



Description:	Emergency Plan		
Ref: EMS 8.2	Issue No: 2	Issue date	15/11/19
Prepared by:	Daniel Westow	Page 1 of 3	
Approved by:	Dave Smyth	Amendments	Removed SLT member

1. Purpose

To prevent or mitigate any Environmental Impacts if an Emergency Situation arises at Konings Juices and Drinks Boxford.

2. References

Boxford – Emergency Preparedness Plan
Spill Response Procedure

Commented [DW1]: Make sure this response and the e-prep plans match.

3. Possible Emergency Situations

Oil Storage, damaged Tank resulting in a very large volume spill with a high risk of contamination via land and water. Oil in tank catches fire resulting in a high risk of contamination via air. Contamination also from the measures used to control and extinguish the fire.

Chemical Storage, large volume spill with a high risk of contamination via water and land. An explosion involving stored chemicals with a high risk of contamination via air land and water.

Ammonia Chillers

A large leak from the ammonia chillers would result in contamination into the air.

Transport, a multi vehicle accident with a high risk of diesel, oil spills and fire using pathways of air, water and land.

Juice Storage, a large volume spill with a high risk of contamination via the land and water and into the stream or lagoon.

Cooling towers, legionella growth in the cooling towers and release in to the air could cause widespread illness to susceptible individuals.

Drainage, If there is a breach in the drains raw waste from the factory could enter the stream or lagoon and contaminate both land and water.



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Caustic delivery by tanker. If there was a leak in the delivery hose this could leak to storm drain and contaminate the lagoon.

To control and mitigate the above emergency situations:

- Konings staff will be trained in chemical handling and the correct PPE to wear when dealing with chemicals.
- Staff will also be given spill training for oil and chemicals
- Personnel dealing with the cooling towers will receive legionella training.
- All environmental incidents and corrective action requests will be reported via near miss report.

Emergency Situations

In an emergency situation involving fire, explosion or where people are at risk or injured:

- Sound the fire alarm, follow the fire drill and evacuate the building.
- Call the emergency services – note ensure you tell the fire services we are Konings at Leavenheath.
- Phone the senior managers if none are on site.
- Do not enter the building or try to deal with the situation
- Remain calm and wait in a safe area.

Environmental Emergencies

In the event of a spill of oil, juice or chemical:

- Inform the WWTP Utilities engineer, the Site Health, Safety, Sustainability & Environment Specialist, FLM or Key Operator.
- Put on the appropriate PPE
- Use spill kit to soak up the liquid
- Use drain covers to protect the water drains
- Fit drain bungs stored at WWTP and Filling Hall into drain line to stop flow
- Alert the laboratory as to how much liquid and what will be entering the effluent plant.
- If the liquid from the spill is entering the lagoon, monitor the lagoon.
- All details of the incident must be entered onto an Incident Report.



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- Generate near miss as necessary
- In the event of an oil spill inform the Engineers to lift the drain covers and check the **oil interceptors**.

Commented [DW2]: We need a PM for this

Clean up

All adsorbent granules, pads and booms used for spill soak up etc; are to be treated as hazardous waste and bagged or placed in labelled bins to be stored on the hard standing area for disposal.

Corrective Actions

All incidents and emergencies will be investigated and corrective actions and preventative measures put in place.

Communication

On site contacts in hours and out of hours
Phil Clark - 07968376805
Dave Smyth - 07766492127
Sam Conning - 07884234449
Mark Hamblion - 07785762971
Daniel Westow - 07810832561

Environment Agency 24 hour emergency line: 0800 807060

WASTE MANAGEMENT REGISTER - EMSW4

EA Code	Description	Where is it created?	How is it collected/handled?	How is it segregated?	How is it stored?	Where is it stored?	Who is it transferred to?	What records are held?	Waste Carriers Reg. No.	Registration Date	Expiry Date
150106	Mixed recycling (Paper, card, plastic bottles, flexible plastics, cans, tins)	Various Locations	Recycling Bins	Mixed with mixed recycling	Bin	Various Locations	Biffa waste services Ltd	Duty of Care Certificate	CBDU104360	24/04/2019	23/05/2022
o20705	WWTP/Sludge	WWTP	Held in the WWTP	-	WWTP	WWTP	A A Turner tankers Ltd	Waste transfer notes	CBDU237630	11/05/2018	11/05/2021
200301	General waste	Various locations	Bins	N/A	Bin	Various Locations	CSH Environmental	Duty of Care Certificate	CBDU29520	04/03/2019	02/04/2022
200301	General waste	Various locations	Bins	N/A	Bin	Various Locations	Biffa waste services Ltd	Duty of Care Certificate	CBDU104360	24/04/2019	23/05/2022
18104	Sanitary	Toilets	Sanitary bins	Dedicated bin	Bin	Various Locations	Sterling washroom services	Waste Transfer note	CBDU46556	20/09/2018	27/11/2021
200121	Fluorescent Tubes	Old lighting		Dedicated bin	Bin	Stationary Cupboard	CSH Environmental	Duty of Care Certificate	CBDU29520	04/03/2019	02/04/2022
200134	Batteries	Various locations	Battery bin	Dedicated bin	Bin	Engineering workshop	ACM Environmental PLC	Duty of Care Certificate	CBDU42580	02/10/2018	13/11/2021
80317	Toner Cartridges	Various Locations	Recycling box	Dedicated recycling box	Bin	Stationary Cupboard	Office IS	Waste Transfer Note	CBDU119303	18/07/2019	21/07/2022
	Pommace	Press Room	Collected in the bulker	-	Bulker	Yard	Boxford and Suffolk Farms	Surplus Food Movement Note			
101111	Glass	Lab, Engineering	Stored in glass bins	Dedicated bin	Bin	Engineering/Lab/Bin by weighbridge	CSH Environmental	Duty of Care Certificate	CBDU29520	04/03/2019	02/04/2022
200136	WEEE	Various	Put in the WEEE skip	Seperated after use	Bin	Goods in canopy	CSH Environmental	Duty of Care Certificate	CBDU29520	04/03/2019	02/04/2022
170407	Metal	Various	Put in the metal skip	Serparated at use	Skip	Yard	CSH Environmental	Duty of Care Certificate	CBDU29520	04/03/2019	02/04/2022
170201	Wood	Various	It is put in the wood skip	Serparated at use	Skip	Yard	CSH Environmental	Duty of Care Certificate	CBDU29520	04/03/2019	02/04/2022
Various	Hazardous Waste	Various locations	It is collected at location when it is created.	Each waste stream is stored seperately	Bins, IBC's	Chemical store in yard	Wastecare	Hazardous waste consignment note.	CBDU84992	29/01/2019	13/02/2022
Various	Hazardous Waste	Various locations	It is collected at location when it is created.	Each waste stream is stored seperately	Bins, IBC's	Chemical store in yard	ACM Environmental PLC	Hazardous waste consignment note.	CBDU42580	02/10/2018	13/11/2021
130507	Oil interceptor waste	Drains	Oil interceptors	Oil interceptors	Oil interceptor tanks	Drain pits	A A Turner tankers Ltd	Waste transfer notes	CBDU237630	11/05/2018	11/05/2021
130507	Oil interceptor waste	Drains	Oil interceptors	Oil interceptors	Oil interceptor tanks	Drain pits	Binder	Hazardous waste consignment note.	CBDU93441	08/03/2019	13/04/2022
150101	Cardboard boxes	Dry goods	Collected on pallets	Seperated at use	Pallets	Dry goods area	Saddlers	Waste Transfer Note	CBDU102023	30/04/2019	03/06/2022
o20701	Out of spec apples	Apple Handling	Bins	Seperated at use	Bulker	Yard	Stennetts	Waste Transfer Note	CBDU279365	08/03/2019	08/03/2022
o20704	Pressed apple cake	Squeerer unit	Bins	Seperated at use	Bulker	Yard	CSH Environmental	Duty of Care Certificate	CBDU29520	04/03/2019	02/04/2022
200304	Human Effluent	Toilets	Drains	n/a	Pit by Klargestor	Pit	Binder	Hazardous waste consignment note.	CBDU93441	08/03/2019	13/04/2022
140601	HFC/CFC	Air conditioning	Contractor	n/a	Air conditioning	Removed from site by contractor	2F	Hazardous waste consignment note.	CBDU121082	08/07/2019	29/07/2022
200201	Grass cuttings etc	Yard	Contractor	n/a	Bags/Bins	Removed from site by contractor	Envirocare grounds maintenance	Waste transfer note	CBDU327187	22/02/2017	24/02/2023
Various	Hazardous Waste	Ammonia room	Contractor	Storage container	IBC/Drum	Removed from site by contractor	Air-Conditioning refrigeration tech ltd	Hazardous waste consignment note.	CBDU298523	19/07/2019	19/07/2022
130507	Waste Oil	Engineering	Contractor	n/a	In machine	Removed from site by contractor	Safety Kleen	Waste transfer note	CBDU89939	12/03/2019	04/04/2022
Various	Hazardous waste	Various locations	Contractor	Seperated and stored after use	IBC/Drum	Removed from site by contractor	Labwaste Ltd	Hazardous waste consignment note.	CBDU342084	23/06/2020	23/06/2023
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Records

Waste Transfer Note

Consignment Note

Duty of Care Certificate

Surplus Food Movement Note



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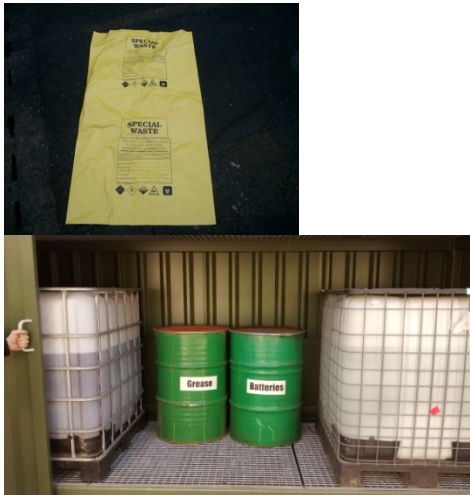
WHY WE HAVE THIS S.W.P: *To enable personnel to deal safely and efficiently with various types of spills in the workplace with no risk to the environment.*

PPE – *To be decided by risk assessment, at a minimum chemical gloves and eye protection must be worn. If you are unsure what the spill is full chemical PPE including chemical suit, boots, gloves and face shield to be worn.*

Boxford SWP Reference: - ESWP1

ONLY COMPETENT INDIVIDUALS ARE PERMITTED TO PERFORM THIS TASK
DO NOT ATTEMPT TO REMOVE THE SPILL UNLESS YOU ARE CONFIDENT TO DO SO SAFELY WITH NO RISK TO THE ENVIRONMENT.

Key Safe Behaviour / Safe Conditions	Notes
<p>1 In the event of a spillage, locate your nearest chemical spill kit which is clearly marked.</p>	<p>These are situated,</p> <p>External: - WWTP, Caustic tanker fill point, loading dock, chemical storage area. Granules are stored at the hard stand.</p> <p>Internal: - Electric fork truck charging stations, press room under stairs.</p>
<p>2 Remove contents of kit as required. Remember to <u>put on all your PPE</u>. Use hazard tape to fence off the area.</p> <p>*Isolate the source of the spill to stop further spillage developing.</p>	<p>This consists of: absorbent pads, booms, loose fill cushions, chemical gloves, barrier tape, hazardous waste bags.</p> 
<p>3 If necessary, deploy booms to contain spillage.</p> <p>Ensure none of the spill enters the drains network.</p>	<p>These may be tied together using the strings at each end. If it is not possible to tie them together they should be overlapped by at least 8cms.</p> 

<p>4 The loose fill cushions can be utilised to block drains and gullies.</p>	
<p>5 The absorbent pads may be utilised by either loose scattering over surface spillage or for wiping down. Remember to use chemical gloves supplied.</p>	
<p>6 After use all contaminated absorbent materials should be deposited in the polythene bag supplied and secured using the cable tie.</p>	<p>The bag should be marked “Hazardous Material” with the spill liquid identified. The waste bag must be stored in the waste container at the chemical store.</p> 
<p>7 In the event of a spillage the Shift FLM and Health, Safety, Sustainability and Environment Specialist should be informed.</p>	
<p>8 The first person at the scene of a spillage will complete a ‘Near miss Report’ on My-Compliance and inform the FLM/KO.</p>	
<p>9 Ensure the spill kit is replenished immediately after use.</p>	<p>Inform the Health, Safety, Sustainability and Environment Specialist if we are running low on supplies.</p>

		Controlled Doc Reference	ESWP1
Written By	D Westow	Date	31/08/18
Reviewed By	D. Westow	Date	25/02/21
Updated By	D. Westow	Date	25/02/21
Approved By	D. Smyth	Date	25/02/21

Report No.	UT-AI-2358-001
Request/P.O. No.	
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ULTRASONIC INSPECTION REPORT

Client & Address: Crown Oils Ltd @ Konings Juices, Sudbury, CO10 5AF		Procedure No: UT05 Issue 2	
		Ref. Standard: BS EN ISO 16809:2019	
		Acc. Standard: Factual	
		Visual Condition: Painted, Acceptable	
Location: As Above	Material: Carbon steel	Heat Treatment: PRE: No	
Date Received: 12/08/20	Thickness: 5-6mm	Heat Treatment: Post: No	
Date Tested: 13/08/20	Weld Type: N/A		
Test Equipment: USM Go+ / 19020054	Compression Probe Ref Level: 2nd BWE to 100% FSH		
Calibration Block: C/S Step wedge	Serial No: 55849		
Couplant: Fluxo US-1	Batch No: L180420-002	Exp Date: 20.04.2023	
Reference Block: N/A	Transfer Correction: 0dB		
Probe Used:	96334		
Angle:	0°		
Size:	10mm		
Frequency:	5mHz		
Sensitivity:	38db		

Inspection Details

Project:

External Ultrasonic thickness survey was carried out on a self-bunded 40,000 litre fuel tank. The survey consisted of min-max thickness readings at cardinal points to the bund where accessible, min-max thickness readings at directional quadrants on the roof and all nozzles and manways.

Restrictions: There was no access to the internals via the roof manway (N2) so the only readings for the inner wall were spot readings through the lower manway (N1). Ladder access only to UT2 and UT3 at South and East.

Minor paint loss and minor surface corrosion to shell and roof cone.

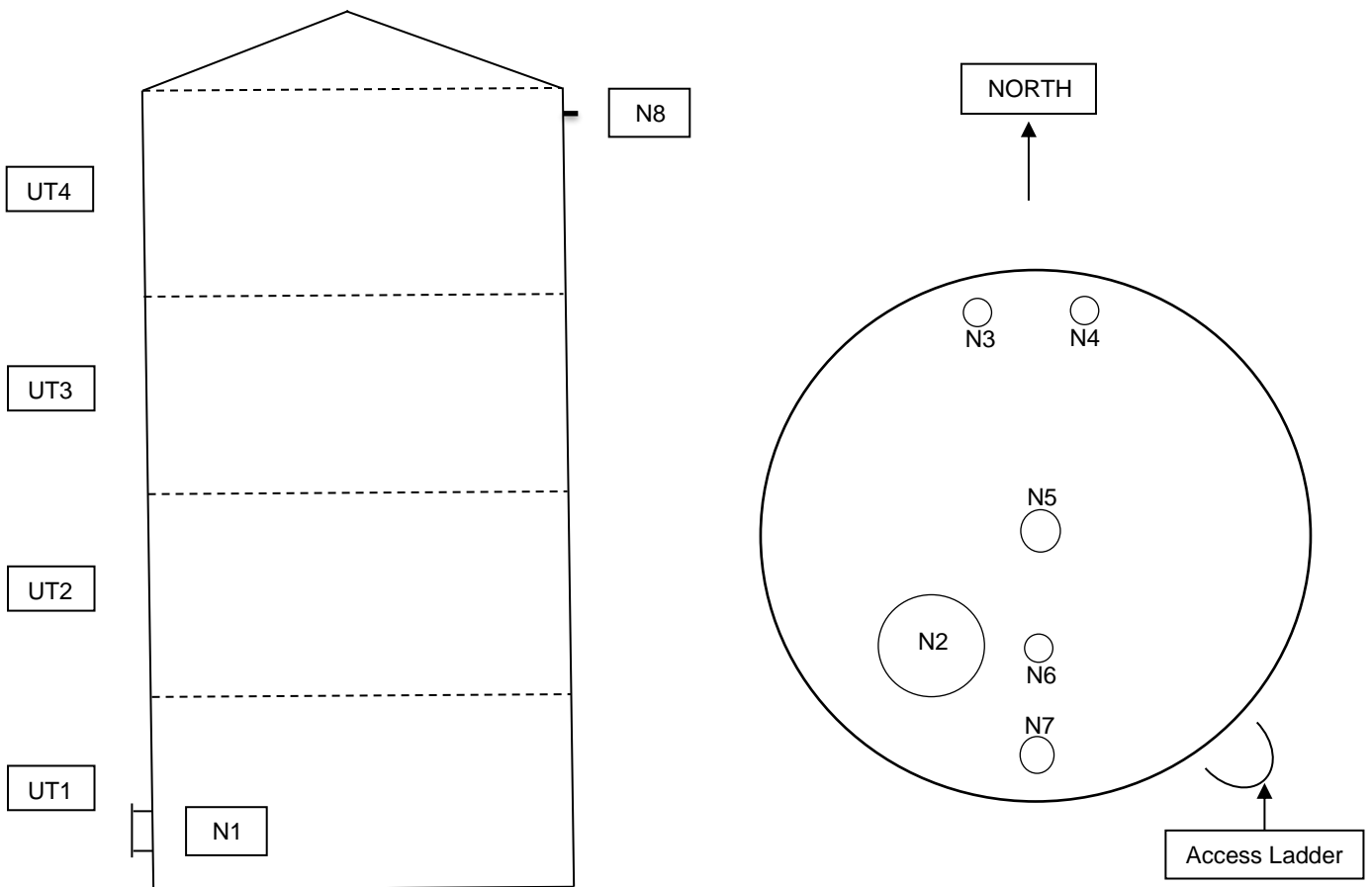
See results table below.

All Readings In mm
Lowest Reading: 5.2
NR=No Reading

Alliance

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	North to East		East to South		South to West		West to North	
	Min	Max	Min	Max	Min	Max	Min	Max
Roof Cone	6.2	6.4	6.0	6.3	6.1	6.4	6.1	6.4
Floor	No Access							
Inner Wall	Spot readings through lower manway only				6.5	6.6	6.6	6.6

	Min	Max	Size	Comments
N1	5.1	5.4	22"	Lower Manway – 100mm of Shell readings around manway 5.2 – 5.4
N2	5.2	5.4	22"	Roof Manway
N3	3.8	3.9	2"	Feed Pipework
N4	3.5	3.7	1.5"	Feed Pipework
N5	5.1	5.3	3"	Feed Pipework
N6	3.8	3.9	2"	Probe
N7	5.0	5.2	2.5"	Feed Pipework
N8	NR	NR	1"	Overflow – 100mm of Shell readings around overflow 5.3 – 5.4

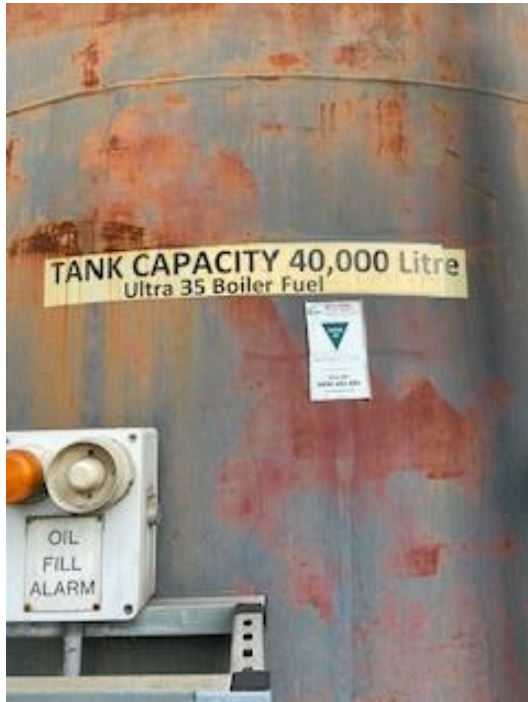
	North		South		East		West	
	Min	Max	Min	Max	Min	Max	Min	Max
UT1	5.2	5.5	5.3	5.5	5.3	5.6	5.2	5.4
UT2	5.3	5.5	5.3	5.5	5.2	5.4	No Access	No Access
UT3	No Access	No Access	5.2	5.5	5.2	5.5	No Access	No Access
UT4	5.2	5.5	5.2	5.4	5.2	5.4	5.2	5.5



Alliance

INSPECTION

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Showing info and bund surface condition.



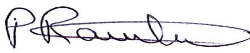
Showing roof nozzles and top manway N2.



Showing N1 and only access to inner wall



Showing inner wall surface condition.

Alliance Inspection Representative:	Client Representative:
Signed: 	Signed:
Name: Paul Rawlings PCN 2 307856	Name:
Date: 17/08/2020	Date:

Storage arrangements – Konings Juices and Drinks – Boxford

Raw Materials

Number	Description	How it is stored
1	Apple intake – Apple storage	Apples are stored in trailer units before they are conveyed into the factory. The drains around this area go to the WWTP.
2	Frozen drum storage	Frozen drums are stored in the cold store before being processed.
3	Liquid flavourings	The liquid flavourings are stored in bunded fireproof Denios storage containers.
4	Processed juice storage	Juice is stored in final tanks before it is sent to be bottled. The drains in this area go to the WWTP.
5	Packaging consumables	Plastic preforms, film & labels is stored in the dry goods warehouse in racking.
6	Finished goods	Palletised finished goods are stored in the cold store until they are collected.

Chemicals & Oil

Number	Description	How it is stored
7	Diesel tank	10586L Storage tank on bunded hardstand
8	Oil tank	45000L Double skinned tank. Ultrasonic instrument is fitted to provide low level, high level and overfill alarms.
9	Ammonia compressors	2 x 97Kg charge in each compressor
10	Glycol storage tank	Tank in the 1 st floor of the utilities block. The drains go to the WWTP.
11	Liquid nitrogen storage	6000L stored in a tank. The system will automatically vent at 16 bar.
12	WWTP chemical storage	Bunded IBC storage
13	Chemical storage area	IBC's and drums stored in Denios chemical storage containers.
14	Nitrogen & PAA IBC	IBC's are kept on bunds inside a small housing.
15	Caustic Tank	5500L Double skinned caustic tank. Internal drains go to the WWTP.
16	Line 2 CIP set	Chemical IBS's are stored on individual bunds
17	Oil store	Storage container for various oil. Stored in fireproof chemical container.
18	Hydraulic Presses	Oil stored in hydraulic system. Drip trays are located at the back of the presses. All the drains go to the WWTP.
19	BBM Compressor glycol	IBC stored on a bund
20	BBM Hydraulics	Hydraulic oil used on BBM system.
21	Crop residue tank	Stored in a 20000L tank. Tank is on a bunded area. Any leaks go to the WWTP.
22	PAA & Sodium hydroxide	IBC's stored on bunds
23	Bulk LPG storage	12 X underground storage bullets.
24	FLT LPG storage	1 x LPG bullet

Waste

Number	Description	How it is stored
25	Biffa mixed recycling skips	Mixed recycling is stored in red Biffa skips.
26	Cardboard storage	Cardboard is stored under the dry goods canopy until it is sent to be reused/recycled.
27	Pallet storage	Pallets are stored here until they are used/returned.
28	Waste chemical storage	IBC's and waste chemicals are stored in a bunded chemical container before they are disposed of.
29	Wood, Metal, and general waste skip.	Waste skips are kept on the hard stand area.
30	Klargester	Underground Klargester, solids are removed by a 3 rd party, liquids are sent to the WWTP.
31	Sump pit	10m ³ Pit
32	Sludge Tank	400m ³ Tank
33	Aeration Tank 1	1200m ³ Tank
34	Aeration Tank 2	650m ³ Tank
35	Balance Tank	170m ³ Tank
36	Cake Skip	Skip used to collect squeezed solids from the WWTP

Staff are trained in dealing with spills. We also have an environmental safe working practice (ESWP1) which is included in our Emergency preparedness plan.

Once the spills have been cleared any liquids/materials collected are stored securely and sent for disposal as hazardous waste.

