

Odour Management Plan True Hill Farm

The following plan has been prepared as part of the EPR permit application.

The following tables highlight the likely sources of odour arising from Broiler production at True Hill Farm.

Actions and measures are listed that will prevent where possible or minimise odour emissions at True Hill Farm.

Site plan shows all material storage areas and potential odour emission sources.

Plan to be reviewed every year from permit issue date, prior to any major changes to operations (to ensure effectiveness) or following any complaint, any changes to OMP or other management plans to be documented dated and signed and Area Officer notified.

Actions and preventative measures in OMP referenced from Odour Assessment Document and Fugitive Emissions Assessment in line with the H1 Risk Assessment, to be implemented in conjunction with the following key documents;

Emergency Plan

Technical Standards

Routine Maintenance Schedule

Health Plan

Contingencies

Environmental Management

Key responsibility for the OMP and the referenced plans are the Operator or deputies who have been briefed on the requirements.

Example Odour Complaint form attached.

True Hill Farm

True Hill Farm consists of eight poultry houses for broiler production. The houses have been sited as far as possible away from nearby receptors. The prevailing wind is from the southwest. Each house will be fitted with air scrubbers reducing all emissions.

The table below lists sensitive receptors within 400m of the site boundary.

Receptor Name	Description	Distance	Orientation	National Grid Reference
Residential	Residential	25 m	West	573244,296840
Residential	Residential	58m	West	573182,296840
Residential	Residential	84m	South West	573237,296683
Residential	Residential	115m	South West	573228,296650
Commercial	Commercial	155m	South West	573193,296631
Commercial	Commercial	380m	West	572905,296996
Residential	Residential	141m	South	573294,296581
Residential	Residential	168m	South	573307,296560
Residential	Residential	198m	South	573311,296528

Residential	Residential	246m	South	573352,296483
Residential	Residential	277m	South	573364,296457
Residential	Residential	300m	South	573374,296433
Residential	Residential	325m	South	573341,296399
Residential	Residential	352m	South	573392,296383
Residential	Residential	374m	South	573399,296364
Residential	Residential	234m	Southeast	573661,296624
Residential	Residential	236m	Southeast	573645,296608
Residential	Residential	241m	Southeast	573638,296590
Residential	Residential	254m	Southeast	573617,296563
Residential	Residential	262m	Southeast	573589,296536
Residential	Residential	274m	Southeast	573567,296515
Residential	Residential	297m	Southeast	573552,296486
Residential	Residential	383m	South	573375,296348

Residential	Residential	393m	South	573348,296338
Residential	Residential	360m	South	573362,296370
Residential	Residential	369m	South	573345,296362
Residential	Residential	399m	South	573557,296343
Residential	Residential	399m	South	573326,296325
Residential	Residential	383m	South	573314,296340
Commercial	Commercial	387m	South	573272,296351
Residential	Residential	315m	South West	573181,296444
Commercial	Commercial	399m	South West	573194,296463
Residential	Residential	385m	South	573457,296368
Residential	Residential	360m	South	573444,296390
Residential	Residential	355m	South	573485,296393
Residential	Residential	344m	South	573496,296405
Residential	Residential	343m	South	573510,296414

Residential	Residential	336m	South	573522,296431
Residential	Residential	321m	South	573541,296454
Residential	Residential	278m	South	573570,296515
Residential	Residential	268m	South	573588,296534
Residential	Residential	260m	South	573613,296565
Residential	Residential	256m	South	573636,296594
Residential	Residential	253m	South	573649,296612
Residential	Residential	251m	South	573660,296624
Residential	Residential	254m	South	573676,296633
Residential	Residential	283m	North East	573912,297195
Commercial	Commercial	313m	North East	573949,297193
Commercial	Commercial	358m	North East	573963,297283
Commercial	Commercial	386m	North East	573954,297343
Commercial	Commercial	201m	North East	573758,297274

Odour Related Issue	Potential Risks and Problems	Actions taken to minimise odour and odour risks at True Hill Farm	Completion date
Broiler Production	Odour levels	Twice daily olfactory checks coinciding with stock inspections (normally 07.00-10.00 hrs and 16.00-19.00hrs) (if required) any abnormalities recorded and investigated – see contingencies and routine maintenance and inspection schedule. Main site operations at western side of site away from nearest receptors.	In place

Manufacture and selection of feed	Milling and mixing of compound feeds. The use of poor quality and odorous ingredients. Feeds which are 'unbalanced' in nutrients, leading to increased excretion and litter moisture and emissions of ammonia and other odorous compounds to air.	Feed specifications are prepared by the feed compounder's nutrition specialist. Feed is supplied only from UKAS accredited feed mills, so that only approved raw materials are used. Protein is reduced in accordance with SGN EPR6.09 'How to comply with your environmental permit for intensive farming' 'How to comply with your environmental permit for intensive farming'.	In place
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Feed delivery and storage	Spillage of feed during delivery and storage. Creation of dust during feed delivery.	Feed delivery systems are sealed to minimise atmospheric dust. Any spillage of feed around the bin is immediately swept up. The condition of feed bins is checked frequently so that any damage or leaks can be identified. Feed deliveries are monitored to avoid dust and spills – As per routine inspection and maintenance schedule. See site plan.	In place
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Air Scrubbers	Odour Levels	Reduced odour levels with the continuous use of chemical air scrubbing	In place
Ventilation and Dust	Inadequate air movement in the house, leading to high humidity and wet litter Inadequate system design, causing poor dispersal of odours. Extraction fans located close to sensitive receptors. Dust	All ten houses will be fitted with air scrubbing systems. Use of high velocity roof extraction fans/gable for hot weather cooling, checked prior to cycle commencement by qualified electrician who will provide 24hr breakdown cover – See electrical service reports The ventilation system is regularly adjusted to match the age and requirements of the flock. The ventilation system is designed to efficiently remove moisture from the house. Humidity recorded daily and maintained in the range of 55 – 65% keeping a balance of dry litter and avoiding dust production. Stock inspections carried out by trained staff to avoid panicking birds creating dust. Dust levels if present is controlled during cleanout operations - As per routine inspection and maintenance schedule and clean out operations.	In place
Bird Depletion	Fugitive release from doors during catching	Minimum ventilation in operation. Doors opened and closed for forklift entry/exit.	

Litter management	Odours arising from wet litter (see above).	Controls on feed and ventilation (see above) help to maintain litter quality. Additional controls include:- Use of nipple drinkers with drip cups to minimise spillage. Daily checks of drinker height and pressures to avoid capping. Insulated walls and ceilings to prevent condensation. Concrete floors to prevent ingress of water. Stocking levels at optimum to prevent overcrowding. Use of veterinarian bespoke health plan. See health plan	In place
Carcase disposal	Inadequate storage of carcasses on site.	Carcasses placed into plastic sealed bags, stored in containers away from sensitive receptors. Weekly collection by a licensed agent. Daily levels of mortalities recorded with abnormalities investigated – See health plan	In place

House clean out	Creation of dust associated with litter removal from houses. Use of odorous products during cleaning.	Houses sealed after bird depletion. Minimum ventilation in operation during de-littering. Litter carefully placed into trailers.	In place In place
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		Trailers sheeted before leaving fill position. Only DEFRA approved and suitable products used. Chemical containers triple washed at point of use. Yard areas kerbed to prevent run off. Wash water tank levels monitored during washing and emptied regularly to prevent overfill – See Key responsibilities Clean out commenced within one day following destocking. Maximum duration 3 days.	
Used Litter	Storage of used litter on site. Transport of litter and land spreading.	No storage on site at any time. Litter removal operation monitored at all times, any spillages swept up and put into skip/trailer immediately. All trailers sheeted before leaving fill position. Avoidance of double handling. Litter sold to third parties for land spreading. Vehicles routed to the northwest away from nearest receptors.	In place
Washing operations including vehicles	Loss of dirty water to Land or Watercourse	Use of specialist contractors for washing operations. Bespoke terminal hygiene program followed, detailing quantities of water and chemical dilution rates. Key staff monitoring washing operations ensuring effective drainage to dirty water tanks. Dirty water tanks monitored during wash down to maintain freeboard –See Key responsibilities Vehicle washing at designated wash point. All sediment traps and drains cleaned both before and after washing operations – See Inspection and maintenance schedule	In place

Fugitive emissions	Leaks to doors, bin pipes, feed bins, fuel and chemical storage	Checks to feed storage and fill pipes as per routine maintenance schedule. Fuel oil in approved bunded storage tanks. Chemicals – only small amounts of footdip disinfectant held on site in secondary containment	In place
Dirty water management	Standing dirty water during the production cycle or at clean out. Application of dirty water to land.	Working areas around houses are concreted and kept clean during production cycle. At clean out dirty water from houses together with lightly contaminated yard wash is directed to the underground storage tanks (see site plan), before being removed off site and spread to land under control of a separate farming business. Written agreement is in place. Maximum duration 3 days.	In place
Abnormal operations	Water leak/pipe failure Bird health/sickness	Water consumption monitored daily ensuring early detection, wet area - blanket covered with top up bedding material to prevent increased odour. Veterinarian contacted (24hour cover) Litter covered with fresh top up bedding to minimise increased odour until bird health recovered –See health plan Abnormal events documented, dated and signed, appropriate plans reviewed and updated to prevent reoccurrence ie. Routine maintenance schedule, Technical standards	In place
Waste production/storage	Odour from production or storage areas	No storage or production of odorous waste on site. Waste management plan in force detailing types and quantities produced along with disposal routes. Records kept on site.	In place
Materials/storage	Potential odour source	Feed delivered into sealed vermin proof silos. Sealed delivery system into poultry houses with no milling or mixing on site. Remaining feed at end of cycle stored in sealed silo and used on subsequent cycle.	In place

		Marked on site plan. 3 month shelf life of feed negating the need for removal. Raw materials inventory recorded and kept on site – See key responsibilities	
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Complaints Procedure

In the event of a substantiated odour complaint the cause would be investigated, and actions taken listed in the odour/contingency plans to cease the release. Area officer would be notified immediately, a review of the OMP conducted at the earliest opportunity with any changes communicated to Area officer for approval. A complaints report would be filled out and retained on site.

Odour Contingency						
Source	Potential Cause	Trigger Factor with immediate action	Timed Action	Mitigation Measures to be implemented and remain operative until cessation trigger verified	Additional Mitigation	Cessation Trigger
Feed delivery and storage	Pipe or bin failure causing leak	Daily inspection	24 hours	Repair to pipe work or feed bin with immediate effect, use other bins, spills cleaned up immediately. Integrity of pipe work and bin checking frequency reviewed and updated in routine maintenance and inspection document, with changes recorded and dated.	Bin/pipework replaced	Visual inspection
Carcase storage and disposal	Container failure/damage	Daily Inspection	24 hours	Carcases removed from damaged container into	N/A	Visual Inspection

				additional container, damaged container replaced/repaired immediately.	Alternative collection implemented	
Variations in stocking density/bird growth	Rapid bird growth or poor growth due to illness.	Deviation in predicted growth	24 hours	Bird growth monitored Daily Ventilation and heating controls advanced to account for additional live-weight within house. Veterinarian advice sought immediately for bird illness with additional bedding added to prevent/minimise odour release. Document and record abnormalities. Ensure stocking density complies with BAT standards and bird permit places.	Immediate veterinarian advice sought	Growth rates normal
Air scrubbing systems	Circulation pump Failure	Increased odour	2 hours	Installers providing 24/7 breakdown cover	Spare pump carried on site	Systems fully operational. Repairs effected and documented

Air scrubbing systems	PH Level out of parameters	Increased odour	1 hour	Sensor replaced Operator	Spare sensors carried on site	Systems fully operational. Repairs effected and documented
Air scrubbing systems	Conductivity out of parameters	Increased odour	1 hour	Sensor replaced Operator	Spare sensors carried on site	Systems fully operational. Repairs effected and documented
Air scrubbing systems	Clean water level	Increased odour	1 hour	Check inlet Operator		Systems fully operational. Repairs effected and documented
Air scrubbing systems	Dirty water level	Increased odour	1 hour	Check drain Operator		Systems fully operational. Repairs effected and documented
Air scrubbing systems	Pump Kw	Increased odour	2 hours	Installers providing 24/7 breakdown cover	Spare pump carried on site	Systems fully operational. Repairs effected and documented

Air scrubbing systems	Package pressure differential	Increased odour	3 hours	Installers providing 24/7 breakdown cover		Systems fully operational. Repairs effected and documented
Air scrubbing systems	Ventilation fan failure	Increased odour	2 hours	Installers providing 24/7 breakdown cover/electrician providing 24/7 breakdown cover	Spare fan carried on site	Systems fully operational. Repairs effected and documented
Ventilation System	Fan/system failure	System fully alarmed	2 hours	Alternative ventilation fan used as houses have spare capacity installed, electrician call out	N/A	Repairs effected and documented
Drinker systems	Leaky systems/pipe failure	Deviation in expected water consumption	2 hours	Any leaks isolated and repaired immediately. Wet areas covered with additional bedding to minimise odour. Arrange system integrity testing at cycle end, findings to be documented and recorded, pipe work/system parts to	N/A	Normal consumption

				be replaced as per report.		
Bird depletion	Fugitive odour release	OMP monitoring		Minimum ventilation rate to prevent fugitive release of odour, review OMP with any changes documented and recorded and submitted to Environment Agency Area Officer for approval.	N/A	OMP monitoring recording reduced low levels
Litter Removal	Fugitive odour release from poultry houses	Raised odour levels during OMP monitoring		Minimum ventilation rate to prevent fugitive release of odour, review OMP with any changes documented and recorded and submitted to Environment Agency Area Officer for approval.	Review of littering out procedures	OMP monitoring levels returned to normal
Washing operations/dirty water	Odour release from drainage/storage	Raised odour levels during OMP monitoring		Arrange drainage integrity testing and drain cleaning, record and document findings. Dirty water	Ventilation rates decreased	OMP monitoring levels normal

	Delay in dirty water removal	Washing procedure monitoring	4 hours	tanks filled with clean water and agitated prior to removal to remove any possible sediment/stagnation. Washing operations suspended, agreement with neighbouring farms for dirty water removal	Licensed waste disposal contractor used to prevent extended storage requirement Specialist drainage contractor called out	Normal washing resumed after visual inspection
	Blocked drains		1 hour	Blockage cleared		
Litter/manure	Wet litter	Raised odour levels during OMP monitoring	2 hours	Additional bedding applied to maintain dry friable litter. Initiate olfactory checks to ensure effectiveness.	Additional ventilation implemented to dry litter	OMP monitoring levels normal

Key Responsibilities

Task	Staff position responsible
Olfactory checks	Persons not involved in the poultry production
Overseeing/monitoring feed deliveries	Manager/Assistant
Sweeping feed spillages	Lorry driver/ Assistant
Feed bin and pipe integrity checks	Manager/Assistant
Adjusting ventilation	Manager/Assistant
Stock inspections	Manager/Assistant
Daily checks on drinker heights and pressures	Manager/Assistant
Air scrubber operation	Manager/Assistant
Carcase disposal	Manager/Assistant
Integrity checks for carcase containers	Manager/Assistant
Monitoring wash tank levels and organising tank emptying	Manager/Assistant
Cleaning of sediment traps/drains	Manager/Assistant
Monitoring of water consumption for leak detection	Manager/Assistant
Documenting/reviewing abnormal events	Manager
Reviewing annual plans	Manager
Complaints Log	Manager

Monitoring Procedure

Procedure

Monitoring is carried out weekly, by means of “sniff testing” at the monitoring points by persons not involved directly with the operations at the installation.

Monitoring will be carried out twice weekly at the installation boundary

All records will be securely stored and held on site for inspection.

Monitoring will be by means of self-assessed “Sniff Testing” by person/persons not normally working on the poultry installation.

Severity Scoring

0 – No Odour Detected

1 – Low Intermittent Odour Detected

2 – Low Continuous Odour Detected

3 – Medium Odour Detected

4 – High Odour Detected

5 – Very High Odour Detected

In the event of odour scores of 3, 4 or 5 being recorded the site staff will be alerted to implement contingency measures. Retesting at the installation boundary will be conducted following any actions implemented to ensure the effectiveness of recorded actions implemented.

Monitoring procedure/frequency to be reviewed annually or in the event of a complaint.

OMP to be reviewed annually or following a complaint, or any changes to operations.

In the event of substantiated odour complaints are received over a one-month period without resolution to odour problem a formal action plan with measures and timescales for relevant odour issues shall be presented to the Environment Agency for approval

Odour Complaint Form

Installation Name	Date Recorded	Reference Number
Name and Address of caller:		
Tel. No. of caller		
Location of caller in relation to Installation		
Time and Date of complaint		
Date, Time and duration of Offending odour		
Has the caller any other Comments about the odour?		
Weather conditions		

Wind strength and direction			
Any previous complaints Relating to this odour?			
Any other relevant information			
Potential odour sources that could give rise to the complaint			
Operating conditions at the time offending odour occurred			
Follow up Date and time caller contacted			
Action taken			
Amendment requirement to Odour Management Plan			
Form completed by		Signed	

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Odour management plan to be reviewed annually or following a complaint or any changes to operations.

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