



Safety,
Health and
Environment



Performance

2 0 0 5



INEOS Chlor

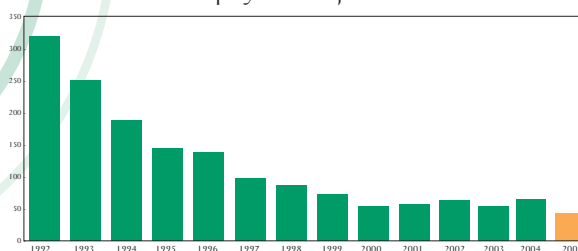
Towards Zero Injuries at Work

Minor Injuries

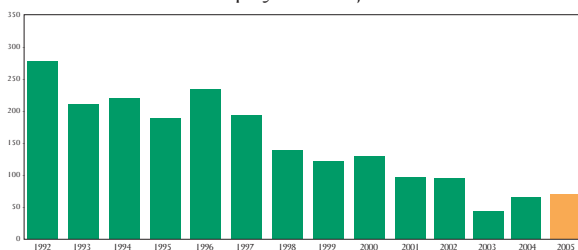
As progress towards achieving its objective of zero injuries at work, INEOS Chlor requires its employees and all who work under its control to follow a set of behavioural standards encompassed within the "SHE Standards for Manufacturing", designed to foster a culture to achieve that aim.

Progress in 2005:

Employee All Injuries



Non-Employee All Injuries

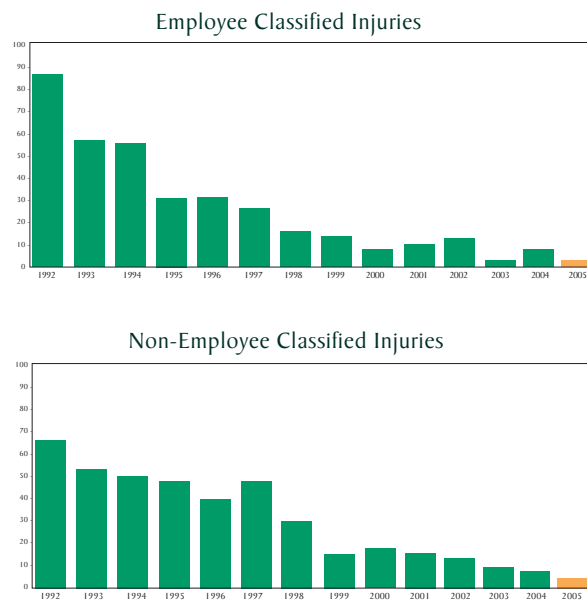


In 2005, the total number of injuries sustained at Runcorn Site fell by 13% on the previous year. Whilst the number of injuries to INEOS Chlor employees reduced significantly in the year, there was a slight increase in the number of injuries to contractors. This increase is due in part to increased reporting of the very minor injuries (e.g. plaster required) - the type of injury that can result from simple DIY activities at home. We continue to closely monitor injury performance and to identify lessons that can be learnt to prevent harm to those working at Runcorn Site.

Classified Injuries

As progress towards achieving its objective of zero injuries at work, INEOS Chlor will have as a target each year, both for its employees and those who work under its control, the number of injuries which require more than first-aid treatment to be at least one less than its best year, starting from a target for 2001 of 9.

Progress in 2005:



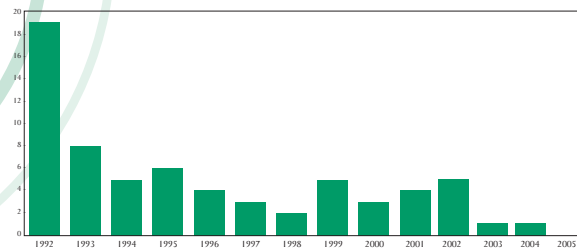
In 2005 the Company achieved its best Classified Injury performance to date. This is an outstanding achievement given the significant increase in construction and maintenance activities taking place at Runcorn Site during the year.

Reportable Injuries

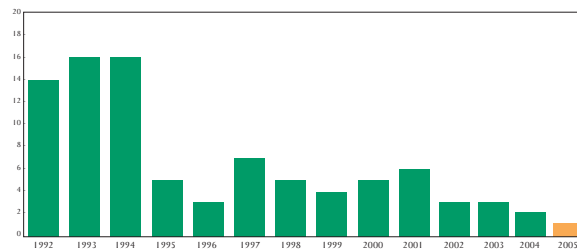
The target for INEOS Chlor is that there should be no injury at work to its employees or to those working under its control of such a serious nature that it must be reported to the statutory authorities.

Progress in 2005:

Employee Reportable Injuries



Non-Employee Reportable Injuries



We continue to achieve a best in class performance for Reportable Injuries. In 2005 a full year was worked by INEOS Chlor employees without a single Reportable Injury at Runcorn Site; this exceptional performance represented an injury-free period of 4.75 million hours by year-end. Our contractor partners also achieved their best ever performance; this represented an injury free period of over 1 million hours by the end of the year.

Towards Zero Work-Related Ill Health

Physical Agents

INEOS Chlor will put in place the necessary procedures and take the necessary actions to ensure that there are no further cases of work-related ill health due to exposure to excessive noise, vibration or radiation arising from its activities.

Progress in 2005:

- *Our rolling 3-year programme of noise surveys continued; there were no new cases of noise induced hearing loss amongst employees.*
- *There were no recorded cases of exposure to ionising radiation above the internal INEOS Chlor standards, which is set at one twentieth of the dose limit set by the Health & Safety Executive.*
- *We continued with our programme of hand and arm vibration measurements. New regulations came into force during the year and our standards reflect this change.*

Occupational Health

INEOS Chlor will work to reduce the number of its workforce who suffer from work related ill health effects.

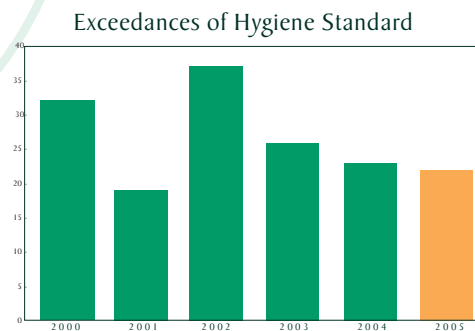
Progress in 2005:

The continued improvement in managing the health of INEOS Chlor employees has been maintained. Improved communication processes between management, Occupational Health professionals and Human Resources resulted in fewer people suffering severe work related ill health problems, for example due to stress at work.

Exposure to Chemicals

INEOS Chlor will monitor the potential exposure of those who work on its sites to hazardous substances. The Company will fully investigate any recorded over-exposure and take steps as are necessary to drive such occurrences towards zero.

Progress in 2005:



INEOS Chlor carries out extensive personal monitoring amongst workers at Runcorn Site and achieved a compliance of more than 99% across 2750 samples taken in the year.

Towards Environmental Sustainability

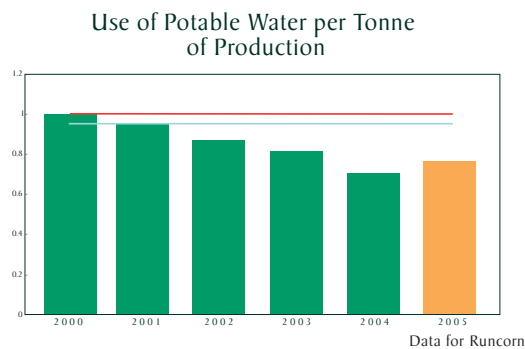
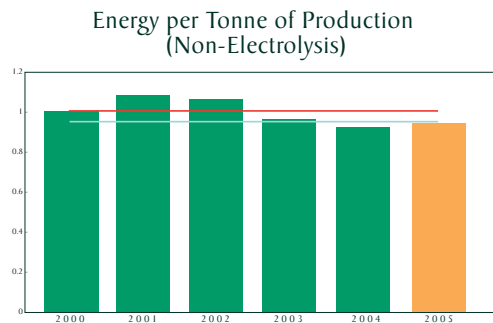
Use of Resources

By 2005 INEOS Chlor will:

- reduce its energy consumption for non-electrolysis uses by 5%
- reduce its use of potable water for production purposes by 5%

per tonne of production based on a 2000 baseline.

Progress in 2005:



Energy usage is closely monitored. Projects to improve the efficiency of energy usage across the Runcorn Site continued in 2005; however energy usage remained more or less the same as the previous year.

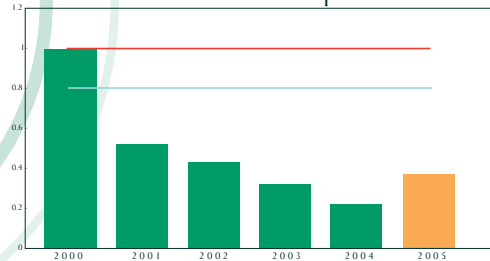
The downward trend in potable water usage continued in 2005 as a result of ongoing programmes to reduce potable water demand across the Runcorn Site manufacturing processes.

Reduction of Releases – Environmental Burden

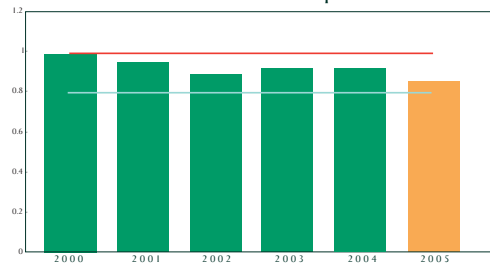
By 2005 INEOS Chlor will reduce by at least a further 20% its impact on environmental properties relating to atmosphere and water, based on a 2000 baseline.

Progress in 2005:

VOCs with Potential for Harm Released to Atmosphere



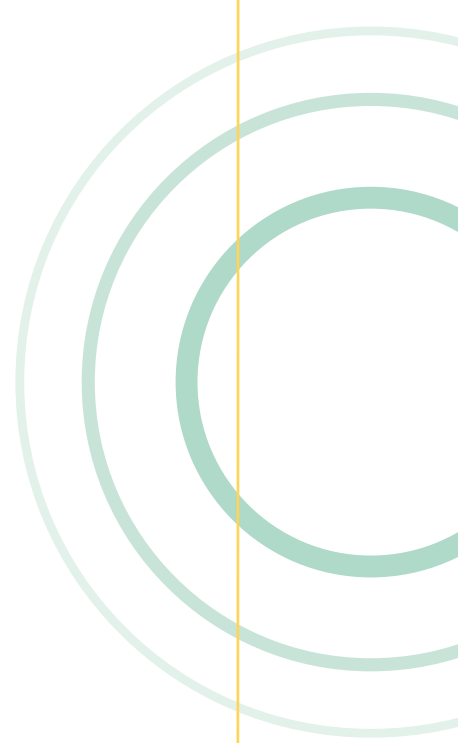
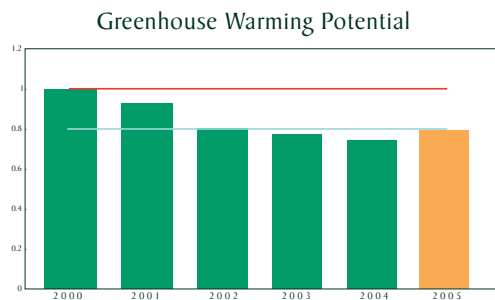
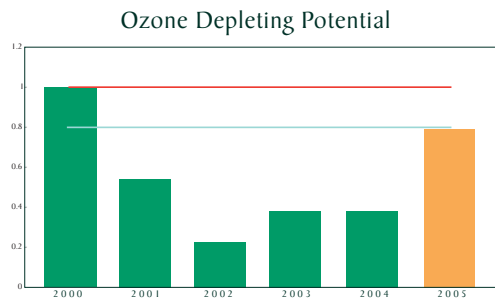
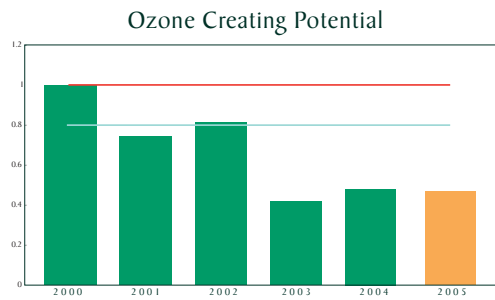
Inorganic Substances with Potential for Harm Released to Atmosphere



In 2005 a major planned overhaul of our Environmental Improvement Project reduced the availability of the vents incineration process and so emissions increased during this period, but were still well within levels set by the Regulator.

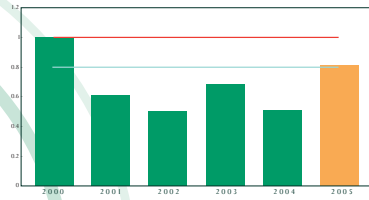
The impact of INEOS Chlor operations on the environmental burden for water is relatively small. The quantity of mercury discharged to the Weston Canal increased in 2004 as a result of a temporary process change during a planned maintenance event.

In terms of releases to air, most measures taken in the air around Runcorn Site were below the limit of detection and concentrations of key substances are one thousandth of the HSE working level.

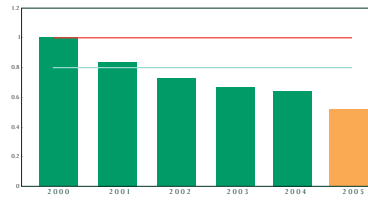




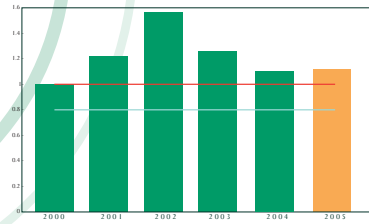
Metals to Water



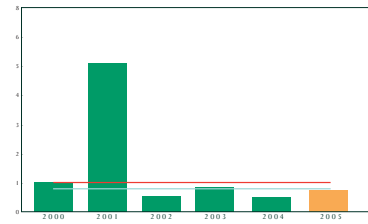
Toxic CHCs to Water (EQS based)



Chlorine Release to Water



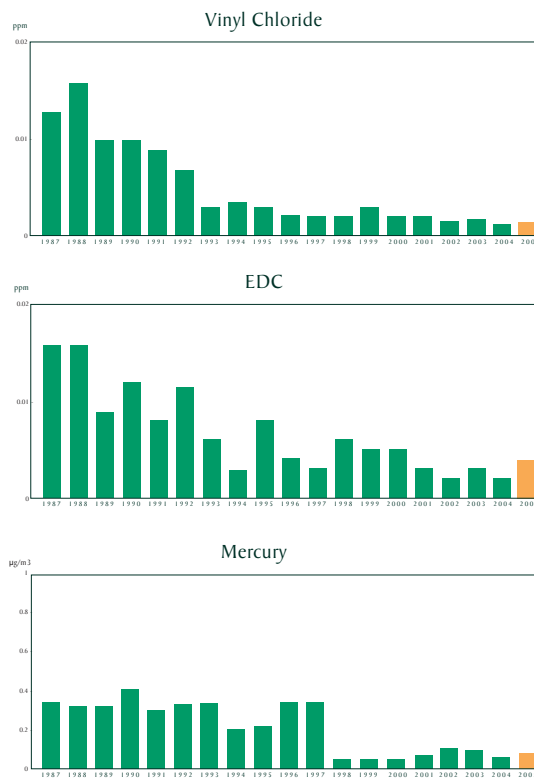
Aqueous Oxygen Demand



Reduction of Releases – Measurement

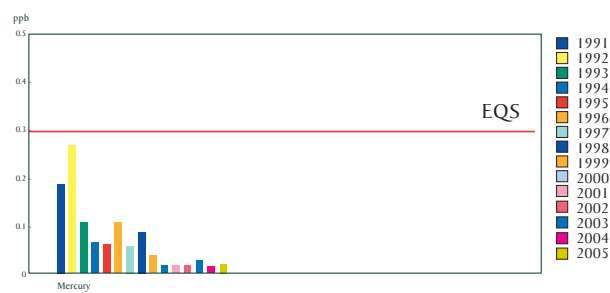
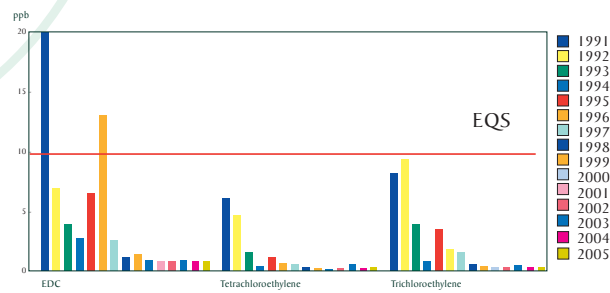
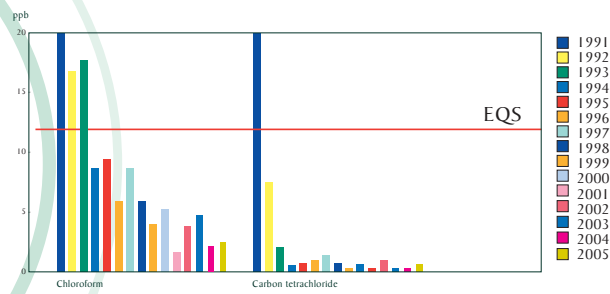
INEOS Chlor will continue to measure the effect that its operations may be having on the environment local to its sites.

Progress in 2005:



The concentrations of each of the water pollutants measured by the Environment Agency remain very low, with around one third of results being at quantities so low they are undetectable.

Environment Agency (EA) data for the concentrations of key pollutants at the Environmental Quality Standard (EQS) monitoring point at Sutton Weir.



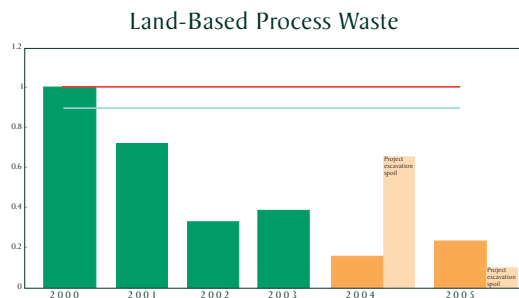
The downward trend continues. Around one third of the results are now below the limit of detection.

Reduction of Releases – Waste Hierarchy

INEOS Chlor will manage its waste in such a way as to minimise its impact on the environment by:

- reusing or recycling waste materials where practicable
- when disposal is inevitable then, where practicable
 - treating the waste before it leaves our control
 - recovering energy from the waste
 - sending the waste to landfill as a last resort
- reducing the amount of waste for disposal by 10% by 2005, based on a 2000 baseline.

Progress in 2005:



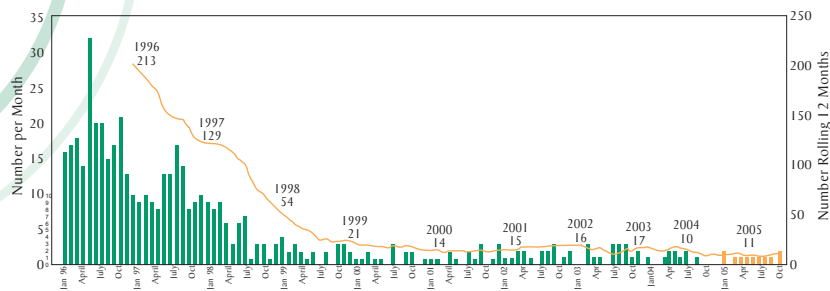
Reduction in waste and improvements in the management of waste are key targets for INEOS Chlor in its drive towards environmental sustainability.

Major construction projects underway at Runcorn Site in 2005 contributed to the waste generated during this period. Plant produced waste remains very low.

Reduction of Releases – Towards Zero Incidents

As progress towards its objective of zero environmental incidents that either have a potential impact off-site or are a breach of our permits, INEOS Chlor will have an annual target of a reduction in the number of such incidents over the previous year, starting from a target for 2001 of 15.

Progress in 2005:



There were a total of 11 reportable incidents in 2005, slightly up on the previous year. All bar one of these incidents was associated with a minor breach of consent on the outfalls at Runcorn Site. None of the incidents gave rise to action by the regulatory authorities. In the year, we achieved compliance of 99.99% across all samples taken.

Protection of Habitats

INEOS Chlor will manage and conserve designated wildlife habitats that are located on its sites.

Progress in 2005:

In addition to protecting habitats on land owned by the Company, such as Clifton Clough Ancient Woodland, we continue to provide funding for community environmental projects through Cheshire Wildlife Trust and other environmental bodies, for example a native bluebell planting scheme at Marbury Park, Cheshire.

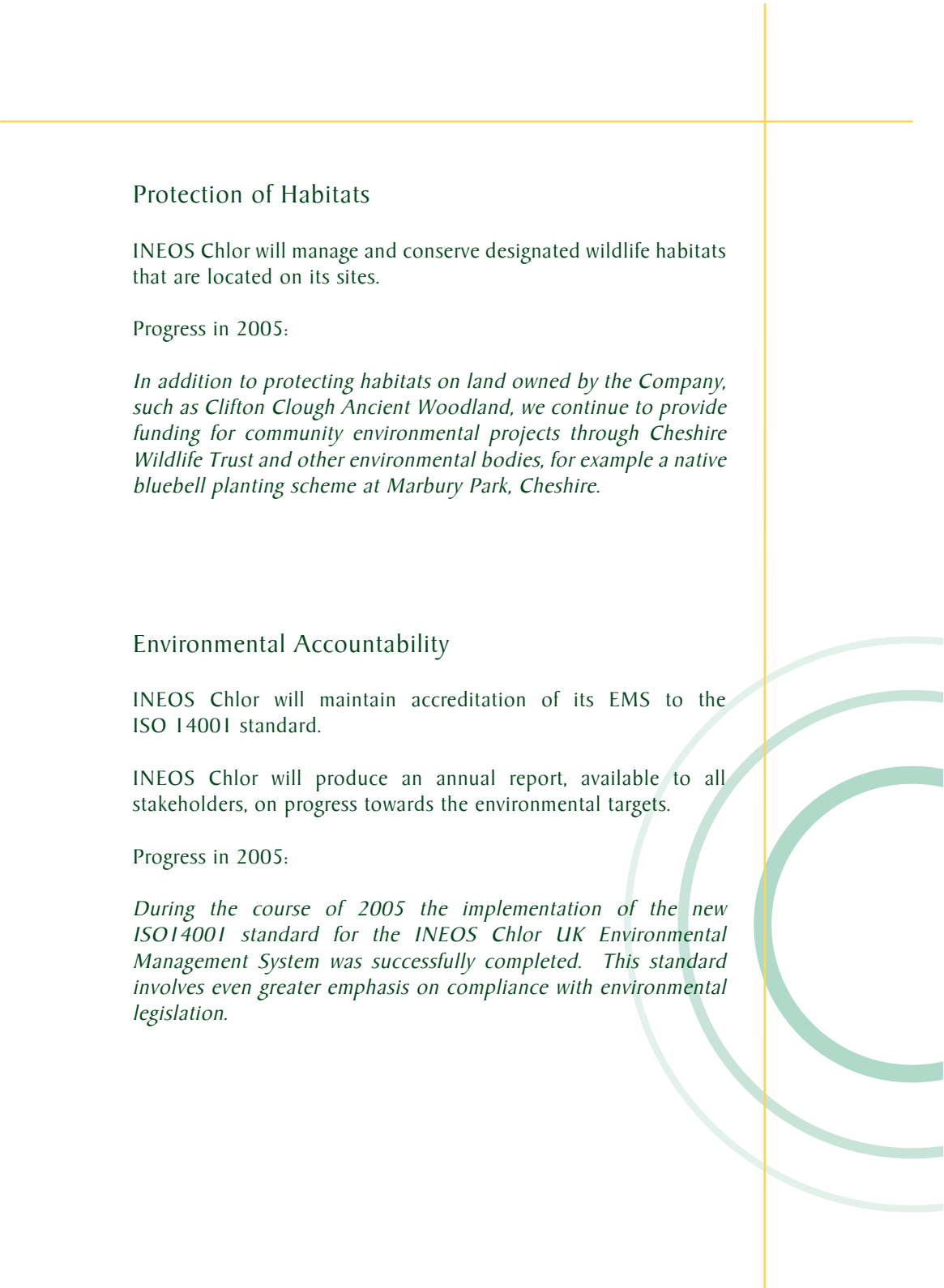
Environmental Accountability

INEOS Chlor will maintain accreditation of its EMS to the ISO 14001 standard.

INEOS Chlor will produce an annual report, available to all stakeholders, on progress towards the environmental targets.

Progress in 2005:

During the course of 2005 the implementation of the new ISO14001 standard for the INEOS Chlor UK Environmental Management System was successfully completed. This standard involves even greater emphasis on compliance with environmental legislation.





INEOS Chlor
www.ineoschlor.com