams .................................................. Administrative Assistant

* * * * *
GLACIER PARK IRON ORE PROPERTIES, LLC

CORPORATE OFFICE
755 E. Mulberry Ave., Suite 600
San Antonio, TX 78212
Phone: 210-821-6523

Mr. David Schlagel ......................................................... President
Matt Gonzales ................................................................. Accountant

HIBBING OFFICE
801 E. Howard Street
PO Box 429
Hibbing, MN 55746
Phone: 218-262-3886

Jeff Tromp ............................................................... Chief Mining Engineer
John Dixon ...................................................... Senior Land / Mining Inspector
Ben Gardeski .................................................. Senior Mining Engineer / Inspector
Austin Dusek .................................................... Geologist / GIS Specialist
Robert Crowe ................................................ Mining Engineer / Inspector

********

HARTLEY OFFICE
740 East Superior Street
Duluth, Minnesota 55802
Phone: 218-723-8060

Patrick Flattery ................................................................. Trust Manager

********
IRON MINING ASSOCIATION OF MINNESOTA
324 West Superior Street
Suite 502
Duluth, Minnesota  55802
Phone: 218-722-7724
Fax: 218-720-6707
www.taconite.org

2017 IMA Staff
Kelsey Johnson ........................................ President and Treasurer
Katy Lofquist ........................................... Media Manager

2017 IMA Board of Directors
William Bond ........................................... ArcelorMittal
Jonathan Holmes ..................................... ArcelorMittal
Patrick Bloom ........................................ Cleveland Cliffs Inc.
Sandy Karnowski ..................................... Cleveland Cliffs Inc.
Jack Croswell ........................................ Cleveland Cliffs Inc. - Hibbing Taconite
Todd Nelson .......................................... Cleveland Cliffs Inc. - Hibbing Taconite
Ed LaTendresse ..................................... Cleveland Cliffs Inc. - Northshore Mining Co.
Chad Asgaard ......................................... Cleveland Cliffs Inc. - United Taconite
Santi Romani .......................................... Cleveland Cliffs Inc. - United Taconite
Jim Perry ............................................. Furin & Shea Welding & Fabricating Inc.
Jim Hoolihan ......................................... Industrial Lubricant
Jason Janisch ......................................... Jasper Engineering
Nels Ojard ............................................. Krech Ojard & Associates
Brian Maki ............................................. Lakehead Constructors
Art Lind ................................................ Lind Industrial Supplies
Bruce Mars ............................................. Mars Supply Co.
Steve Harms ........................................... RMS Equipment
Jon Anderson ......................................... Pit & Quarry Supply
David Bednarz ....................................... Steel Dynamics
Mark Lorenz .......................................... Steel Dynamics
Matt Thibodeau ..................................... Thibodeau, Johnson & Feriancek PLLP
Christina Bartovich ................................. U.S. Steel Minnesota Ore Operations
Larry Sutherland ................................. U.S. Steel Minnesota Ore Operations
             (Board Chair)
Tim Kalisch .......................................... U.S. Steel Minnesota Ore Operations
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* * * * *

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David Hamalainen ........................................ Assistant Mine Inspector
Derek Harbin ............................................. Assistant Mine Inspector

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* * * * *
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Daniel J. Goyen ........................ Conference Litigation Representative
Dan L. Venier ........................ Conference Litigation Representative
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UNITED STEEL WORKERS OF AMERICA
LOCAL UNITS

LOCAL #6860
UNITED TACONITE LLC
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Larry Roberts ......................................................... Safety Coordinator
Bryan Sandnas ....................................................... Plant Safety Chairman
Gary Butala ........................................................... Mine Safety Chairman

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Joe Ferris ............................................................... Safety Representative
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Jeff Stalboerger ...................................................... Area Chair, Shop
Kelly Peterson ....................................................... Area Chair, Pit
Lorne Middlestead ................................................ Area Chair, Pond
Tawnya Gustafson .................................................. Area Chair, Crusher
Carl Jeranek .......................................................... Area Chair, Pellet Plant
Eric Staydohar ....................................................... Area Chair, Electrical

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Jeff Walters ........................................................ Safety Chairman
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Tom French .................................................. Safety Coordinator
Reed Milos .................................................. Sub Chair, Safety
Jim Kottke .................................................. Sub Chair, Safety
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Paul Centa .................................................. Treasurer
Mitch McDonald ......................................... Safety Committee Chairman
Mark Hagsten ........................................ Safety Committee Co-Chairman
Matt Robillard ................................. Safety Coordinator - Minntac/Keetac
Steve Bonach ........ Full-Time Safety Representative, Mine/Shops
Mitch McDonald ..... Full-Time Safety Representative, Concentrator/ Crushers
Paul Coombe ............................................ Full-Time Safety Representative,
Agglomerators I, II, III

* * * * *

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Shawn Braford ............................................ "E" Board Member
Mark Towner .............................................. "E" Board Member
Michael G. Warner .................................. Recording Secretary
Shelly A. Wiitanen ......................... Office Manager, Sergeant at Arms
NON-FATAL LOST-TIME AND SERIOUS ACCIDENTS

ARCELORMITAL MINORCA MINE INC:

Concentrator Millwright, Date of Accident – April 11, 2017. Employee was ascending a set of three steps, and on the first step weight was placed on side of right foot causing employee’s ankle to roll. Incident resulted in an ankle fracture. Employee remains off work. Days Lost – 157 (in 2017)

HIBBING TACONITE:

Drill Operator, Date of Accident – January 5, 2017. The employee was attempting to access the drill house stairs on the back of the drill. While employee was pulling themself up the ladder, they felt a pulling sensation below their left shoulder blade and back resulting in a thoracic strain. Days Lost – 2

Maintenance Mechanic, Date of Accident – January 9, 2017. The MMG was replacing a trough idler assembly. While pulling the old trougher assembly from belt, they felt a pain in the left shoulder. The idler was located in very close proximity to the feeder (1st trougher located past the feeder). Due to the limited work area because of the impact bed located below the belt and feeder located above, the idler has to be forced out. Employee did not seek medical attention at the time and continued to work. Further medical evaluation resulted in surgical repair of shoulder in April 2017. Days Lost – 56

Electrician, Date of Accident – January 19, 2017. While the employee was walking they clipped/stepped on a 1” x 6” piece of rubber skirting that was lying off to the side of the walkway (6” into the walkway and butted up to the toe board) causing pain in their right foot. Walkway is approximately 3+ feet in width. Incident resulted in right foot sprain. Days Lost – 5

Drill Operator, Date of Accident – February 12, 2017. The employee was quickly descending the drill using main steps facing forward (away from stairs) by the drill cab. As they reached the last step (spring loaded), the step bounced back causing the drill operator to lose their balance and fall forward landing on their left shoulder area. Incident resulted in dislocated left shoulder. Days Lost – 22
HIBBING TACONITE COMPANY (cont)

Maintenance Mechanic, Date of Accident – April 24, 2017. The employee was assigned to disconnect the dewatering pumping lines (suction) from the pump header at pumping site. Employee was taking the last bottom bolt out of the flanged connection end. The pipe spun around and hit the employee on the head in the area of their safety glasses resulting in a small cut alongside the employee’s left eyebrow. Days Lost – 1

Laborer, Date of Accident – November 20, 2017. A labor crew member was moving loops of cable for preparation of lifting the cables using the cable standards. While doing so, the employee’s right leg caught on something while they were trying to turn and twisted their knee causing the employee to fall to the ground. Incident resulted in surgical repair for a torn right ACL ligament. Days Lost – 40 (in 2017)

NORTHSHELTER MINING COMPANY

Babbitt:
None

Silver Bay:

Plant Maintenance Technician, Date of Accident – February 6, 2017. A maintenance technician was descending a ladder after working on a screen deck. When he stepped off the ladder onto an inclined walkway, the grating moved slightly causing him to twist/sprain his ankle. Days Lost – 6

Plant Maintenance Technician, Date of Accident – June 9, 2017. A maintenance technician was using his hand to guide wire rope onto the spool of an air powered tugger when he lost his balance. He fell forward and his fingers wrapped under the rope on the spool. He suffered a fracture to the tip of one of his fingers. Days Lost – 8

Fine Crusher Operations Technician, Date of Accident – August 22, 2017. An operations technician was stuffing rags into a narrow gap on a crusher rock box when he felt a pop in the tip of his finger. He was later diagnosed with a tendon tear that needed to be surgically repaired. Days Lost – 12
UNITED TACONITE:

Plant Operator, Date of Accident – February 8, 2017. While attempting to remove a bolt, the employee was operating an 18-volt cordless drill and pressed the trigger with the intent of loosening the bolt, but it was set for tightening instead. This movement jerked the wrist causing pain. On 2/11/17 employee sought medical attention and was diagnosed with a wrist fracture. Days Lost – 49

Diesel Mechanic, Date of Accident – May 19, 2017. The employee slipped and fell egressing out of a skid steer and fractured his elbow. Days Lost – 20

Maintenance Mechanic, Date of Accident – August 18, 2017. The injured employee was arc airing a crusher mantle liner when a hot piece of slag contacted the employee’s coveralls, burned through and caused a small burn on left ankle. It was treated as a first aid injury. Weeks later, it became infected and became a lost time on 8/31. Days Lost – 2

Maintenance Mechanic, Date of Accident – November 26, 2017. The employee was cleaning the upper walkway in the fine crusher with a water hose. He stepped backwards and his left foot slipped on the wet transition surface causing him to fall backwards and roll right ankle. Days Lost - 20

USS CORPORATION, MINNESOTA ORE OPERATIONS

KEETAC:

None

MINNTAC:

Coarse Crusher MTM, Date of Accident – June 6, 2017. Employee fractured his right leg just above his ankle while working on the #2 primary concave job. The MTM was attaching a 4-legged chain to the concave jig in order to set the last row of concaves in the #2 primary crusher. The MTM had just completed attaching the 4th hook to the lifting jig while standing on a 4-step Cotterman portable staircase. As he was descending the staircase, he felt the staircase tip back, which startled him. He then leaped off the staircase landing, breaking his right ankle. He stated he was on the 3rd step off the ground when he leaped off. He fell onto his side as soon as his foot contacted the ground. His partner heard this and came to his aid. Days Lost – 15
MINNTAC COMPANY (cont)

Field Maintenance MTM, Date of Accident – June 30, 2017. Employee was placing a shank on the #12 shovel and lifted and wiggled the shank while the shank was attached to the crane. During the process of final positioning, the employee stated they felt a pop and sharp pain in the left elbow. The incident resulted in a torn bicep tendon. Days Lost – 21

Shops MTM, Date of Accident – July 17, 2017. Employee was in the process of assembling a hydraulic dipper in the Dipper Shop. While walking around the bowl, the employee stated they slipped on a 1" x 1" piece of metal on the floor. The employee caught themselves with their right leg, straining the right hip. The pain went away, but returned the next morning. The incident resulted in a torn hip labrum. Days Lost – 35

Coarse Crusher MTM, Date of Accident – August 2, 2017. Employee was removing crusher arm shoulder blocks from the 5201 crusher that weigh approximately 193 lbs. Previous to the injury, the middle shoulder block was removed without incident. While an MTM was operating the crane, the injured employee was located inside the crusher next to the shoulder block and had attached a one-legged chain to the outer shoulder block for removal. Tension had been applied to the block a couple of times without freeing the block from its position. The injured employee moved 4-6 feet away from the shoulder block as they again attempted to free the shoulder block. Tension was again applied to the block and it freed itself and traveled toward the injured employee. The shoulder block contacted and crushed the employee's left hand against the primary crusher wall causing a fracture of the hand as well as a large laceration. Days Lost - 12