

FINAL REPORT

Solid Waste & Waste Water Management Plan for Expansion of the Briens Road, Northmead Bottling Plant

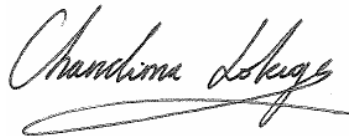
Prepared for
Coca-Cola Amatil (Aust) Pty Ltd
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Executive Summary

This Solid Waste and Waste Water Management Plan (WMP) relates to the proposed development for Coca-Cola Amatil (Aust) Pty Ltd at their Northmead Bottling Plant and Distribution Centre, 102-128 Briens Road, Northmead NSW.

The project comprises of Solid Waste Management issues associated with:

- Demolition;
- Site preparation works including excavation and bulk earthworks;
- Construction and use of a new 32 metre high automated high-bay warehouse and associated conventional height staging area;
- Adaptation of an existing warehouse to accommodate three new production lines and manufacturing services including boiler, refrigeration plant and compressor;
- Construction and use of a new building to house a canteen, offices and training facilities;
- Construction of a new gatehouse and driver amenities;
- Upgrading of the on-site storm-water drainage system;
- Implementation of access and traffic circulation improvements, including parking and new entrances; and
- Site landscaping.

The WMP covers the demolition, excavation, construction and operational solid and waste water generation and management phases and has been prepared in accordance with the requirements of Parramatta City Council (waste management plan) where applicable, Environmental guidelines – assessment and classification and management of liquid and non-liquid wastes (DEC), NSW Government's Waste Avoidance and Resource Recovery (WARR) Strategy (DEC) and Coca-Cola Amatil's (CCA) Environmental Management System (EMS) as it pertains to waste management and recycling.

Preliminary estimates of solid waste generation and recycling targets for each phase are listed below:

Phase	Solid Waste Generated	Comments
Demolition	~6,940m ³	• Recyclable secondary resource material: (i.e. > 90% recovered)
Excavation	Quantities not determined at this stage	• Recycling or reuse • Vegetation for composting • Excavated clean fill for reuse on site

Executive Summary

Phase	Solid Waste Generated	Comments
Construction	~705m ³	• High level of recycling • Waste management aspects to be incorporated into the modular building system and high bay stacking system. • Minimum wastage with steel structure, panelling, cladding and roofing systems. • Some concrete and formwork wastage. • Large quantities of packaging materials for recycling • Returnable packaging and pallets
Operational	1,250 tonnes per annum	• High level of recycling currently undertaken at the site • Additional waste quantities to be incorporated in to existing EMS • Site greenwaste separate to maximise off-site recycling

The Waste Water Management issues associated with the project comprise of:

- Liquids from product destruction; and
- Waste water treatment.

Preliminary estimates of waste water generation are listed below:

Activity	Quantities Generated	Comments
Product destruction	26,000L/annum by 2015	• Increase by 45% by 2015 in line with the proposed increase in production
Waste water treatment	211ML/annum by 2015	• Increase by 11% to 2015

1.1 Introduction

Coca-Cola Amatil (Aust) Pty Ltd (CCA) is proposing to expand its facility at Briens Road, Northmead. As part of this project a Project Application is being submitted to the Minister for Planning under Part 3A (Major Projects) of the Environmental Planning and Assessment Act (EP&A). The Department of Planning (DoP) has issued the Director General's requirements (DGR) for the project and has identified, amongst other matters, Waste is a key issue for consideration in this application.

1.2 Scope of Works

This Solid Waste and Waste Water Management Plan (WMP) has been prepared in accordance with:

- The requirements of Parramatta City Council (waste management plan) where applicable;
- Environmental guidelines – assessment and classification and management of liquid and non-liquid wastes (DEC);
- NSW Government's Waste Avoidance and Resource Recovery (WARR) Strategy (DEC); and
- CCA's Environmental Management System as it pertains to waste management and recycling.

1.3 Site Address

Coca-Cola Amatil (Aust) Pty Ltd, Northmead Bottling Plant and Distribution Centre,
102-128 Briens Road, Northmead NSW.

1.4 Existing Licences (Solid Wastes and Waste Water)

The site and its activities are covered by Environment Protection Licence (Number 2911), issued under Section 55 Protection of the Environment Operations Act 1997. The licence permits no more than 10 tonnes per year of Group A wastes (waste oil/water, hydrocarbons/water mixtures or emulsions (J120)) being generated and stored at the premises.

The site has an Industrial Trade Wastewater Agreement Licence No.: 23086 with an expiry date: of 22 December 2007.

1.5 Brief description of Proposal

The project comprises of Solid Waste and Waste Water Management issues associated with:

- Demolition;

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- Site preparation works including excavation and bulk earthworks;
 - Construction and use of a new 32 metre high automated high-bay warehouse and associated conventional height staging area;
 - Adaptation of an existing warehouse to accommodate three new production lines and manufacturing services including boiler, refrigeration plant and compressor;
 - Construction and use of a new building to house a canteen, offices and training facilities;
 - Construction of a new gatehouse and driver amenities;
 - Upgrading of the on-site storm-water drainage system;
 - Implementation of access and traffic circulation improvements, including parking and new entrances; and
 - Site landscaping.

1.6 Overview of Proposed Solid Waste Management Activities

Demolition

- The following will be demolished as part of the works for this application:
 - Existing gatehouse;
 - Approximately 1,050m² from the south of the existing warehouse and the adjoining existing truck dock structure including a portion of the external east wall;
 - Approximately 200m² of south west corner of the existing warehouse building to provide for improved vehicle circulation;
 - The single storey building located on 104 Briens Road accommodating CCA finance and equipment services; and
 - The rear portion of the single storey building located on 120 Briens Road accommodating toilet and storage facilities.

Excavation

- Vegetation stockpiled for shredding and off site removal to composting facility; and
- Excavated clean fill reused on site.

Construction

- Construction of the following facilities will occur in five stages:
 - Stages 1 and 5 – Adaptation of the existing warehouse to accommodate three new production lines and manufacturing services including boiler, refrigeration plant and compressor;
 - Stage 2 – New 32 metre high and 128 metre long automated high-bay warehouse;
 - Stage 3 – New building to house a canteen, offices and training facilities;
 - Stage 4 – New gatehouse and driver amenities, upgrading of the on-site storm-water drainage system and new road construction for improved traffic access, circulation, parking and new entrances as well as site landscaping.

Operational

- No additional functions will be included in the proposed development from those already existing on the site currently. Additional waste and recycling will be generated by the development that will be managed within the existing waste management systems currently servicing the site.

1.7 Overview of Proposed Waste Water Management Activities

- Continuation with product destruction activities as currently occurring on-site; and
- Increase in throughput of waste water treatment plant located on site with subsequent increase in discharge to sewer and increase in sludges for removal off-site.

Demolition Waste

SECTION 2

DEMOLITION PHASE:			DESTINATION		
MATERIALS ON SITE			REUSE AND RECYCLING		DISPOSAL
Type of Materials	Estimated Vol. (m ³)	Wt. (T)	ON-SITE Specify proposed reuse or on-site recycling methods	OFF-SITE Specify contractor and recycling outlet	Specify contractor and landfill site
DEMOLITION	Total: ~ 6,940m ³		Off site recyclable secondary resource material: 80%		
Metal	265		Separate into stockpiles on site	Send to metal recycler	To be determined & advised
Timber	225	-	Separate into stockpiles on site	Strip out salvage and stockpile for landfill	To be determined & advised
Brick, tile, concrete & masonry	3260	-	Separate into stockpiles on site	Send to masonry recycler	To be determined & advised
Bitumen & Base course	2790	-	Separate into stockpiles on site	Stockpile and send to masonry/bitumen recycler	To be determined & advised
Asbestos	200	-	To be removed in accordance with the Code of Practice for the Safe Removal of Asbestos [NOHSC:2002(2005)]	To be removed in accordance with the Code of Practice for the Safe Removal of Asbestos [NOHSC:2002(2005)]	Appropriately licensed landfill
Mixed Waste	200	-	Separate into stockpiles on site	Stockpile for landfill	To be determined & advised
Comments:	Note: Volumes are preliminary estimates only, based on material volumes not materials plus airspace normally seen in waste skips				

Excavation Waste

SECTION 3

EXCAVATION PHASE:			DESTINATION		
MATERIALS ON SITE			REUSE AND RECYCLING		
	Estimated		ON-SITE	OFF-SITE	DISPOSAL
Type of Materials	Vol. (m³)	Wt. (T)	Specify proposed reuse or on-site recycling methods	Specify contractor and recycling outlet	Specify contractor and landfill site
EXCAVATION			Reusable secondary resource material: 90% *Excavation Contractor not finalized		
Vegetation	Quantities not determined at this stage		Stockpile for shredding	Send off-site for composting	Compost
Excavation: • Excavated clean fill	Quantities not determined at this stage		Stockpile for reuse (Material will be spread during bulk earthworks)	No surplus	No disposal
Total: Quantities not determined at this stage					

Construction Waste

SECTION 4

CONSTRUCTION PHASE:			DESTINATION		
MATERIALS ON SITE			REUSE AND RECYCLING		DISPOSAL
Type of Materials	ESTIMATED Vol. (m ³)	Wt. (T)	ON-SITE Specify proposed reuse or on-site recycling methods	OFF-SITE Specify contractor and recycling outlet	Specify contractor and landfill site
CONSTRUCTION	~ 705m ³		Off site recyclable secondary resource material: 70%		* Contractor not selected
Metals	55	-	Separate to a designated bin	Transfer to a metal recycle	Recycle
Timber	80	-	Separate to a designated bin	As above	Recycle or landfill to be advised
Concrete/Masonry	150	-	Separate to a designated bin	Transfer to a masonry recycler	Recycle
Packaging	300	-	Separate to a designated compound	Transfer to paper/cardboard and plastic recycler	Recycle
Mixed Waste	120	-	Separate to a designated bin	As above except to landfill	Landfill to be advised
Structure: Metal & Masonry plus Mixed Waste Fit out/Interior: Cardboard packaging, Metal, Electrical cabling plus Mixed Waste The waste management aspects of the project will be incorporated into the modular and repetitive nature of the building system. Minimum wastage will occur with the steel structure, panelling, cladding and roofing systems. There will be some concrete and formwork wastage. The high bay warehouse stacking components will arrive on site in modular form ready for assembly. However, it is anticipated that there will be large quantities of packaging materials (such as pallets, cardboard, strapping and shrink wrap) Materials to be delivered to site in returnable packaging and pallets.					
Comments:	Note: Volumes are preliminary estimates only, based on material volumes not materials plus airspace normally seen in waste skips				

5.1 Overview

The development will be made up of:

- Production facilities;
- High bay warehouse;
- Despatching; and
- Loading facilities.

5.2 Existing Solid Waste Management Activities

The site is currently used by CCA as a bottling plant and warehouse with associated offices and parking. CCA's has in place an Environmental Management System (EMS). This includes two key performance areas for solid waste and recycling: Total solid waste generated and Percentage of waste sent for recycling. CCA in the NSW operations have extensive systems in place to manage waste materials on site and much of the packaging material supplied to CCA is returned to suppliers for re-use. Where this is not possible CCA have developed over 14 recycling streams at the Northmead operation covering materials such as cardboard, paper, timber, aluminium cans, scrap metal, stainless steel, glass, PET, plastic drums, IBC's, plastic wrap, and printer toner cartridges.

Solid Waste Materials Onsite

A range of waste materials are currently produced on site and as part of the operations including:

- General waste
- Cardboard
- Paper
- Scrap metal
- Metal drums
- Aluminium cans
- Timber pallets
- Glass
- Empty PET bottles
- PET and poly strapping
- Plastic drums, detergent and sanitiser containers
- Plastic shrink wrap
- Plastic drums (IBCs)
- Inks and solvents
- Radioactive sources
- Waste oil & lubricant
- CCA have procedures for the management of these wastes and overall; procedures relating to the handling of controlled and non-controlled wastes and pre-packing procedures

Solid Waste Generation

CCA records quantities of solid waste generated at the Northmead site and the following is documented as being generated over 2005/2006 financial year. This data will be used to assist in identifying impacts to the operational solid waste streams of the proposed development:

Solid Waste Stream	2005/2006 (12 Months) (Tonnes)
General waste	106
Cardboard	154
Paper	6
Scrap metal, including metal drums and aluminium cans (including cans from Product Destruction)	381
Timber pallets	16
Glass (including glass from Product Destruction)	10
Empty PET bottles (including PET from Product Destruction)	270
Mixed plastics including PET and poly strapping, plastic drums, detergent and sanitiser containers and plastic shrink wrap	100
Plastic drums (IBCs)	10
Total	1053

The future waste and recycling generation rates have been based on the expansion of specific functions with the facility as shown below.

Solid Waste Recycling and Management

CCA has in place systems and procedures for the handling, separation and disposal of solid waste and recyclable on the site as follows:

Material	Management
General solid waste	Non-recyclable waste placed in general 3 cubic metre waste bins and removed offsite by a waste licensed contractor to a licensed solid waste facility
Cardboard	Separated for recycling and place in designated cardboard recycling bins for removal off site by cardboard recycler
Paper	Separated for recycling and place in designated blue bins for removal off site by paper recycler

Material	Management
Scrap metal	All metal is separated on site into 'steel only' skip bins and removed off site by a metal recycler One off machinery parts included in removal program
Aluminium cans	Separated and placed in can crusher for collection and removal off site by a metal recycler
Timber pallets	Broken pallets to be separated and placed in wood skip bins for removal offsite by a waste licensed contractor to a licensed solid waste facility
Glass	Placed in recycling bins and removed off site by a glass recycler
Empty PET bottles	Placed in recycling bins and cages around site and removed off site by a plastic recycler
PET and poly strapping	PET strapping and poly strapping kept separate and placed in wool bail bags or PET chipping device and removed off site by a plastic recycler
Plastic drums, detergent and sanitiser containers	Triple rinsed or pressure washed along with emptied and placed in caged area for removal off site by a plastic recycler
Plastic shrink wrap	Shrink wrap kept separate and placed in "wool bail" bags or plastic baling device and removed off site by a plastic recycler
Plastic drums (IBCs)	IBC's separated to designated recycling area for removal off site for recycling
Inks and solvents	Designated separate waste storage for inks and solvents. Maximum of 60L prior to removal off site. Handled in accordance with CCA's Controlled Waste Disposal Procedures
Radioactive sources	Handling in accordance with Licensed/ Controlled Wastes Disposal Procedure EMS-PRO-N-P-022, Radiation Control Act 1990, Radiation Control Regulation 2003 and CCA OHS Policy & Procedures. Pick up and disposal by a licensed contractor
Waste oil & lubricants	Waste oil transferred to banded oil storage area and transferred into the bulk waste oil drums (IBC) in the designated waste oil store and removed off site by a oil collection contractor. Handled in accordance with CCA's Controlled Waste Disposal Procedures

5.3 Generation Rates for Ongoing Management of Solid Waste

The future solid waste and recycling generation rates have been based on the expansion of specific functions with the facility as shown below.

Functions	Existing (m ²)	Proposed (m ²)	Change (%)
Office Accommodation	1,100	1,100	No change *
Finance	1,730	0	Removed off-site *
Equipment Servicing	4,120	0	Removed off-site
Production	8,665	20,505	~240
Warehousing & Dispatch	12,850	15,775	~125 #
Misc (gatehouse etc)	240	300	Minor change

* Note: Combine office space is reduced from 2,830m² to 1,100m² a reduction to 39%.

Note: The increasing in floor area is 23% however, the storage capacity from the existing warehousing to the new high bay warehouse will increase by 150%, in terms of pallet storage, from 20,000 maximum to 50,000 maximum and production will increase by 45%.

5.4 Anticipated Solid Waste Generation

Anticipated solid waste generation – for when the facility comes online in 2008 – has been estimated based on applying the following change factors to each of the specific solid waste streams.

Solid Waste Stream	Change Factor (%)	Existing (Tonnes p.a.)	Proposed (Tonnes p.a.)
General waste (Note 1)	-50	106	53
Cardboard	45	154	223
Paper (Note 1)	-50	6	3
Scrap metal, including metal drums and aluminium cans (including cans from Product Destruction) (Note 2)	20	381	457
Timber pallets (Note 3)	10	16	18
Glass (including glass from Product Destruction) (Note 2)	20	10	12
Empty PET bottles (including PET from Product Destruction) (Note 2)	20	270	324
Mixed plastics including PET and poly strapping, plastic drums, detergent and sanitiser containers and plastic shrink wrap	45	100	145
Plastic drums (IBCs)	45	10	15
Total		1053	1250

Note 1: Reduced due to Finance moving off site (subject to separate application, however, CCA's current and future solid waste management practices will include this facility).

Note 2: Improvements in production will see a reduction in volume per unit case of product. This increase has a reduced change factor of 20%.

Note 3: Due to automation and reduction in pallet handling this increase in timber pallet waste has a reduced change factor of 10%.

Solid Waste Recycling and Management

The existing systems and procedures for the handling, separation and disposal of solid waste and recyclable on the site will be maintained and expanded to include the additional future volumes generated. Current EMS procedures will be updated as required.

5.5 Site Green Waste

The site will have some landscaped areas and a landscape maintenance contractor will be engaged to tend to the landscaping. Part of their responsibilities will be to separate green waste into suitable categories to maximise off-site recycling, and minimise the generation of non-recyclable materials.

6.1 Existing Waste Water Management Activities

Liquids from Product Destruction

The product destruction is undertaken by CCA employees at the site in a purpose-built fully enclosed space in the re-pack area adjacent to the existing lower level production hall. Waste liquid product is drained from cans and bottles and captured in a bunded holding pit. Cans and bottles are separated for recycling as described in Section 5. The liquid waste product is pumped from the holding pit to a bunded 20,000L above-ground holding tank and taken off site by a waste management contractor and disposed to a licensed premise. CCA currently generate 18,000L of liquid waste per week year round.

Waste Water Treatment Plant

The waste water treatment (WWT) plant provides primary treatment only, screening solids, separating grease and oils, aeration and providing pH correction before discharge. Waste water is collected from floor wastes and collection pits in the production areas of the Northmead facility. The waste water includes washing water from floor and hard surfaces in the plant, some water soluble lubricant used on bottle and can conveyors and rinse and sanitising water used to wash out product process tanks, pumps, pipework and filling machines. The wash-out water contains diluted product (basically sugar solution), and sanitising chemicals (primarily sodium hypochlorite but some acid based sanitisers). Other waste water sources include filter back-wash water, boiler blow-down, cooling tower sump over-flows and the like.

The waste water from the plant is collected in the collection pit and pumped into a dissolved air flotation (DAF) unit that separates the suspended solids, grease and oil. Any grease and oil drains into a collection tank. Very little oil and grease is collected and nothing has been disposed of from this collection tank to date. The second stage of the treatment involves waste water entering the aeration tank to begin consuming the dissolved nutrients (sugar). In the third stage the waste water enters a pH correction tank and dosed with either sulphuric acid (H_2SO_4) or sodium hydroxide (NaOH) to within the Sydney Water discharge limits flowing through a flow-meter to the sewer.

Currently approximately 190ML/annum is directed and treated by the WWT plant with the current peak flow being 64kL/hr. The WWT plant's peak inflow is 105kL/hr sustainable for one hour until the capacity of the tanks is exceeded. The maximum sustainable inflow is 69kL/hr which is limited by the peak outflow rate of 19L/s.

Sludge is removed from the collecting pit, the DAF unit and the pH correction tank annually. The aeration tank is cleaned of sludge approximately every five years. During a 12 month period the plant generates 22kL of liquid and 2 tonnes of solid/sludge. A waste contractor removes the liquid and sludge wastes for disposal at a licensed facility. It is noted that CCA does not test the liquid and sludge wastes.

The existing Sydney Water trade waste agreement limits are as follows:

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- Temperature not to exceed 38°C;
 - Colour - not defined in agreement;
 - pH must be between 7 and 10;
 - No fibrous solids;
 - Gross Solids to have a max linear dimension of 20mm maximum cross-section of 6mm² and a maximum quiescent settling velocity less than 3m/hr; and
 - Flammability of discharge shall be less than 5% of the lower explosive limit of at 25°C.

The existing Sydney Water site specific flow rate limits are as follows:

- Maximum instantaneous flow rate: 19L/s;
- Maximum daily flow: 1400kL;
- Maximum average daily flow: 895kL;

The site specific pollutant load limits being the long term average daily mass limits (a 12 month arithmetical average of composite samples taken on site.) triggering pollutant load charges are as follows:

- Grease and oil: 11.70 kg/day;
- Suspended solids: 97.40 kg/day; and
- BOD₅: 1563.62 kg/day.

6.2 Anticipated Waste Water Generation

Product Destruction

Production at the facility will increase by 45%. It is estimated that the volume of damaged product and liquid waste from the product destruction area will grow at approximately 3.75% per annum in line with growth of production volumes. The 2005 volume of 18,000L per week will grow to 20,100L in 2008 and 26,000L in 2015.

Product destruction will be managed as per the existing arrangements. The existing infrastructure will remain, however, collection frequencies will increase.

Waste Water Treatment Plant

The current WWT system has the capacity to service the increase production of the expanded plant.

At present the annual volume of waste water being treated through the WWT plant is increasing at a slower rate to the rate of increase in production volume due to improvements in plant water efficiency. Additional water efficiency measures are planned resulting in an annual waste water growth of approximately 1.5% per annum compared to a production volume increase of 3.75% per annum. The total increase in waste water will be approximately 11% over the design horizon for the proposed development taking the volume treated from 190ML/annum to 211ML/annum and generating a corresponding increase in the solid fraction for disposal.

The nature of the waste water being treated by the WWT plant, in terms of pollutants and the input concentrations, will not change with the proposed development nor will there be an increase in the instantaneous maximum flows to the sewer.

The following conclusions are made:

- A high percentage of demolition, excavation and construction solid wastes can be reused or recycled;
- Operational solid wastes for the proposed development will increase by 25% and are similar in nature to the current operational wastes;
- Liquid wastes from the product destruction activities of the proposed development will increase by 3.75% per annum in line with growth of production volumes and will be identical to the current liquid wastes;
- The existing WWT facility has the capacity to service the increase production of the expanded plant; and
- Waste water and sludges from the operation of the proposed development will increase by 11% to 2015 and will be identical to the current liquid wastes.

In regard to Solid Waste it is recommended that:

- The following targets be set as performance requirements for the project:
 - 80% off site recycling for demolition wastes;
 - 90% recycling for excavation wastes;
 - 70% off site recycling for construction wastes;
- The management of the operational wastes for the proposed development will be incorporated into the existing CCA Environmental Management System.

In regard to Waste Water it is recommended that:

- Improvements in liquid waste management on site be continued;
- QA to continue to increase and reduce the need for product destruction;
- The WWT plant sludge be tested and re-classified.
- The management of the operational liquid wastes for the proposed development will be incorporated into the existing CCA Environmental Management System.

URS Australia Pty Ltd (URS) has prepared this report in accordance with the usual care and thoroughness of the consulting profession for the use of Coca-Cola Amatil (Aust) Pty Ltd and only those third parties who have been authorised in writing by URS to rely on the report. It is based on generally accepted practices and standards at the time it was prepared. No other warranty, expressed or implied, is made as to the professional advice included in this report. It is prepared in accordance with the scope of work and for the purpose outlined in the Proposal dated June 2006.

The methodology adopted and sources of information used by URS are outlined in this report. URS has made no independent verification of this information beyond the agreed scope of works and URS assumes no responsibility for any inaccuracies or omissions. No indications were found during our investigations that information contained in this report as provided to URS was false.

This report was prepared between 7 July 2006 and 28 August 2006 and is based on the conditions encountered and information reviewed at the time of preparation. URS disclaims responsibility for any changes that may have occurred after this time.

This report should be read in full. No responsibility is accepted for use of any part of this report in any other context or for any other purpose or by third parties. This report does not purport to give legal advice. Legal advice can only be given by qualified legal practitioners.