



Project is world first
2



In at the deep end
3



Milestones celebrated
4

opendoor

We're focused on creating a zero carbon future

The last 12 months have been many different things to all of us, but for everyone it has been challenging.

Our business was severely impacted at the beginning of lockdown, when we saw sales volumes fall by 80 per cent.

This, in turn, led us to stop kiln production fully for six weeks during April and May as demand for our products fell away during the first lockdown.

Fortunately, demand for materials then picked up and in particular for bagged cement, with summer being extremely busy as we all, me included, decided to do some of the bigger jobs at home instead of taking a holiday.

While we had our own short furlough period during the quietest times, I am very

pleased we have maintained employee numbers and, in fact, have been able to increase our production headcount by offering full-time positions to all four of our apprentices. They are a fantastic group of individuals and a key part of the long-term plans we have for the site.

The current economic challenges are significant but will be overcome. What we are truly focused on is the biggest challenge we all have, climate change and how we create our zero carbon future.

Cement and concrete are essential basic materials for modern life and in many situations there are no viable alternatives, therefore we must find a way to move towards zero CO₂ as quickly as possible. This will need innovation, creativity,

ingenuity and investment.

Our parent company HeidelbergCement is leading our industry in developing targets and actions to reduce the impact of our operations, both in terms of reducing and/or capturing and storing CO₂. These targets and actions flow through to every part of what we do at Ribblesdale, some examples of which are included in this newsletter.

Gary Young
Works manager



Wellbeing is a top priority

Ribblesdale works is putting a strong focus on the mental health of its employees.

As part of a UK-wide Hanson initiative, the works has boosted its number of mental health first aiders to 11 – all have completed a two-day training course, with more scheduled for later this year.

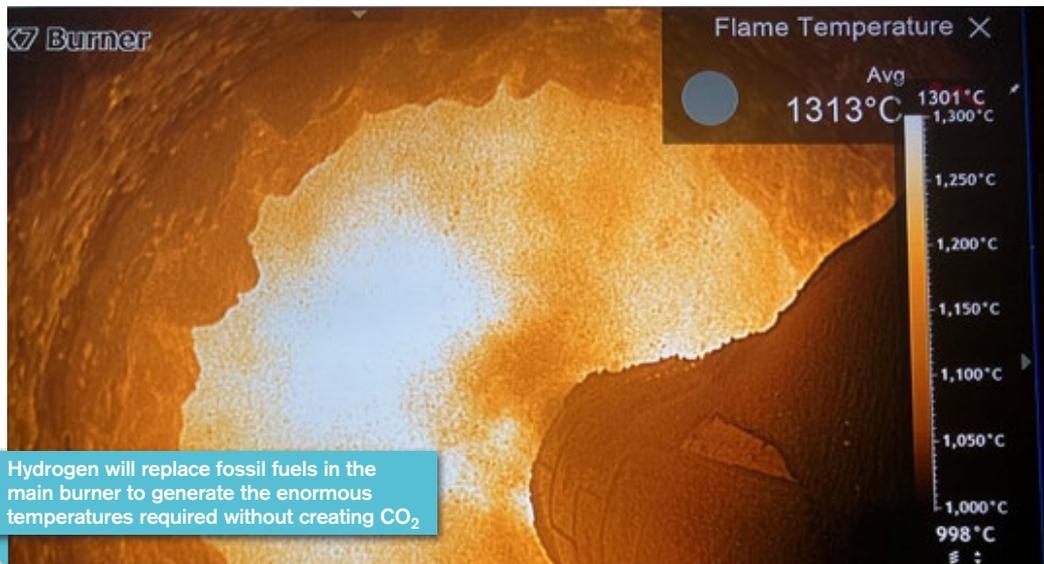
A dedicated wellbeing room in the main office building offers information leaflets and books on subjects including stress, anxiety, bereavement and debt.

A computer is available for people to search for support organisations and a telephone if they need to call a charity or organisation.

The room was set up by the manager's PA Marie Cossins and former employee Dave Pomfret.

Works manager Gary Young said: "This year has been particularly tough for

● **Turn to page 2**



Hydrogen trial has huge potential

Ribblesdale works has been chosen for a major trial aimed at using hydrogen as a replacement for fossil fuels in the cement manufacturing process.

The project has the potential to impact on worldwide cement production as the results of this summer's trial will be shared with the industry worldwide to maximise the environmental benefits of the technology.

This follows a £6.2 million grant from UK Government's Department for Business, Energy and Industrial Strategy

(BEIS) to the Mineral Products Association (MPA) to test whether a combination of biomass, hydrogen and plasma technology could reduce carbon emissions through switching from fossil fuels on an industrial scale.

A feasibility study in 2019 suggested that using 70 per cent biomass, 20 per cent hydrogen and 10 per cent plasma energy could lead to cement and limekilns operating with a net zero carbon fuel mix. MBM, fuel derived from meat

and bonemeal, has already been trialled successfully on the plant's main burner.

If adopted by just the UK cement industry, the project has the potential to save around two million tonnes of carbon a year, equivalent to annual emissions from 266,000 homes.

Ribblesdale works manager Gary Young said: "As a company, cutting CO₂ emissions is a key priority and we have already made good progress through using alternative fuels in the kiln."

Wellbeing a top priority

● From page 1

a lot of people and for a lot of different reasons. The list of mental health first aiders and information about the wellbeing room has been circulated to the workforce.”

The room can be used for any telephone counselling if somebody struggles to find a quiet, private space. It can be also used to speak to a line manager or a colleague or to just take five minutes to gather your thoughts. There is also a Hanson UK helpline available.

The mental health first aiders are Darryl Chadwick, Alex Smith, Marie Cossins, Zak Holgate, Daniel Hothersall, Tom Grainger, Ceri Jones, Ben King, Steven Turner, Russell Ward and Edward Chatburn.



Works manager's PA Marie Cossins in the new wellbeing room

INDUSTRIAL PAST REVEALED

Restoration work on four historic limekilns at Hanson Cement's Bellmanpark quarry is throwing up some interesting artefacts which will help record the industrial archaeology of the buildings.

The renovation project aims to protect the tops of the limekilns from the ingress of rainwater which has been washing away the lime mortar from between the stone and brickwork.

Work started in February to remove vegetation before the tops of the kilns are cleaned.

The second stage will be to place turf, from nearby fields owned by Hanson Cement, to help seal the tops and protect the kilns from rain damage.

Jane Entwistle, technical director of structural engineers Thomasons, who are overseeing the restoration, said: "During the clean-up phase we were surprised to find industrial artefacts such as picks, chains and iron parts which may come from the old conveyors."

Talk to us...

Hanson Cement operates an open door policy – if you want to talk to us about our operations or visit the works, please contact **Gary Young** on **01200 414261** or email **gary.young@hanson.com**

Low-carbon project is world first

Hanson UK has become a partner in the HyNet North West consortium, which aims to create the world's first low-carbon industrial cluster.

The proposed hydrogen and carbon capture and storage project is critical to the UK's transition to net zero greenhouse gas emissions by 2050.

Involvement in HyNet, **illustrated below**, is the next step in the company's path towards industrial scaling of carbon capture technologies.

Carbon capture and utilisation or storage is key to the climate strategy.

HyNet covers the largest concentration of advanced manufacturing and chemical production in the UK.

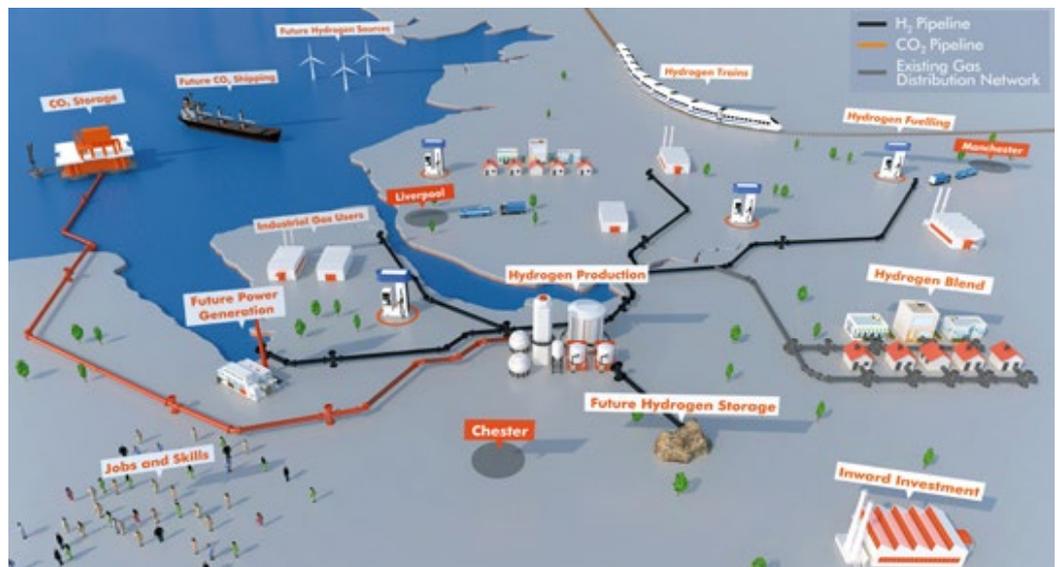
HyNet will collect captured carbon dioxide from industrial locations in the north west and north Wales and pipe it across land to a gas terminal at Point of Ayr in Flintshire for storage offshore in depleted gas reservoirs in Liverpool Bay.

In parallel, low carbon

hydrogen will be produced, initially in Cheshire, to enable fuel switching across the north west by industry and flexible power generation, as well as for transport and for heat.

The project will reduce CO₂ emissions by up to 10 million tonnes a year by 2030.

HyNet will deliver 80 per cent of the national hydrogen production target, 100 per cent of the national target for carbon capture and storage by 2030 and a hydrogen town.



Process emissions capture will reduce CO₂

After promising results from the first phase, HeidelbergCement is starting the further development and scaling-up of the LEILAC (low emissions intensity lime and cement) technology, which has the potential to capture around 20 per cent of a cement plant's CO₂ emissions.

Two thirds of the CO₂ emissions are process-related – released when heating the limestone – and were believed to be unavoidable.

But the LEILAC 1 project has already demonstrated that CO₂ can be successfully

captured and that the technology works on a larger scale.

Phase two at HeidelbergCement's Hanover plant is around four times larger than the first and will capture 20 per cent of the cement plant's capacity, corresponding to around 100,000 tonnes of CO₂ a year. The overall project is expected to be completed by 2025.

The technology has the potential to enable the cement and lime industries to efficiently capture their process emissions on an industrial scale.



Simon Bamber, left, with weighbridge technician Mark Riley

Simon tackles new challenge

With more than 30 years experience in the transport industry, former professional rugby league player Simon Bamber is ready to tackle a new challenge as transport office manager at Ribblesdale works.

At Ribblesdale, Simon looks after a fleet of 44 lorries and 62 drivers, as well as five weighbridge technicians.

Brought up in the Widnes area, Simon was encouraged to take up rugby by former Wales and British Lions centre John Bevan, who taught at his

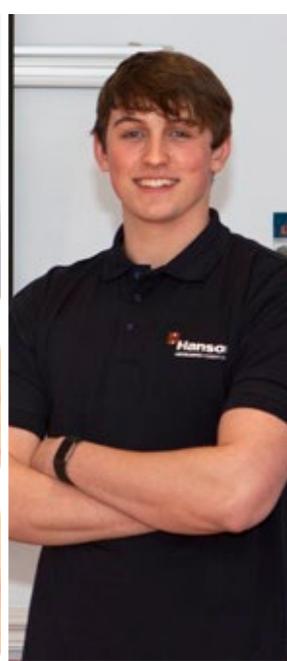
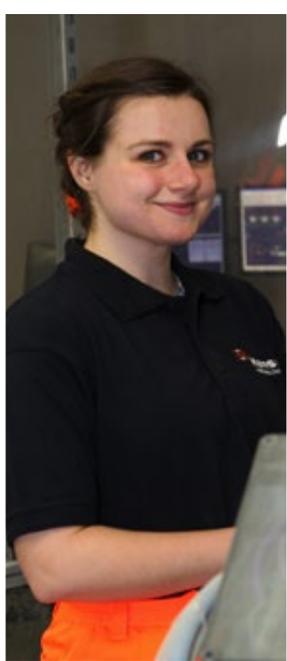
school. As an amateur, Simon represented Warrington, Lancashire, England and Great Britain, while as a professional he played centre for Rochdale and St Helens.

He is married to Tracy and they have two children. Nowadays, he enjoys watching sport and walking his cocker spaniel dog.

Simon said: "This is a new industry for me. I would like to grow the Ribblesdale team and make it the best in the north and ultimately the best in the UK."



Left to right, Harris Holgate, Sam Wallace, Miriam Joyce, James King and Aidan Walton



Apprentices and graduates are just the job

Apprentices Harris Holgate and Aidan Walton, who have spent the last four years training as electricians, have passed their BTEC level 4 higher national certificate with distinction and both have secured jobs at Ribblesdale works.

They now go on to study for their higher

national diplomas at Training 2000 Blackburn, which under the current Covid restrictions is being carried out remotely.

James King is soon to complete his apprenticeship and will be working as a process technician, operating the kiln system.

Miriam Joyce and Sam Wallace have completed degrees in chemical engineering and are now part of the works' graduate programme.

They are both gaining technical and practical experience for future engineering and management roles.



Darren Chown has been busy since joining at the start of the first lockdown

Navy man Darren's in at the deep end

Life might have appeared pretty mundane for new packing and logistics plant supervisor Darren Chown after spending 16 years looking after Trident nuclear missiles on Royal Navy submarines and seven years driving British Army tanks through the world's war zones.

But, far from it. Darren joined Ribblesdale works at the start of the first lockdown and simply hasn't had time to reflect on 23 years in the armed forces.

He said: "It's a massive change from looking after nuclear missiles to looking after bags of cement. But it's been really busy. I joined

the Ribblesdale team just when the furlough started and haven't stopped."

During the glorious weather of the first lockdown, Ribblesdale works couldn't make cement fast enough as people on furlough got on with home DIY jobs.

Originally from Colchester, Darren, 46, served on submarine *HMS Vanguard* and was responsible for the care and maintenance of its Trident missiles. He now lives in Clitheroe with son Ethan and during his spare time enjoys cycling, running and generally keeping fit, which he says is a spin-off from his Army days.

Long servers celebrate milestones

Maintenance electrician Fred Smalley from Clitheroe has notched up an incredible 50 years' service at Ribblesdale works.

Fred, who plans to retire soon, is proud his family has more than 100 years' association with the cement works.

His grandfather Alf Hart was a master burner at the works in the 1930s and delayed his retirement to be the first person to light the new No 5 kiln. His uncle Doug Hart clocked up a further 25 years' service and Fred's brothers Michael and Philip and sister Anne all worked at Ribblesdale.

Fred started as an apprentice electrician in 1970, married Judith in 1979 and they have a daughter, Amanda. In his spare time, he enjoys watching Blackburn Rovers FC.

Steven Todd is also a maintenance electrician and has been with the company 45 years, having joined Ribblesdale Cement in 1976. Steven is Clitheroe born and bred and in his spare time enjoys motorbikes, football and fishing, particularly in Scotland.

Michael Cowking can claim to have 100 per cent success in job interviews! His first after school was for an apprentice electrician role and, 45 years later, he is still with the company. Michael, 61 and from Bolton-by-Bowland, is now a maintenance electrician and software controller.



Long servers, left to right, Steven Todd, Fred Smalley and Michael Cowking

Process operative Mohammed Ilyas has completed 40 years' service. He lives in Clitheroe with his wife Balqees and they have five children – three boys and two girls – and two grandchildren. During his leisure time he enjoys gardening and walking.

Also celebrating 40 years is maintenance fitter/team leader John Wilson from Clitheroe, who joined after qualifying as an electrician. Graham Kenyon, 57, is also a maintenance fitter. He is married to Katharine and they have one daughter. He enjoys walking and motorbikes. He started as an apprentice on the same day as another maintenance fitter celebrating 40 years, Matthew King from Chatburn.

35 years: quarryman David Astin; electrical supervisor David Jackson; maintenance fitter David Grooby; shift manager Sean

Wilson and LGV fitter/team leader Paul Nash, all from Clitheroe; technical manager Nick Sharpe, Ingleton.

30 years: weighbridge technician Paul Menzies, Great Harwood; quarry supervisor Benjamin King and stores supervisor Terry Braithwaite, Clitheroe; maintenance fitter David Gaskill, Worston; IT systems manager Norman Mitchell, Oswaldtwistle.

25 years: electrical engineer Ben Nicholson, Skipton; shift manager David Shuttleworth, Gisburn; stores attendant Michael Whittaker, LGV drivers Leonard Gallagher, Mark Perkins, Nigel Tilley, Stephen Bowen, all from Clitheroe; Mark Harwood, Copster Green; Keith Moores, Blackburn; Gary Purcell and David Sherwood, Colne; Peter Kabrna, Barrowford; Derek Haworth and Ronald Haycock, Great Harwood.

Retiring six have almost two centuries of experience...

Six long-serving employees have retired after amassing almost 200 years at Ribblesdale works.

They are electrical supervisor Derek Lloyd, 64, from West Bradford; quarry maintenance fitter Tony Fox, 64, from Newton-in-Bowland; technical development manager Chris Tomlinson, 60, from Clitheroe; process analyst David Salisbury, 61, also from Clitheroe; LGV driver Philip Harwood; and quarry operative Douglas Brierley.

Derek, who started as an apprentice electrician aged 16 in 1973, has completed 47 years' service. He is married to Jacqui, who he met 42 years ago when she worked in the canteen. They have two children and three grandchildren. During his retirement, he hopes to spend more time on his computer and walking the dog.

Quarry maintenance fitter Tony Fox, 64, spent 46 years at Ribblesdale works. Since his retirement, he has switched from maintaining large quarrying machines to caring for his vintage tractors, including a Massey Ferguson 35 which he exhibits at local shows. He and his wife Jacqueline live in Newton-in-Bowland.

Chris joined in 1982 as a laboratory technician and went on to study concrete

technology at Leeds Building College. As part of his role as technical development manager, he played a significant role in the supply of Ribblesdale cement for construction of the new Hinkley Point C nuclear power station.

He enjoys walking, running and cycling – he and his wife Helen take part in an annual 100-mile charity cycle ride. They have two daughters.

David spent the early part of his working life farming in Zimbabwe, but returned to the UK when the political situation became

unstable. He joined the Ribblesdale team in 1989 as a temporary employee in the stores and has since clocked up 31 years.

During his time he has also worked as garage co-ordinator, electrical craftsman, tester and lab analyst. He is Clitheroe born and bred and is married to Ann. They have two children and three grandchildren. He enjoys watching Burnley FC and has just joined the Ramblers Association and is planning a walking break in Wales.

LGV driver Philip had 19 years' service, while Doug clocked up 17 years.



Retirees, left to right, Tony Fox, Chris Tomlinson and David Salisbury. Inset, Derek Lloyd