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**Stack Emissions Testing Report Commissioned by**  
Henkel AG & Company

**Installation Name & Address**

Henkel AG & Company  
5 Cromwell Road  
St Neots  
Cambridgeshire  
PE19 1QL

**Stack Reference**

Cumulative LEV Extraction

**Dates of the Monitoring Campaign**

4th December 2020

**Job Reference Number**

EST-6019

**Report Written by**

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Team Leader  
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## CONTENTS

TITLE PAGE

CONTENTS

EXECUTIVE SUMMARY

Monitoring Objectives	3
Monitoring Results	4
Monitoring Dates & Times	5
Process Details	6
Monitoring & Analytical Methods	7
Summary of Sampling Deviations	7
Sampling Location	8
Plant Photos / Sample Points	9

APPENDIX 1 - Monitoring Personnel & List of Equipment

APPENDIX 2 - Raw Data, Sampling Equations & Charts

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## Executive Summary

(Page 1 of 7)

### MONITORING OBJECTIVES

Henkel AG & Company, St Neots  
Cumulative LEV Extraction  
4th December 2020

#### Overall Aim of the Monitoring Campaign

Element were commissioned by Henkel AG & Company to carry out stack emissions testing on the Cumulative LEV Extraction at St Neots.

The aim of the monitoring campaign was to perform testing, as requested by the customer, for a number of prescribed pollutants. There are no emission limits set for any of the pollutants at this time.

#### Special Requirements

There were no special requirements.

#### Target Parameters

Total VOCs (as Carbon)

Executive Summary  
(Page 2 of 7)

MONITORING RESULTS

Henkel AG & Company, St Neots  
Cumulative LEV Extraction  
4th December 2020

where MU = Measurement Uncertainty associated with the Result

Concentration				
Parameter	Units	Result	MU +/-	Limit
Total VOCs (as Carbon)	<sup>1</sup> mg/m <sup>3</sup>	94.3	2.2	-
Water Vapour	% v/v	0.88	1.24	

<sup>1</sup> Reference Conditions (REF) are: 273K, 101.3kPa, without correction for water vapour content.

# Executive Summary

(Page 3 of 7)

## MONITORING DATE(S) & TIMES

Henkel AG & Company, St Neots  
 Cumulative LEV Extraction  
 4th December 2020

Parameter	Units	Concentration		Sampling Date(s)	Sampling Times	Duration mins
Total VOCs (as Carbon)	R1	mg/m <sup>3</sup>	94.3	04/12/2020	09:10 - 15:10	360
Water Vapour	R1	% v/v	0.88	04/12/2020	09:10 - 09:40	30

All results are expressed at the respective reference conditions.

# Executive Summary

(Page 4 of 7)

## PROCESS DETAILS

Henkel AG & Company, St Neots  
 Cumulative LEV Extraction  
 4th December 2020

### Standard Operating Conditions

Parameter	Value
Process Status	Normal Operation
Capacity (of 100%) and Tonnes / Hour	Full Operation
Continuous or Batch Process	Batch
Feedstock (if applicable)	Various Applications
Abatement System	None
Abatement System Running Status	N/A
Fuel	N/A
Plume Appearance	None Visible

# Executive Summary

(Page 5 of 7)

## MONITORING & ANALYTICAL METHODS

Henkel AG & Company, St Neots  
 Cumulative LEV Extraction  
 4th December 2020

Parameter	Monitoring				Analysis				Overall Status	LOD (Average)
	Standard	Technical Procedure	Sampling Status	Testing Lab	Analytical Procedure	Analytical Technique	Analysis Status	Analysis Lab		
Water Vapour	EN 14790	CAT-TP-05	MCERTS	EET	CAT-TP-05	Gravimetric	MCERTS	EET	MCERTS	0.10 % v/v
Total VOCs (as Carbon)	EN 12619:2013	CAT-TP-20	MCERTS	EET	Flame Ionisation Detection by Sick 3006 FID				MCERTS	0.32 mg/m <sup>3</sup>

## ANALYSIS LABORATORIES

(with short name reference as appears in the table above)

## SUMMARY OF SAMPLING DEVIATIONS

Parameter	Run	Deviation
Total VOC's & Water Vapour	1	End of pipe sampling was necessary as there were no sampling ports installed on the stack.
Total VOC's	1	All sample gas was extracted from the stack via a pre-installed length of unheated tubing. The integrity of this tubing could not be accessed. Element's sampling equipment was leak checked as per the requirements of the standard.
Water Vapour	1	The measurement uncertainty for water vapour was greater than 20%. This was due to the low level of water vapour which was found to be present in the stack.

## Executive Summary

(Page 6 of 7)

### SUITABILITY OF SAMPLING LOCATION

#### Duct Characteristics

Parameter	Units	Value
Type	-	Circular
Depth	m	-
Width	m	-
Area	m <sup>2</sup>	-
Port Depth	cm	-
Orientation of Duct	-	Vertical
Number of Ports	-	-
Sample Port Size	-	-

#### Location of Sampling Platform

General Platform Information	Value
Permanent / Temporary Platform	On Ground
Inside / Outside	Inside

#### Platform Details

EA Technical Guidance Note M1 / EN 15259 Platform Requirements	Value
Sufficient working area to manipulate probe and operate the measuring instruments	Yes
Platform has 2 levels of handrails (approx. 0.5m & 1.0m high)	N/A
Platform has vertical base boards (approx. 0.25m high)	N/A
Platform has chains / self closing gates at top of ladders	N/A
There are no obstructions present which hamper insertion of sampling equipment	Yes
Safe Access Available	Yes
Easy Access Available	Yes

#### Sampling Location / Platform Improvement Recommendations

All platforms should be designed in accordance with the requirements in the Environment Agency's Technical Guidance Note M1 and EN 15259.

#### EN 15259 Homogeneity Test Requirements

There is no requirement to perform a EN 15259 Homogeneity Test on this Stack.



Executive Summary

(Page 7 of 7)

PLANT PHOTOS

Photo 1

Photo 2

None Available

None Available

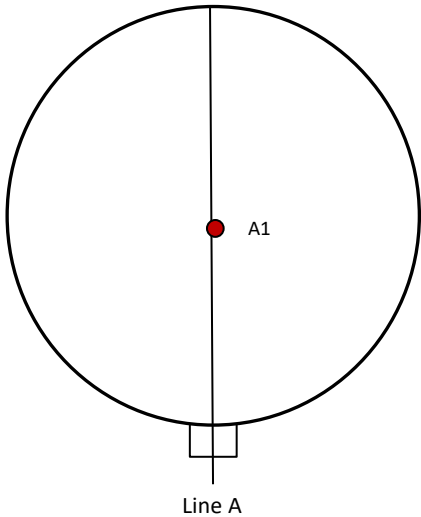
Photo 3

Photo 4

None Available

None Available

SAMPLE POINTS



- where

○ = isokinetic point sampled at

● = isokinetic point not sampled at

● = combustion gases sample point

○ = non-isokinetic sample point

## APPENDICES

### APPENDIX CONTENTS

APPENDIX 1 - Stack Emissions Monitoring Personnel, List of Equipment & Methods and Technical Procedures Used

APPENDIX 2 - Summaries, Calculations, Raw Data and Charts

## APPENDIX 1

### STACK EMISSIONS MONITORING PERSONNEL

Position	Name	MCERTS Accreditation	MCERTS Number	Technical Endorsements
Team Leader	Harpreet Badwal	MCERTS Level 2	MM 03 149	TE1 TE2 TE3 TE4
Team Leader	Lee Heaton	MCERTS Level 2	MM 17 1433	TE1 & TE4

### LIST OF EQUIPMENT

Extractive Sampling		Instrumental Analysers		Miscellaneous Items	
Equipment Type	Equipment I.D.	Equipment Type	Equipment I.D.	Equipment Type	Equipment I.D.
Control Box DGM (1)	-	Horiba PG-350E	-	Digital Manometer (1)	-
Control Box DGM (2)	-	Horiba PG-250	-	Digital Manometer (2)	-
Box Thermocouples (1)	-	Servomex 5200 MP	-	Digital Temperature Meter	-
Box Thermocouples (2)	-	Eco Physics CLD 822Mh	-	Stopwatch	CAT 14.84
Umbilical (1)	-	ABB AO2020-URAS26	-	Barometer	CAT 13.40
Umbilical (2)	-	Testo 350 XL	-	Stack Thermocouple (1)	-
Oven Box (1)	-	Ankersmid APS 313	-	Stack Thermocouple (2)	-
Oven Box (2)	-	Gasmeter DX4000	-	Stack Thermocouple (3)	-
Heated Probe (1)	-	Gasmeter Sampling System	-	1m Heated Line (1)	-
Heated Probe (2)	-	Bernath 3006 FID	CAT 8.32	1m Heated Line (2)	-
Heated Probe (3)	-	M&C PSS	-	1m Heated Line (3)	-
S-Pitot (1)	-	Mass Flow Controller (1)	CAT 6.61	5m Heated Line (1)	-
S-Pitot (2)	-	Mass Flow Controller (2)	CAT 6.62	15m Heated Line (1)	-
L-Pitot	-	Mass View (1)	CAT 25.59	20m Heated Line (1)	-
Site Balance	CAT 17.33	Mass View (2)	CAT 25.60	20m Heated Line (2)	-
500g / 1Kg Check Weights	CAT 17.33 a & b	Hioki 5043 (V)	CAT 11.115	Dual Channel Heater Controller	-
Last Impinger Arm	-	Easylogger EN-EL-12 Bit	-	Single Channel Heater Controller	-
Callipers	-	Bioaerosols Temperature Logger	-	Laboratory Balance	-
Tubes Kit Thermocouple	-	Electronic Refrigerator	-	Tape Measure	CAT 16.45

### METHODS & TECHNICAL PROCEDURES USED

Parameter	Standard	Technical Procedure
Water Vapour	EN 14790	CAT-TP-05
Total VOCs (as Carbon)	EN 12619:2013	CAT-TP-20

# APPENDIX 2

## WATER VAPOUR: RESULTS SUMMARY

Henkel AG & Company, St Neots  
Cumulative LEV Extraction

### Sample Runs

Parameter	Units	Run 1	Mean
Concentration	% v/v	0.88	0.88
Uncertainty	±% v/v	1.24	1.24

### General Sampling Information

Parameter	Value
Standard	EN 14790
Technical Procedure	CAT-TP-05

## WATER VAPOUR: SAMPLING DETAILS

### Sample Runs

Parameter	Units	Run 1
Sampling Times	-	09:10 - 09:40
Sampling Dates	-	04/12/2020
Sampling Device	-	MFC / MV
Duration	mins	30
Volume Sampled (STP, Dry)	m <sup>3</sup>	0.0704
Volume Sampled (STP, Wet)	m <sup>3</sup>	0.0710
Sample Flow Rate	l/min	2.35
Liquid Trap Start Mass	g	1175.0
Liquid Trap End Mass	g	1174.7
Silica Trap Start Mass	g	1411.1
Silica Trap End Mass	g	1411.9
Total Mass Of Water Vapour	g	0.5
Calculated Water Vapour	% v/v	0.88

**Where:** MFC stands for Mass Flow Controller, MV stands for Mass View Flowmeter

# APPENDIX 2

## WATER VAPOUR: QUALITY ASSURANCE

### Sample Runs

Leak Test Results	Units	Run 1	
Mean Sampling Rate	l/min	2.3	
Pre-Sampling Leak Rate	l/min	0.01	
Post-Sampling Leak Rate	l/min	0.01	
Allowable Leak Rate	l/min	0.05	
Leak Test Acceptable	-	Yes	

Water Droplets	Units	Run 1	
Are Water Droplets Present	-	No	

Measurement Uncertainty	Units	Run 1	
Measurement Uncertainty (MU)	%	141.6	
Allowable MU	%	20.0	
MU Acceptable	%	No	

Silica Gel	Units	Run 1	
Less than 50% Faded	%	Yes	

Test Conditions	Units	Run 1	
Ambient Temperature Recorded?	-	Yes	

### Method Deviations

Nature of Deviation	Run Number	
(x = deviation applies to the associated run)	1	
End of pipe sampling was necessary as there were no sampling ports installed on the stack.	x	
All sample gas was extracted from the stack via a pre-installed length of unheated tubing. The integrity of this tubing could not be accessed. Element's sampling equipment was leak checked as per the requirements of the standard.	x	
The measurement uncertainty for water vapour was greater than 20%. This was due to the low level of water vapour which was found to be present in the stack.	x	

## APPENDIX 2

### WATER VAPOUR: MEASUREMENT UNCERTAINTY CALCULATIONS

Measured Quantities	Value		Standard uncertainty		
	Symbol	Run 1	Symbol	Units	Run 1
Sampled Volume (STP)	$V_m$	0.0704	$uV_m$	m <sup>3</sup>	0.0014
Repeatability of Weighing	$R_w$	0.50	$uR_w$	g	0.12
Reading of Balance	$R_b$	0.50	$uR_b$	g	0.00
Leak	L	0.43		%	-

Uncertainty as a Percentage				Requirement of Standard
Measured Quantities	Units	Run 1		
Sampled Volume (STP)	%	2.00		≤2%
Repeatability of Weighing	%	24.00		No Requirement
Reading of Balance	%	0.50		No Requirement
Leak	%	0.43		≤2%

Uncertainty in Measurement Units				Sensitivity Coefficient	
Measured Quantities	Symbol	Units	Run 1	Run 1	
Sampled Volume (STP)	$V_m$	m <sup>3</sup>	0.0704	12.47	
Repeatability of Weighing	$R_w$	g	0.50	1.76	
Reading of Balance	$R_b$	g	0.50	1.76	
Leak	L	% v/v	0.00	1.00	

Uncertainty in Result		
Measured Quantities	Units	Run 1
Sampled Volume (STP)	% v/v	0.018
Repeatability of Weighing	% v/v	0.211
Reading of Balance	% v/v	0.004
Leak	% v/v	0.002

Parameter	Units	Run 1
Combined uncertainty	% v/v	0.21
Expanded uncertainty (95% confidence)	% v/v	0.41
Expanded uncertainty (95% confidence), estimated with Method Deviations	% v/v	1.24
Uncertainty if Water Droplets are present	% v/v	N/A
Reported Uncertainty	% v/v	1.24
Expanded uncertainty (95% confidence)	%	47.2
Expanded uncertainty (95% confidence), estimated with Method Deviations	%	141.6
Uncertainty if Water Droplets are present	%	N/A
Reported Uncertainty	%	141.6

## APPENDIX 2

### TOTAL VOCs (as CARBON): RESULTS SUMMARY

Henkel AG & Company, St Neots  
Cumulative LEV Extraction

#### Sample Runs

Parameter	Units	Run 1	Mean
Concentration	mg/m <sup>3</sup>	94.3	94.3
Uncertainty	±mg/m <sup>3</sup>	2.2	2.2
Mass Emission	g/hr		
Uncertainty	±g/hr		

#### General Sampling Information

Parameter	Value	
Standard	EN 12619:2013	
Technical Procedure	CAT-TP-20	
Probe Material	Stainless Steel	
Filtration Type / Size	0.1µm Glass Fibre	
Heated Head Filter Used	No	
Heated Line Temperature	180°C	
Span Gas Type	Propane In Synthetic Air (5 Grade)	
Span Gas Reference Number	CYL 1.0271a	
Span Gas Expiry Date	15/03/2022	
Span Gas Start Pressure (bar)	100	
Gas Cylinder Concentration (ppm)	802	
Span Gas Set Point (ppm)	802.00	
Span Gas Uncertainty (%)	N/A	
Zero Gas Type	Synthetic Air (5 Grade)	
Number of Sampling Lines Used	1/1	FORMAT: Number Used / Number Required
Number of Sampling Points Used	1/1	FORMAT: Number Used / Number Required
Sample Point I.D.'s	A1	

#### Reference Conditions

Reference Conditions are: 273K, 101.3kPa, without correction for water vapour content.

### TOTAL VOCs (as CARBON): DATA TREND

**Total VOCs**

— At Reference Conditions

**- Run 1**

Concentration (mg/m³)

Time (HH:MM)

Time (HH:MM)	Concentration (mg/m³)
09:10	60
09:18	190
09:27	85
09:35	110
09:44	95
09:52	85
10:01	80
10:09	110
10:18	55
10:26	110
10:35	105
10:43	140
10:52	150
11:00	160
11:09	150
11:17	180
11:26	210
11:34	100
11:43	140
11:51	160
12:00	160
12:08	150
12:17	140
12:25	120
12:34	70
12:42	50
12:51	40
12:59	60
13:08	70
13:16	80
13:25	100
13:33	110
13:42	120
13:50	140
13:59	35
14:07	130
14:16	40
14:24	30
14:33	20
14:41	10
14:50	5
14:58	2
15:07	1



## APPENDIX 2

### TOTAL VOCs (as CARBON): SAMPLING DETAILS & QUALITY ASSURANCE

#### Sampling Details

Parameter	Units	Run 1
Sampling Times	-	09:10 - 15:10
Sampling Dates	-	04/12/2020
Instrument Range	ppm	1000
Span Gas Value	ppm	802.0

#### Quality Assurance

	Zero Drift	Units	Run 1
CAL 1	Zero Down Sampling Line (Pre)	ppm	0.00
	Zero Down Sampling Line (Post)	ppm	2.00
	Zero Drift	ppm	2.00
	Allowable Zero Drift	± ppm	40.10
	Zero Drift Acceptable	-	Yes

	Span Drift	Units	Run 1
CAL 1	Span Down Sampling Line (Pre)	ppm	802.00
	Span Down Sampling Line (Post)	ppm	814.00
	Span Drift	ppm	12.00
	Allowable Span Drift	± ppm	40.10
	Span Drift Acceptable	-	Yes

Test Conditions	Units	Run 1
Run Ambient Temperature Range	°C	3 - 6

#### Method Deviations

Nature of Deviation	Run Number	
(x = deviation applies to the associated run)	1	
End of pipe sampling was necessary as there were no sampling ports installed on the stack.	x	
All sample gas was extracted from the stack via a pre-installed length of unheated tubing. The integrity of this tubing could not be accessed. Element's sampling equipment was leak checked as per the requirements of the standard.	x	

## TOTAL VOCs (as CARBON): MEASUREMENT UNCERTAINTY CALCULATIONS

Performance characteristics	RUN 1	Units
Limit value	-	mg/m <sup>3</sup> (REF)
Allowable MU	15.0	%
Measured concentration	95.09	mg/m <sup>3</sup> (STP, dry)
Range Used	1000.0	ppm
Range Used [A]	1606.1	mg/m <sup>3</sup>
Cal gas conc.	802.0	ppm
Conversion	1.61	ppm to mg/m <sup>3</sup>
MCERTS Range [B]	15.0	mg/m <sup>3</sup>
Lower of [A] or [B]	15.0	mg/m <sup>3</sup>
Cal gas conc.	1288.1	mg/m <sup>3</sup>

Performance characteristics	RUN 1	Units
Response time	45	seconds
Number of readings in measurement	360	-
Repeatability at zero	2.00	% full scale
Repeatability at span level	0.00	% full scale
Deviation from linearity	0.46	% of value
Zero drift	0.25	% full scale
Span drift	1.50	% full scale
Volume or pressure flow dependence	1.60	% of full scale
Atmospheric pressure dependence	0.30	% of value/kPa
Ambient temperature dependence	1.40	% full scale/10K
Combined interference	0.45	% range
Dependence on voltage	0.50	% full scale/10V
Losses in the line (leak)	0.00	% of value
Uncertainty of calibration gas	2.00	% of value

Performance characteristic	RUN 1	Units
Standard deviation of repeatability at zero	use rep at span	mg/m <sup>3</sup>
Standard deviation of repeatability at span level	0.00	mg/m <sup>3</sup>
Lack of fit	0.04	mg/m <sup>3</sup>
Drift	0.00	mg/m <sup>3</sup>
Volume or pressure flow dependence	0.00	mg/m <sup>3</sup>
Atmospheric pressure dependence	0.01	mg/m <sup>3</sup>
Ambient temperature dependence	0.20	mg/m <sup>3</sup>
Combined interference (from MCERTS Certificate)	0.04	mg/m <sup>3</sup>
Dependence on voltage	0.06	mg/m <sup>3</sup>
Losses in the line (leak)	0.00	mg/m <sup>3</sup>
Uncertainty of calibration gas	1.10	mg/m <sup>3</sup>

Measurement uncertainty	Result	RUN 1	Units
Combined uncertainty		95.09	mg/m <sup>3</sup>
Expanded uncertainty	k = 1.96	1.12	mg/m <sup>3</sup>
Expanded uncertainty		2.20	mg/m <sup>3</sup>
Uncertainty corrected to std conds. (O <sub>2</sub> )		2.20	mg/m <sup>3</sup> (REF)

	RUN 1	Units
Expanded uncertainty (no O <sub>2</sub> ) - at 95% Confidence	2.31	% of Value
Expanded uncertainty (no O <sub>2</sub> ) - at 95% Confidence	N/A	% at ELV
Overall Allowable uncertainty (no O <sub>2</sub> ) - at 95% Confidence	N/A	% at ELV
<b>Result of Compliance with Uncertainty Requirement</b>	<b>N/A</b>	-

	RUN 1	Units
Expanded uncertainty (with O <sub>2</sub> ) - at 95% Confidence	N/A	% of Value
Expanded uncertainty (with O <sub>2</sub> ) - at 95% Confidence	N/A	% at ELV
Overall Allowable uncertainty (with O <sub>2</sub> ) - at 95% Confidence	N/A	% at ELV
<b>Result of Compliance with Uncertainty Requirement</b>	<b>N/A</b>	-

Requirement for SRM is that Uncertainty should be <15% of the value at the ELV, on a dry gas basis, or if O<sub>2</sub> correction is applied less than 15% + the uncertainty associated with the O<sub>2</sub> correction (using sqrt of sum squares to add uncertainty components).

Version Number	Record of changes made within this version of the document
V1	The original document issued to the client