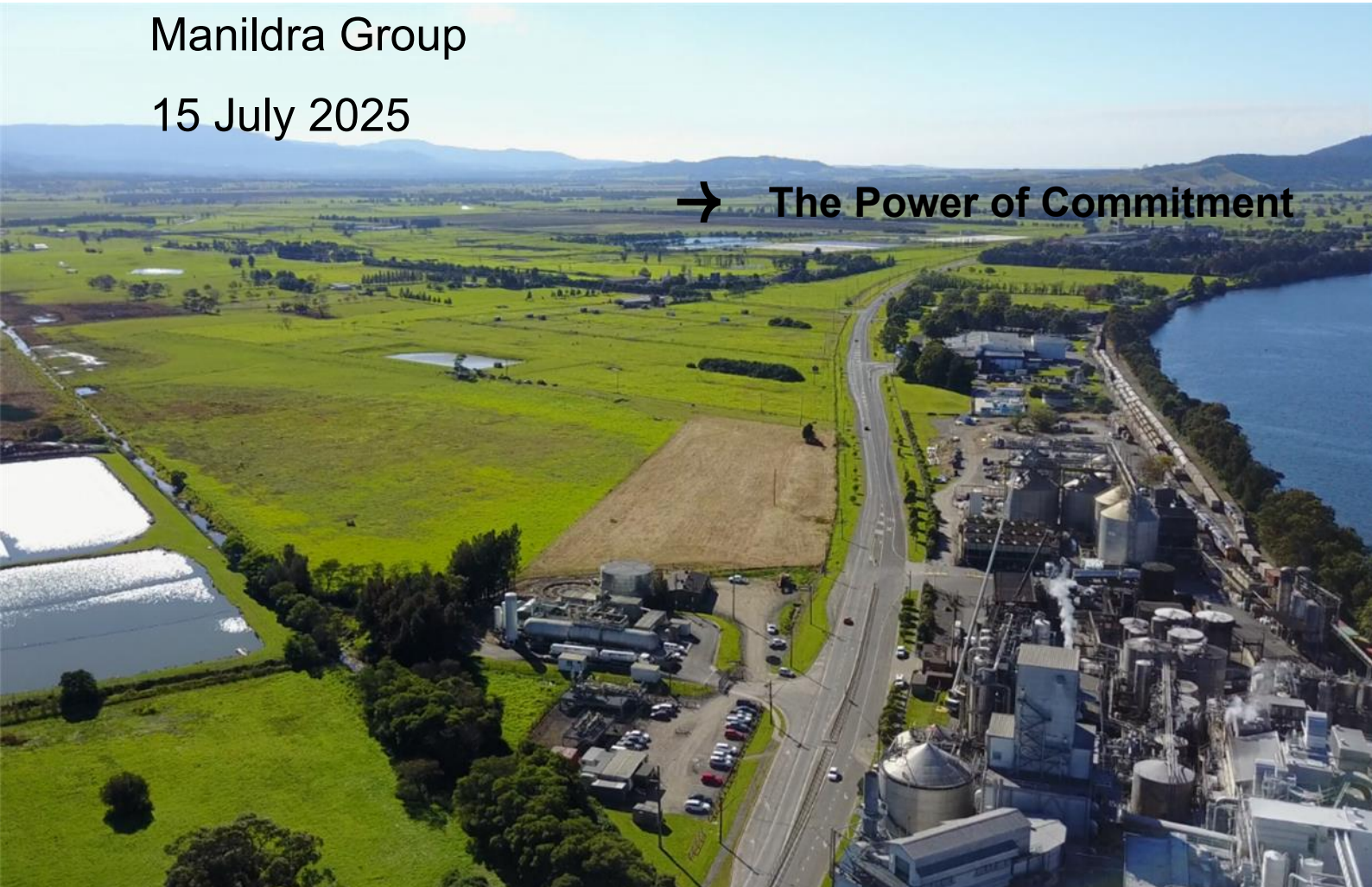
Shoalhaven Starches Modifications 25 and 29

Construction Air Quality Management Plan

Manildra Group

15 July 2025



→ The Power of Commitment

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The Power of Commitment

Contents

1. Introduction **1**

2. Project description **2**

3. Legislative and policy context **3**

3.1 Assessment criteria 3

4. Construction methodology **4**

4.1 Modification 25 4

4.2 Modification 29 7

5. Management measures **9**

5.1 Prevention measures 9

5.2 Mitigation measures 10

5.3 Rectification measures 10

6. Monitoring and evaluation **10**

6.1 Monitoring overview 10

6.2 Complaint-based monitoring 10

6.3 Reporting 10

7. References **12**

Table index

Table 1 Conditions of consent 1

Table 2 Air quality impact assessment criteria 4

Table 3 Summary of proposed rail extension construction works 5

Table 4 Receptors within 250 m of the construction footprint for each modification 9

Figure index

Figure 1 Indicative location of proposed construction works for MOD25 6

Figure 2 Indicative location of proposed construction works for MOD29 8

Appendices

Appendix A Modification 25 – Proposed rail extension and dryers 3 & 4 baghouse drawing set

Appendix B Modification 29 drawing set

Appendix C Environmental Complaints Handling Procedure

1. Introduction

GHD Pty Ltd (GHD) has been engaged by Shoalhaven Starches Pty Ltd (Manildra) to prepare a Construction Air Quality Management Plan (CAQMP) for the following proposed modifications:

– Modification 25 (MOD25): Rail line extension and extension to the Product Dryers 3 and 4.
– Modification 29 (MOD29): Installation of additional evaporators, and associated substations, and re-configuration of the approved biofilters

This CAQMP has been developed to satisfy the requirements of Schedule 3, Condition 8D and 8F of Shoalhaven Starches Expansion Development Consent 06_0228, approved by the NSW Department of Planning and Environment.

Condition 8D of the consent states:

Prior to the construction of MOD 29, the Applicant must prepare and implement a CAQMP. The CAQMP must:

a. Be prepared by a suitably qualified and experienced person(s);
b. Include the mitigation measures nominated in the Air Quality Impact Assessment, prepared by GHD Group Pty Ltd, Date April 2024; and
c. Include site-specific, measurable and auditable key performance indicators to evaluate the implemented construction mitigation measures.

Condition 8F of the consent states:

Prior to construction of MOD 25, the Applicant must:

a. Prepare a CAQMP in accordance with condition 8D, including incorporation of the mitigation measures identified in MOD 25;
b. Not commence construction of the works described in MOD 25 until the CAQMP required under (a) has been submitted to the Planning Secretary; and
c. Implement the most recent version of the CAQMP submitted to the Planning Secretary for the duration of construction of the works described in MOD 25.

This CAQMP has been prepared prior to the commencement of any site works to promote employment of best practices. References to where each relevant condition of consent has been addressed in this plan is shown in Table 1 below.

Table 1 Conditions of consent

Consent requirement	Section in Plan
Condition 8D	
(a) Be prepared by a suitably qualified and experienced person(s);	Evan Smith has 20 years relevant experience including over 10 years of undertaking air quality works for Shoalhaven Starches. Julia Potgieter has over 3 years of experience working in air quality impact assessment and management plans.
(b) Include the mitigation measures nominated in the Air Quality Impact Assessment, prepared by GHD Group Pty Ltd, Date April 2024; and	Section 4.2
(c) Include site-specific, measurable and auditable key performance indicators to evaluate the implemented construction mitigation measures.	Section 4.2
Condition 8F	

Consent requirement	Section in Plan
(a) Prepare a CAQMP in accordance with condition 8D, including incorporation of the mitigation measures identified in MOD 25	This report, section 4.2
(b) Not commence construction of the works described in MOD 25 until the CAQMP required under (a) has been submitted to the Planning Secretary; and	NA
(c) Implement the most recent version of the CAQMP submitted to the Planning Secretary for the duration of construction of the works described in MOD 25.	NA

This report: has been prepared by GHD for Manildra Group and may only be used and relied on by Manildra Group for the purpose agreed between GHD and Manildra Group as set out in section 1 of this report.

GHD otherwise disclaims responsibility to any person other than Manildra Group arising in connection with this report. GHD also excludes implied warranties and conditions, to the extent legally permissible.

The services undertaken by GHD in connection with preparing this report were limited to those specifically detailed in the report and are subject to the scope limitations set out in the report.

The opinions, conclusions and any recommendations in this report are based on conditions encountered and information reviewed at the date of preparation of the report. GHD has no responsibility or obligation to update this report to account for events or changes occurring subsequent to the date that the report was prepared.

The opinions, conclusions and any recommendations in this report are based on assumptions made by GHD described in this report. GHD disclaims liability arising from any of the assumptions being incorrect.

Accessibility of documents

If this report is required to be accessible in any other format, this can be provided by GHD upon request and at an additional cost if necessary.

2. Project description

Manildra operates the Shoalhaven Starches factory (the factory) at Bolong Road, Bomaderry, near Nowra, in NSW (the site). At the factory, flour and grains are processed to produce ethanol, starch, gluten, glucose and distiller's dried grain (DDG).

Manildra is the holder of Environment Protection Licence (EPL) number 883 issued by the New South Wales Environmental Protection Authority (NSW EPA).

Manildra seek to construct modifications to the factory (MOD25 and MOD29) and are required to prepare a CAQMP for these works. The proposed modifications for MOD25 involve:

- Extending their existing rail line that services the factory operations from its present terminus at the eastern boundary of Lot 1 DP544730 in an easterly direction across adjoining lands that formed part of the former Australian Paper Mill and which are now under the ownership of the Manildra Groupe of Companies; and
- Undertaking an extension to the Product Dryers 3 and 4 building located within the main factory site to enable the installation of starch grinding baghouses. The proposed starch grinding bag house is to be erected above the existing starch dryer building. This addition will have a height above ground level of 28.84 metres (the existing building has a height of 20.34 metres). The purpose of the starch grinding bag house is to improve the quality of the starch product. The current grinding system does not have the capacity to grind starch to a sufficient fineness to meet market requirements

The proposed modifications for MOD29 involve construction of the following additional plant and equipment:

- Water balance syrup recovery evaporator (MVR No. 4) and relocation of approved cooling towers in that location.
- Stillage evaporators (2 units), finisher, cooling towers, odour recovery scrubber, and associated stillage vessels and processing equipment.
- Re-configuration of the approved biofilters.

– Main distribution substation (x2)
– Substation (x2) and switch room

The primary pollutant of concern from the proposed works will be particulate matter (dust) from excavation works, construction works, and vehicle movements on unpaved surfaces.

Minor combustion emissions from operation of vehicles and plant equipment will occur however these are anticipated to be negligible in the context of the factory site and therefore have not been considered further in this CAQMP.

3. Legislative and policy context

The relevant legislation and guidance for the AQIA of the project are:

– NSW *Protection of the Environment Operations Act 1997* (POEO Act) – The POEO Act provides the statutory framework for managing pollution in NSW, including the procedures for issuing licences for environmental protection on aspects such as waste, air, water, and noise pollution control. The POEO Act requires that no occupier of any premises causes air pollution (including odour) through a failure to maintain or operate equipment or deal with materials in a proper and efficient manner. For point source emissions where no standard of concentration and/or rate has been set, and for non-point source emissions, the operator must also take all practicable means to minimise and prevent air pollution (sections 124, 125, 126 and 128 of the POEO Act). The POEO Act includes the concept of 'offensive odour' (section 129) and states it is an offence for scheduled activities to emit 'offensive odour', subject to limited defences.
– NSW Protection of the Environment Operations (Clean Air) Regulation 2021 (POEO Clean Air Regulation) – The POEO Clean Air Regulation provides regulatory measures to control emissions from motor vehicles, fuels, and industry.
– National Environment Protection Council (NEPC) National Environment Protection (Ambient Air Quality) Measure 2021 (the Air NEPM) – The National Environment Protection Council of Environmental Ministers, now the National Environment Protection Council (NEPC), set uniform national standards for ambient air quality. The document containing these standards is known as the Air NEPM, which also contains goals for the identified relevant pollutants inclusive of particulates and concentration limits, averaging periods, and number of allowed exceedances for each of the identified pollutants.
– *NSW EPA Approved Methods for the Modelling and Assessment of Air Pollutants in New South Wales* 2022 (the Approved Methods) - The Approved Methods lists the statutory methods for modelling and assessing emissions of air pollutants from stationary sources in NSW. It considers the above-mentioned legislation and guidance to provide pollutant assessment criteria.
– Work Health and Safety Act 2011 No 10 (WHS Act) – The WHS Act aims to provide a framework to secure the health and safety of workers and workplaces. The WHS Act approves Codes of Practice which provide detailed information on how standards required under WHS laws can be achieved. The WHS Codes of Practice relevant to this CAQMP include the following:
  - Code of Practice: Construction work (NSW Government, 2019)
  - Code of Practice: Excavation work (NSW Government, 2020)
  - Code of Practice: How to manage and control asbestos in the workplace (NSW Government, 2022)
  - Code of Practice: How to safely remove asbestos (NSW Government, 2022)
– Environment Protection Licence (EPL) – Manildra is the holder of EPL number 883 issued by the NSW EPA. The EPL states that all operations and activities occurring at the premises must be carried out in a manner that will minimise dust at the boundary of the premises.

3.1 Assessment criteria

Assessment criteria for the project was taken from the Approved Methods and are summarised in Table 2. The application of each impact assessment criteria is variable for each pollutant based on the following factors:

- **Averaging period** – the period over which modelled concentrations are averaged.
- **Statistic** – the statistic of the modelled concentrations. As an example for a 1-hour averaging period, the 'maximum statistic' would be the highest predicted value at any receptor for the entire modelling period. The 99.9th percentile statistic would be (approximately) the ninth highest hour in a one year modelling period.
- **Impact location** – the location at which the impacts are to be assessed. For some pollutants, impacts are assessable only at sensitive receptor locations, while some impacts are assessable at and beyond the boundary of the site. The criteria apply at ground level where receptors are likely to be exposed.
- **Impact type** – the type of impact assessed. For some pollutants, the impacts are assessable only for the project's contribution to pollutant concentrations at the relevant impact location (referred to as 'incremental impacts'). For other pollutants, the cumulative impact (which includes both the incremental concentration as well as the background concentration) is assessed.

Table 2 Air quality impact assessment criteria

Pollutant	Averaging period	Statistic	Impact location	Impact type	Criterion
TSP	Annual	Maximum	Sensitive receptor	Cumulative	90 µg/m^3
PM_{10}	24 hours	Maximum	Sensitive receptor	Cumulative	50 µg/m^3
	Annual	Maximum	Sensitive receptor	Cumulative	25 µg/m^3
$PM_{2.5}$	24 hours	Maximum	Sensitive receptor	Cumulative	25 µg/m^3
	Annual	Maximum	Sensitive receptor	Cumulative	8 µg/m^3
Dust deposition	Annual	Maximum	Sensitive receptor	Incremental	2 g/m^2/month
	Annual	Maximum	Sensitive receptor	Cumulative	4 g /m^2/month

4. Construction methodology

4.1 Modification 25

It is understood that the proposed construction of the rail extension (MOD25) would be undertaken across two general stages:

- Preparatory earthworks – this would involve:
  - Excavation and relocation of spoil (estimated to be approximately 11,000 m^3 of spoil based on the findings of a preliminary geotechnical assessment that indicated the need to excavate a length of 1,100 m long by 10 m wide to an average depth of 1 m.
  - Placement of structural fill and capping material to replace excavated spoil (approximately 11,000 m^3)
  - Creation of a hard stand for rail wagon maintenance area
- Rail construction works – this would involve:
  - Laying of ballast
  - Placement of railway sleepers
  - Installation of rail track

A summary of the proposed construction plant/equipment and expected duration of works is provided in Table 3.

Table 3 Summary of proposed rail extension construction works

Construction stage	Plant and equipment	Expected duration
Preparatory earthworks	– 2 x Excavators – 2 x Front end loaders – 2 x Dump trucks – 4 x Road trucks – Water truck (used for dust mitigation) – Roller – Grader – Road trucks for material deliveries	– Excavation and relocation of spoil 2-3 weeks – Placement of structural fill and capping material 2-3 weeks – Creation of a hard stand for rail wagon maintenance area 2 weeks Stage duration: 6 – 8 weeks
Rail construction works	– 3 x Excavators – 3 x Front End Loaders – 3 x Dump trucks – Drott – Rollers – Watercarts (used for dust mitigation) – Jackson Tamper – Kershaw Regulator	Stage duration: 4 weeks
Construction of the rail extension		Total duration: 10 – 12 weeks

The indicative location of proposed construction works and location of nearest receptors are shown in Figure 1. A drawing set showing the location of the proposed rail extension in more detail is provided in Appendix A.

The Air Quality Assessment for MOD25 (GHD, 2022) indicated that the risk identified for earthworks activities was **Low Risk** while the risk identified for all other construction and track-out activities was **negligible** for all receptors. While risk identified was at most Low Risk, dust management strategies have been proposed to further reduce the potential for dust impacts, and to provide a pathway should dust impacts occur.

Excavation works and vehicle movements on unpaved roads are considered likely to have the highest emissions of dust during the construction period. Construction of the product dryer building extension will not include ground excavation and works will be undertaken within sealed road areas of the factory.

Figure 1 Indicative location of proposed construction works for MOD25

4.2 Modification 29

It is understood that the proposed construction of MOD29 would primarily consist of installation of pre-fabricated structures/equipment and would involve the following activities:

- Preparatory works:
  - Preparation of substation site for piling and installation of slab on ground
  - Installation of timber piles and concrete slab on ground
- Construction/installation works:
  - Installation of concrete tilt slab building
  - Construction/installation of substations and switchroom
  - Construction/installation of stillage evaporators (2 units), finisher, cooling towers and associated equipment
  - Relocation of the approved cooling towers
  - Reconfiguration of biofilter No. 3

The indicative construction footprint with a 250 metre buffer zone is shown in Figure 2. A drawing set showing the proposed modifications in more detail is provided in Appendix B.

The Air Quality Assessment for MOD29 (GHD, 2024) indicated that the risk identified for all construction and track-out activities was **negligible** for all receptors. While risk identified was at most negligible, dust management strategies have been proposed to further reduce the potential for dust impacts, and to provide a pathway should dust impacts occur.

Excavation works and vehicle movements on unpaved roads are considered likely to have the highest emissions of dust during the construction period.

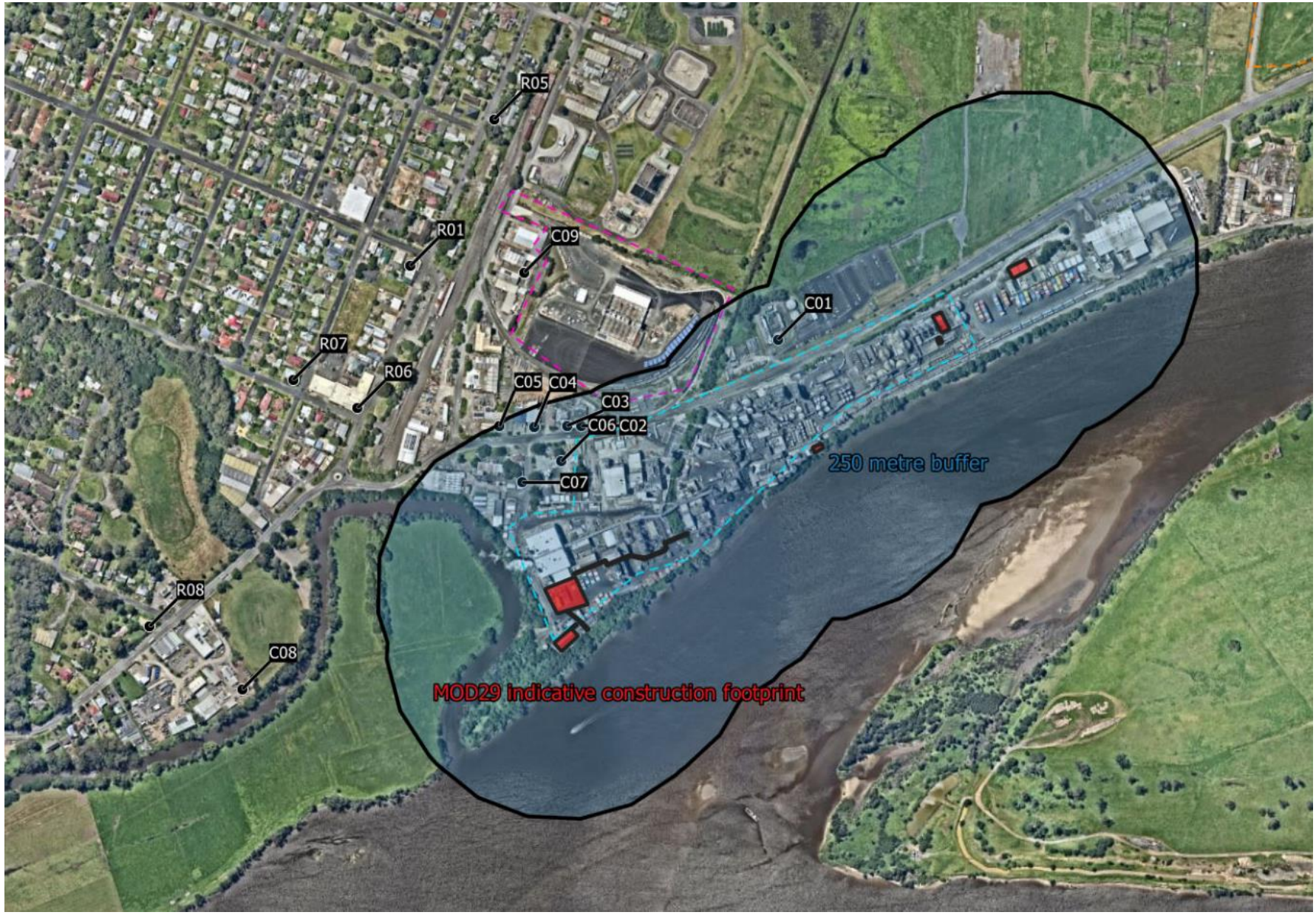

Figure 2 Indicative location of proposed construction works for MOD29

5. Management measures

The main features of the dust management strategies are based on prevention, mitigation and rectification. The mitigation and rectification measures will be implemented as required and their exact details will be based on a case by case situation depending on the issue and technical solutions available at the time. The proposed management strategies are described in the following sections.

Receptors within 250 metres of the construction footprint have potential to be impacted by the construction works. These receptors have been identified for each modification as presented in Table 4.

Table 4 Receptors within 250 m of the construction footprint for each modification

Modification	Receptors
MOD25	– 280 Bolong Rd – 390 Bolong Rd
MOD29	– Boc Gases (Bolong Rd) (C01) – Trackside Takeaway (1/21 Bolong Rd) (C02) – Jim Freeman Plumbing & Southern Industrial Plumbing Group (27 Bolong Rd) (C03) – C & S Frew Fabrications (1/29 Bolong Rd) (C04) – Mobil (33 Bolong Rd) (C05) – Cleary Bros Bomaderry (34 Bolong Rd) (C06) – Poolside Shoalhaven (36 Bolong Rd) (C07)

5.1 Prevention measures

- Prepare dust management education material for inclusion in site inductions, training and daily toolbox meetings. Inform construction staff of activities likely to cause high dust emissions (as part of site inductions) and appropriate methods to mitigate dust emissions.
- Plan land vegetation clearing, earthworks, rehabilitation and construction activities to keep exposed areas to a minimum and schedule major dust generating activities to occur one at a time.
- Implement on site traffic and operational controls to prevent unnecessary dust generation from vehicle movements including sweeping access roads as required, inspect incoming trucks to ensure trucks transporting material are covered and that tailgates are firmly fixed, enforcing speed limits and operating wheel washing facilities at exits from unsealed roads for use during wet conditions.
- Do not undertake dust generating activities during adverse weather conditions when visible plumes of dust are observed to leave the facility boundary.
- Inform receptors within 250 metres of the proposed construction works (refer Table 4) and provide them with a number to contact during construction if they have any questions or complaints.
- Cover loads during transport to prevent loss of material during haulage.

Key performance indicators to evaluate the efficacy of the prevention measures include:

- The frequency and effectiveness of dust management education material being incorporated into site inductions and daily toolbox meetings
- The success in minimizing exposed areas through the scheduling of dust generating activities
- Adherence to traffic and operational controls reducing unnecessary dust from vehicle movements
- Compliance with speed limits and the use of wheel washing facilities
- The communication effectiveness with receptors within 250 metres(refer Table 4), ensuring they are informed and their concerns addressed promptly

Other indicators include the percentage of loads covered during transport and the avoidance of dust generating activities during adverse weather conditions

5.2 Mitigation measures

- Perform daily inspections for visible dust emissions along the site boundary of the facility (refer Section 6 for details).
- Use dust suppression techniques (such as watering via watering trucks or sprinkler systems) to maintain moist conditions on cleared or exposed areas, stockpile areas, unsealed roadways and high dust generating equipment.
- Undertake continuous visual monitoring of dust emissions.
- Reduce or stop construction works if dust plumes are observed travelling off site beyond the site boundary, particularly towards the receptors within 250 metres (refer Table 4).
- Retain as much vegetative screening between the facility and the nearest sensitive receptors as possible.

5.3 Rectification measures

- Record environmental complaints and maintain regular reviews and reporting of performance.
- Consider spraying dust suppressants on the soil/cover material stockpiles.
- Increase the amount of watering on stockpiles and water cart equipment for operational areas if required.
- Develop alternative operational methods to reduce dust generation.

6. Monitoring and evaluation

6.1 Monitoring overview

Air quality monitoring shall be undertaken as following:

- Continuously monitoring of excessive dust generation by staff during day-to-day activities. To be implemented by raising staff awareness of potential air quality impacts and educating staff on appropriate responses. This should be regarded as standard operating practice for all staff.
- Ad hoc monitoring investigation to be undertaken as required in response to a reason (e.g. complaint received, change of typical operating procedures or at the request of the site manager etc). This will involve a boundary survey to investigate and mitigate the responsible source(s) (refer Section 6.2).

6.2 Complaint-based monitoring

If any valid air quality complaints are received, or excessive dust is noticed at the site boundary, air quality checks by the Environmental Coordinator are required immediately including air quality checks at residential receiver locations to verify the complaint details where applicable. A boundary survey shall be undertaken to investigate and mitigate the responsible source(s).

6.3 Reporting

The impact of construction activities can be influenced by numerous factors such as weather conditions, activities undertaken on that day and equipment used onsite, which can contribute to an increase in dust emissions. Recording monitoring and inspection results as well as conditions which influence dust can help to assess if management measures are effective and help define corrective actions, if required.

Environmental reporting for all ad hoc investigations must include the following (at a minimum):

- Date, time and reason for the investigation.

- Outcomes of the investigation (e.g. source(s) identified as responsible for causing the disturbance and mitigation measure implemented).
- If initiated by a complaint, the following is required:
  - All complaints will be handled according to the Shoalhaven Starches Environmental Complaints Handling Procedure (see Appendix C)
  - Air quality checks by the Environmental Coordinator immediately, including air quality checks at residential receiver locations to verify the complaint details where applicable
  - All corrective and preventative actions implemented will be documented as per Shoalhaven Starches Corrective and Preventative Action Procedure (QMS-P-0130)
  - Details of the date and time the complaint was received and the date and time that the dust was observed.

7. References

GHD. (2022). *Shoalhaven Starches Modification 25 - Proposed Rail Line Extension and Additions to Product Dryer 3 & 4 Air Quality Assessment.*
GHD. (2024). *Shoalhaven Starches Modification 29 - Air Quality Impact Assessment.*
NSW Government. (2019). *Code of Practice: Construction Work.*
NSW Government. (2020). *Code of Practice: Excavation Work.*
NSW Government. (2022). *Code of Practice: How to manage and control asbestos in the workplace.*
NSW Government. (2022). *Code of Practice: How to safely remove asbestos.*

Appendix A

Modification 25 – Proposed rail extension and dryers 3 & 4 baghouse drawing set

EXISTING APPROVED PLANT.
NEW PROPOSALS.
APPROVED PLANT YET TO BE CONSTRUCTED.
COGEN PROPOSAL PENDING APPROVAL.

app. irrigation.

POND 6

MANILDRA ENVIRONMENTAL FARM.

BVF

BOLONG ROAD

PAPER MILL SITE.

RAIL LINE EXTENSION.
Drw–002 & –003.

Shoalhaven River

STARCH GRINDING BAG HOUSES.
Drws–004 & –006.

SHOALHAVEN STARCHES COMPLEX.

ISLAND

REV	ZONE	DETAILS	DRN	DATE	CHKD	APPD
P02	A L L	Rail realigned.	P.C.	09/05/22	BH	
P01	A L L	First Issue.	P.C.	13/12/21	BH	

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MANILDRA GROUP

DRAWN 18/10/2021	DATE	JOB TITLE SHOALHAVEN STARCHES.BOMADERRY. NSW	SHT SIZE A3
CHKD	DATE	DWG TITLE NEW PROPOSALS. O/A SITE PLAN.	
APPD	DATE		REV. P02
SCALE 1:7500	7393	DWG No. MN7464–001	

EXISTING APPROVED PLANT –BLACK.
RAIL EXTENSION –RED.

BOLONG ROAD

10M SETBACK

18M SETBACK

143M

273M

PROPOSED CONCRETE PLANT BY OTHERS.

RAIL MAINTENANCE SPUR. (100M).

A
DP 384559

1
DP 544730

1
DP 531429

1
DP 530968

MANILDRA OLD PAPER MILL SITE.

LOT BOUNDARY.

EXISTING MESH FENCE TO BE RELOCATED SOUTH WHERE REQUIRED. 160M x 3M max.

EXISTING BRICK PUMP HOUSE TO BE DEMOLISHED.

EXISTING SHED

EXISTING SHEDS

EXISTING PIT

EXISTING SEWER MANHOLES

EXISTING ABOVE GROUND TANK

EXISTING PITS

VALVE

PUMP HOUSE

REALIGNED FENCE

100M

280M

6M SETBACK

342M

180M

73M

950M DOUBLE TRACK RAILWAY.
100M SINGLE TRACK RAILWAY.
143M MAINTENANCE SPUR RAILWAY.

Shoalhaven River

REV	ZONE		DRN	DATE	CHKD	APPD
P14	ALL	Track reworked.	P.C.	9–05–22	B.H.	
P13	ALL	Track reworked.	P.C.	3–05–22	B.H.	
P12	ALL	Track reworked.	P.C.	21–04–22	B.H.	
P11	ALL	Wording amended.Track totals text reinstalled.	P.C.	4–04–22	B.H.	
P10	ALL	Existing fence highlighted.Contours shown.	P.C.	24–03–22	B.H.	
P09	ALL	Set back now shown from fence.	P.C.	23–03–22	B.H.	

Commitment to Excellence
GEM OF THE WEST

MANILDRA GROUP
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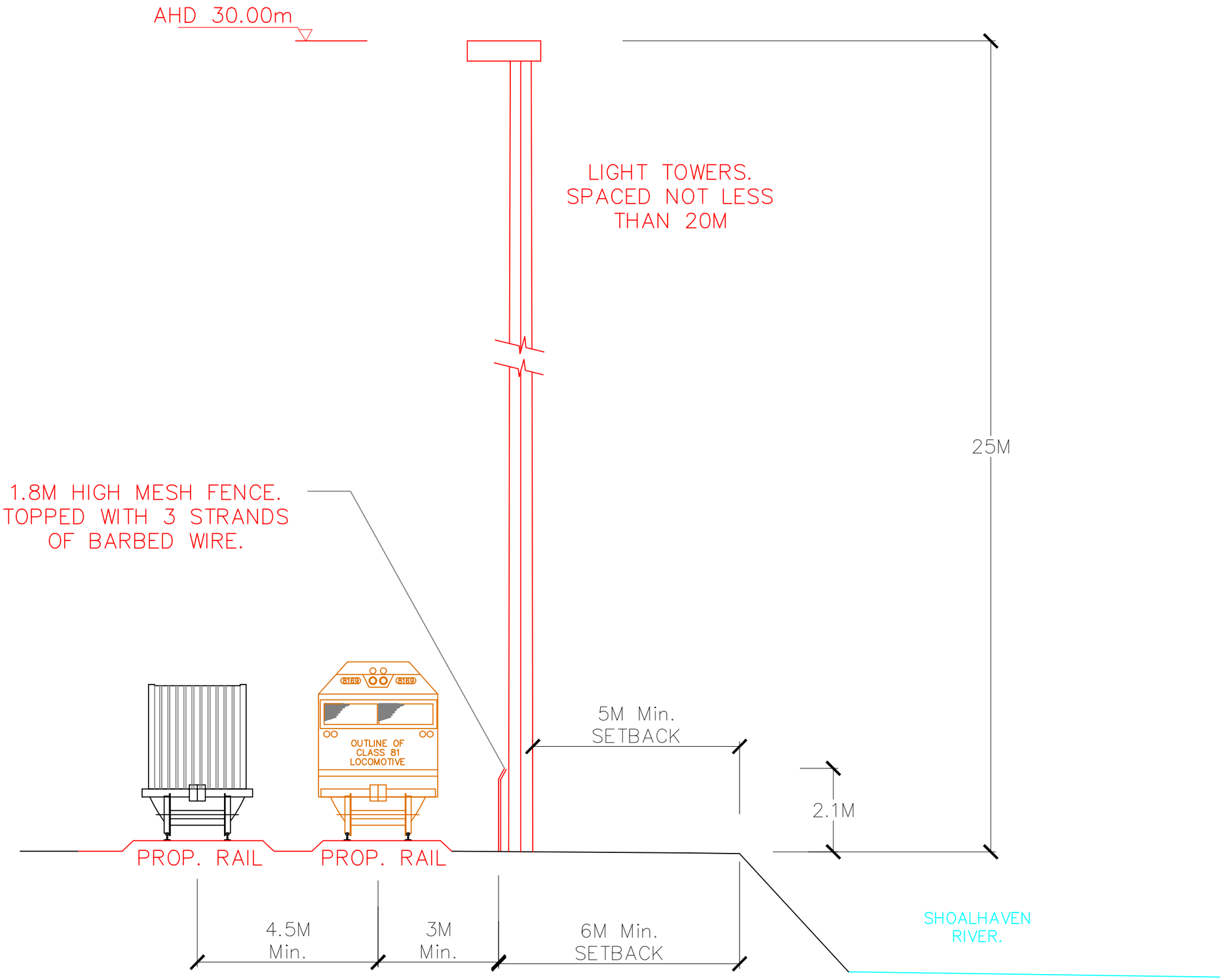
PC Drafting 0439 436508

P.C.	12/5/21	SHOALHAVEN STARCHES.BOMADERRY. NSW	A3
CHKD B.H.	DATE	DWG TITLE PAPER MILL RAIL EXTENSION. SITE PLAN.	REV.
APPD	DATE		
	SCALE 1:2500	PROJECT No. 7464 / DWG No. MN7464–002	P14



TYPICAL ELEVATION.

REV	ZONE		DRN	DATE	CHKD	APPD
P05	ALL	Set back amended.	P.C.	09–05–22	B.H.	
P04	ALL	Fence height added.	P.C.	04–04–22	B.H.	
P03	ALL	Drawing number changed.	P.C.	13–12–21	B.H.	M.O.
P02	ALL	Layout amended.	P.C.	09–12–21	B.H.	M.O.
P01	ALL	Draft.	P.C.	08–12–21	B.H.	M.O.

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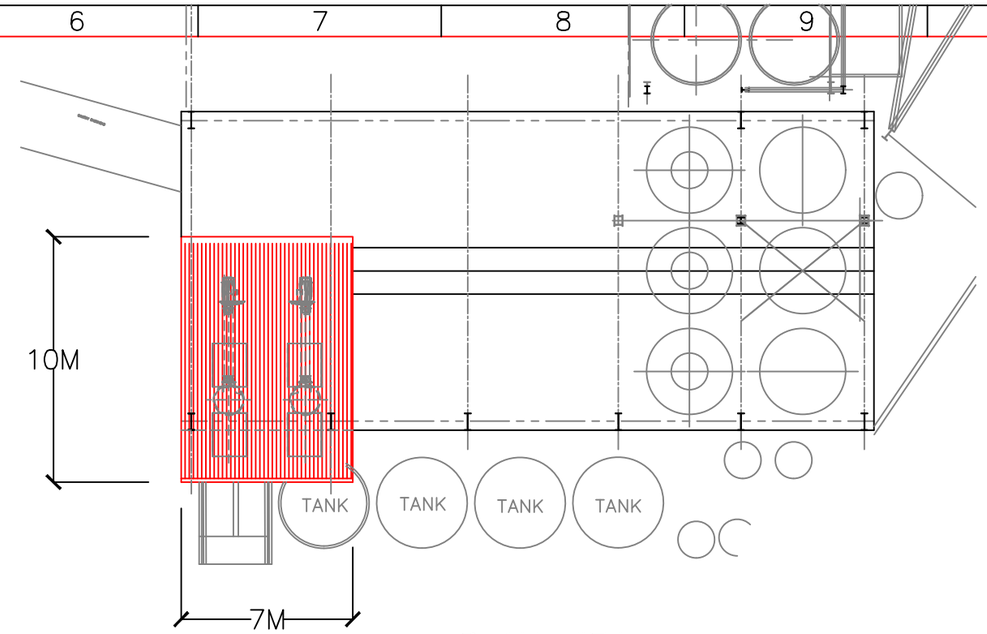
PC Drafting.
0439 436508

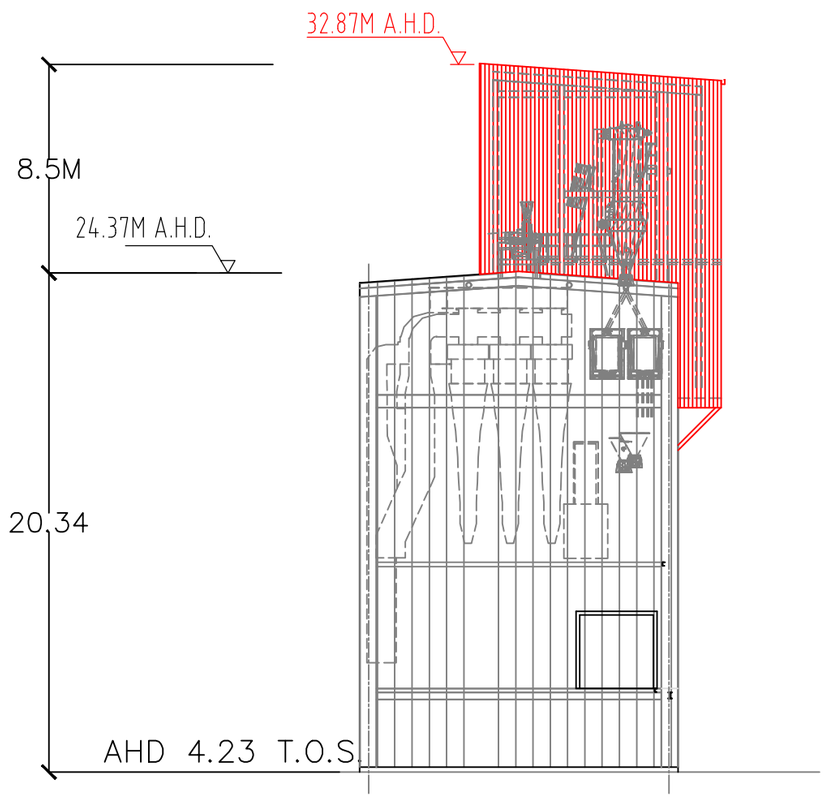
P.C.	12/5/21	SHOALHAVEN STARCHES.BOMADERRY. NSW	A3
CHKD B.H.	DATE	DWG TITLE PAPER MILL RAIL EXTENSION. TYPICAL ELEVATION.	REV.
APPD	DATE		
	SCALE 1:100	PROJECT No. 7464 / DWG No. MN7464–003	P05

EXISTING APPROVED PLANT.

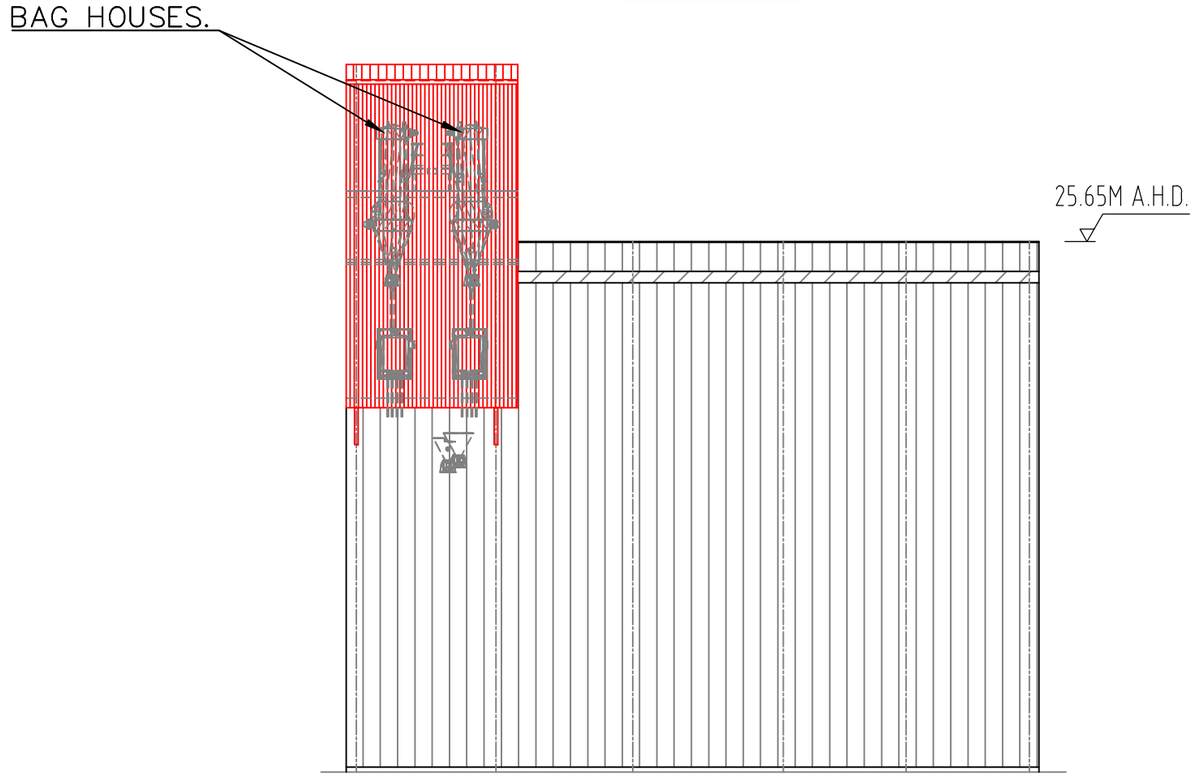
PROPOSED ADDITION.



PLAN VIEW



EASTERN ELEVATION



NORTHERN ELEVATION

REV	ZONE	DETAILS	DRN	DATE	CHKD	APPD
P06	ALL	Title & drawing No. changed,Mod 25 title removed.	P.C.	10-12-21	B.H.	
P05	ALL	Title now only Mod 25.	P.C.	26-10-21	B.H.	
P04	E7	Bag house wording added.	P.C.	30/9/21	B.H.	
P03	ALL	SD3 & SD 4 added to title block.	P.C.	21/9/21	B.H.	
P02	ALL	Was one bag house being shown.	P.C.	21/9/21	B.H.	
P01	ALL	Was MN7192-012	P.C.	14/9/21	B.H.	

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P.C.		SHOALHAVEN STARCHES.BOMADERRY. NSW	SHT SIZE A3
CHKD BH	DATE 30/03/21	DWG TITLE PRODUCT DRYERS 3 & 4. STARCH GRINDING BAG HOUSES.	
APPD	DATE		REV. P06
	SCALE 1:250	PROJECT No. 7393 / DWG No. MN7464-004	

EXISTING APPROVED PLANT –BLACK.
RAIL EXTENSION –RED.

Fence

Stake

EXISTING MESH FENCE
TO BE RELOCATED SOUTH.

EXISTING SHED

EXISTING SHEDS

4.0

4.5M Cts.

5.8M

7.17M

PROPOSED RAIL.

2.25M

EXISTING MESH FENCE

PROPOSED RAIL.

6.2M Cts.

MESH FENCE

FENCE

T.O. BANK

LOT BDY.

160M
OF RELOCATED FENCE.

6M MIN. SETBACK

Shoalhaven River

REV	ZONE		DRN	DATE	CHKD	APPD
P04	ALL	Rail realigned.	P.C.	9-05-22	B.H.	
P03	ALL	Relocated fence dimension added.	P.C.	4-04-22	B.H.	
P02	ALL	Existing fence highlighted.	P.C.	24-03-22	B.H.	
P01	ALL	First drawn.	P.C.	23-03-22	B.H.	M.O.

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0439 436508

P.C.	12/5/21	SHOALHAVEN STARCHES.BOMADERRY. NSW	A3
CHKD B.H.	DATE	DWG TITLE PAPER MILL RAIL EXTENSION. PLAN AT STORAGE SHED..	REV.
APPD	DATE		
	SCALE 1:500	PROJECT No. 7464 / DWG No. MN7464–005	P04

EXISTING APPROVED PLANT.

PROPOSED ADDITION.

BOLONG ROAD

DRYER #5.

INTERIM PACKING PLANT

Abernathys Creek

ELECTRICAL SUB-STATION

PACKAGING BUILDING

PRODUCT DRYERS 3 & 4.

STARCH GRINDING BAG HOUSES.

ETHANOL

STARCH PLANT

GLUCOSE PLANT

GLUCOSE TANKS

CONTAINER STORAGE AREA

DDG DRYERS.

BOILER HOUSE

FLOUR MILLS

LOT BOUNDARY

SUB/STN

ELECT S/ROOM

Shoalhaven River

REV	ZONE	DETAILS	DRN	DATE	CHKD	APPD
P01	ALL	This drawing added to set.	P.C.	4/4/22	B.H.	

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P.C.		SHOALHAVEN STARCHES.BOMADERRY. NSW
CHKD BH	DATE 04/04/22	DWG TITLE PRODUCT DRYERS 3 & 4. DRYER SITE PLAN.
APPD	DATE	
	SCALE 1:750	PROJECT No. 7393 DWG No. MN7464-006

SHT SIZE A3

REV. P01

PROPOSED RAIL EXTENSION AND
DRYERS #3 & #4 BAG HOUSES.

PROJECT No. 7464

09/05/22

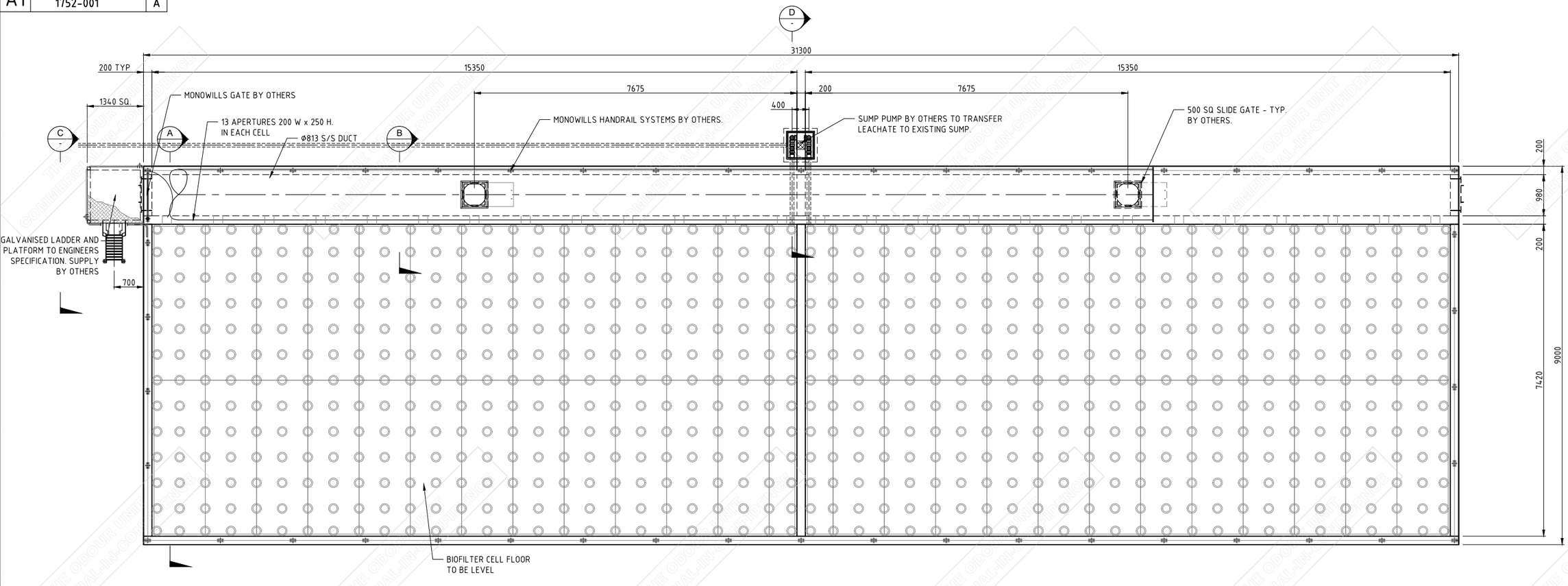
Drawing No.	REV.	
MN7464-001	P02	OVERALL SITE PLAN.
MN7464-002	P14	PAPER MILL RAIL EXTENSION.SITE PLAN.
MN7464-003	P05	PAPER MILL RAIL EXTENSION.ELEVATION.
MN7464-004	P06	PRODUCT DRYERS 3 & 4.STARCH GRINDING BAG HOUSES.
MN7464-005	P04	PAPER MILL RAIL EXTENSION.PLAN AT FENCE RELO.
MN7464-006	P01	STARCH GRINDING BAG HOUSES SITE PLAN.

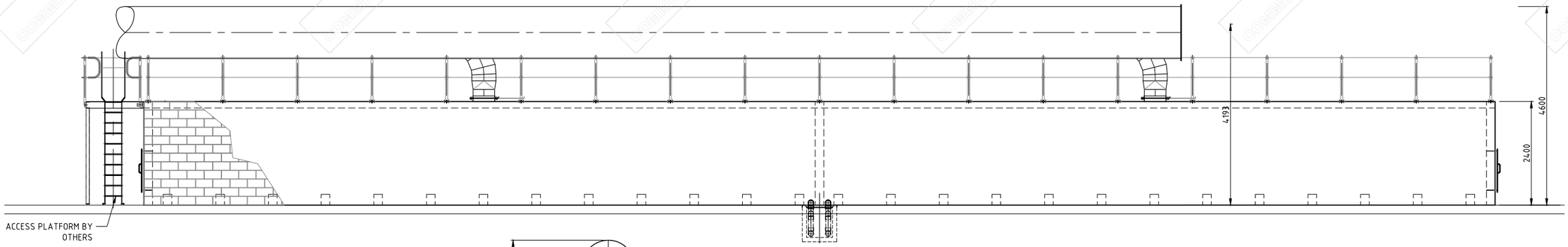
Appendix B

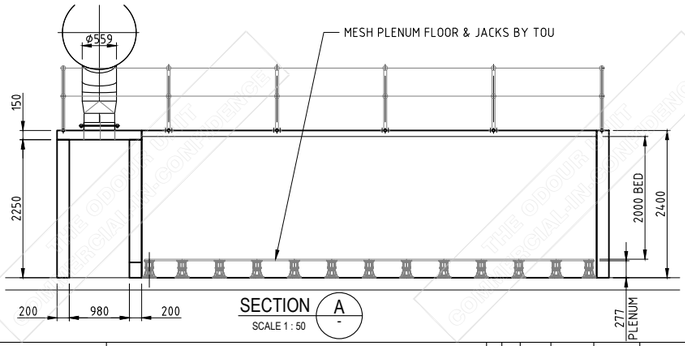
Modification 29 drawing set

A1 | DRAWING No. 1752-001 | REV A

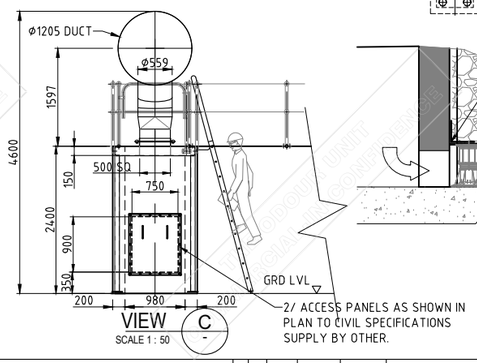
DO NOT SCALE, IF IN DOUBT ASK - DIMENSIONS IN MILLIMETRES U.N.O.



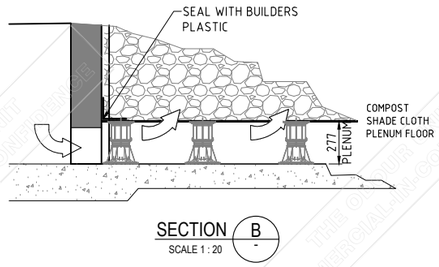




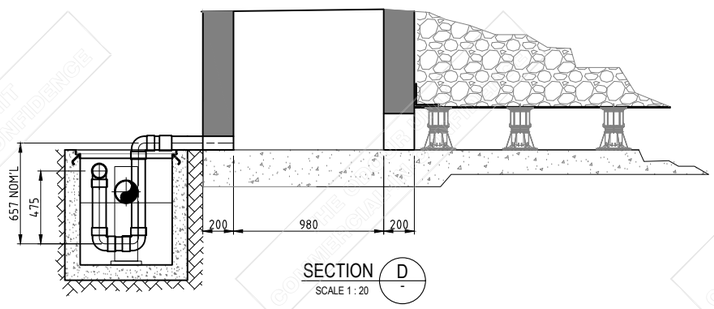
SECTION A
SCALE 1 : 50



VIEW C
SCALE 1 : 50



SECTION B
SCALE 1 : 20



SECTION D
SCALE 1 : 20

NOTES:

1. ALL INTERNAL SURFACES OF BIOFILTER SHALL BE WATERPROOFED WITH EITHER, FRP, EPOXY OR APPROVED ALTERNATIVE.
2. ALL JOINS BETWEEN BIOFILTER FLOOR AND WALLS SHALL BE SEALED.

REFERENCES

DRG No.	TITLE
SK-006	STANDARD DOUBLE DRAIN SUMP - ARRANGEMENT

REVISIONS

REV	BY	DATE	A.R.N.	DESCRIPTION

REVISIONS

REV	BY	DATE	A.R.N.	DESCRIPTION

THE ODOUR UNIT PTY LTD
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DRAWN TO AS 1100	SCALE (A1)	
DRAWN	W. WESTWOOD.	16 JAN 23
CHECKED		
APPROVED	T. SCHULZ	
DESIGN ENG.	W.WESTWOOD	

CLIENT / PROJECT: SHOALHAVEN STARCHES
160 BOLONG RD, BOMADERRY, NSW.

TITLE: SHOALHAVEN STARCHES
MOD 22 - EVAPORAOR UPGRADE
BIOFILTER ARRANGEMENT

DRAWING No. 1752-001 | REV A
CLIENT CODE N1752L.04
JOB No. N1752L
A1
AutoCAD FILENAME 1752-001A.DWG

EXISTING APPROVED PLANT.

MOD 29.

APPROVED MOD 19 SHOWN RELOCATED.

APPROVED PLANT YET TO BE CONSTRUCTED OR UNDER CONSTRUCTION.

RAILWAY STREET

APPROVED EXIT.

PACKER ALTERATIONS MOD 21 UNDER CONSTRUCTION.

APPROVED CONTAINER STORAGE AREA.

MANILDRA LAND

FERMENTER SITE. Drws.MN7193-001 to MN7193-006.

MAIN DISTRIBUTION SUBSTATION 0.2 & 0.3.

MVR #4.

(DP 638246)

GATE 13.

GATE 11

GATE 9

GATE 7

GATE 4

GATE 2

GATE 1

GATE 3

GATE 5

BOLONG ROAD

CLEARY BROS CONCRETE BATCHING PLANT

MANILDRA COMPLEX

CAR PARKING

FORMER DAIRY FARMERS FACTORY.

APPROVED MOD 19 COOLING TOWERS RELOCATED AND HEIGHT INCREASED.

MVR #4 SWITCH ROOM.

STARCH & GLUCOSE PLANT SUBSTATION.

EVAPORATOR SITE. Drws.MN7838.

Shoalhaven River

REV	ZONE	DETAILS	DRN	DATE	CHKD	APPD
P36	ALL	Scrubber added to tank farm.Sub was grain plant sub.	P.C.	12-02-24	J.S.	
P35	ALL	Proposals reduced.Was part of Mod 22.	P.C.	06-02-24	J.S.	

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DRAWN PC	DATE 25-06-20	SITE MANILDRA-SHOALHAVEN STARCHES PTY LTD.	SHT SIZE A3
DESIGNED. AT	DATE	JOB TITLE NOWRA PLANT.	SHEET
CHKD SR	DATE	DWG TITLE MOD 29. FERMENTER AND EVAPORATOR OVER ALL SITE PLAN.	OF
APPD BH	DATE		REV. P36
	SCALE 1:3000	PROJECT No. 7193AA / DWG No. MN7193-001	

EXISTING APPROVED PLANT.

MOD 29.

APPROVED MOD 19 SHOWN RELOCATED.

APPROVED PLANT YET TO BE CONSTRUCTED.

11M

BOLONG ROAD

LOT BOUNDARY

LANDSCAPING SCREEN.

LANDSCAPING SCREEN.

18M SETBACK.

MAIN DISTRIBUTION SUBSTATION 0.2 & 0.3.

Substation

21M SETBACK.

MVR4 & STAIRWELL.

WORKSHOP

26.8M

Evaporator

Cooling Towers

RELOCATE

19

18

RL 4.80m

COOLING TOWER HEIGHT INCREASED TO 10.4M FROM 7.6M.

5.8M MVR 4 SWITCH ROOM.

COOLING TOWERS

SERVICE ROADWAY

5.84M

12M

Substation

AIR CON

AIR CON.

SERVICE ROADWAY

Cooling Towers

6.1M

31.2M

APPROX RAILWAY LINES

REV	ZONE	DETAILS	DRN	DATE	CHKD	APPD
P24	G4	Substation addition.	P.C.	12-04-23	D.J.	
P24	G4	Substation addition.	P.C.	12-04-23	D.J.	
P24	H1	Existing scrubber stack extension added.	P.C.	12-04-23	D.J.	
P23	E5	Footprint was 10m wide (now 11m wide).	P.C.	12-10-22	D.J.	
P22	H6	Cooling towers height increased.	P.C.	20-7-22	B.H.	
P21	G7	Scrubber #12 added & #21 removed.	P.C.	19-7-22	B.H.	
P20	ALL	Layout reconfigured.	P.C.	01-7-22	B.H.	

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PC Drafting 0439 436508 Est. 2003

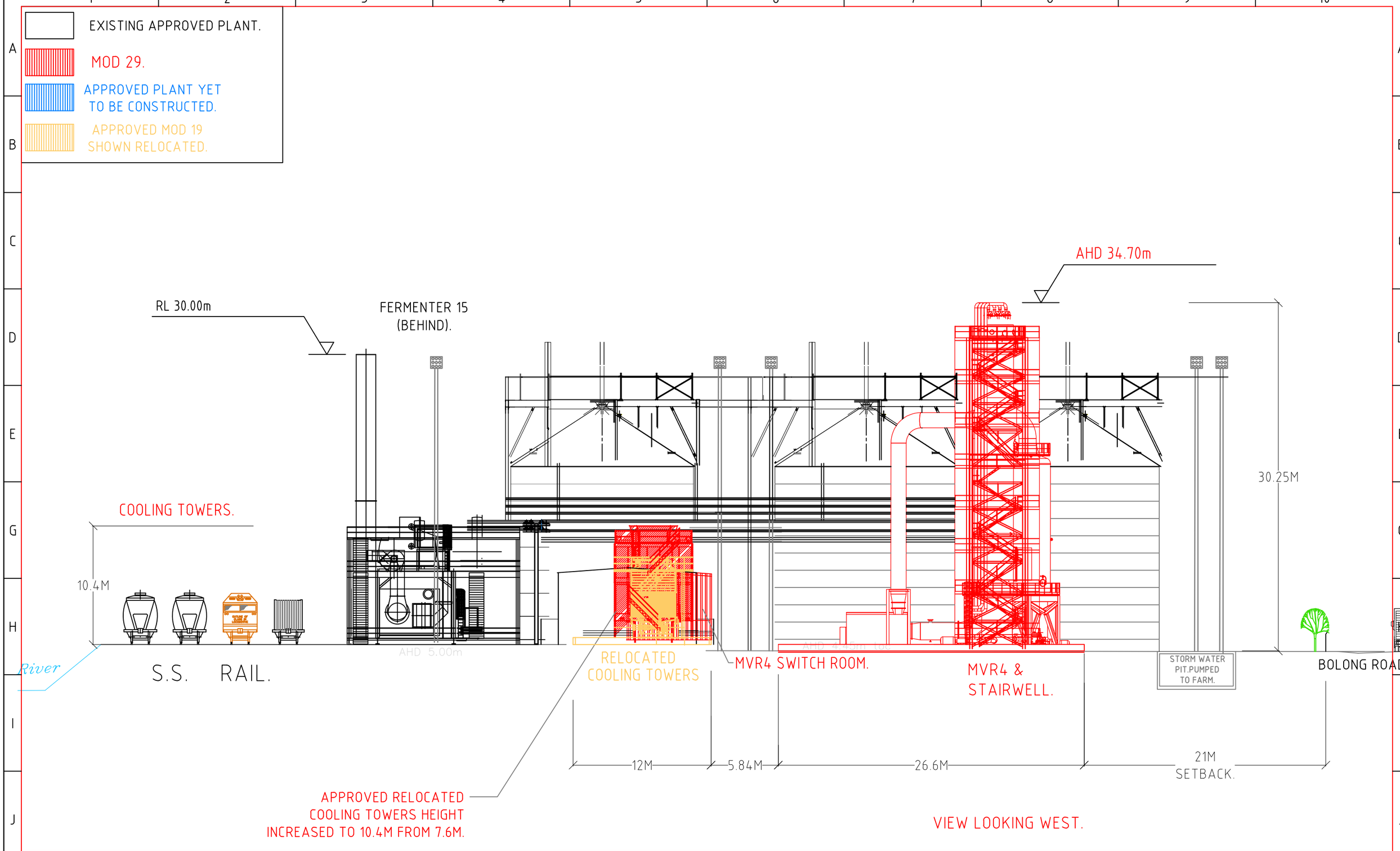
P.C.	01/12/20	SHOALHAVEN STARCHES.BOMADERRY. NSW	SHT SIZE A3
CHKD BH	DATE	DWG TITLE MOD 29. SITE PLAN VIEW.	
APPD	DATE		REV. P26
	SCALE 1:500	PROJECT No. 7193B	DWG No. MN7193-002

EXISTING APPROVED PLANT.

MOD 29.

APPROVED PLANT YET TO BE CONSTRUCTED.

APPROVED MOD 19 SHOWN RELOCATED.



REV	ZONE	DETAILS	DRN	DATE	CHKD	APPD
P18	ALL	Scaled back & was part of mod 22.	P.C.	05-02-24	JS	
P17	ALL	Substation extension added.Completed works now shown grey.	P.C.	14-07-23	B.H.	
P16	ALL	Scrubber stack heights increased.Air cons added to sub.	P.C.	12-4-23	B.H.	
P15	ALL	Cooling towers height increased.	P.C.	20-7-22	B.H.	
P14	ALL	Layout reconfigured.	P.C.	01-7-22	B.H.	

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Est. 2001

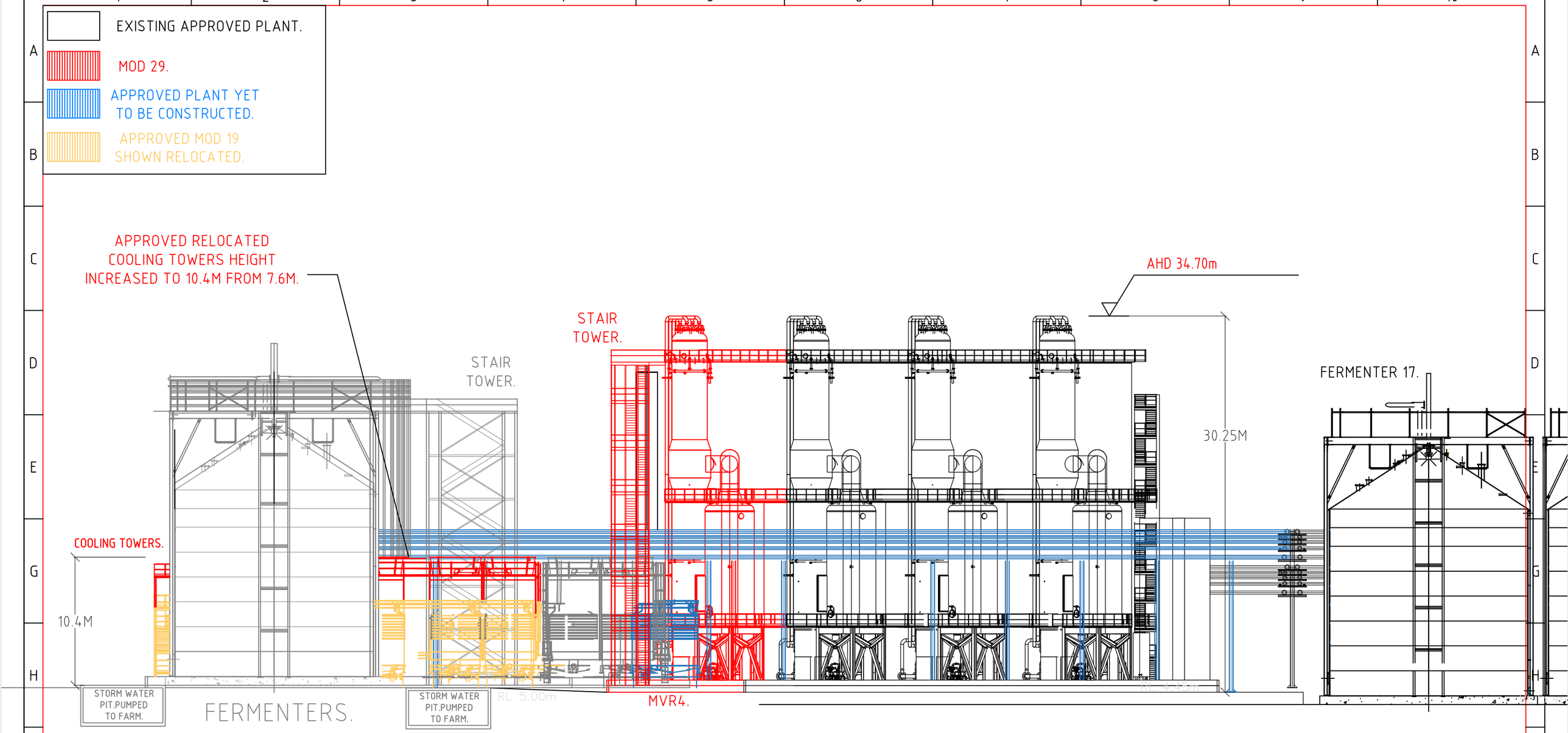
DRAWN	DATE	JOB TITLE		SHT SIZE
P.C.		25/06/19	SHOALHAVEN STARCHES.BOMADERRY. NSW	A3
CHKD T.J.	DATE	DWG TITLE	MOD 29. EASTERN ELEVATION.	REV.
APPD	DATE			P18
	SCALE 1:500	PROJECT No. 7193D	DWG No. MN7193-003	

EXISTING APPROVED PLANT.

MOD 29.

APPROVED PLANT YET TO BE CONSTRUCTED.

APPROVED MOD 19 SHOWN RELOCATED.



VIEW LOOKING SOUTH FROM BOLONG ROAD. (LANDSCAPING SCREEN NOT SHOWN).

REV	ZONE	DETAILS	DRN	DATE	CHKD	APPD
P20	ALL	Stair tower added.	P.C.	13-02-24	JS	
P19	ALL	Scaled back & was part of mod 22.	P.C.	05-02-24	JS	
P18	ALL	Substation extension added.Completed works now shown grey.	P.C.	14-07-23	B.H.	
P17	ALL	Scrubber stack heights increased.#12 & existing added.	P.C.	12-4-23	B.H.	
P16	ALL	Stair tower moved 1m east.	P.C.	12-10-22	DJ	
P15	ALL	Cooling towers height increased.	P.C.	20-7-22	B.H.	
P14	ALL	Layout reconfigured.	P.C.	01-7-22	B.H.	

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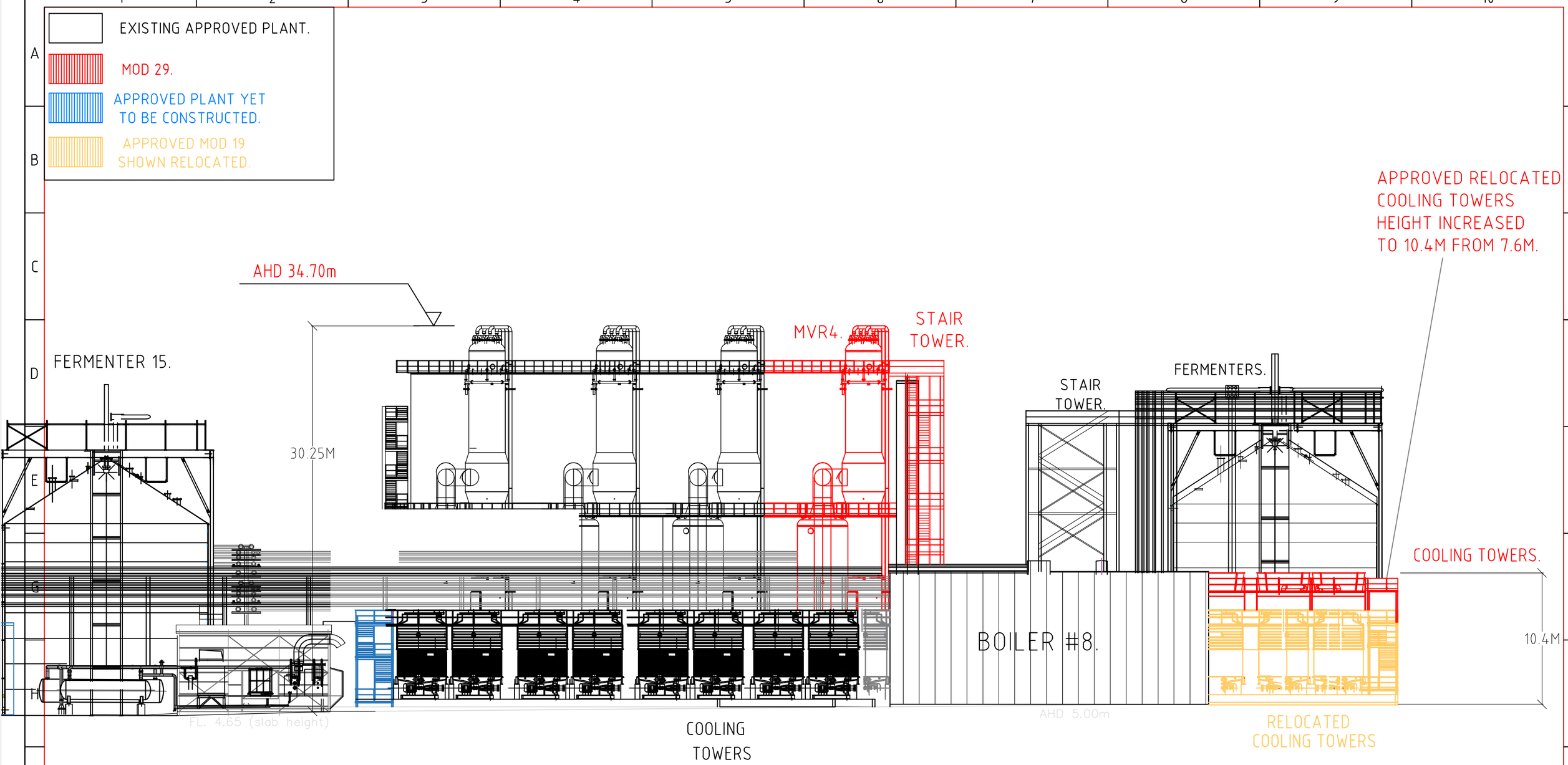
DRAWN P.C.	DATE 25/06/19	JOB TITLE SHOALHAVEN STARCHES.BOMADERRY. NSW	SHT SIZE A3
CHKD T.J.	DATE	DWG TITLE MOD 29. NORTHERN ELEVATION.	
APPD	DATE		REV. P20
	SCALE 1:500	PROJECT No. 7193D	DWG No. MN7193-004

EXISTING APPROVED PLANT.

MOD 29.

APPROVED PLANT YET TO BE CONSTRUCTED.

APPROVED MOD 19 SHOWN RELOCATED.



VIEW LOOKING NORTH.

REV	ZONE	DETAILS	DRN	DATE	CHKD	APPD
P22	ALL	Proposed new cooling towers removed.	P.C	13-02-24	JS	
P21	ALL	Scaled back & was part of mod 22.	P.C	05-02-24	JS	
P20	ALL	Substation extension added.Completed works now shown grey.	P.C	14-07-23	B.H	
P19	ALL	Scrubber stack heights increased.Air cons added to sub.	P.C	12-4-23	B.H	
P18	ALL	Stair tower moved 1m east.	P.C	12-10-22	DJ	
P17	ALL	Cooling towers height increased.	P.C	20-7-22	B.H	

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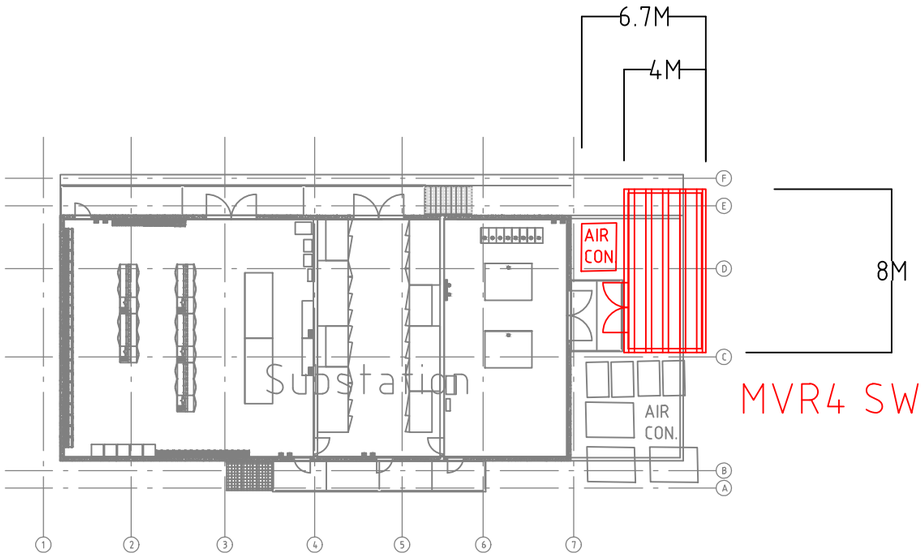
DRAWN P.C.	DATE 25/06/19	JOB TITLE SHOALHAVEN STARCHES.BOMADERRY. NSW	SHT SIZE A3
CHKD	DATE	DWG TITLE MOD 29. SOUTHERN ELEVATION.	REV. P22
APPD	DATE		
	SCALE 1:300	PROJECT No. 7193D / DWG No. MN7193-005	

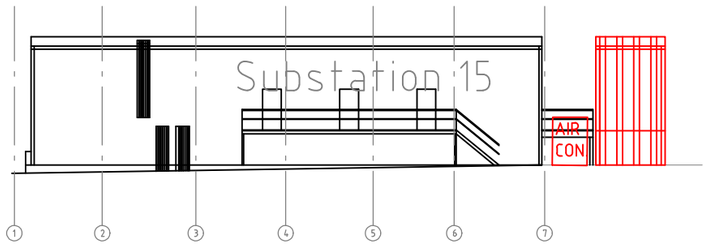
EXISTING APPROVED PLANT.

MOD 29 PROPOSALS.

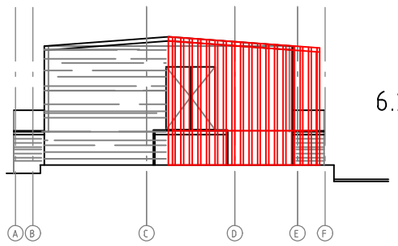


MVR4 SWITCH ROOM.

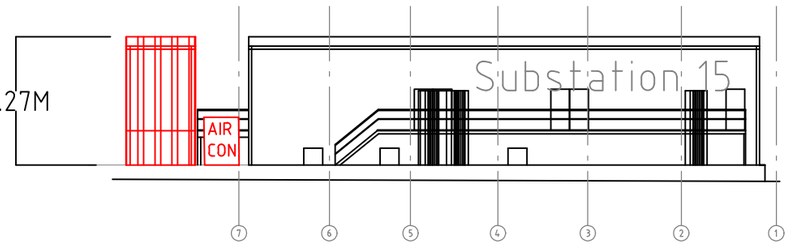
PLAN VIEW.



SOUTHERN ELEVATION.



EASTERN ELEVATION.



NORTHERN ELEVATION.

REV	ZONE	DETAILS	DRN	DATE	CHKD	APPD
P06	ALL	Top floor extension removed.	P.C.	5-2-24	JS	
P05	B4	Eastern extension added.	P.C.	13-7-23	B.H.	
P04	ALL	Air con units/roof top added.	P.C.	19-4-23	B.H.	
P03	ALL	AHD added.	P.C.	12-12-22	B.H.	
P02	ALL	Stair heights adjusted.	P.C.	19-7-22	B.H.	
P01	ALL	New proposal.	P.C.	6-6-22	B.H.	

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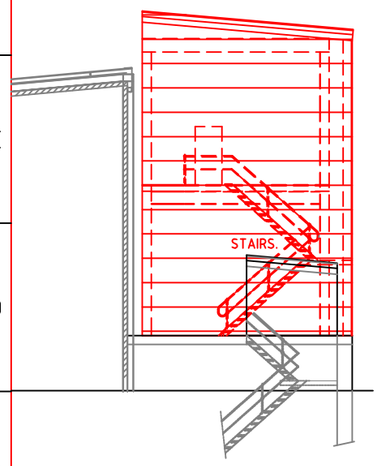
DRAWN	DATE	JOB TITLE	
P.C.	6/06/22		SHOALHAVEN STARCHES.BOMADERRY. NSW
CHKD B.H.	DATE	DWG TITLE	MOD 29. MVR4 SWITCH ROOM.
APPD	DATE		
	SCALE 1:300	PROJECT No. 7769B	DWG No. MN7193-006

SHT SIZE A3

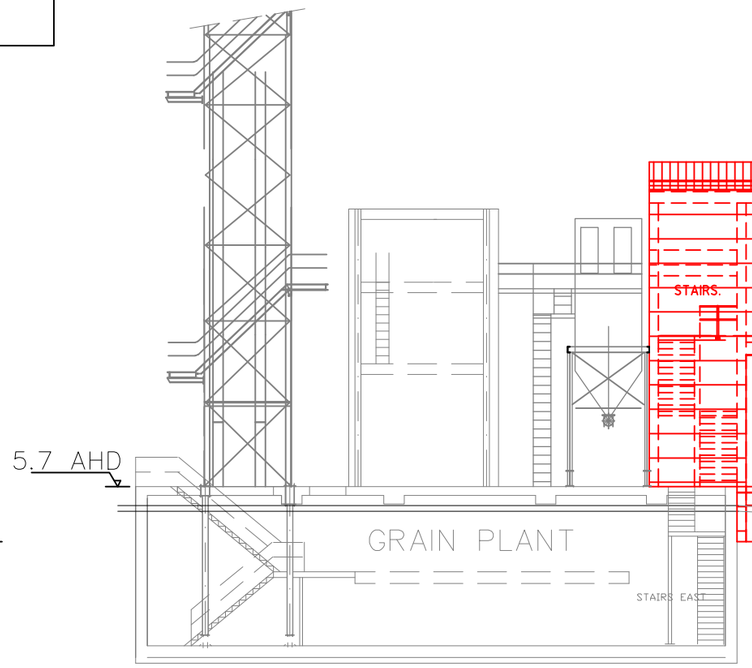
REV. P06

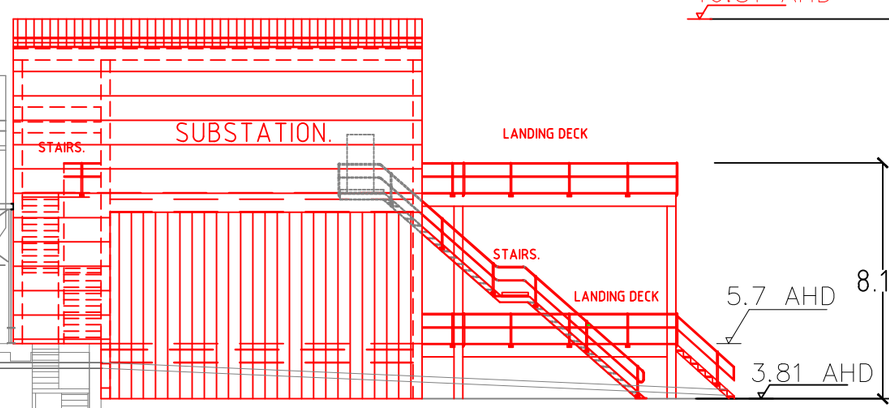
EXISTING APPROVED PLANT.

MOD 29.

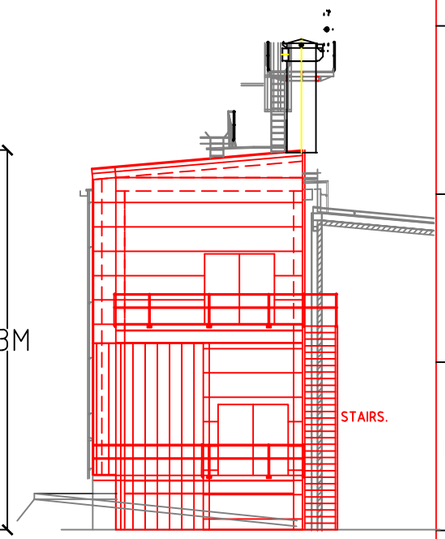


WESTERN ELEVATION.

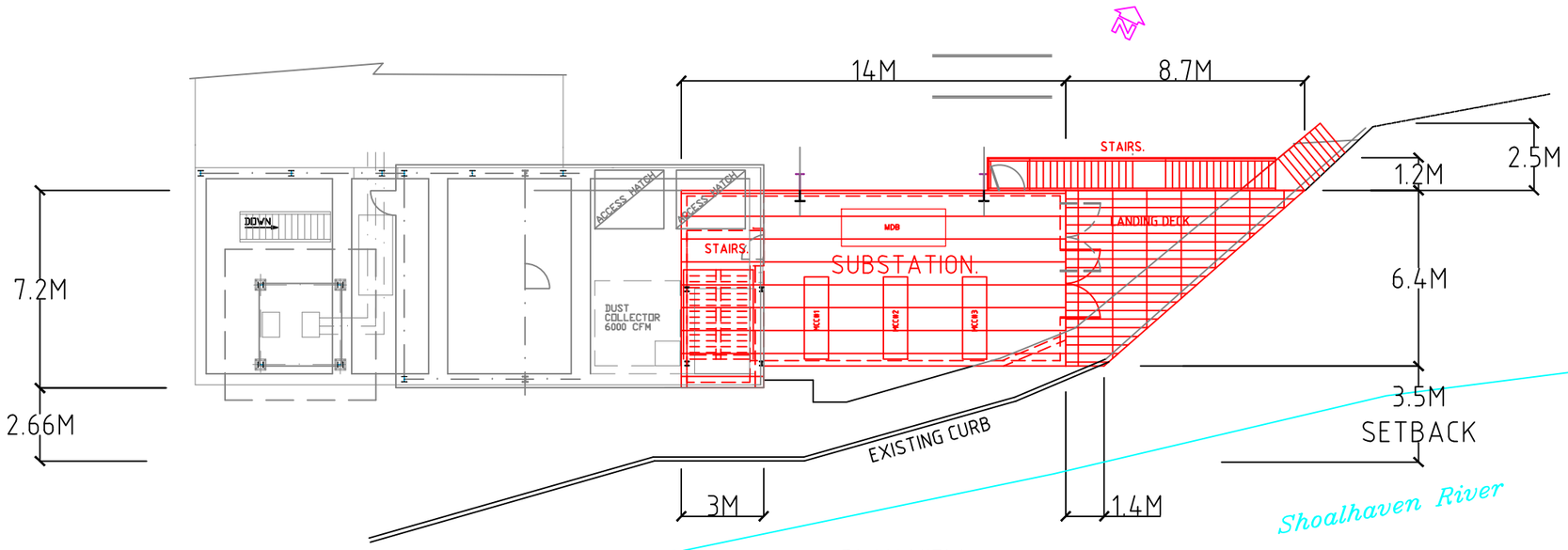




SOUTHERN ELEVATION.



EASTERN ELEVATION.



PLAN VIEW.

REV	ZONE	DETAILS	DRN	DATE	CHKD	APPD
P07	ALL	Was mod 22.	P.C.	7/02/24		
P06	ALL	Indicative Mod 26 removed.	P.C.	14/07/23		
P05	ALL	Indicative Mod 26 added.	P.C.	01/08/22		
P04	ALL	North-eastern stairs added.	P.C.	26/07/22		
P03	ALL	Was MN7769-009.	P.C.	21/07/22	BH	
P02	ALL	Was MN7079-013.	P.C.	10/11/21	BH	
P01	ALL	First proposal.	P.C.	30/8/21	JC	PW

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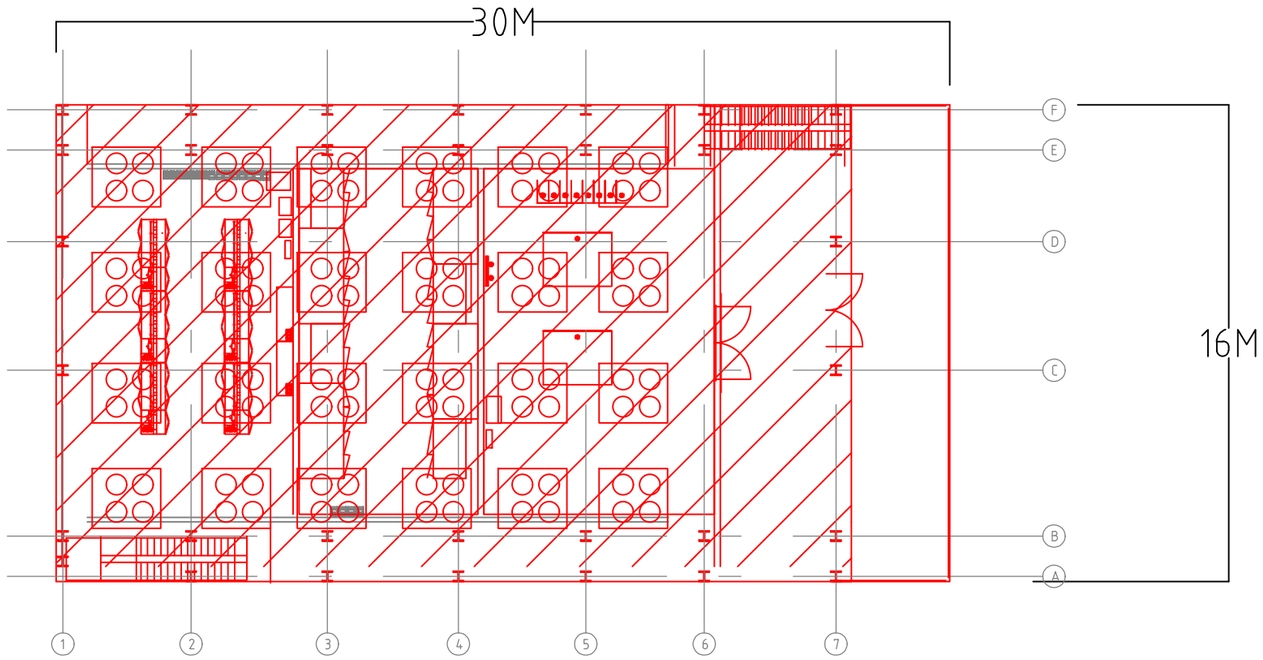
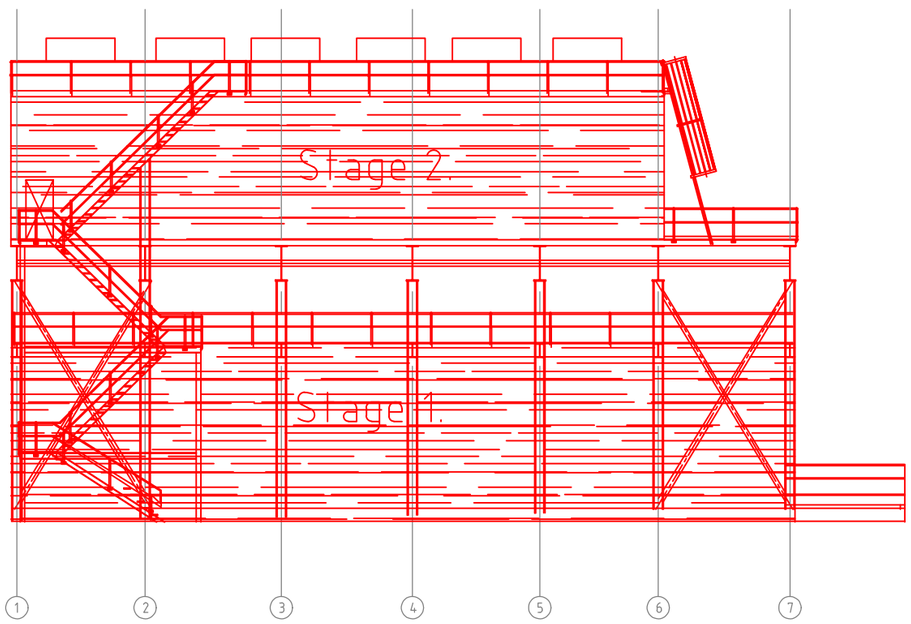
Est. 2001

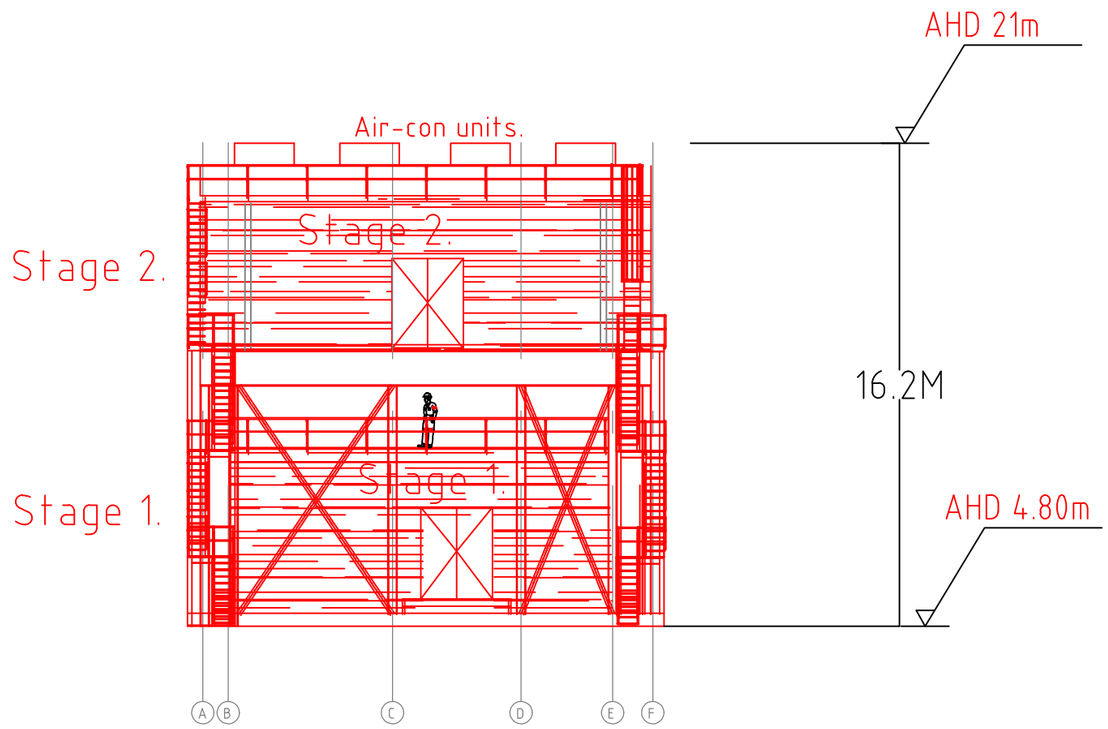
P.C.		SHOALHAVEN STARCHES .BOMADERRY.NSW.	SHT SIZE A3
CHKD JC	DATE 30/8/21	DWG TITLE MOD 29. STARCH & GLUCOSE PLANT SUBSTATION.	
APPD	DATE		REV. P07
	SCALE 1:200	PROJECT No. 7532 / DWG No. MN7193-010	



PLAN VIEW.



SIDE ELEVATION.



END ELEVATION.

REV	ZONE	DETAILS	DRN	DATE	CHKD	APPD
P02	ALL	This drawing was the container inverter.	P.C.	14-8-23	JC	
P01	ALL	New proposal.	P.C.	14-8-23	JC	

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0439 436508
Est. 2001

DRAWN P.C.	DATE 14/08/23	JOB TITLE SHOALHAVEN STARCHES.BOMADERRY. NSW	SHT SIZE A3
CHKD JC	DATE	DWG TITLE MOD 29. MAIN DISTRIBUTION SUB-STATION 0.2 & 0.3.	
APPD	DATE		REV. P02
	SCALE 1:200	PROJECT No. 7549-013 / DWG No. MN7549-013	

MOD 29.

PROJECT No. 7193D

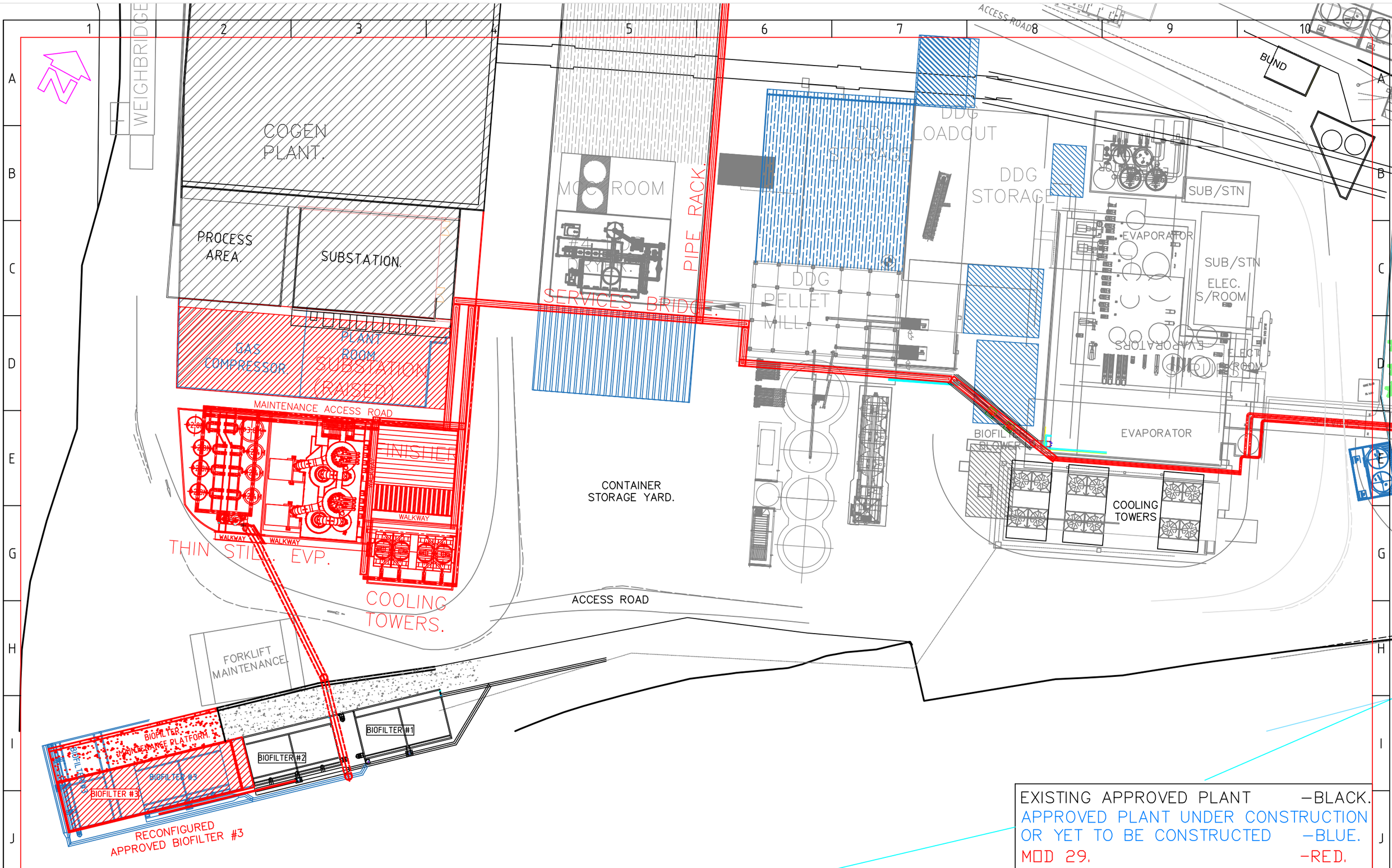
13/02/24

FERMENTER ADDITIONS.

Drawing No.	REV.	
MN7193-001	P36	SITE PLAN.
MN7193-002	P26	SITE PLAN VIEW.
MN7193-003	P18	EASTERN ELEVATION.
MN7193-004	P20	NORTHERN ELEVATION.
MN7193-005	P22	SOUTHERN ELEVATION.
MN7193-006	P06	MVR4 SWITCH ROOM.
MN7193-010	P07	STARCH & GRAIN PLANT SUBSTATION.
MN7549-013	P02	MAIN DISTRIBUTION SUBSTATION 0.2 & 0.3

EVAPORATOR UPGRADE.

MN7838-001	P14	SITE PLAN VIEW.
MN7838-002	P11	SITE SOUTHERN ELEVATION.
MN7838-003	P07	SITE EASTERN ELEVATION.
MN7838-004	P03	FINISHER GA.
MN7838-005-1	P01	THIN STILLAGE EVAPORATOR.GA.
MN7838-005-2	P01	THIN STILLAGE EVAPORATOR.3D.
MN7838-006	P04	SUBSTATION RAISED GA.
MN7838-008	P06	COOLING TOWER GA.
MN7838-009	P07	BIO-FILTER LAYOUT.
MN7838-013	P03	TANK FARM.
1752-001	A	BIO-FILTER GA.



EXISTING APPROVED PLANT —BLACK.
APPROVED PLANT UNDER CONSTRUCTION OR YET TO BE CONSTRUCTED —BLUE.
MOD 29. —RED.

REV	ZONE	DETAILS	DRN	DATE	CHKD	APPD
P14	G2	Scrubber added.	P.C.	12/2/24	TC	
P13	ALL	Stage 1 shown only.	P.C.	05/2/24	JS	
P12	E3	Evaporator footprint supplied from ETEA.	P.C.	10/7/23	FRAN.	
P11	E3	Evaporator recon.	P.C.	25/6/23	FRAN.	

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P.C.

CHKD: IGOR
DATE: 28/05/22
APPD:
DATE:
SCALE: 1:600

SHOALHAVEN STARCHES.BOMADERRY.NSW.

DWG TITLE: MOD 29.EVAPORATOR UPGRADE. SITE PLAN.

PROJECT No. 7838-SP

DWG No. MN7838-001

A3

REV. P14

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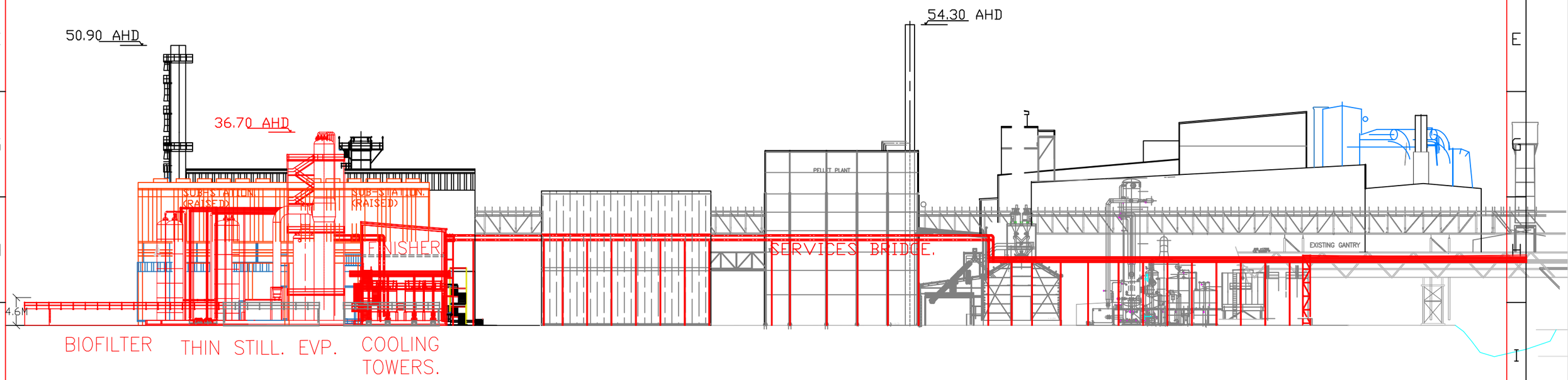
MOD 29 -RED.



REV	ZONE	DETAILS	DRN	DATE	CHKD	APPD
P11	ALL	Proposal reduced.Was Mod 29.	P.C.	6/2/24	J.S.	
P10	ALL	Biofilter layout updated.	P.C.	24/7/23	FT	
P09	G5	Thin stillage evaporator 100mm higher.	P.C.	10/07/23	FT	
P08	G5	Stack added.	P.C.	27/04/23	J.S.	
P07	ALL	Cooling tower remodeled.	P.C.	20/04/23	FT	
P06	ALL	Mill feed silos added.	P.C.	17/04/23	FT	
P05	ALL	#6 DDG Dryer building extension.	P.C.	23/12/22	J.S.	

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P.C.		SHOALHAVEN STARCHES.BOMADERRY.NSW.	A3
CHKD IGOR	DATE 28/05/22	DWG TITLE MOD 29.EVAPORATOR UPGRADE. SITE SOUTHERN ELEVATION.	REV.
APPD	DATE		
	SCALE 1:600	PROJECT No. 7838 / DWG No. MN7838-002	P11

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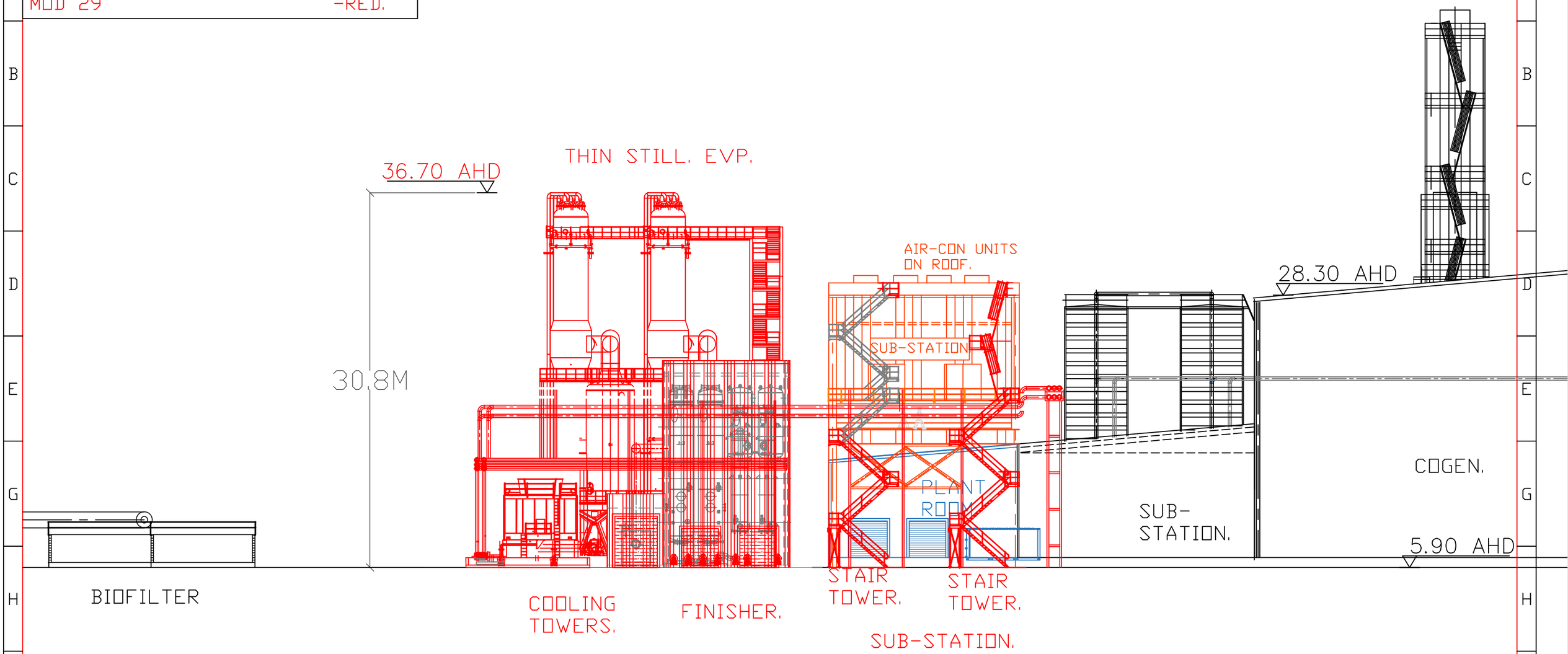
MOD 29 —RED.



EASTERN ELEVATION AT EVAPORATORS.

REV	ZONE	DETAILS	DRN	DATE	CHKD	APPD
P07	ALL	Proposal scaled back.Was Mod 22.	P.C.	6/2/24	JS	
P06	ALL	Biofilter layout updated.	P.C.	24/7/23	FT	
P05	ALL	Thin stillage evaporator 100mm higher.	P.C.	10/7/23	FT	
P04	ALL	Cooling towers remodeled.	P.C.	20/4/23	B.H.	
P03	ALL	Substation remodeled.	P.C.	17/4/23	B.H.	
P02	ALL	AHD added.	P.C.	12/12/22	B.H.	
P01	ALL	First issue.	P.C.	27/06/22	B.H.	

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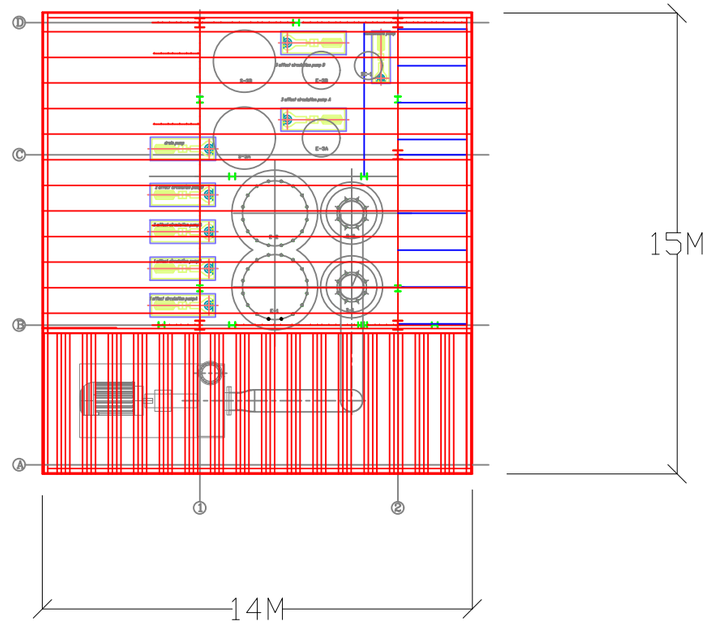
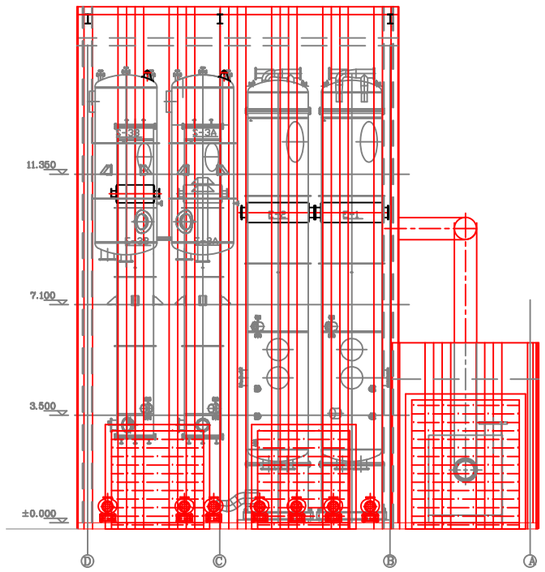
P.C.		SHOALHAVEN STARCHES.BOMADERRY.NSW.	A3
CHKD IGOR	DATE 28/05/22	DWG TITLE MOD 29.EVAPORATOR UPGRADE. SITE EASTERN ELEVATION.	
APPD	DATE		REV.
	SCALE 1:300	PROJECT No. 7838 / DWG No. MN7838-003	P07

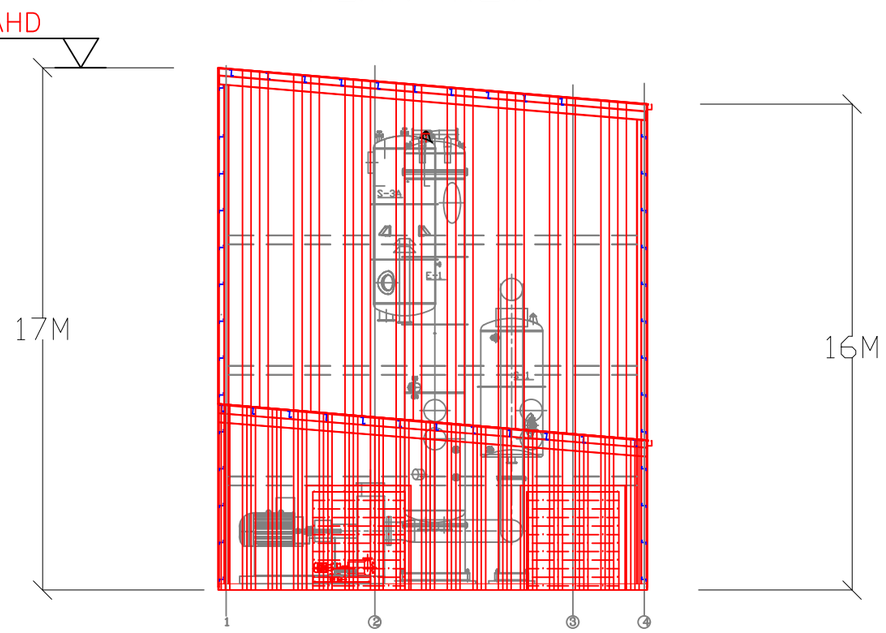
MOD 29 -RED.



PLAN VIEW.



FRONT ELEVATION.



SIDE ELEVATION.

REV	ZONE	DETAILS	DRN	DATE	CHKD	APPD
P03	ALL	Was part of Mod 22.	P.C.	6/2/24	JS	
P02	ALL	AHD added.	P.C.	12/12/22	B.H.	
P01	ALL	First Issue.	P.C.	27/06/22	B.H.	

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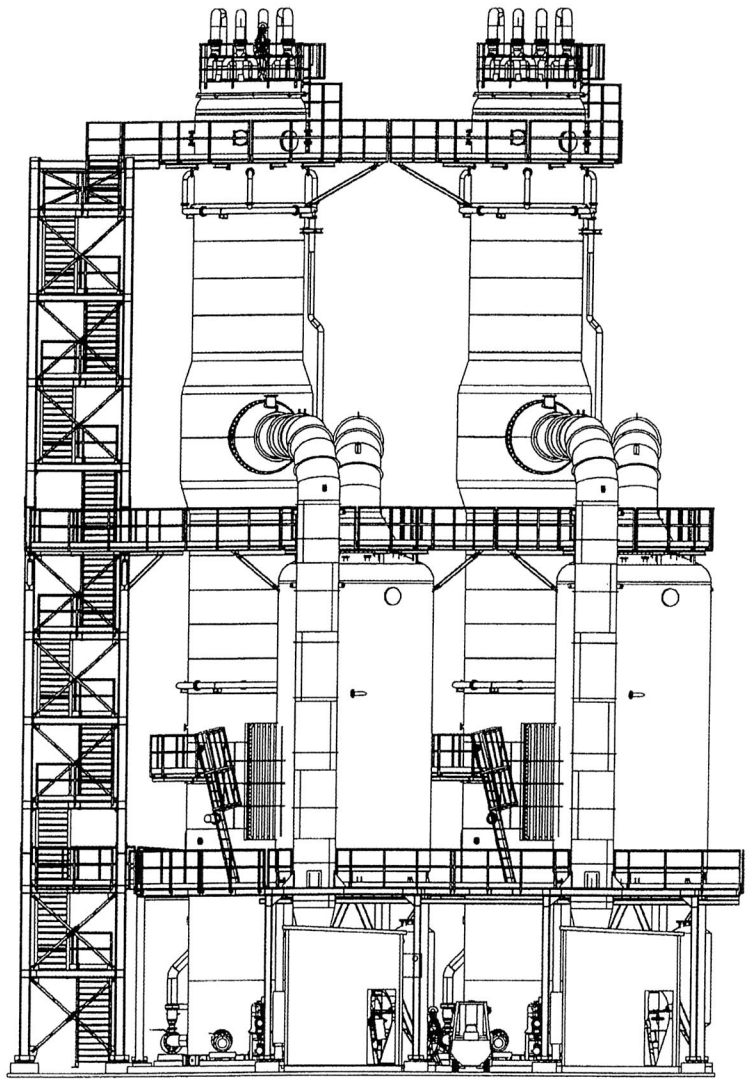
P.C.		SHOALHAVEN STARCHES.BOMADERRY.NSW.
CHKD IGOR	DATE 28/05/22	DWG TITLE MOD 29.EVAPORATOR UPGRADE. FINISHER GA.
APPD	DATE	
	SCALE 1:200	PROJECT No. 7838 / DWG No. MN7838-004

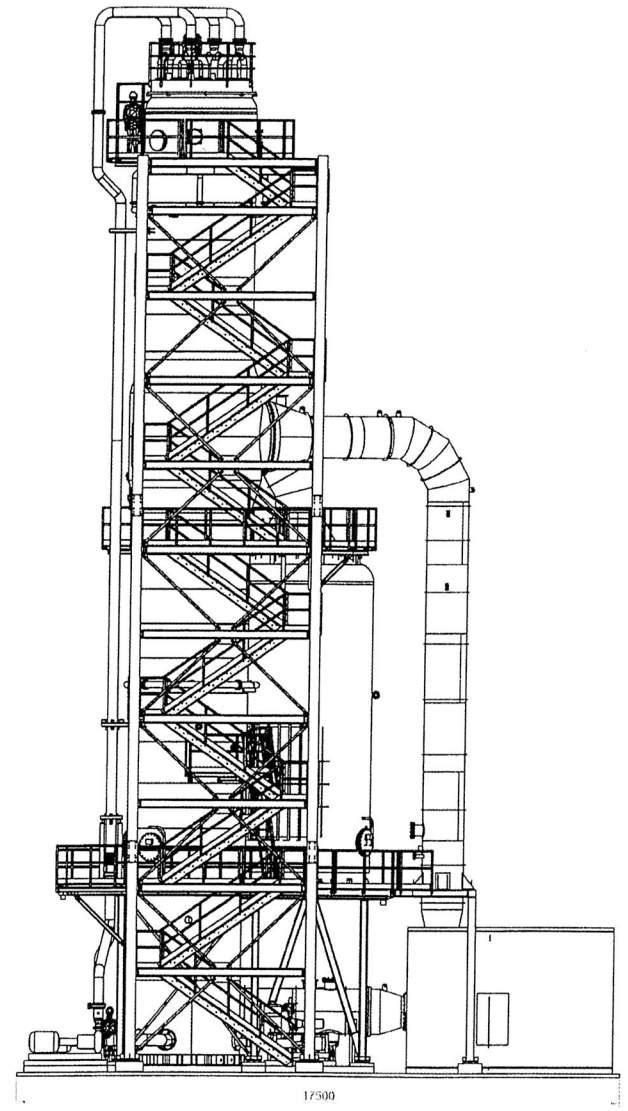
A3

REV. P03

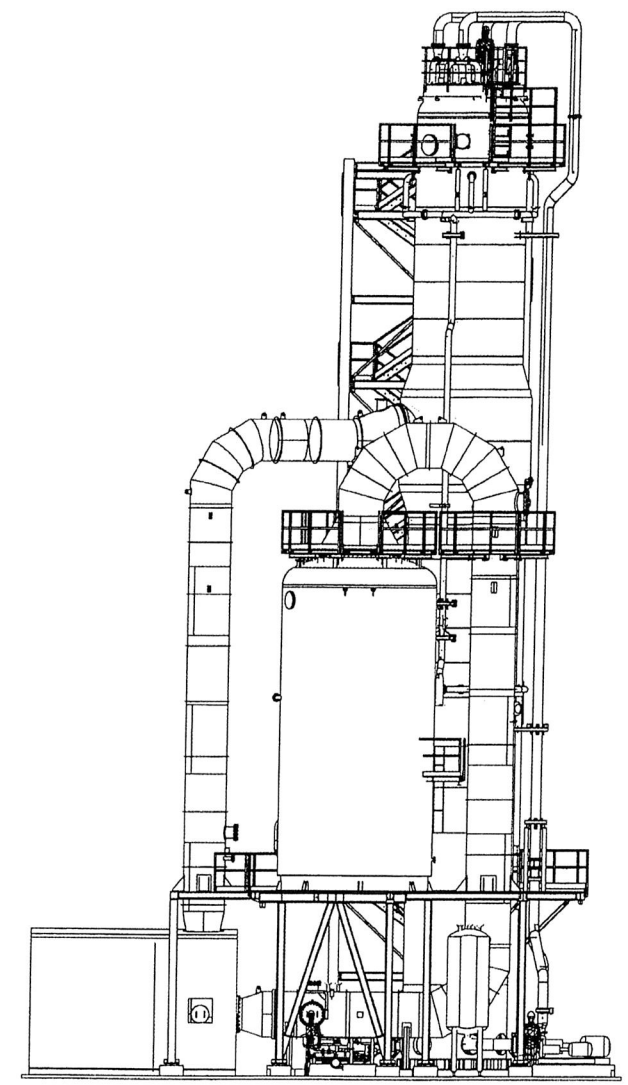
FRONT VIEW



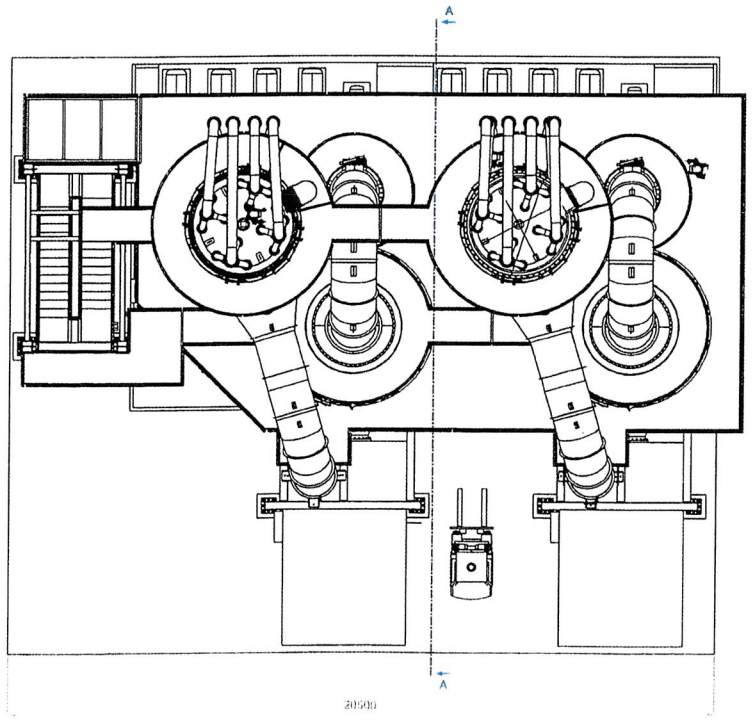
SIDE VIEW



SEC A-A



TOP VIEW



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SHOALHAVEN STARCHES BOMADERRY NSW

DWG TITLE

MOD 29 EVAPORATOR UPGRADE
THIN STILLAGE EVAPORATOR GA

PROJECT No. 7838

DWG No. MN7838-005-1

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Fax. +39.0175.216812

Project: MVRs 7-8

Title: 3D LAYOUT

Type:

Customer: MANILDRA

DWG NR: E52001

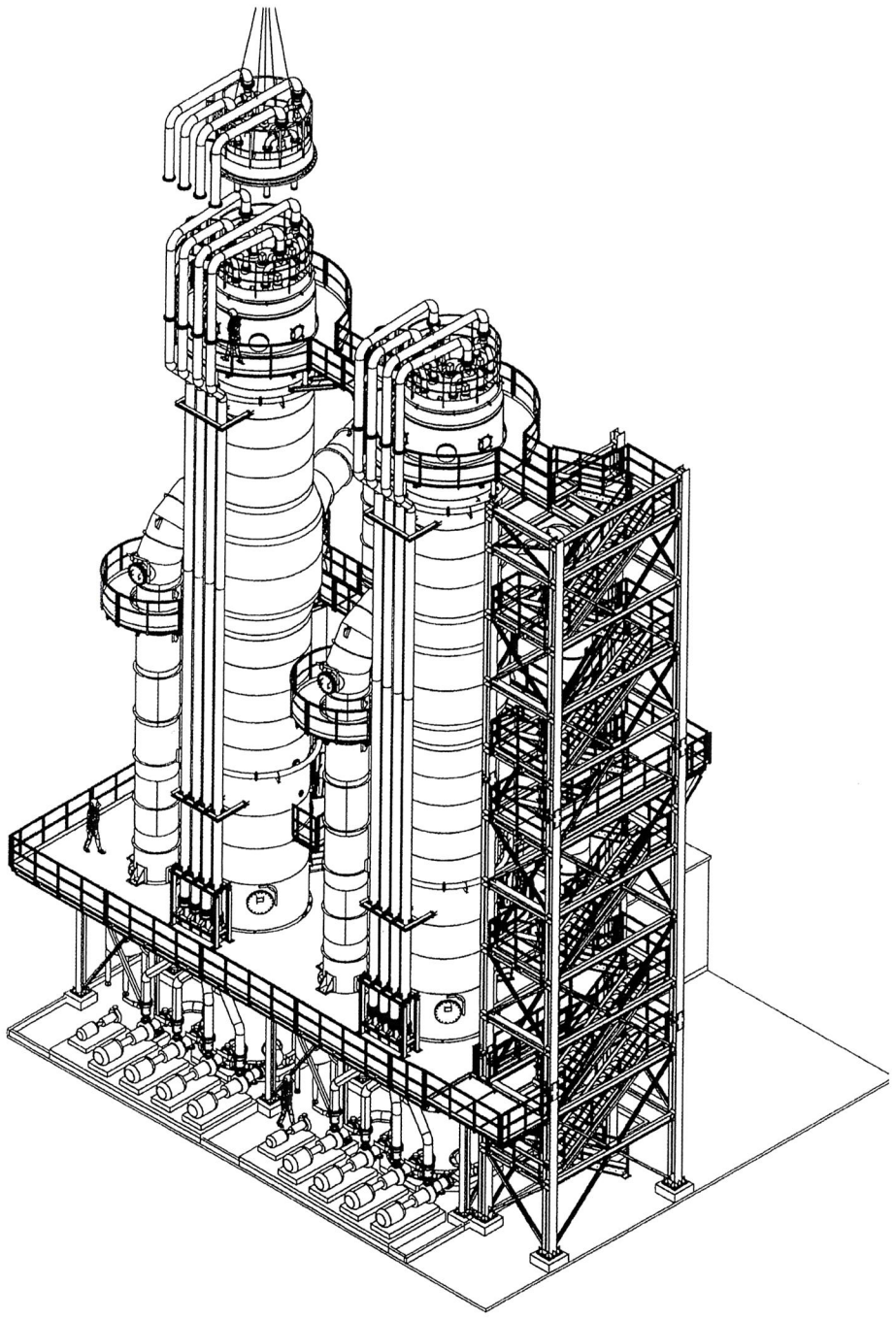
Mod: ----

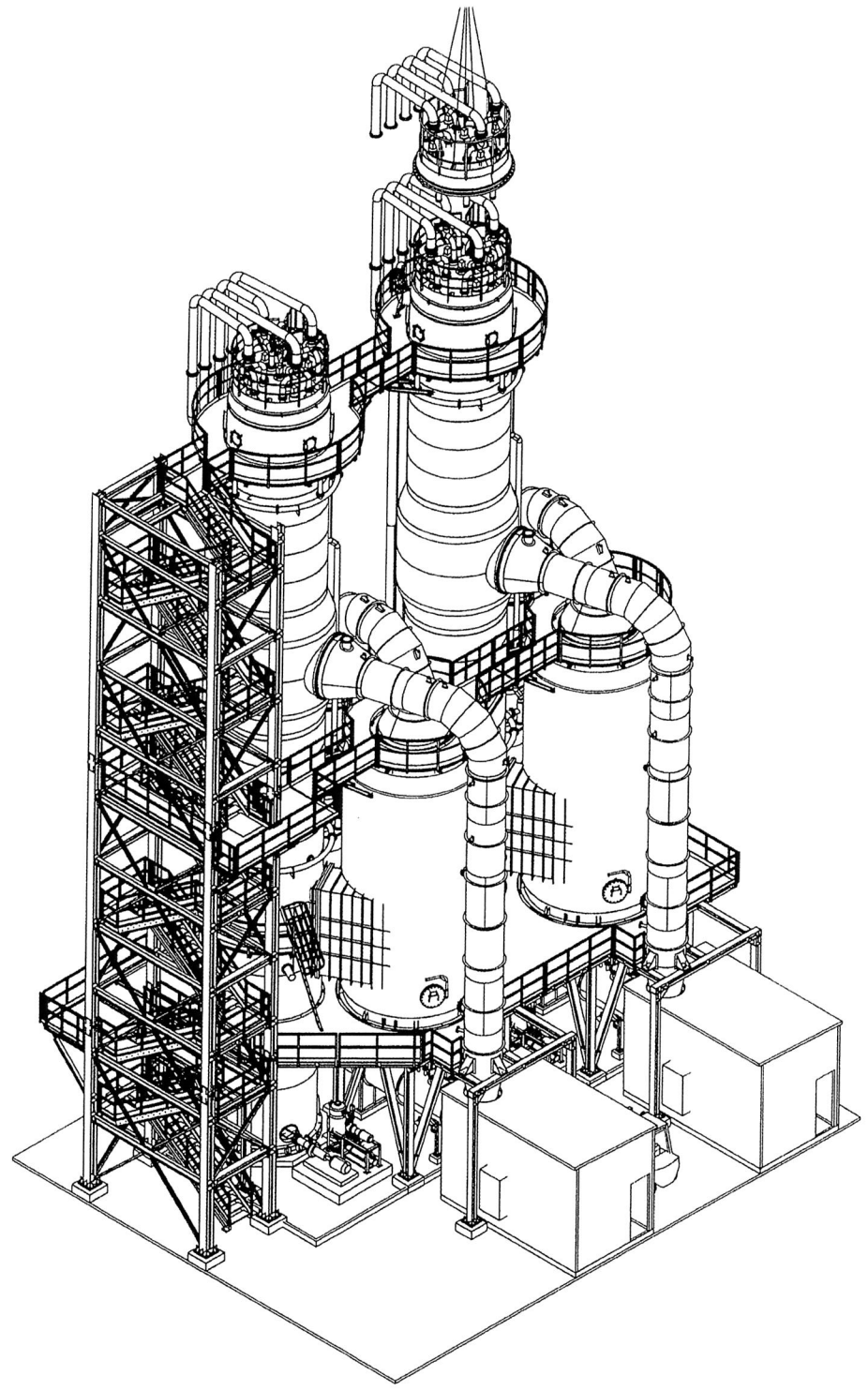
Drawn: 03/11/22 by: Garnero F.

Scale: 1:100

Chk'd: mm/dd/yy by: Surname N.

Format: A1





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SHOALHAVEN STARCHES.BOMADERRY.NSW.

DWG TITLE

MOD 2a EVAPORATOR UPGRADE.
THIN STILLAGE EVAPORATOR GA.3D.

PROJECT No. 7838

DWG No. MN7838-005-2

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Project: MVRs 7-8

Title: 3D LAYOUT

Type:	Customer: MANILDRA	DWG NR: E52001	rlv: ----
		Drawn: 03/11/22 by: Garnero F.	Scale: 1:100
		Chk'd: mm/dd/yy by: Surname N.	Format: A1

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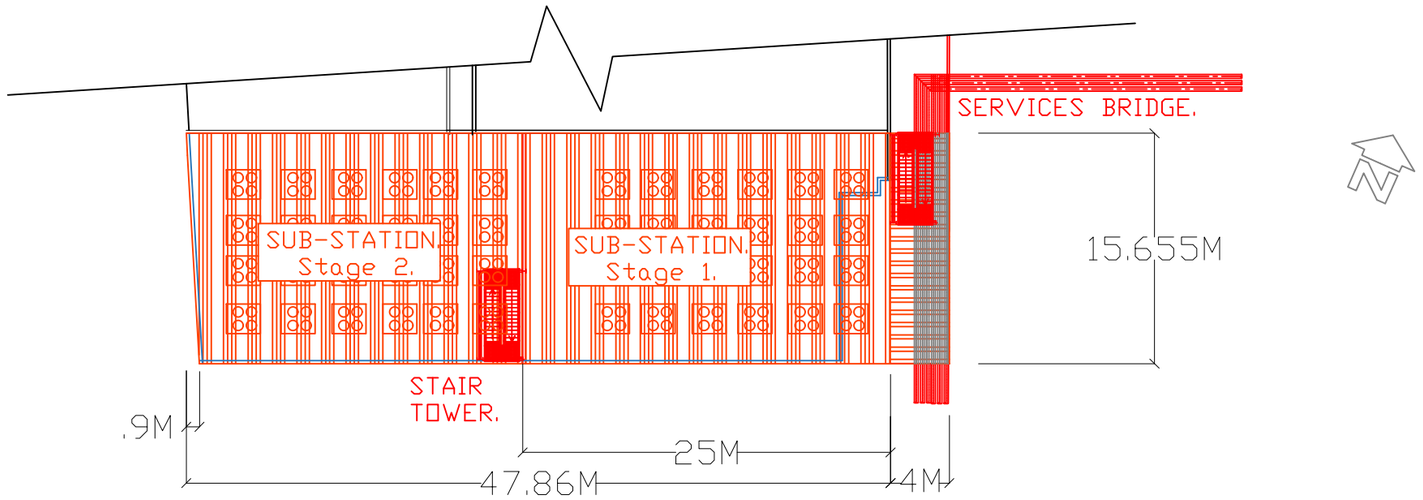
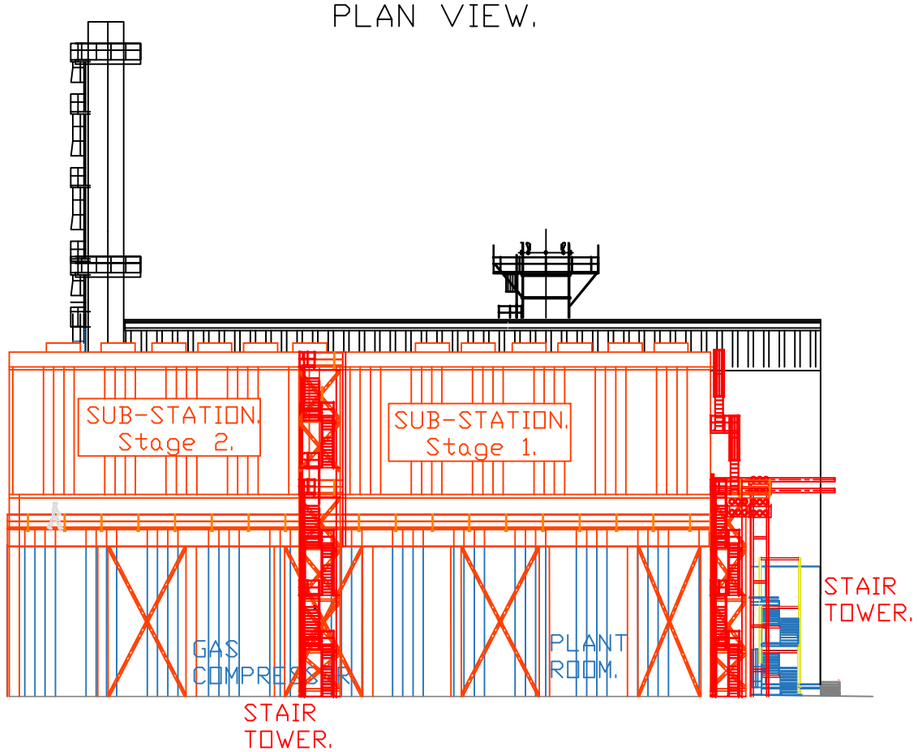
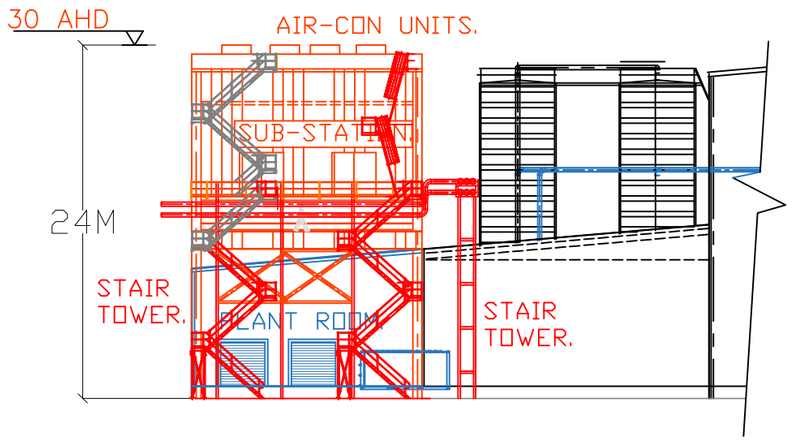
EXISTING APPROVED PLANT —BLACK.
APPROVED PLANT UNDER CONSTRUCTION OR YET TO BE CONSTRUCTED —BLUE.
MOD 29 —RED.



PLAN VIEW.



SOUTHERN ELEVATION



EASTERN ELEVATION

REV	ZONE	DETAILS	DRN	DATE	CHKD	APPD
P04	ALL	Proposal scaled back.Was part of Mod 22.	P.C.	6/2/24	JS	
P03	ALL	AHD increased.Air-con added.	P.C.	17/4/23	FT	
P02	ALL	AHD added.	P.C.	12/12/22	B.H.	
P01	ALL	First issue.	P.C.	27/06/22	B.H.	

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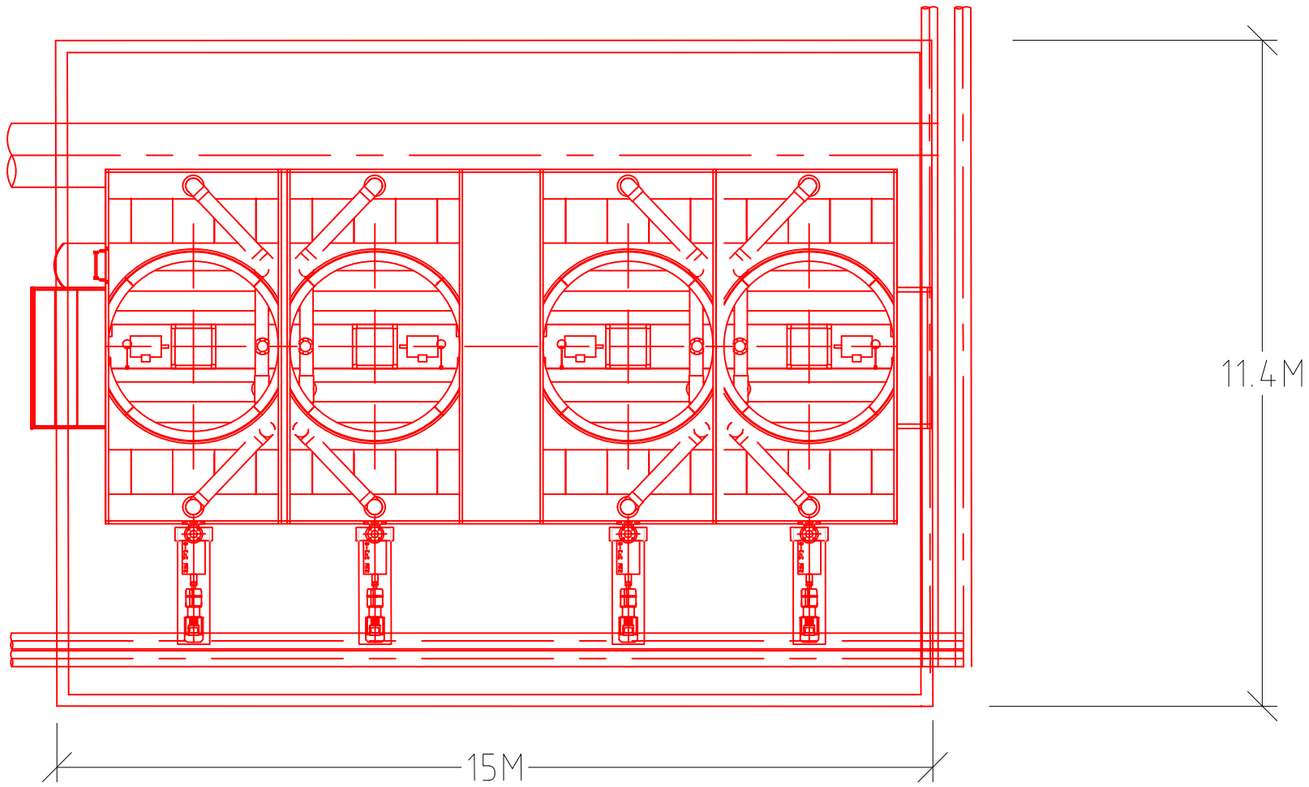
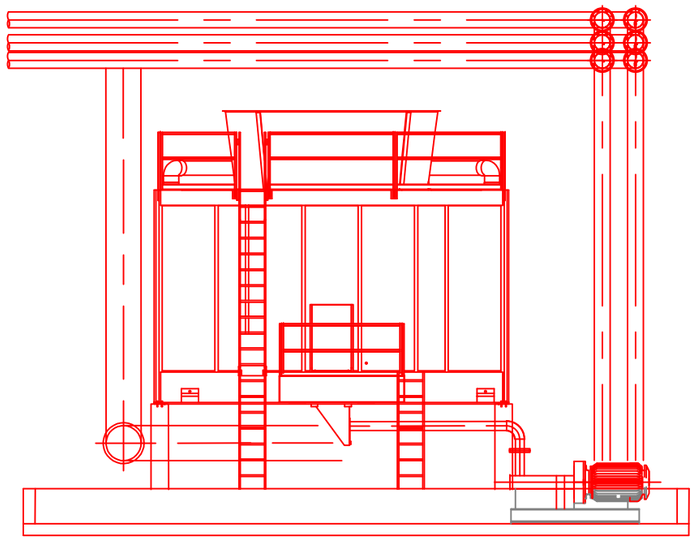
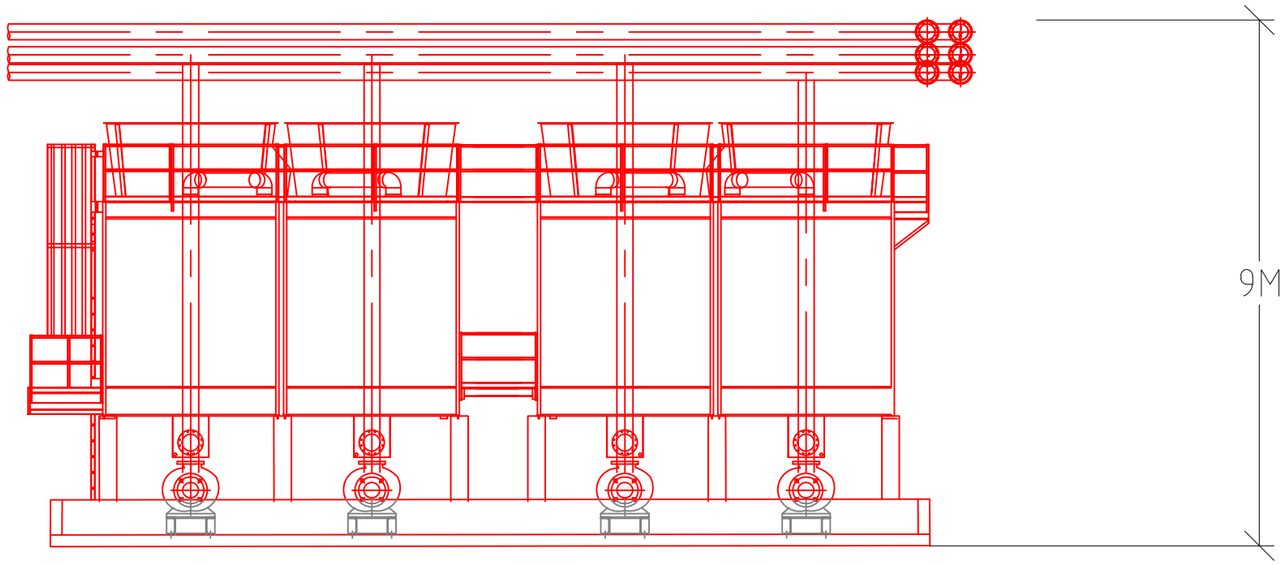
P.C.		SHOALHAVEN STARCHES.BOMADERRY.NSW.	A3
CHKD IGOR	DATE 28/05/22	DWG TITLE MOD 29.EVAPORATOR UPGRADE. RAISED SUB-STATION.	REV.
APPD	DATE		
	SCALE 1:400	PROJECT No. 7838 / DWG No. MN7838-006	P04



PLAN VIEW.



END ELEVATION.



SIDE ELEVATION.

REV	ZONE	DETAILS	DRN	DATE	CHKD	APPD
P06	ALL	Was mod 22.	P.C.	06/2/24	J.S.	
P05	C10	Cooling tower was 10.1m wide.	P.C.	26/04/23	FT	
P04	ALL	Cooling tower model changed.	P.C.	20/04/23	FT	
P03	ALL	AHD added.	P.C.	12/12/22	J.S.	
P02	ALL	Western cooling towers now shown.	P.C.	30/11/22	J.S.	
P01	ALL	First issue.	P.C.	18/10/22	B.H.	

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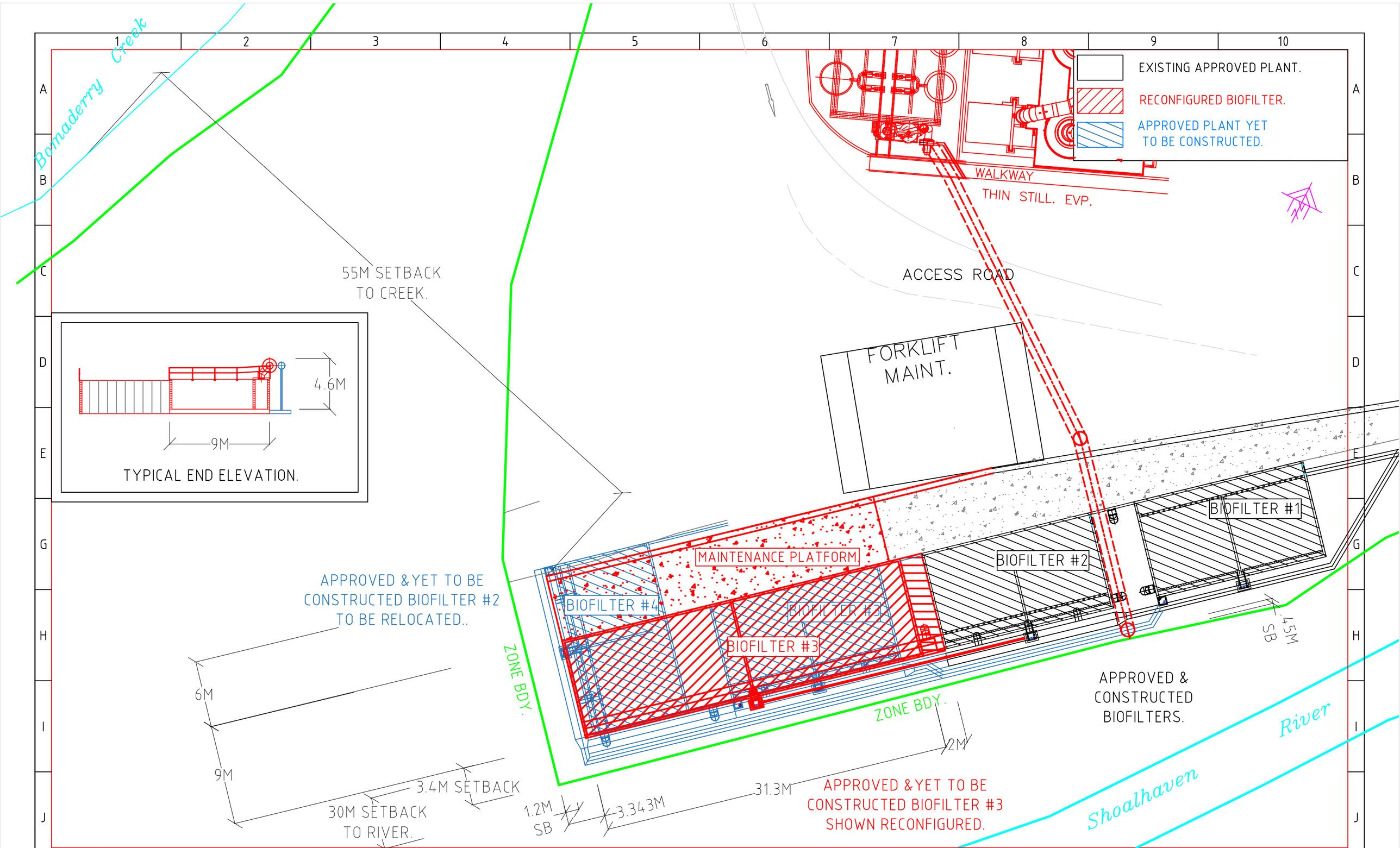
P.C.		SHOALHAVEN STARCHES.BOMADERRY.NSW.	A3
CHKD ---	DATE 18/10/22	DWG TITLE MOD 29.EVAPORATOR UPGRADE. COOLING TOWERS GA.	REV.
APPD	DATE		
	SCALE 1:100	PROJECT No. 7838A / DWG No. MN7838-008	P06



REV	ZONE	DETAILS	DRN	DATE	CHKD	APPD
P07	ALL	Biofilter #3 relo.,evaporator & Thermal oxidiser removed.Was mod 22.	P.C.	23-02-23	JS	
P06	ALL	Biofilter #3 relo.Thermal oxidiser added.	P.C.	23-01-23	TC	
P05	ALL	Approved now relocated.	P.C.	24-11-22	JS	
P04	ALL	Was MN7532-013.Evaporator & fork m'tence added.	P.C.	15-11-22	BH	
P03	ALL	Was MN7462-015.	P.C.	25-07-22	BH	
P02	ALL	Setback to creek added.Title now Mod 25.	P.C.	26-10-21	BH	
P01	ALL	Layout added.	P.C.	29-9-21	PW	

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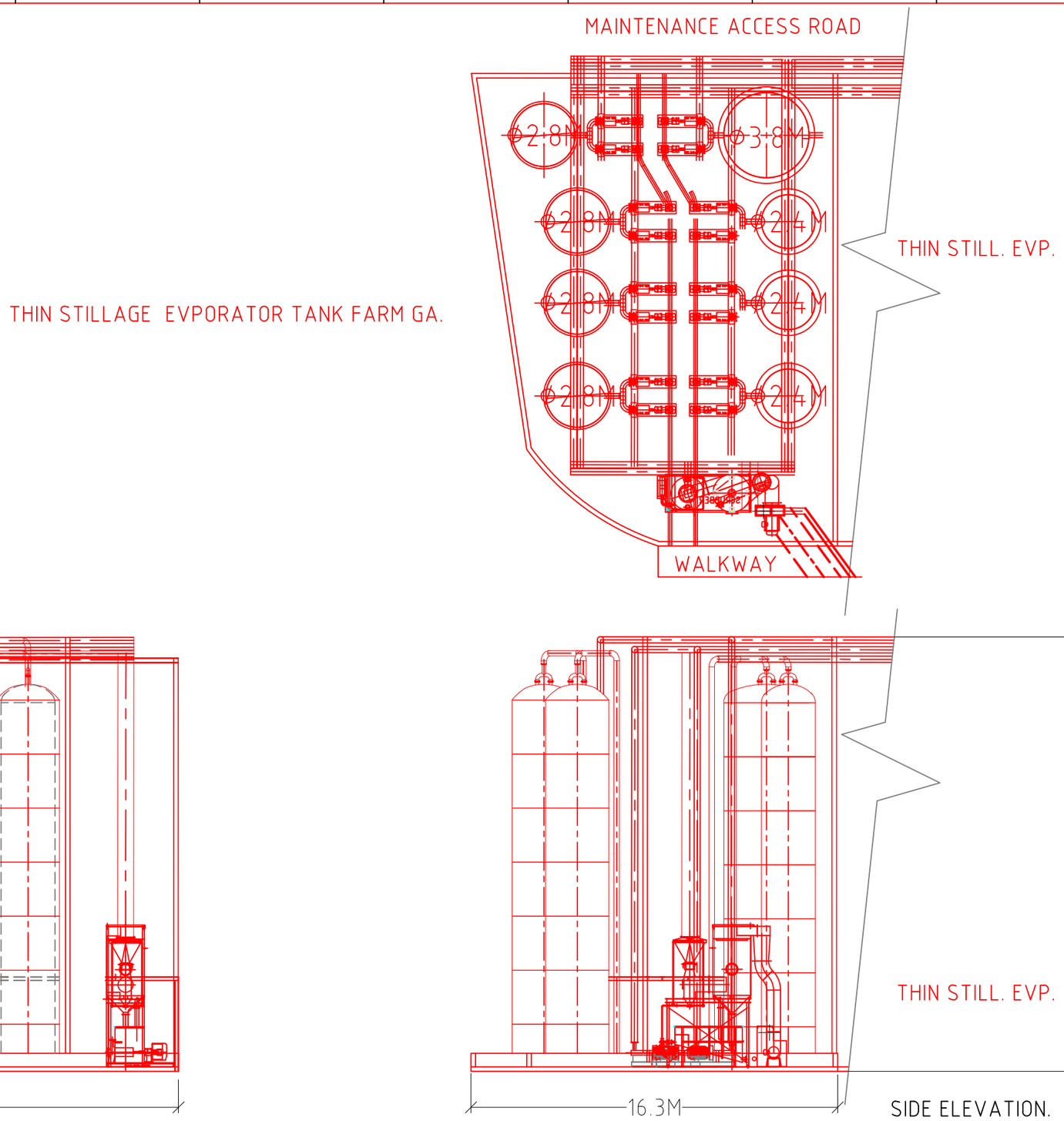
DRAWN	DATE	JOB TITLE	SHOALHAVEN STARCHES.BOMADERRY. NSW	SHT SIZE
P.C.	29/09/21			A3
CHKD BH	DATE	DWG TITLE	MOD 29.EVAPORATOR UPGRADE. BIOFILTER SITE PLAN AND END ELEVATION.	
APPD	DATE			REV.
	SCALE 1:300	PROJECT No. 7462D	DWG No. MN7838-009	P07



END ELEVATION.

SIDE ELEVATION.

REV	ZONE	DETAILS	DRN	DATE	CHKD	APPD
P03	ALL	Scrubber added.	P.C.	12/02/24	TC	
P02	ALL	Was part of mod 22.	P.C.	6/02/24	JS	
P01	ALL	First issue.	P.C.	21/04/23	FT	

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P.C.		SHOALHAVEN STARCHES.BOMADERRY.NSW.	A3
CHKD ---	DATE 21/04/23	DWG TITLE MOD 29.EVAPORATOR UPGRADE. THIN STILLAGE EVPORATOR TANK FARM GA.	REV. P03
APPD	DATE		
	SCALE 1:200	PROJECT No. 7838A / DWG No. MN7838-013	

Appendix C

Environmental Complaints Handling Procedure

System Procedure

Environmental Complaints Handling

Contents

1 Purpose 3
2 Scope 3
3 Specifications 3
4 Action on non-conformance 3
5 Frequency 3
6 Reference 3
7 Procedure 3
8 Review 6
9 Document Control 6

1 Purpose

Effective investigation of environmental complaints.

2 Scope

All environmental complaints.

3 Specifications

Nil

4 Action on non-conformance

Compliance Manager

Environmental & Sustainability Leader

Corrective & Preventative Action Procedure (QMS-P-0130)

5 Frequency

As required.

6 Reference

Flow diagram.

Environmental Complaints Fast Track System

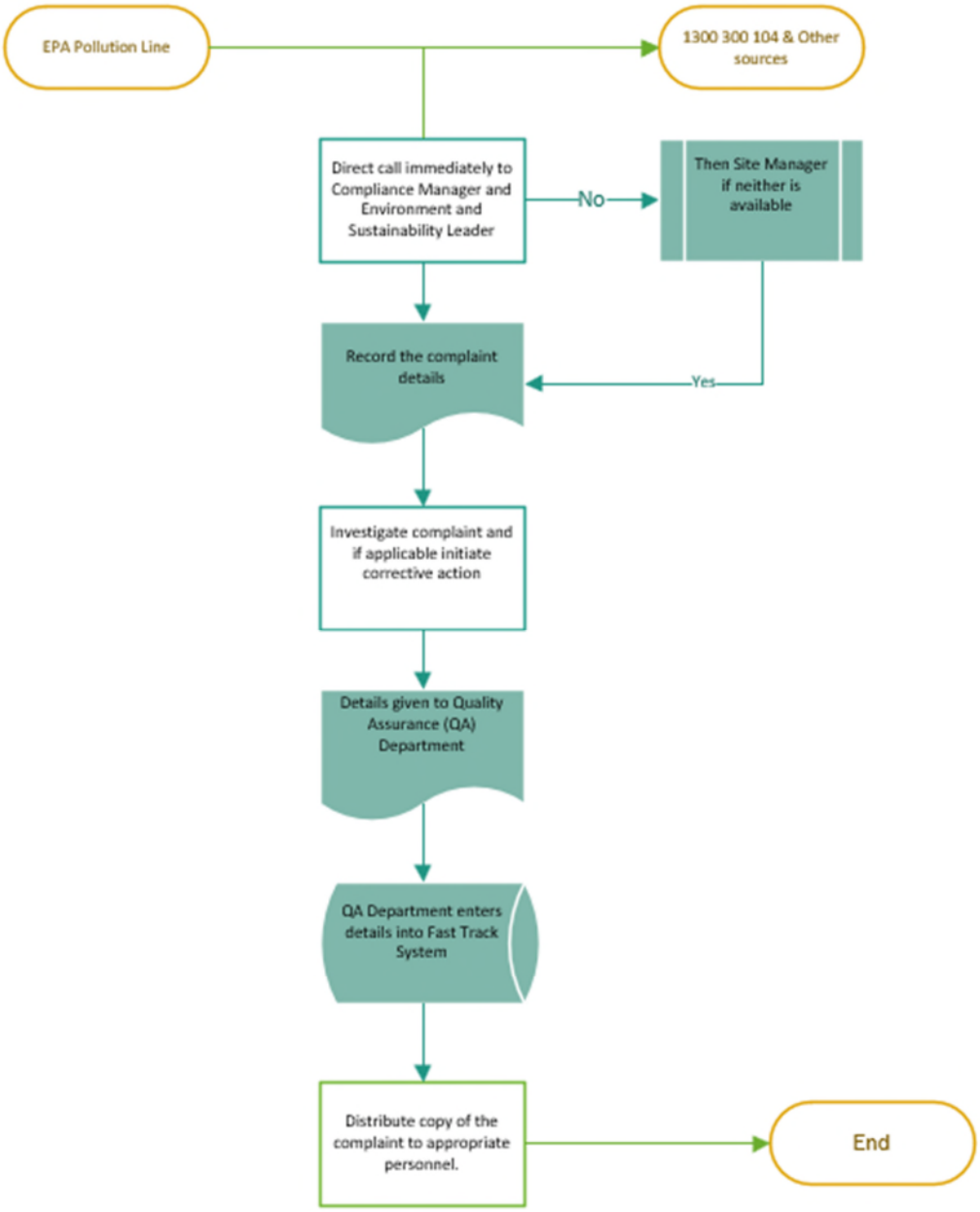
Environment Protection Licence No. 883

7 Procedure

1. The Environmental Complaints Handling procedure must reflect the requirements of Environmental Licence No. 883, as set out in Sections M5 of the licence.
2. The Compliance Manager, Environment and Sustainability Leader and the Site Manager have ownership of the system and have authority and responsibility to ensure that necessary corrective actions are taken.
3. Environmental complaints can be received through any of the following avenues.
    a. Environment Protection Authority (EPA)
    b. 24 hour a day complaints hotline (call centre)
    c. Ringing the main office.

4. The following procedure is followed when a complaint is received:
    a. All environmental complaints must be directed immediately to the Compliance Manager or Environment and Sustainability Leader.
    b. If the either of the above is not available, then direct to the Site Manager.
    c. The following details are recorded (where given by the complainant):
        i. Name of complainant and contact details (if they want to be identified). Details are required to enable Shoalhaven Starches to report back to the person once the complaint is investigated.
        ii. Nature of complaint – noise, dust/smoke, odour, spill, incident etc.
        iii. Duration of the problem (dates and times)
    d. The Compliance Manager and/or Environment and Sustainability Leader then investigates the complaint and if applicable initiate's corrective action. Refer to QMS-P-0130 Corrective and Preventative Action procedure.
    e. Once the investigation is complete, the details are given to the Quality Assurance Department and the details entered into the Environmental Complaints section of the Fast Track System.
    f. A copy of the complaint is forwarded to the Site Manager and relevant Plant Manager as required.
5. Details of complaints received by the EPA are sent to the Compliance Manager and Environment and Sustainability Leader for investigation and dealt with as per the above procedure.
6. If the complaint is the same as the one received directly by the company, then the EPA reference Number is added to the existing complaint (hence so doubling up does not occur).
7. Environmental Complaints are also reviewed on an annual basis as part of the company's Annual Environmental Report. This annual review includes comparison with previous years.

Complaints Procedure



8 Review

This document will be reviews every 2 years.

9 Document Control

Version	Author	Date	Summary of Changes

ghd.com

→ The Power of Commitment