

HANSON CEMENT LIAISON COMMITTEE

MEETING DATE – THURSDAY 22 SEPTEMBER 2016

PRESENT:	Terry Reynolds	-	Hanson Cement
	Nick Sharpe	-	Hanson Cement
	Linda England	-	Bellman Committee
	Mary Gysbers	-	Bellman Committee
	Andrew Bristol	-	West Bradford PC
	Stephen Booth	-	Chatburn PC
	Jonathan Haine	-	LCC
	Cllr R Hargreaves	-	RVBC
	Cllr R Sherras	-	RVBC
	Alan Taylor	-	RVBC
	Olwen Heap	-	RVBC

1 APOLOGIES FOR ABSENCE

- 1.1 Apologies for absence were received from RV Councillors Ian Brown and Ian Sayers; Cty Cllr Albert Atkinson; Simon Moorhouse and Sam Wrathall – Hanson Cement; and Phil Goodwin – Environment Agency

2 MINUTES

- 2.1 The minutes of the meeting held on 24 March 2016 were circulated and approved as a correct record.

3. SITE PERFORMANCE

- 3.1 321 day programme plus 21 days shutdown in January and 2 other planned shutdowns

3.2 Health & Safety

- Mitigation works had taken place following an incident on site where a contractor had damaged his foot when a chain broke. HSE had been on site.
- January shutdown sees 300 contractors on site
- Employees are positively challenged on a daily basis – an extremely low level of incidents
- Leak of Cemfuel started a fire that caused a shutdown for a week. Cables and instruments were damaged. These have now been repaired and modified with the rubber being replaced by steel where possible to ensure it doesn't happen again (revenue loss of £5/6k per hour during an unscheduled shutdown)

3.3 H & S Improvements

- Continuous route to improving compliance and standards across the site
- Invested in 66 new vehicles @ £170k each
- All wagons are sheeted before they leave site
- Wash facility on site
- A new multi-million pound scrubber – this scrubs out SO2 and other elements out of the alternative fuels
- New dust filter systems on cement mills 7 & 8 – installation of bag filters and separators
- Ducting replacement programme to main ID inlet, main scrubber outlet and GCT ducting
- All contractors receive notice of site rules that are monitored by security
- Modified signage on site; improved traffic management and pedestrian walkways
- Legacy activity – improve structure of site including fabric of buildings and mills and silos

3.4 Fuels

- A target of 60% alternative fuels made up of 6% tyres; 21% SRF; 18% Cemfuel; 7% MBM and 6% pulverised fly ash – a gate fee is received from the Government for using these fuels
- 40% coal
- Currently trialling 'car frag' – anything not metal from a wrecked car

3.5 Hinckley Point

- Hanson are the supplier of cement to this project – 8 year construction period
- Ribblesdale works will supply 'nuclear concrete' as it meets the performance requirements – approved process and quality
- 200k tonnes from Ribblesdale Works over the next few years

4. QUARRY UPDATE

- 4.1 Coplow restoration is now complete and the area has been re-seeded to create a natural landscape. If anyone would like a tour – contact Sam Wrathall
- 4.2 Lanehead – 3600 trees have been planted on the North face. Local volunteers have ben invoved with the support of Lancashire Wildlife Trust.
- 4.3 Exploratory Test Drilling has been taking place to build a block map of depths in the quarry. This data has been passed to Heidelberg for modelling. Total reserves in Bellman / Lanehead will last for a significant number of decades

5. STAFFING

- 5.1 There has been a slight increase in staff on site including the local apprenticeship scheme – 2 apprentices (16 years), 1 lead apprentice (18 years) and 2 graduates.

6. PLANT CHALLENGES

- 6.1 Improving H&S Performance
- 6.2 Improving Plant Reliability
- 6.3 Addressing 'legacy' and driving the 5 year capitals improvement plan. Being successful in delivering these will support:
- Delivering our goal of zero harm
 - Delivering a sustainable ongoing position for cement supply to market
 - Ensuring environmental compliance and improvement

7. OPEN DOOR REVIEW

- 7.1 Terry circulated the community newsletter and asked for feedback / improvements. He also asked that everyone check out the website and again give feedback.

8. AOB

- 8.1 Lynda asked for an alternative site access to the dog walking area at the top of Old Road since the builders had diverted the footpath during their housebuilding. Sam would investigate.
- 8.2 Lynda also asked for a 'quarry' sign to be placed at the top of Old Road where the new houses are being built so that prospective buyers are aware that it exists.

9. DATE OF NEXT MEETING

- 9.1 The next meeting of the Hanson Cement Liaison Committee will be held on Thursday 23 March 2017.

HANSON CEMENT LIAISON COMMITTEE EXTRAORDINARY MEETING – THURSDAY 7 DECEMBER 2016

PRESENT:	Terry Reynolds	-	Hanson Cement
	Nick Sharpe	-	Hanson Cement
	Simon Moorhouse	-	Hanson Cement
	Iain Walpole	-	Hanson Cement
	David Weeks	-	Hanson Cement
	Tom Glyn-Jones	-	Environment Agency
	Linda England	-	Bellman Committee
	Mary Gysbers	-	Bellman Committee
	Marilyn Woods	-	West Bradford PC
	Jonathan Haine	-	LCC Planning
	Cty Cllr Albert Atkinson	-	LCC
	Cllr R Hargreaves	-	RVBC
	Cllr I Brown	-	RVBC
	Cllr I Sayers	-	RVBC
	Alan Taylor	-	RVBC
	Olwen Heap	-	RVBC

1 APOLOGIES FOR ABSENCE

- 1.1 Apologies for absence were received from RV Councillor Richard Sherras; and Stephen Booth, Chatburn PC

2. HANSON INVESTIGATIONS INTO DUST EMISSIONS

- 2.1 Terry reported upon 3 recent Major Incident Reports (MIR) that had happened on site. The incidents had been both unrelated and unforeseen and had been quickly resolved by the site team and reported to the Environment Agency

- Kiln 7 – main filter trip
- Mill 7 – transformer failure
- Mill 8 – cold start

- 2.2 Simon gave a simplified explanation of the plant operation with the aid of a diagram which also showed the computer screens seen by the controllers. The operation works 24/7.

- 2.3 Details of the 3 incidents were outlined by Nick Sharpe

- 15 September @ 6.14 – lasted for 5 minutes (6.14 – 6.19) resulting in elevated levels of dust being emitted from mill 7 stack. The root cause was found and corrective actions were taken – namely a new regime of planned maintenance and increased staffing levels.
- 19 September @ 22.14 – lasted 24 minutes (22.14 – 22.38) resulting in elevated levels of dust being emitted from kiln 7 stack. An alarm had been missed = human error. Corrective action now includes automatic shutdown if a trip is not acted upon immediately.
- 2 October @ 8.30am – lasted 5 minutes (8.30 – 8.35) resulting in elevated levels of dust being emitted from mill stack 8. This was a 'unique' event when starting up from cold after a prolonged shutdown. Corrective action includes a new proven written procedure with all staff being trained.

3. EA INVESTIGATION AND ONGOING COMPLIANCE WORK

- 3.1 Tom gave an overview of how complaints received are dealt with by the EA. He reported that it was unusual to get complaints from Hanson Cement (a good record over the last 5 years).

- 3.2 Following receipt of several complaints site visits had been made to the complainants to see how severe the incident was and to Hanson Cement to see how the incidents had been investigated and what corrective actions had been taken.
- 3.3 Under the permit the operator (Hanson) had a duty to inform the EA of the incidents and had done so.
- 3.4 An audit process had been triggered in to the incidents that would take place in January 2017 and a report produced. This would be put on the public register. At this point there would be a decision about whether any further action would be taken.
4. KEY IMPROVEMENTS CAPITALS AND STRATEGIES 2016/17 – 2020
- 4.1 Terry outlined a comprehensive £25 million investment to improve the environmental performance of the plant and ensure it operates within new regulatory limits which come into force in April 2017.
- 4.2 It will cover health, safety and environmental performance and plant reliability and address legacy issues through a five-year capital investment plan which will
- Deliver the goal of zero harm
 - Deliver a sustainable ongoing position for cement supply to market
 - Ensure environmental compliance and improvement
- 4.3 The plan includes
- Scrubber and ducting replacement plan
 - Mills and silo refurbishment
 - Ducting refurbishment (pyro process)
 - Clinker transport and dust management
 - Building fabric and structures
 - Logistics and workplace transport
- 4.4 Several members of the committee asked questions which were answered. Terry asked that if anyone had further questions to contact him at any time.
5. DATE OF NEXT MEETING
- 5.1 The next ordinary meeting of the Hanson Cement Liaison Committee will be held on Thursday 23 March 2017.

Meeting closed at 3.15pm

HANSON CEMENT LIAISON COMMITTEE MEETING DATE – THURSDAY 23 MARCH 2017

PRESENT:	Terry Reynolds	-	Hanson Cement
	Sam Wrathall	-	Hanson Cement
	Lynda England	-	Bellman Committee
	Mary Gysbers	-	Bellman Committee
	Marilyn Wood	-	West Bradford PC
	Stephen Booth	-	Chatburn PC
	Jonathan Haine	-	LCC
	Cty Cllr A Atkinson	-	LCC
	Cllr I Brown	-	RVBC
	Cllr R Sherras	-	RVBC
	Cllr I Sayers	-	RVBC
	Olwen Heap	-	RVBC

1 APOLOGIES FOR ABSENCE

- 1.1 Apologies for absence were received from RV Councillor R Hargreaves; RV Officer Alan Taylor; and Tom Glyn-Jones – Environment Agency

2 MINUTES

- 2.1 The minutes of the meetings held on 22 September 2016 and 7 December 2016 were circulated and approved as a correct record.

3. SITE PERFORMANCE

- 3.1 321 day programme plus 21 days shutdown in January and 2 other planned shutdowns

3.2 Health & Safety

- Low level accidents / incidents throughout the January shut down with over 300 contractors and 100 employees on site – NO accidents.
- Significant improvements in hygiene and housekeeping standards
- Focus on vehicles and contractor management
- Strategies to reduce emissions and impact on environment on-going
- Waste stream management project in place – ‘zero waste to landfill’ approach – a graduate is working on this project assessing the current situation on site and looking at ways to improve and reduce costs.
- New quarry excavator purchased
- 2 x Kodi vehicles purchased to reduce manual handling
- Delivered site specific ‘back to work’ and sustainability work activity based around ‘behavioural safety’ and more recently on water discharge compliance activity and plans
- Site H & S comms programme in place and running – 5 on site with generic access to intranet. Community web pages set up and 14,000 ‘Open Door’ newsletters delivered. Also looking to do an internal one for staff.
- Workplace transport upgrade completed – new signage, speed limits and management on site, pedestrian routes, traffic light system/crossings and extended barriers.

3.3 Fuels

- A target of 60% alternative fuels. Figures at the start of the year are slightly squiffed with the January shut down and February start-up. Figures are made up of 52.7% coal; 2% tyres; 14.4% solvents; 15.7% Industrial Commercial Waste; 7.8% animal meal and 6.3% pulverised fly ash. These would improve from March onwards.

- Continue to work with Lancashire Waste Recycling on improving SRF consistency and in deriving new fuel base biomass additives and improvements
- Capital AFE submission to install new SRF plant capable of improvement to throughput rates
- Continue to review other strategic alternative fuels for longer term
- Integrated within 'zero waste to landfill' strategy

4. QUARRY UPDATE

- 4.1 Coplow restoration is now complete – include a site visit at the next meeting in September. Also like to visit the historical English Heritage site at Bellman.
- 4.2 There have been no Lost Time Incidents (LTI) with Hanson employees in the quarry for 7 years 15 days
- 4.3 Since 2013 the Tarmac stone debt has reduced by 1.3 million tonnes and there is about 100,000 tonnes left which should take until the end of April to extract. Work will then continue at Horrocksford.
- 4.4 A joint scheme with Tarmac is being negotiated with regard to going deeper in the quarry. The permission is subject to a S106 on water monitoring.
- 4.5 In Lanehead historically there has been 80/20 high/low stone production requirements. Actual is now 72/28 which has increased the cement making reserve by 3,390,577 tonnes.
- 4.6 A new 2 year contract has been agreed with Brian Dent who has subsequently invested in a new excavator.
- 4.7 New project being pursued with the roller mill and the purchase of a self-cleaning magnet that will take out any waste scrap metal and therefore avoid damage and time consuming mill stops.

5. PLANT CHALLENGES

- 5.1 Improving H&S Performance
- 5.2 Improving Plant Reliability
- 5.3 Addressing 'legacy' items – capital approvals include
 - Conveyor upgrades and DCE upgrades along the main transport routes
 - Building fabric and structural / infrastructure improvement plans
 - Roads and logistics improvement plans
 - Tower improvement – new floors and infrastructure
 - Scrubber and ductings replacement plan
 - Mills and silos refurbishment programme
 - Ductings refurbishment programme
 - Logistics and workplace transport – HSE
- 5.4 All UK business including Hanson UK have been tasked to operate low level dust emissions from April 2017 which for Ribblesdale will require new filtration units in order to meet the new limits. The 1st stage has been completed – mills 7 & 8 are built and in place. Mill 8 is already running and mill 7 will start this weekend. The 2nd stage of this project is replacement of the older generation separators.
- 5.5 The new design vessel for the new scrubber is complete and being shipped from India ready for installation beginning at the end of July.

6. COMPLAINTS

6.1 The Environment Agency had carried out a full audit at the end of January following the incidents at the end of 2016.

6.2 To date in 2017 there had been 3 Part A notifications that had all been actioned and resolved.

7. AOB

7.1 Lynda referred to the medieval strip fields at Bellman and requested that fences be replaced and some planting done in order to restore these. They are environmentally valuable assets. Sam would work with Lynda on this.

7.2 Sam reported that a woodland management review had recently been carried out with a view to a future programme of restoration.

8. DATE OF NEXT MEETING

8.1 The next meeting of the Hanson Cement Liaison Committee will be held on Thursday 21 September 2017. Site visits would be incorporated into this meeting.

HANSON CEMENT LIAISON COMMITTEE MEETING DATE – THURSDAY 9 OCTOBER 2017

PRESENT:	Terry Reynolds	-	Hanson Cement
	Sam Wrathall	-	Hanson Cement
	Graeme McGibbon	-	Hanson Cement
	Lynda England	-	Bellman Committee
	Marilyn Wood	-	West Bradford PC
	Jonathan Haine	-	LCC
	Tom Glyn – Jones	-	Environment Agency
	Cllr I Brown	-	RVBC
	Cllr R Sherras	-	RVBC
	Cllr I Sayers	-	RVBC
	Olwen Heap	-	RVBC

1 APOLOGIES FOR ABSENCE

- 1.1 Apologies for absence were received from RV Councillor R Hargreaves; Mary Gysbers and Cty Cllr Albert Atkinson

2 MINUTES

- 2.1 The minutes of the meetings held on 23 March 2017 were circulated and approved as a correct record.

3. SITE PERFORMANCE

- 3.1 January 2018 shutdown will be from 6 January for 23/35 days

3.2 Health & Safety

- Low level accidents / incidents in general
- Focus on vehicles and contractor management
- Safety and Well Being stand down 23 October – all on site
- Strategies to reduce emissions and impact on environment on-going – BAT AEL compliance and low level fugitive dust improvement programmes in place to mitigate and excursions of dust from the site ongoing
- Delivered site specific 'back to work' and sustainability work activity based around 'behavioural safety' and more recently on water discharge compliance activity and plans
- Workplace transport upgrade completed – new signage, speed limits and management on site, pedestrian routes, traffic light system/crossings and extended barriers
- Speeding ANPR system now active and transgressors being sent direct letters
- Full structural survey – both with refurbishment and improvement capitals approved 2017-20 Tower improvements = £0.5M for new floors and infrastructure
- Optimisation and renewal programme – new fleet of train wagons; x-bar cooler; kiln shell; CM9; raw mill refurb and other key projects over the coming years
- Ribblesdale Reader – trial period newsletter

Terry showed time lapse videos of the removal of the scrubber and replacement of new filters on mills 7 & 8.

3.3 Fuels

- Currently a target of 60% alternative fuels targeting increasing to circa 70%. Figures are made up of coal; tyres; solvents; Industrial Commercial Waste (SRF) and animal meal with some light fuel oil and pulverised fly ash
- Hope to further improve cost base for Plant as we progress with some key capital activity next year
- Jan 2018 completely refurbish and upgrade the SRF plant to deliver a more controllable and consistent supply to the Kiln

- Hope to reduce use of tyre chips and MBM and replace with other waste products that would otherwise go to landfill
- Continue to review other strategic alternative fuels for longer term
- Integrated within these developments is our 'zero waste to landfill' strategy

4. QUARRY UPDATE

- 4.1 Coplow restoration is now complete – another area has been reseeded – thanks to teams of volunteers working with Phil Dykes for their support of this project
- 4.2 Work continues in Horrocksford area – pushing the top benches back to final boundary positions
- 4.3 Tarmac working back in Lanehead – stone debt has been repaid
- 4.4 A joint scheme with Tarmac is being reviewed with regard to going deeper in the quarry. The permission is subject to an agreed S106 on water monitoring.
- 4.5 Biodiversity corner at Chatburn continues to flourish – a very successful project

5. BOUNDARY FENCE Discussion – OLD ROAD, CHATBURN

- 5.1 A public footpath runs partially across Hanson land and partially across land under private ownership where new houses are being built.
- 5.2 The fencing continues to suffer damage despite constant repair by Hanson
- 5.3 Investigations now under way with LCC regarding the public footpath and it's route across this land

6. QUALITY & ENVIRONMENT

- 6.1 In 2017 to date 13 dust complaints had been received one of which was justified after investigation. No complaints had been received in July, August or September. One noise complaint had been received which when investigated transpired to be Network Rail carrying out works
- 6.2 There had been several Part A notifications that had all been actioned and resolved except one that was ongoing.
- 6.3 New permit issued with tighter emission limits in April 2017.
- 6.4 The plant is operating without the scrubber operating during the upgrade works – Managers constantly monitoring for odour, plume appearance and emissions in the local area
- 6.5 Coplow restoration work is ongoing through to 2018
- 6.6 No water abstraction required from the River Ribble in 2017 – reuse of water from quarry
- 6.7 No significant quality issues

7. AOB

- 7.1 Marilyn reported that some contract vehicles were sweeping out in a layby. Terry asked for details of registration numbers, times and dates so that this could be followed up.
- 7.2 Terry and Sam gave members of the committee a walking tour of the site.

8. DATE OF NEXT MEETING

- 8.1 The next meeting of the Hanson Cement Liaison Committee will be held on Thursday 22 March 2018.

HANSON CEMENT LIAISON COMMITTEE

MEETING DATE – THURSDAY 22 MARCH 2018

PRESENT:	Terry Reynolds	-	Hanson Cement
	Sam Wrathall	-	Hanson Cement
	Graeme McGibbon	-	Hanson Cement
	Lynda England	-	Bellman Committee
	Marilyn Wood	-	West Bradford PC
	Mary Gysbers	-	Bellman Committee
	Phil Dykes	-	Wildlife Trust
	Tom Glyn – Jones	-	Environment Agency
	Cllr I Brown	-	RVBC
	Cllr R Sherras	-	RVBC
	Cllr I Sayers	-	RVBC
	Cllr R Hargreaves	-	RVBC
	Heather Barton	-	RVBC

1 APOLOGIES FOR ABSENCE

1.1 None received

2 MINUTES

2.1 The minutes of the meetings held on 9 October 2017 were circulated and approved as a correct record.

3. SITE PERFORMANCE

3.1 Environmental and Health & Safety

- Graeme gave an overview of complaints received since January 2017 – date (Mar 2018). Overall it was good but with a spike in November of 3 odour, 2 dust and a noise complaint.
- NOx and SO2 emissions are both well below EA limits – stable and compliant
- Dust and HCl emissions are both well below limits – HCl spikes when the scrubber/raw mill is off
- Carbon monoxide is well below limits
- Ammonia and total organic carbon (TOC) is also well below limits
- Water discharges (2 into River Ribble and 1 into Worston Brook) are well within limits of both pH and suspended solids

3.2 Scrubber Refurbishment Project

- Graeme explained the delays to the scrubber refurbishment project that included modification to civils; piping issues; technical clarifications with supplier; technical issues with Finite Element Analysis.
- Mechanical completion – 9 May 2018
- Electrical completion – 6 April 2018
- Cold/Dry commissioning – 27 April 2018
- Optimisation and Performance tests and plant handed over to production – 8 May 2018

3.3 Fuels

- Production is up to 700k tonnes a year of clinker which is the highest since 2008
- Fuels used are made up of coal; tyres; solvents; Industrial Commercial Waste (SRF) and animal meal with some light fuel oil and pulverised fly ash
- Continue to review other strategic alternative fuels for longer term
- Integrated within these developments is our 'zero waste to landfill' strategy

4. QUARRY UPDATE
 - 4.1 Employee Lost Time Incidents free for 8 years 35 days and Contractor LTI = 6 years 311 days
 - 4.2 Work continues in Horrocksford area – pushing the top benches back to final boundary positions towards Bold Venture. There have been some issues in this area with what was the old Horrocksford plant with metals / cables etc left in the ground. A capital bid for a self-cleaning overband magnet at a cost of £57k is ready to submit that will take the metals out of the raw meal.
 - 4.3 Tarmac working back in Lanehead – stone debt has been repaid
 - 4.4 A joint scheme with Tarmac is being reviewed with regard to going deeper in the quarry. The permission is subject to an agreed S106 on water monitoring.
 - 4.5 Biodiversity corner at Chatburn continues to flourish – a very successful project
 - 4.6 There are total reserves for approximately 42 years. Currently taking approximately 1.2m tonnes out of the quarry per year.
 - 4.7 A review of the mobile plat is being undertaken. This is of the yellow trucks that do the hauling in the quarry with a view to optimising the fleet and finding savings.
 - 4.8 Since Tarmac have started quarrying again there is shared access and egress to the quarry. The narrow road has been widened and a protective central barrier is to be installed to keep quarry vehicles away from cars and pedestrians.
 - 4.9 Phil Dykes reported that there were ongoing works taking place at Coplow. Good progress was being made. He would carry out some monitoring of species over the next few months and prepare a presentation for the end of the summer.
5. FACTORY SHUTDOWN – JANUARY 2018
 - 5.1 Terry explained in detail how the shutdown had been organised. £3.2 had been spent in 21 days. There had been significant contractor controls which had contributed in having only one first aid incident but no lost time injuries. These controls were imperative with the numbers of contractors on site during this period.
 - 5.2 All works had been carried out under Construction Design and Management Regulations. AVETTA checks of both individuals and companies had taken place to ensure full compliance against Hanson criteria.
 - 5.3 There is another shutdown scheduled for the end of July 2018.
6. HINKLEY POINT
 - 6.1 Hanson is the major supplier of cement and most other products to this site and will be part of their programme for the next 3 years. An extra train has been commissioned from 2 April 2018 to transport the material.
 - 6.2 Discussions are also taking place with the Government about another 4 plants.
7. AOB
 - 7.1 Lynda asked about fencing the strip fields at Worston. Sam reported that it was going to part of a much bigger job now - £15k.
 - 7.2 Lynda reported that she had discovered several lengths of blue plastic in Worston Brook left behind after the oil tanker crash on the A59. Tom Glyn-Jones (EA) would investigate.
 - 7.3 Lynda expressed disappointment that the ivy on the roadside near the works looks very grey – Terry would investigate.

- 7.4 Lynda reported that there was a lot of litter stuck in the trees on the Old Road, Chatburn building site. She acknowledged it was not a Hanson problem but Sam would investigate anyway.
- 7.5 Lynda also asked, on behalf of Chatburn Parish Council, about the application to move electricity poles on this same site. Terry would update her separately.
- 8 DATE OF NEXT MEETING
- 8.1 The next meeting of the Hanson Cement Liaison Committee will be held on Thursday 20 September 2018.