



Trial outcomes - Kiln 6

We are pleased to advise that the results of the feed diversion trials in the Kiln 6 stack at our Munster site have now been shared with the Department of Water and Environmental Regulation (DWER) as part of the Works Approval review and reporting process.

We look forward to sharing the outcomes of the trial with the community in the coming weeks through regular updates on our website and community briefing sessions.



Background



In 2019, we commissioned specialist studies into odour management at our Munster operations, in parallel with investigations required by DWER.

These investigations found that odour was generated in the stacks when the raw material of shellsand, which is sourced from the nearby ocean and used for making lime, was heated between 400°C and 600°C.

By exposing the shellsand to higher temperatures earlier in the process, odour causing substances are destroyed before they are emitted. The modification does not introduce anything new to the process, it just changes the feed location of the shellsand. This is referred to as engineering or feed diversion.

In August 2021, DWER gave approval for Cockburn Cement (CCL) to conduct feed diversion trials to reduce the risk of odour in the Kiln 6 stack at our Munster site, under Works Approval W6533/2021/1. Since then, we have undertaken engineering work to build the required feed diversion infrastructure and conducted engineering trials over the 2022/2023 summer period. Pleasingly, the trial has been successful.

About the trial period

On 30 May 2022, environmental commissioning of the feed diversion commenced and we ran a series of discrete trial periods until the last trial on 28 April 2023. The total time for feed diversion testing during this period was 25.3 days.

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| • Initial trials | 30 May 2022 – 2 November 2022 |
| • Extended commissioning trials | 8 December 2022 – 31 January 2023 |
| • Final trial | 28 April 2023 |

The success of the trials was measured by evaluating the below criteria at different process temperatures:

- The number of odour units recorded in the stack
- The results of independent field odour surveys undertaken in the community
- The number of community complaints about odour



Results of the trials

The results of the trials are positive and show a significant reduction in odour detection and intensity in the community during the testing period.

- Significant reduction in odour units from baseline stack testing results.
- Reduced community complaints received by CCL when Kiln 6 was operating the trial.
- No significant changes to the emissions profile from Kiln 6.
- No process safety concerns
- Demonstrated ability to implement/continue use of the technology by summer 2023/24, pending approval from DWER.

Implementing for long-term improvements

CCL has applied to DWER for approval to use the feed diversion on Kiln 6. This approval from DWER is required to operate the feed diversion and we have requested this approval be provided as soon as possible.

We look forward to sharing more information on this investment into Kiln 6 and thank the community for their feedback.

Learn more at a community information session

We invite you to meet directly with our team to learn more about the feed diversion trial investigations, the findings and next steps.

If you would like more information about the trials, please register your interest in attending a briefing session via our webpage, cockburncementcommunity.com.au, or by contacting the project team on **08 9411 1000**.

It is anticipated that the sessions will be held in October 2023.

Register your interest

More information

Community members can find out more information or provide feedback by contacting our team through the 24/7 community hotline on 1800 156 826 or email community@cockburncement.com.au.

It is important to us that Cockburn Cement information and news is readily available, easy to access, current and informative. Cockburn Cement intends to provide further updates to the community as we begin to implement long term plans at our Munster site.

Cockburn Cement Community

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For further information visit:
www.cockburncementcommunity.com.au

You can speak to a member of the team,
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