

Old Dutch®

Foods Limited



100 Bentall Street, Winnipeg, Manitoba R2X 2Y5 • Telephone (204) 632-0249 • Fax (204) 632-7016

Date: November 2, 2017

Director
Environmental Approvals Branch
Manitoba Sustainable Development
Suite 160, 123 Main Street
Winnipeg, Manitoba R3C 1A5

Dear Sir/Madam:

Old Dutch Foods Ltd with Environment Act licence # 1076 is pleased to submit the completed Environment Act Proposal Form, Environment Act Proposal and \$7500 application fee that you requested. Please advise if you have any questions regarding the attached documents or if you require additional information.

Sincerely,

A handwritten signature in black ink that reads "Mary Jane Porte".

Mary Jane Porte
Plant Manager
(204) 632-3716

"manufacturers of fine quality foods"

Environment Act Proposal Form



Name of the development: Installation of wastewater system, kettle fryers, packaging machines, distribution		
Type of development per Classes of Development Regulation (Manitoba Regulation 164/88): Class 2 Developments		
Legal name of the applicant: Old Dutch Foods Ltd.		
Mailing address of the applicant: 100 Bentall Street		
Contact Person: Mary Jane Porte		
City: Winnipeg	Province: MB	Postal Code: R2X2Y5
Phone Number: (204) 632-0249 Fax: (204) 632-7016 email: maryjane.porte@olddutchfoods.com		
Location of the development: 100 Bentall St. Winnipeg, MB R2X2Y5		
Contact Person: Mary Jane Porte		
Street Address: 100 Bentall Street		
Legal Description: Old Dutch Foods Ltd.		
City/Town: Winnipeg	Province: MB	Postal Code: R2X2Y5
Phone Number: (204) 632-0249 Fax: (204) 632-7016 email: maryjane.porte@olddutchfoods.com		
Name of proponent contact person for purposes of the environmental assessment: Mary Jane Porte		
Phone: (204) 632-3716	Mailing address: 100 Bentall Street, Winnipeg, MB R2X 2Y5	
Fax: (204) 632-7016		
Email address: maryjane.porte@olddutchfoods.com		
Webpage address: www.olddutchfoods.com		
Date: Nov 2, 2017	Signature of proponent, or corporate principal of corporate proponent: 	
	Printed name: MARY JANE PORTE	

PRINT

RESET

A complete **Environment Act Proposal (EAP)** consists of the following components:

- Cover letter**
- Environment Act Proposal Form**
- Reports/plans supporting the EAP** (see ["Information Bulletin - Environment Act Proposal Report Guidelines"](#) for required information and number of copies)
- Application fee** (Cheque, payable to Minister of Finance, for the appropriate fee)

Per Environment Act Fees Regulation
(Manitoba Regulation 168/96):

Class 1 Developments	\$1,000
Class 2 Developments	\$7,500
Class 3 Developments:	
Transportation and Transmission Lines ..	\$10,000
Water Developments	\$60,000
Energy and Mining.....	\$120,000

Submit the complete EAP to:

Director
Environmental Approvals Branch
Manitoba Conservation and Water Stewardship
Suite 160, 123 Main Street
Winnipeg, Manitoba R3C 1A5

For more information:

Phone: (204) 945-8321

Fax: (204) 945-5229

<http://www.gov.mb.ca/sd/eal>

Environment Act Proposal

Old Dutch Foods Ltd. – Winnipeg Manitoba

Environmental Act Licence No. 1076

A. Executive Summary

Old Dutch Foods Ltd. in Winnipeg, MB manufactures seasoned and salted potato chips. From 1989 to date the company made a lot of improvements to its facility to meet the market demand, increase production efficiency, replace obsolete machineries with high efficient and automated equipment, increase line extension, eliminate if not minimize environmental pollutants and comply with regulatory standards. The changes that were made in the facility are the following: Installation of wastewater system to treat the wastewater and reduce the BOD, Total Suspended solids (TSS), total nitrogen, and total phosphorus in effluent being discharged to the sewer system; Installation of 2 kettle fryers, 3 additional packaging machines, and kettle chips distribution system to extend product line; Installation of air handling heater unit (AHU) to improve the ventilation and heating in the facility; Installation of pan washer to clean packaging machine parts efficiently, effectively and in accordance with food safety standards; Installation of Oberlin oil filter system to reduce the free fatty acid of used oil; Installation of nitrogen and air supply upgrade; Installation of Best Sorter for PC32 to replace obsolete Optical Sorter to increase production efficiency and have consistent product quality; Replacement of 4 obsolete packaging machines with high speed Polaris 3 packaging machine to accommodate the production of smaller bags; Installation of Best Sorter for kettle line to increase production efficiency and have consistent product quality; Installation of shrink wrap machine for variety pack production; Replacement and automation of potato holding bins to increase production efficiency and replace old equipment; Installation of shrink wrap machine for variety pack production; Automation of PC32 cooker to increase production efficiency and replaced obsolete controller; Replacement of old Heat Exchanger; Installation of CAF thickening device to optimize the wastewater treatment; Replacement of 2 obsolete Polaris E packaging machines with Polaris 3c to improve production efficiency; and installation of 6 metal detectors. The carbon emissions data between 1997-2005 and 2006-2016 were analyzed and compared to determine the significant impact of the aforementioned changes to the environment. Based on the analysis there was a 30% increase in carbon emissions from 2006-2016 when compared to 1997-2005 due to increase in production volume. However, ODF processing plant average total carbon emissions is still below the annual threshold of 10,000 MT CO₂ to a cap of 25000 MT CO₂ by the Western Climate Initiative (WCI) threshold for greenhouse gas (GHG) reporting since ODF calculated CO₂ emissions in 1994-2005 was 3672 MT CO₂ while the calculated CO₂ emissions in 2006-2016 was 2560-4649 MT CO₂. Please note that the ODF used the emissions factor of 0.0019 MT CO₂ equivalents per cubic meter of natural gas for industrial, commercial and residential combustion to calculate for the CO₂ emissions. This factor was provided by Manitoba Hydro and is based on the data provided in the Environment Canada Inventory Report,

annex 8. There was no change in the list of hazardous materials after the equipment installation. Consideration is given to local activities, biophysical environment and the development on human health and safety that may have a potentially adverse impact, and measures are taken to prevent product contamination.

B. Introduction and Background

Old Dutch Foods Ltd. aims for continuous improvement to keep up with the market, demand, trend and technology advancement, ensure food safety and quality of our products, provide consumers with exciting & innovative products, ensure safety of our employees, maximize production efficiency, and ensure compliance to federal, provincial and municipal regulatory and legislative standards for health and safety, food safety and environment. For these reasons, Old Dutch Foods Ltd in Winnipeg plant made some improvements and changes in the facility from 1986 to date which include the installation of wastewater system, extension of product lines (kettle and variety pack), replacement of obsolete equipment (heat exchanger, holding bins system, packaging machines), automation of equipment (PC32 continuous cooker, holding bin system, distribution system), installation of HVAC system & nitrogen generator, and addition of new and high efficient equipment (Best sorter for kettle and PC32 lines). Old Dutch Foods Ltd. considered the environment, waste reduction, efficiency and safety of our products & employees when these changes were made and implemented.

C. Description of Proposed Development

The following alterations had been done at Old Dutch Foods Ltd, Winnipeg facility from 1989 to 2017:

1. Installation of the wastewater system to treat the wastewater and reduce the BOD, total suspended solids, Total Nitrogen and Total Phosphorus of effluent being discharged to the sewer
 - Installed in February 1994
 - Scope of works includes installation of platform for drumshears and CAF system, drumshear for solid waste, drumshear for untreated wastewater coming from potato unloading area, cooker area, peeler and inspection area, parallel plate clarifier tank for starch, parallel plate clarifier tank for untreated wastewater, feed reservoir, activayor, mixing tank, Cavitation air flotation (CAF) system, holding tank, solids screening press, auger, chemical metering pumps, moyno pump, transfer pump, sandpiper pumps, motors, flow meter, control panel, floor drains, plumbing and piping installation for wastewater, air supply and water supply lines, and electrical installation.

2. Installation of 2 Kettle Fryers, 3 additional Packaging Machines, and kettle chips distribution system to extend product line

- Installed in July 2006
- The scope of work includes the following:
 - Fabricate and install conveyor supports, offload cooker hoods & oil tank-hoist to mezzanine level-RR
 - Modify of peeler room & slicer infeed equipment
 - Install cooker hoods, level & adjust cooker hoods
 - Install new fresh oil tank, auger conveyors, packaging conveyors & tipper, cookers, conveyors, electrical panels, oil tank grouting.
 - Fabricate pack table frames
 - Weld electrical panels
 - Modify /install cooling conveyors, continue hoods/stacks, oil tank concrete fill, fabricate catwalks, modify conveyor supports-scale platform
 - Install distribution conveyors, place Ishida scales, set Star filter & used oil tank, fabricate & install walkways
 - Fabricate packer table frames
 - Modify of scale platform for Atlas.
 - Fabricate platform stairs, seasoning panel stands & install panels
 - Fabricate handrails/kickplate ,packaging table turntable, install Atlas scales & welding, fabricate finished product conveyors, place N2 generator equipment, weld N2 supply pipe brackets, fabricate beam bedding\
 - fabricate & install conveyors, walkway handrails, electrical boxes, set compressor
 - fabricate & install conveyor & bushings, fabricate, paint & install oil tank guard
 - fabricate slicer & peeler platforms
 - fabricate tipper guard, install slicer & peeler platform
 - fabricate tipper guard, install hot water boiler equipment, complete slicer/peeler stairs & platforms
 - Sandblast tipper guard, clean previous welds, and seal holes in peeler room floor.
 - Coat tipper guard with food grade Protekote & install
 - Install & wire potato bin VFD drives for automatic control system
 - Install electrical cable tray for new packaging machines
 - Relocate light fixture
 - Install & wire potato supply control panel
 - Install electrical peeler room, new auger conveyor
 - Disconnect distribution conveyors for relocating
 - Supply 2 seasoning control panels
 - Kettle & packaging systems---wire, cable, conduit, fittings installation
 - Install electrical for Ludell water heater
 - Wire & connect safety switches for tipper cage
 - Install SS guards at cookers motor control centre (MCC)
 - Install cooker indicator beacons
 - Install 3 aluminum, carton chutes, stainless steel motor control centre guards and trial seasoning chute
 - Ludell hot water boiler installation & water plumbing

- Install exhaust stack, insulate hot water piping
- Oil system pumps, valves & plumbing; combustion gas & air plumbing
- Fabricate & install kettle stack
- Cooker /filter plumbing and welding
- Tag valves
- fabricate & install brackets to support fryers piping
- Installation & plumbing of Nitrogen Generator, air compressor & dryer
- Install air compressor cooling air ductwork, motorized dampers and damper motors, and insulation
- Fabricate mold & 3 new pack-off tables
- Roof penetrations for stacks & blowers, sleepers & cladding
- Construct new hall/walkway to separate and redirect foot traffic at new packaging line
- Frame in 10 x 10 overhead door- boiler & compressor rooms -treated lumber, insulate & exterior metal cladding
- Temp control & combustion/intake and exhaust air installation

3. Installation of air handling heater unit (AHU) to improve the ventilation and heating at the facility

- Installed in June 2007 to May 2008
- The scope of work includes fabrication and installation of structural support; placed air handler plus new bollards to protect well water return line; relocation of the well water distribution line and upgraded the AMU progress to Oct 17. March 20, 2008: sheet metal – wall openings/hoarding and plumbing were done as well as wired and connected the AHU

4. Installation of Pan washer for washing Ishida machine parts

- Installed in Aug 2007
- The scope of work includes the following:
 - Fabricate and install pan washer platform
 - Paint platform with 3 coats of epoxy paint
 - Install exhaust for pan washer
 - Plumbing of hot and cold water supply lines and valves
 - Wire and connected pan washer
 - Install splitter and 2 x 100 amp switches
 - Curb and seal roof penetration for pan washer exhaust stack

5. Installation of Oberlin Oil Filter system to treat used oil and reduce the free fatty acid

- Installed in May-August 2008
- The scope of work includes the following:
 - Lift filter and storage tank to mezzanine
 - Expand door opening for oil storage tank starter base

- Move and hoist 2000 gal storage tank into position
- Install 2 control units for Oberlin oil filter system
- Support additions
- Install electrical wiring
- Installation and plumbing of oil filtering system

6. Nitrogen and air supply upgrade

- Installed in June to December 2009
- The scope of work includes the following:
 - Install wiring for 126 HP 575V air compressor and dryer
 - Run CAT 5 cable from electrical room to compressor room, install 3 x HRCU class J fuses to MB hydro
 - Mount 3 control boxes, run modem telephone line, mount compressor switches
 - Manufacture and install nitrogen tank guard rail as required by Department of Labour
 - System installation
 - Correct safety relief valves as required by MB Hydro and Department of Labour
 - Install and test 9 relief valves
 - Hook up electrical for relocation of GA75 air compressor
 - Install air supply ducting to relocated GA75 VSD compressor
 - Install 3 damper actuators for GA 75 VSD
 - Test DDC programming

7. Installation of Best Sorter for PC32 to replace old Optical sorter, to increase production efficiency and to have consistent product quality.

- Installed in January to March 2010
- The scope of work includes the following:
 - Manufacture key conveyor support legs extensions
 - Insulation and installation of clamps for PVC chiller lines
 - Lift and place sorter on Mezzanine
 - Installation of Best Sorter electrical
 - Modify key conveyor for infeed to Best Sorter
 - Shorten outfeed chain conveyor

8. Replacement of 4 obsolete packaging machines with high speed Polaris 3 packaging machine for 16g bags production

- Installed in May to November 2010
- The scope of work includes the following:
 - Connect new conveyors and Bulk Storage Unit (BSU)
 - Install 600 amp distribution panel with all breakers and 600 amp Main

- Install 480 V panel on mezzanine and supply 600/480 transformer
- Install access stairway and walkway and SS platform
- Wire and connect 4 new packaging machines
- Set Ishida scales including deck modification
- Install 4 – electrical plugs for pack off conveyors and turntables
- Installation of Ishida scales

9. Installation of Best sorter for Kettle Line to increase production efficiency and have consistent product quality

- Installed in May to June 2012
- The scope of work includes:
 - Lift and place sorter on the fryer area
 - Installation of sorter electrical
 - Installation of Best sorter

10. Installation of shrink wrap machine for variety pack

- Installed in May to June 2015
- The scope of work includes:
 - Move and place the shrink wrapper in the designated area in the Dutch Crunch room
 - Install the shrink wrapper machines
 - Install the conduit and electrical for the shrink wrap machine

11. Replacement and automation of potato holding bins to increase production efficiency and replace old equipment.

- Installed in January 2016
- The scope of work includes:
 - Demolition of exterior black wall at the rear of Potato Storage Room and installation of temporary roll up door. This will be used to remove existing bins and access for new bins.
 - Remove bins legs, tilt belts, supporting framework, catwalk, belt, potato flume
 - Cut and remove HVAC unit cold water supply, hot water, return lines.
 - Disconnect and remove air handler from unit from ceiling.
 - Bin system positioning and installation.
 - Install horizontal apportioning conveyor, bin filling auger, access catwalk, product flume.
 - Relocate and install destoner tank, potato pump assembly, Lakos filtration system, incline conveyor, pit pump and HVAC unit.
 - Install potato diameter sizer.
 - Electrical installation for bin system, HVAC unit, Motor Control Center, and Disconnect switches

- Install zero speed proximity sensors on existing conveyors
- Install proximity sensor on the flume water flow flap
- Install hydro lift tank start level switch
- Install zero speed proximity sensor on the new sizer
- Network switch panel fabrication
- Network cable installation
- Bin system HMI development
- Bin system PLC program development
- Switch panel fabrication
- Install servers in office network rack

12. Automation of PC 32 cooker to increase production efficiency.

- Installed in May 2016
- The Scope of work includes:
 - Upgrade piping of Fryer CIP, JIB flush, heat exchanger and oil tank.
 - Install new valves.
 - Install and wire all actuators, limit switches and solenoids.
 - Fabrication and Installation of Motor Control Center
 - Upgrade paddle and submerger drive split of PC32 cooker.
 - Install an analog oil level sensor
 - Install position feedback sensor on HX damper linkage
 - Develop fryer HMI, PLC program
 - Fabricate the fryer HMI panel
 - Move salter VFD to the salter frame
 - Install safety switches on the slicer covers
 - Replace the vibratory salting conveyor with a belt conveyor
 - Install oil tank level sensors
 - Design and install a CIP water and caustic supply and recovery system
 - Automate the oil handling and drain valve

13. Replacement of old Heat Exchanger since insulation is worn out and booster line was leaking.

- Installed in Oct 27-Nov 3, 2016
- The scope of work includes:
 - Remove old Heat Exchanger, ducting, stack, old booster heater, process piping, gas train, small air handler and heater
 - Modifications of the roof to allow for removal and re-install of the booster heater
 - Install new heat exchanger, new booster heater and stack
 - Install approximately 20' of new 6" cs pipe to the new heat exchanger booster lines

- Install new roof curb/flashing
- Re-install circulation piping
- Piping of gas train
- Relocation and re-supporting of the existing duct to match the new unit
- Disconnect and reconnect the electrical wiring of the unit
- Install small scaffold for piping re-install
- Insulation of piping and headers

14. Installation of CAF thickening device to optimize the waste water treatment.

- Installed in Aug 8, 2016
- The scope of work includes:
 - Wire one 4-20mA output from existing flow meter to input card on RTC-ST (feed sludge flow)
 - Wire one 4-20 mA output from RTC-ST to existing analog splitter box (polymer dose)
 - Mount the Hach RTC cabinet and Solitax SC1000
 - Install conduit and run power supply (120vAC 13A) to Solitax SC1000 and RTC-ST module
 - Install Solitax SC 1000, RTC113 Sludge Thickening Module, and EWON Cellular Modem
 - Pull 1 conductor shielded cable (18 AWG Twisted Pair) between sc1000 communication card and RTC-ST module
 - Wire the cable from 2 SOLITAX™ and 1 DPD1P1 to the sc1000 controller
 - Install probes

15. Replacement of 2 obsolete Polaris E packaging machines to improve production efficiency.

- Installed in May, 2017
- The scope of work includes:
 - Remove old Polaris E packaging machines and Ishida machines
 - Install 2 new Polaris machines and 2 Ishida machines
 - Install electrical wiring
 - Commissioning and testing

16. Installation of 6 metal detectors for the packaging machine.

- Installed in May, 2017
- The scope of work includes:
 - Install brackets, cylinder and cone
 - Install electrical wiring
 - Install the metal detector
 - Calibration, commissioning and testing

D. Description of Existing Environment in the Project Area

Old Dutch Foods Ltd. is located in the Inkster Industrial Park at 100 Bentall Street, Winnipeg, Manitoba, Canada. The park is contemporary by Winnipeg standards and is located in the centre/north sector of the city. It has all municipal service. There are good traffic arteries serving the Park. The park is conveniently located for downtown, the Winnipeg Airport, the St. James Industrial Park, and community facilities such as the Polo Park Shopping Centre. The area is 8.02 acres. It is zoned MP2 which is approved for warehousing and light industrial use. The building was built in 1977. The total area of the building is 132,247 square feet. The site is irregular in shape. It is located at the end of Bentall Street which is a cul-de-sac off Mountain Avenue. There is no access to any other traffic artery or lane. The site is flat. There appears to be no problem with site drainage or back-up of sewers. Consideration is given to local activities that may have a potentially adverse impact, and measures are taken to prevent product contamination. The site boundaries are clearly defined. Measures necessary to protect the site from any potential contaminants are in place and periodically reviewed to ensure they continue to be effective. The company also finds ways to eliminate if not minimize environmental pollutants and abides by the regulatory guidelines by the province of Manitoba and other federal regulatory requirements.

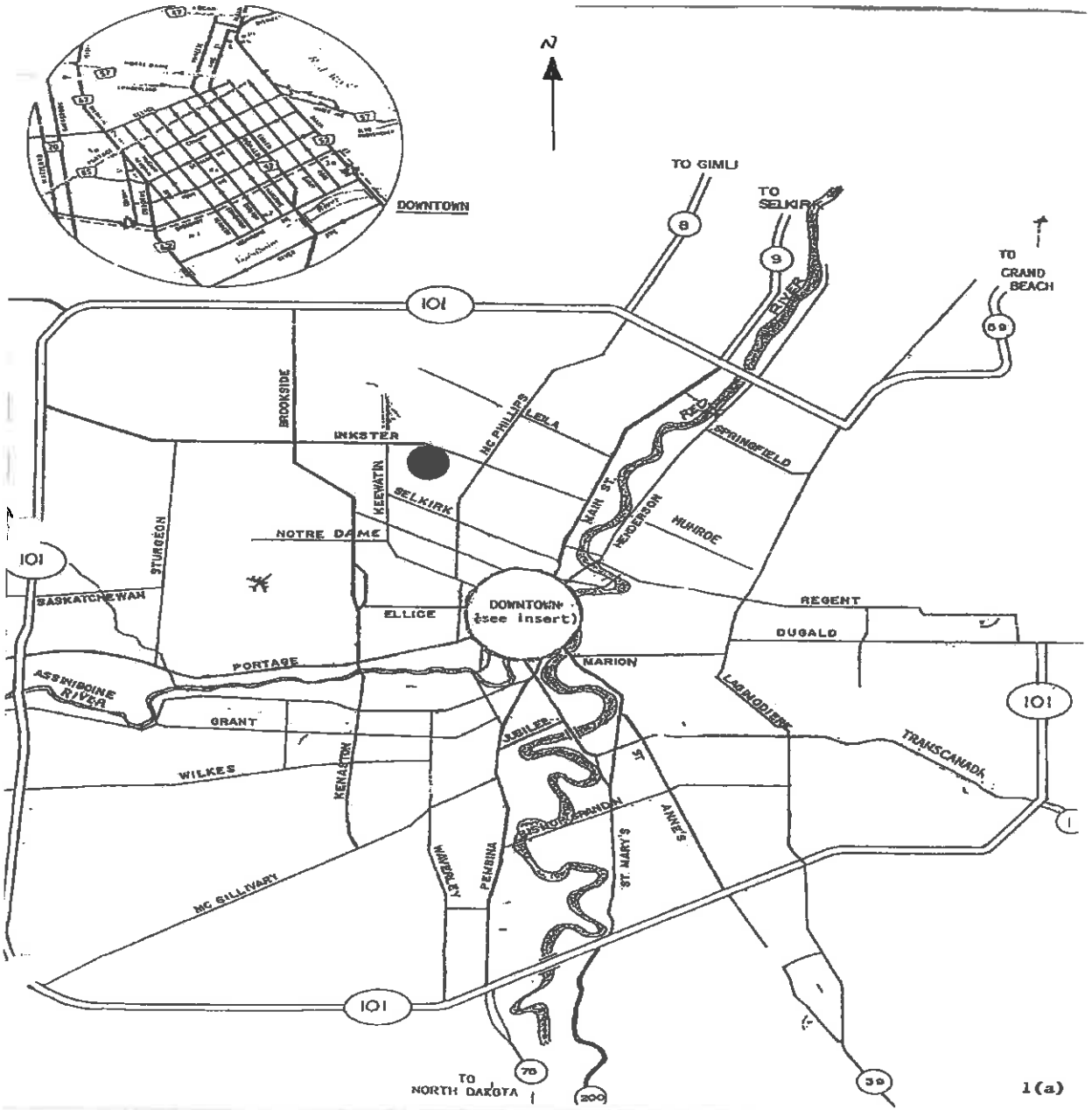
The facility is surrounded by the following establishments:

North West: Smith's Quality Meats - Manufacturer of beef and bison burgers, smoked, cooked and sausage products including corned beef, roast beef, salami, pepperoni and smokies. Smith's also supplies portioned-controlled beef, pork, lamb, veal and bison to the food service industry; *North East: Felder Machinery Imports* - Distributor of Felder, Hammer and Format 4 Machines in Western Canada as well as woodworking machines, tools and accessories from leading manufactures; *North East: Heritage Baptist Church*; *West: Richellieu Hardware* - An importer, distributor and manufacturer of specialty hardware and complementary products; *East: Winnipeg Free Press* - Newspaper printing and distribution; *West: McKillican Canadian* - Largest wholesale distributors of specialty building materials; *South East: Public Works & Government Services Canada Building*; *Across the Street - Cormer Group Industries* - Experts in precision high speed machining and integration of components and assemblies of aerospace parts; *South West: Lifetouch*- Provides photography services; *South West: ProTELEC Alarms* - Provides residential, personal and commercial security and alarm services; and *South East: Wood Wyant Supplies*- Distributor of sanitation chemicals.

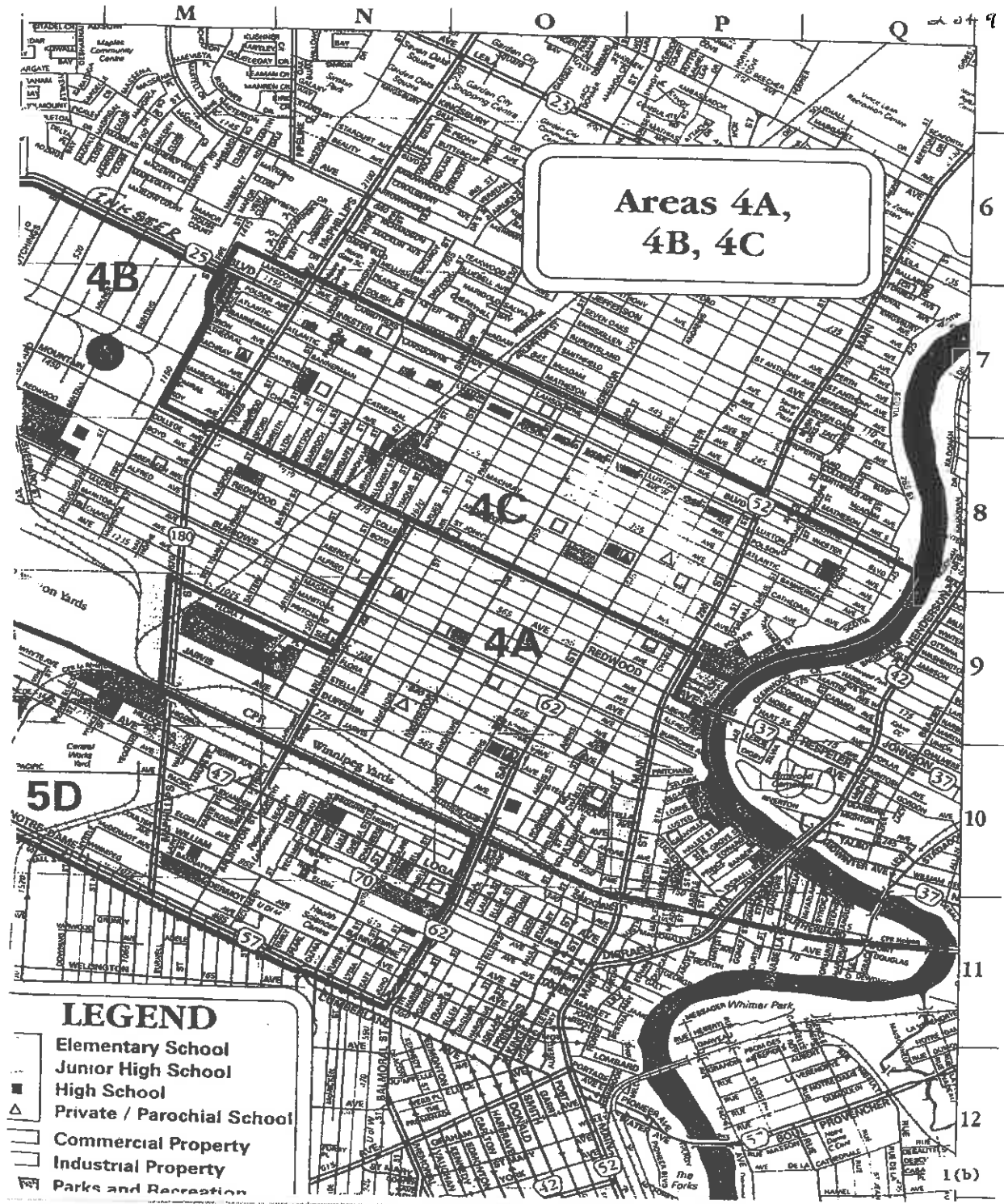
The Potato chips processing is described below:

Potatoes are transferred to the potato hopper in the peeler room through the flume system. Potatoes from the potato hopper are transferred into the designated peeler which are peeled then inspected at the inspection table. From the inspection table the peeled potatoes are directed to the slicers using the transfer augers then to the catch can for PC32 line or potato batch weight hopper for Kettle line. Potatoes from the hopper are sliced using the slicer heads. Potato slices from the PC-32 continuous cooker undergo wash step then they pass through an air blower, removing excess water prior to entering the cooker where they are fried. The potato slices from the Kettle line are transferred in the designated kettle fryer using the bi-directional conveyor then they are fried at approximately 11 minutes per batch. Finished chips are inspected using the Best Sorter where chips with defects are rejected. Once chips are inspected they are transferred into the distribution system which consists of the transfer 1, transfer 2, shakers & cross feeders. A Chip sizer may be used depending on the production schedule. Chips are seasoned or salted, equipment such as seasoning hoppers, tecweighs, seasoning drums and secondary feeders are used during the seasoning application. Then chips are weighed using the Ishida Machine and packaged in the designated packaging bag using the Packaging machines. Products are boxed then scanned using the x-ray machine prior to storage to the finished product warehouse.

Site Location Map










Site Area Map



Areas 4A,
4B, 4C

LEGEND

-  Elementary School
-  Junior High School
-  High School
-  Private / Parochial School
-  Commercial Property
-  Industrial Property
-  Parks and Recreation

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Map of business establishments surrounding site vicinity



E. Description of Environmental and Human Health Effects of the Proposed Development

The installation of wastewater treatment in 1994 and the CAF thickening device to optimize the waste water treatment have positive impact on the environment since the wastewater system reduces the BOD, TSS, Nitrogen and phosphorus of effluent being discharged to the sewer.

The addition of kettle fryers to extend the product line may have contributed to the carbon emissions increased of 30% from 2006 to 2016 when compared to 1997-2005 data because it has increased the production volume of ODF Winnipeg facility by 18%, however in general no significant impact on the environment was noted from the alterations that were made from 1986 to date. Since the overall the average total carbon emission by ODF processing plant from 1997 to 2016 was 3672 MT CO₂ with the range of 2520- 4649 MT CO₂. This number is below the threshold of 10,000 MT CO₂ to a cap of 25000 MT CO₂ annually by the Western Climate Initiative's (WCI) threshold for greenhouse gas (GHG) reporting. Please see the attached CO₂ emissions data for your reference. Please note that ODF used the emissions factor of 0.0019 MT CO₂ equivalents per cubic meter of natural gas for industrial, commercial and residential combustion to calculate the CO₂ emissions. This emissions factor was provided by Manitoba Hydro and is based on the data provided in the Environment Canada Inventory Report, annex 8.

The new equipment that Old Dutch Foods Ltd installed in the recent years is energy efficient which can lead to a substantial reduction in energy.

There was no change in the list of hazardous materials after the equipment installation. Please also note that ODF has waste disposal program in place to ensure compliance to food safety, health safety, federal, provincial and municipal regulations and standards.

Old Dutch Foods Ltd. Yearly Carbon Emissions and Production Volume Analysis and Data

Year	CUM GAS USED	CO ₂ Emissions, MT (Correction Factor: 0.0019 tonnes CO ₂ e/m ³)	Difference in CO ₂ emissions (Current Year v.s. Previous Year)	% Change	Description of Alteration	Production Volume, lbs	% Change
1997	1,605,934	3051				10,649,106	
1998	1,508,316	2866	-185	-6%		8,896,601	-16%
1999	1,770,477	3364	498	17%		10,958,600	23%
2000	1,814,626	3448	84	2%		11,431,954	4%
2001	1,655,622	3146	-302	-9%		10,759,346	-6%
2002	1,326,168	2520	-626	-20%		8,459,624	-21%
2003	1,705,676	3241	721	29%		10,734,490	27%
2004	1,841,309	3498	258	8%		12,103,562	13%
2005	1,703,071	3236	-263	-8%		10,941,498	-10%
2006	1,828,251	3474	238	7%	Installation of 2 Kettle Fryers, 3 additional Packaging Machines, and kettle chips distribution system to extend product line	11,958,653	9%
2007	2,186,504	4154	681	20%	Installation of air handling heater unit (AHU) to improve the ventilation and heating at the facility. Installation of Pan washer for washing Ishida machine parts	13,135,919	10%
2008	2,388,349	4538	384	9%	Installation of Oberlin Oil Filter system to treat used oil and reduce the free fatty acid	13,964,520	6%

2009	2,446,930	4649	111	2%	Nitrogen and air supply upgrade	14,433,092	3%
					Installation of Best Sorter for PC32 to replace old Optisort, to increase production efficiency and to have consistent product quality.		
2010	2,154,757	4094	-555	-12%	Replacement of 4 obsolete packaging machines with high speed Polaris 3 packaging machine for 16g bags production	12,180,137	-16%
2011	2,231,186	4239	145	4%		12,677,632	4%
2012	2,029,548	3856	-383	-9%	Installation of Best sorter for Kettle Line to increase production efficiency and have consistent product quality	11,338,334	-11%
2013	2,153,397	4091	235	6%		11,407,989	1%
2014	2,153,397	4091	0.0000	0%		11,244,871	-1%
2015	2,022,863	3843	-248	-6%	Installation of Shrink Wrap Machine	11,391,603	1%
					Replacement and automation of potato holding bins to increase production efficiency and replace old equipment.		
					Automation of PC 32 cooker to increase production efficiency.		
					Replacement of old Heat Exchanger since insulation is worn out and booster line was leaking		
					Installation of CAF thickening device to optimize the waste water treatment.		
2016	2,129,857	4047	203	5%		12,626,892	11%

Note:

3672 Average CO2 emissions 1997-2016

3152 Average CO2 emissions 1997-2005

4098 Average CO2 emissions 2006-2016

increased in CO2 emissions after the installation and/or replacement of equipment and production volume increase from 2006-2016, MT

% Change in CO2 emissions 1997-2005 v.s. 2006-2016

10,548,309

12,396,331

1,848,022

18%

Average Production Volume 1997-2005

Average Production Volume 2006-2016

Average Production Volume Increase 2006-2016

% change in production volume 1997-2005 v.s. 2006-2006

2519.72 ODF Minimum CO2 emissions 1997-2016
4649.17 ODF Maximum CO2 emissions 1997-2016

10000 MT to a cap of 25000 MT

CO2 emissions Threshold for greenhouse gas (GHG) reporting by Western Climate Initiative's (WCI)



F. Mitigations Measures and Residual Environmental Effects

Old Dutch Foods Ltd waste management program is described below. This program ensures that waste generated from plant operations are managed and disposed of according to the food safety, health safety, federal, provincial and municipal regulations and standards.

2.1.6 Waste Disposal

Objective:

1. To ensure that waste is effectively, efficiently and regularly removed from premise and processing environment
2. To ensure that waste is handled and stored properly in the designated area

Scope: Dry, liquid, toxic waste processing, storage and disposal

Responsibility: Inspection – Quality Assurance Coordinator
Disposal – Packaging Machine Operator, Central Lab Technician, Packer, Assigned Shipping Personnel, Assigned Receiving Personnel, Assigned Sanitation Personnel or Waste Water/Starch System Personnel
Verification - Plant Manager and/or the Quality Assurance Coordinator

Overview

- 2.1.6.1 Establishments are designed and constructed so that there is no cross-contamination between the sewage system and any other waste effluent system in the establishment and they do not pass directly over or through production areas unless they are controlled to prevent contamination. These systems are equipped with appropriate traps and vents.
- 2.1.6.2 Adequate facilities, equipment, and containers that are clearly identified, leak proof, and where appropriate, covered, are provided and maintained for the storage of waste and inedible material prior to removal from the establishment. Waste is removed and facilities and containers are cleaned at an appropriate frequency to minimize contamination.

Solid Waste Disposal Procedure

2.1.6.3 Solid waste at Old Dutch Foods Ltd. consists of the following:

1. Raw Potato Waste from raw potato inspection area collected during work in progress and during cleaning/sanitation.
2. Raw potato waste from potato unloading area collected during work in progress and during cleaning/sanitation.
3. Defective packaging materials and products from packaging area.

Revised by: Suzy Marion

Reviewed & Approved by: Houmaro Kone

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4. Inedible potato chips and crumbs from fryers and Best Sorter rejects collected during work-in-progress and during cleaning/sanitation.
 5. Defective cardboards, boxes and cardboard scraps from incoming materials.
 6. Empty chemical containers.
 7. Unused and obsolete chemicals such as detergents and sanitizers.
 8. Wooden pallets.
 9. Obsolete maintenance parts and plant equipment.
 10. Damaged or obsolete dry ingredients such as seasoning or salt
- 2.1.6.4 Solid waste is held in the designated container and area. Waste is disposed of as per assigned frequency to minimize contamination. Below is the detail of the program.
1. **Imported** raw potato waste from the raw potato inspection area and raw potato unloading area are collected in waste bins located in the waste water/starch system room. The contracted company, Waste Management, picks up the waste and hauls it to BFI Prairie Green landfill site. The frequency of disposal is 2-3 times per week or whenever waste bins are full. The receiving personnel contacts Waste Management whenever raw potato waste disposal is required out of the assigned schedule.
Locally sourced raw potato waste is removed daily and hauled to a cattle feed lot (Ernie Klassen)
 2. Solid waste from the production area, shipping area, receiving area and laboratory contains packaging materials, defective finished products, used raw material containers and other solid waste are collected in the designated waste bins. A garbage bag is placed in each waste bin to keep bins tidy and clean. When the bin is full personnel assigned in the area takes out the garbage, places it in the designated area and replaces the garbage bag. At the end of each production day the assigned sanitation personnel and shipping personnel destroy all garbage in the garbage compactor. The compactor bin is located outside the building but its door is located in the compressor room where garbage is disposed of. This is collected by the contracted company, Waste Management, once per week and sent to landfill.
 3. Inedible potato chips collected from the PC32 Best Sorter reject shaker are crushed into tote bags located in the main floor below X-force distribution system. As required, the receiving personnel moves full inedible chips tote bags to receiving-temporary storage area. Growers picks up this waste 1-2 times per week or whenever bags are full and it is sent to a feed mill for animal feed.
 4. Inedible potato chips and crumbs collected from Kettle Best Sorter reject bin, fryers and during/after sanitation of equipment & area are dumped into the waste chute and collected into the waste bin located in the waste water starch system room. The receiving personnel or the waste-water/starch-system personnel dispose of full inedible bin into the outside waste bin. The contracted company, Waste Management, picks up the waste and hauls it to BFI Prairie Green landfill site.
 5. Defective cardboards, boxes and card board scraps from incoming materials are collected in a metal bin and baled. This is collected by Cascades Recovery Inc.,

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once per week and sent for recycling. The operating procedure for **baling machine** is as follows:

- a. Close and lock main door by tightening hand wheel (ratchet on XHD) lock.
- b. Open Safety Gate and Load Material to be baled.
- c. Pull down "Safety Gate".
- d. Turn key switch to "ON" position.
- e. Press the "Down Push Button", Platen will automatically cycle.

Repeat steps 1 through 5 until bale is formed, Platen will automatically stop in the "DOWN" position when bale is full. Some balers also have an OPTIONAL full bale light that will come on at the time the platen automatically stops.

- f. Tie-off and eject bale using the following procedure:
 - i. Open main door when platen stops in down position.
 - ii. Insert "baling wires" through the floor slots.
 - iii. Insert "baling wires" back through the platen slots from the rear of the baler.
 - iv. Tie-off baling wires located in the front of baler.
 - v. Located at the rear of baler; hook up the "ejector chain(s) to the Red Platen Brackets (above ejected chain drop off(s)).
 - vi. Remove bale.
 - vii. Close main chamber door and tighten door hand wheel (ratchet on XHD) lock. (Do not load new material at the point. Wait until steps "viii" is complete).
 - viii. Close safety gate and run platen down to automatically remove Ejector Chain(s) from Red Platen Brackets.

Ready to repeat steps "a" through "f" for next bale.

6. Empty chemical containers are sent back to the chemical supplier for recycling.
7. Unused and obsolete chemicals are disposed of as per chemical material safety data sheet (MSDS).
8. Pallets are collected, inspected for damage and segregated accordingly. Pallets to be returned to suppliers such as West Rock, CHEP and Norampac are placed in the designated area by the temporary staging area as well as the pallets from packaging films, finished products and pallets for use in the plant. Wooden pallets that are not returnable to suppliers are stored in the designated area in Potato Room and/or temporary storage area in receiving area. These are re-used for baling machine and excess or damaged pallets are sold to Kroeker farms for recycling. West Rock, Chep and Norampac pallets are being picked-up by the supplier as per assigned schedule.

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9. Obsolete equipment and parts are stored outside the building in the designated area. The scrap metal dealer sorts and buys the metal that they can use. The remaining equipment and parts are disposed of in the Waste Management bin for landfill.
10. Damaged and obsolete raw materials or dry ingredients are documented prior to disposal. The receiving personnel records the quantity of raw materials to be disposed of then dump them into the garbage compactor at the end of production. The receiving personnel forwards the record of damaged or obsolete materials that has been discarded to the purchasing officer to ensure proper inventory record.

Liquid Waste or Effluent Processing and Disposal

2.1.6.5 Wash water from the Potato Wash Tank goes through the drumshears and is separated into liquid waste and solid material. The Liquid waste is directed to the Starch Clarifying Tank which is located in the starch/waste water system room. The overflow passes through a series of totes, allowing starch to settle in the container. This by product is collected by Manitoba Starch once per week and processed to food grade potato starch. The waste water will then go to the Feed Reservoir 1 where it will either be recycled and go back into the Potato wash tank or go into Feed Reservoir 2.

2.1.6.6 Waste water from the potato unloading area, receiving area, potato room, cooker area, inspection area and peeler room goes through a second drumshear to separate solid from the liquid waste. Liquid waste is directed into clarifier tank located in the starch/waste water room. The waste water is then transferred into the Feed Reservoir 2. Feed Reservoir 2 has a probe to read the Total Suspended Solids (TSS) of the Influent. Old Dutch Ltd treats the Influent to remove soils and solid material prior to draining it into the sewage system. Procedures are as follows:

1. Waste water from the clarifier tank is automatically transferred into a mixer. 7% PC1194 Klaraid solution (coagulant) is added into the incoming liquid in the mixing tank and 0.6% Polyfloc CP1618 (Polymer) solution are added into the outgoing liquid from the mixing tank. The volume of coagulant and polymer being added during waste water treatment is depended on the the Total Suspended Solids (TSS) and flow rate of the influent. This is done through HACH CAF Thickening System that is in place. This system ensures that Old Dutch Foods Ltd effluent TSS level is below the limit that is set by the City of Winnipeg.

Please note that to prepare 7% coagulant 7L (3 lbs) of PC1194 Klaraid is mixed with 100L of water. To prepare 0.3% polymer 3.8 kg (8.4lbs) of Polyfloc 1618 is mixed with 250Gal of water. The operator determines the volume of the coagulant solution and polymer solution in the designated container and prepares them as required during the day. The operator records on form 2.1.7 Waste Water Record the amount of solution mixed and the time solution is prepared during the day (box # 14 and box #15 on the checklist).

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2. The Coagulant is added based on Influent Total Suspended Solids and the Flow Rate. The Polymer is added based on the Coagulant added multiplied by a factor of 31. If the Hach system is not working then the manual mode is used.

Manual Mode:

7% PC1194 Klaraid solution (coagulant) and 0.6% Polyfloc CP1618 (Polymer) are added into the tank at the flow rate indicated on the table below.

Table 2.1.6.6 Effluent Chemical Feed Rates

Flow Rate	PC1194 Klaraid Feed Rate (7% Coagulant Solution)	Polyfloc 1618 Feed Rate (0.3% Polymer Solution)
50 USGPM	186 mls/min	2.481 / min
60 USGPM	223 mls/min	2.971 / min
70 USGPM	259 mls/min	3.461 / min
80 USGPM	279 mls/min	3.951 / min
90 USGPM	334 mls/min	4.451 / min

3. Treated effluent from the mixing tank goes into the CAF (cavitation air flotation) tank. Also liquid waste from the seasoning mezzanine goes into drains in waste water room and then into CAF tank. The liquid overflow from this tank goes to drain then to the sewer. The viscous treated effluent goes into the holding tank and pumped through the filter press. This process separates the solid materials from liquid waste where liquid is discharged into a sump pit and solid materials are collected within the press plates. When required or after each daily production the assigned personnel disassembles the unit to clean and remove the solid waste that has been collected from the effluent. The solid waste is transferred into a waste bin then disposed of into the bin with other solid waste located outside the building. Below is how the CAF system works:
- There are four sections: an aeration section with cavitation aerator, flotation (clarification) area, solids discharge chamber, and clarified effluent channel and adjustable weir section.*
 - Wastewater enters a baffled aeration section. Here, the cavitation aerator (2 HP) draws ambient air down a shaft and injects microbubbles directly into the wastewater. The bubbles fasten to the particles, flow upward and support the particle at the surface.*
 - The floated solids, (fats, oils, grease, suspended, colloidal solids) are removed by a scraping mechanism, which propels the sludge up a metal beach into a discharge channel. There, collected solids are transferred to a container for disposal. Both mechanisms are driven by a 1/2 HP gear motor.*
 - Recirculation tubes from the aeration chamber continually recycle substantial volumes of liquid. This eliminates deposition on the bottom and assures continual circulation of tank contents.*
 - Clarified water gravity flows to an adjustable weir section, which controls the water level of the main tank. From the weir, the effluent is discharged.*

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4. Personnel assigned in the waste water system follows the waste water treatment standard procedure below when performing the task and records the flow rate, coagulant stroke, polymer stroke, coagulant dose, polymer dose, pH, solids reading both influent and effluent and the amount of polymer and coagulant used to prepare the required effluent chemicals into form 2.1.7 Waste Water Record.

2.1.6.7 Waste oil from PC32 steam stack and untreated wastewater due to overflow goes to the drain located in between fresh oil tanks 2 and 3. The liquid from this pit is put through the oil skimmer to separate the oil. The waste oil is disposed of into an inedible finished chip bins/mud from the press at the end of each weekly production. The untreated wastewater is pumped into the clarifier tank and goes through wastewater treatment. The contracted Waste Company will pick up the bins and haul them to the landfill for disposal.

Waste Water Treatment Standard Operating Procedure:

- a. At start up and every 4 hours, check the “flow rate” of waste water from the SC1000 Hach Display. Record your reading on checklist box # 5 of form 2.1.7.
- b. Check the polymer and coagulant pumps and make sure that they are working. At start up and every 4 hours, read the coagulant (Klaraid) and Ploymer dose from the SC1000 Hach Display and record on checklist box #6 & #7. Once per shift, read the coagulant and polymer stroke on the pump dial and record your reading on checklist box #1 & #2.
- c. At Startup and every 4 hours, Check the PH and solids reading for both influent and effluent on the SC1000 HACH Display. Record the “PH” reading on checklist box #10 of form 2.1.7 and the “solids” reading on checklist box #11 of form 2.1.7.
- d. Check the CAF aerator and make sure it is working.
- e. Check the CAF skimmer auger drive and make sure it is working.
- f. Check the skimmings pump and make sure it is working.
- g. Check the waste trasfer pump # 2 and make sure it is working.
- h. Check the slicer waste water starch pump and auger drive and make sure that they are woking.
- i. Check the general waste water pump and auger drive and make sure that they are woking.
- j. Check the press and see if it needs to be dumped. Dump press and wash with pressure washer if necessary.
- k. Check the large and small drum shears and make sure they are both working. Rinse the screens daily.
- l. Wash the floor daily with foam force and make sure to rinse the chemical away from the pits at the end of the CAF tank.

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- m. At start up and every 4 hours visually check the colour of starch and CAF tank solutions in the tank. Indicate “W” on checklist box #8 if the starch solution looks white and “B” if the solution looks brown. Indicate “W” on checklist box #9 if the CAF tank solution looks white and “B” if the solution looks brown. You may also specify other colour observations on these lines.
- n. Once per shift check and test the chemicals being pumped per minute into the CAF tank using the drop test. The procedure is as follows:
- i. ***Polyfloc solution (polymer) Drop Test procedure***
1. Close the 3 polymer line valves.
 2. Clear the stop watch.
 3. Open the polymer drain valve that is used for drop test.
 4. Start the stop watch and collect the polymer solution in a graduated cylinder at the same time for 15 seconds.
 5. Close the polymer drain valve.
 6. Open the 3 polymer line valves.
 7. Read the amount of polymer that you collected in the graduated cylinder and multiply the reading by 4.
 8. Record the time of test and your result in the “amount of polymer” checklist box #3.
- ii. ***Klaraid solution (coagulant) Drop Test procedure***
1. Make sure that the Klaraid (coagulant) drain valve (bottom left valve) that is directed to the coagulant, Klaraid drum is closed.
 2. Make sure that the middle drain valve (left valve located above the Klaraid drum) is closed.
 3. Fill the Klaraid (coagulant) graduated cylinder by opening the top valve which is located just above the cylinder.
 4. Close the top valve when the solution reaches the “0” line on the graduated cylinder. You may exceed above this line but do not start stop watch until it reaches the “0” line.
 5. Clear the stop watch.
 6. Open the middle left valve, located over Klaraid drum and start the stop watch.
 7. Close the middle left valve when the stop watch read 15 seconds.
 8. Read the volume of Klaraid from the graduated cylinder and multiply by 4.
 9. Record the time of test and your result in the “amount of coagulant” checklist box #4.
- o. At Start-up and every 4 hours +/- 30 min check for warnings or errors on the SC1000 Hach Display and record your findings on checklist box #12 of 2.1.7

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wastewater record. Yellow or Red screens indicate warnings or errors. Resolve these warnings for errors by selecting Main Menu >> Diagnostics >> Selecting Appropriate Sensor. Any Breakdowns should be recorded on form 4.2.28 Equipment Breakdown / Downtime report.

- p. At Start-up and every 4 hours +/- 30 min check the prognosis status on the Hach Display and record the measurement confidence and service indicator on checklist box #13 of 2.1.7 waste water record. You can view issues by selecting the respective bar. Maintenance should be planned and requested accordingly.
- q. At Start-up and every 4 hours +/- 30 min check the oil skimmer to make sure it is on, in good running condition and the oil skimmer belt is in place. Record your observations on #14 of 2.1.7 wastewater record. Any Breakdowns should be recorded on form 4.2.28 Equipment Breakdown / Downtime report.
- r. Check the white starch bins and change with new ones as they get full.
- s. Check the waste bin that collects peel waste and remove and replace with new bin when full.
- t. Check the waste bin that collects waste being dumped from the fryer area. Dump outside in waste bin when full.
- u. At the end of production place the well water hose into the pit at the end of the CAF tank and flush out for a couple of hours until the pit is clean.
- v. Once per week visually check the effluent. Does it look like the filtrate probe is reading correctly? Record you result on form 2.1.7.1 Waste Water Record.
- w. Once per week verify that the pH probe is calibrated by following the procedure below:

Check Standard

1. Push the wrench icon to access the options menu.
2. Select "run check standard"
3. Get the standard solution shown on display
4. Rinse the probe with distilled water. Blot dry with a kim wipe.
5. Put the probe in the standard solution until the temperature sensor is completely submerged, move the probe up or down or gently tap on the beaker to remove air bubbles from the probe.
6. Push "read". The display will show "stabilizing" and a progress bar as the reading stabilizes. The display shows the value of the check standard and either check standard passed or check standard failed.
7. If the display shows Check Standard Passed, the check standard measurement is within the accepted limits. Select "Done" to continue with the sample measurement.

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8. If the display shows Check Standard Failed, the measurement is outside of accepted limits set and a recalibration is required. To correct the probe calibration and status indicator, calibrate the probe.

Calibration

1. Push Calibrate. The display shows the buffers that are necessary for calibration.
 2. Prepare the fresh buffers in separate beakers or appropriate containers.
 3. Rinse the probe with distilled water. Blot dry with a Kim Wipe.
 4. Put the probe in the pH buffer solution & stir gently. Make sure that the reference junctions are completely submerged. Shake the probe from side to side in the sample to refresh the reference junction.
 5. Push read. Stir gently. The display will show "stabilizing" and a progress bar as the probe stabilizes in the standard. The display will show the buffer that has just been read & shows the temperature corrected pH value when the reading is stable.
 6. Repeat steps 4-6 until the minimum # of calibration points specified in the current method have been collected
 7. Push "done & view calibration summary". The display will not show "Done" until the minimum # of calibration points have been collected.
 8. Push Store to accept the calibration & go back to measurement mode.
- x. Once per month a Sample of the Influent and Effluent is taken and sent to ALS Environmental for validation of Total Suspended Solids. Record the readings on 2.1.7.2 Waste Water Record.
- 2.1.6.8 Liquid waste from the laboratory such as used oil samples are collected in an empty 4L container with label. The assigned sanitation crew or production personnel transfers the oil into a tote container specific for this use. This will be disposed of once the container is full.

Toxic Waste Disposal

- 2.1.6.9 Old Dutch Foods Ltd does not handle toxic waste per se in the facility. Spent hydraulic oil, obsolete chemicals and paint etc. are sent to Miller Environmental for proper disposal. At times when chemical and lubricant spills occur the company follows the recommended MSDS spill cleaning procedures.
- 2.1.6.10 Waste oil from PC32 steam stack & untreated wastewater overflow is put into inedible finished chip bins/mud from press and hauled to the Landfill by the contracted Waste Company.

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Waste Flow Diagram

2.1.6.11 Please refer to 2.1.6.9.1 Waste Flow Diagram – Mezzanine level and 2.1.6.9.2 Waste Flow Diagram-Main Floor and 2.1.6.9.3 Waste Flow Diagram – Starch / waste water system room.

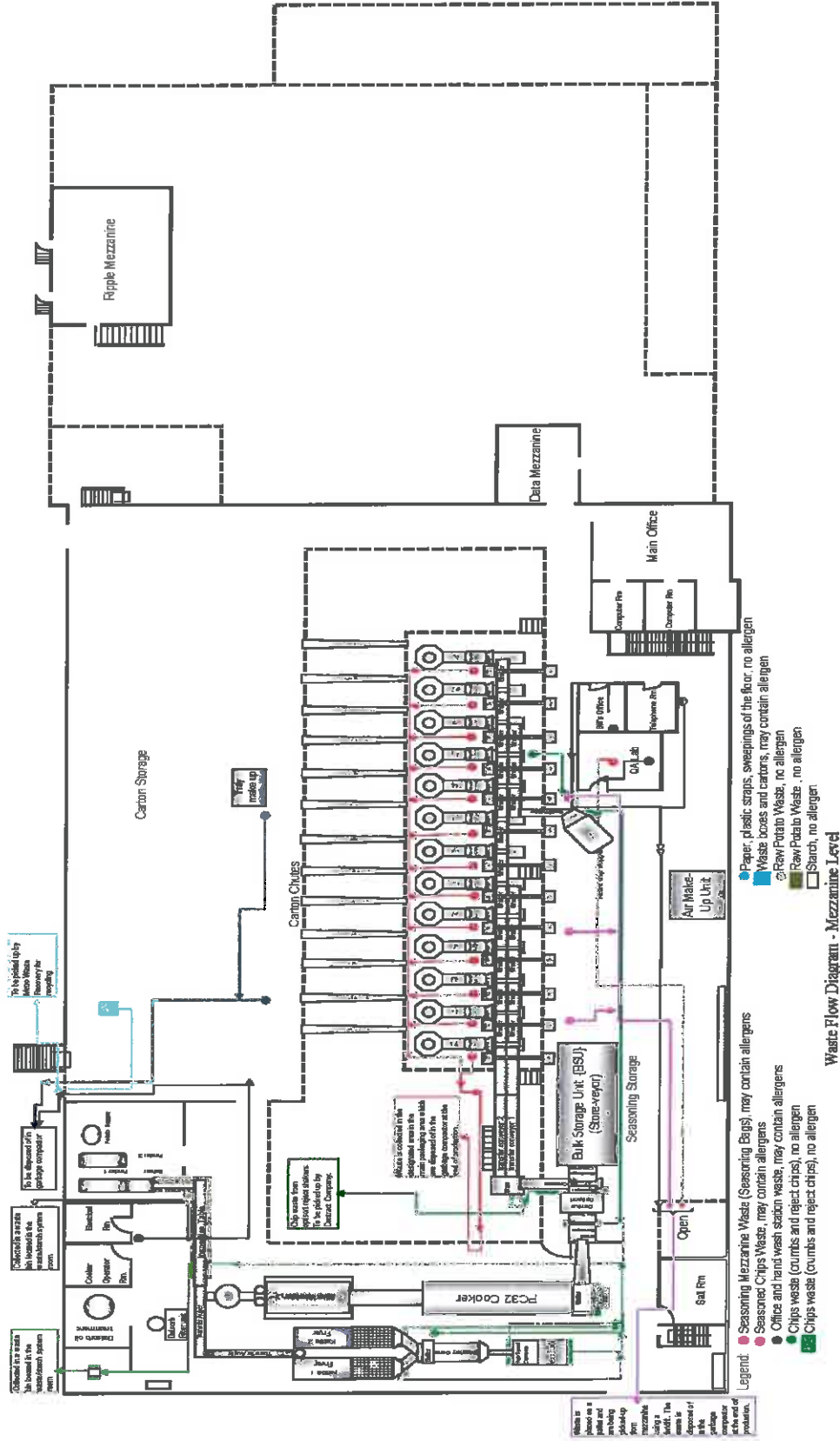
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A handwritten signature in black ink, appearing to read 'Houmaro Kone', followed by a superscript '1'.



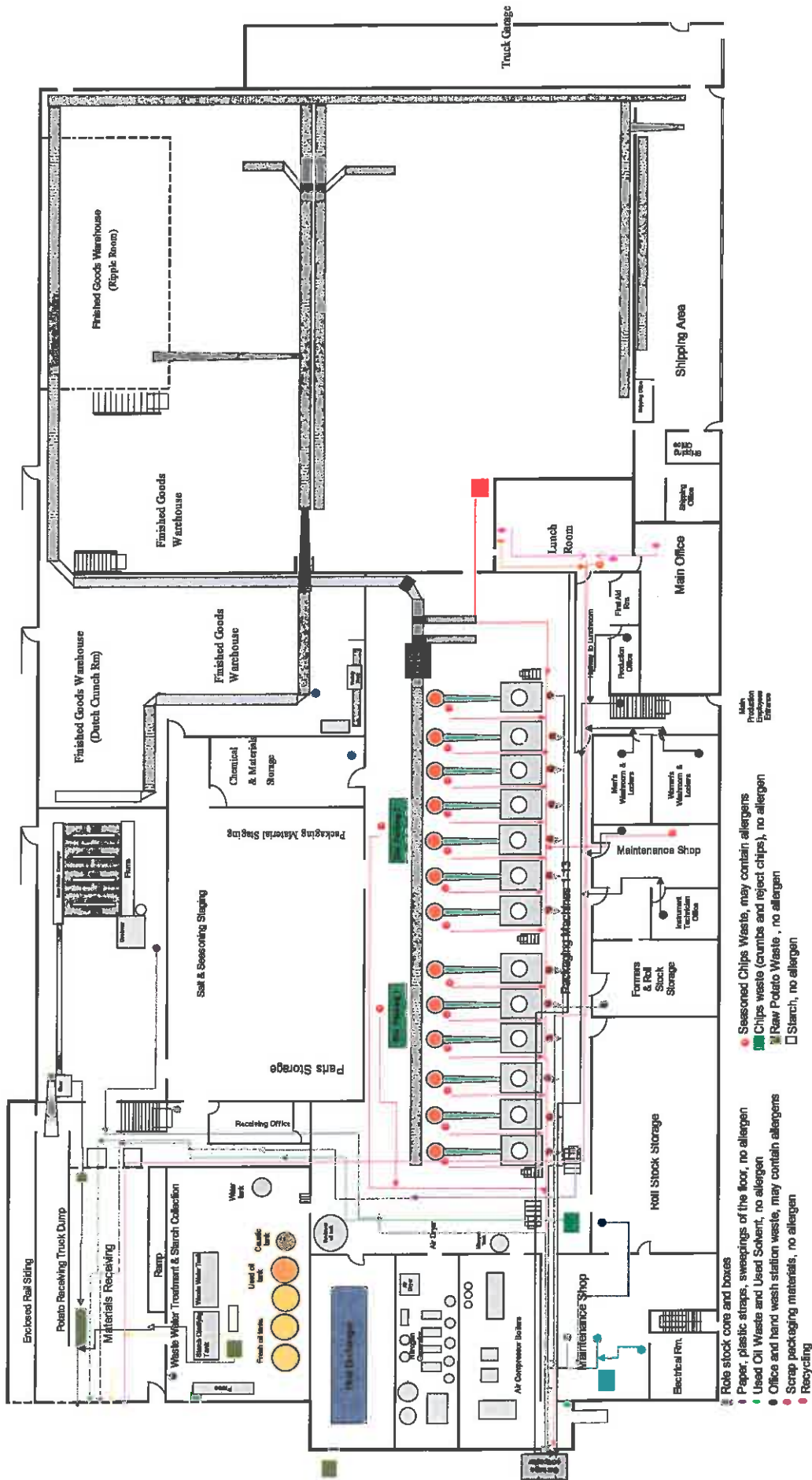
2.1.6.11.1 Waste Flow Diagram – Mezzanine Level



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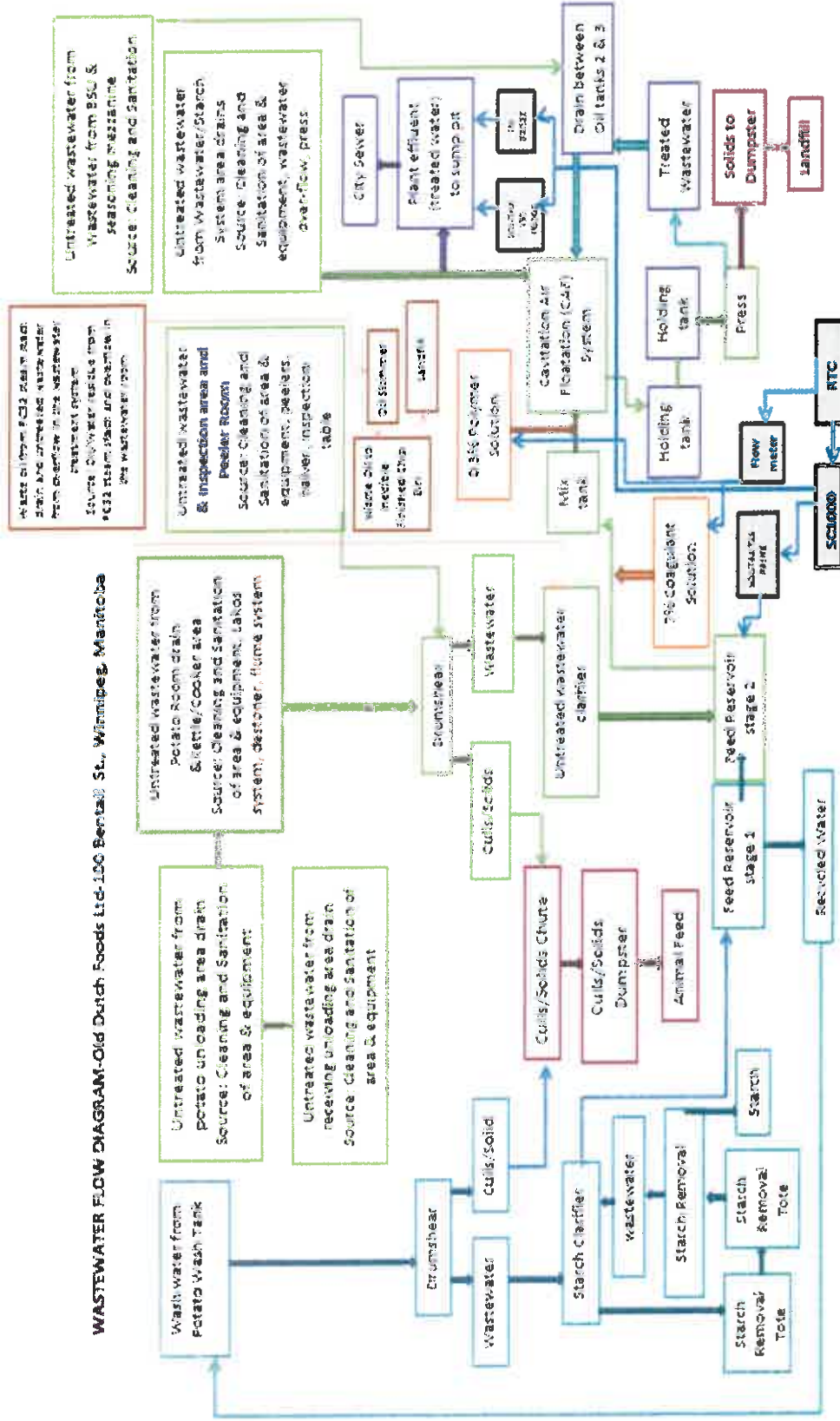
2.1.6.11.2 Waste Flow Diagram – Main Floor



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2.1.6.11.3 Waste Flow Diagram - starch/wastewater system room



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G. Follow-up Plants, including Monitoring and Reporting

Old Dutch Foods Ltd. monitors the total suspended solids (TSS) of influent and effluent of wastewater through CAF Thickening device. Samples of influent are also collected and send out for TSS and biochemical oxygen demand (BOD) analysis as per assigned frequency. The City of Winnipeg also collects and analyzes the TSS, BOD, Total Nitrogen and total Phosphorus in wastewater they collected as per assigned frequency. The results of their analysis are sent to ODF and data are analyzed/reviewed.

Waste management program is covered under the Old Dutch Foods Ltd. Food Safety Program. This program is being reviewed as per assigned frequency.

Old Dutch Foods Ltd monitors its gas and electricity consumption. From these data the CO2 emissions are calculated and analyzed.

H. Conclusions

Old Dutch Foods Ltd. installed new equipment and upgraded old equipment from 1986 to date. Because the kettle line had been added, production volume has increased by 18% from 2006 to date when compared to 1994-2005 volume. As a result of increase in production volume, 30% increase in CO2 was noted from 2006-to 2016. However, the overall average of total carbon emissions by ODF processing plant from 1997 to 2016 was 3672 MT CO2 with the range of 2520- 4649 MT CO2. This number is below the threshold of 10,000 MT CO2 to a cap of 25000 MT CO2 annually by the Western Climate Initiative's (WCI) threshold for greenhouse gas (GHG) reporting. Old Dutch Foods Ltd. has good waste management program to ensure municipal, provincial and federal guidelines for waste, hazardous materials and wastewater disposal are met.

The site is situated in the Inkster Industrial Park and located in the centre/north sector of the city. The area is approved for warehousing and light industrial use. Consideration is given to local activities, biophysical environment and the development on human health and safety that may have a potentially adverse impact, and measures are taken to prevent product contamination.