REC Environmental Monitoring

a division of Resource and Environmental Consultants Ltd

Client **Xaarjet Limited**
1 Hurricane Close
Ermine Business Park
Huntingdon
Cambs
PE29 6XX

Part 1: Executive Summary

Report for the Periodic Monitoring of Emissions to Air.

Site	**Huntingdon**
Plant	**LEV 9 :- Exhaust Stack & Ducting After Tools Process**
Sampling Date	**3rd March 2015**
Report Date	**18th March 2015**
Job Number	**EM-1p02810**
Permit Number	**B22/11**

Report Prepared by: ***Print*** **Gary Thackray**

MCERTS No. **MM02 078** **Level 2 TE: 1,2,3,4**

Report Approved by: ***Sign*** EBuffam ……

Print **Emily Buffam**

MCERTS No. **MM04 502** **Level 2 TE: 1,2,3,4**

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MCERTS THE ENVIRONMENT AGENCY'S MONITORING CERTIFICATION SCHEME

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Contents

Monitoring Objectives

The monitoring was undertaken to Investigate emissions coming from the main out let and a secondary point after some Tooling processes.

All monitoring procedures were carried out to the MCERTS requirements under the REC Environmental Monitoring quality system to ISO 17025: 2005.

Monitoring was undertaken for the listed emissions from the following sampling positions:

Sampling Location	Emission
LEV 9 :- Exhaust Stack & Ducting After Tools Process	**Total organic carbon**

Special Monitoring Requirements

There were no special requirements for this monitoring campaign.

Summary Of Methods

Emission	Method number	Method standard
Gas velocity and volume flow	TPM/01A	BS EN ISO 16911-1:2013
TOC	TPM/13	BS EN 12619 : 2013

Summary Of Results

The table presents the atmospheric emissions from the tests undertaken on behalf of **Xaarjet Limited**
The results were measured from the sample positions downstream of the arrestment plant.

Emission at Huntingdon	Sampling Time			Emission Result	Authorised Limit	Uncertainty +/-	Detection Limit	Mass Emission
LEV 9 :- Exhaust Stack	Date	Start	End	mg/m^3*	mg/m^3*	mg/m^3*	mg/m^3*	g/h
TOC	03/03/15	11:10	13:35	61.9	75	1.73	0.16	146.1

Emission at Huntingdon	Sampling Time			Emission Result	Authorised Limit	Uncertainty +/-	Detection Limit	Mass Emission
LEV 9 :- Ducting after Tools process	Date	Start	End	mg/m^3*	mg/m^3*	mg/m^3*	mg/m^3*	g/h
TOC	03/03/15	11:10	13:35	4.15	75	1.18	0.16	6.22

* at reference conditions	Stack Gas Weight	0 °C	Without correction for moisture
	29.00 Kg/kmol	101.3 kPa	Oxygen No Correction %

Where applicable
Oxides of nitrogen results are expressed as nitrogen dioxide
TOC results are expressed as total carbon

Throughout Report:

*	Reference conditions (see above)	Nm^3 273 K, 101.3 kPa
**	Analysis not required	# - UKAS accredited only
ND	Non detectable	## - Not Accredited
s - Subcontracted laboratory analysis		N/A Not applicable

The reported expanded uncertainty is based on a standard uncertainty multiplied by a coverage factor k=2, providing a 95% confidence level. The uncertainty evaluation has been carried out in accordance with UKAS requirements.

Summary Of Results, Exhaust Gases

The table presents the atmospheric emissions from the tests undertaken on behalf of **Xaarjet Limited**
The results were measured from the sample positions downstream of the arrestment plant.

Emission at Huntingdon		Sampling Time			Emission Result	Authorised Limit	Uncertainty +/-	Detection Limit	Mass Emission
LEV 9 :- Exhaust Stack		Date	Start	End	mg/m^3*	mg/m^3*	mg/m^3*	mg/m^3*	g/h
TOC	Test 1	03/03/15	11:10	11:40	34.8	75	1.36	0.16	82.0
TOC	Test 2	03/03/15	11:40	12:10	85.7	75	2.08	0.16	202.2
TOC	Test 3	03/03/15	13:05	13:35	65.2	75	1.76	0.16	153.9

Emission at Huntingdon		Sampling Time			Emission Result	Authorised Limit	Uncertainty +/-	Detection Limit	Mass Emission
LEV 9 :-Ducting after Tools process		Date	Start	End	mg/m^3*	mg/m^3*	mg/m^3*	mg/m^3*	g/h
TOC	Test 1	03/03/15	11:10	11:40	5.42	75	1.18	0.16	8.12
TOC	Test 2	03/03/15	11:40	12:10	3.74	75	1.18	0.16	5.60
TOC	Test 3	03/03/15	13:05	13:35	3.30	75	1.17	0.16	4.94

* at ref Conditions	Stack Gas Weight	0 °C	Wet Gas		
	29.00 Kg/kmol	101.3 kpa	Oxygen	None	%

Where applicable
Oxides of nitrogen results are expressed as nitrogen dioxide
TOC results are expressed as total carbon

Throughout Report:

*	Reference conditions (see above)	Nm^3 273 K, 101.3 kPa
**	Analysis not required	# - UKAS accredited only
ND	Non detectable	## - Not Accredited
s - Subcontracted laboratory analysis		N/A Not applicable

The reported expanded uncertainty is based on a standard uncertainty multiplied by a coverage factor k=2, providing a 95% confidence level. The uncertainty evaluation has been carried out in accordance with UKAS requirements.

Operating Information

The tables below shows details of the operating information on each sampling date for: **LEV 9 :- Exhaust Stack & Ducting After Tools Process**

Date	Process type	Process duration	Fuel	Feedstock	Abatement	Load
03/03/2015	Production and cleaning of inkjet cartridges	Continuous	N/A	N/A	N/A	*See below

*** 11:10 - 11:40 :- Background sampling with no tooling processes running**
*** 11:40 - 12:10 :- 1st Test period while tooling processes were taking place**
*** 13:05 - 13:35 :- 2nd Test period while tooling processes were taking place**

Comments & Monitoring Deviations

A waste gas homogeneity test to BS EN 15259:2007 (MID) is not required:-
The homogeneity test is not applicable to non-combustion processes.

All monitoring was performed in accordance with the relevant procedures.

The velocity and temperature profile at the sampling location met the requirements of BS EN 13284-1: 2002.

When the results are expressed as non-detected the mass emissions are calculated from the detection limit and therefore they are worst case results.

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Part 2: Supporting Information

Report for the Periodic Monitoring of Emissions to Air.

Client	**Xaarjet Limited**
Site	**Huntingdon**
Plant	**LEV 9 :- Exhaust Stack & Ducting After Tools Process**
Sampling Date	**3rd March 2015**
Report Date	**18th March 2015**
Job Number	**EM-1p02810**
Permit Number	**B22/11**

Report Prepared by:	***Print***	**Gary Thackray**	
	MCERTS No.	**MM02 078**	**Level 2 TE: 1,2,3,4**
Report Approved by:	***Sign***	EBuffam	
	Print	**Emily Buffam**	
	MCERTS No.	**MM04 502**	**Level 2 TE: 1,2,3,4**

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APPENDIX 1

Emission Monitoring Procedures And Instrumentation

Gas velocity and temperature

Documented in-house procedure TPM01/A to the main procedural requirements of BS EN ISO 16911-1:2013

Velocity and temperature measurements are performed using a calibrated Pitot tube, a calibrated pressure differential reading device and a calibrated thermocouple. Velocity and possible flow deviation measurements are carried out at selected, representative points in the gas stream.

Total organic carbon

Documented in-house procedure TPM/13 to the main procedural requirements of BS EN 12619:2013.

Continuous analysis using probe, sample line and multi range Flame Ionisation Detector (FID) analyser. The analyser is calibrated before and during the tests using certified gas mixtures of nitrogen, oxygen and propane. Sampling points are selected in accordance with the findings of any BS EN 15259 assessment.

Sampling Project Personnel Competency And Expiry Dates

		MCERTS No	Level 1	Level 2	TE1	TE2	TE3	TE4
Report prepared by:	Gary Thackray	MM02 078	-	31/08/2015	31/03/2018	30/10/2019	31/08/2015	31/08/2015
Report authorised by:	Emily Buffam	MM04 502	-	30/06/2016	30/06/2016	31/08/2016	31/08/2016	31/08/2016
Team leader:	Gary Thackray	MM02 078	-	31/08/2015	31/03/2018	30/10/2019	31/08/2015	31/08/2015
Technician:	Craig MacDonald	MM11 1130	-	-	-	-	-	-

Equipment References

Equipment	Reference Number
FID	**VC12 & VC08**
Heated Line	**HL47 & HL40**
Stack Thermocouple	**TS37**
Barometer	**Met Office**
Pitot	**PT129**
Thermometer	**TK21**
Manometer	**PI20**
Balance	**BL24**
Weights	**W38 & W37**

APPENDIX 2

Date	03/03/2015
Time	15:40
Pitot Cp	1.01

Barometric pressure	101.1	kPa
Duct static pressure	0.07	kPa
Stack Area	0.071	m^2

Stack Diameter (circular)	0.30	m

Traverse Point	Traverse Line	Depth cm	ΔP mmH_2O	T ^oC	Angle ^{o}	velocity m/s
1						
2						
3	A	5.0	3.3	19	<15	7.4
4	A	5.3	3.5	19	<15	7.6
5	A	7.5	3.9	19	<15	8.0
6	A	10.7	6.3	19	<15	10.2
7	A	19.3	7.1	19	<15	10.9
8	A	22.5	8.0	19	<15	11.5
9	A	24.7	8.2	19	<15	11.6
10	A	25.0	9.1	19	<15	12.3
11						
12						

Average Pitot DP	5.95	mmH_2O
Average Temperature	292.2	K
Average Velocity	9.9	m/s
Average volumetric flow rate	0.70	m^3/s at stack conditions
Average volumetric flow rate	0.66	m^3/s (wet STP)
Average volumetric flow rate	N/A	m^3/s (dry, STP, reference oxygen concentraion)

Sampling plane requirements Re: BS EN 13284-1:2001 5.2

a	Angel of gas flow less than 15^o with regard to duct axis	YES
b	No local negative flow	YES
c	Minimum pitot greater than 5Pa	YES
d	Ratio of highest to lowest local gas velocity less than 3:1	YES

Minimum local gas velocity	7.4
Maximum local gas velocity	12.3
Ratio of highest to lowest local gas velocity	1.67

Preliminary Velocity Traverse LEV 9 Exhaust Stack

Date	03/03/2015
Time	15:05
Pitot Cp	1.01

Barometric pressure	101.1	kPa
Duct static pressure	0.01	kPa
Stack Area	0.071	m^2

Stack Diameter (circular)	0.30	m

Traverse Point	Traverse Line	Depth cm	ΔP mmH_2O	T ^oC	Angle ^{o}	velocity m/s
1						
2						
3	A	5.0	2.0	19	<15	5.8
4	A	5.3	2.2	19	<15	6.1
5	A	7.5	2.2	19	<15	6.1
6	A	10.7	2.7	19	<15	6.6
7	A	19.3	2.4	19	<15	6.4
8	A	22.5	2.7	19	<15	6.6
9	A	24.7	2.5	19	<15	6.5
10	A	25.0	2.4	19	<15	6.4
11						
12						

Average Pitot DP	2.40	mmH_2O
Average Temperature	292.2	K
Average Velocity	6.3	m/s
Average volumetric flow rate	0.45	m^3/s at stack conditions
Average volumetric flow rate	0.42	m^3/s (wet STP)
Average volumetric flow rate	N/A	m^3/s (dry, STP, reference oxygen concentraion)

Sampling plane requirements Re: BS EN 13284-1:2001 5.2

a	Angel of gas flow less than 15^o with regard to duct axis	YES
b	No local negative flow	YES
c	Minimum pitot greater than 5Pa	YES
d	Ratio of highest to lowest local gas velocity less than 3:1	YES

Minimum local gas velocity	5.8
Maximum local gas velocity	6.6
Ratio of highest to lowest local gas velocity	1.14

Preliminary Velocity Traverse LEV 9 Ducting After Tools Process

Date 03/03/2015

From 11:10 to 11:40 30 minute mean

Volatile organic compounds	vppm, wet	21.64	mg/m³*	34.77

From 11:40 to 12:10 30 minute mean

Volatile organic compounds	vppm, wet	53.33	mg/m³*	85.70

.

From 13:05 to 13:35 30 minute mean

Volatile organic compounds	vppm, wet	40.60	mg/m³*	65.25

Sampling Detection Limits

Volatile organic compounds	vppm	0.10	mg/m³*	0.16

Reference Gas Details

Species	Units	Value	Cylinder Reference	Analyser Range	Uncertainity *k* = 2
Nitrogen	%	99.999	VC1891018	-	± 2
Volatile organic compounds	vppm	80.7	VCFC7814	100	± 2

Zero And Span Gas Details

Species	units	Initial Time	10:34	Final Time	13:46
		Initial Zero	Initial Span	Final Zero	Final Span
Volatile organic compounds	vppm	0.00	80.70	2.83	78.70

Exhaust Gas Continuous Analysis Data LEV 9 Exhaust Stack

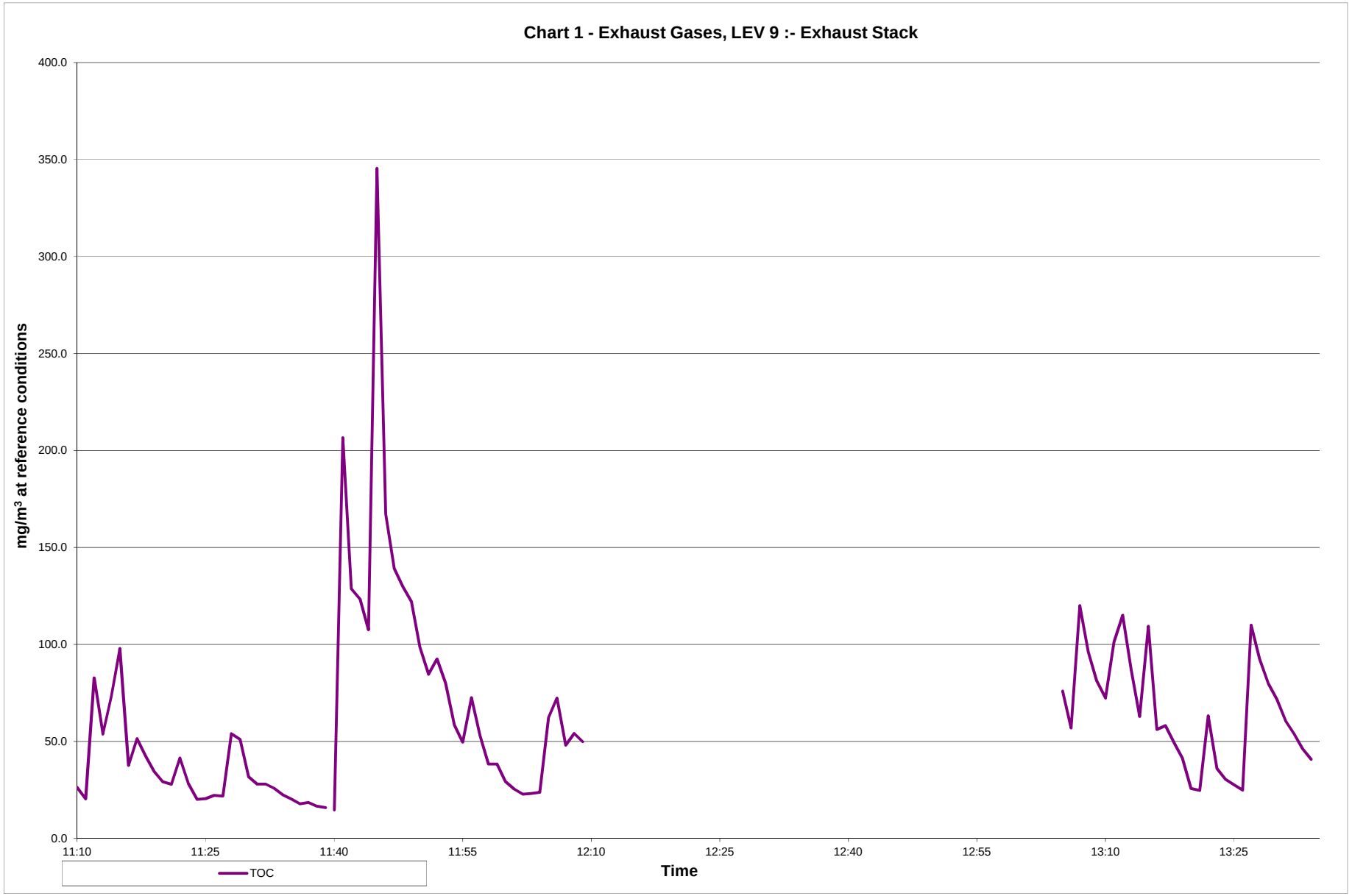


Chart 1 - Exhaust Gases, LEV 9 :- Exhaust Stack
400.0
350.0
300.0
250.0
200.0
150.0
100.0
50.0
0.0
mg/m³ at reference conditions
11:10
11:25
11:40
11:55
12:10
12:25
12:40
12:55
13:10
13:25
Time
TOC

Date 03/03/2015

From 11:10 to 11:40 30 minute mean

Volatile organic compounds	vppm, wet	3.37	mg/m³*	5.42

From 11:40 to 12:10 30 minute mean

Volatile organic compounds	vppm, wet	2.32	mg/m³*	3.74

.

From 13:05 to 13:35 30 minute mean

Volatile organic compounds	vppm, wet	2.05	mg/m³*	3.30

Sampling Detection Limits

Volatile organic compounds	vppm	0.10	mg/m³*	0.16

Reference Gas Details

Species	Units	Value	Cylinder Reference	Analyser Range	Uncertainity *k* = 2
Nitrogen	%	99.999	VC1891018	-	± 2
Volatile organic compounds	vppm	80.7	VCFC7814	100	± 2

Zero And Span Gas Details

Species	units	Initial Time	10:52	Final Time	14:46
		Initial Zero	Initial Span	Final Zero	Final Span
Volatile organic compounds	vppm	0.00	80.70	0.20	80.60

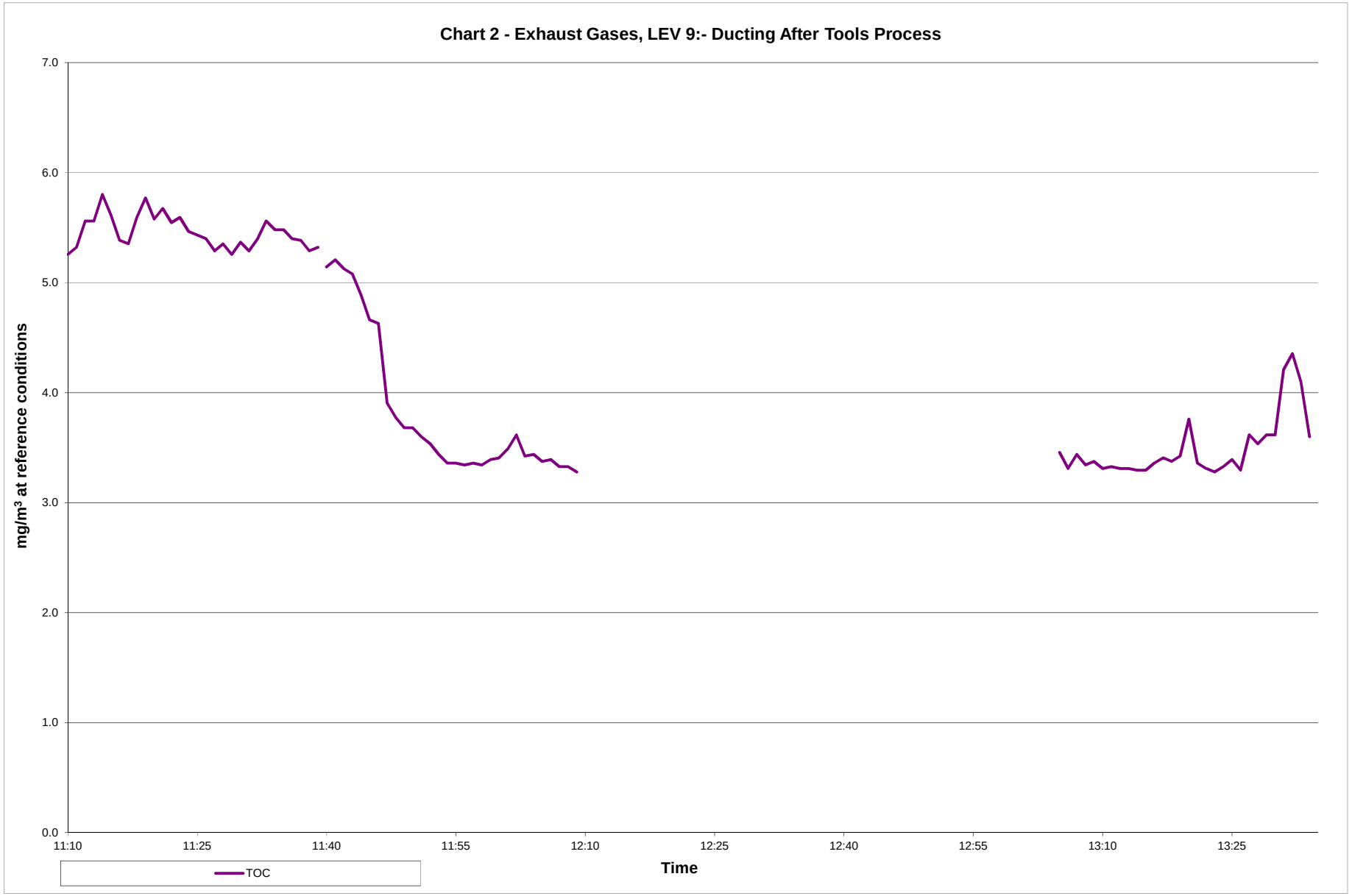


Chart 2 - Exhaust Gases, LEV 9:- Ducting After Tools Process
mg/m³ at reference conditions
7.0
6.0
5.0
4.0
3.0
2.0
1.0
0.0
11:10
11:25
11:40
11:55
12:10
12:25
12:40
12:55
13:10
13:25
Time
TOC

APPENDIX 3

Diagram Of The Sampling Location (LEV 9 Exhaust Stack)

Diagram of sampling points across the cross section of the duct (not to scale).

Traverse length = 0.30 m

Point	% of D	Location cm
1	50.0	15.0

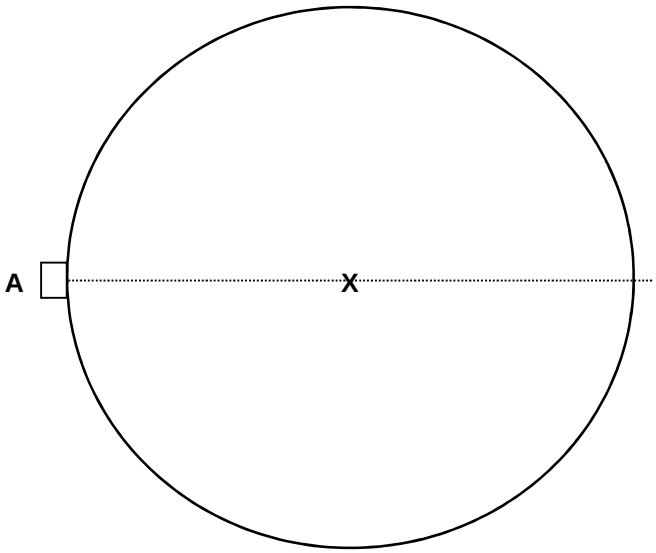
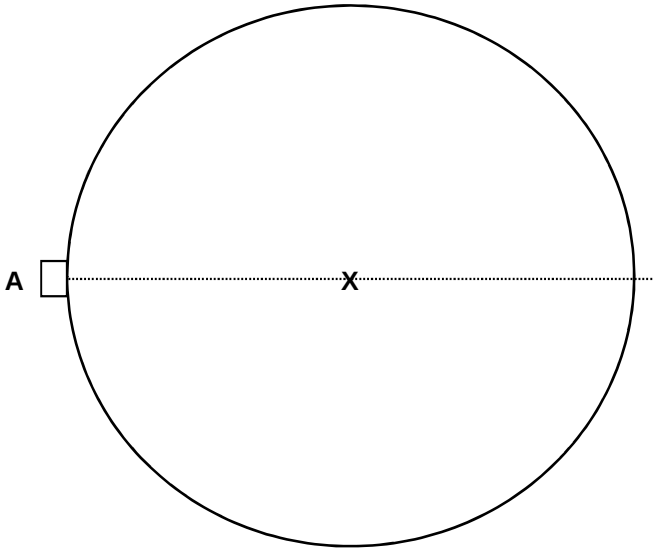


Diagram Of The Sampling Location (LEV 9 Ducting After Tools Process)

Diagram of sampling points across the cross section of the duct (not to scale).

Traverse length = 0.30 m

Point	% of D	Location cm
1	50.0	15.0



General Calculations

Stack area:

$$Area\,of\ a\,circle = \frac{\pi.D^2}{4}$$

D = Diameter (m)
π = 3.142

Pressure conversion:

1mmH2O = 0.00980665 kPa
1mmH2O = 9.80665 Pa
1 mar = 0.1 kPa

Water vapour concentration:
From reference calculations (taken from BS EN 14790):

$$V_{WC(\%)} = \frac{\frac{m_{WC}.V_{mol(std)}}{M_W}}{\frac{m_{WC}.V_{mol(std)}}{M_W} + V_{m(std)}} \times 100$$

VWC (%) = Water vapour content on wet basis, in volume % (m^3 of water vapour in m^3 of wet gas)
Vm(std) = Dry gas volume measured, corrected to standard conditions (m^3)
mWC = Mass of water collected in the impingers (g)
Mw = Molecular weight of water, 18.01534 rounded to 18 (g/mol)
Vmol(std) = Molar volume of water at standard conditions = 0.0224 (m3/mol)

Gas meter volume at standard conditions (STP)
From reference calculations (taken from BS EN 14790):

$$V_{m(std)} = y_d \times (V_2 - V_1) \times \frac{T_{std}}{T_m} \times \frac{p_m}{p_{std}}$$

Vm(std) = Dry gas meter volume at standard conditions (m^3)
yd = Gas meter calibration coefficient
(V2-V1) = Dry gas meter volume at actual conditions (m^3)
Tm = Actual Temperature (K)
Tstd = Standard temperature (273 K)
pm = Absolute pressure at the gas meter (kPa)
pstd = Standard gas pressure (101.3 kPa)

Isokenetic Ratio (%):
From reference calculations (taken from EA TGN M2):

$$IsokineticRatio(\%) = \frac{Velocity\ at\ the\ sampling\ nozzle}{Velocity\ of\ the\ stack\ gas} \times 100$$

Estimating Measurment Uncertainty
Uncertainty estimates are calculated using the general rule of uncertainty propagation. Guidance is taken from publications including UKAS document M3003 and ISO 20988:2007.

Flow Calculations

Velocity:
From reference calculations (taken from ISO 10780):

$$\bar{v} = KC\sqrt{\frac{T_s \Delta \bar{p}}{p_e M_s}}$$

$\bar{v} =$ Average velocity (m/s)
C = velocity calculation constant = 129
Ts = Average stack temperature (K)
Ms = Molar mass of gas; assume 29 kg/kmol unless the molar mass is < 27 kg/kmol or > 31 g/kmol
K = Pitot calibration coefficient
Pe = Absolute gas pressure (kPa)
$\Delta \bar{p} =$ Average pitot tube pressure differencial (kPa)

Volume flow rate
From reference calculations (taken from ISO 10780):

$$q_{va} = \bar{v}A$$

qva = Average flow rate (m^3/s)
$\bar{v} =$ Average velocity (m/s)
A = Stack cross-sectional area (m^2)

Volume flow rate corrected for moisture
From reference calculations (taken from BS ISO 9096):

$$q_m = q_{va}\frac{(100 - H_a)}{(100 - H_m)}$$

qm = Corrected volume flowrate (m^3/s)
qva = Volume flow rate at actual conditions (m^3/s)
Ha = Moisture at actual conditions (%volume)
Hm = Reference moisture (%volume)

Volume flow rate corrected for temperature and pressure
From reference calculations (taken from BS ISO 9096):

$$q_m = q_{va}\frac{(T_m\ p_a)}{(T_a\ p_m)}$$

qm = Corrected volume flowrate (m^3/s)
qva = Volume flow rate at actual conditions (m^3/s)
Ta = Temperature at actual conditions (K)
Tm = Reference Temperatue (K)
pa = Absolute gas pressure at actual conditions (kPa)
pm = Reference pressure (kPa)

Volume flow rate corrected for oxygen
From reference calculations (taken from BS ISO 9096):

$$q_m = q_{va}\frac{(20.9 - O_{2,ref})}{(20.9 - O_{2,m})}$$

qm = Corrected volume flowrate (m^3/s)
qva = Volume flow rate at actual conditions (m^3/s)
O2,m = Actual oxygen concentration (%)
O2,ref = Reference oxygen concentration (%)

Concentration Calculations

Concentration:
From reference calculations (taken from BS EN 13284-1):

$$c = \frac{m}{V}$$

c = Concentration
m = Mass of substane
V = Volume sampled

Mass Emission

$$Mass\ emission = c \times q_m$$

c = Concentration
q = Volume flow rate

Concentration corrected for oxygen:
From reference calculations (taken from BS ISO 9096):

$$c_m = c_a \times \frac{20.9 - O_{2,ref}}{20.9 - O_{2,a}}$$

cm = Concentration at reference conditions
ca = Actual concentration
O2, ref = Reference oxygen (%)
O2, a= Actual Oxygen (%)

Concentration corrected for moisture:
From reference calculations (taken from BS ISO 9096):

Convert wet gas to dry gas

$$c_{dry} = c_{wet} \times \frac{100}{100 - H_a}$$

Convert dry gas to wet gas

$$c_{wet} = c_{dry} \times \frac{100 - H_a}{100}$$

cwet = Concentration wet gas
cdry = Concentration dry gas
Ha = Water vapour content (%vol)

Conversion of parts per million (ppm) to mg/m^3
From reference calculations (taken from EA TGN M2):

$$Concentration(mg/m^3) = \frac{Concentration(ppm) \times molecular\ weight(g)}{molar\ volume(l)\ at\ a\ given\ temperature}$$

molar volume at 273K = 22.4 litres

When Converting TOC

$$Concentration(mg/m^3) = \frac{Concentration(ppm) \times molecular\ weight\ of\ carbon\ in\ span\ gas(g)}{molar\ volume(l)\ at\ a\ given\ temperature}$$

molar volume at 273K = 22.4 litres

Calculation of Uncertainty Estimates - Instrumental Monitoring Techniques

Model equation

$$C_{ppm} = C_{reading} + Corr_{fit} + Corr_{0,dr} + Corr_{s,dr} + Corr_{rep} + Corr_{adj} + \sum_{i=1}^{p} Corr_{\inf} + Corr_{\text{int}}$$

Where:

$C_{,ppm}$	=	concentration in ppm	$Corr_{rep}$	=	correction of repeatability of measurement
$C_{NO,reading}$	=	concentration given by analyser	$Corr_{adj}$	=	correction of adjustment
$Corr_{fit}$	=	correction of lack of fit	$Corr_{inf}$	=	correction of influence quantities
$Corr_{0,dr}$	=	correction of zero drift	$Corr_{int}$	=	correction of interferents
$Corr_{s,dr}$	=	correction of span drift			

Calculation of partial uncertainties

$u(Corr_{fit}) = \dfrac{\left(\dfrac{X_{fit,\max}}{100 \times range}\right)}{\sqrt{3}}$

Where:
$X_{fit,max}$ is the maximum allowable deviation from linearity

Expressed as % of the range and calculated by applying a rectangular probability distribution

$u(Corr_{0,dr}) = \dfrac{X_{0,dr}}{\sqrt{3}}$ $\quad u(Corr_{s,dr}) = \dfrac{X_{s,dr}}{\sqrt{3}}$

$u(Corr_{rep}) = \max(S_{0,rep}\ ;\ S_{srep}) = S_{rep}$

Where:
$S_{r,0}$ is the standard uncertainty at zero level
$S_{r,s}$ is the standard uncertainty at span level

$u(Corr_{adj}) = u(Corr_{loss}) + u(Corr_{cal})$

Where:
$u(Corr_{loss})$ is the uncertainty due to losses in sample line
$u(Corr_{cal})$ is the uncertainty due to losses in sample line
$cj_{,loss}$ is the concentration of sample loss at span level
U_{cal} is the expanded uncertainty of the calibration gas

$u(Corr_{loss}) = \dfrac{C_{j,loss}}{\sqrt{3}}$

$u(Corr_{cal}) = \dfrac{U_{cal}}{2}$

$$u(Corr_{inf}) = c_j \sqrt{\frac{\left(x_{j,\max} - x_{j,adj}\right)^2 + \left(x_{j,\min} - x_{j,adj}\right) \times \left(x_{j,\max} - x_{j,adj}\right) + \left(x_{j,\min} - x_{j,adj}\right)^2}{3}}$$

Where:
c_j is the sensitivity coefficient of the influence quantity
$x_{j,min}$ is the minimum value of the influence quantity during monitoring
$x_{j,max}$ is the maximum value of the influence quantity during monitoring
$x_{j,adj}$ is the value of the influence quantity during adjustment

$$u(Corr_{int}) = \frac{c_j}{Int_{j,test}} \sqrt{\frac{Int_{j,\max}{}^2 + Int_{j,\min} \times Int_{j,\max} + Int_{j,\min}{}^2}{3}}$$

and

Where:
c_j is the sensitivity coefficient of the interferent j
$Int_{j,test}$ is the concentration of the interferent j used to determine c_j
$Int_{j,min}$ is the minimum value of the interferent j quantity during monitoring
$Int_{j,max}$ is the maximum value of the interferent j quantity during monitoring
$Int_{j,adj}$ is the concentration of the interferent j in the cal gas used to adjust the analyser
$S_{int,p}$ is the sum of interferents with positive impact
$S_{int,n}$ is the sum of interferents with negative impact

$u(\Sigma Corr_{int}) = \max\left[S_{Int,p}; S_{Int,n}\right]$

Combined uncertainty

$u(C_{,ppm}) =$

$$\sqrt{u^2(corr_{fit}) + u^2(corr_{0,dr}) + u^2(corr_{s,dr}) + u^2(corr_{rep}) + u^2(corr_{s,vf}) + u^2(corr_{a,press}) + u^2(corr_{temp}) + u^2(corr_{volt}) + u^2(corr_{adj}) + S_{Int}{}^2}$$

Overall expanded uncertainty (k = 2) $U(C_m) = u(C_m) \times k$

Uncertainty of NOx measurements

$u(C_{NOx\ ,\ conv}) = \dfrac{C_{NOx} \times R \times \eta}{\sqrt{3}}$

Where:
C_{NOx} is the concentration of NOx measured by the analyser
R is the ratio of NO:Nox in the stack gas
η is the NOx converter efficiency

Combined uncertainty NOx measurements

$u(C_{NOx\ ,\ stack}) =$

$$\sqrt{u^2(corr_{fit}) + u^2(corr_{0,dr}) + u^2(corr_{s,dr}) + u^2(corr_{rep}) + u^2(corr_{s,vf}) + u^2(corr_{a,press}) + u^2(corr_{temp}) + u^2(corr_{volt}) + u^2(corr_{adj}) + S_{Int}{}^2 + u^2(corr_{NOx,conv})}$$

Uncertainty of mass concentration at oxygen reference concentration

$u(C_{,\ O2\ ref}) =$

$$\sqrt{u^2(corr_{fit}) + u^2(corr_{0,dr}) + u^2(corr_{s,dr}) + u^2(corr_{rep}) + u^2(corr_{s,vf}) + u^2(corr_{a,press}) + u^2(corr_{temp}) + u^2(corr_{volt}) + u^2(corr_{adj}) + S_{Int}{}^2 + \left(\frac{u^2(O_{2,meas,dry})}{(21 - O_{2,meas,dry})^2}\right)}$$

Where:

$u(C,O_{2,ref})$	=	uncertainty associated with the mass concentration at O_2 ref. concentration	in	mg/m^3
$C,O_{2,ref}$	=	mass concentration at O_2 reference concentration	in	mg/m^3
$O_{2,meas}$	=	O_2 measured concentration	in	% volume
$u((O_{2,meas})dry)$	=	uncertainty associated to the measured O_2 concentration	in	% (relative to $O_{2\ meas}$)

APPENDIX 4

Uncertainty Estimate For The Measurement Of Total Organic Carbon BS EN12619:2013 (LEV 9 Exhaust Stack)

Analyser Type/Model	Sick Maihak
Reference Oxygen %	0 (0 = No correction)

		Test 1	Test 2	Test 3
Limit value	mg/m^3	75	75	75
Limit value	ppm	46.7	46.7	46.7
Measured concentration	ppm	21.6	53.3	40.6
Measured concentration	mg/m^3	34.8	85.7	65.2
Concentration at O_2 ref. concentration	mg/m^3	N/A	N/A	N/A

Calibration gas	ppm	80.7	80.7	80.7
Calibration gas	mg/m^3	129.7	129.7	129.7
Analyser range	ppm	9.3	9.3	9.3
Analyser range	mg/m^3	15.0	15.0	15.0

Correction of Lack of Fit

Lack of fit	% range	2.0	2.0	2.0
	$u(Corr_{rfit})$	0.11	0.11	0.11

Corrections of Zero and Span Drift (*All drift is calculated for ∴ the residual is assumed to be < 5% u(max))

Zero Drift	% range	0.00	0.00	0.00
	$u(Corr_{r0dr})$	0.00	0.00	0.00
Span Drift	% range	0.00	0.00	0.00
	$u(Corr_{rsdr})$	0.00	0.00	0.00

Correction of Repeatability of Measurement

Repeatability SD at span level	% range	0.0	0.0	0.0
(Not reported)	$u(Corr_{rrep})$	0.00	0.00	0.00

Correction of adjustment

losses in the line	% range	0.12	0.12	0.12
	$u(Corr_{rloss})$	0.02	0.04	0.03
Uncertainty of calibration gas	% range	2.0	2.0	2.0
	$u(Corr_{rcal})$	0.22	0.53	0.41

Correction of Influence of Interferents

N_2O	% range			
	$u(Corr_{rN2O})$	0.00	0.00	0.00
CO_2	% range			
	$u(Corr_{rCO2})$	0.00	0.00	0.00
CH_4	% range			
	$u(Corr_{rCH4})$	0.00	0.00	0.00
Total of interferent influences $u(\Sigma Corrint) = \max[S_{Int.p}; S_{Int.n}]$	% range	2.50	2.50	2.50
	$u(\Sigma Corr_{int})$	0.16	0.16	0.16

Correction of Influence Quantities

Sensitivity to sample volume flow	% range	1.60	1.60	1.60
	$u(Corr_{rflow})$	0.09	0.09	0.09
Sensitivity to atmospheric pressure	% range			
(Not reported)	$u(Corr_{rpress})$	0.00	0.00	0.00
Sensitivity to ambient temperature	% range	-2.40	-2.40	-2.40
	$u(Corr_{rtemp})$	-0.28	-0.28	-0.28
Sensitivity to electrical voltage	% range	0.50	0.50	0.50
(Not reported)	$u(Corr_{rvolt})$	0.10	0.10	0.10

Interferent Concentration Variations	Minimum	Maximum	Value at cal	Performance	Units
CH_4 range	0	10	0	50	mg/m^3
N_2O range	0	0	0	20	mg/m^3
CO_2 range	8	12	0	15	mg/m^3
Oxygen effect variations	Minimum	Maximum	Value at cal	Performance	Units
Oxygen effect	0	20	0	2	mg/m^3

Influence Quantitiy Variations

	Minimum	Maximum	Value at cal	Performance	Units
Sensitivity to sample volume flow	55	65	60	5	l/h
Sensitivity to atmospheric pressure	99	100	99	1	kPa
Sensitivity to ambient temperature	278	313	288	10	K
Sensitivity to electrical voltage	187	250	230	5	V

Measurement uncertainty		Test 1	Test 2	Test 3
Combined uncertainty	ppm	0.42	0.65	0.55
Combined uncertainty	mg/m^3	0.68	1.04	0.88
Combined uncertainty at oxygen reference	mg/m^3	0.68	1.04	0.88

Expanded uncertainty expressed with a level of confidence of 95%, k=2

Overall uncertainty	ppm	0.8	1.3	1.1
Overall uncertainty	mg/m^3	1.4	2.1	1.8
Overall uncertainty relative to measured value	%	3.9	2.4	2.7
Overall uncertainty relative to range	%	9.1	13.9	11.7
Overall uncertainty relative to ELV	%	1.1	1.6	1.4

The uncertainty evaluation has been carried out in accordance with UKAS requirements.

Uncertainty Estimate For The Measurement Of Total Organic Carbon BS EN12619:2013 (LEV 9 Ducting After Tools Process)

Analyser Type/Model	Sick Maihak
Reference Oxygen %	0 (0 = No correction)

		Test 1	Test 2	Test 3
Limit value	mg/m^3	75	75	75
Limit value	ppm	46.7	46.7	46.7
Measured concentration	ppm	3.4	2.3	2.1
Measured concentration	mg/m^3	5.4	3.7	3.3
Concentration at O_2 ref. concentration	mg/m^3	N/A	N/A	N/A

Calibration gas	ppm	80.7	80.7	80.7
Calibration gas	mg/m^3	129.7	129.7	129.7
Analyser range	ppm	9.3	9.3	9.3
Analyser range	mg/m^3	15.0	15.0	15.0

Correction of Lack of Fit

Lack of fit	% range	2.0	2.0	2.0
	$u(Corr_{rfit})$	0.11	0.11	0.11

Corrections of Zero and Span Drift (*All drift is calculated for ∴ the residual is assumed to be < 5% u(max))

Zero Drift	% range	0.00	0.00	0.00
	$u(Corr_{r0dr})$	0.00	0.00	0.00
Span Drift	% range	0.00	0.00	0.00
	$u(Corr_{rsdr})$	0.00	0.00	0.00

Correction of Repeatability of Measurement

Repeatability SD at span level	% range	0.0	0.0	0.0
(Not reported)	$u(Corr_{rrep})$	0.00	0.00	0.00

Correction of adjustment

losses in the line	% range	0.12	0.12	0.12
	$u(Corr_{rloss})$	0.00	0.00	0.00
Uncertainty of calibration gas	% range	2.0	2.0	2.0
	$u(Corr_{rcal})$	0.03	0.02	0.02

Correction of Influence of Interferents

N_2O	% range			
	$u(Corr_{rN2O})$	0.00	0.00	0.00
CO_2	% range			
	$u(Corr_{rCO2})$	0.00	0.00	0.00
CH_4	% range			
	$u(Corr_{rCH4})$	0.00	0.00	0.00
Total of interferent influences $u(\Sigma Corrint) = \max[S_{Int.p}; S_{Int,n}]$	% range	2.50	2.50	2.50
	$u(\Sigma Corr_{int})$	0.16	0.16	0.16

Correction of Influence Quantities

Sensitivity to sample volume flow	% range	1.60	1.60	1.60
	$u(Corr_{rflow})$	0.09	0.09	0.09
Sensitivity to atmospheric pressure	% range			
(Not reported)	$u(Corr_{rpress})$	0.00	0.00	0.00
Sensitivity to ambient temperature	% range	-2.40	-2.40	-2.40
	$u(Corr_{rtemp})$	-0.28	-0.28	-0.28
Sensitivity to electrical voltage	% range	0.50	0.50	0.50
(Not reported)	$u(Corr_{rvolt})$	0.10	0.10	0.10

Interferent Concentration Variations	Minimum	Maximum	Value at cal	Performance	Units
CH_4 range	0	10	0	50	mg/m^3
N_2O range	0	0	0	20	mg/m^3
CO_2 range	8	12	0	15	mg/m^3
Oxygen effect variations	Minimum	Maximum	Value at cal	Performance	Units
Oxygen effect	0	20	0	2	mg/m^3

Influence Quantitiy Variations

	Minimum	Maximum	Value at cal	Performance	Units
Sensitivity to sample volume flow	55	65	60	5	l/h
Sensitivity to atmospheric pressure	99	100	99	1	kPa
Sensitivity to ambient temperature	278	313	288	10	K
Sensitivity to electrical voltage	187	250	230	5	V

Measurement uncertainty		Test 1	Test 2	Test 3
Combined uncertainty	ppm	0.37	0.37	0.37
Combined uncertainty	mg/m^3	0.59	0.59	0.59
Combined uncertainty at oxygen reference	mg/m^3	0.59	0.59	0.59

Expanded uncertainty expressed with a level of confidence of 95%, k=2

Overall uncertainty	ppm	0.7	0.7	0.7
Overall uncertainty	mg/m^3	1.2	1.2	1.2
Overall uncertainty relative to measured value	%	21.7	31.4	35.6
Overall uncertainty relative to range	%	7.9	7.8	7.8
Overall uncertainty relative to ELV	%	0.9	0.9	0.9

The uncertainty evaluation has been carried out in accordance with UKAS requirements.