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ADVANCE
ENVIRONMENTAL

PARTICULATE EMISSION MONITORING
EXPRESS ASPHALT
DOYLE DRIVE
COVENTRY
WEST MIDLANDS

REPORT ON PARTICULATE EMISSION MONITORING

to

DETERMINE THE LEVELS OF PARTICULATE EMISSION

from the

ROADSTONE COATING PLANT

at

EXPRESS ASPHALT
DOYLE DRIVE
COVENTRY
WEST MIDLANDS

Report Submitted To:

EXPRESS ASPHALT
DOYLE DRIVE
COVENTRY
WEST MIDLANDS
CV6 6NW

Report Prepared by:

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Company Principal

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Associate

Date: 10.10.11

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SUMMARY INFORMATION

Determined	Units	Results	Limit
Particulate Concentration (STP)	mg/m^3	14.2	50
Mass Emission (STP)	kg/hr	0.36	-
Stack Temperature	^oC	77	-
Gas Velocity	m/s	14.90	-
Stack Volume Flow Rate (Actual)	m^3/hr	34131	-
Stack Volume Flow Rate (STP)	m^3/hr	26685	-

All results are reported at reference conditions of 273K, 101.3kPa, wet gas.

1. INTRODUCTION

On 10 October 2011, particulate emission testing was undertaken by Advance Environmental, on the asphalt plant at Aggregate Industries UK Limited, Coventry.

The purpose of the emission testing was to ensure compliance with the requirements of the permit issued by the Local Authority under The Environmental Permitting (England and Wales) Regulations 2010.

2. BACKGROUND INFORMATION

The environmental Permitting (England and Wales) Regulations 2010 (EPR), came into force on 6 April 2010. The regulations combine Pollution Prevention and Control and Wate Management Licensing.

Environmental Permits automatically replaced previously issued Pollution Prevention and Control permits (PPC) permits with effect from April 2010. As with PPC permits, to continue operations, all sites operating scheduled processes must obtain an EPA permit from their Local Authority and comply with the conditions contain therein. The conditions will include a requirement to monitor emissions to air both periodically and continuously in accordance with relevant clauses of following process guidance note:-

* Process Guidance Note PG3/15a(04) Secretary of State's Guidance for Roadstone Coating Processess.

3. MONITORING CONTRACTOR

The emission monitoring was co-ordinated by Mr K Gough, Company Principal, Advance Environmental. Mr Gough has 21 years experience of undertaking particulate emission testing on plant used in the quarrying aand allied industries.

The lead engineer managing the on site testing is MCERTS Level 2 accredited.

4. MONITORING PROTOCOL

4.1 Test Method and references

Isokinetic sampling of the contained emission sources was undertaken using the APEX Instruments Inc Method Five isokinetic sampling apparatus in accordance with the main procedural requirements within the following British Standards and Technical Guidance Notes:-

* BS ISO 9096:2003 - Stationary source emissions. Manual Dertermination of mass concentration of particulate matter.

* Environment Agency - Technical Guidance Document (Monitoring) M1 Sampling requirements for monitoring stack emissions to air from industrial installations; and

* Environment Agency - Technical Guidance Document (Monitoring) M2 Monitoring of Stack Emissions to Air.

4.2 Sampling Procedure

The work carried out was, as far as was reasonably practical, in accordance with BS ISO 9096.

Isokinetic flow means that sample gases laden with particulates are drawn off at the same velocity as the free stream velocity in the flue. Isokinetic sampling thus avoids possible inertial effects of particulates approaching the vicinity of the inlet nozzle which may result in significant error.

The Apex Instruments test equipment was designed to meet the sampling requirements of US EPA Method 5 and with a modified nozzle design, meets the sampling requirements of BS ISO 9096.

The principle of the standard is to draw a known volume of dust laden gas isokinetically through a filter. The weight gain on the filter, after sampling, divided by the gas sample volume equates to the particulate concentration, which in turn can be used to calculate a mass emission.

4.3 Sampling equipment

The test equipment is inspected prior to use and it's calibration status observed. This includes:-

* *Pitot Tube* - All pitot tubes are checked for damage, alignment and that there are no blockages;

* *Manometer* - Check of oil levels, connectors and orientation level;

* *Thermocouple* - Temperature is measured using k type thermocouples. Each thermocouple is inspected for calibration and damage. Digital temperature meters are used in conjunction with k type thermocouples which are also checked for calibration dates;

* Gas meter - The calibration of the gas meter is checked before and after sampling using a critical orifice.

* *Nozzles* - All nozzles used have been constructed in accordance with BS ISO 9096. Each nozzle is checked for damaged and measured using a vernier caliper on at least 3 planes. Non conforming nozzles will be rejected.

* *Balance* - A Mettler Toledo balance is used to weigh filters. It is calibrated yearly by the manufacturer and checked daily by in-house weights.

* *Filters* - Pall quartz membrane filters with a collection efficieny of >99.5% at 0.3microns.

4.4 Preparation for sampling

4.4.1 Filter Preparation

Filters are pre-conditioned before arrival on site. The filters are dried in an oven at 180^{o} for a period of at least one hour and then placed to cool in a dessicator for at least four hours. The filters are then weighed on a five figure balance and placed in individual transport containers. Spare Filters are prepared to obtain blank values.

4.4.2 Sampling Location

No site visit was undertaken prior to undertaking the sampling procedure, as monitoring had previously been undertaken at the site, during which time the sampling position, working platform, sampling ports, access and safety precautions were found to be satisfactory.

The internal dimension of the flue was known from previous monitoring undertaken. However, further measurements were taken to check that the internal diamerter had not changed.

Prior to sampling a pressure and temperature survey, using a pitot static tube, a micromanometer, a digital thermometer and a nickel-chromium/nickel-aluminium thermocouple, is carried out to check whether the flow conditions meet with the requirements of BS ISO 9096. From this initial survey sample locations, isokinetic flow rates, nozzle size, and sample period can be worked out.

4.5 Sample Collection

A leak check is carried out before and after sampling to confirm all the suction is drawn through the nozzle.

With the required isokinetic flow rates known the sample probe is inserted into the stack at 90^{o} to the gas flow, this is to stop any particulate matter impinging on the filter before

The filter head and probe were allowed to obtain the stack gas temperature.

The initial gas meter reading was noted and the suction device and timer started. The correct flow rate for isokinetic sampling was set and the nozzle positioned to face parallel to the gas flow.

Sampling was then carried out for the planned duration and number of sample points, recording all the necessary data for final calculations. On completion, the suction device and timer were stopped and the final gas meter volume recorded.

The probe was removed from the process stack and a further leak test carried out prior to removal of the filter, which was subsequently removed and placed in a storage container.

Any residual particulates upstream of the filter was washed with acetone into an appropriate beaker.

Due to limited production it was not possible to repeat all of the above procedures to obtain duplicate samples.

At all times during the sampling procedure the sampling technicians were in contact with the process operator to ensure that the plant was in full production and there were no changes in the process that might affect the representative nature of the samples collected.

4.6 Analysis of samples

On returning to the laboratory, the used filters were dried in an oven at 160^{o}C for a minimum of one hour and then desiccated and weighed as before. The water/acetone washings are first evaporated, without boiling, then dried and weighed as above. The total particulate mass is the sum of the differential filter weight added to the differential water/acetone rinsings component.

4.7 Calculation of results

The calculations were made using the formula specified in BS ISO 9096.

The recorded filter weights, velocity, temperature, sampling duration and internal flue dimensions were then used to calculate:-

* the mass rate of solids emission in kg/hr; and
* the solids concentration in mg/m^3.

4.8 Sampling Results

A particulate emission test was carried out, under continuous operating conditions, to assess the emission concentration in the exhaust gases. The sample time of the test was 32 minutes.

At the time of sampling, a particulate matter of 14.2mg/m^3 at reference conditions was measured. It can be concluded, therefore, that the emission from this plant was found to comply with the emission limit currently imposed.

4.9 Comments

On the completion of sampling, the data from the PCME DT 990 continuous emission monitor was interrogated and the average results, which were recorded during the measurement period, noted. A level of 12.4134mg/m3 was obtained together with an existing calibration factor of 6.9221. It can be concluded that the monitor would benefit from an adjustment of the current calibration factor to 7.8905.

Full test data demonstrating procedural compliance with BS ISO 9096 for total particulate monitoring is provided in following sections.

5. SAMPLING RECORDS

5.1 Process Conditions

Arrestment Plant:	Bag Filter
Particulate Type:	Aggregate
Plant Loading:	Continuous - various grades @ 40tph
Appearance of plume	No visible discharge

5.2 Sampling Results

	Test Run No. 1.	
Time of Test:	09.22 - 09.54	
Sampling Duration: (mins)	32	
Gas Temperature (°C)	77	
Mean Velocity at Sampling Points: (m/s)	15.11	
Gas Flow Rate at STP (1): (m^3/min)	429.2	
Particulate Loading at STP (1): (mg/m^3)	14.15	
Particulate at Normalised Conditions (2): (mg/m^3)	-----	-----

(1) Particulate stated at 273K, 101.3kPa without correction for water vapour.

(2) State normalised conditions (eg 11% O_2 etc).

5.3 - Calculations Sample Run No. 1

On-site measurements

O2 = 18.6 % CO2 = 1.3 % N2 = 80.1 %

Bws = 0.05 Ps = 101.5 kPa Ts = 350.0 K

Md = Molecular weight of gas at DGM (g/g mole)

Md = $(0.44 \times \%CO_2) + (0.32 \times \%O_2) + (0.28 \times \%N_2)$

= 28.95 g/g mole

Ms = Molecular weight of gas wet (g/g mole)

= 28.40 g/g mole

Stack gas velocity at sample points

V = Kp x Cp x Ö(Ts.DP/Ps.Ms) Kp = 4.07

= 15.11 m/s DP = 114.3 av. Dp at sample plane

Cp = 1.00 pitot tube coefficient

Stack gas volume at sample points

Q = V x A x 60 A = 0.64 area of stack m^2

= 576.8 m^3/min

Volume of water vapour collected, standard conditions (m^3)

Vwstd = 0.00124 x Vlc Vlc = 26 ml

= 0.03212 m^3

Volume of gas metered, standard conditions (m^3)

$$Vmstd = \frac{2.695 \times Vm \times (Pa + (DH/102)) \times Yd}{(T + Tm)}$$

= 0.63665 m^3

Tm = 19 °C

Vm = 0.5998 m^3

Pa = 101.50 kPa

DH = 42.7 mm H_2O

Yd = 1.128

Moisture content

Bwo = Vwstd/(Vwstd +Vmstd)

= 0.04802

Dry total flow of stack gas, standard conditions (m^3/min)

$$Qstd = \frac{Q \times Ps(2.695)(1 - Bwo)}{Ts + 273}$$

= 429 m^3/min

Ts = 77.0 °C

Ps = 101.5 kPa

Percent isokinetic

$$\%I = \frac{(6.184 \times 10^5)(Ts + 273) \times Vmstd}{Ps \times V \times Aa \times t \times (1-Bwo)}$$

= 104.3 %

Aa = 28.3 area of nozzle m^2

5.3 - Calculations Sample Run No. 1 Cont.

Filter & rinsing weights sample no. 1

weight gain on filters =	9.01	mg
weight of acetone wash =		mg
total weight gain (M) =	9.01	mg

Particulate concentration (mg/m^3)

C = M/Vmstd M = 9.01 mg

= 14.15 mg/m^3

Particulate emission rate (kg/hr)

E = (C x Qstd x 60)/1000

= 0.36 kg/hr

5.4 - Sample Blank

An overall sample blank was taken after the measurement series, following the sampling procedure in the methodology without starting the suction device and keeping the blank in the duct for 15 minutes with the sampling nozzle 180o from the direction of flow. This leads to an estimation of the the dispersion of results related to the whole procedure.

weight gain on filters =	0.00004	mg
weight of acetone wash =		mg
total weight gain (M) =	0.00004	mg

Particulate concentration (mg/m^3)

C = M/Vmstd M = 0.04 mg

= 0.06 mg/m^3

5.5 - On Site Velocity and Flow Data

Company	EXPRESS ASPHALT	Stack Diameter	0.90	m
Site	DOYLE DRIVE	Area	0.64	m^2
Location	ROADSTONE COATING PLANT	Barometric Pressure	101.5	kPa
Job No	302	Stack Pressure	0.01	kPa
Operators	AJY/MJR	Pitot Tube Coefficient	0.997	

Preliminary readings taken before sampling

			Pitot Traverse B	
Pitot Settings	D P pa	Temp °C	D P pa	Temp °C
1	106	77	102	77
2	112	77	108	77
3	114	77	115	77
4	111	77	114	77
5	108	77	111	77
6	106	77	115	77
7	110	77	119	76
8	113	78	120	76
9	115	78	122	76
10	109	77	110	76

av temp (K)=((average temp traverse A+average temp traverse B)/2)+273	350
av press (Pa)=((average press traverse A+average press traverse B)/2)	112

Suitability of sampling positions & Required No. of sample points	Actual Stack Conditions
Permitted highest to lowest pressure range = 9:1	1.2 : 1
Negative pressure	Not permitted
Differential pressure minimum > 5 Pa	102
No. of sampling points	4

5.6 - Sampling Conditions

	Sample Run No. 1		
Sample Position	Stack Temp ^{o}C	Velocity Pressure DP (Pa)	Nozzle Area mm^2
0.15D	77	112	28.3
0.85D	78	115	28.3
0.15D	77	108	28.3
0.85D	76	122	28.3

5.7 - Weighing Results

The below filters and acetone rinsings were weighed on a balance in a temperature

Sample Run No.1.	Ref No.	Weight gms Before	After	Collected	Sample time at each point (mins)	% weight gain
Filter	18	0.05420	0.06321	0.00901	8.0	16.6%
Acetone					0.0	
Total weight = 0.00901						
Sample Blank	Ref No.	Weight gms Before	After	Collected	Sample time at each point (mins)	
Filter	19	0.05464	0.05468	0.00004	n/a	0.1%
Acetone						
Total weight = 0.00004						

5.8 - Main conditions for compliance with BS ISO 9096:2003

The following requirements must be met:

Preliminary Velocity Survey

		Pass	Fail
	No negative flow at sampling points	*	
	Direction of gas flow within 15^{o} of flue axis	*	
	Pitot-static pressure differential greater than 5 Pa (3m/s)	*	
	Ratio of highest to lowest pitot-static readings less than 9:1	*	

Sampling procedure

	Sampling plane was corectly positioned	*	
	Sampling centroids of equal area	*	
	Nozzle was facing upstream to within $\pm$ 10^{o}	*	
	Leak check performed	*	
	Constant 'at' during cumulative sampling	*	

Post Sampling Operations

	Leak test performed	*	
	Isokinetic rate 95 % to 115 %	*	
	Samples achieved stable weights	*	

Note :

A single tick in the "fail" column indicates that this test does not comply with the full provisions of BS ISO 9096:2003. Due to site/sampling locations it is not always practically possible for all the conditions to be met. Best practical means are employed to try and achieve a representative result.