

## Boral Cement Berrima 2019 Whole of Community Meeting Notes

Meeting Date:	25 July 2019
Meeting Location:	Joadja Room, Mittagong RSL Club, Bessemer Street, Mittagong
Community Attendees:	<b>John &amp; Beverly George</b> <b>Greg &amp; Leonie Knapman</b> <b>Paul &amp; Angela Jordan</b> <b>John Barrett</b> <b>Leon Gross</b> <b>Heather Edwards</b> <b>Michael &amp; Mandy Eccleston</b> <b>Kelly Wilson</b> <b>Tanya Monck</b> <b>Megan Kain</b> <b>Clive West</b> <b>Sue Wallace</b> <b>Trent Ellison</b>
Boral Attendees:	<b>Dean Beltrame</b> (Acting Operations Manager, Berrima Cement) <b>Greg Johnson</b> (Environment & Sustainability Manager, Boral Cement) <b>Madeline Westnidge</b> (Administration Coordinator, Berrima Cement) <b>Paul Jackson</b> (Stakeholder Relations Manager, Boral Land & Property) <b>(Chair)</b>
Apologies:	Nil
Distribution:	Boral Cement Berrima website ( <a href="http://www.boral.com.au/berrimacement">www.boral.com.au/berrimacement</a> )
Disclaimer:	<i>These notes are taken from presentations and conversations which formed part of this meeting. The content of this document, while reflecting an accurate summary of proceedings, should not be taken to represent <b>exact dialogue</b> unless specifically minuted as such.</i>

Meeting Item	Description
Meeting commenced	18:06
Welcome, administration and safety moment	Chair <b>Paul Jackson</b> welcomed everyone to this third 'Whole of Community' meeting since the Berrima Cement Works' communication and engagement approach was updated, following on from the last session held 6 December.  Attendees from Boral were introduced including <b>Dean Beltrame</b> , the Acting Operations Manager for the Cement Works. Dean agreed to oversee the site following the departure of <b>Stuart Hutchings</b> earlier in the year.  Dean outlined his background of many years with Boral which includes a previous period at Berrima. His most recent position was as the Mine

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Manager at the Marulan South Limestone Mine which provides the Cement Works with its raw limestone feed.

After outlining the agenda for the evening, Paul attended to the administration of the meeting by asking whether there were any matters arising from the WoC meetings of August and December 2018, or the inaugural Community Liaison Group meeting held during June 2019.

At this point a number of attendees made comment about the effects of a dust 'event' that had impacted the New Berrima village at the end of June and during the start of this month.

Paul noted these concerns and assured attendees that information had been prepared for discussion later in the meeting.

No apologies were noted. The group then shared a 'safety moment' - a standard for Boral meetings focussed upon a safety related 'experience' with a view to sharing learnings more widely among attendees.

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Year in Review:  
Operations,  
Production, Safety

Paul invited Dean to overview the 2018-19 financial year at the Cement Works, noting the 'Whole of Community' meetings are so aligned to allow residents an opportunity to hear about and reflect on the past 12 months.

Dean began by highlighting the site's continuing excellent record with safety, the Cement Works recording just two medical treatment injuries (MTIs) during the year.

In terms of personnel, Dean noted a huge shift in the experience of the site had taken place during 2019, with ten people having left the Cement Works with a total of around 180 years' service.

Production has continued along well with around 1.2 million tonnes of cement produced during the year, still driven by the State Government's high infrastructure demands.

Dean also noted the integration of the Solid Waste Derived Fuels (SWDF) system into production during the course of the year, as well as the completion of upgrades on the site's rail infrastructure.

*Questions asked and comments made at this point of the meeting*

- **Question (Q):** *Trucks are starting to use Taylor Avenue in larger volumes due to the presence nearby of larger businesses such as Inghams, the Livestock Exchange and so on. Can these be better managed, and does Boral have any input on this with its contribution of trucks?*

**Response (R):** *Any management of movements along Taylor Avenue is really a Matter for Wingecarribee Council as it is a public road. That said, we try to be conscious of ensuring our logistics do not overly impinge on the community, and we certainly contribute to the upkeep and maintenance of Taylor Avenue through levies.*

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- **Q:** *Has Boral ever considered creating an access down the old railway line to the Old Hume Highway?*  
**R:** *This has come up often in the past but we have no current proposal to do this.*
  - **Q:** *Recently we have seen trucks queuing in the streets. Why has this been happening?*  
**R:** *That is not something we've been aware of and so will investigate further and report back through the Community Liaison Group (CLG). It certainly doesn't make us happy to hear that's been happening as there should be no need for trucks to queue outside our grounds.*
  - **Q:** *What is the rail infrastructure which has been upgraded?*  
**R:** *Most of the work has been track maintenance and replacing old and outdated timber sleepers. We've also been automating some systems in an effort to improve safety.*
  - **Q:** *Are you looking at putting gates in at the level crossing on Berrima Road?*  
**R:** *We've looked at one or two minor improvements for the crossing but with the commencement of work on the rail overpass, the relative expense of signals and the relatively low speeds of the trains at the crossing, we're more likely to wait for the new bridge as a permanent solution to the delays created at the crossing.*
  - **Q:** *Does Boral own the level crossing near Inghams?*  
**R:** *No.*

The meeting then moved on to discussion about the major dust 'event' that took place during the end of June and beginning of July.

Dean explained that over the course of 24 and 25 June, the site received a sudden and unexpected influx of complaints about dust settling on properties and vehicles, particularly from Brisbane and Melbourne Streets.

An investigation was commenced and it was found that dust was being emitted through an exhaust outlet from a dust collector within Cement Mill 6. The outlet was some 12 metres high from ground level.

Further inspection revealed three out of 144 dust collectors (bags in the mill's filtration system designed to capture 'fugitive dust') had failed. These were replaced by 1 July, with the other 141 also replaced by 4 July.

On 5 July, the Cement Works issued a written update to all properties in New Berrima, outlining what had happened and the actions taken as a result. This prompted more contact with the site and more complaints.

As part of rectifying the situation, the Cement Works began issuing vouchers for a local car detailing business, with almost 70 issued by 11 July.

The site reported details of the entire incident to the Environment Protection Authority on 12 July and has been working with them since on corrective

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actions and looking at future mitigation measures.

Dean noted there were extenuating circumstances which led to the delay in first identifying the problem. During the period, New Berrima experienced light rain and low fog as well as brisk southerly winds of around 20 to 22 kilometres an hour.

Combined with the height of the exhaust outlet which placed it out of normal eye level, and the absence of cameras looking at that part of the plant, the dust was virtually undetectable on site.

**Greg Johnson** then ran through a number of initiatives which the site had identified for investigation and implementation as a result of the incident and work with the EPA.

He explained that the fans feeding the dust collectors would be modified and dampeners installed to reduce the risk of premature damage to the bags, while maintenance of the dust collectors would move from 'condition based' (replace when deteriorating) to 'predictive based' (replace once recommended service hours are reached).

Greg also mentioned that the Cement Works' required Air Quality Management Plan (AQMP) would be revised for the inclusion of a 'Trigger Action Response Plan' (TARP).

Instituting a TARP will result in early action being taken to prevent future dust emissions once certain listed conditions, such as unfavourable weather, are met at the site. All employees will be trained in the TARP procedures once developed.

Finally, Greg indicated the site would be obtaining equipment to conduct a feasibility trial of 'real time' air quality monitoring. Implementation of this system would see data about conditions at the monitoring point relayed direct to the Cement Works control room as it happens, allowing preventative action to be taken as needed.

*Questions asked and comments made at this point of the meeting*

- **Comment (C):** *This 'event' has created some real upset in New Berrima. Our local social media forums have been filled with chatter and information or misinformation, our cars, plants and houses are covered in cement dust. People are genuinely concerned, especially about whether their health and safety has been affected by this.*

**R:** *We understand the concern and the inconvenience and have been working hard to take corrective action and 'make good' where we can. Although we were due to have this meeting anyway, the information we're sharing here is meant for all locals with respect to what happened, what we're doing to fix it, and what we're doing to ensure the risk of it happening again is reduced.*

- **Q:** *Why wouldn't you have seen so much dust coming out of your site?*

**R:** *For the reasons we've given. It was just too hard to spot the dust with the colour of the sky and the leakage being out of normal view. We could not have foreseen this incident occurring. Unfortunately in an*

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*environment like the Cement Works, things will unexpectedly fail from time to time.*

- **Q:** *What's the timeframe for implementing the 'real time' monitoring?*

**R:** *The system is Australian made. We expect it'll take two to three months from the confirmation of the order to make.*

- **Q:** *Are you modifying the dust collector fans now?*

**R:** *Yes. We've changed them and the dust collectors are responding well.*

- **Q:** *There are already about six or seven dust monitors around the Cement Works. Will they be upgraded as well?*

**R:** *No as not all of them are 'monitors'. The gravimetric bottles you might be referring to are a tool for compliance, not for proactive preventative measures. Our desire to trial 'real time' monitoring is out of our commitment to decrease the risk of this type of 'event' happening again.*

- **Q:** *You mention the dust was coming out of an outlet 12 metres off the ground, but these monitors will be, what, one or so metres in height?*

**R:** *The 'real time' monitors do have a slight elevation but are designed to measure what 'falls out' of the air at ground level. This reflects the experience you might have if your house or car was being covered with dust. It means we know what's happening when it's happening and can trigger into action to prevent a major issue. If we find we need to install more monitoring points, we'll have a look at that.*

- **Q:** *One of the things affected at my place which you don't offer cleaning vouchers for is my solar panels. We had someone try to clean them and the dust just wouldn't come off. They had no idea what else might work. Is there a different solution to getting solar panels clean than what's used on cars? We've tried vinegar, soapy water – we'd just like some direction on what to try.*

**R:** *After discussion about this with some neighbours, we tried some of the product they use at the car detailer's with limited success. It appears this is a bit of a problem the solar manufacturers don't know much about, so we'll keep looking into what the options are and the once we've narrowed down on the right product or method, we'll communicate that out to residents.*

- **Q:** *You mention monitoring and trigger actions which are good, but why not a second level of mitigation and protection? This stuff is getting into our lungs!*

**R:** *First it needs to be recognised there are multiple potential sources of dust in our area – not all of it comes from the Cement Works. In this instance, the dust definitely was from us and for that we apologise profusely. Our site also has multiple dust potential generation points which we need to focus upon and mitigate. Dust can come from our stack, through vents and doors as it did in this case, from our open stockpiles, from the shale quarry and so on. That's why these initial*

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responses are more broadly focussed.

- **Q:** *What volume of dust is coming out of the stack that it can settle so thickly on our cars and homes?*

**R:** *As discussed, during this most recent event the dust was not coming from the stack but rather an exhaust outlet at the mill. It's actually rare that dust comes from the main stack. Monitoring of the stack looks at the level of particulates in the air as these are potentially far more harmful than the coarse or 'nuisance' dust which has impacted cars and homes.*

- **Q:** *Is the EPA monitoring the situation?*

**R:** *We have regular reporting obligations to the EPA so they are aware of what has been happening, especially since our self-reporting of the 'event' to them. The monitoring data we share through these community meetings and on our website demonstrates that we are constantly collecting information and sharing it not just with authorities, but with the public.*

- **C:** *I spend a lot of time maintaining my car and the car detailer you use will only wash my car clean, not do a polish within the voucher you have offered us. While they do a good job with the washing, it's not quite the whole job.*

**R:** *Noted.*

- **Q:** *One of the things affected at my place which you don't offer cleaning vouchers for is my solar panels. We had someone try to clean them and the dust just wouldn't come off. They had no idea what else might work. Is there a different solution to getting solar panels clean than what's used on cars? We've tried vinegar, soapy water – we'd just like some direction on what to try.*

**R:** *After discussion about this with some neighbours, we tried some of the product they use at the car detailer's with limited success. It appears this is a bit of a problem the solar manufacturers don't know much about, so we'll keep looking into what the options are and the once we've narrowed down on the right product or method, we'll communicate that out to residents.*

- **Q:** *What am I breathing in, though? The Sunday night was especially bad on Argyle and Howard Streets.*

**R:** *As we noted, there are multiple sources of dust around New Berrima, not just the Cement Works. So, while we're putting our hands up for this 'event' as it's undeniable it was us, commenting on what you're 'breathing in' would need to account for what might be coming from us plus what's coming in from surrounding farms, the industries to the east, any distant fires – basically everything captured by our monitoring.*

- **Q:** *Does the EPA audit the Cement Works, either regularly or 'spot'?*

**R:** *As explained, we have regular reporting obligations based upon our monthly monitoring results. We also have to submit what's called an 'annual return' which summarises these results and any which are*

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*reported on a six- or twelve-monthly basis. Every three years we are also subjected to an independent audit. The EPA also 'risk rates' sites like ours and we're currently considered as 'level 1' – not a high risk site. We're obviously proud of this and are striving to maintain that position – issues like this 'dust event' do not help with this objective.*

- **Q:** *The site is turning over \$41 million a year. Surely you can afford to install a second 'bagging' system?*

**R:** *We believe the system we have is very efficient and that on this occasion, we've had an unlucky and unforeseen failure. The replacement of all of the bags combined with the other measures mentioned should see our risk of a repeat failure decreased.*

- **Q:** *How many people do you have at the site?*

**R:** *About 105.*

- **C:** *A second filtration system could be installed and would be costly, but would also greatly assist the site if there was another failure.*

**R:** *Noted.*

- **C:** *How much is Boral spending on finding better solutions?*

**R:** *We're looking for the most sustainable solutions, both environmentally and economically. In order to deliver upon some of these planned commitments, we need to upgrade our technology and that doesn't necessarily happen overnight. In the interim, we're simply trying a few options to help reduce the risk.*

- **C:** *You must understand we have concerns about our health.*

**R:** *We do understand this. As we move into the next section on our environmental performance, you'll see a range of data which leads us to believe that any health risk is very low. We can organise an independent industrial hygienist to attend our next meeting if this will help alleviate concerns.*

- **C:** *On your website and in the information you distribute to customers, you provide a Material Data Safety Sheet (MSDS) which outlines that cement dust can be hazardous.*

**R:** *That is correct and in line with legislated requirements. Our operation is also run to the requirements and limits set in law and monitored by authorities such as the EPA. Generally these limits have been established by their experts and policy makers to fall well within any risk levels of human harm. We have demonstrated ongoing compliance with these requirements at Berrima.*

- **Q:** *Does cement contain silica? Are you on top of that?*

**R:** *Yes, there is a small component of silica in the limestone used to make cement at Berrima. These levels are minute, however, and are factored into production accordingly, We also monitor for silica as part of the overall reporting regime.*

- **Q:** *Do you know what the dust that is dropping all over New Berrima*
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*right now is?*

**R:** *We believe it's what we call 'coarse' or 'nuisance' dust. In terms of particulate size, it's what we refer to as 'PM10' or greater.*

- **Q:** *Can you explain more about the filter bags? Where they are, and how they work?*

**R:** *The filter bags are designed to capture any loose or 'fugitive' dusts within the process. A 'jet stream' forces the dust-laden air through the bags, with particulates caught in the bag material and 'clean' air travelling through. The bags are emptied of the 'dust' regularly, with the dust returned to the process for integration into the cement products we make. Filter bags can be found on all sorts of plant and equipment at the Cement Works. We have 'bag houses' on the limestone precipitator, through the 'clinker' section – all throughout the process. The majority of these points are enclosed.*

- **Q:** *One thing that can also help is the watering of surfaces and planting of trees around the site. Are you still carrying out watering?*

**R:** *Yes. It is industry best practice to water what we call 'hard stand' surfaces to discourage dust generation. We have a water cart operating on our internal roads and we also use road sweeping. There are 'wheel washes' to reduce sediment being tracked out onto public roads. On-site speed limits are low to discourage the generation of dust under vehicle wheels. At our on-site shale quarry and around our stockpile area, we have a rule that loaders must lower, not dump, loads onto trucks to again decrease the risk of dust emissions.*

- **Q:** *Why not plant native trees at the front of the site and revegetate to help screen the dust away from New Berrima?*

**R:** *In recent years we have completed a great degree of tree planting and vegetation around the site in line with our Landscape Management Plan. This was framed for aesthetic and environmental reasons, but also to assist with dust management. We're also considering a proposal from the community to establish 'habitat corridors' along the site's boundaries which indeed may also have a dust management benefit.*

- **C:** *One thing you haven't mentioned is the impact of these alternative fuels you've started burning at site over the last year. I have asthma and it's become worse since you started burning tyres again at the Cement Works. I've read a lot of material online about the experiences of people in the UK living near places that burn tyres and the outcomes are not good for health. What sort of studies have you done on the effects of burning tyres on those around you?*

**R:** *Although the Cement Works has planning approval to use rubber tyre 'chips' as an energy source for the kiln, we have not used them since 2008. So we're not sure what your point is as there's definitely been no use of these materials for more than 10 years.*

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Solid Waste  
Derived Fuels  
(SWDF) update

Dean and Greg then moved into giving an update on the SWDF program and system which has been under construction and began commissioning during the reporting year.

Greg mentioned that the 'Proof of Performance' report required by the Department of Planning and the EPA on the system had been submitted at the end of February.

In response, the authorities had granted the Cement Works authority to continue use of the system, however limited the use of SWDFs to 40 percent of the overall kiln energy fuel mix (originally approved for 50 percent).

Both agencies also increased the regularity of kiln stack testing to quarterly for the first 12 months the system is operated, with quarterly monitoring reports to be submitted to the Department.

Dean then outlined the carbon dioxide savings that had been realised to date through use of the system, with an estimated 13000 tonnes equivalent saved between August 2018 and the end of June.

*Questions asked and comments made at this point of the meeting*

- **Q:** *What do these SWDFs comprise of?*

**R:** *We are using two SWDFs in the kiln at the moment. The first is called Wood Waste Derived Fuel (WWDF) which consists of the leftovers from industries which use wood. This includes wood chipping, furniture making, pallets and similar items. The second is Refuse Derived Fuel (RDF) which uses the combustible elements of construction and demolition waste, such as papers, cardboard, woods, some plastics and so on. Materials for the RDF are carefully selected and processed to required specifications – it's important to note it's not made from any old rubbish which gets thrown into people's wheelie bins or skips.*

- **Q:** *With those sort of elements in the SWDFs, surely there is smoke and smell as a result of burning them? And is the wood treated?*

**R:** *Because the kiln operates at extremely high temperatures (up to 1400°C), the components which would create smoke and odour if they were burned in a backyard fire are basically vaporised. As a result, the risk of smoke and smell is miniscule, as is the emission of hazardous trace elements which we are monitoring for anyway.*

- **Q:** *What is the effect of using SWDFs on the quality of the cement product?*

**R:** *None. The SWDFs are part of the fuel energy system which provides the heat necessary to drive the kiln.*

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Year in Review:  
Environment

Paul then invited Greg to continue on with his overview of the Cement Works' environmental performance for the year.

Greg began by outlining the range of reports and plans which the Cement Works is required to have in place for operations, all of which are available

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via the Berrima website.

Greg also mentioned that extensive noise monitoring had been undertaken around the site during the year and reported upon. The Cement Works remains in compliance with requirements for noise, with two minor actions noted to help further improve noise management.

Attendees were then taken through the results of monitoring for air and water quality throughout the year, with no compliance matters identified.

Finally, Greg highlighted the Cement Works' efforts toward pest animal control, particularly rabbits, tree planting, and reminder residents of their ability to be added to the site's Pollution Incident Response Register.

*Questions asked and comments made at this point of the meeting*

- **Q:** *Why are you monitoring air quality for PM10 and not PM2.5?*

**R:** *Our compliance requirements only need us to monitor for PM10. The feasibility trial for 'real time' monitoring will also include PM2.5.*

- **Q:** *Why are you baiting the rabbits on your site?*

**C:** *The rabbits are leaving their (the Cement Works) site and wrecking the surface of the local oval. They're also digging holes under people's buildings!*

**C:** *Did you know the local Land Services can send people to assist with pest animals on private property?*

**R:** *We'll look into that to see whether that can help us with our efforts to deplete their population.*

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## Planning and Projects

Paul then spoke on behalf of his colleagues at Boral's Land and Property Group to update attendees on various planning applications which have been, or are about to be, made on behalf of the Cement Works.

Approval was received during April for the extension of the SWDF intake shed was approved earlier in the year, with construction now well progressed.

Also during April, consent was granted for the Cement Works to import and store a supply of 'HiCal 50', a coal and bitumen based waste anode material from the Hunter Valley, for use in the kiln's energy system.

As HiCal 50 may only be used while the kiln is in the midst of running, the Cement Works will now seek a planning modification for the material to additionally be used during start-up and shut-down conditions.

The site is also waiting on the outcome of an application to implement 'isotainer' loading activities at the Cement Works. Use of isotainers on rail will have a significant effect on the amount of trucks moving to and from the Cement Works.

Finally, Paul mentioned that applications would be prepared in the coming year to replace or refurbish the water pipeline which connects the Cement Works to the Wingecarribee River, as well for the broadening of the

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'window' that SWDF trucks can be received at the site.

*Questions asked and comments made at this point of the meeting*

- **Q:** *How does the SWDF come to the Cement Works?*  
**R:** *From Sydney, down the motorway by truck.*
- **Q:** *How many trucks are there?*  
**R:** *It currently averages at just over one an hour during the permitted hours for SWDF deliveries.*

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Community and  
General Business

Paul then covered off on community activities for the past year. He started by mentioning that the Community Liaison Group (CLG) required by the Cement Works' planning consent had been re-formed and met for the first time during June.

The three community and one Council representative were named, with the next meeting being held in September. Paul has written to the Department of Planning seeking formal endorsement of the membership.

Images were then shown of some of the variety of community activities supported by the Cement Works during the past year.

Attendees were then asked for items of general business. Several New Berrima residents then took the opportunity of having the new site management in the room to comment that it had appeared the Cement Works has started to 'care' less and less about New Berrima in recent years.

They cited that when an issue arises, it's rare for anyone to come and look at people's affected properties with any swiftness. It was raised that while the Cement Works happily admits that it is meeting standards, to the community simply 'meeting' doesn't appear adequate.

Another resident mentioned that better parking arrangements and perhaps amenities were needed for truck drivers stopping in the village, resulting in drivers sometimes making less than acceptable alternative arrangements.

Dean outlined the facilities available within the Cement Works site for drivers, and highlighted that not all trucks stopping on Taylor Avenue were associated with Boral. With that said, he committed to looking at the issue further.

Another group of residents noted that the standard of care at the Berrima Recreation Hall and Oval had also declined, with the grounds deteriorating, lights broken and mowing not being attended to. Calls to the Cement Works are going unanswered.

Dean again committed to look into this and meet with any affected groups.

There being no further business or comments raised, Paul thanked everyone for their attendance and closed the meeting.

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Next Meeting	July 2020, earlier if special matters require
Meeting Close	20:40

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**Action Items Arising From Meeting**

<b>Action No.</b>	<b>Details</b>	<b>Responsibility</b>	<b>Due</b>
1	Investigate claims heavy vehicles have been queuing in the streets outside the Cement Works and report back to the Community Liaison Group.	Cement Works	Next CLG meeting (Sep 2019)
2	Research cleaning products/methods for removing cement dust off solar panels and publicise to residents once known.	Cement Works	ASAP
3	Arrange for an independent industrial hygienist to present at next WoC meeting on health risks and exposure to coarse and other dusts.	Cement Works	Next WoC meeting (2020)
4	Investigate assistance which can be offered by Local Land Services for the control of rabbits on the Cement Works site.	Cement Works	Ongoing
5	Meet with Berrima Recreation Hall and Oval user groups to revise maintenance and upkeep issues	Cement Works	ASAP