

FOYLE MEATS MELTON RD SIX HILLS MELTON MOWBRAY LE14 3PR

Environmental Permit Application Odour Management Plan Document Ref: Attachment B.3.8.2

FOYLE MEATS, SIX HILLS, MELTON MOWBRAY, UK

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### **1.0 INTRODUCTION**

A statutory odour nuisance is defined as an odour that is so offensive and/or prolonged that it significantly interferes with the enjoyment and use of the affected property.

Many things can affect whether an odour would be considered a statutory nuisance: time of day the odour occurs; how long it is a problem for; the type of smell and its effects; the character of the area.

For example, in the countryside it is reasonable to expect odour from farming activities.

Due to the complex nature of odour perception by the human olfactory system, levels of sensitivity to odour within a population will vary. Consequently, the perceived offensiveness of an odour will vary from person to person. In addition, the context in which the odour occurs will affect the nuisance value of an odour.

As odour accounts for a significant proportion of the complaints that local councils and the Environment Agency receive regarding environmental pollution, it is important that management are cognisant of odour issues in design and management of a facility.

The Odour Management Plan (OMP) is a core document that is intended to detail operational and control measures appropriate to the management and control of odour at a site. The format of the OMP should provide sufficient detail to allow staff to clearly understand the operational procedures for both normal and abnormal conditions.

The Odour Management Plan is a living document and should be reviewed annually, following any significant change to the site, or following any pertinent odour complaints. It should form the basis of a document Environmental and Odour Management system for the operating site.

Requirements for the Odour Management Plan should be implemented throughout the site with a branched management system implemented in order to share responsibility around the site. The environmental manager should ensure all works are performed in accordance with the OMP.

### 1.1 Background

Panther Environmental Solutions Ltd was commissioned by Foyle Ltd to prepare an Odour Management Plan for their Melton Mowbray facility, in support of an application for an Environmental Permit.

Activities at the site include the slaughter of cattle and the dressing, chilling and quartering of beef carcasses, the cutting of beef and the harvesting of offal, cod fat and bones, the packing of beef, beef offal, cod fat and bones into vacuum pouches and lined cardboard boxes.

As with many large-scale food processing factories, Foyle - Melton Mowbray processing operation is faced with the challenge of eliminating, or mitigating where necessary, odours emanating from various point sources at the facility so as to avoid impacting the surrounding environment and the public at large.

This Odour Management Plan (OMP) will seek to outline measures to be employed, as required, to prevent any odour problems emanating from the site, predominantly in relation to the storage of biodegradable waste. It will also include identification of potential sources of risk, mitigation measures employed and how Foyle Meats will respond to complaints etc.

This Odour Management Plan has been prepared in accordance with guidance on best practice, and in particular the following specific regulations and guidance (where applicable) contained in:

- Environmental Permitting (England and Wales) Regulations 2016;
- Environmental Permitting Core Guidance (DEFRA, Updated March 2013);
- General Environment Agency Guidance;
- H4 Odour Management How to comply with your environmental permit.

This Odour Management Plan is a live document and as such will be subject to regular review and revision. In all circumstances, revisions will be submitted to the Environment Agency (EA) for review and approval.

### 1.2 Guidance

### **Control and Monitor Emissions for Your Environmental Permit - Odour**

You must prevent or, where that is not possible, minimise odour if you have a waste, mining waste or installation permit. To do this you must use all appropriate measures, normally including:

- restricting raw materials that are likely to cause odour, like putrescible or already putrid biodegradable waste.
- minimising quantities and storage times for odorous or potentially odorous materials
- managing materials and processes in ways which minimise the production of odorous chemicals.
- working within the effective operational capacity of your site
- providing effective containment and abatement for odorous materials and activities

You must respond effectively and proportionately to any process monitoring.

### <u>Control and Monitor Emissions for Your Environmental Permit: Odour management</u> <u>plan</u>

You must write an odour management plan that explains how you will prevent or, where that is not possible, minimise odour if your site causes odour pollution, or if you carry out any of the following activities:

- landfilling biodegradable waste
- household, commercial and industrial waste transfer station
- composting in open windrows
- composting in vessels
- mechanical biological treatment
- sewage sludge treatment
- clinical waste treatment
- animal carcass incineration

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- pet cemetery
- mobile plant for landspreading, the treatment of land for land reclamation, restoration or improvement and landspreading of sewage sludge
- anaerobic digestion
- mobile plant for the treatment of waste soils and contaminated material, substances or products manufacture, use or recovery of compounds containing sulphur, ammonia, amines and amides, aromatic compounds, styrene, pyridine and esters
- abattoirs and renderers
- food production involving any form of cooking or heating and brewing
- refineries
- distilling or heating tar or bitumen

If you're applying for a bespoke permit for one of these activities you will need to submit your plan with your application.

#### How to comply with your environmental permit: Getting the Basics Right (EPR 1.00)

If there is a significant possibility that odour from your activities may cause annoyance/nuisance beyond your site boundary, you should have a written odour management plan. This should show what the sources and risk to receptors are, the measures you will employ and how you will respond to prevent or minimise the odour. The easiest way to do this is to follow the risk assessment for odour in Part 1 of the H1 Environmental Risk Assessment (see Annex 1) and describe how you will manage the risks. You may need to update this plan with further measures as necessary to ensure that the condition continues to be met. Activities for which odour is a key issue and should always have an odour management plan, are listed in Annex 2.

You do not have the right to cause odours outside your site due to your activities. Your neighbours do have a right to expect that your activities will not detract from their quality of life. They have a right to expect that their environment will be free from odours caused by your activities either on a continuous basis or at frequent intervals.

While there may be no problem at the moment, if circumstances change, for example development occurs around your site such that your activities then affect people outside the site, you will have to take action to prevent or minimise those problems.

Your activities may cause smells that may cause annoyance to people beyond your site boundary. It is up to you to prevent such emissions, or where that is not practical, to minimise them using appropriate measures. Unless already specified in your permit, the measures you decide to use will depend on your industry sector/regime and your individual circumstances. There are a number of options available to control odour. The EA will expect you to balance the costs and environmental benefits. The measures you decide to use will have to meet the objective of the rule.

Appropriate measures to reduce odour include:

- Choosing raw materials that are less likely to cause odour problems.
- Cutting the quantities and storage times of biodegradable materials.
- Avoiding conditions which encourage anaerobic breakdown.
- Enclosing smelly materials in a building or vessels and extracting fumes with equipment such as scrubbers or bio-filters.

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- Reducing temperatures and exposed surface areas.
- Reducing or stopping your activities that are causing the odour until either the circumstances have changed or other appropriate measures have been put in place to allow the operations to re-commence without nuisance.

Further measures specific to your sector may be found in the relevant activity-specific guidance note (see Annex 1).

### How to comply with your environmental permit Additional guidance for: The Red Meat Processing (Cattle, Sheep and Pigs) Sector (EPR 6.12)

In *How to comply with your environmental permit: Getting the basics right* (GTBR) the EA described the standards and measures that they expect businesses to take in order to control the risk of pollution from the most frequent situations in the waste management and process industries.

This sector guidance note is one of a series of additional guidance for Part A(1) activities listed in Schedule 1 of the Environmental Permitting Regulations (the Regulations). The EA expect you to use the standards and measures in this note in addition to those in GTBR to meet the objectives in your permit.

### How to comply with your environmental permit: H4 Odour Management

The Odour Management Plan (OMP) has been prepared in accordance with the H4 – Horizontal Odour Guidance document.

The H4 guidance provides a regulatory framework by which a permitting officer can ensure compliance by the provision of specific conditions. The guidance acknowledges that assessment and control of odour can be difficult due to dispersal and the episodic nature of odour events.

The Environment Agency (EA) published this guidance document H4 Odour Management – How to comply with your environmental permit in 2011, which is part of a suite of guidance notes issues by the EA and is designed to help both holders and potential holders of permits understand how to apply for, vary and comply with their permit. This document supersedes the previous draft H4 guidance and the EA's internal guidance on the management of odour at waste facilities.

The current form of odour condition used in environmental permits usually consists of two elements:

- the odour boundary condition, which specifies the outcome which the operator must achieve (i.e. no pollution beyond the site boundary); and
- a condition requiring compliance with an OMP (where activities are considered likely to give rise to odour)

There may also be specific operational conditions relating to odour control, which require certain techniques or specify emission limits.

This document provides a summary of the physical and management controls that will be employed to minimise odour release. It provides a site-specific assessment of the potential sources of odour, the pathways odour can take from the site and the receptors it is likely to

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impact. The potential release points of odour are identified and the management systems to prevent and control fugitive odour emissions. Monitoring and reporting systems are described in addition to emergency contingency plans.

which indicates a problem, or reports from the community of odour pollution.

### **1.3** Site Location

Foyle Food Group operates a slaughtering facility on a 24,000 M<sup>2</sup> site located at Six Hills, Melton Mowbray, LE14 3PD, United Kingdom

The site is located approximately 10.5 km west-northwest of Melton Mowbray, 17.5 km north to north-east of Leicester City and 20.5 km south to south-east of Nottingham City.

#### **1.4** Site Processes/Activities

The site currently consists of a large cattle slaughtering processing facility.

Activities at the site include the slaughter of cattle and the dressing, chilling and quartering of beef carcasses, the harvesting of offal, cod fat and the packing of beef offal and cod fat into vacuum pouches and lined cardboard boxes.

The company's customer base is split between commercial and retail. The site produces primal frozen quarters which are dispatched to other Foyle Foods site for further processing. Boning is not carried out at the site.

The site employs approximately 77 staff, including office and admin personnel.

The actual tonnage of finished product produced in 2022 was 6,948 tonnes, which is an average of 134 tonnes per week.

The plant operates production shifts on a five-day basis between 07:00-15:00, while cleaning occurs during evening & night-time hours. Weekend work may occur at peak production times and the engineering team provide 24/7 cover.

No effluent treatment occurs at the site. Effluent in stored in the Effluent Storage Sump and the Truck-Wash Sump, which are emptied daily by road tanker.

All water is sourced from a main supply, while the site contains a single hot water boiler.

All waste is segregated on-site for removal to offsite waste facilities as appropriate.

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#### **Listed Actions:**

• Environmental Permitting (England and Wales) Regulations 2016, SCHEDULE 1: Activities, Installations and Mobile Plant, PART 2: Activities,

**CHAPTER 6: Other Activities** 

Section 6.8: Part A(1): (b): '*Slaughtering animals at a plant with a carcass production capacity of more than 50 tonnes per day.*'

• Environmental Permitting (England and Wales) Regulations 2016, SCHEDULE 1: Activities, Installations and Mobile Plant, PART 2: Activities,

CHAPTER 6: Other Activities

Section 6.8: Part A(1): (d): (i): 'Only animal raw materials (other than milk only) with a finished production capacity greater than 75 tonnes per day.'

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The manufacturing process can be divided into the following:

#### <u>Lairage</u>

Cattle scheduled for slaughter are delivered to the site by road. The animals are placed in livestock holding pens in the lairage.

#### <u>Slaughter Lines</u>

Cattle are stunned and hung by their back legs on an overhead rail system. The cattle then have the main arteries in their throats cut by trained slaughter operatives.

Blood from slaughtered animals is collected by means of a dedicated collection system. Blood is then transferred from the blood trough to the blood storage tank.

#### Head, Horn and Hoof Removal

Heads, horns and hooves are manually removed from cattle carcass using hydraulically operated cropping shears and are sent to Specified Risk Material (SRM) skips for staining with blue dye.

#### <u>Hide Removal</u>

After bleeding, cattle have the mask and ears manually removed. After removal, the mask, which is classed as SRM, is stored in dedicated storage areas and stained with blue dye before disposal.

#### Trimming and Evisceration

Green offal (lungs, trachea) are collected and taken for further processing at off-site facilities. Gut (paunch) contents is also removed at this stage and stored for collection by a contractor for land-spreading. The respiratory, pulmonary and digestive organs are then removed and sent for disposal or further processing as required. Red offal (heart, liver and kidneys) are removed and sent to the Red Offal processing area.

#### **Red Offal Further Processing**

Further to being initially chilled, red offal is trimmed, packed, labelled and weighed and sent to the chill for storage.

#### Carcass Quartering

The cattle carcasses are split along the spine using purpose designed electric saws. The spinal cord is then removed from the carcass using a vacuum suction system. Each side is cut, resulting in beef quarters.

### <u>Chilling</u>

The beef quarters are placed in chilled storage prior to deboning.

#### <u>De-boning</u>

Beef quarters are de-boned, with bones directed to the designated bones trailer. The product would then be weighed and inspected, before being packaged and palletised.

#### <u>Dispatch</u>

An off-site contract cold storage facility is used, which is approved at group level, and BRC certificated.

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#### **1.5** Sensitive Receptors

Odour sensitive receptors are defined as receptors, which are potentially sensitive to odour.

An Odour Sensitive Receptors can include:

- factories and other businesses
- fields and allotments used to grow food
- public footpaths
- residential homes,
- playing fields and playgrounds
- schools, hospitals and other public buildings
- conservation and habitats protected areas and areas of scientific interest

The northern and eastern site boundaries are bounded by green-field, which contains an operational farmstead.

The northeast of the site is bounded by a green-field, beyond which is the Six Hills Leisure facility and golf course. At its closest point, this golf course comes within c.125m of the site boundary.

The west boundary is bounded by two industrial units and associated carpark, beyond which is the A46 road.

The south of the site is mostly bounded by a local access roadway into the adjacent industrial units and partially bounded by the B676 road.

The closest residential properties to the site are located on the A46 Road, *c*.220m south-west of the site boundary.

Surround the site there are boundary odour sensitive receptors, which represent the closest possible receptors with the potential to be populated at any one time.

There are no Special Area of Conservation (SAC) within a 10km radius of the site. The closest is River Mease SAC, which is located c.29.25km West-Southwest of the site boundary.

There are no Special Protection Areas (SPA) within a 10km radius of the site. The closest is Rutland Water SPA, which is located *c*.25.95km East-Southeast of the site boundary.

There are no National Nature Reserves (NNR) within a 10km radius of the site. The closest is Charnwood Lodge NNR, which is located c.17.94km West-Southwest of the site boundary.

These sites are considered outside of the zone of influence regarding odour.

The Twenty Acre Piece SSSI is located c.160m west of the site boundary. as can be seen in Section 1.6, wind from the east only occurs for 1.35% of yearly hours, which would not be considered the prevailing wind direction for the area. Therefore, odour dispersion from the site in the directions of the SSSI would be infrequent.

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The closest residential odour sensitive receptors detailed below and are mapped in Appendix A.1.

Dof	Grid	Ref.	Location Type	Location		
Kel.	X	Y	Location Type	Location		
OSR1	465530	321302		Residential property located approx. 840m east-northeast of the site boundary.		
OSR2	464396	320752	Residential Odour	Residential property located approx. 225m southwest of the site boundary.		
OSR3	464286	320616	Sensitive Receptor	Residential property located approx. 400m southwest of the site boundary		
OSR4	464375	320952		Residential complex located approx. 175m west of the site boundary		

 Table 1.5: Location of Odour Sensitive Receptors

Grid Ref Source: https://gridreferencefinder.com/

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### **1.6** Meteorological Conditions

The dispersion of odour may be affected by the local weather conditions, with particular reference to wind direction and speed. The closest meteorological station is East Midlands (EGNX) within the East Midlands Airport, located 20km west-north-west of the Foyle site. Data from RenSMART Wind data archive has been utilised to characterise the meteorological conditions which are likely to be experienced on site.

As can be seen from the wind distribution table and wind-rose diagram below, the prevailing wind direction is from the south, which occurs for 21.1% of the yearly hours.

It can also be seen that the majority of wind is from the south to west directions (S, SSW, SW, WSW & W), which when combined occurs for 74.4% of the yearly hours.

Wind Direction											
Dir	Ν	NNE	NE	ENE		E	ES	E	SE		SSE
%	3.51	3.00	2.54	0.90	1.	.35 1.12		2	2.13		5.47
Dir	S	SSW	SW	WSW		W WN		WNW			NNW
%	21.10	16.91	14.49	12.54	12.54 9.36		1.69		1.34		2.56
Wind Speed											
Speed	0-1	1-2	2-3	3-4	Ļ	4	-5		5-6		6-7
m/s	2.21	8.13	13.54	1 16.4	-0	16	.64	1	4.14		10.38
Speed	7-8	8-9	9-10	10-1	1	11	-12	1	2-13		13-14
m/s	7.14	4.65	2.88	1.73	8	0.	.98	(	).58		0.31
Speed	14-15	15-16	16-17	7 17-1	8	18	-19	1	9-20		>20
m/s	0.12	0.07	0.03	0.0	1	0.	01	(	0.00		0.01

Table 1.6.1: East Midlands (EGNX) - Wind Distribution



Figure 1.6.2: East Midlands (EGNX) - Wind Rose Diagram

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### 2.0 ODOUR SOURCE INVENTORY

#### 2.1 Odour Sources

The main sources of potential odour associated with the site is wastes, which are organic in nature and have the potential to biodegrade over a relatively short timeframe, and the effluent storage.

Other waste stored on site include plastic (recycled), cardboard (recycled), metals (recycled), wood pallets, fluorescent tubes, waste solvent containers and waste engineering oil. These wastes are considered negligible in terms of odour generating potential.

As per the site's Register of Environmental Aspects and the site-wide audit, potential on-site sources of nuisance odours include:

- Effluent Storage.
- Waste Disposal (animal by-product, blood, general waste etc.)
- Contractors (boilers, refrigeration, drains waste etc.)

In certain facilities, drainage and bad housekeeping can be a significant source of odour. The build-up of waste material on rough concrete surfaces can lead to significant emissions especially during warmer summer months. Great care should be taken to ensure the elimination of unscheduled emissions such as these through good housekeeping and management.

Fugitive odour emissions are generally associated with:

- Yard areas used to store waste containers.
- Blocked waste water pipes, gullies and drains.
- Blood storage tank malfunction.
- Refrigerant leak.
- Natural gas leak.
- Spillage.

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#### 2.2 Activities Involving Odour Sources

The normal activities involving the sources of odour include;

- Waste Handling and Storage
- Effluent Storage

All production is carried out internally. This consist of the following processing techniques and unit operations as listed in the Best Available Techniques in the Food, Drink and Milk Industries (August 2006 & January 2017):

- Materials handling and storage (A.1),
- Cutting, slicing, chopping, mincing, pulping and pressing (B.1),
- Cooling, chilling and cold stabilisation (G.1),
- Packing and filling (H.1),

These processing techniques or unit operations are used in the processing of meat and thus do not create offensive odours.

Waste storage and consequent ageing of the waste material is considered the activity most likely to represent the largest risk in terms of odour generation. Waste of all types will not be stored on site for durations exceeding 1 week.

### 2.3 Accidents/Incidents Involving Odour Sources

Accidents and their consequences should be considered for a range of potential risks from the overall operation.

With regards to accidents/incidents/events involving sources of odour, these could be related by the follow methods:

- Spillages
- Loss of Containment.
- Leakage

All vehicles removing waste from the site will be fully enclosed and visual inspections are carried out.

### 2.4 Location of Potentially Odorous Activities

As alluded to throughout this document, it can be considered that the handling & storage of waste and effluent treatment has the highest potential to be the cause of unacceptable fugitive odorous emissions.

All Potential Fugitive Air Emission Points Sources are mapped in Appendix B.

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#### 2.5 Receptors

•		
Receptors	<ul><li>Describe the type of receptor and give an approximation of its extent/size/population, as appropriate.</li><li>On a large installation, different receptors may be affected by different sources.</li><li>Describe the location or indicate on a plan of the locality (show too the installation</li></ul>	See Appendix A for Odour Sensitive Receptor Map.
	boundary where possible).	
Have any assessments of environmental impact been undertaken?	i.e. any assessments which look at the IMPACT on the receptors – i.e. not at source, although they may use source-based data as input. Such assessment could include dispersion modelling, population panels, attitude surveys, field observers, simplified olfactometry (sniff testing) or any ambient air monitoring.	See Section 1.6 above for summary of Odour Assessment carried out in 2021 in support of an Environmental Permit
	When were these undertaken and for what reason? What were the findings in terms of impact	Application
Is any routine monitoring undertaken?	Is additional monitoring undertaken (i.e. not relating to the previous row) which relates to impact. This might include regular "sniff testing" at the boundary or some form of ambient air monitoring. What form how often and what are typical results?	Odour is included in the facilities Daily Environmental Checksheet.
Overview of complaints received	Have complaints ever been received? How many, when, and how many separate incidents or sources/receptors do these relate to? What is/was the cause and has it been rectified? If not already covered elsewhere in the application, the Operator should confirm that he has a procedure in place for dealing with complaints.	The site had not received any complaints with regards to odour since production started at this location.
Have any limits or other condition(s) been applied?	Have any conditions or limits been imposed by any regulatory Authority which relate to sensitive receptors or to other locations which represent the effect on receptors, e.g. boundary fence?	No limits or other conditions have been applied with regard to odour at the facility.

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### 2.6 Potential Odour Sources

Table 2.6: Potential Odd	our Sources
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I.D	Source	Risk/Hazard	Impacted Receptor	
	-	Areas		
A1	Lairage/Intake Area	Potential for spillage, which may cause odour.	Human Beings	
A2	Dispatch Area	Potential for spillage, which may cause odour.	Human Beings	
A3	Carpark Area	None	None	
A4	By-Product Handling Area	Potential for spillage, which may cause odour.	Human Beings	
A5	Recycling Storage Area	None	None	
A6	General Waste Storage Areas	Potential for build-up of organic material as a result of overfilling, which may cause an odour.	Human Beings	
A7	Maintenance Workshop	Potential for spillage, which may cause odour.	Human Beings	
A8	Chilled Storage	Potential for leak, which may cause odour.	Human Beings	
A9	Effluent Storage	Potential for spillage, which may cause odour.	Human Beings	
		Equipment		
E1	Boiler	Emissions of CO, NOx or particulate matter.	Human Beings	
E2	Condensers	None	None	
E3	Refrigeration Plant	Potential for leak of refrigerant, which may cause an odour.	Human Beings	
E4	Vac-Pack Compressors	None	None	
E5	Compressed Air Units	None	None	
E6	Forklift Operations	Emissions of CO, NOx or particulate matter.	Human Beings	
E7	General Waste Compactor	Potential for build-up of organic material	Human Beings	
		Waste		
W1	General Waste	Potential for build-up if not removed regularly, which may cause an odour. Potential for build-up of organic material	Human Beings	
W2	Recyclable Plastic	None	None	
W3	Recyclable Wood	None	None	

I.D	Source	Risk/Hazard	Impacted Receptor
W4	Recyclable Metal	None	None
W5	By-Product Waste	Potential for organic decay if not collected regularly, which may cause an odour. Potential for build-up of organic material	Human Beings
W6	Effluent Storage	Potential for spillage.	Human Beings
W7	Blood Storage	Potential for spillage.	Human Beings
	-	Drainage	
D1	Stormwater Drains	Potential for blockage, which could cause a build- up of material which could cause an odour.	Human Beings
D2	Process & foul line	Potential for blockage, which could cause a build- up of material which could cause an odour.	Human Beings

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### **3.0 ASSESSMENT OF RISKS**

### 3.1 Methodology

The risks identified in Table 2.6 were assessed against the risk classification tables (RCT) in Tables 3.1 and 3.2. The risk classification tables were designed to reflect the levels of risk appropriate to the Foyle facility.

Ratings taken from a risk classification table were applied to the consequence and likelihood of occurrence of each risk. A risk score was calculated for each risk using the ratings. The risks were then ranked and compared based on the risk scores.

The risks were placed in a risk matrix to illustrate the ranking of each risk, and to allow the risks to be quantified and visually prioritised. The risk matrix is a particularly useful tool for tracking changes in risk levels over time.

#### 3.2 Risk Classification

The Risk Classification Tables (RCT) has been designed to reflect the critical levels of risk appropriate to the Foyle – Melton Mowbray site. The RCT provides likelihood of occurrence and environmental consequence for the ranking of risks. These are included in table 3.3 below.

Deting	Likelihood				
Kating	Category	Description			
1	Very Low	Very low chance (0-5%) of hazard occurring in 30 yr period			
2	Low	Low chance (5-10%) of hazard occurring in 30 yr period			
3	Medium	Medium chance (10-20%) of hazard occurring in 30 yr period			
4	High	High chance (20-50%) of hazard occurring in 30 yr period			
5	Very High	Very high chance (>50%) of hazard occurring in 30 yr period			

**Table 3.1**: Risk Classification Table (Likelihood)

Table 3.2: Ris	sk Classification	Table (	(Consequence	•)
	on onaboliteation	I GOIO	( Combequence	· .

Deting	Consequence					
Kating	Category	Description				
1	Very Low	No impact or negligible change to the environment				
2	Low	Minor / localised impact or nuisance				
3	Medium	Moderate impact to the environment				
4	High	Severe impact to the environment				
5	Very High	Massive impact to a large area, irreversible in the medium term				

FOYLE, SIX HILLS, MELTON MOWBRAY, UK

### 3.3 Risk Register

 Table 3.3: Risk Register – Classified by Risk Score

Risk ID	Source/Process	Location	Odour Likelihood Rating	Basis Of Likelihood	Consequence Rating	Basis Of Consequence	Risk Score
				Areas			
A1	Lairage/ Intake Area	Eastern Face of Facility	2	Deliveries are supervised by site personnel trained in spillage response. Cattle holding area was continually washed down daily.	3	Potential odourous material at this location is cattle manure, which is washed into the slatted tank below the lairage as required.	6
A2	Dispatch Area	Rear of Facility	1	Trailer loading is supervised by site personnel trained in spillage response. All loading occurs internally. Materials are transported using forklifts operated by trained personal.	2	All materials being handled are frozen and in sealed containers within wrapped pallets.	2
A3	Carpark Area	North- western Yard	1	There are no chemicals or waste within this area.	1	None.	1
A4	By-Product Handling Area	Rear yard	3	Materials are transported using forklifts operated by trained personal.	3	Spillage may occur as a result of operator error.	9

Risk ID	Source/Process	Location	Odour Likelihood Rating	Basis Of Likelihood	Consequence Rating	Basis Of Consequence	Risk Score
				Area is washed down regularly to prevent the build-up of organic material.		Drainage is directed to the nearby effluent storage tank.	
A5	Recycling Storage Area	Rear of Facility	1	This type of waste is odourless.	1	None	1
A6	General Waste Storage Areas	Rear of Facility	2	Disposal of Waste procedure (OP04) in place. Site inspection procedure in place. General waste compact is a sealed unit. General waste is collected weekly.	3	If organic material (waste product & canteen waste) did build-up, it would decay creating an odour, especially in warm conditions.	6
A7	Maintenance Workshop	Rear of Facility	1	All materials are stored on bunds or within bunded fireproof cabinets. OP09 – Bund Inspection procedure in place. Spill kit kept in vicinity of workshop.	2	Potential for minor spillage.	2

Risk ID	Source/Process	Location	Odour Likelihood Rating	Basis Of Likelihood	Consequence Rating	Basis Of Consequence	Risk Score
A8	Chilled Storage	Site wide	1	There is a chance of this occurring in a 30-year period. Leaks are usually due to manifold breaks in the chill or refrigeration rooms. Preventative maintenance and leak test plan in place. Equipment is maintained regularly. Refrigerant R404A contains a faint odour under all conditions	2	Refrigerant may be detected for a short period before alarm sound from the leak detection system.	2
A9	Effluent Storage	By-product Handling Area	2	Overflowing of tank can lead to large above- ground surface area of material being, with odour being easily dispersed by wind conditions. Effluent storage has 1- day retention time.	3	By-product Handling Area is manned and monitored at all times. Any issues would be identified and remedied within a short time frame.	6

Risk ID	Source/Process	Location	Odour Likelihood Rating	Basis Of Likelihood	Consequence Rating	<b>Basis Of Consequence</b>	Risk Score
				Effluent storage tank is emptied daily.			
	<u></u>	<u>I</u>	<u>Į</u>	Equipment	<u>I</u>	<u></u>	<u> </u>
E1	Boiler	Boiler Room.	2	<ul> <li>Monitoring of emission values on an annual basis during maintenance.</li> <li>Boiler stack emissions are visually assessed daily for black smoke.</li> <li>Equipment is maintained regularly by contractor.</li> <li>NOx, SOx and particulate matter levels are low due to boilers fuelled by natural gas.</li> <li>Boiler is small with a thermal input of 750kW.</li> </ul>	2	Due to the height of the stacks, odour may travel beyond the site boundary and also disperse at a greater rate.	4
E2	Condensers	Site Wide	2	Very low likelihood as emission is steam. Equipment is maintained regularly by contractor.	2	Potential for odour detection outside of the site boundary in the event of a malfunction.	4

Risk ID	Source/Process	Location	Odour Likelihood Rating	Basis Of Likelihood	Consequence Rating	Basis Of Consequence	Risk Score
			Refrigerant R404A contains a faint odour under all conditions.				
				Leak detection system in place.			
E3	Refrigeration Plant	Site Wide	2	<ul> <li>Very low likelihood as emission is vented steam.</li> <li>Equipment is maintained regularly by contractor.</li> <li>Refrigerant R404A contains a faint odour under all conditions</li> <li>Leak detection system in place.</li> </ul>		Potential for odour detection outside of the site boundary in the event of a malfunction.	4
E4	Vac-Pack Compressors Yard 1		This equipment does not create an emission containing odour. Equipment is maintained regularly by Busch (uk).	1	None	1	
E5	Compressed Air Units	Rear of Facility	1	This equipment does not create an emission containing odour and is electrically powered.	1	None	1

Risk ID	Source/Process	Location	Odour Likelihood Rating	Basis Of Likelihood	Consequence Rating	Basis Of Consequence	Risk Score
				Equipment is maintained regularly by contractor.			
E6	Forklift Operations	clift ations Site wide 1		Forklifts are maintained on a regular basis. Operators inspect the forklifts for emissions continuously during use.	2	Slight increase in fume type odour within the site.	2
Е7	General Waste Compactor	Rear of Facility	2	Disposal of Waste procedure (OP04) in place. Site inspection procedure in place. General waste compact is a sealed unit. General waste is collected weekly.	3	If organic material (waste product & canteen waste) did build-up, it would decay creating an odour, especially in warm conditions.	6
	-	-	-	Waste	-	-	
W1	General Waste	General Waste Area	2	OP04-Disposal of Waste Procedure in place. General waste compact is a sealed unit. Waste is collected on a weekly basis.	3	If the waste is not collected or the bins are over filled, odour may be generated.	6

Risk ID	Source/Process	Location	Odour Likelihood Rating	Basis Of Likelihood	Consequence Rating	Basis Of Consequence	Risk Score
W2	Recyclable Plastic	Recycling Storage Area	1	Very low likelihood as this waste is odourless under all conditions. OP04-Disposal of Waste Procedure in place.	1	None	1
W3	Recyclable Wood	Recycling Storage Area	1	Very low likelihood as this waste is odourless under all conditions. OP04-Disposal of Waste Procedure in place.	1	None	1
W4	Recyclable Metal	Recycling Storage Area	1	Very low likelihood as this waste is odourless under all conditions. OP04-Disposal of Waste Procedure in place.	1	None	1
W5	By-Product Waste	By-Product Handling Area	3	Storage trailer are removed off-site daily. Trailers are covered during transport. Licenced waste contractors are used for the transport of waste.	3	If not removed from site regularly or stored incorrectly, decay may create an odour, especially in warm conditions.	9

Risk ID	Source/Process	Location	Odour Likelihood Rating	Basis Of Likelihood	Consequence Rating	Basis Of Consequence	Risk Score
				Local drainage is directed to the effluent storage tank. OP04-Disposal of Waste Procedure in place.			
W6	Effluent Storage	By-Product Handling Area	2	Procedure in place.Overflowing of tank can lead to large above- ground surface area of material being, with odour being easily dispersed by wind conditions.2Effluent storage has 1- day retention time.Effluent storage tank is emptied daily.		By-product Handling Area is manned and monitored at all times. Any issues would be identified and remedied within a short time frame.	6
W7	Blood Storage	Rear of Facility	2	All blood in stored in sealed stainless-steel tanks. All tanks are regularly inspected.	2	Potential for odour detection outside of the site boundary in the event of a malfunction or spillage	4

Risk ID	Source/Process	Location	Odour Likelihood Rating	Basis Of Likelihood	Consequence Rating	Basis Of Consequence	Risk Score
				Local drainage is directed to the effluent storage tank.			
				OP11-Spillage Response procedure in place.			
				Drainage Network			
D1	Stormwater Drains	Site Wide	1	Not tested as part of Environmental management system. Concrete underground pipes, likelihood of leaking over 30-year period is minimal.	2	Stormwater drains contain no material that can create odour.	2
D2	Process & foul line	Site Wide	2	Drainage pipes are cleaned quarterly by external contractor. All internal drains contain screens/ catchpots designed to catch large particles. Dry cleaning is also carried out. Manholes on site are visually inspected.	2	All line are either sealed or internal.	4

FOYLE MEATS, SIX HILLS, MELTON MOWBRAY, UK

### 3.4 Indicative BAT

Table 3.4: How To Comply With Your Environmental Permit Additional Guidance For: The Red Meat Processing Sector (EPR 6.12):

BAT GUIDANCE	FACILITY COMPLIANCE	ACTION GOING FORWARD					
3.0 EMISSIONS AND MONITORING							
3.4 Odour							
In addition to good housekeeping, the key factors in controllin	ng odour from the storage of blood / by-product	ts are exposure time and temperature.					
For example the storage of solids below 5°C and blood below	v 10°C is reported to reduce odour problems.						
In addition to the requirements in "Getting the basics right",	the following should be used where appropri-	ate in this sector:					
<ol> <li>Minimise manure production by controlling feeding rate prior to transportation of animals to site</li> </ol>	Farmers are informed and aware of the policy to limit feeding of animals before delivery. Animal feed is restricted to maintenance levels in the week leading up to slaughter.						
2. Storage of putrescible waste /by-products/ in sealed containers	All CAT1 & CAT3 waste is stored in covered watertight trailers before being removed off-site daily.						
3. Frequent clean-down of waste containers to prevent build-up of malodorous material	All waste storage contains are cleaned- down daily.						
4. Frequent e.g. daily removal off site of blood/ by- products	CAT1, CAT3 and blood is removed off- site daily.						
5. Refrigeration of blood/ animal by-products / putrescible material if extended on-site storage is carried out.	The blood storage tanks are refrigerated using a Packo Cooling system and a TAE- evo Chiller Unit.						
<ul> <li>6. Enclosure of potentially odorous operations e.g.</li> <li>macerator equipment used to chop and wash inedible offal</li> <li>effluent treatment plant</li> </ul>	<ul><li>All offal processing occurs internally.</li><li>No ETP on-site.</li></ul>	Site to investigate the feasibility of installing a primary effluent treatment plant.					
7. Install odour abatement e.g. activated carbon filter on the blood storage tank vents.	The blood tank does not contain a vent as the levels stored on-site are relatively low,	If odour complaints begin to arise, investigate the practicality of					

BAT GUIDANCE	FACILITY COMPLIANCE	ACTION GOING FORWARD
	the blood is prevented from putrefying through refrigeration and the tanks are emptied daily.	installing odour abatement on the blood tank vents.
8. Back vent road tankers through the odour abatement unit during blood collection	N/A	
9. Use of screens/catchpots to prevent meat scraps / fats from entering drainage system	All internal drains contain screens/ catchpots designed to catch large particles.	
10. Ensure that effluent treatment plant is adequately maintained. Where present, aeration tanks should be kept aerated and mixed at all times except where maintenance necessitates shut-down of the aeration system. Implement alternative operational arrangements during shut-down to avoid odour nuisance.	No ETP on-site.	Site to investigate the feasibility of installing a primary effluent treatment plant.
11. Control of hydraulic retention times and desludging in effluent systems to prevent malodours.	No ETP on-site.	Site to investigate the feasibility of installing a primary effluent treatment plant.

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### 3.5 Risk Matrix

The Risk Matrix has been developed to allow the risks to be easily displayed and prioritised. The consequence and likelihood ratings are used in the matrix; with the level of consequence forming the x-axis and the likelihood forming the y-axis. This matrix provides a visual tool for regular risk reviews and the success of mitigation can be easily identified. The risk matrix is displayed in Table 3.5. The risks have been colour coded in the matrix to provide a broad indication of the critical nature of each risk. The colour code is as follows:

- Red These are considered to be high-level risks requiring priority attention. These risks have the potential to be catastrophic and as such should be addressed as a priority.
- Amber Yellow These are medium to high-level risks requiring action, but are not as critical as a red coded risk.
- Green These are lowest-level risks and indicate a need for continuing awareness and monitoring on a regular basis. Whilst they are currently low or minor risks, some have the potential to increase to medium or even high-level risks and must therefore be regularly monitored. If cost effective mitigation can be carried out to reduce/mitigate the risk even further this should be pursued.

	V. High	5					
	High	4					
	Medium	3			A4, W5.		
kelihood	Low	2		E1, E2, E3, W7, D2.	A1, A6, A9, E7, W1, W6.		
Lil	V. Low	1	A3, A5, E4, E5, W2, W3, W4.	A2, A7, A8, E6, D1.			
			Trivial	Minor	Moderate	Major	Massive
			1	2	3	4	5
				(	Consequence	2	

Table 3.5: Risk Matrix – Current Risk Status

The risk matrix indicates that there are no existing risks in the red or yellow zones requiring priority attention.

All risks are located in the green zone, indicating a need for continuing awareness and monitoring on a regular basis. Assessment of the green zone risks during the preparation of the workshop has indicated that many of these risks can be reduced through the implementation of mitigation or management measures. These measures should be adopted where considered cost-effective to further reduce the risks.

FOYLE MEATS, SIX HILLS, MELTON MOWBRAY, UK

#### **3.6** Appropriate Odour Mitigation Controls

A variety of wastes are stored on-site which include:

- Plastic (recycles),
- Cardboard (recycles),
- Metals (recycles),
- Wood Pallets

- WasBLoodte Solvent Containers,
- General Waste,
- Effluent
- Animal By-Product,

Wastes with the potential to generate odour are limited to by-production waste, general waste and effluent water.

By-product waste is stored within watertight trailers, which are covered upon removal from site.

General waste consisting of mainly plastic personal protective equipment, hairnets, canteen waste and soiled packaging are put into designated covered bins before being placed into the waste compactor.

Wastes are transported from the site by road. Records are weight based, which is attained by weighbridge. Once checked in at the site office, waste delivery vehicles are directed to the appropriate part of the site and loaded.

The control of potential fugitive emissions is achieved largely through implementation of good management practices and housekeeping.

The control of odour as a result of accidents/incident/events:

**Spillages**: Spill kits and absorbent materials are kept on site in various locations and will be used in the event of a spillage.

**Loss of Containment**: All hazardous and potentially odours materials are stored in designated areas and kept within bunds or bunded structures.

Leakage: All pipework is regularly inspected.

The following procedures are in place at Foyle – Melton Mowbray, which help to reduce the risk of odour:

- OP01 Operational Control Procedure
- OP04 Disposal of Waste
- OP05 Surfacewater Protection
- OP06 Contract Maintenance
- OP08 Receipt of Bulk Liquids
- OP09 Bund Inspection
- OP11 Spillage Response

FOYLE MEATS, SIX HILLS, MELTON MOWBRAY, UK

#### 4.0 MONITORING AND TRIGGER LEVELS

#### 4.1 Odour Monitoring

On-site ambient monitoring is undertaken in accordance with the guidance set out in EA Horizontal Guidance document 'H4 Odour Management – How to Comply with your Environmental Permit'.

This monitoring is primarily undertaken at the boundary of the site, with monitoring beyond the site boundary in response to the identification of potential significant odours within the site (i.e. breach of trigger levels). Off-site monitoring will also take place in receipt of a complaint.

All monitoring is carried out in cognisance of the prevailing weather conditions.

Monitoring comprises of weekly olfactory monitoring (i.e. 'sniff' tests) with monitoring record sheets completed and filed accordingly. Any odour emissions noted results in the implementation of the Odour Management Plan protocols detailed herein.

Any complaints received by the facility in relation to odour will be fully investigated in accordance with site's Quality Management System (QMS) and is detailed in the following sections. The resultant actions will be recorded in the Site Diary/Daily Log and with the Environmental Agency.

Further details of odour monitoring undertaken are provided within the following paragraphs.

#### Meteorological Conditions

Meteorological forecasts and weather conditions (including cloud cover, wind speed and wind direction) are monitored and recorded daily to enable potential odour problems to be predicted and necessary remedial actions to be implemented.

#### Regular Inspection/Olfactory Monitoring

Odour monitoring is undertaken in order to assess how successful the operational management and mitigating control measures are at the facility and to identify if necessary whether odour is causing a potential nuisance to ensure that appropriate remediation measures are adopted early.

Odours that may be attributable to the facility are those that are monitored for.

All facility personnel are responsible for reporting any odour problems as soon as reasonably possible to the Site Manager, Environmental Manager or the next level of management if not available.

Management ensures that weekly inspections are made of the facility and its perimeter in order to identify any sources of odour and to establish whether any odours that are attributed to site operations are discernible at the perimeter of the facility.

Monitoring is carried out by staff whom have had limited exposure to operational areas of the site to minimise the risk of inspection being carried out by staff that may be suffering from odour fatigue (i.e. accustomed/desensitised to the odour of concern).

#### FOYLE MEATS, SIX HILLS, MELTON MOWBRAY, UK

If significant odours are identified around the periphery of the site and trigger level are deemed to be exceeded, olfactory monitoring will be extended beyond the boundary to determine the extent of any impact and in consideration of the presence of a sensitive receptor and wind direction. The location of monitoring will also depend on the location of any complaints received by the facility with the monitoring results recorded in the site diary/daily log and with the Environmental Agency.

Olfactory monitoring or sniff testing is carried out in accordance with the recommendations detailed in the E.A. H4 guidance, including avoiding strong foods or drinks and strongly scented deodorisers or toiletries etc. for at least a half-hour prior to the monitoring. In addition, individuals suffering from a cold, sore throat or sinus problem that may impair their ability to detect odours. Likewise, the olfactory monitoring will be undertaken by employees that have not been desensitized by frequent and extensive exposure to on-site odours.

The designated personnel exit their vehicle and remain in that locality for a minimum of 5minutes whilst breathing normally. Any external activities that may contribute to odour generation in the surrounding area are also noted together with weather conditions (including wind direction and speed) and then an assessment of the intensity of the odour is made using the guide below.

### 4.2 Monitoring Trigger Levels

In the event that odour, that can be directly attributable to site activity, is detected above intensity ranking 2 (moderate odour) at the site boundary during the weekly olfactory monitoring, the management is informed immediately, and the approximate location and extent of the odour plume assessed, and site operations reviewed and potentially suspended.

### Odour Intensity Scale

- 0. No detectable odour
- 1. Faint Odour (barely detectable, need to stand still and inhale facing the wind)
- 2. Moderate Odour (easily detectable while walking and breathing normally, possibly offensive)
- 3. Strong Odour (bearable but offensive might make clothes / hair smell?)
- 4. Very Strong Odour (unbearable, difficult to remain in area affected by odour)

However, it is not simply the intensity that is assessed, as consideration are given to the FIDOR (Frequency of detection, Intensity, Duration, Offensiveness and Receptor sensitivity) principle such that for example a long duration lower intensity odour or a very offensive short duration event be assessed and investigated.

Template weekly 'Odour Investigation Field Sheets' are presented in Appendix C.

### FOYLE MEATS, SIX HILLS, MELTON MOWBRAY, UK

The following key describes the numerical values used to describe observation point sensitivity, wind strength, odour persistence, and odour intensity:

Note 1: Observation point Sensitivity							
1	Remote (no housing, commercial/industrial premises or public area within 500m of observation point)						
2	Low sensitivity (no observation point)	housing, commercial/i	ndustri	ial premises or public area within 100m of			
3	Moderate sensitivity of observation point	y (housing, commercial t)	l/indus	trial premises or public area within 100m			
4	High sensitivity (ho observation point)	using, commercial/ind	ustrial	premises or public area within area of			
5	Extra sensitive (con within area of obser	nplaints arising from re vation point)	sident	s, businesses and users of public areas			
		Note 2: Win	d Str	ength			
0	Calm	Smoke rises verticall	у				
1	Light air	Direction of wind is	shown	by smoke drift, but not wind-vanes.			
2	Light Breeze	Wind felt on face; lea	aves ru	stle, ordinary vane moved by wind.			
3	Gentle Breeze	Leaves and small twi	igs in c	constant motion.			
4	Moderate Breeze	Raises dust and loose	e paper	; small branches are moved.			
5	Fresh Breeze	eeze Small trees in leaf begin to sway.					
6	Strong Breeze	Large branches in motion; umbrellas used with difficulty against the wind.					
7	Near Gale	Whole trees in motio wind.	n; inco	onvenience felt when walking against			
8	Gale	Twigs break off trees	s; prog	ress generally impeded.			
9	Strong Gale	Slight structural dam	age oc	curs (chimney pots and slates removed).			
		Note 3: Weath	er Co	nditions			
	Precipita	tion		Temperature			
1	I	Dry	1	Cold			
2	Rained	Recently	2	Cool			
3	Dr	izzle	3	Warm			
4	Ra	ining	4	Hot			
5	Fo	oggy					
		Note 4: Odou	r Pers	sistence			
0	No Odour						
1	Intermittent (detected	ed intermittently during	g the pe	eriod of assessment)			
2	Persistent (detected	throughout the period	of asse	essment)			
		Note 5: Odor	ur Int	ensity			
0	No detectable odour	r <u> </u>					
1	Faint Odour (barely	detectable, need to sta	nd stil	l and inhale facing the wind)			
2	offensive)	asily detectable while v	valking	g and breathing normally, possibly			
3	Strong Odour (bear	able but offensive – mi	ght ma	ake clothes / hair smell?)			
4	Very Strong Odour	(unbearable, difficult t	o rema	in in area affected by odour)			

Wind direction is given as 'the direction from which wind blows' as per Agency Odour Investigation Field Record Sheets.

FOYLE MEATS, SIX HILLS, MELTON MOWBRAY, UK

#### 5.0 COMPLAINTS PROCEDURE

The site had not received any complaints with regards to odour since production started at this location.

In the event of the site receiving an official odour complaint, the following protocol will be followed.

#### 5.1 Complaints Process

Any complaints received by the facility from members of the public or via the regulatory bodies (including Environment Agency and Local Authority), will be recorded and investigated.

In order to assist in the investigation and determining the source of the odour as much information and detail about the complaint will be recorded, as per EMS-12: *Communications* 

#### 5.2 Means of Contact

The facility will be readily contactable to outside organisations and to members of the public. The site signage board (placed in a readily visible location) and security hut contain the necessary contact details for both the site operations and Environment Agency.

Any complaints received directly to the site will be notified to the Environment Agency as soon as is practicably possible.

Should an off-site issue arise, the complainant will have a readily available means of getting in touch with the relevant management personal.

All communication will be recorded as per EMS-ER05: Complaints Report Form

#### 5.3 Complaint Recording

Should a complaint be received, the following information will be recorded;

- Complaint details (including address of complainant wherever possible) and the location where odour is perceived;
- The time of occurrence, duration, persistence, offensiveness and a description of the odour.
- Weather conditions including atmospheric pressure, wind speed and wind direction;
- Results of latest olfactory monitoring carried out by facility personnel;
- Operational status of the facility (noting any abnormal conditions that may have caused the complaint);
- Details of the proposed corrective action, if required.

Appendix D contains a Template 'Odour Complaint Report Form'.

Records of complaints received will be kept in the appropriate file in the site office for inspection and review by both internal and external personnel.

### **ODOUR MANAGEMENT PLAN** Foyle Meats, Six Hills, Melton Mowbray, UK

#### 5.4 Complaint Screening

As part of each odour complaint received, these will be objectively assessed against the wider environment to ensure that the source of the emission is traced back to the correct source. As discussed earlier in this OMP, it is essential that the source is correctly identified in order that mitigating measures can be applied effectively and correctly. If necessary, the complaint will also be assessed against previous records to place the nature of the complaint into context.

#### 5.5 Complaint Investigation

In the event that odour from the facility is found to be causing a problem, as determined and confirmed by investigation into off site complaints or during routine monitoring; measures will be taken to determine the source, and the following courses of action as detailed below shall be taken:

- Additional olfactory monitoring as detailed above to identify the extent of the plume and potential cause for the odour i.e. material and/or process activity;
- Examination of the operational activities at the facility at the time of the odour complaint or odour identification;
- Examination of the meteorological conditions at the time of the complaint or odour identification;
- Carry out a review of the operational procedure and process controls and instigate any control measures immediately following identification of the problem;
- Further olfactory monitoring will be carried out to ensure the issue has been addressed and to monitor the effectiveness of any control measures undertaken.

### FOYLE MEATS, SIX HILLS, MELTON MOWBRAY, UK

### 5.6 Contingency Measures

The following table contains a list of contingency measures, which should be followed in the event of an issue arising for the potential odour sources identified in Table 2.6.

Source	Issue	Contingency Plan		
	-	Area		
Lairage/ Intake Area	Odour due to Spillage	Implement Relevant Procedure.		
Dispatch Area	Odour due to Spillage	Implement Relevant Procedure.		
By-Product Handling Area	Odour due to Spillage	<ul> <li>Implement Relevant Procedure.</li> <li>Flush remaining material through drainage network to effluent storage tank.</li> </ul>		
General Waste Storage Areas	Odour due to Spillage	• Implement housekeeping procedure.		
Maintenance Workshop	Odour due to Spillage	<ul> <li>Implement Relevant Procedure.</li> <li>Use spill-kit material to absorb spillage.</li> <li>Dispose of spill-kit material appropriately.</li> </ul>		
Chilled Storage	Odour due to Spillage	<ul><li>Shut down relevant equipment.</li><li>Contact contractor for immediate maintenance.</li></ul>		
Effluent Storage Odour due to Spillage or overflow		<ul> <li>Spillage may be directed to drains using pressurised water and coarse brush.</li> <li>Contact contractor for immediate emptying of the storge tank.</li> </ul>		
		Equipment		
Boiler	Black Smoke creating odour	<ul><li>Turn off boiler and close all fuel valves.</li><li>Contact contractor to investigate the issue.</li></ul>		
Condensers & Refrigeration Plant	Odour due to Leak	<ul><li>Shut down refrigeration plant.</li><li>Contact contractor for immediate maintenance.</li></ul>		
External Forklift Operations	Black Smoke	<ul> <li>Stop operation of equipment.</li> <li>Have mechanically repaired by maintenance or supplier.</li> </ul>		
General Waste Compactor	Odour due to Malfunction	<ul> <li>Shut down compactor.</li> <li>Contact contractor for immediate maintenance or replacement.</li> </ul>		
	-	Waste		
General Waste	Waste not collected	<ul> <li>If this issue is not addressed in the Disposal of Waste Procedure, the following should be carried out:</li> <li>Contact the General Waste contractor and request immediate collection.</li> <li>If collection cannot be made within a reasonable timeframe, another registered waste carrier should be contacted.</li> </ul>		
	Build-up of organic waste	<ul><li>Implement House Keeping Procedure.</li><li>Review Disposal of Waste Procedure</li></ul>		

Source	Issue	Contingency Plan
By-Product Waste	Waste not removed off-site	<ul> <li>If this issues is not addressed in the Disposal of Waste Procedure, the following should be carried out:</li> <li>Contact the relevant contractor and request immediate collection.</li> <li>If collection cannot be made within a reasonable timeframe, another registered waste carrier should be contacted.</li> </ul>
	Build-up of organic waste	<ul> <li>Implement House Keeping Procedure.</li> <li>Flush remaining material through drainage network to effluent storage tank.</li> </ul>
		Drainage
Stormwater Drains	Build-up of material	Contact external company to clear pipework.
Process & foul line	Build-up of material	Contact external company to clear pipework.

FOYLE MEATS, SIX HILLS, MELTON MOWBRAY, UK

#### 6.0 ACTIONS, CONTINGENCIES AND RESPONSIBILITIES

#### 6.1 Default Procedure

In the event that an emission of odour is identified during the normal course of operations, either through weekly routine monitoring, or in response to off-site complaints, the default procedure will be to investigate the emission in line with Section 5.5 above which is an appropriate response to both off site complaints as well as on site investigations following on from routine inspections.

It is the responsibility of the site management team (Site Manager and associated supervisors) to ensure procedures as set out are put into action.

#### 6.2 Emergency Procedure

In the event of an emergency, the site Business Continuity Plan, which is still being developed, would be adhered to. The objective of the site's BCP is to plan, as part of its duty of care to employees and customers the need to cater, as far as is reasonably practicable, for all eventualities that may adversely affect the operation of the business.

As part of that duty, the BCP is in place to assist in the speedy and efficient return to normal business activities should a major incident occur which directly impinges on our business activities.

The approach in this document is to assist management and the BCP team members in returning the business to its position in the marketplace before the disaster.

General	Site Specific
Electricity Failure	Natural Disaster
Contaminated Water Supply	Major Accident
Product Recall	Major Spillage
Malicious Tampering/Extortion	<ul> <li>Illness – Normal Workforce Not Available</li> </ul>
Bomb Alert	<ul> <li>Transport Issue – Normal Workforce Not Available</li> </ul>
Key Supplier Failure	Loss of Computer Systems

There are a number of emergency scenarios considered in the site BCP, including:

Each Scenario contains a section addressing the following: an overview/description; impact; duration; actions required, key contacts; risk assessment (severity and likelihood rating).

Monitoring for odorous emissions will be undertaken during these scenarios, where appropriate, in which extreme release of odour is expected. Odour masking agents can be utilised if necessary, and operations that may lead to increased odour release will be temporarily stopped.

Consideration will also be made as to the suspension of receipt of potentially odorous substances and/or the removal of from the site, if odours that can be directly attributable to the substance, is detected above intensity ranking 2 (moderate intensity) at the site boundary, in accordance with the monitoring trigger levels outlined in Section 4.2 above.

#### FOYLE MEATS, SIX HILLS, MELTON MOWBRAY, UK

This document also contains all essential contact details, including: Foyle Food Group Personnel; Emergency Services; Key General Contacts (Gas, water etc); Insurers; Key Customer; Key Suppliers, Cleaning, Construction and Equipment Suppliers.

The BCP a site-specific plan for Foyle – Melton Mowbray. It is also a confidential document, as knowledge of how the site will react to an emergency scenario may influence or give an advantage to individuals intending to purposely harming the site.

The following is the table of contents so far for the sites BCP:

#### 1.0 Purpose

- 1.1 Scope
- 1.2 Plan Objectives
- 1.3 Assumptions
- 1.4 Disaster Definition
- 1.5 Recovery teams
- 1.6 Team member responsibilities
- 1.7 Instructions for using the plan
  - 1.7.1 Invoking the Plan
  - 1.7.2 Disaster Declaration
  - 1.7.3 Notification
  - 1.7.4 External communications
  - 1.7.5 Emergency management standards
  - 1.7.6 Emergency management procedures
  - 1.7.7 In the event of a natural disaster
  - 1.7.8 In the event of a fire
  - 1.7.9 In the event of a network services provider outage
  - 1.7.10 In the event of a flood or water damage
- 1.8 Plan review and maintenance

#### 2.0 Alert/Verification/ Declaration phase

- 2.1 Plan checklists
- 2.3 Flow diagrams
- 2.4 Notification of incident affecting the site
- 2.5 Provide status to EMT
- 2.6 Decide course of action
- 2.7 Inform team members of decision
- 2.8 EMT notifies account teams/customers
- 2.9 Contact Haulers' and Farmers (see Appendix I)

#### **3.0** Disaster Declared: mobilize incident response team/Report to command center

- 3.1 Conduct detailed damage assessment (This may also be performed prior to declaring a disaster)
- 3.2 Contact EMT/decide whether to continue to business recovery phase

#### 4.0 Business recovery phase (full recovery)

- 4.1 System and facility operation requirements
- 4.2 Notify technical engineering staff/coordinate relocation to new facility
- 4.3 Secure funding for relocation
- 4.4 Notify EMT and corporate business units of recovery Startup
- 4.5 Operations recovered

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### 5.0 Appendixes

- 5.1 Appendix A: Foyle Gloucester recovery teams
  - 5.1.1 Emergency management team (EMT)
  - 5.1.2 Location Response Coordinator (LRC)
  - 5.1.3 Location Response Team (LRT)
  - 5.1.4 Incident Response Team (IRT)
  - 5.1.5 I.T. Technical Support (TS)
- 5.2 Appendix B: Recovery team contact lists
  - 5.2.1 Emergency management team (EMT)
  - 5.2.2 Location Response Coordinator (LRC)
  - 5.2.3 Location Response Team (LRT)
  - 5.2.4 Incident Response Team (IRT)
  - 5.2.5 I.T. Technical Support (TS)
- 5.3 Appendix C: Emergency numbers
  - 5.3.1 First Responders, Public Utility Companies, Others
- 5.4 Appendix D: Contact list
- 5.5 Appendix E: Emergency Command Center (ECC) Locations 5.5.1 Emergency Command Centre
- 5.6 Appendix F: Minimum acceptable recovery configuration
- 5.7 Appendix G: Forms
  - 5.7.1 Incident/Disaster form
  - 5.7.2 Critical equipment status form
- 5.8 Appendix H: Building Evacuation Information
- 5.9 Appendix I: Inventory of Primary Equipment and Systems
- 5.10 Appendix J: Inventory of Backup Equipment and Systems
- 5.11 Appendix K: Approved Vendor List
  - 5.11.1 Server and Computer Equipment Suppliers
  - 5.11.2 Civil/Structural Engineering Companies
  - 5.11.3 Electrical Contractors
  - 5.11.4 Excavating Contractors
  - 5.11.5 Emergency Generators
  - 5.11.6 Mechanical Engineering (HVAC, Facilities, etc.)
  - 5.11.7 Plumbing
  - 5.11.8 Site Security Services
  - 5.11.9 Additional Suppliers / Contractors

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### 6.3 Event Reporting

In the event of any significant environmental emergency/incident, a representative of Foyle will notify the EA by telephone immediately, but first having due regard for the incident at hand and any remediation actions required to ensure the safety of site personnel and the immediate environment.

Details of any environmental incident will be confirmed to the EA in writing by first class post or fax, on the next working day after identification of the incident. This confirmation will include: the time and duration of the incident; the receiving environmental medium or media where there has been any emission as a result of the incident; an initial estimate of the quantity and composition of any emission; the measures taken to prevent or minimise any further emission and a preliminary assessment of the cause of the incident.

Any incident notified to the EA will be investigated, and a report of the investigation sent to the EA. The report will detail, as a minimum, the circumstances of the incident, an assessment of any harm to the environment and the steps taken to bring the incident to a halt. The report will also set out proposals for remediation (if appropriate) and for preventing a repetition of the incident.

### 6.4 **Problem Resolution**

Once the identified problem has been rectified, a report will be prepared assessing the nature of the incident, the actions taken to resolve, and what changes could be made to the operational practises that would ensure, wherever possible, that the issue had less of a chance of arising in future.

This information will be provided to the Environment Agency in accordance with the Event Report procedures discussed in Section 6.3 above. Any improvements or amendments to operational practices will be discussed with the Environment Agency prior to their implementation.

### **Odour Management Plan** Foyle Meats, Six Hills, Melton Mowbray, UK





### **Odour Management Plan** Foyle Meats, Six Hills, Melton Mowbray, UK

Appendix A.2: Source Monitoring Locations Map



### **Odour Management Plan** Foyle, Six Hills, Melton Mowbray, UK

Appendix B: Potential Fugitive Air Emission Points Sources



### **Odour Management Plan** Foyle, Six Hills, Melton Mowbray, UK

App	endix	C:	Template	Odour	Investig	ation	Field	Sheet
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General	Reference Site Lo	cation	A	Assessment	by			Date of Assessment
			Y	Your Name:	ors present			
Pre- Assessme nt Preparati on	Observer is free from medical conditions (cold, sore throat, sinus trouble)?	Observer abstinence (30 min) from smoking, flavoured drinks, scented toiletries and deodorisers?	Reason for or assessment – Complaint ve routine; other	dour erification; r (specify).	Map – H showing location	Ias a map assessment s been attached?	Weather Condition (record wind info	ons Note 3 o on page 2)
s these notes must be ie field observations :leaf)	<ul> <li>Note 1: Observation</li> <li>0 Remote (no housing, compoint)</li> <li>1 Low sensitivity (no housi observation point)</li> <li>2 Moderate sensitivity (hous observation point)</li> <li>3 High sensitivity (housing point)</li> <li>4 Extra sensitive (complain observation point)</li> </ul>	<b>n point Sensitivity (assuming detectable, if not then 0)</b> nmercial/industrial premises or public area within 500m of observation ing, commercial/industrial premises or public area within 100m of using, commercial/industrial premises or public area within 100m of g, commercial/industrial premises or public area within area of observation ints arising from residents, businesses and users of public areas within area of			en 0) n	<ul> <li>Note 3: Weather Conditions         Precipitation – dry, rained recently, drizzle, raining, foggy Temperature – cold, cool, warm, hot     </li> <li>Note 4: Odour Persistence         <ul> <li>No Odour</li> <li>Intermittent (detected intermittently during the period of assessr</li> <li>Persistent (detected throughout the period of assessment)</li> </ul> </li> </ul>		
Notes (the ranking systems in used when completing th table over	Note 2: Wind Stree0Calm1Light air2Light Breeze3Gentle Breeze4Moderate Breeze5Fresh Breeze5Fresh Breeze6Strong Breeze7Near Gale8Gale9Strong Gale	sngth Smoke rises vertically Direction of wind shown by smol Wind felt on face; leaves rustle, o Leaves and small twigs in constau Raises dust and loose paper; smal Small trees in leaf begin to sway Large branches in motion; umbre wind Whole trees in motion; inconveni Twigs break off trees; progress g Slight structural damage occurs (	ke drift, but not w ordinary vane mov nt motion Il branches are mo Ilas used with dif ence felt when we enerally impeded chimney pots and	vind vanes ved by wind oved, ficulty against t alking against v slates removed	he , vind	<ul> <li>Note 5: Odour I</li> <li>No detectable odour</li> <li>Faint Odour (barely wind)</li> <li>Moderate Odour (ea normally, possibly o</li> <li>Strong Odour (bearat</li> <li>Very Strong Odour (odour)</li> </ul>	<b>ntensity</b> detectable, need to star sily detectable while w ffensive) ble but offensive – mig (unbearable, difficult to	nd still and inhale facing the alking and breathing ght make clothes / hair smell?) o remain in area affected by
ur ce gatio dour	Start Time Do any o those rec	of the odours experienced on-site ma corded during the off-site survey?	tch in character	List areas ins	spected		What relevant activit during the off-site of	ies were occurring on-site lour assessment?
Odoi Sour Investi <u>s</u> n (Post O	Finish Time Potential	on-site odour sources identified						

### **Odour Management Plan** Foyle, Six Hills, Melton Mowbray, UK

	Observer Location		(nd = if	Wind not detect	table)	Ti	ime	Odour	Rating	Odour Description Comments
Parameter	Name of household / commercial site (describe so that location can be easily identified again by a third party)	Sensitivity (1-5) Note 1	Direction from which wind blows	Orientation (Observer Vs. facility)	Strength Note 2	Start Time (24hrclock)	Period of observation	Odour Persistence (0-2) Note 4	Odour Intensity (0-4) Note 5	Description of any odours, other source(s) of odours etc. (Also note variable weather conditions etc.)
Thresholds that could indicate nuisance		≥3		Down-Wind Approx. DW or not detectable etc.				1 or 2	≥2	<b>Guide-</b> A location where the score meets or exceeds all the threshold values may be deemed subject to nuisance/significant impairment, particularly if the observations are supported by public complaints on impact, frequency and duration of odours.
ations										
)bserv										
Field (										
Brief deta	ails of any meeting with local	residents	complain/	ts received	l during	g assessi	ment (inc	clude names/	/addresses/tel	ephone numbers etc.):

FOYLE, SIX HILLS, MELTON MOWBRAY, UK

Appendix D: Template Odour Complaint Report Form						
	Odour Complaint Report Form					
Time and date of complaint:	Name and address of complainant:					
Telephone number of com	plainant:					

### Appendix D: Template Odour Complaint Report Form

Date of odour:		
Time of odour:		
Location of odour, if not	t at above address:	
Weather conditions (i.e.	, dry, rain, fog, snow):	
Temperature (very warn	n, warm, mild, cold or	
degrees if known):		
Wind strength (none, lig	ht, steady, strong,	
gusting):		
Wind direction (eg from	NE):	
	Complainant's descri	ption of odour:
What does it sme	ell like?	
• Intensity (see bel	low):	
• Duration (time):		
Constant or inter	mittent in this period:	
Does the compla	inant have any other	
comments about	the odour?	
Are there any other com	plaints relating to the	
installation, or to that lo	cation? (either	
previously or relating to	the same exposure):	
Any other relevant infor	mation:	
Do you accept that odou	r likely to be from your	
activities?		
What was happening on	site at the time the	
odour occurred?		
Operating conditions at	time the odour occurred	
(eg flow rate, pressure a	t inlet and pressure at	
outlet):		
Actions taken:		
Form completed by:	Date	Signed
	Duit	S.B.104
	1	

Appendix E:	Odour	Management	Action	Plan
		<u> </u>		

	AREA SOURCE	Odour Source	ACTION PLAN	IMPLEMENTATION / COMPLETION DATE	
1.a			All relevant staff to be trained on OMP measures.	Immediate	
1.b			Review and update OMP initially on an annual basis or following any relevant changes at the site and should be responsive to the results of internal monitoring of the odour and any complaints of odour. Key Performance Indicators (KPI's): - Number of Complaints, - Number of abnormal odour events (odour patrol checks), - Results/recommendations of any surveys	Annually/ as necessary	
1.c			Carry out weekly odour patrol checks and keep log of all findings, including weather conditions and wind direction. At times where a complaint has been received or issues identified during environmental checks, monitoring or during maintenance, daily monitoring should be carried out at times relevant to the complaint or identified issues until the investigation is complete.	Weekly / as necessary	As per Appendix C
1.d			Keep a log of environmental odour complaints, including description of the odour, details of investigation, any follow-up actions and outcomes.	Immediate	As per EMS- ER07
1.e			Keep a log of odour monitoring carried out, including reason for survey, main findings and remedial actions taken.	On-going	As per Appendix F

	AREA SOURCE	Odour Source	ACTION PLAN	IMPLEMENTATION / COMPLETION DATE	
1.f			Inform neighbours (i.e. village council) of any abnormal planned operations/projects which may lead to significantly increased odours. Provide detail of timing and likely duration to minimise odour impact. Provide contact details of relevant members of staff for the receipt of environmental complaints to neighbours.		Include in environmental communicatio ns policy.
2.	Main Facility	Open Doors	Maintain a closed-door policy in all areas containing potentially odorous materials, particularly during warm weather. Monitoring of compliance is controlled during on-going environmental and quality control checks.	On-going	
3.	Main Facility	Canteen	Assess odours as part of weekly odour patrols.	Weekly	
4.	Equipment	Production Extraction Fans	Assess odours as part of weekly odour patrols.	Weekly	

	AREA Source	Odour Source	ACTION PLAN	IMPLEMENTATION / COMPLETION DATE	
5.	External Yards	General Waste / Recycling Storage	Ensure all waste skips and bins are sealed and adequately covered to prevent any potential odours. Inspect all skips and bins onsite as part of weekly environmental odour patrol check. Clean containers if necessary (avoid build-up of odorous materials). General waste to be removed offsite weekly. Remove waste offsite more frequently during warm weather	On-going Weekly As necessary Weekly As required	
			conditions if odours begin to develop.		

	AREA SOURCE	Odour Source	ACTION PLAN	IMPLEMENTATION / COMPLETION DATE	
6.	By-Product Handling Area	CAT1 & CAT 3 Waste Storage	<ul> <li>Putrescible wastes to be collected and removed to waste trailer daily, particularly during warm weather conditions.</li> <li>Final on-site putrescible waste containers to be sealed / covered while not being filled. Inform waste collectors of requirement for sealed / covered containers.</li> <li>Inspect all containers onsite as part of weekly environmental odour patrol check.</li> <li>Clean containers if necessary (avoid build-up of odorous materials)</li> <li>Remove waste offsite more frequently during warm weather conditions if odours begin to develop.</li> </ul>	Daily Immediate Weekly As required As required	
7.	External Yards	Stores Yard	<ul><li>Ensure all yard areas are kept free of putrescible spills or the build-up of organic materials.</li><li>Drivers and operators to be informed of requirement to report spillages.</li><li>Clean yard area of spillages as they occur.</li></ul>	On-going Immediate As necessary	

	AREA SOURCE	Odour Source	ACTION PLAN	IMPLEMENTATION / COMPLETION DATE	
8.	External Yards	Dispatch Yard	Ensure all intake/dispatch areas are kept free of putrescible spills or the build-up of organic materials.	On-going	Include in
			Drivers and operators to be informed of requirement to report spillages.	Orientation	training material
			Clean yard area of spillages as they occur.	As necessary	
9.	Vehicles	Waste Trailers / Tankers	Ensure all vehicles or containers used to transport materials off- site are sealed and adequately covered to prevent any potential odours in transit.	On-going	
			Clean vehicles to remove potentially odorous materials from wheels and exterior as necessary to prevent odours during transport.	As necessary	
10.	WWTP	WTPPlant and equipmentMaintain equipment, including preventative maintenance schedule, to ensure high efficiency.		On-going	
11.	WWTP	Drains	Ensure all drains are flushed regularly and prevent persistent build-up of organic matter in drains by design.	On-going	
12.	WWTP	Inlet Sump	Minimise residence time for effluent in the inlet sum as practical	On-going	
13.	WWTP	Auger screens	Remove screened solids to waste to storage daily.	Every day	
			Remove screened solids to waste storage twice daily during warm weather conditions.	Twice Daily (warm days)	
			Clean down yard area around screen daily.	Daily	

	AREA SOURCE	Odour Source	ACTION PLAN	IMPLEMENTATION / COMPLETION DATE	
14.	Effluent sump	Screenings	Ensure all trailers and skips used to transport waste off-site are sealed and adequately covered to prevent any potential odours in transit.	On-going	

<b>Appendix F:</b>	Template Od	our Complaints/N	Ion-Conformance	/ Odour-Monitoring-I	Report Log
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Date	Type (Complaint / Non– Conformance / Assessment)	Complaint type / Area / Process / Report Type	Description	Corrective Action Taken	Outcome
	i.e. Complaint	i.e. Odour	i.e. Effluent odour in local area	i.e. Reduce inlet sump volume. Carry out an odour survey.	i.e. No further odours detected in area.
	i.e. Non-Conformance	i.e. Sludge spill	i.e. spill of sludge on hardstanding during collection	i.e. Clean spill.	i.e. No further odours detected in area.
	i.e. Assessment	i.e. complaint investigation survey	i.e. Report Recommendations; No.1: No.2:	i.e. recommendations implemented	i.e. No remaining actions