



**International Finance Corporation**  
**Environmental, Health and**  
**Safety Guidelines for**  
**Food and Beverage Processing**

**Liquid Effluents**

Process wastewater, domestic sewage and contaminated stormwater should be treated to meet the following specified limits before being discharged to surface waters:

<i>Parameter/Pollutant</i>	<i>Maximum Value</i>
pH	6 to 9
BOD <sub>5</sub>	50 mg/L
Oil and grease	10 mg/L
Total suspended solids	50 mg/L
Coliforms	Less than 400 MPN/100 mL (MPN - Most Probable Number)
Temperature increase	Less than or equal to 3°C <sup>1</sup>

<sup>1</sup>The effluent should result in a temperature increase of no more than 3 degrees Celsius at the edge of the zone where initial mixing and dilution take place. Where the zone is not defined, use 100 meters from the point of discharge.

Liquid effluent discharges to a public or private central wastewater treatment system may be subject to pre-treatment requirements. Sponsors should provide information from the local authority or private central wastewater treatment company, to confirm that the treatment system has the capacity to adequately treat the project's liquid effluents.

**Stack Emissions**

Concentrations of contaminants emitted from stacks including boilers, furnaces, incinerators and electrical generating equipment should not exceed the following limits:

<i>Parameter/Pollutant</i>	<i>Maximum Value</i>
Particulate Matter (PM <sub>10</sub> )	
≥50 MWe	50 mg/Nm <sup>3</sup>
<50 MWe	100 mg/Nm <sup>3</sup>
Nitrogen Oxides, as NO <sub>2</sub>	
Coal fired	750 mg/Nm <sup>3</sup>
Oil fired	460 mg/Nm <sup>3</sup>
Gas fired	320 mg/Nm <sup>3</sup>
Sulfur Dioxide	2,000 mg/Nm <sup>3</sup>

**Ambient Noise**

Noise abatement measures should achieve the following levels, measured at noise receptors located outside the project property boundary, with a maximum increase in the existing ambient level of L<sub>eq</sub> 3 dB(A) where the existing ambient level exceeds L<sub>eq</sub> 45 dB(A).

**Ambient Noise**

<i>Receptor</i>	<i>Maximum Allowable L<sub>eq</sub> (hourly), in dB(A)</i>	
	<i>Daytime 07:00 - 22:00</i>	<i>Nighttime 22:00 - 07:00</i>
Residential; institutional; educational	55	45
Industrial; commercial	70	70

**Solid and Liquid Wastes**

a) Project sponsors should recycle or reclaim materials where possible.

b) If recycling or reclaim is not practical, wastes must be disposed of in an environmentally acceptable manner and in compliance with local laws and regulations.

c) All hazardous materials, process residues, solvents, oils, and sludges from raw water, process wastewater and domestic sewage treatment systems must be disposed of in a manner to prevent the contamination of soil, groundwater and surface waters.

### **Other General Environmental Requirements**

a) Formulations containing chromates should be avoided in water treatment processes.

b) Transformers or equipment containing polychlorinated biphenyls (PCBs) or PCB-contaminated oil should not be installed, and existing equipment involving PCBs or PCB-contaminated oil should be phased out and disposed of in a manner consistent with the requirements of the host country.

c) Processes, equipment and central cooling systems involving the use or potential release to the environment of chlorofluorocarbons (CFCs), including halon, should not be installed, and their use in existing processes and systems should be phased-out and disposed of in a manner consistent with the requirements of the host country.

d) Storage and liquid impoundment areas for fuels, raw and in-process materials, solvents, wastes and finished products should be designed with secondary containment (e.g. dikes, berms) to prevent spills and the contamination of soil, groundwater and surface waters.

### **Workplace Air Quality**

a) Periodic monitoring of workplace air quality should be conducted for air contaminants relevant to employee tasks and the plant's operations.

b) Ventilation, air contaminant control equipment, protective respiratory equipment and air quality monitoring equipment should be well maintained.

c) Protective respiratory equipment must be used by employees when the exposure levels for welding fumes, solvents and other materials

present in the workplace exceed local or internationally accepted standards, generally expressed as threshold limit values (TLVs).

### **Workplace Noise**

a) Feasible administrative and engineering controls, including sound-insulated equipment and control rooms should be employed to reduce the average noise level in normal work areas.

b) Plant equipment should be well maintained to minimize noise levels.

c) Personnel must use hearing protection when exposed to noise levels above 85 dBA.

### **Work in Confined Spaces**

a) Prior to entry and occupancy, all confined spaces (e.g., tanks, sumps, vessels, sewers, excavations) must be tested for the presence of toxic, flammable and explosive gases or vapors, and for the lack of oxygen.

b) Adequate ventilation must be provided before entry and during occupancy of these spaces.

c) Personnel must use air-supplied respirators when working in confined spaces which may become contaminated or deficient in oxygen during the period of occupancy.

d) Observers/assistants must be stationed outside of confined spaces to provide emergency assistance, if necessary, to personnel working inside these areas.

### **Hazardous Material Handling and Storage**

a) All hazardous (reactive, flammable, radioactive, corrosive and toxic) materials must be stored in clearly labeled containers or vessels.

b) Storage and handling of hazardous materials must be in accordance with local regulations, and appropriate to their hazard characteristics.

c) Fire prevention systems and secondary containment should be provided for storage

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facilities, where necessary or required by regulation, to prevent fires or the release of hazardous materials to the environment.

**Health - General**

- a) Sanitary facilities should be well equipped with supplies (e.g., protective creams) and employees should be encouraged to wash frequently, particularly those exposed to dust, chemicals or pathogens.
- b) Ventilation systems should be provided to control work area temperatures and humidity.
- c) Personnel required to work in areas of high temperature and/or high humidity should be allowed to take frequent breaks away from these areas.
- d) Pre-employment and periodic medical examinations should be conducted for all personnel, and specific surveillance programs instituted for personnel potentially exposed to toxic or radioactive substances.

**Safety - General**

- a) Shield guards or guard railings should be installed at all belts, pulleys, gears and other moving parts.
- b) Elevated platforms and walkways, and stairways and ramps should be equipped with handrails, toeboards and non-slip surfaces.
- c) Electrical equipment should be grounded, well insulated and conform with applicable codes.
- d) Personnel should use special footwear, masks and clothing for work in areas with high dust levels or contaminated with hazardous materials.
- e) For work near molten or high temperature materials, employees should be provided with non-slip footwear, gloves, safety glasses, helmets, face protection, leggings and other necessary protective equipment.
- f) Eye protection should be worn by personnel when in areas where there is a risk of flying

chips or sparks, or where intense light is generated.

- g) Personnel should wear protective clothing and goggles when in areas where corrosive materials are stored or processed.
- h) Emergency eyewash and showers should be installed in areas containing corrosive materials.
- i) A safety program should be established for construction and maintenance work.
- j) A fire prevention and fire safety program should be implemented and include regular drills.

**Training**

- a) Employees should be trained on the hazards, precautions and procedures for the safe storage, handling and use of all potentially harmful materials relevant to each employee's task and work area.
- b) Training should incorporate information from the Material Safety Data Sheets (MSDSs) for potentially harmful materials.
- c) Personnel should be trained in environmental, health and safety matters including accident prevention, safe lifting practices, the use of MSDSs, safe chemical handling practices, and proper control and maintenance of equipment and facilities.
- d) Training also should include emergency response, including the location and proper use of emergency equipment, use of personal protective equipment, procedures for raising the alarm and notifying emergency response teams, and proper response actions for each foreseeable emergency situation.

**Record Keeping and Reporting**

- a) The sponsor should maintain records of significant environmental matters, including monitoring data, accidents and occupational illnesses, and spills, fires and other emergencies.

- b) This information should be reviewed and evaluated to improve the effectiveness of the environmental, health and safety program.
  
- c) An annual summary of the above information should be provided to IFC.