Agri-Mark, Inc. dba/Cabot Creamery Collection and Land Application System 2016 Inspection Report

INSPECTION REPORT

Project ID 16-041
June 13, 2016

This project was performed by Stone Environmental, Inc. for Agri-Mark Inc., dba Cabot Creamery.
EXECUTIVE SUMMARY

On May 17, 2016, Stone Environmental Inc. (Stone) conducted a thorough inspection and evaluation of the collection and land application system for the dairy processing wastewater (DPWa) as per Agri-Mark, Inc. dba/ Cabot Creamery, Indirect Discharge Permit (IDP) #9-0043, January 12, 2016 Part II, Condition F2, I4(A). Overall, the operation, documentation, maintenance and land application of the DPWa was operating extremely well, in excellent condition, and performed in accordance with the conditions and requirements set forth in the IDP. Present during the entire inspection from Cabot was Aaron Page, Environmental Engineer (EE). Others present from Cabot during certain phases of the inspection were Marcel Gravel, Cristin O’Donnell, Chris Pearl, Rejean Pion, Marvin Colburn, Harvey Lyons, Dick Trucott, and Ron Metevier. Bryan Harrington from the State of Vermont was also present during most of the inspection including observing a land application to an agricultural field. The inspection included following the DPWa from generation to land application, and a full document review. The inspection also included observing the land application of the dairy processing wastewater on to disposal fields. Two improvements were noted from last year’s inspection:

1. Cabot has hired an Environmental Engineer to oversee the IDP permit and processes. He provides oversight on the operation and documentation required with the IDP permit.
2. Cabot’s EE and their vendor have summarized in a master list the chemicals used in each facility on a daily basis. The list contains average use per day, composition information and approximate concentrations based on the amount used. The following cleaning chemicals were added; sulfuric acid 93%, Sterilex Activator Solution, Sterilex Disinfectant and PURE Hi-Foam. Although these were new to the product line they were not actually new chemicals, but reformulation of other products used in the past.

There were no findings generated as a result of the inspection which indicated compliance issues; one recommendation/observation was made, which is as follows:

1. It is recommended that Cabot review the SOP manuals annually and replace worn binders with new ones and verify that they are up to date with all the new permit information and maps with current farm names.
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1. INTRODUCTION

In accordance with Agri-Mark, Inc. dba/ Cabot Creamery, Indirect Discharge Permit (IDP) #9-0043, January 12, 2016 Part II, Condition F2, I4(A), Stone conducted a year 2016 inspection and evaluation of the collection and land application system for the dairy processing wastewater (DPWa) at their manufacturing facility, located in Cabot, Vermont. The evaluation and inspection was conducted under the direction of Julie Moore, P.E. of Stone and performed by Kim Watson, RQAP-GLP of Stone on Tuesday May 17, 2016. Present during the entire inspection from Cabot was Aaron Page, EE. Others interviewed and present from Cabot during certain phases of the inspection were Marcel Gravel, Cristin O’Donnell, Chris Pearl, Rejean Pion, Marvin Colburn, Harvey Lyon, Dick Trucott, and Ron Metevier. Bryan Harrington from the State of Vermont was also present during most of the inspection and was present during a land application to an agricultural field. The inspection was limited to the collection and land application system for the DPWa (IDP, Part II) and did not pertain to polished permeate disposal (IDP, Part I) or the sanitary wastewater from the facilities. This report documents the objectives, criteria, procedures, findings, observations and recommendations of the inspection.

The DPWa that leaves the plant facility exits the manufacturing building and the cut-and-wrap building via floor drains and flows by gravity to a storage tank (capacity 4,500 gallons) under the pumping station located across the main road from the main Cabot facility. The DPWa is composed of a quantity of milk, whey spillage, cottage whey rinse water, and the water used to sanitize the trucks, CIP (clean-in-place) lines, and equipment. The pumping station has pumps in tandem and a backup power supply system, which allows for continued operation of the manufacturing facility in the event of temporary pump or grid power failure and an alarm system to alert personnel when the storage tank capacity is about to be exceeded. DPWa is pumped from the pumping station upslope by an underground pipeline to two 100,000 gallon storage tanks, in tandem, located near the Waste Treatment Department garage. A continuous flow meter in the pump house is used to measure the volume of DPWa produced and pumped to the storage tanks. A digital meter in the loading shed records influent and effluent volumes sent to and from the storage tanks. The storage volumes are recorded daily on the washwater storage tank level form submitted in the monthly report using the digital read-out. From the tanks, the DPWa is gravity fed into disposal trucks and disposed of by diffuse land application. A digital flow meter located in the loading shed controls and records the volume transferred to the disposal vehicles; in addition the strip chart reader documents actual flow into the trucks. The vehicles used for land application are equipped with a high pressure spray nozzle (Big Gun) which distributes the DPWa to the approved disposal fields in a uniform manner.

The inspection of the collection and land application management system, recordkeeping of Daily Journals, and daily wastewater production records are evidence that the dairy process water collection, and dispersal operations performed by Cabot Creamery are functioning very well, are well documented, and are in compliance with the conditions and requirements of the IDP, and associated procedures and
guidelines. During the inspection Stone made a specific recommendation to update the standard operating procedure binders. This is outlined in Section 4 of this report.
2. OBJECTIVES

The objectives of the annual inspection were:

- To make a thorough inspection, evaluation, and report of the collection and land application system.
- To determine whether Cabot Creamery is complying with all monitoring, recordkeeping, record retention (archiving), and information requirements specified in IDP ID-9-0043-4A.

The inspection included the following:

- Examining the collection system and pump station(s) used to convey the dairy processing DPWa from the production area to the storage tanks;
- Verifying the proper operation of the pump(s) and, if applicable, any alarm systems;
- Examining the tanks and containment structures as well as any leakage detection systems;
- Checking the calibration of flow meters used to determine the volume of DPWa stored in the tanks or verifying, by the review of recent documentation (within the past two years), that the meters are properly calibrated within a 10% tolerance;
- Checking the equipment utilized to fill the spray trucks and observing the procedure utilized to fill the trucks;
- Observing the land application of dairy processing wastewater on disposal fields, and checking the proper operation of the each truck's spray nozzle;
- Checking each vehicle's daily journal for compliance with the requirements of Condition E7; and,
- Noting any necessary repairs, maintenance and/or improvements that should be made to the land application system.

The performance standards or evaluation criteria for the inspection were based on the written IDP #ID-9-0043-4A including Attachment A-1, A-2, B or C, “Approved Disposal Fields” and “Approved Application Rates” and Attachment B “Listing of Manure Pits”. The criteria and procedures set forth in the Vermont Guidelines for Land Application of Dairy Processing Wastes, August 14, 1990.
3. GENERAL OBSERVATIONS

The inspection report is presented in the order of the system process. The inspection was performed in a manner to follow the DPWa process from its origin to distribution as an agricultural soil amendment. The inspection started inside the cheese processing facility, then we moved on to the cut and wrap facility to ensure that all the internal washwater drains were functioning, clean, and clear of any debris. We then went to the pumping station and ended at the truck loading area and garage. The inspection included traveling with truck operators, observing land application of the washwater, and record keeping.

3.1. Pumping Station

The pumping station has two pumps in tandem and a backup power supply (generator) located next to the pump house. Both pumps were operational and working well according to the maintenance log. The main pump comes on when the water level reaches 3.5 feet in the tank and shuts off when the level drops back to 2 feet, with a flow rate of 230 gallons per minute. The second pump comes on when the water level reaches 4 feet and it shuts off when the level drops back to 2 feet; the rate increases to 310 gallons per minute with both pumps on. An alarm system is located at the pumping station, the processing facility, and at the storage tanks and goes off when the water depth in the tank reaches 4.5 feet. DPWa is pumped from the pumping station upslope, by an underground pipeline, to two storage tanks (100,000 gallons each) located near the Waste Treatment Department garage. A continuous flow meter in the pump house measures the volume of DPWa produced and reads the gallon per minute of DPWa pumped to the storage tanks. Observed and operating in parallel to the flow meter is a strip dial, which continuously monitors the gallons pumped per minute.

Cabot Maintenance is responsible for documentation and maintenance of the pumps in the pumping station. A daily journal is kept on the pump maintenance and daily records are kept on the gallons of DPWa produced and pumped to the storage tanks. The total daily volume of DPWa generated is recorded each morning from the digital flow meter located in the pump house and entered into a spreadsheet. The in-line flow meter was replaced on March 29, 2016 with a newly calibrated flow meter. The calibration certificate (Exhibit 1) for the actual meter was traceable to the specific meter in the pumping house.

3.2. Storage Tanks

There are two tanks in tandem which can store a total of up to 200,000 gallons of washwater. The tanks are set inside a lined pit, with a berm on all sides directing rain water to a drain in the center of the pit. This drain connects to the sump under the loading area that drains back to the pump station, which gets pumped back to the storage tanks. The liquid levels in the storage tanks are monitored digitally in the pump house. The DPWa is gravity fed into the disposal vehicles for land application.
3.3. Drivers, Disposal Vehicles and Loading Area (Shed)

Marcel Gravel, Plant Manager, is the contact for regulatory operations in the IDP, and is identified as the Chief Operator of the wastewater system. Aaron Page, EE has been identified as the lead for system reporting, regulatory review and day-to-day operations. Rejean Pion is also identified as the Assistant Chief Operator and is a vehicle driver of one of the land application vehicles. Four other drivers hold a Grade I Operator license, so as to have qualified personnel available seven days per week. The DPWa storage tank levels are recorded twice daily on the “Wash Water Storage Tank Levels” form as required by the IDP (morning and evening) and are included in the Monthly Disposal Report using the digital system in the loading hut.

Cabot employs six full time drivers and five part time driver. All of the drivers have a Class A or B commercial driver’s license and have annual physicals for medical clearance as required under the Vermont Department of Transportation (DOT) regulations.

The Waste Treatment Department at Cabot maintains a fleet of six disposal vehicles adequate to properly dispose of DPWa through land application, including discharges to manure slurry pits as allowed by IDP Part II–Section D8. Each truck is red (includes Cabot’s phone number), is numbered (trucks, #403, #404, #405, #406, #407 and #408), and has a 4,000 gallon holding tank. Cabot just purchased a new truck #409 which was at the vendor getting retrofit as an additional disposal vehicle, which would increase the fleet to seven. However, as I understand, Cabot plans to retire Truck #403. Maintenance of the disposal vehicles is performed in-house. Maintenance records are kept on each of the vehicles and recorded in a maintenance log. All vehicles’ inspection was current. Each vehicle’s “Big Gun” high pressure spray nozzle was in good condition, clean and clear. DOT maintenance records were available in all vehicles. The records were filled out on a daily basis and signed by the driver. Daily Journals and standard operating procedure (SOP) manuals were available in every vehicle and reviewed during the inspection. The Daily Journals were compliant with the requirements of Condition I11 of the permit. Drivers were recording their observations more frequently and included the actual groundwater levels next to the well IDs, and the actual pH of the washwater when taken.

The SOP manual available in every vehicle contained appropriate procedural documents including “Land Application of Dairy Processing Wastewater” and the procedure for determining depth to groundwater measurements. Also included in the manuals are site maps of every approved disposal field and overweight permits for the towns involved in the disposal program. The site maps of approved disposal fields provide details regarding the approved acreage for disposal (summer, fall or verified fields), location of observation wells, soil borings, water wells, buildings, slopes, distances and any limitations imposed upon that disposal field such as isolation distances, slope, soils and hydrogeology. However, it was observed that some of the three ring binders were worn and all but two binders had the new 2016 IDP permit. In addition, although the maps were available some maps needed updates due to farm name changes. Therefore, it is recommended that Cabot review the SOP manuals annually and replace worn
binders with new ones and verify that they are up to date with all the new permit information and maps with current farm names.

The DPWa is loaded into the disposal trucks by gravity through a controlled flow system within the truck loading area shed. The in-line Seimen flow meter was replaced with a calibrated meter on March 29, 2016. A daily “Remaining Capacity Report” is printed from the Wastewater Management System and is available in the loading shed for the drivers. Daily route plans are provided to each driver so they can record where they have applied. The Wastewater Management System was up to date and included the upgrades made in January of 2016. The driver can control the amount loaded using an automated volume control and a manual control. A mirror is located on the top of the loading arm which provides a sight-line into the vehicle tank. Each driver is responsible for loading their vehicle and selecting a site for disposal based on the available “Remaining Capacity Report.” Each driver, also, had a “Capacity Report” in their vehicle. Additionally, a strip chart recorder in the pump house records all flow of wastewater into the disposal vehicles.

3.4. Land Application to Approved Disposal Field and Manure Pit

Two land application trips were randomly selected for observation on May 17th, 2016. Land applications were observed with driver with Dick Trucott in truck #403 and Harvey Lyon in truck #406. Drivers were interviewed during the inspection and the inspector accompanied the driver on the trip to the disposal locations (Chandler farm 0017B and Lyon field 0116A). The drivers chose a field on their route plan, loaded their truck to capacity using the flow control system in the loading shed and traveled to the assigned field. There was no visible standing water in the fields. The wind directions were checked so DPWa spray would not be carried off the spray sites. The DPWa was applied to the field, stationing the truck and setting the gun to achieve a uniform application. The DPWa was sprayed from the vehicle and was moved slowly to cover the appropriate acreage (covering approximately 1/8 acre) for truck #406; truck #403 was moved incrementally due to loading on the hydraulic system rather than continuously to cover the appropriate acreage. The driver recorded the farm name, the field number, the field code, the truck route taken, and the start and stop times of disposal in the bound daily journal in the vehicle and on their route plan.

3.5. Data Input, Calculation, and Reporting

Aaron Page was interviewed regarding the input, calculation, and reporting of DPWa management data. Aaron Page enters field data from IDP Attachment A-2, B and C into the Wastewater Management System database regarding the landowner and address, usable acreages, application rates, seasonal gallons available for application, and description codes. Data entries are also performed by Rejean Pion and Marvin Colburn. Mr. Page ensures that the data in the Wash Water Data Management System is accurate and up to date.
Mr. Page, or his designee, enters the daily disposal data from the route plan into the database daily. The route reports are prepared by Mr. Page or his designee daily, prior to the start of the days applications. Mr. Page prepares the required regulatory reports to the State which are reviewed and signed off on by Marcel Gravel.

Monthly disposal reports are submitted as required under Part II–Condition I12 of the IDP and the April 2016 and May 2016 Monthly reports were available during the inspection. An annual report is submitted to the Secretary of the Agency of Natural Resources, per Part II–Condition I13.

According to Mr. Page there were no notice of violations in the last year. Mr. Page also provided the auditor with a driver checklist for land application on one-time use fields and explained how they were added to the database (Exhibit 2). In 2015, four different cleaning chemicals were added to the CIP process; sulfuric acid 93%, Sterilex Activator Solution, Sterilex Disinfectant and PURE Hi-Foam.

Although, these were new to the product line they were not actually new chemicals but reformulation of other products used in the past. An improvement from years past was the actual tracking of chemicals used and daily average use per day calculations. Cabot’s EE and their vendor have summarized in a master list the chemicals used in each facility on a daily basis. The list contains approximate average use per day, composition information and approximate concentrations based on the amount used.

3.6. Inspection Compliance Checklist

A completed Inspection Compliance Checklist is provided in Appendix A (Exhibit 3) of this report.
4. FINDINGS AND RECOMMENDATIONS

The collection and land application system for the DPWa is operating very well, is well documented, and within the terms and conditions set forth in Part II of the IDP. Operations management is adequate, well organized, and well-liked by the staff. The drivers were knowledgeable and competent, and understood the restrictions and limitations for land application as outlined in the permit and the state guidelines. There were no findings generated as a result of the inspection which indicated compliance issues. There was a single recommendation/observation made which is as follows and should be checked annually:

1. It is recommended that Cabot review the SOP manuals annually and replace worn binders with new ones and verify that they are up to date with all the new permit information and maps with current farm names.
APPENDIX A: EXHIBITS 1 - 3
**Packing List**

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**Sold To:**

TWINCO CORP  
PO Box 8  
WEST FALLS NY 14170  

**Ship To:**

TWINCO CORP  
PO Box 8  
WEST FALLS NY 14170  
ATTN: Jeff Hayes  
145 ELIOT RD  
WEST FALLS NY 14170

**Shipping details:**

- **Ship via:** FXFREI Fedex Freight Priority  
- **Freight Terms:** Prepaid and Add

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*If this invoice, delivery note, or packing list represents an export transaction, then these commodities, technology or software (items) were exported from the United States in accordance with the Export Administration Regulations. In all cases, diversion contrary to U.S. law is prohibited. These items are not to be used, directly or indirectly, in prohibited nuclear, chemical/biological or missile weapons activities. This is to certify that the information on this invoice, delivery note, AOS or packing list is true and correct and that the contents of this shipment are as stated therein.*

*We hereby certify that these goods were produced in compliance with all the applicable requirements of Section 6, 7, and 12 of the Fair Labor Standards Act, as amended, and regulations and orders of the United States Department of Labor issued under Section 14, thereof.*
Customer:
Name: TWINCO CORP.
Address: 145 ELLICOTT RD.
WEST FALLS, NY 14170
Phone: 
Email: 

MAGFLO® Identification:
TAG No./Name: 
Sensor Code No.: 7ME631
Sensor Serial No.: 755736T137
Transmitter Code No.: 7ME691
Transmitter Serial No.: N1D5079775
Location: 

Results:
Verification file name or No. Transmitter Sensor Insulation Magnetic Circuit
File #3 Passed Passed Passed

Velocity

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Current Output 4-20mA Frequency Output 0-10kHz

Transmitter Settings:
Qmax: 500.000 US G /min
Flow Direction: Positive
Low flow Cut-off: 1.50%
Empty Pipe: OFF
Current Output: 0N (4-20mA)
Time Constant: 5.0 Sec.
Relay Output: Error Level
Digital Output: OFF
Frequency Range: N/A
Time Constant: N/A
Volume/pulse: 0.01 p/c
Pulse width: 0.056 sec.
Pulse polarity: Positiv

Sensor Details:
Size: DN 150 6 IN
Cal. Factor: 17.99939919
Correction Factor: 1.0
Excitation Freq.: 6.25Hz

Verificator Details (083F5061)
Serial No.: 101415N400
Device No.: 90952
Software Version: 1.40
PC-Software Version: 5.01
Cal. date: 2015.10.26
ReCal. date: 2016.10.26

Comments:
These tests verify that the flowmeter is functioning within 2% deviation of the original test parameters.
Verification is traceable to National and International Standards.

Date and signature: 2/9/16

2016.02.09
JOE MCFARLAND
## SIEMENS
### Process Instrumentation and Analytics

**Repair & Evaluation Form**

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**Reason for return:**
- CUSTOMER REQUEST VERIFICATION TEST

### VISUAL INSPECTION

Does returned unit represent above model number?  
- ☐ YES  
- ☐ NO

If not, list discrepancies:
- [ ]

Select Condition:
- ☐ OK
- ☐ Cracked
- ☐ Stained/Water Residue
- ☐ Display
- ☐ Electrical Terminals
- ☐ Burnt
- ☐ Process Threads
- ☑ Other: FLOWTUBE NECK BENT WHEN RECEIVED

Are Process Connections Clogged or Pneumatic Ports Dirty?  
- ☑ NO  
- ☐ YES

Select the type of blockage:  
- ☐ DEBRIS  
- ☑ FLUID

### FUNCTIONAL TESTS

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- Mechanical Adjustments:
- Power Up:
- Push Button:
- Menu Operation:
- Calibration/Verifier (mag):
- Process Threads:
- Input/Output signal response:

### ANALYSIS

- All Device functions:  
- ☑ ☐

**Check:** FLOWTUBE WITH OHM METER, COIL READS, OK. NO SHORTS. ELECTRODE SHOW GOOD CONTINUITY. WITH NO SHORTS, PERFORM VERIFIER TEST ON FLOWTUBE. UNIT PASSED ALL TESTS. WILL SUPPLY CERTIFICATE OF RESULTS.

### CORRECTIVE ACTION

- NO CORRECTIVE ACTION TAKEN.

### ADDITIONAL COMMENTS

- ANY ADDITIONAL PROBLEMS, CONTACT TECH SUPPORT.

Valid Warranty Claim:  
- ☑ NO  
- ☐ YES  

Technician:  
- [ ]

Time Stamp:  
- 2/9/2016 3:12:33 PM

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https://pibusales.sea.siemens.com/Applications/RMA/RepairForm/RepairForm.asp
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<td>RMA FOR VERIFICATION RMA# 4700683652 QTY 3 - MAG3100 FLOWTUBES REF PO# 62120</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Handling Unit Summary**

<table>
<thead>
<tr>
<th>Dimensions</th>
<th>Gross Weight</th>
<th>Net Weight</th>
<th>Cubic Volume</th>
</tr>
</thead>
<tbody>
<tr>
<td>Inches</td>
<td>Lbs</td>
<td>Kgs</td>
<td>Cubic Feet</td>
</tr>
<tr>
<td>Meters</td>
<td></td>
<td></td>
<td>Cubic Meters</td>
</tr>
<tr>
<td>L</td>
<td>0.00</td>
<td>0.00</td>
<td>0.00</td>
</tr>
<tr>
<td>W</td>
<td>0.00</td>
<td>0.00</td>
<td>0.00</td>
</tr>
<tr>
<td>H</td>
<td>0.00</td>
<td>0.00</td>
<td>0.00</td>
</tr>
</tbody>
</table>

*If this invoice, delivery note, or packing list represents an export transaction, then these commodities, technology or software items were exported from the United States in accordance with the Export Administration Regulations. In all cases, diversion contrary to U.S. law is prohibited. These items are not to be used, directly or indirectly, in prohibited nuclear, chemical/ biological or missile weapons activities. This is to certify that the information on this invoice, delivery note, ASN or packing list is true and correct and that the contents of this shipment are as stated herein.*

*We hereby certify that these goods were produced in compliance with all the applicable requirements of Section 6, 7, and 12 of the Fair Labor Standards Act, as amended, and regulations and orders of the United States Department of Labor issued under Section 14, thereof.*

Page 14 of 22
### Customer:
- **Name**: TWINCO CORP.
- **Address**: 145, ELICOTT RD.
- **Phone**: 
- **Email**: 

### MAGFLO® Identification:
- **TAG No./Name**: 0
- **Sensor Code No.**: 7ME631
- **Sensor Serial No.**: 084940H054
- **Transmitter Code No.**: 7ME691
- **Transmitter Serial No.**: N1D5079775

### Results:

#### Verification file name or No.
- **Transmitter**: File #2
- **Sensor**: Passed
- **Insulation**: Passed
- **Magnetic Circuit**: Passed

#### Velocity

<table>
<thead>
<tr>
<th>Velocity</th>
<th>Theoretical</th>
<th>Current Output</th>
<th>Frequency Output</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Theoretical</td>
<td>Actual</td>
<td>Deviation</td>
</tr>
<tr>
<td>0.5m/s</td>
<td>4.800mA</td>
<td>4.802mA</td>
<td>0.25%</td>
</tr>
<tr>
<td>1.0m/s</td>
<td>5.600mA</td>
<td>5.603mA</td>
<td>0.17%</td>
</tr>
<tr>
<td>3.0m/s</td>
<td>8.800mA</td>
<td>8.801mA</td>
<td>0.02%</td>
</tr>
</tbody>
</table>

#### Transmitter Settings:
- **Qmax.**: 500.000 US G /min
- **Flow Direction**: Positive
- **Low flow Cut-off**: 1.50%
- **Empty Pipe**: OFF

#### Sensor Details:
- **Size**: DN 150 6 IN
- **Cal. Factor**: 17.86133003
- **Correction Factor**: 1.0
- **Excitation Freq.**: 7.5Hz

#### Verificator Details (083F5061):
- **Serial No.**: 101415N400
- **Device No.**: 90952
- **Software Version**: 1.40
- **PC-Software Version**: 5.01
- **Cal. date**: 2015.10.26
- **ReCal. date**: 2016.10.26

### Comments:

These tests verify that the flowmeter is functioning within 2% deviation of the original test parameters. Verification is traceable to National and International Standards.

Date and signature: 2016.10.26, Joe McFarland
SIEMENS
Process Instrumentation and Analytics

RMA No: [4790683652]
Serial No: [7MHE510-439E6-1024]
Reference No: [300032772]

Reason for return:
CUSTOMER REQUEST VERIFICATION TEST

VISUAL INSPECTION

Does returned unit represent above model number? ☐ YES ☐ NO
If not, list discrepancies:

Select Condition:
☐ OK
☐ Cracked
☐ Stained/Water Residue
☐ Display
☐ Electrical Terminals
☐ Burnt
☐ Process Threads
☐ Other: LINER DIRTY.

Are Process Connections Clogged or Pneumatic Ports Dirty? ☐ NO ☐ YES
Select the type of blockage: ☐ DEBRIS ☐ FLUID

FUNCTIONAL TESTS

<table>
<thead>
<tr>
<th>Pass</th>
<th>Fall N/A</th>
</tr>
</thead>
<tbody>
<tr>
<td>☐</td>
<td>☐</td>
</tr>
</tbody>
</table>

Mechanical Adjustments: ☐ ☐ ☐
Power Up: ☐ ☐ ☐
Push Button: ☐ ☐ ☐
Menu Operation: ☐ ☐ ☐
Calibration/Verifier (mag): ☐ ☐ ☐
Process Threads: ☐ ☐ ☐
Input/Output signal response: ☐ ☐ ☐

ANALYSIS

All Device functions: ☐ ☐

CHECK FLOW TUBE WITH ODM METER, COIL READING, READS OK.
SHOOTS ELECTRODES SHOWS GOOD CONTINUITY, WITH NO SHORTS. PERFORM VERIFICATION TEST
ON FLOW TUBE. UNIT PASSED ALL TESTS. WILL SUPPLY CERTIFICATE OF TEST RESULTS.

CORRECTIVE ACTION

NO CORRECTIVE ACTION TAKEN.

ADDITIONAL COMMENTS

ANY ADDITIONAL PROBLEMS CONTACT TECH SUPPORT.

Valid Warranty Claim: ☐ NO ☐ YES
Technician: [MCFedX, MBEH, MBEH]
Time Stamp: 2/9/2016 3:20:42 PM
#3

## Packing List

<table>
<thead>
<tr>
<th>Handling Unit #:</th>
<th>00000000000000001004052172</th>
<th>Handling Unit #:</th>
<th>1 of 3</th>
</tr>
</thead>
<tbody>
<tr>
<td>Siemens Ref #:</td>
<td>SI6004008852880172</td>
<td>Printed on:</td>
<td>02/10/2016</td>
</tr>
<tr>
<td>Sales order #:</td>
<td>3900111272</td>
<td>Rq. sn. date:</td>
<td>01/22/2016</td>
</tr>
<tr>
<td>Delivery #:</td>
<td>SI6004008852880</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Shipment #:</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Project #:</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Subcontracting PO #:</td>
<td>3900111272</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Customer PO #:</td>
<td>62120</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Final Customer PO #:</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Sold To:**

<table>
<thead>
<tr>
<th>TWINCO CORP</th>
<th>PO Box 8</th>
<th>WEST FALLS NY 14170</th>
</tr>
</thead>
</table>

**Bill To:**

<table>
<thead>
<tr>
<th>TWINCO CORP</th>
<th>PO Box 8</th>
<th>WEST FALLS NY 14170</th>
</tr>
</thead>
</table>

**Forwarding Agent:**

| TWINCO CORP | PO #52120 | ATTN: Jeff Jayas | 145 ELICOTT RD | WEST FALLS NY 14170 |

**Shipment Details:**

- **Ship via:** FXFREA Fedex Freight Priority
- **Freight Terms:** Prepaid and Add

<table>
<thead>
<tr>
<th>Line</th>
<th>Material Number/Description</th>
<th>Qty Ordered (PCS)</th>
<th>Qty Shipped in HL (PCS)</th>
<th>Qty Back-ordered (PCS)</th>
<th>Weight (Lbs)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1040</td>
<td>7ME6S104FJ111AA2</td>
<td>1</td>
<td>1</td>
<td>0</td>
<td>89.287</td>
</tr>
<tr>
<td></td>
<td>MAG3100, 8&quot; Neoprene, Poly NPT</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>HTS 9026102040 ECCN EAR99</td>
<td>Country of Origin: GB</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>RMA # 4700683852</td>
<td>Customer PO item #: 001000</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>RMA FOR VERIFICATION</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>RMA # 4700683852</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>QTY 3-MAG3100 FLOWTUBES</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>REF PO # 82120</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Handling Unit Summary**

- **Total:** 1 | 1 | 0 | 89.3

**Dimensions**

<table>
<thead>
<tr>
<th>Item</th>
<th>Gross Weight</th>
<th>Net Weight</th>
<th>Cubic Volume</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Lbs</td>
<td>Kgs</td>
<td>Cubic Feet</td>
</tr>
<tr>
<td></td>
<td>Lbs</td>
<td>Kgs</td>
<td>Cubic Meters</td>
</tr>
</tbody>
</table>

**Notes:**

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- We hereby certify that these goods were produced in compliance with all the applicable requirements of Section 6, 7, and 12 of the Fair Labor Standards Act, as amended, and regulations and orders of the United States Department of Labor issued under Section 14, thereof. *This paragraph must be typed or printed in a font size at least 0.8 times the size of the body text.

Page 17 of 22
**Customer:**

Name: TWINCO CORP.
Address: 145 ELLICOTRD.
WEST FALLS, NY 14170

Phone: ___________________________
Email: ___________________________

**MAGFLO® Identification:**

TAG No./Name: 0
Sensor Code No.: 7ME531
Sensor Serial No.: 061940H082
Transmitter Code No.: 7ME591
Transmitter Serial No.: N1D5079775
Location: ___________________________

**Results:**

<table>
<thead>
<tr>
<th>Velocity</th>
<th>Theoretical</th>
<th>Current Output</th>
<th>Frequency Output</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Theoretical</td>
<td>Actual</td>
<td>Deviation</td>
</tr>
<tr>
<td>0.5m/s</td>
<td>4.800mA</td>
<td>4.803mA</td>
<td>0.37%</td>
</tr>
<tr>
<td>1.0m/s</td>
<td>5.600mA</td>
<td>5.603mA</td>
<td>0.20%</td>
</tr>
<tr>
<td>3.0m/s</td>
<td>8.800mA</td>
<td>8.801mA</td>
<td>0.01%</td>
</tr>
</tbody>
</table>

Current Output: 4-20mA
Frequency Output: 0-10kHz

**Transmitter Settings:**

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Setting</th>
</tr>
</thead>
<tbody>
<tr>
<td>Qmax</td>
<td>3000.00 US G/min</td>
</tr>
<tr>
<td>Flow Direction</td>
<td>Positive</td>
</tr>
<tr>
<td>Low flow Cut-off</td>
<td>0.50%</td>
</tr>
<tr>
<td>Empty Pipe</td>
<td>OFF</td>
</tr>
<tr>
<td>Current Output</td>
<td>ON (4-20mA)</td>
</tr>
<tr>
<td>Time Constant</td>
<td>5.0 Sec.</td>
</tr>
<tr>
<td>Relay Output</td>
<td>Error Level</td>
</tr>
<tr>
<td>Digital Output</td>
<td>Pulse</td>
</tr>
<tr>
<td>Frequency Range</td>
<td>N/A</td>
</tr>
<tr>
<td>Time Constant</td>
<td>N/A</td>
</tr>
<tr>
<td>Volume/pulse</td>
<td>0.99999953 US G/p</td>
</tr>
<tr>
<td>Pulse width</td>
<td>0.0041 sec.</td>
</tr>
<tr>
<td>Pulse polarity</td>
<td>Positiv</td>
</tr>
</tbody>
</table>

**Sensor Details:**

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Setting</th>
</tr>
</thead>
<tbody>
<tr>
<td>Size</td>
<td>DN 200 8 IN</td>
</tr>
<tr>
<td>Cal. Factor</td>
<td>31.11448669</td>
</tr>
<tr>
<td>Correction Factor</td>
<td>1.0</td>
</tr>
<tr>
<td>Excitation Freq.</td>
<td>3.75Hz</td>
</tr>
</tbody>
</table>

**Verificator Details (083F5061):**

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Setting</th>
</tr>
</thead>
<tbody>
<tr>
<td>Serial No.</td>
<td>101415N400</td>
</tr>
<tr>
<td>Device No.</td>
<td>90952</td>
</tr>
<tr>
<td>Software Version</td>
<td>1.40</td>
</tr>
<tr>
<td>PC-Software Version</td>
<td>5.01</td>
</tr>
<tr>
<td>Cal. date</td>
<td>2015.10.26</td>
</tr>
<tr>
<td>ReCal. date</td>
<td>2016.10.26</td>
</tr>
</tbody>
</table>

**Comments:**

These tests verify that the flowmeter is functioning within 2% deviation of the original test parameters.

Verification is traceable to National and International Standards.

Date and signature: 2/9/16 2016.02.09

JOE MCFARLAND
SIEMENS
Process Instrumentation and Analytics

RMA No: 4706083652
Serial No: 7ME610 0514040002
Reference No: 89004441272

Reason for return:
CUSTOMER REQUEST VERIFICATION TESTING

VISUAL INSPECTION

Does returned unit represent above model number? □ YES □ NO
If not, list discrepancies:
Select Condition:
□ OK
□ Cracked
□ Stained/Water Residue
□ Display
□ Electrical Terminals
□ Burnt
□ Process Threads
□ Other:

Are Process Connections Clogged or Pneumatic Ports Dirty? □ NO □ YES
Select the type of blockage: □ DEBRIS □ FLUID

FUNCTIONAL TESTS

Pass Fail N/A
Mechanical Adjustments: ○ ○ ○
Power Up: ○ ○ ○
Push Button: ○ ○ ○
Menu Operation: ○ ○ ○
Calibration/Verificator (mag): ○ ○ ○
Process Threads: ○ ○ ○
Input/Output signal response: ○ ○ ○

ANALYSIS

All Device functions: ○ ○

CHECK FLOWTUBE WITH OHM METER, COIL READS OK, NO SHORTS, ELECTRODE SHOW GOOD CONTINUITY, WITH NO SHORTS, PERFORM VERIFICATOR TEST ON FLOWTUBE, UNIT PASSED ALL TESTS, WILL SUPPLY CERTIFICATE OF RESULTS.

CORRECTIVE ACTION

NO CORRECTIVE ACTION TAKEN.

ADDITIONAL COMMENTS

ANY ADDITIONAL PROBLEMS, CONTACT TECH SUPPORT.

Valid Warranty Claim: □ NO □ YES
Technician: [MGFSX] Joseph McFarland
Time Stamp: 2/9/2016 3:03:40 PM
DRIVER CHECKLIST FOR LAND APPLICATION ON ONE-TIME USE FIELDS

Farm Name: ______________________ Town: ______________________

Field ID#: ______________

Estimated Acreage Which Can Be Sprayed: ______________________

<table>
<thead>
<tr>
<th>ISOLATION DISTANCES</th>
<th>Circle one:</th>
</tr>
</thead>
<tbody>
<tr>
<td>Are There Any:</td>
<td></td>
</tr>
<tr>
<td>Swales</td>
<td>Yes  No</td>
</tr>
<tr>
<td>Surface Waters</td>
<td>Yes  No</td>
</tr>
<tr>
<td>Wells or other water supply</td>
<td>Yes  No</td>
</tr>
<tr>
<td>Bedrock Outcrops</td>
<td>Yes  No</td>
</tr>
<tr>
<td>Places of Habitation</td>
<td>Yes  No</td>
</tr>
</tbody>
</table>

Required Isolation Distances:
- Swales 100 feet
- Surface Waters 100 feet
- Wells/Water Supply 500 feet
- Bedrock Outcrops 100 feet
- Places of Habitation 300 feet

CAN YOU MAINTAIN ALL ISOLATION DISTANCES WHEN SPRAYING?  Circle One: Yes No

Do not spray if you cannot maintain the required isolation distances.

What is the SLOPE of the area to be sprayed upon?

____________________%  

Do not spray if the estimated slope is greater than 20%.

Driver Signature: ______________________ Truck Number: ______________

Date: ______________________
## GENERAL IDP INSPECTION CHECKLIST

May 2016

<table>
<thead>
<tr>
<th>Auditor: Kim B. Watson, RQAP-GLP, Professional Engineer: Julie Moore, P.E. Stone Environmental, Inc.</th>
<th>Audit Date:</th>
</tr>
</thead>
<tbody>
<tr>
<td>Agri-Mark, Inc. dba Cabot Creamery, Cabot Creamery Facility, Cabot Vermont Indirect Discharge Permit Inspection</td>
<td>May 17, 2016</td>
</tr>
</tbody>
</table>

**Personnel Interviewed:**

- Aaron Page
- Chris Pearl
- Curtis O'Donnell
- Marcel Gravel
- Bryan Harrington
- Harvey Lyons

**Regulatory Documents Compliance:**

- IDP Permit No. ID-9-0043: January 12, 2016
- VT Guidelines for Land Application of Dairy Processing Wastes
- Others:

**WASTE PROCESS OPERATIONS – INDIRECT DISCHARGE OF DAIRY PROCESSING WASTEWATER PROCESSING**

PART II, III — Type of Waste - Dairy Processing water: may contain, whey spillage, cottage (acid) whey, cottage rinse water, water used to clean the lines and equipment.

### Indirect Discharge Permit Inspection Item

<table>
<thead>
<tr>
<th>Question</th>
<th>REF/Other</th>
<th>Y/N</th>
<th>Comments</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. examination of the collection system and pump station(s) used to convey the dairy processing wastewater from the production areas to the storage tanks;</td>
<td>Section 14</td>
<td>ENRICH No. 299 HYDROXY SAW No. 480</td>
<td></td>
</tr>
<tr>
<td>2. verification of the proper operation of the pump(s) and, if applicable, any alarm systems;</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>3. examination of the tanks and containment structures as well as any leakage detection systems;</td>
<td></td>
<td>AMMONIA</td>
<td></td>
</tr>
<tr>
<td>4. checking the calibration of flow meters used to determine the volume of dairy processing wastewater stored in the tanks or verifying, by the review of recent documentation (within the past two years), that the meters are properly calibrated within a 10% tolerance:</td>
<td></td>
<td>Maintenance Shop 3/29/2016 - Cal. Simmons</td>
<td></td>
</tr>
<tr>
<td>5. checking the equipment utilized</td>
<td></td>
<td>FT-WWP-0001 - Gal. Simmons</td>
<td></td>
</tr>
<tr>
<td>Question</td>
<td>REF/Other</td>
<td>Y/N</td>
<td>Comments</td>
</tr>
<tr>
<td>-------------------------------------------------------------------------</td>
<td>-----------</td>
<td>-----</td>
<td>--------------------------------------------------------------------------</td>
</tr>
<tr>
<td>to fill the spray trucks and observing the procedure utilized to fill the trucks:</td>
<td></td>
<td>Y</td>
<td></td>
</tr>
<tr>
<td>6. observing the land application of dairy processing wastewater on disposal fields, and checking the proper operation of the each truck's spray nozzle;</td>
<td></td>
<td>Y</td>
<td>Trip #1 - 00178 Chandler Farm TRUCK #403 - Intermediate movement - and transmission - note @107AM - #406, H. Lyon Farm 116A - MCM4 closely common. Well.</td>
</tr>
<tr>
<td>7. checking each vehicle's daily journal for compliance with the requirements of Condition I11, (Daily Journal).</td>
<td></td>
<td>Y</td>
<td>NEED NEW PERMITS IN #403/404 NEED NEW BINDER IN #406 Improvements. 1. Hing EE 2. Chemical usage master list.</td>
</tr>
<tr>
<td>8. noting any necessary repairs and maintenance and/or improvements that should be made to the land application system.</td>
<td></td>
<td>Y</td>
<td></td>
</tr>
</tbody>
</table>

TRUCKS

- 402 - visual - ok
- 403 - visual - all looks good.
- 404 - visual - all looks good.
- 405 - 2016
- 406 - P.W. Jedick - OK
- 407 - out of service
- 408 -
- 409 - NEW

Drivers
- Andy Luce
- Bob Wright
- Richard Trucott
- Rejean Pion
- Marvin Colburn
- Dan Breitmeyer
- Harvey Hejna
- Dan Gonyau
- Gerard Pion
- Ren Mekitier
- Larry LaCross

pH treatment

\[
\text{Field} = \frac{5}{10} \text{keep}
\]