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ANNEX IV

PROCESSING

CHAPTER IV

ALTERNATIVE PROCESSING METHODS

Section 1

General provisions

1. Materials resulting from the processing of Category 1 and 2 materials, except biodiesel produced in accordance with point D of Section 2 of this Chapter, shall be permanently marked in accordance with the requirements for the marking of certain derived products set out in Chapter V of Annex VIII.
2. The competent authority of a Member State shall make the results of official controls available to the competent authority of another Member State upon request, when an alternative method is used for the first time in that Member State, in order to facilitate the introduction of the new alternative method.

Section 2

Processing standards

A. Alkaline hydrolysis process

1. Starting material

For this process, animal by-products of all categories may be used.

2. Processing method

Alkaline hydrolysis shall be carried out according to the following processing standards:

- (a) Either a sodium hydroxide (NaOH) or potassium hydroxide (KOH) solution (or a combination thereof) must be used in an amount that assures approximate molar equivalency to the weight, type and composition of the animal by-products to be digested.

In the case of high fat in the animal by-products that neutralises the base, the added base must be adjusted so that the molar equivalency referred to is achieved.

- (b) Animal by-products must be placed in a steel alloy container. The measured amount of alkali must be added either in solid form or as a solution as referred to in point (a).
- (c) The container must be closed and the animal by-products and alkali mixture must be heated to a core temperature of at least 150 °C and at a pressure (absolute) of at least 4 bars for at least:
 - (i) three hours without interruption;

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- (ii) six hours without interruption in case of treatment of animal by-products referred to in Article 8(a)(i) and (ii) of Regulation (EC) No 1069/2009.

However, materials derived from Category 1 materials comprising of animals killed in the context of TSE eradication measures which are either ruminants not requiring TSE testing or ruminants which have been tested with a negative result in accordance with Article 6(1) of Regulation (EC) No 999/2001 may be processed in accordance with point 2(c)(i) of this Section; or

- (iii) one hour without interruption in the case of animal by-products consisting of fish or of poultry materials.

- (d) The process must be carried out in a batch system and the material in the vessel must be constantly mixed in order to facilitate the digestion process until the tissues are dissolved and bones and teeth are softened; and

- (e) The animal by-products must be treated in such way that the requirements regarding time, temperature and pressure are achieved at the same time.

B. High pressure high temperature hydrolysis process

1. Starting material

For this process, Category 2 and Category 3 materials may be used.

2. Processing method

High pressure high temperature hydrolysis shall be carried out according to the following processing standards:

- (a) The animal by-products must be heated to a core temperature of at least 180 °C for at least 40 minutes without interruption at a pressure (absolute) of at least 12 bar, heated by indirect steam application to the biolytic reactor;
- (b) The process must be carried out in a batch and the material in the vessel must be constantly mixed; and
- (c) The animal by-products must be treated in such a manner that the requirements regarding time, temperature and pressure are achieved at the same time.

C. High pressure hydrolysis biogas process

1. Starting material

For this process, animal by-products of all categories may be used.

2. Processing method

The high pressure hydrolysis biogas process shall be carried out according to the following processing standards:

- (a) The animal by-products must be first processed using processing method 1 (pressure sterilisation) as set out in Chapter III in an approved processing plant;
- (b) Following the process referred to in point (a), the defatted materials must be treated at a temperature of at least 220 °C for at least 20 minutes at a pressure (absolute) of at

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least 25 bar, heated in a two-step procedure, first by direct steam injection, secondly indirect in a coaxial heat exchanger;

- (c) The process must be carried out in a batch or continuous system and the material is constantly mixed;
- (d) The animal by-products must be treated in such a manner that the requirements regarding time, temperature and pressure are achieved at the same time;
- (e) The resulting material must then be mixed with water and anaerobically fermented (biogas transformation) in a biogas reactor;
- (f) In the case of starting material of Category 1, the entire process must take place on the same site and in a closed system and the biogas produced during the process must be combusted rapidly in the same plant at a minimum of 900 °C followed by rapid chilling ('quenching').

D. Biodiesel production process

1. Starting material

For this process, a fat fraction derived from animal by-products of all categories may be used.

2. Processing method

Biodiesel production shall be carried out according to the following processing standards:

- (a) Unless fish oil or rendered fat are used which have been produced in accordance with Sections VIII or XII of Annex III to Regulation (EC) No 853/2004, respectively, the fat fraction derived from animal by-products must be first processed using:
 - (i) in the case of Category 1 or 2 materials, processing method 1 (pressure sterilisation) as set out in Chapter III; and
 - (ii) in the case of Category 3 materials, any of the processing methods 1 to 5 or processing method 7 or, in the case of material derived from fish, processing methods 1 to 7 as set out in Chapter III;
- (b) The processed fat must then be processed further using one of the following methods:
 - (i) a process whereby the processed fat must be separated from the protein and in the case of fat from ruminant origin, insoluble impurities in excess of 0,15 % by weight must be removed, and the processed fat must be subsequently submitted to esterification and transesterification.

However, esterification is not required for processed fat derived from Category 3 material. For esterification the pH must be reduced to less than 1 by adding sulphuric acid (H₂SO₄) or an equivalent acid and the mixture must be heated to 72 °C for at least two hours during which it must be intensely mixed.

Transesterification must be carried out by increasing the pH to about 14 with potassium hydroxide or with an equivalent base at 35 °C to 50 °C for at least 15 minutes. Transesterification shall be carried out twice under the conditions described in this point using a new base solution. This process must be followed by refinement of the products including vacuum distillation at 150 °C, leading to biodiesel;

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- (ii) a process using equivalent process parameters authorised by the competent authority.

E. Brookes' gasification process

1. Starting material

For this process, Category 2 and Category 3 material may be used.

2. Processing method

Brookes' gasification shall be carried out according to the following processing standards:

- (a) The afterburner chamber must be warmed up using natural gas;
- (b) The animal by-products must be loaded into the primary chamber of the gasifier and the door must be closed. The primary chamber must have no burners and must be heated instead by the transfer of heat by conduction from the afterburner, which must be underneath the primary chamber. The only air admitted to the primary chamber must be via three inlet valves mounted on the main door to enhance the efficiency of the process;
- (c) The animal by-products must be volatilised into complex hydrocarbons and the resultant gases must pass from the primary chamber via a narrow opening at the top of the back wall to the mixing and cracking zones, where they must be broken down into their constituent elements. Finally the gases must pass into the afterburner chamber where they must be burned in the flame of a natural gas fired burner in the presence of excess air;
- (d) Each process unit must have two burners and two secondary air fans for back-up in case of burner or fan failure. The secondary chamber must be designed to give a minimum residence time of two seconds at a temperature of at least 950 °C under all conditions of combustion;
- (e) On leaving the secondary chamber the exhaust gases must pass through a barometric damper at the base of the stack, which cools and dilutes them with ambient air, maintaining a constant pressure in the primary and secondary chambers;
- (f) The process must be carried out over a 24-hour cycle, which includes loading, processing, cool down and ash removal. At the end of the cycle the residual ash must be removed from the primary chamber by a vacuum extraction system into enclosed bags and sealed before transporting;
- (g) The gasification of material other than animal by-products must not be permitted.

F. Combustion of animal fat in a thermal boiler process

1. Starting material

For this process, a fat fraction derived from animal by-products of all categories may be used.

2. Processing method

Combustion of animal fat in a thermal boiler shall be carried out according to the following processing standards:

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- (a) Unless fish oil or rendered fat are used which has been produced in accordance with Sections VIII or XII of Annex III to Regulation (EC) No 853/2004, respectively, the fat fraction derived from animal by-products must first be processed using:
- (i) in the case of fat fraction of Category 1 and 2 materials which is intended to be combusted in another plant,
 - for the fat fraction from the processing of ruminants which have been tested with a negative result in accordance with Article 6(1) of Regulation (EC) No 999/2001 and from the processing of animals, other than ruminants which require TSE testing, any of the processing methods 1 to 5 as set out in Chapter III of this Annex.
 - for the fat fraction from the processing of other ruminants, processing method 1 as referred in Chapter III; and
 - (ii) in the case of Category 1 and 2 materials intended for combustion within the same plant and in the case of Category 3 material, any of the processing methods 1 to 5 or processing method 7; in the case the materials are derived from fish, processing methods 1 to 7 as set out in Chapter III;
- (b) The fat fraction must be separated from the protein and in the case of fat from ruminant origin which is intended to be combusted in another plant, insoluble impurities in excess of 0,15 % by weight must be removed;
- (c) Following the process referred to in points (a) and (b), the fat must be:
- (i) vaporised in a steam-raising boiler and combusted at a temperature of at least 110 °C for at least 0,2 seconds; or
 - (ii) processed using equivalent process parameters authorised by the competent authority;
- (d) The combustion of material of animal origin other than animal fat must not be permitted;
- (e) The combustion of the fat derived from Category 1 and Category 2 materials shall take place in the same plant where the fat is rendered with the aim of utilising the energy generated for the rendering processes. However, the competent authority may authorise the movement of that fat to other plants for combustion provided that:
- (i) the plant of destination is authorised for the combustion;
 - (ii) the processing of food or feed in an approved plant on the same premises takes place under strict conditions of separation;
- (f) The combustion must be carried out in accordance with Union legislation for the protection of the environment, in particular, with reference to the standards of that legislation regarding best available techniques for the control and monitoring of emissions.
- G. Thermomechanical biofuel production process
1. Starting material
- For this process, manure and digestive tract content and Category 3 material may be used.
2. Processing method

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Thermomechanical biofuel production shall be carried out according to the following processing standards:

- (a) The animal by-products must be loaded into a converter and subsequently treated at a temperature of 80 °C for a period of eight hours. During this period, the material must be constantly reduced in size using appropriate mechanical abrasion equipment.
- (b) The material must be subsequently treated at a temperature of 100 °C for at least two hours.
- (c) The particle size of the resulting material must not be larger than 20 millimetres;
- (d) The animal by-products must be treated in such a manner that the requirements regarding time, temperature and pressure set out in points (a) and (b) are achieved at the same time;
- (e) During the heat treatment of the material, evaporated water must be continually extracted from the air-space above the biofuel and must be passed through a stainless steel condenser. The condensate must be kept at a temperature of at least 70 °C for at least one hour before being discharged as wastewater;
- (f) After the heat treatment of the material, the resulting biofuel from the converter must then be discharged and automatically conveyed by a fully covered and interlocked conveyor to incineration or co-incineration on the same site;
- (g) The process must be carried out in a batch mode.

Section 3

Disposal and use of derived products

1. Products derived from the processing of:
 - (a) Category 1 material shall be:
 - (i) disposed of in accordance with Article 12(a) or (b) of Regulation (EC) No 1069/2009;
 - (ii) disposed of by burial in an authorised landfill;
 - (iii) transformed into biogas, provided the digestion residues are disposed of in accordance with points (i) or (ii); or
 - (iv) further processed into fat derivatives for uses other than feeding.
 - (b) Category 2 or Category 3 material shall be:
 - (i) disposed of as provided for in point 1(a)(i) or (ii), with or without prior processing as provided for in Article 12(a) and (b) of Regulation (EC) No 1069/2009;
 - (ii) further processed into fat derivatives for uses other than feeding;
 - (iii) used as an organic fertiliser or soil improver; or
 - (iv) composted or transformed into biogas.
2. Materials resulting from processing in accordance with:

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- (a) the alkaline hydrolysis process defined in point A of Section 2 may be transformed in a biogas plant and subsequently combusted rapidly at a minimum of 900°C, followed by rapid chilling ('quenching'); where material referred to in Article 8(a) and (b) of Regulation (EC) No 1069/2009 has been used as starting material, the transformation into biogas shall take place on the same site as the processing and in a closed system;
 - (b) the biodiesel production process may be:
 - (i) in the case of biodiesel and of residues from the distillation of biodiesel, used as a fuel without restrictions under this Regulation (end point);
 - (ii) in the case of potassium sulphate, used for the production of derived products for application to land;
 - (iii) in the case of glycerine:
 - derived from Category 1 or Category 2 material which has been processed in accordance with processing method 1 as set out in Chapter III, transformed into biogas.
 - derived from Category 3 material, used for feeding.
3. Any resulting waste from the processing of animal by-products in accordance with this Section, such as sludge, filter contents, ash and digestion residues shall be disposed of in accordance with Regulation (EC) No 1069/2009 and with this Regulation.

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