



# Visy Pulp and Paper Tumut CEMS - Exceedance Report

16/08/2024

Reporting Period: 1/07/2024 - 1/08/2024 Environment Protection Licence No: 10232

## Main Stack 1

Monitoring Location No: 1  
 Monitoring Type: Continuous  
 Sample Type: Air  
 Description: Exit point from Stack 1 to atmosphere

| Opacity           |                |                 |                         |  |   |             |
|-------------------|----------------|-----------------|-------------------------|--|---|-------------|
| Period: 6 Minutes |                | Limit: 20.00 %  |                         |  |   |             |
| Start Time        | End Time       | Cause           | Operational State       | Explanation  | Corrective Action   | Max Reading |
| 06/07/24 12:06    | 06/07/24 12:24 | Lime Kiln B ESP | Equipment Issue/Failure | Opacity exceedances caused by high CO spikes tripping the ESP. | Times on exceedances longer than usual, it was discovered this morning ID fan control was running in Auto mode thus the slower reaction time, this control mode should be E1 which will have a quicker response to low O2 in the flue gas, this was corrected this morning. | 56.24       |
| 06/07/24 22:12    | 06/07/24 22:24 | Lime Kiln B ESP | Equipment Issue/Failure | Opacity exceedances caused by high CO spikes tripping the ESP. | Times on exceedances longer than usual, it was discovered this morning ID fan control was running in Auto mode thus the slower reaction time, this control mode should be E1 which will have a quicker response to low O2 in the flue gas, this was corrected this morning. | 65.21       |
|                   |                |                 |                         |  |   |             |

|                |                |                        |   |   |   |       |
|----------------|----------------|------------------------|---|---|---|-------|
| 07/07/24 17:00 | 07/07/24 17:18 | Lime Kiln B ESP        | Equipment Issue/Failure                     | Opacity exceedances caused by high CO spikes tripping the ESP.  | Times on exceedances longer than usual, it was discovered this morning ID fan control was running in Auto mode thus the slower reaction time, this control mode should be E1 which will have a quicker response to low O2 in the flue gas, this was corrected this morning. | 50.95 |
| 10/07/24 08:48 | 10/07/24 09:00 | Recovery Boiler A ESP1 | Equipment Issue/Failure                     | ESP Field 1 tripped   | No apparent fault found, unit was reset and started, ongoing monitoring.  | 30.83 |
| 12/07/24 17:24 | 12/07/24 17:36 | Lime Kiln B            | Lime Kiln B Un Scheduled Start-up/Shut-down | Kiln was shut down due to a large ball forming in the kiln that had to be shot out, causing the exceedance.           | Ball broken up and kiln restarted and stabilized  | 35.79 |
| 12/07/24 23:06 | 12/07/24 23:12 | Lime Kiln B            | Lime Kiln B Un Scheduled Start-up/Shut-down | Kiln had to be stopped again during the night to shoot a ring and some ball formation.                                | Ring and ball cleared; plant restarted and stabilized.  | 23.18 |
| 14/07/24 04:42 | 14/07/24 04:48 | Power Boiler EP        | Equipment Issue/Failure                     | Power Boiler ESP Field 1 tripped due to ash hopper 1 full and blocked in the outlet and shorting out the first field. | Continuously blowing back into hopper outlet and transporting ash also hammering outlet vibration plates to get ash flowing to hopper for removal.  | 22.66 |
| 14/07/24 16:30 | 14/07/24 16:36 | Power Boiler EP        | Equipment Issue/Failure                     | Power Boiler ESP Field 1 tripped due to ash hopper 1 full and blocked in the outlet and shorting out the first field. | Continuously blowing back into hopper outlet and transporting ash also hammering outlet vibration plates to get ash flowing to hopper for removal.  | 27.48 |
| 14/07/24 16:42 | 14/07/24 16:48 | Power Boiler EP        | Equipment Issue/Failure                     | Power Boiler ESP Field 1 tripped due to ash hopper 1 full and blocked in the outlet and shorting out the first field. | Continuously blowing back into hopper outlet and transporting ash also hammering outlet vibration plates to get ash flowing to hopper for removal.  | 21.44 |
| 15/07/24 16:18 | 15/07/24 16:24 | Power Boiler EP        | Equipment Issue/Failure                     | Power Boiler ESP field 1 out of service due to ash buildup in the hopper causing a short in the plates.               | Still working on trying to empty the hopper.  | 20.72 |
| 15/07/24 16:36 | 15/07/24 16:48 | Power Boiler EP        | Equipment Issue/Failure                     | Power Boiler ESP field 1 out of service due to ash buildup in the hopper causing a short in the plates.               | Still working on trying to empty the hopper.  | 22.30 |
| 16/07/24 03:48 | 16/07/24 03:54 | Power Boiler EP        | Equipment Issue/Failure                     | Power Boiler ESP field 1 out of service due to ash buildup in the hopper causing a short in the plates.               | Still working on trying to empty the hopper.  | 20.04 |
| 16/07/24 04:18 | 16/07/24 04:24 | Power Boiler EP        | Equipment Issue/Failure                     | Power Boiler ESP field 1 out of service due to ash buildup in the hopper causing a short in the plates.               | Still working on trying to empty the hopper.  | 26.08 |



|                |                |                        |   |   |   |       |
|----------------|----------------|------------------------|---|---|---|-------|
| 16/07/24 15:54 | 16/07/24 16:00 | Power Boiler EP        | Equipment Issue/Failure                     | ESP Field 1 down due to a short caused by sand buildup in the plates, soot blowing causes the ID fan to increase and disturb the ash causing the exceedance.                              | Soot blowing completed and opacity returned to normal, will have to shut boiler to clean ash hopper on field 1.                   | 24.50 |
| 16/07/24 16:12 | 16/07/24 16:18 | Power Boiler EP        | Equipment Issue/Failure                     | ESP Field 1 down due to a short caused by sand buildup in the plates, soot blowing causes the ID fan to increase and disturb the ash causing the exceedance.                              | Soot blowing completed and opacity returned to normal, will have to shut boiler to clean ash hopper on field 1.                   | 23.89 |
| 18/07/24 02:36 | 18/07/24 02:42 | Lime Kiln A            | Equipment Issue/Failure                     | Process upset caused exceedance.  | Process stabilized and being monitored.   | 28.80 |
| 18/07/24 05:12 | 18/07/24 05:48 | Lime Kiln A            | Equipment Issue/Failure                     | Kiln A Gas was turned off leading to a high CO spike tripping the ESP, the ID fan was not reduced for some time after the ESP was shut down causing the excessive time of the exceedance. | Plant was shut down for maintenance and ID fan should have been reduced accordingly. Will review shut down with persons involved. | 35.46 |
| 18/07/24 06:54 | 18/07/24 07:06 | Recovery Boiler A ESP2 | RB A Scheduled Start-up/Shut-down           | Recovery Boiler A PSD - also had to shut ESP 2 down for maintenance - Replacing rotary feeder gearbox and Replacing Conveyor 709 bearing seal.  | All Maintenance issues resolved, and ESP restarted  | 29.21 |
| 18/07/24 07:18 | 18/07/24 07:24 | Power Boiler EP        | Equipment Issue/Failure                     | Power Boiler ESP field 1 out of service due to ash buildup in the hopper causing a short in the plates.   | Still working on trying to empty the hopper.  | 20.31 |
| 18/07/24 09:06 | 18/07/24 09:12 | Lime Kiln A            | Lime Kiln A Un Scheduled Start-up/Shut-down | ID Fan was stopped and cleaned and when restarted caused the opacity exceedance as the ESP'S was still offline for the shut   | Once the ID fan settled opacity reduced to below exceedance limit.  | 20.81 |
| 18/07/24 16:12 | 18/07/24 16:18 | Power Boiler EP        | Equipment Issue/Failure                     | Power Boiler ESP field 1 out of service due to ash buildup in the hopper causing a short in the plates.   | Still working on trying to empty the hopper.  | 22.89 |
| 19/07/24 03:30 | 19/07/24 03:42 | Power Boiler EP        | Equipment Issue/Failure                     | Power Boiler ESP field 1 out of service due to ash buildup in the hopper causing a short in the plates.   | Still working on trying to empty the hopper.  | 56.68 |
| 19/07/24 04:06 | 19/07/24 04:12 | Power Boiler EP        | Equipment Issue/Failure                     | Power Boiler ESP field 1 out of service due to ash buildup in the hopper causing a short in the plates.   | Still working on trying to empty the hopper.  | 20.30 |
| 20/07/24 05:18 | 20/07/24 05:24 | Power Boiler EP        | Equipment Issue/Failure                     | Power Boiler ESP field 1 out of service due to ash buildup in the hopper causing a short in the plates.   | Still working on trying to empty the hopper.  | 22.04 |
|                |                |                        |   |   |   |       |

|                |                |                 |                         |   |  |       |
|----------------|----------------|-----------------|-------------------------|---|--|-------|
| 20/07/24 05:30 | 20/07/24 05:36 | Power Boiler EP | Equipment Issue/Failure | Power Boiler ESP field 1 out of service due to ash buildup in the hopper causing a short in the plates. | Still working on trying to empty the hopper. | 26.54 |
|----------------|----------------|-----------------|-------------------------|---|--|-------|

| Sulphur Dioxide (SO2) Period: 60 Minutes Limit: 250.00 mg/Nm3 |                |              |                                   |  |  |             |
|---|----------------|--------------|-----------------------------------|--|--|-------------|
| Start Time  | End Time       | Cause        | Operational State                 | Explanation  | Corrective Action  | Max Reading |
| 18/07/24 11:00  | 18/07/24 16:00 | Power Boiler | RB A Scheduled Start-up/Shut-down | NCG / SOG Diverted to the Power Boiler while Recovery Boiler A was on a planned Shut Down. | All repairs done and Gasses diverted back to Recovery Boiler A | 381.83      |

## Main Stack 2

Monitoring Location No: 22  
Monitoring Type: Continuous  
Sample Type: Air  
Description: Exit point from Stack 2 to atmosphere

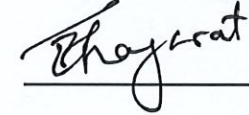
| Opacity Period: 6 Minutes Limit: 20.00 % |                |                             |                       |                  |                   |             |
|--|----------------|-----------------------------|-----------------------|------------------|-------------------|-------------|
| Start Time                               | End Time       | Cause                       | Operational State     | Explanation      | Corrective Action | Max Reading |
| 01/07/24 10:00                           | 01/07/24 10:06 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | n/a               | 22.49       |
| 02/07/24 10:00                           | 02/07/24 10:06 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | n/a               | 22.60       |
| 03/07/24 10:00                           | 03/07/24 10:06 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | n/a               | 24.59       |
| 04/07/24 10:00                           | 04/07/24 10:06 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | n/a               | 23.93       |
| 05/07/24 10:00                           | 05/07/24 10:06 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | N/A               | 24.32       |
| 06/07/24 10:00                           | 06/07/24 10:06 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | N/A               | 22.64       |
| 07/07/24 10:00                           | 07/07/24 10:06 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | N/A               | 23.89       |
| 08/07/24 10:00                           | 08/07/24 10:06 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | n/a               | 24.15       |
| 09/07/24 10:00                           | 09/07/24 10:06 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | n/a               | 24.98       |
| 10/07/24 10:00                           | 10/07/24 10:06 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | N/A               | 24.62       |
| 11/07/24 10:00                           | 11/07/24 10:06 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | n/a               | 24.19       |
| 12/07/24 10:00                           | 12/07/24 10:06 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | n/a               | 24.67       |
| 13/07/24 10:00                           | 13/07/24 10:06 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | n/a               | 20.04       |



|                |                |                             |                       |                  |     |       |
|----------------|----------------|-----------------------------|-----------------------|------------------|-----|-------|
| 15/07/24 10:00 | 15/07/24 10:06 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | n/a | 22.25 |
| 17/07/24 09:54 | 17/07/24 10:00 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | n/a | 22.10 |
| 18/07/24 09:54 | 18/07/24 10:00 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | n/a | 20.75 |
| 20/07/24 09:54 | 20/07/24 10:00 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | n/a | 23.61 |
| 23/07/24 10:18 | 23/07/24 10:24 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | n/a | 24.75 |
| 24/07/24 10:18 | 24/07/24 10:24 | Auto Zero Span Verification | Normal (Steady State) | Auto calibration | N/A | 23.17 |
| 25/07/24 10:18 | 25/07/24 10:24 | Auto Zero Span Verification | Normal (Steady State) | Auto calibration | N/A | 22.65 |
| 26/07/24 10:18 | 26/07/24 10:24 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | n/a | 22.95 |
| 27/07/24 10:18 | 27/07/24 10:24 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | n/a | 22.98 |
| 28/07/24 10:18 | 28/07/24 10:24 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | n/a | 24.50 |
| 29/07/24 10:18 | 29/07/24 10:24 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | n/a | 23.58 |
| 30/07/24 10:18 | 30/07/24 10:24 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | n/a | 22.77 |
| 31/07/24 10:18 | 31/07/24 10:24 | Auto Zero Span Verification | Normal (Steady State) | Auto Calibration | n/a | 20.51 |

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