Asset Management
Asset Standard
Odour Management Plan

Didcot STW

DIDCS1ZZ

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Contents

Figures and Tables:

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Owner Review Requirements

Document to be reviewed when any changes are made to the site or processes.

Local Review Requirements

Site Manager should be informed when handwritten amendments are made to this document.

Revision No	Reason for Revision	Prepared by	Approved by	Date
1	Creation of OMP in new standard format	[redacted]		July 2014
2	New Performance Manager + review of OMP + New inlet pumping station No 2.	[redacted]	[redacted]	June 2018
2.1	Update from Audit	[redacted]	[redacted]	December 2018

		[redacted]		
3.0	New Sludge Treatment Centre Permit Application	[redacted]	[redacted]	September 2022
3.1	IED AD Permit Application Resubmission	[redacted]	[redacted]	November 2023

Sign Off

Operations Area Manager	[redacted]	Date: January 2024
Performance Manager	[redacted]	Date: January 2024

Glossary of Terms

TERM	DESCRIPTION
AD	Anaerobic Digestion
BNR	Biological Nutrient Removal
CHP	Combined Heat and Power
CSM	Customer and Stakeholder manager
DEFRA	Department for Environment, Food and Rural Affairs
EA	Environment Agency
EMS	Environmental Management System
EPR	Environmental Permitting (England and Wales) Regulations 2016
FFT	Flow to Full Treatment
H4	Environment Agency - How to comply with your permit – H4 Odour Management, March 2011
ICA	Instrumentation Control & Automation
IED	Industrial Emissions Directive
OCU	Odour Control Unit
OMC	Operational Management Centre
OMP	Odour Management Plan
PFT	Picket Fence Thickener
PM	Process Manager
PS	Pumping Station
PST	Primary Settlement Tank
Receptors	Sensitive receptors are any fixed buildings or installations where odour annoyance may occur, such as residential homes, schools, hospital, offices, shops or garden centres. Open areas such as playgrounds and public footpaths should also be listed where these are known to have been affected by odour.

SAP	Thames Water's enterprise resource and planning system
SCADA	Supervisory Control and Data Acquisition
SOM	Site Operating Manual
STC	Sludge Treatment Centre
STW	Sewage Treatment Works
TCM	Technically Competent Manager
TM	Team Manager
UWWTD	Urban Waste Water Treatment Directive

1 Introduction

This Odour Management Plan (OMP) forms part of Didcot STW Best Operating Practice and is a constituent part of the Environmental Management System (EMS). A key related document is the Site Operating Manual (SOM) – this document can be found as a hard copy in the Didcot STW administration building and on Thames Water's database SharePoint, within the EMS pages.

The purpose of this OMP is to define how the potential and actual generation of odour from Didcot STW are identified, and how, as far as is reasonably practicable, they are controlled and recorded. It is primarily a management guide; detailed operational procedures are contained within the SOM.
Changes to OMP procedures are captured in the SOM as part of the periodic reviews of this document.

The effectiveness of the odour control measures will be reviewed annually or sooner if any of the following occur:

- If the site in question acquires any other permitted activity with the potential to increase the risk of odour off site.
- When significant changes are made to the site which may affect odour, e.g., capital spend.
- As a result of a change in pattern of odour complaints, increase in public concern and as soon as possible after a significant incident.
- When the site management changes.
- If there is a material change in relevant regulations or guidance.
- If there is an odour release incident.
- If a contingency measure is triggered

This OMP is an operational document that has been developed following a review of the potential risk areas for odour release. It details operational and control measures appropriate to the reduction or elimination of the impact of odours from wastewater treatment works. It provides detail to allow operators and maintenance staff to understand the operational procedures for both normal and abnormal conditions.

This OMP was updated in 2022 to incorporate appropriate odour control measures for activities that will be newly regulated under an Environmental Permit issued under the Environmental Permitting (England and Wales) Regulations 2016 (EPR), following the principles transposed through the Industrial Emissions Directive. This follows the reinterpretation of the Industrial Emissions Directive in exclusion of UWWTD activities - meaning that anaerobic digestion (AD) on a Sewage Treatment works now needs an Environmental Permit.

The Odour Management plan has been structured to distinguish between the two regulatory regimes, which are fully described in the Site Information chapter. The wastewater treatment process is covered by the Urban Wastewater Treatment Directive (UWWTD). The Environmental Permit for the Sludge Treatment Centre (STC) covers various process including but not limited to, the AD process, combustion of biogas in the CHP plant and the storage of resulting sludge. This OMP responds to odour risks from both UWWTD and STC permitted processes (referred to as the Sludge Treatment Centre Permit).

This OMP is stored electronically on SharePoint within the EMS page. A hard copy is kept on site within the Site Operating Manual.

1.1 Relevant Guidance

Where this Odour Management Plan relates to STW activities regulated under the UWWTD this OMP may still draw upon elements of best practice taken from H4 but this should not be inferred as H4 being applicable to these activities.

The following guidance has been used to inform the contents of the OMP where it relates to activities regulated under the Sludge Treatment Centre Permit. This guidance does not apply to UWWTD activities.

- Environment Agency - How to comply with your permit – H4 Odour Management', March 2011 (H4)
- Commission Implementing Decision (EU) 2018/1147 of 10 August 2018 establishing best available techniques (BAT) conclusions for waste treatment, under Directive 2010/75/EU of the European Parliament and of the Council (Waste Treatment BAT Conclusions)

The OMP format used is in line with that adopted for other Thames Water sites.

Copies of the Odour Risk Assessment, Odour Improvement Plan, Customer Communications Plan, and Site drawings are included in Appendices 1-4.

2 Site Information

2.1 Location and Receptors

Site Address:

Didcot STW
Basil Hill Road
Didcot
Oxfordshire
OX11 7HJ
What 3 words ref: ///lighters.mentioned.wasps
EPR Permit number to be included when issued

This site is located off Basil Hill Road. It is located within a suburban area of Didcot, Oxfordshire with commercial and industrial premises located on all sides. The nearest residential properties are located within 200m of the southern boundary.

Didcot STW serves the town of Didcot and the surrounding villages which correspond to a Population Equivalent (PE) of approximately 45,000.

Receptors

The nearest receptors are given in Table 2.1 - Location of potentially sensitive odour receptors.and have been marked on site location map in Figure A2 of Appendix 4.

Table 2.1 - Location of potentially sensitive odour receptors.

	Receptor Address	Receptor type	Approximate distance to the nearest site boundary (m)	Direction from the site	Receptor Sensitivity
1	Collect Way Footpath, Didcot, Oxfordshire	Pedestrian	Adjacent to main entrance gate	East	Medium
2	Southmead Industrial Estate, Didcot, Oxfordshire	Industrial	100m	All directions	Medium
3	Milton Park	Industrial	1560m	West	Medium
4	ASDA distribution Centre	Industrial	1630m	Northwest	Medium
5	Didcot B Power station	Industrial	1100m	Northwest	Medium
6	Trident Business Park	Commercial	310m	West	Medium
7	Omega Business Park	Industrial	20m	East	
8	Thames Valley Network Rails, Didcot, Oxfordshire	Transport	170m	East	Medium
9	Didcot Parkway Railway Station	Transport	850m	Southeast	Medium
10	Appleford Village	Residential/ Open Area	1500m	North	High

11	Foxhall Residential park, Didcot, Oxfordshire	Residential – Static caravans	200m	South	High
12	Ladygrove Parish Area	Residential	330m	East	High
13	All Saints Parish Area	Residential	420-2000m	South, Southwest	High
14	Orchard Parish Area	Residential	800-1700m	Southeast	High
15	Park Parish Area	Residential	1300m	South	High
16	Northbourne Parish Area	Residential	1200m	Southeast	High
17	Millbrook Parish Area	Residential	1750m	Southeast	High
18	Willowbrook Leisure Centre	Open Area	650m	Southeast	Low
19	Ladygrove Hill	Open Area	860m	East	Low
20	Great Western Drive Park	Open Area	500m	South	Low
21	Loyd Recreation Park	Open Area	970m	South	Low
22	Edmonds Park	Open Area	1600m	South	Low
23	Boundary Park	Open Area	1370m	Southwest	Low
24	Neighbourhood Park	Open Area	1490m	Southwest	Low
25	Ladygrove Park Primary School	School	630m	Southeast	High
26	All Saints C Of E Primary School	School	1300m	Southeast	High
27	St Birinus School	School	1200m	Southeast	High
28	Willowcroft Community School	School	1000m	Southeast	High
29	Manor Primary School	School	990m	South	High
30	Didcot Girls' School	School	1100m	South	High
31	Aureus Primary School	School	1950m	Southwest	High
32	Didcot Primary Academy	School	1700m	Southwest	High
33	UTC Oxfordshire	School	2000m	Southwest	High
34	Aureus Secondary School	School	1970m	Southwest	High
35	Stephen Freeman Community Primary School	School	1000m	Southwest	High

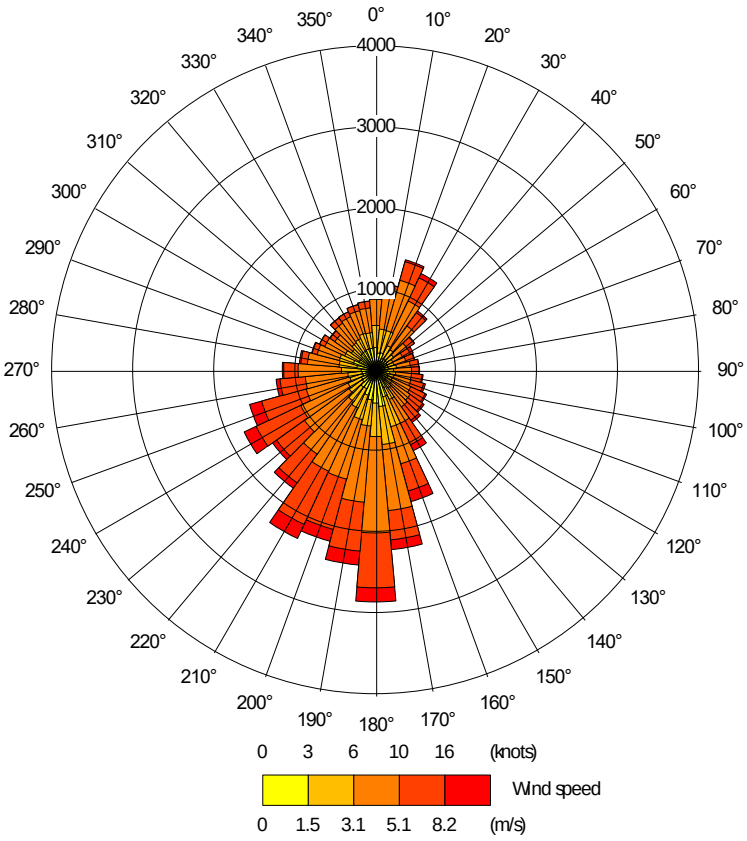
2.2 Off-site sources of odour

There was a landfill waste facility and a farm approximately 500 m to the northeast boundary of the site which may have the potential to generate odour.

2.3 Wind Rose and Weather Monitoring

RAF Benson meteorological station (approximate location NGR E 462586 N 191079) is located approximately 10.7 km east of the site and is considered the closest most representative meteorological monitoring station to the site. Data is recorded at the meteorological station in hourly measurements and the figure below presents the relationship between the frequency and speed of wind from compass point directions for the combined years 2016 – 2020. The figure illustrates the predominant wind direction to be southerly, which means receptors north of the site would have the highest probability of experiencing potential increases in odour emissions.

Figure 2.1: Wind rose – RAF Benson meteorological station 2016 - 2020



There is no on-site weather station at Didcot. Weather on site can be reviewed if complaints are received or during periods of abnormal operations. The internal 'Weather' SharePoint site provides adverse weather information, and the UK Met Office website can also be used.

2.4 Site Layout and Treatment Processes

For site plans, see appendix 4. Further details of the site layout and treatment processes are given in the following sections of the Site Operating Manual and are therefore only given summary attention in this OMP:

Section	Description
1	Governance & Control
2	Location, key layout plans and diagrams. Site services, including power, water, drainage, SCADA and ICA. Consent details, process overview, chemical and waste handling.

3	Detailed description of each treatment process, including sludge and odour control.
4	Maintenance
5	Plant control, monitoring, and logging.

2.5 Process Description

The following sections describe the processes of wastewater and sludge treatment and should be read in conjunction with the site plan and process flow diagram given in Figures D1 and D2 in Appendix 4.

2.5.1 UWWTD activities

Preliminary Treatment

Inlet flow is received to the Inlet Wet Well No 1 via 2 x gravity mains. Inlet Wet Well No 2 via a single gravity main from Great Western. The flows are then pumped separately up to the Inlet Works, where rag is removed via 3 x Band Screens and is then sent through a Washpactor. Screenings are deposited into 1 x Skip. Grit is then removed via 2 x Grit Kings and dropped into 1 x common Grit skip. Phosphorous removal is with dosing Ferric Sulphate at the inlet works just before vortex to PST distribution.

Storm Tank Management

There are 4 x Storm Tanks. There is a central chamber which all 4 tanks drain to with 1 return pump. Overflow from the storm tanks passes through the CopaTrawls before joining the watercourse through a separate outfall.

Primary Treatment

There are 2 x circular, ½ bridge scraped, conical bottomed Primary Settlement Tanks. The Primary Settlement Tanks are automatically de-sludged under normal operating conditions to the Picket Fence Thickener.

Secondary treatment

There are 3 x diffused air Activated Sludge Lanes. From the Aeration Lanes flow then goes to the 3 x circular scraped Final Settlement Tanks via a common feed chamber where the Surplus Activated Surplus Activated Sludge and Returned Activated Sludge gravitate from the bottom of the FST to a well, where the RAS is returned to the front of the Aeration Lanes and mixed with primary settled sewage. The SAS is pumped to the aquabelts for thickening. Phosphorus removal dosing is carried out in the centre section of each lane.

Tertiary Treatment

There are 2 x low head Sand filters. Sodium hypochlorite is dosed into the backwash pumps on the tertiary treatment bridges, when required.

Final Effluent Discharge

Final Effluent is discharged onto the Moor Ditch which then goes to the River Thames at Long Wittenham.

2.5.2 Sludge Treatment Centre Permit Activities

The STC comprises an offloading point for permitted imported waste at the Works Inlet of the STW. This material is passed to the Works Inlet to be treated by the UWWTD process. Sludge from the Primary Settlement Tanks (PSTs) is drawn off and pumped to the Picket Fence Thickeners (PFTs) for thickening and then pumped to the Sludge Blending Tank. Surplus Activated Sludge (SAS) from elsewhere in the aerobic treatment process is separately pumped to a SAS Buffer Tank, which is outside of the scope of this permit, before it is thickened in the SAS Thickening Plant with the aid of a polymer coagulant before the thickened SAS is pumped to the Sludge Blending Tank. Imported sludge from other works accepted into a Sludge Import Tank, is passed via Sludge Screens and pumped to the Sludge Import Buffer Tank via Screen Sludge Pumping Station. Imported sludge is then pumped to the Sludge Blending Tank and mixed with indigenous sludge. Liquors from the PFTs and the SAS Thickening Plant is returned to the Works Inlet for treatment via Liquor Return Pumping Station 2 via site drainage. From the Sludge Blending Tank, mixed sludges are pumped to one of the two Primary Digester Tanks.

The two Primary Digester Tanks are of the same steel construction, aboveground tanks and fitted with Pressure Relief Valves (PRVs). Safety systems are also fitted to the biomethane Gas to Grid plant. Sludge within each Primary Digester Tank is heated via a dedicated heat exchange system which uses heat generated from the two site boilers.

Following treatment over an appropriate number of days within the Primary Digester Tanks, sludge is transferred to one of the three above ground, open topped Secondary Digester Tanks. Digested sludge is held in these tanks for an appropriate retention time to ensure that the required level of pathogen kill is achieved in order to comply with digested sludge cake output quality requirements.

Digested sludge is then pumped to the Dewatering Feed Buffer Tank and further pumped to the Sludge Dewatering Plant where it is dewatered with the addition of a polymer coagulant. The liquor from dewatering is returned to the Works Inlet for additional treatment via Liquor Return Pumping Station 3 and 1 via the site drainage and the dewatered, digested sludge cake is conveyed to the Cake Pad and deposited on the engineered concrete bay. Digested sludge cake is temporarily stored on open cake pad prior to removal from the site under the Sludge Use in Agriculture Regulations 1989 (SUiAR), and in accordance with the Biosolids Assurance Scheme (BAS).

Biogas from the Primary Digester Tanks is captured and transferred to a double membrane Biogas Storage holder. The biogas transfer pipeline is equipped with condensate pots that capture entrained moisture from the generated biogas and allow it to be drained into the site drainage system for treatment. The Biogas Storage holder is fitted with Pressure Release Valves (PRVs) as a safety precaution in the event of over pressurising the system. The biogas is taken from the Biogas Storage for upgrading to biomethane in the biomethane Gas-to-Grid plant or for combustion in one of two boilers at the site to generate heat for use within the site's Primary Digester Tanks, which are dual fuelled with natural gas from the public supply. Biogas is used within the biomethane Gas-to-Grid plant, where the biogas is subject to cleaning and moisture removal, carbon dioxide separation and injection into the medium pressure biogas network. The boilers are less than 1.0 MWth each and are too small to be considered as 'existing' combustion plant under the Medium Combustion Plant Directive (MCPD). In the event there is excess biogas, i.e. more than the biomethane Gas-to-Grid plant or boilers can utilise, or in the event that the boilers are unavailable or in the event of off-specification biogas, there are two ground mounted flares: one relating to the wider STC nd another which will support the gas to grid plant.. Flare use currently can exceed 10% of annual hours at Didcot to dispose of biogas in a controlled manner which explains the development of a consumptive solution (gas to grid).

This OMP includes the import of treated sludge cake from other works, for temporary storage in the Cake Pad, pending offsite recovery. All such imports will be subject to appropriate waste pre-acceptance and acceptance checks, prior to import, including checking whether the incoming cake complies with the requirements of SuiAR and BAS.

Imported treated sludge cake is offloaded in the Cake Pad, so as to be stored separately to indigenous sludge cake. The waste stream is the same as that arising from the treatment of sludge within the Didcot STC with the same characteristics, composition and eventual end use – application to land. As such, the infrastructure which is acceptable for use for site cake is appropriate for the imported material.
Cake is stored on an impermeable surface within the Cake Pad, for the shortest time practicable, the duration depending on factors such as prevailing weather and availability of the landbank.
A temporary centrifuge is also available at Didcot STC to dewater indigenous sludge from the PFTs or to dewater imported sludge. Dewatered sludge is deposited on the Cake Pad while dewatering liquors are transferred to Liquor Return Pumping Station 3 and returned to the Works Inlet via the Liquor Balancing Tank and Liquor Return Pumping Station 1.

3 Site Management Responsibilities and Procedures

3.1 Site Roles

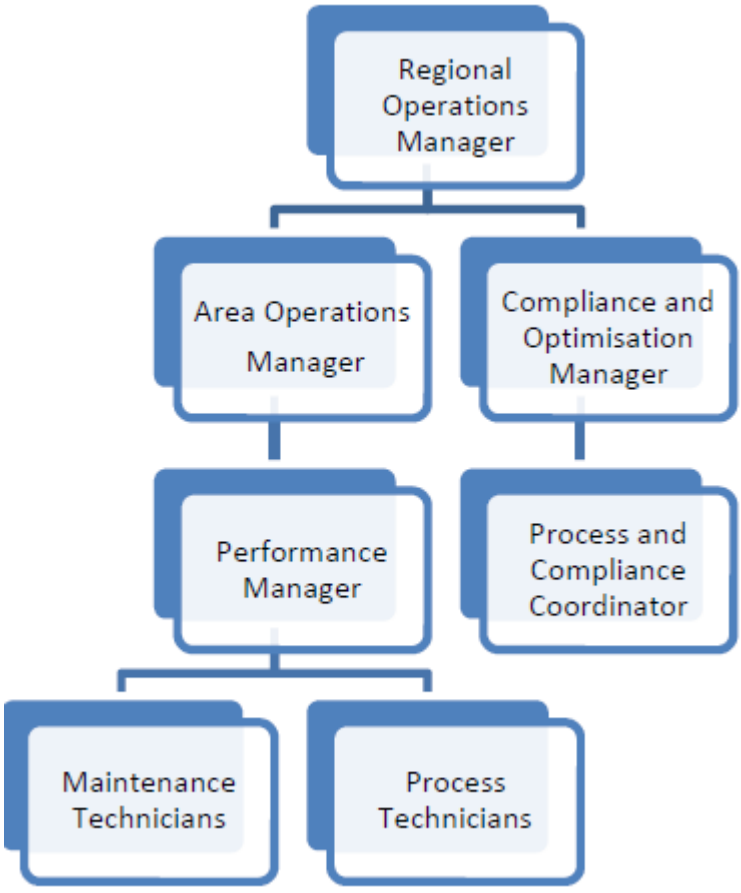


Figure 3.1 - Site Roles

Table 3.1 - Tasks and Responsibilities

Role	Tasks and Responsibilities
Regional Operations Manager	Responsible for the overall performance of STW in this region.
Area Operations Manager	Responsible for overall performance of the STW in the area, including assessing the scope of, and updating the OMP as it is implemented.
Performance Manager	Responsible for overall performance of the STW and will be responsible for • odour control and management at the site • day to day implementation of the OMP • assessing the scope of, and updating, the OMP as it is implemented. • dealing with customer complaints • day-to-day operation of the STW • Ensuring staff Thames Water staff undergo appropriate training
Technically Competent Manager	Hold the required WAMITAB qualification to support the activities on site under EPR, ensuring permit conditions are complied with.
Maintenance and Process Technicians	Day to day duties include maintaining and operating process equipment.
Customer and Stakeholder Manager (CSM)	Responsible for managing liaison with all external customers and stakeholders in liaison with customer centre, escalation team, local govt. liaison team etc.
Compliance and Optimisation Manager	Responsible for process investigations and technical assistance.
Process Compliance Coordinator	Reports to Compliance and Optimisation Manager. Responsible for process monitoring, improvement and troubleshooting.
Duty Manager	The duty manager is centrally based (off-site) and is responsible for event management across the business.
Customer Centre	Responsible for receiving all customer calls, logging them and passing them to the appropriate operational departments.

The site is manned during 07.30 – 15.30 Monday to Friday.

3.2 Key Contacts

Role	Name	Email address	Phone Number
Area Operations Manager	[redacted]	[redacted]	[redacted]
Performance Manager	[redacted]	[redacted]	[redacted]
Technically Competent Manager	[redacted]	[redacted]	[redacted]
Customer Centre	Didcot STW	customer.feedback@thameswater.co.uk	0800 316 9800

3.3 Operator Training

Staff working on site undergo a site induction that is carried out by the Performance Manager. The site induction includes direction to the presence and location of the various operational procedures which include the SOM and the OMP. In addition, Site Tech 1's undergo a specific programme of training which covers management of activities on site.

All training records are currently held on Learning on Tap where they are accessible by the site Performance Manager and individual members of staff.

There is a requirement for a permitted activity at this site the site management team will hold a Level 4 WAMITAB qualification, and meet a weekly site attendance requirement, to demonstrate technical competence.

4 Odour Critical Plant Operation, Monitoring and Management Procedures

Odour prevention and reduction is achieved at Didcot through at least an annual review, or sooner as mentioned in Section 1, of the Odour Risk Assessment, Odour Improvement Plan and Odour Management Plan. In combination with the maintenance and monitoring carried out on site mentioned in sections 4 and 5.

Through our Odour Management Plans and maintenance procedures, the primary focus is on effective process control to minimise the risk of off-site odour nuisance. Similarly, our site-based frontline Wastewater Treatment Operations team are focussed on effectively managing the on-site process.

4.1 Odour Sources, Critical Issues and History

There have been no recent formally recorded odour complaints (end of 2022). Some complaints were received historically before the works was redeveloped.

An odour risk assessment of the activities at Didcot and mitigation under normal and abnormal conditions is given in Appendix 1.

An Odour Improvement Plan is included as Appendix 2.

Critical Odour Issues, Emergency Response and Mitigation Measures are summarised in Tables 4.3 to 4.7.

4.2 Identification of Odour Critical Plant

4.2.1 Odour Risk Assessment

An Odour Risk Assessment has been carried out and a copy is included in Appendix 1. The Odour Risk Assessment is not a ‘one-off’ exercise but an on-going process. It is constructed in the following manner:

- Each part of the treatment process is considered under different operating modes – e.g., normal, failure, abnormal: system overload, summer conditions, maintenance etc.
- The nearest customers to the particular odour source are identified.
- The likely frequency and duration of occurrence for each eventuality is identified.
- A score is assigned to the severity (0 – 5) of odour under each operating mode.
- A score is assigned to the probability (0 – 5) of causing an odour nuisance for each operating mode.
- Multiplying the severity of odour and probability of causing an odour nuisance generates a ‘Current Odour Emission Risk’ score. Between 0 (zero risk) and 25 (maximum risk), this is used to decide where mitigation should be applied in the short term and determine where in the longer term enhanced improvement measures are required. Where improvements are identified as necessary (i.e., where suitable mitigation measures are not already in place), entries are made onto the Odour Improvement Plan.

- The need for operational mitigation, enhanced measures and customer communication is stated and brief details given.

Items scored in the Odour Risk Assessment with a risk score greater than 10, and where existing operational mitigation measures are not sufficiently robust, will have Improvement Plans generated to address the odour issues. The Odour Improvement Plan for Didcot STW is included in Appendix 2.

4.2.2 Potential Odour sources

The following list of potential UWWTD odour sources been identified during the risk assessment:

- General Odour
- Inlet SPS 1 & 2
- Cess Reception
- Storm Tanks
- Screening
- Washpactor
- Skip
- Grit Removal
- Grit skips
- Flow & Distribution to Primary Settlement Tanks
- Primary Settlement Tanks
- Fats, Oil & Grease Scum Removal System
- Primary Raw Desludge Pumping
- Feed chamber to Secondary Treatment
- Activated Sludge Plant Lanes & Zones
- Flow & Distribution to Secondary Settlement
- Final Settlement Tanks
- Scum Removal System
- RAS Chambers & Pumping
- SAS Chambers & Pumping
- SAS Buffer Tank
- Lift station
- Filtration - Sand filters
- Back Wash Returns
- Final Effluent

The following list of potential Sludge Treatment Centre odour sources have been identified during the risk assessment:

- Sludge Import Tank
- Rotmat
- Screenings skip
- Screened sludge PS
- Sludge Import Buffer Tank
- PFT - Raw sludge thickening
- SAS Thickening & Pumping
- Sludge blending tank
- Return Liquors
- Digester feed PS
- Primary Digestion
- Gas holder

- Biogas scrubbing plant
- Secondary Digestion and Mixing
- Dewatering feed buffer tank
- Press Feed PS
- Beltpress
- Filtrate PS
- Conveyor
- Cake Pad & Drainage
- Vehicle Movements & Wash Down
- Waste Gas Burner
- Gas to Grid
- Standby Generators
- OCUs

4.2.3 Odour Critical Plant

The following list of odour critical plant[1] has been identified during the Odour Risk Assessment:

- Inlet works SPS 1 + 2
- Cess reception, discharge, wash down and drainage
- Odour control packages

4.2.4 Waste Storage for Sludge Treatment Centre Permit

Waste is not stored on site prior to treatment through the UWWTD or AD process. A list of the main tanks relating to the sludge treatment process and their associated volumes and retention times is shown below.

Table 4.1 Sludge Treatment Centre Permit Tank Inventory

Tank Purpose	Number	Operational Volume (m^3)	Construction	Average Retention Time
Sludge import tank	1	27.5	Steel	1 hour
Sludge import buffer tank	1	670	Steel	1 week
Picket Fence Thickener	1	861	Steel	24 hours
Picket Fence Thickener	1	525	Steel	24 hours
Sludge blending tank	1	861	Steel	2 days
Primary Digester Tanks	2	1,304	Steel	18 days
Secondary Digester Tank	2	865	Concrete	4 days
Secondary Digestion GRP Tank	1	594	Steel	
Dewatering Feed Buffer Tank	1	670	Steel	24 hours
Liqour Balancing Tank	1	594	Steel	3 days

An inventory of potential odorous materials relating to the Sludge Treatment Centre Permit is shown in Table 4.2 below. Air Emission Points are listed, and the locations shown on the site plan in Figure C of Appendix 4.

Table 0.2 Odorous materials for Sludge Treatment Centre Permit

Odorous and potentially odorous material (any solid, liquid or gas)	Location of odorous materials on site	Maximum quantity on site at any given day	Maximum time held on site (hours or days)	EWC Codes	Type of Emission	Odour potential High Risk / Medium Risk / Low Risk
Cake (including imports)	Cake Pad	1250 tonnes	70 days	19 06 06	Diffuse	Low
Biogas	See Air Emission Point Plan	Gas holder capacity is 600 m^3.	Continuous operation	N/A	NA	Low
Liquor	Site drainage	Liquor is continuously pumped to the head of works	Continuous pumping of liquors from liquor return pumping well.	16 10 02	Diffuse	Low
Raw imported sludge	Sludge Import tank	Refer to Table 4.0 Site Tank Inventory	Retention times for each stage of the process are detailed in Table 4.0	19 08 05	Point Source (See OCU Entry)	Medium/High
Primary Sludge	PFTs.	Refer to Table 4.0 Site Tank Inventory	Retention times for each stage of the process are detailed in Table 4.0	19 08 05	Point Source (See OCU Entry)	Medium/High
Surplus Activated Sludge	SAS Thickening Plant	-	-	19 08 05	Diffuse	Medium/High
Sludge Screenings	Raw Sludge Import Tank	1 Skip	3 weeks	19 08 01	Diffuse	Low

Odorous and potentially odorous material (any solid, liquid or gas)	Location of odorous materials on site	Maximum quantity on site at any given day	Maximum time held on site (hours or days)	EWC Codes	Type of Emission	Odour potential High Risk / Medium Risk / Low Risk
Odour Control Units	See section 5	See section 5	-	-	Point Source	Medium

Table 4.2 Odorous raw materials for Sludge Treatment Centre Permit

Raw Material	Odorous	Storage	Mitigation	Odour Risk
Flopam EM840HIB Flopam FO4650MPM	mild odour	1. 2,000 L stored in 1,000L IBCs on portable bunds 2. 4.0 tonnes stored in bulk bags	1. Fully contained 2. Stored in building	Low
FloFoam H16	Mild odour	1,000L stored in IBC on portable bund	Fully contained	Low
Biogas	NA	NA	NA	Low
Liquid Propane	Odourless	6 tonnes in 3x 2 tonne in propane tanks	Fully contained	Low
Granular activated Carbon	Odourless	One tank for H2S filtration approx. 2.5 tonnes in storage tanks One tank for siloxane filtration approx. 2 tonnes in storage tanks	Fully contained	Low
O Scent Tertiarybutylmercaptane and Dimethylethylsulphide blend	Characteristic	50 litres in gas bottles	Fully contained	Low
Helium	Odourless	100 litres in gas gottles	Fully contained	Low
Nitrogen, other inert ga mixtures	Odourless	Minimal in gas bottles	Fully contained	Low

Low odour raw materials are chosen for use, as far as practicable.

4.3 Odour Control Measures

The SOM referred to above complies with Thames Water's Asset Standards – Operating Standards. It states the operational procedures to be followed in order to maintain and operate plant to agreed company standards. These standards include, where appropriate, procedures for ensuring that generation of odour is kept to a minimum. Refer to risk assessment in Appendix 1 where these measures are summarised.

4.3.1 Odour Control Units

OCU 1 (A7)

There is one Hibernia Odour Control Unit, filled with calcified seaweed. This unit covers the following process units:

- Sludge Import Tank
- Screened Sludge Pumping Station
- sludge import buffer tank
- sludge blending tank
- Picket Fence Thickener 1

OCU2 (A8)

A new odour control unit on Picket Fence Thickener 2 is an activated carbon filter.

There are two centrifugal extraction fans which extract air via ducting on the GRP roof section of the PFT tank.

4.3.2 Site Specific Measures and abnormal events

H4 has been used to guide the preparation of this OMP where it relates to activities regulated under the Sludge Treatment Centre Permit. As this guidance does not apply to UWWTD activities, where reference to H4 is made within this document this should not be inferred as H4 being applicable to UWWTD activities. Specific tasks and measures taken in intermittent, abnormal, and emergency events associated with the control of odours at Didcot STW are summarised in the tables below.

The routine operational tasks carried out at Didcot STW to specifically mitigate against generation of odour are also listed in the tables below.

Tables 4.3-4.7 - Summary of Critical Odour Issues, Emergency Response and Mitigation Measures

The purpose of Table 4.3-4.7 shall be to identify site specific emergency response procedures and mitigation measures relating to site odour generation and release. They include:

- Generic odour issues and mitigation measures relating to site-specific process stages; and,
- Additional site-specific odour issues and mitigation measures associated with process stages identified under the site Odour Risk Assessment.

Daily and weekly Site Round and Sludge Round checks are also carried out on each part of the process to ensure correct operation, these are shown in Appendix 5 and 6.

Table 4.3: Summary of routine odour mitigation tasks for assets under UWWTD

Odour source	Odour and offensiveness L/M/H	Specific odour management tasks	Responsibility	Monitoring	Monitoring Frequency	Trigger for action	Remedial Action and Timescale
General	General (L)	Ensure site is kept clean and tidy	Site Tech 1s Team Manager	Visual Inspection	Daily	Spillage identified.	Clean up as soon as possible and no later than the end of the day.
		Any spillages to be cleaned up as soon as practicable	Site Tech 1s	Visual Inspection	Daily	Spillage identified.	Clean up as soon as possible and no later than the end of the day.
		Site odour acceptability checked during site walkaround.	Site Tech 1s	Qualitative assessment	Daily	Elevated odour on site identified.	Reports to Performance Manager at team huddle/SAP Plus entry where corrective action identified. For a spillage; immediate/asap resolution.
Inlet SPSs Linked Tasks specified in Appendix 5 section 2.2	Raw Sewage (L)	A programme for self-cleaning has been introduced, where all four pumps run down individually 3 times a day.	Site Tech 1s	Visual Inspection	Daily	Spillage identified	Clean up as soon as possible and no later than the end of the day.

Cess Reception Linked Tasks specified in Appendix 5 section 2.1	Raw sewage and cess waste (M)	The area is daily cleaned at a minimum to minimise odour.	Site Tech 1s	Visual Inspection	Daily	Elevated odour on site identified.	Hose pipe available for clean up in the area. CCTV of the area. Reports to Performance Manager at team huddle/SAP Plus entry where corrective action identified. For a spillage; immediate/asap resolution.
Storm Tanks Linked Tasks specified in Appendix 5 section 2.6	Raw sewage (L)	A specialist contractor is called to clean the storm tanks when empty after a significant storm event.	Performance Manager		As required	Collected debris in storm tanks indicating attention to tank cleaning system needed, especially sensors and/or presence of debris outside of storm events.	Manual interventions to debris clearance are of high priority and the four storm tanks would be emptied and cleaned as soon as practicable after a storm. Any attention to sensors is through site tech 1 site round and within 8 hours.

Screens / Skip / Grit Removal / Grit Skips Linked Tasks specified in Appendix 5 section 2.3-2.5	Raw sewage and cess waste / Screenings / Sewage / Grit (L)	A specialist contractor is called to remove sewage, sludge screenings skips, and grit skips once full.	Performance Manager		As required	A specialist contractor is called to remove sewage, sludge screenings skip, and grit skips once full. Repair plant.	Removal of grit removal skips follows approach for screenings (although odour potential can be proportionally less).
Flow & Distribution to Primary Settlement Tanks	Raw sewage (L)		Performance manager/ Site Tech 1s	Visual Inspection	Daily	Elevated odour on site identified.	Find cause and resolve / Change tanks and clear blockage.
Primary Settlement Tanks Linked Tasks specified in Appendix 5 section 3	Settled sewage (L)	The PSTs are fitted with a scum removal system and a scraper. Both PSTs are automatically desludged under normal operations. The blanket level is manually monitored.	Performance manager/ Site Tech 1s	Visual Inspection	Daily	Clean tanks	The PSTs are fitted with a scum removal system and a scraper. Both PSTs are automatically desludged under normal operations. The blanket level is manually monitored.

Fats, Oil & Grease Scum Removal System	Sludge / FOG (L)	Clear blockage/ Skim tank. An auto skimming system is available on site.	Site Tech 1s	Visual Inspection	Daily	Scum board function compromised by excess material.	Removal of accumulated material in scum boards within 3 working days – if mechanical or blockage, a tanker/jetter will be needed and this should be done on a bimonthly basis.
Primary Raw Desludge Pumping	Raw Sludge (L)	Below ground	Site Tech 1s	Visual Inspection	As required	Failure of pump.	
Feed chamber to Secondary Treatment	Settled sewage and RAS (L)	Clear blockage	Site Tech 1s	Visual Inspection	As required	Spillage identified	Clean up as soon as possible and no later than the end of the day.
Activated Sludge Plant Lanes & Zones Linked Tasks specified in Appendix 5 section 4.1	Activated sludge (L)	Clean down/ Change over blowers	Site Tech 1s	Visual Inspection	As required	Blower failure.	Change over blowers. If complete failure LMC to supply temporary blower.
Flow & Distribution to Secondary Settlement	Activated sludge (L)	Clear blockage	Site Tech 1s	Visual Inspection	Daily	Flooding on site	Investigate root cause and repair by operation team as soon as possible.

Final Settlement Tanks Linked Tasks specified in Appendix 5 section 5	Settled effluent (L)	Divert flows/ Clear blockage/ drain down tank and clean/ Reduce flow to tank / Drop RAS bell mouth	Site Tech 1s	Visual Inspection / SCADA	Daily	Debris retained from drain out	Removal by Operational staff within 2 weeks. If pollution is prolonged notify the EA officer.
Scum Removal System	Settled effluent (L)	Clear blockage/ Replacement of pump (spare pump available on site)	Site Tech 1s/ M&E	Visual Inspection	Daily	Scum board function compromised by excess material. Blockage/ Complete failure of plant	Removal of accumulated material in scum boards within 3 working days – if mechanical or blockage, a tanker/jetter will be needed and this should be done on a bimonthly basis
RAS Chambers & Pumping Linked Tasks specified in Appendix 5 section 10	Activated sludge (L)	Set up an over pumping system.	PM / M&E / Tech 1	Visual Inspection/ SCADA	Daily	High and high high alarms. Pump failure	Repair within 2 hours, and/or set up an overpumping system. There are two separate streams.
SAS Chambers & Pumping Linked Tasks specified in Appendix 5 section 10	Activated sludge (L)	Below ground	Site Tech 1s	Visual Inspection/ SCADA	Daily	High and high high alarms.	Turn SAS pumps off and repair within 8 hours. There are two separate streams.

SAS Buffer Tank Linked Tasks specified in Appendix 6 section 3	Activated sludge (L)	n/a	Site Tech 1s	Visual Inspection	As required	Not identified	n/a
Pumping station	Settled effluent (L)	Duty/Assist/Standby pumps available on site.	PM / Tech 1	Visual Inspection	Daily	Pump failure	This will weir over to stream.
Filtration - Sand filters	Settled effluent (L)	Clean unit	Site Tech 1s	Visual Inspection	Daily	Unit drained down.	Clean unit
Back Wash Returns	Settled effluent (L)	Replace pump (spares on site)	M& E/ Site Tech 1s	Visual Inspection	Daily	Pump failure	Spares on site.
Final effluent	Settled effluent (L)	n/a	Site Tech 1s	Visual Inspection	As required	None identified (goes to stream)	n/a

Table 4.4: Summary of routine odour mitigation tasks for assets under Sludge Treatment Centre Permit

Odour source	Odour and offensiveness L/M/H	Specific odour management tasks	Responsibility	Monitoring	Monitoring Frequency	Trigger for action	Remedial Action & Timescale	Odour risk if measures fail
Sludge Import Tank Linked Tasks specified in Appendix 6 section 1	Raw sludge (L)	The imported sludge tank is covered, and odour controlled. Ensure tankers coupled correctly	Site Tech 1s	Visual Inspection	Daily	Lorries discharging into tank may lead to potential odour.	Built in vacuum filter	Medium

Cess Reception Linked Tasks specified in Appendix 5 section 2.1	Raw sewage and cess waste (M)	The area is daily cleaned at a minimum to minimise odour. Ensure tankers coupled correctly	Site Tech 1s	Visual Inspection	Daily	Elevated odour on site identified.	Hose pipe available for clean up in the area. CCTV of the area. Reports to Performance Manager at team huddle/SAP Plus entry where corrective action identified. For a spillage; immediate/asap resolution.	Medium
Rotmat Linked Tasks specified in Appendix 6 section 2	Raw sludge and rag (L)	Find cause and resolve	Site Tech 1s	Visual inspection	Daily	Plant failure/ Maintenance	Clean unit	Low
Screenings skip	Screenings (L)	Clean up spillage	Site Tech 1s	Visual Inspection	Daily	Overfilling/ Failure of collection	Engage with contractor	Low
Screened sludge PS	Raw sludge (L)	Covered and odour controlled. If fails replace pump / Spare pumps available on site	PM/ M&E/ Site Tech 1s	Visual inspection	Daily	Pump or OCU failure	Engage with contractor	Low

Sludge import Buffer Tank Linked Tasks specified in Appendix 6 section 3	Raw sludge (M)	The raw sludge holding tank is covered and odour controlled. If fails close imports and pump through to empty.	PM/ Site Tech 1s	Visual inspection	Daily	Failure of OCU/ Covers left open	Engage with contractors	Low
PFT - Raw sludge thickening Linked Tasks specified in Appendix 5 section 8.2	Raw sludge (L)	The Picket Fence Thickener is covered, and odour controlled. The blanket level is continuously monitored via the SCADA system.	PM/ M&E/ Site Tech 1s	SCADA	Daily	Failure of OCU/ plant failure/ 1 PFT out of service for maintenance	Find cause and resolve/ Clean Engage with contractor.	Medium
SAS Thickening & Pumping Linked Tasks specified in Appendix 5 section 8.3	Activated sludge (L)	Find cause and resolve	M&E/ Site Tech 1s	Visual inspection	Daily	Plant failure	Find cause and resolve	Low
Sludge Blending Tank	Raw and activated sludge (L)	The mixer buffer tanks are covered, and odour controlled.	PM/ Site Tech 1s	Visual inspection	Daily	Failure of OCU/ Covers left open	Engage with contractor	Low/Medium
Return Liquors	Centrate (M)	Below ground	N/A	N/A	N/A			Medium

Digester feed PS	Raw and activated sludge (L)	Covered and odour controlled	PM/ M&E/ Site Tech 1s	Visual inspection	Daily	Pump failure/ OCU failure	Replace pump / Spare pumps available on site Engage with contractor	Low
Primary Digestion Linked Tasks specified in Appendix 6 section 6	Raw and activated sludge (L)	Enclosed	PM/ TM/ Tech 1/ Contractor	Visual	As required	Release of biogas. Blockages. Failure of flare stack.	Stop digester feeding. Empty and clean digester. Find cause and resolve.	Low
Gas holder	Biogas (L)	Isolation system in place.	PM/ TM/ Tech 1	Visual inspection, process monitoring via SCADA and Cockpit.	As required	Leakage	Fix leak immediately. Isolate gas holder. If unable to repair leak, consider notifying EA officer.	Low
Biogas scrubbing plant	Biogas (L)	Enclosed	n/a	n/a	n/a	Out of service	n/a	
Secondary Digestion and Mixing Linked Tasks specified in Appendix 6 section 7	Digested sludge (M)	Rare/ high level warmings in place	Tech 1	Visual inspection	As required	Spillages Maintenance	Clean up spillages	Low

Dewatering Feed Buffer Tank Linked Tasks specified in Appendix 6 section 3	Digested sludge (L)	Rare/ high level warmings in place	Tech 1	Visual inspection	As required	Spillages Maintenance	Clean up spillages	Low
Press Feed PS	Digested sludge (L)	Below ground	n/a	n/a	n/a			
Beltpress Linked Tasks specified in Appendix 6 section 12	Digested sludge (L)	Enclosed in building with forced air ventilation	Tech 1	Visual inspection	As required	Door left open/ Spillages	Close door/ Clean up spillages	Low
Filtrate PS	Filtrate (L)	Below ground	n/a	n/a	n/a			Low
Conveyor	Pressed sludge (L)	n/a	n/a	n/a	n/a			Low
Cake Pad & Drainage (including imports) Linked Tasks specified in Appendix 6 section 16 and 17	Pressed sludge (L)	Cake in storage forms a crust after a day or two reducing risk of odour. No additional turning or handling during cake storage. Subject to pre acceptance checks. Tipper truck drop height less than 2m	Contractor/ PM	Visual inspection	As required	Poor quality cake/ Excess cake stored	Engage with contractor to remove cake.	Medium
Vehicle Movements & Wash Down	Pressed sludge (L)	Have to use wheel wash before leaving site.	M&E	Visual inspection	Daily	Failure of wheel wash	Repair wheel wash. Have a separate wheel wash on site.	Low

Waste Gas Burner Linked Tasks specified in Appendix 6 section 8	Biogas (L)	Rest pilot light	Tech 1/ Contractor	Visual inspection	As required	Failure to ignite/ Failure of gas burner	Find cause and resolve.	Low
Standby Generators	Diesel - Gas oil (L)	Hire stand by generator.	Contractor	Visual inspection	As required	Exhaust not working.	Find cause and resolve. Hire stand by generator.	Low
Gas to Grid *(to be reviewed upon commissioning)*		General housekeeping and maintenance	Tech 1	Visual inspection Maintenance	Daily As required			Low
Odour control units Linked Tasks specified in Appendix 5 section 9		Monthly performance checks by specialist Framework agreed contractors.	Site Tech 1s/Contractor	Monthly Monitoring, see section 5	Monthly	Failure of OCU/ maintenance of OCU	Engage with specialist contractor	Medium
		Check fan operational. On failure notify team leader for notification of maintenance team. Standby fan available.	Site Tech 1s	Visual Inspection	Daily	Failure of OCU/ maintenance of OCU	Engage with specialist contractor	Medium
		Check outlet H2S. On failure notify team leader for notification of maintenance team.	Site Tech 1s/team leader	Handheld equipment	Monthly	Failure of OCU/ maintenance of OCU	Engage with specialist contractor	Medium

		Routine check of washwater spray system, airflow, condition of drive, pH of drainage water, drain, surface of media, water filter	Site Tech 1s	As described in SOM	Monthly	Failure of OCU/ maintenance of OCU	Engage with specialist contractor	Medium
		Media is replaced as per TWUL asset standards.	Site Tech 1s	As described in Equipment Maintenance Standard	As required	Failure of OCU/ maintenance of OCU	Engage with specialist contractor	Medium

Table 4.5: Intermittent (Int), abnormal (Ab), and emergency (E) events for assets under UWWTD

Process stage	Event	Status	Ops mitigation	Expansion of TWUL operational response to odour under Int/Ab//E events	Odour risk after mitigation
Inlet pumping stations	During dry weather	Ab	None	Failure of a storm or dry weather pump would require utilisation of rolling critical spares. Up to 3 days to replace reflecting use of on-site crane. Limited odour risk from pump failure.	Low
	Asset failure on the network	E	Find cause and resolve		Low
	Failure of pumps	E	Find cause and resolve		Low
Cess Reception	Spillages	Ab	Hose pipe available for clean up in the area. CCTV of the area.		Low

Storm tanks	Failure of return pump	Ab	Critical spare available on site On-site cleaning of the storm tanks when empty after a significant storm event.	See previous coverage in Table 4.3.	Low
	Deposit in tanks after storm event	Ab	On-site cleaning of the storm tanks when empty after a significant storm event.		Low
Screenings	Plant failure	Ab	Find cause and resolve.	**Ab:** Loss of 1/2 of the screens would be significant for process operations. As within building, not particularly odorous but potential odour risk from screening handling present on tanker use.	Low
	Dry weather	Ab	None		Medium
Washpactor	Plant failure	Ab	Find cause and resolve.		Low
Skip	Failure of collection	Ab	A specialist contractor is called to remove sewage, sludge screenings skips and grit skips once full.	**Ab**: Skips only accumulate due to presence of liquids. Ramps and tankering used as appropriate. Coverings used.	Low
Grit Removal	Plant failure	Ab	Find cause and resolve / Empty tank and drain/ Critical spare available on site.		Low
	Tank drained down for maintenance	Int	None		Low
Grit skips	Failure of removal	Ab	A specialist contractor is called to remove sewage, sludge screenings skips and grit skips once full.	**Ab**: Skips only accumulate due to presence of liquids. Ramps	Low

				and tankering used as appropriate. Coverings used.	
Flow & Distribution to Primary Settlement Tanks	Dry weather	Ab	n/a		Medium
	Blockages	Int	Find cause and resove / Clear blockage		Low
PSTs	Dry weather	Ab	none		Medium
	Scraper failure	Ab	Find cause and resolve	**Ab:** operational response from couplings and motor issues within 2 weeks turnaround. **E** operation would be loss of 2/3 of the PSTs. Response would be to manually de-sludge with increased export.; 1 to 2 weeks to empty and then contractor support for up to 4 months if complicated repair with use of crane. Scraper failure referenced in Table 4.3.	Low
	Tank drained down for maintenance	Ab	none		Low
Fats, Oil & Grease Scum Removal System	Blockage	Int	Clear blockage		Low
	Asset failure	Ab	Skim tank. An auto skimming system is available on site		Low
Activated Sludge Plant Lanes & Zones	Lane drained down	Ab	Clean down		Low
	Blower failure	Ab	Change over blowers. If complete failure LMC to supply temporary blower.	**Ab:**Sufficient blower stand by capacity.	Low
Flow & Distribution to Secondary Settlement	Blockage	Ab	Clear blockage		Low

Final Settlement Tanks	Blockage	Ab	Divert flows / Clear blockage		Low
	Bridge scraper failure	Ab	Divert flows / drain down tank and clean		Low
	High blanket level	Ab	Reduce flow to tank / Drop RAS bell mouth		Low
	Tank drained down for tank inspection	Ab	Clean		Low
Scum Removal System	Blockage	Ab	Clear blockage		Low
	complete plant failure	Ab	Replace pump / Spare pumps available on site		Low
RAS Chambers & Pumping	Pump failure	Ab	Duty/Assist/Standby pumps available on site		Low
Pumping station	Pump failure	Ab	Duty/Assist/Standby pumps available on site		Low
Filtration - Sand filters	Unit drained down	Ab	Clean unit		Low
Back Wash Returns	Pump failure	Ab	Replace pump / Spare pumps available on site		Low

Table 4.6: Intermittent (Int), abnormal (Ab), and emergency (E) events for assets under Sludge Treatment Centre Permit

Process stage	Event	Status	Ops mitigation	Expansion of TWUL operational response to odour under Int/Ab//E events	Odour risk after mitigation
Sludge Import Tank	Lorries discharging into tank	Int	Built in vacuum filter		Medium
Rotmat	Maintenance	Int	Unit cleaned		Low
	Plant failure	Int	Clean unit / Find cause and resolve		Medium

Screenings skip	Overfilling	Ab	Clean up spillage / Engage with contractor		Low
	Failure of collection	Ab	Engage with contractor		Low
Screened sludge PS	Pump failure	Ab	Replace pump / Spare pumps available on site		Low
	Failure of OCU	Ab	Engage with contractor		Low
Sludge Import Buffer Tank	Failure of OCU	Ab	Engage with contractor		Low
	Covers left open	Ab	Close covers		Low
PFT - Raw sludge thickening	Failure of OCU	Ab	Find cause and resolve / Call contractor		Low
	Plant failure	Ab	Find cause ad resolve	Failure of the units impacts manually on upstream processes. **Int:** re-set unit. **Ab**: would be operational team re-setting or replacement. If mechanical/electrical part failure, a job raised within next working day to examine. **E:** If extended for more than c. 1 week consider supplementing process through exports. This issue would manifest itself in blanket levels which at c. 1m+ of sludge depth consider tankering out. Limited odour risk present from dismantling thickener; more potential for odour from emptying and	Low

				cleaning tank or if septicity present	
	One PFT out of service for maintenance	Int	Clean		Low
SAS Thickening & Pumping	Failure	Ab	Find cause and resolve		Low
Sludge Blending tank	Failure of OCU	Ab	Find cause and resolve/ engage with OCU contractor		Low
	Covers left open	Int	Close covers		Low
Digester feed PS	Pump failure	Int	Replace pump / Spare pumps available on site		Low
	Failure of OCU	Ab	Engage with contractor		Low
Primary Digestion	Release of biogas	Ab	Stop digester feeding		Low
	Blockages	Ab	Empty and clean digester	**Ab/E**: pH is key for process mgt control; monitored on daily basis. If pH drops below a trigger of c. 6.6 tank feed would be reduced & supplemented by tankering in instances of backing up. Temperatures are relatively stable (35-39 degrees as digester average) which minimises the definition of an **Int** event. An **Ab** event might constitute over-feeding of the digesters. **E:** risk of odour at below 6.6 pH would be responded to by ceasing feeding and likely need to re-seed.	Low

	Failure of flare stack	Ab	Find cause and resolve		Low
Gas holder	Leakage	E	Isolate gas holder	**Int/Ab:** Impaired availability of engine/boilers. **E:** failure of CHP engine &/or ground flare. If repair not possible, response would be recourse to a standby boiler/engine/flare to limit whessoe/PRV releases. Lead in time of c. 4 to 6 weeks. Potential for odour to be present from released biogas.	Low
Biogas scrubbing plant	Out of service	Ab	n/a		Low
Secondary Digestion and Mixing	Spillages	Ab	Clean up spillages	**Int:** drain line being blocked/grit build up but over extended timescales. **Ab/E:** drain or transfer line blocked requiring jetting. Low risk of odour; possibly short term from jetting. Timescales for arranging jetting at 3 wkng days through LMC. Lower odour risk from being digested sludge (“earthy”)	Low
	Taken out of service for maintenance	Int	Clean		Low
Beltpress	Door left open	Ab	Close doors		Low
	Spillages	Ab	Clean up spillages		Low
Cake Pad & Drainage(including imports)	Poor quality cake	Ab	Contractor to remove cake		Low
	Excess cake stored	Ab	Contractor to remove cake	The site holds digested cake**.** **Int:** failure of OCU which are re-	Low

				set. **Ab/E**: door failure. Low odour risk.	
Vehicle Movements & Wash Down	Failure of wheel wash	Ab	Repair wheel wash. Have a separate wheel wash on site.		Low
Waste Gas Burner	Failure to ignite	Ab	Reset pilot light		Low
	Failure of gas burner	Ab	Find cause and resolve		Low
Standby Generators	Exhaust not working	Ab	Find cause and resolve / Hire stand by generator		Low
OCU	Failure	Ab	Find cause and resolve/Call specialist contractor. Is duty assist stroke stand-by.	**E**: Complete failure the OCU units bigger odour risk relative to cake & liquors OCUs as **Int/Ab.** Consider temporary odour suppressant sprays for OCUs if cannot be re-started.	Low
	Maintenance	Int	n/a		Low

Table 4.7: General Intermittent (Int), abnormal (Ab), and emergency (E) events

Process stage	Event	Status	Ops mitigation	Expansion of TWUL operational response to odour under Int/Ab/E events	Odour risk after mitigation
Incidents and emergencies					
Fire	Failure of fans or sludge building	E	Use of SHTs for storage of sludge. Tanker from site		Low/Medium
Severe weather	Transport of sludge from site inhibited resulting in back up of	E	Event unlikely as there is provision for 60days storage on		Low

	sludge in site resulting in additional odour release from tanks and PSTs		site plus additional storage in the existing sludge holding tanks		
Flooding	Flooding causing process or equipment problems	E	Not an identified problem at Camberley. Site incident procedures would be followed.	Pumps/tankering arranged through LMC.	Low
Illness/absence of key staff	Accumulation of sludge/loss of odour control etc.	E	Task allocation is independent of individual staff.		Low
Power cuts	Loss of power to fan leading to loss of odour control	E	Emergency power generation for critical activities until power restored.	Greatest risk in persistent inclement weather where temporary external power outages might constitute the most likely externally generated risk. Recourse to temporary generators.	Low
Other incidents	Transport of sludge to land inhibited for other reasons leading to back up of sludge in site resulting in additional odour release from tanks and PSTs	E	Provision for 60days storage on site plus additional storage in the existing sludge holding tanks. Transport to other STWs if necessary	Pumps/tankering arranged through LMC.	Low

4.3.3 Spillages

Spillages significant enough to cause odorous emissions will be cleared as soon as practicable. The person discovering the spillage will inform site management, who will utilise resources as required to clear it.

4.4 Routine Monitoring

Overall plant performance is assessed daily as part of the generic Site and Sludge inspections rounds, which apply to Thames Water large STW sites, and have been included in Appendices 5 and 6, respectively.

The objective of these is to ensure that treatment processes, including odour control, are checked for effective operation as per the SOM. Any of the checks that result in performance of the process outside of the limits defined in the SOM or a fault being detected will require an Operator to change the process to bring the plant back into acceptable limits or the fault needs to be logged and reported for follow up maintenance/repair.

Where remedial actions are identified from any source these are listed in Tables 4.3 & 4.4 with expected durations accompanying rectification. The timescales given are indicative or illustrative but are informed directly by operational experience. Repairs requiring capital funding will take longer as they are directly informed by complexity and will be bespoke to the issue(s) identified.

Various process parameters are monitored using a combination of online instruments (to measure flows, temperatures, pressures, levels); samples that are taken to our UKCAS accredited laboratories or run through sampling tests at the on-site laboratories (%DS, pH, alkalinity, ammonia).

The online instruments all have signals that are taken back to the site SCADA system and these ‘alarm’ if the readings are outside pre-set trigger points. Similarly, laboratory analysis samples will have expected ranges, which if outside of these, a notification is sent to the site process controllers.

In all instances that parameters are out of ‘range’, the operational teams will carry out an investigation to understand the cause and initiate corrective actions. If the reasons are not obvious, the process optimisation team is contacted to evaluate further.

Additionally, each week the various recorded parameters are recorded in the site Cockpit reports to look at trends. These are used to establish if there are gradual changes in performance over time so that early intervention can be carried out.

A range of process parameters are subject to routine monitoring or checking to ensure that the digestion process is operating optimally so that the required sewage cake output quality is achieved.

- **pH:** At a conventional digestion site such as Didcot the processes is maintained around pH 7 but within the range 6.72 – 7.6 (this is % dry solids and digester load dependant) for healthy operation.
- **alkalinity:** Levels dependant on feedstock characteristics (primary sludge: surplus activated sludge (SAS) ratio). Conventional digestion typically, 3,500 - 5,000mg/litre range.
- **temperature:** minimum target of 38°C. This is maintained within the range 36-40°C.
- **HRT (hydraulic retention time):** minimum target is 15-days, there is no upper limit. Retention times shall not be less than 12-days during plant outages to keep the product pathogen kill efficiency control.
- **OLR (organic loading rate):** see table below - this is dependent on the primary/SAS ratio. Didcot fits into the first row of the table.

- Dry solids feed: see table below, Didcot has a target of 6%DS, but this can vary between 3-8%DS and impacts the HRT.

Type of Digestion	0%- 35% SAS[x]	36%- 45% SAS	46%- 50% SAS	51%- 55% SAS	>55% SAS	Max Feed %DS
MAD* in Conventional Digestion	3	2.5	2	1.75	n/a	6
MAD after Pre-pasteurisation	4.5	4	3.5	3	n/a	7
MAD after Acid Hydrolysis	4.5	4	3.5	3	n/a	7
MAD after Thermal Hydrolysis	7	6.5	6	5.5	5.5	14

* mesophilic anaerobic digestion
[x] surplus activated sludge, arising from the UWWTD treatment route.

- **VFA** (volatile fatty acid) concentration: There is no specific range for VFAs as it depends on the feedstock. It is used as an indicator of digester health rather than a process control. The production of organic acids depends on the volume of solids fed to the digester. The typical range for VFAs in a Primary Digester Tank is between 50 and 800 mg/L. When VFA concentrations climb above 1000 mg/L, the digester could be overloaded or experiencing other problems.
- **Ammonia:** Ammonia concentrations of 50 to 1000 mg/L are beneficial, but ammonia levels of 1500 to 3000 mg/L (pH greater than 7.4) could be inhibitory but not always. An ammonia concentration higher than 3000 mg/L for prolonged period is toxic.
- **VFA to Alkalinity ratio:** Very important parameter to monitor for digestion process. The VFA to alkalinity ratio of below 0.4 is good and above this threshold value means diminishing alkalinity and low pH i.e., sour digester content. As long as this ratio is maintained higher VFA and alkalinity digester content can be acceptable and the digestion process is deemed healthy. Anaerobic digestion process is always controlled based on holistic parameters based but not based on single parameter.

Odour monitoring is carried out following receipt of an odour complaint. See section 6.3 Investigation a complaint for full details.

Sniff Testing

Sniff testing has been incorporated into our Odour Improvement Plan (Appendix 2). This is to allow time to ensure that the most effective sniff testing can be carried out using personnel not sensitised to smells on site.

The procedure will be undertaken in response to complaints or if a risk of odour nuisance at sensitive receptors is expected and/or has been substantiated.

- Sniff testing will be carried out at by someone not routinely based at site, who are less sensitised to odour produced on site.
- Assessing potential odour sources within the Urban Waste Water Treatment (UWWT) and Sludge Treatment Centre (STC) processes and attempt to trace the odour to its source.
- The procedure and recording form which will be used can be found in appendix 7 of the OMP.

Further details of routine monitoring tasks are included in the Site Operating Manual.

4.5 Record Keeping

Records of routine monitoring, site and sludge inspection rounds and sludge blanket checks are kept on SAP. Records of skip management, which collect wastes generated from UWWTD activities, and any spillages and remedial actions are held in the ELogbook.

There is a SCADA system on this site.

A monthly condition report on the OCUs is sent to the team manager by the contractor and stored on SharePoint.

4.6 Emergency Response and Incident Response Procedures

Emergencies such as fire, flood and severe weather are managed by Thames Water's Incident Management and Business Resilience team. The processes employed can be found on Thames Water's SharePoint site and are entitled: 'Incident Management Arrangements'. This is a company confidential document and therefore, is not included in the Appendices of this document.

Hazard reporting and accidents are all recorded on the Health and Safety software database SpheraCloud (https://sphera.com) and monitored by Thames Water's Safety, Health & Wellbeing team.

In the event of power failure, the site will run on island mode for the entire site. However, as this doesn't include the odour control units there is a potential temporary risk of odour until power is restored. Absence of key staff should not affect the running of Didcot STW, as Tech 1s from other sites can be called upon to cover, if required.

Tables 4.3 to 4.7 respond to the identification of relevant triggers and actions to minimize odour. OCU monitoring is also included. Monitoring of odour release to atmosphere for wider sludge treatment assets is constrained by sludge containment (say versus an open composting operation), the lack of a confined emission point and the episodic nature of odour release and exposure.

Our Operations Team and odour contractor have recommended consideration of the following techniques either proactively (so accompanying planned or reactive works with known odour risk) and in an investigative capacity attached to an incident:

(a) Targeted use of 'Jerome' hydrogen sulphide analysers
(b) Targeted use of sniff tests ('calibrated nose')
(c)H2S measurements of stored materials where septicity is either present, or the material is at risk of septicity from continued storage especially in the open air, for example, prior to de-watering where measurements of sulphide & dissolved O2 would inform a condition assessment. Quantities and storage times precipitating a need for such assessments. This recommendation is being raised with the Area Process Scientist.
(d) Inclusion of temporary odour suppressants/misting agents and continued access to process critical spares (odour minimisation by early intervention).
(e) Further expansion of odour risk within site incident planning (this is already referenced in Tables 4.5, 4.6 & 4.7 under relevant Intermittent; Abnormal Operation & Emergency scenarios)
(f) Temperature assessment in secondary digester tanks on the basis that increased temperatures give greater potential for volatilisation of odours
(g) For PSTs, asset condition (wear/damage) would consider odour risks where assets are taken offline
(h) Telemetry/alarming of whessoe valve releases – there is an existing phased project within TWUL to enhance this at our sludge locations).

5 Maintenance and Inspection of Plant and Processes

5.1 Routine Maintenance

5.1.1 General Requirements

Site staff have a schedule to ensure routine maintenance for key mechanical items. In addition, a dedicated maintenance team provide additional support for more specialised equipment, e.g. regular calibration of Dissolved Oxygen probes.

In addition to the routine operational tasks, planned preventative and defect maintenance of plant is carried out. Plant which may have an impact on odour release is assigned an appropriate criticality rating to ensure effective performance is maintained. Plant assessed to be odour critical is listed in Section 4.2.3 above.

All maintenance procedures are detailed in the SOM, and when carried out is captured on the corporate system SAP, which generates work requests for the various activities for the treatment process assets at the appropriate frequency.

5.1.2 OCU selection and performance validation

OCU 1(A7)

For continuous operational monitoring, system incorporates:

- Visibility of fans on SCADA, with alarms, for loss of extraction from odorous sources
- OCU failed Alarm

For period monitoring:

- Inlet and outlet Hydrogen Sulphide concentrations recorded and assessed for removal efficiency and below maximum designed inlet loading during monthly inspections. Following the monthly inspections, hydrogen sulphide concentrations are trended by ERG which would enable identification of a decrease in H2S removal. Should this occur, ERG would include this in the recommendation section of their inspection report, for example media replacement.
- System integrity checked during daily site rounds and monthly inspections to confirm extraction points and routes undamaged.

OCU 2 (A8)

Design inlet H2S	50 (average) 150 (maximum)
Design removal efficiency	99%
Design humidity	70%
Design inlet air flow	100 Am3/hr
Media	Deep bed carbon filter

For continuous operational monitoring, system incorporates:

- Visibility of fans on SCADA, with alarms, for loss of extraction from odorous sources

- OCU failed Alarm

For period monitoring:

- Inlet and outlet Hydrogen Sulphide concentrations recorded and assessed for removal efficiency and below maximum designed inlet loading during monthly inspections. Following the monthly inspections, hydrogen sulphide concentrations are trended by ERG which would enable identification of a decrease in H2S removal. Should this occur, ERG would include this in the recommendation section of their inspection report, for example media replacement.
- System integrity checked during daily site rounds and monthly inspections to confirm extraction points and routes undamaged.

Evidence of the systems continuing ability to treat the input flow are confirmed by monthly inlet and outlet odorous gas (hydrogen sulphide) concentrations. Examples of such reductions are given in 5.1.3 iii) of the OMP

5.1.3 Maintenance and Monitoring of Odour Control Units

Operation and maintenance of OCUs is delivered in accordance with the Company's Asset Standards and Equipment Maintenance Standards. This is either delivered in house by Operations or outsourced to contractor. Refer to the Odour Control Unit Asset Standard and Site Operating Manual for more information.

The scope of this table includes anticipated monitoring requirements of emissions to air from the OCU outlets; TWUL's own site round checks as they pertain to OCUs; followed by a further five key performance indicators reflecting discussion with our specialist OCU inspection contractor as of greatest relevance to Didcot.

Table 5.1: Monitoring and maintenance of Odour Control Units

Parameter	Monitoring Method	Action if red flag identified and Expected timescales	Frequency	Biofilter	Carbon	Chemical scrubber
Performance monitoring						
Gas inlet temperature (5-40C)	Temperature probe	Investigate any anomalies relating to temperature, such as individual process checks	Monthly	X	X	X
Gas outlet temperature (5-40C)	Temperature probe	Investigate any anomalies relating to temperature, such as individual process checks				
Gas inlet flow rate or velocity (6m/sec)	Calibrated velocity meter	Investigate any anomalies relating to flow rates; velocities and pressure drop across the system by measuring the inlet and outlet pressure. Check fan functionality; presence of obstructions; bring forward contractor service. If fan replacement needed c. 2* months minimum typical duration depending on severity of issue/condition of back up fan (*time of order to mobilisation; assumes second duty fan runs; timescale includes time to install replacement and fabrication). If solely an electrical issue, recourse to TWUL ICA Technician mostly likely within a week. Other root causes are usually blocked media; duct and failure of non-return dampers around fan sets.	Monthly	X	X	X
Gas outlet flow rate or velocity (6m/sec)	Calibrated velocity meter					
Gas inlet humidity (Post biofilter humidification > 90% Carbon units <70%)	Hygrometer	Check any preheaters fitted to system before carbon, or check irrigation is working on biofilter.	Monthly	X	X	-
Back pressure (to assess media thatching or media compaction) Typically systems work around 0.5 kPA	Calibrated digital pressure meters	Values above threshold would be 'RAG' banded in the OCU contractor inspection reports. If pressure gauges are over-pressurised to the extent fouling is or has occurred to be treated as high priority. Check for blockages, poor FFE quality/check if media is of a type susceptible to biodegradation.	Monthly	X	X	X

pH of discharge irrigation water (2-3pH)	pH paper	Less than 2 increase irrigation.	Monthly	X	-	-
pH of scrubber liquor (9.2 pH)	Calibrated pH probe (calibrated with standard solutions)	Recalibrate pH probe and check dosing and chemical availability	Continuous	-	-	X
Redox potential of scrubber liquor (700-730 mV)	Calibrated redox probe (calibrated with standard solutions)	Recalibrate redox probe and check dosing and chemical availability	Continuous	-	-	X
Gas inlet/outlet concentrations for hydrogen sulphide (50ppb used for media change out)	Drager Tubes/CEN TS 13649 for sampling NIOSH 6013 for analysis OR US EPA M11*	Check functionality of odour control unit. If repair or replacement media required raise a job on SAP or APS risk and arrange for contractor repair. Timescale Bespoke to root cause/see later entries. Arrange re-test post remedial work. Major repairs up to 6 months depending on complexity	Monthly/ 6 monthly	X	X	X
Gas inlet/outlet concentrations for ammonia (20mg/m3)	EN ISO 21877 OR CEN TS 1369 for sampling NIOSH 6016 for analysis*	Check functionality of odour control unit. If repair or replacement media required raise a job on SAP or APS risk and arrange for contractor repair. Timescale Bespoke to root cause/see later entries. Arrange re-test post remedial work. Major repairs up to 6 months depending on complexity	6 monthly	X	X	X
Gas inlet/outlet concentrations VOCs and RSH	RSH – Drager tubes VOC – PID as isobutylene		Quarterly	x	x	x
Maintenance checks and inspections						
Check integrity of tank covers for damage and ensure access hatches are closed		Close hatches ASAP	Daily	X	X	X
Check building & door integrity for damage or leakage; doors closed (if required)		Closed doors ASAP	Daily	X	X	X
Check damper positions on ductwork are in the correct positions		Correct positioning	Daily	X	X	X

Check irrigation and humidification systems are functioning	Turn on systems or investigate malfunction.	Daily	X	-	-
Check for free discharge of effluent from drain	Investigate blockage	Daily	X	-	-
Check irrigation water supply is working at required rate	Visual check on flow gauge, investigate if required.	Monthly[1]	X	-	-
Check condensate removal points for free flow of liquid	Visual check	Daily/Monthly[1]	X	X	X
Check OCU condition for signs of damage or leaks	Call specialist contractor if identified	Daily / Monthly[1]	X	X	X
Check general ductwork for signs of damage or leaks	Condition of ductwork would be 'RAG' banded in the OCU contractor inspection reports. If broken, then odours not being conveyed to OCU and can be indicated by low inlet load. Worst case the ductwork is disconnected ('sucking air') such that odour removal is not taking place.	Daily / Monthly[1]	X	X	X
Check spray pattern from irrigation nozzles and clean nozzles as required	Adjust spray pattern, clean the strainer and unblock nozzles or replace as deemed necessary. Timescale durations of c. 2 weeks where just irrigation required.	Daily / Monthly[1]	X	-	X
Check flexi joints between fans and ductwork for leaks	Contractor inspection reports 'RAG' band these issues with a level of detail to then inform the maintenance response. Timescale durations of 1 to 2 months typical depending on complexity (time of order to mobilisation)	Monthly	X	X	X
Check fans for excessive vibration or noise, belt tension and bearing temperature	Contractor inspection reports 'RAG' band these issues with a level of detail to then inform the maintenance response. Timescale durations of 1 to 2 months typical depending on complexity (time of order to mobilisation)	Monthly	X	X	X
Check irrigation water pH	Contractor inspection reports 'RAG' band these issues with a level of detail to then inform the maintenance response. Timescale	Monthly	X	-	-

	durations of 1 to 2 months typical depending on complexity (time of order to mobilisation)				
Check irrigation pumps condition and operation	Contractor inspection reports 'RAG' band these issues with a level of detail to then inform the maintenance response. Timescale durations of 1 to 2 months typical depending on complexity (time of order to mobilisation)	Monthly	X	-	
Check chemical reagent levels and supply	Order when required. Ensure no low-level alarms.	Weekly	-	-	X
Check chemical dosing and blow down pump condition and operation	If outside pH levels, investigate. Initiates blow down to correct level.	Daily/Monthly	-	-	X
Check blow down rate is within correct range	If outside pH levels, investigate. Initiates blow down to correct level.	Monthly	-	-	X
Check ph and Redox probes are working and in calibration	Contractor inspection reports 'RAG' band these issues with a level of detail to then inform the maintenance response. Timescale durations of 1 to 2 months typical depending on complexity (time of order to mobilisation)	Monthly	-	-	X
Check recirculating liquor strainer and replace if necessary	Flows recorded on SCADA	Monthly	-	-	X
Check water softener is working correctly (if installed)	Water hardener test papers used to check water quality.	Monthly	-	-	X
Check dampers are operational and in good condition	Swap over duty fan to stand by fan and record flow volumes to identify issue.	Monthly	X	X	X
Inspect electrical control panel and check for faults and alarms	Visual inspection by monhtly contractor and investigation any alarm conditions.	Monthly	X	X	X
Simulate duty / standby fan and pump changeover	Contractor inspection reports 'RAG' band these issues with a level of detail to then inform the maintenance response. Timescale durations of 1 to 2 months typical depending on complexity (time of order to mobilisation)	Monthly	X	X	X

Check H_2S meter is functioning and calibrated (if installed)	Check calibration is still in date during monthly contractor inspection.	Monthly	X	X	X

*Only required on OCUs covered by STC permit

Condition of the media in the OCU is monitored by performance checks and by additional testing as required.

The OCUs at Didcot are covered by a service and maintenance contract. They are inspected on a monthly basis and reports are sent to site management. Figure 5.1 below highlights the scope of work required from our OCU Maintenance Contractors through their monthly visits. Monitoring during the visits is as follows:

- Monthly – flow (m^3/h), differential pressure(kPa) and hydrogen sulphide (ppm) at both the inlet and outlet. Where applicable, monitoring may also include fan hours run and removal efficiency of hydrogen sulphide.
- Quarterly – VOC (ppm) and mercaptans (ppm) at the inlet and outlet.

The OCU biofilters are specifically designed to minimise the release of odour, bioaerosols and microorganisms.

and associated physical properties are all important to OCU function and are described below:

(i)Optimum flow rate through the system to allow for effective treatment.

A '**Maximum velocity in duct work'**; rather than volume; is the key design aspect informing effective treatment for new/existing OCUs. Not exceeding 10m/second in a piece of ductwork will avoid noise break out; the industry benchmark for new plant being 8m/second. Given velocity is directly related to the volume; the specification is +/- 20% to reflect instrumentation variation; and therefore all 1 x 2 OCUs are checked to see ***if they can meet 6m/second*** with escalation in monthly contractor inspection reports where this value is not reached. This is a good indicator of functionality, appropriate sizing, and system health.

ii) The trigger levels/ranges for action if processes monitoring parameters are breached/ outside optimal parameters.

All OCUs, irrespective of media type, *will stipulate a minimum of 30 seconds* ***retention time***, for a a biofilter to achieve a minimum of 95%, removal efficiency. A minimum of 2-3 seconds retention time for a carbon filter is stipulated.

H2S readings are reported in the monthly service reports which inform odour equivalents (OEs). The accepted OEs for H2S at 0.5 part per million is equivalent to 1,000 odour units. A "red action" would be raised for any value 0.5 parts per million off the biofilter/carbon filter.

Trigger levels are more difficult to identify for other parameters, such as mercaptans and ammonia since the design assumptions for OCUs are informed by H2S removal. Removal for these parameters is therefore limited. For Total VOCs, *in respect to methane rather than small chain VOCs*, there is no removal.

From a qualitative value, from visual inspections, 'red flags;' would include if irrigation pipework to the biofilter is broken (no water entry to media); neither extraction fan running; broken ductwork leading to the OCU sucking in atmospheric air.

On identification of such red flags, such that the effective function of the OCU is at risk of being compromised, the following actions would be taken:

(i) For significant issues relating to any aspect of 'condition monitoring' - including effective function of the biofilters - impacting upon parameter reductions at the inlet/out; differential pressures or irrigation volumes – the Performance Manager would urgently contact Head of Maintenance at ERG to book in reactive maintenance attention. Timescales would be of highest priority but response times/duration dependent on the issue identified

(ii) For issues relating to housekeeping (leaks) or issues relating to OCU power supply (electrics) – for example, impacting either fan operation - these would be referred to a TWUL Electrician for assessment and either rectified by the area operational team or escalated to an external contractor where repairs are more complex. Timescale for expectation of resolution would typically be within 24 hours.

For either (i) and (ii) if any significant pollution risk (odour) was identified the Performance Manager would contact TWUL's incident help desk. A supporting risk would be recorded in APS (risk assessment software) to support funding where a need for remedial works was identified.

iii) Odorous components in the gas stream and concentrations of emissions

The monthly contractor inspections of each OCU provide data for H2S; VOC; Mercaptans (RsH). The sampling methodology being Drager (gas analysis) tube for c. 30 seconds to 2 minutes duration.

To achieve an appropriate level of surveillance on OCU performance, outside of the contractor monthly inspections, there is additional oversight from the Operations Management Team through:

- Visibility using local SCADA control panels for OCU , which records fan status
- Daily site rounds by Thames Water technicians. These are Psion based checks using SAP Plus for escalations including, for example, internal MANDAT tickets or identifying a need for contractor support. The tasks in the daily checks mirror the numbered tasks in the contractor 'Monthly Health Checks'. See Figure 5.1 and section 9 in Appendix 5 in the OMP. There is connectivity between the site rounds and SCADA, for example, if excessive noise is recorded this could relate to an operational fault in OCU, and in turn, is visualised on the local SCADA screens.

iv) Physical properties of the air stream at point of control i.e., humidity, optimum temp, pH for effective odour control

For **humidity**, *the gas is humidified before being received by the biofilter,* so this parameter has less relevance. Biofilter post humidification should achieve a level of >90%. Carbon units should be set at <70%.

For **temperature**, this is fairly constant throughout the year as this is informed by the need to achieve fairly constant temperatures in the digestion process. A range of 20 to 40^{o}C being standard.

pH will be slightly variable depending on the H2S that is there from the condensing air stream contributing to SO2 formation. This tends not to be an issue at the biofilter itself since the active component of the biofilter will in itself produce SO2 as a waste product from converting the H2S.

pH off a bio-scrubber is checked on the quarterly inspections since it might suggest an issue with the active component of the biofilter being impacted by the accumulation of its waste product thereby making the lower part of the bed inactive. A pH of 2 to 3 would be expected as a theoretical upper limit to liquor discharged from the biofilter but recorded values are significantly less; pH 4 to 5 being

typical (reflecting the logarithmic scale). Note if efficiency of the process is being impacted; pH would also be part of the investigative checks (i.e., more than quarterly).

Figure 5.1 – Monthly OCU Health Checks

Monthly Health Checks

Biofilter

Please enter any comments you may have in the yellow comments boxes

Number	Task	Comments
1	Examine ductwork for any signs of damage or leaks and check condensate drains are free flowing	
2	Visually inspect the Odour control system will be made and any defects or deterioration of the housings will be reported.	
3	Check the airflow through the system and any anomalies investigated.	
4	Measure the pressure drop across the system by measuring the inlet and outlet pressure. Record any abnormalities	
5	Measure the contaminate levels (primarily H2S) at the inlet and at the stack	
6	Check visually all fans, check for excessive noise and report any necessary maintenance to be undertaken as applicable.	
7	Examine the irrigation system to ensure correct operation including spray pattern, clean the strainer and unblock nozzles or replace as deemed necessary.	
8	Take a sample of the drainage water and measure the pH value and compare to target pH value (this is not pH 7 for modern biotech)	
9	Check all hatches and doors for integrity and ensure they are closed	

Chemical Scrubber

Please enter any comments you may have in the yellow comments boxes

Number	Task	Comments
1	Examine ductwork for any signs of damage or leaks and check condensate drains are free flowing	
2	Check visually all fans, check for excessive noise and report any necessary maintenance to be undertaken as applicable.	
3	Visually inspect the Odour control system will be made and any defects or deterioration of the housings will be reported.	
4	Check the airflow through the system and any anomalies investigated.	
5	Measure the pressure drop across the system by measuring the inlet and outlet pressure. Record any abnormalities	
6	Measure the contaminate levels (primarily H2S) at the inlet and at the stack	
7	Check visually all fans, check for excessive noise and report any necessary maintenance to be undertaken as applicable.	
8	Examine the recirculation pumps and distribution pipework to ensure correct operation, clean the strainer and check trough / distributor.	
9	Carry out a functional check of the dosing system ensuring target pH and Redox are achieved, and validate the probe calibration using a handheld unit	
10	Calibrate if necessary	
11	Visually check the seals of all hatches note any leaks.	
12	Visually check the wet scrubber housing, note any significant deterioration	
13	Scrubber dosing cabinet - Check chemical dosing pumps for leaks	
14	Scrubber dosing cabinet - Check that dosing rates are correct	
15	Scrubber dosing cabinet - Check all valves, instruments and pipe-work for leaks	
16	Scrubber dosing cabinet - Check inside of cabinet for chemical residue and dirt and wash if necessary	
17	Scrubber dosing cabinet - After wash down check catch-pot high level alarm is working before draining	

Carbon Adsorber

Please enter any comments you may have in the yellow comments boxes

Number	Task	Comments
1	Examine ductwork for any signs of damage or leaks and check trapped condensate drains are free flowing. If a manual drain valve is provided, operate the valve until the flow of condensate ceases and leave valve in closed position.	
2	Check visually all fans, check for excessive noise and report any necessary maintenance to be undertaken as applicable.	
3	Visually inspect the Odour control system will be made and any defects or deterioration of the housings will be reported.	
4	Check the airflow through the system and any anomalies investigated.	
5	Measure the pressure drop across the system by measuring the inlet and outlet pressure. Record any abnormalities. Read off Delta-P gauge if fitted or using a portable manometer	
6	Measure the contaminate levels (primarily H2S) at the inlet and at the stack	
7	Check visually all fans, check for excessive noise and report any necessary maintenance to be undertaken as applicable.	

5.1.4 Records

Maintenance history records are kept electronically on SAP or the company's SharePoint system.

5.2 Fault Reporting

Faults identified during routine inspections are reported to the Performance Manager who assesses criticality before entering the task into the job scheduling system for allocation to an appropriate person and to a timescale appropriate to the criticality.

5.3 Emergency Repairs

24-hour maintenance cover is available at the discretion of the Performance Manager or Duty Manager, with planned follow up.

Less urgent repairs are assessed for criticality and dealt with during normal working hours.

6 Customer Communications

6.1 Customer Odour Complaints Process

Customer contacts regarding Didcot STW will be made via the Customer Services Centre, Operations will investigate and take appropriate action. Complaints may also be received from the local council and Environment Agency.

Customers / residents are encouraged to communicate with local Thames Water Operations via the Customer Centre to report if they are noticing odour from Didcot STW, to ensure that all contacts are recorded and actioned.

Customers have 3 main options to report complaints to Thames Water:

1. Thames Water Website – "Report A Problem" at https://www.thameswater.co.uk/contact-us/report-a-problem/report-a-problem-online.

2. Email - customer.feedback@thameswater.co.uk with the subject 'Didcot Sewage Treatment Works'

3. Telephone - Thames Water Customer Services 0800 316 9800

If the customer / resident would prefer to contact either South Oxfordshire District Council or the Environment Agency instead, their contact details are as follows:

South Oxfordshire DC – Environmental Services
Telephone: 01491 823416

Environmental Agency -
Telephone: 0800 807060

Customer contacts regarding Didcot STW that are received directly on site are responded to by the local Operations team. The Performance Manager, at the earliest opportunity, will inform the Customer and Stakeholder Manager (CSM) of the contact details in order that they can ensure the complaint is captured and recorded by the Customer Services Centre.

Complaints received via Customer Services Centre:

- Complaint information is logged electronically by the Customer Services Centre.
- An action is raised to Waste Operations Control Centre (WOCC) who contact the CSM by telephone and email the complaint information to both the CSM and Performance Manager
- The Performance Manager and CSM will review the complaint and take action to investigate (see section 6.3)
- The CSM is responsible for contacting the customer and updating them on the outcome of the investigation.
- Any problems are noted and remedial work actioned. An update of action taken and feedback given to the customer is emailed to the WOCC by the CSM.
- The WOCC update the electronic complaint report and it is closed down.

Complaints received via email or post:

- Complaint information is logged electronically by Customer Relations and allocated a Case Manager.
- The complaint is emailed to the CSM who reviews the complaint and investigates with the Performance Manager (see section 6.3).
- Actions taken are emailed back to the Case Manager who updates the electronic system and updates the Customer.

Complaints received via Customer Centre out of normal working hours

- For a large number of calls, or serious concerns, the Out of Hours Coordinator will be contacted to respond.
- For all other calls Didcot STW site management will investigate and respond the next working day.

6.2 Customer Communication Plan

The Customer Communication Plan in Appendix 3 identifies how and when contact will be made with customers and stakeholders in relation to stable, abnormal and emergency site operation.

6.3 Investigating a complaint

Upon receiving a complaint Thames Water have 24 working hours to respond to the customer with an update. Within these 24 hours, the CSM will contact to the Performance Manager who will carry out an investigation to determine whether the odour source is coming from the Thames Water site. If the odour is decided to be from the Thames Water site, then the root cause is investigated.

Should the source of the odour be confirmed as coming from the Thames Water Operations then the Performance Manager will review all activities currently taking place on site, including any maintenance, cleaning, and non-standard activities to identify the root cause, and ensure appropriate mitigation measures are in place.

If the Performance Manager cannot identify the source of the odour, but complaints persist, the CSM will ensure the customer who made the complaint is contacted and obtain further details. These details include their address in relation to the site location, the time of occurrence and for how long. If odour problems continue to persist, Thames Water may even ask the customer to keep a detailed odour diary to ensure their issue can be fully addressed.

The root cause investigation may include site walkaround checks, which look for irregularities such as spillages / open doors and hatches, ensuring appropriate measures as detailed in table 4.3-6 are in place. It may also include off-site visits to the Customer location.

When the root cause of the odour is found, the Customer will be updated with an explanation and provided with a timescale for its resolution. Furthermore, the situation is assessed for hazards to determine any possibility of health risk to the local community.

To ensure any limitations regarding everyday staff becoming desensitised to the odour, if site odour complaints persist with no result in locating its source, personnel who do not spend prolonged time on a single site, such as the Area Operations Manager, will participate in the walkaround checks.

6.4 Notification of Operations with Potential to Cause an Odour Problem

Where operations may impact on local residents, notification will be made to the Customer Centre who will log the details on their Bulletin Board. This will be used to provide information directly to customers who call with queries. Letter drops may also be used.

The Environmental Health Officer of South Oxfordshire District Council will be contacted directly if there are risks of odour generation (e.g. digester cleaning, tank cleaning or process issues). NOTE: This will only take place on known sensitive sites where Local Authorities and the EHO are already involved.

For assets under STC permit, we notify the EA in accordance with the permit conditions and notifications procedure, see appendix 3.

If notified by the Environment Agency that the activities are giving rise to pollution outside the site due to odour, Thames Water shall investigate and carry out a review of the OMP and appropriate measures if deemed necessary.

Appendices

Appendix 1. Odour Risk Assessment

AM-OMP%20Didcot%20STW-RA.xlsm

Appendix 2. Odour Improvement Plan

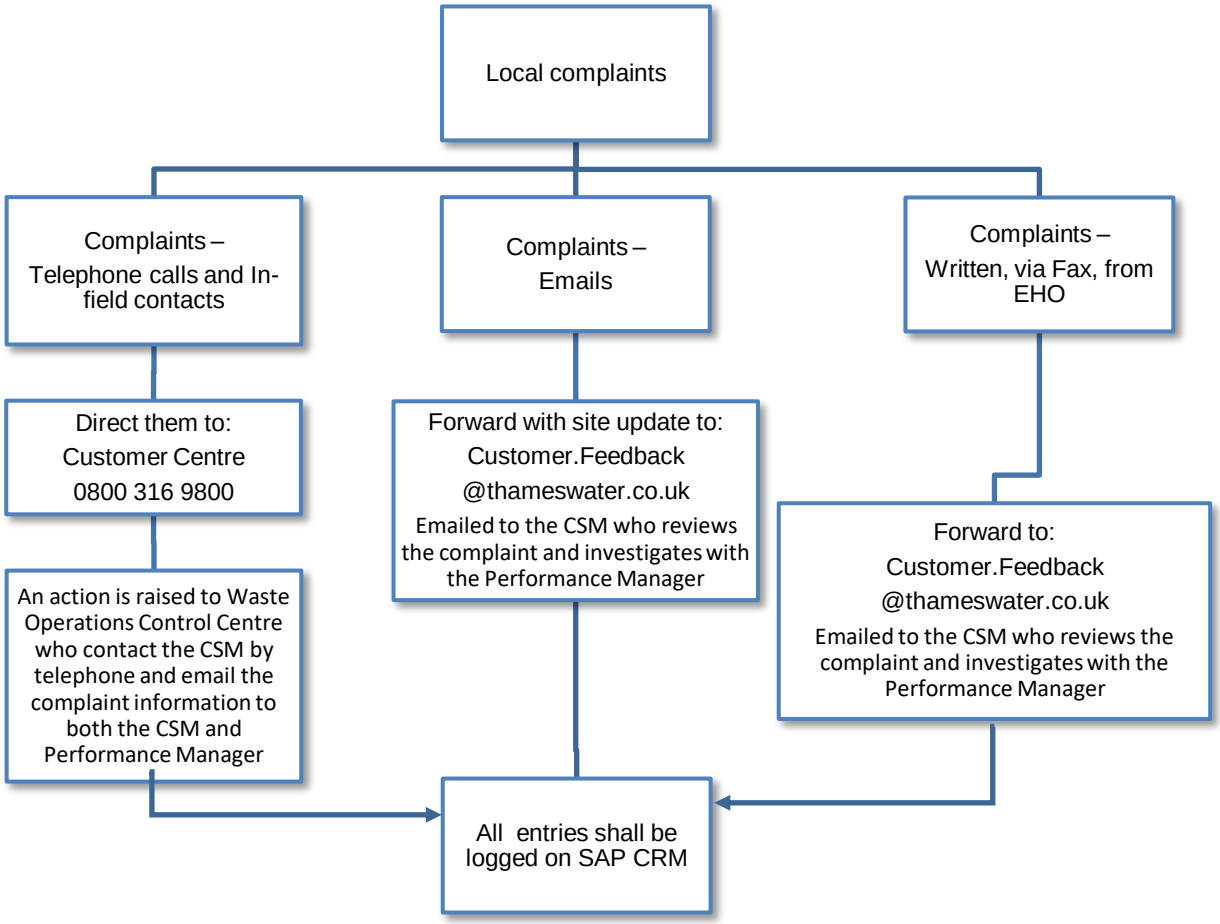
Odour Implementation Plan Didcot STW

Review Date		Jan-24				
Process Stage	**Owner**	**Summary - Plan**	**Action**	**Challenges**	**Measures to mitigate**	**Timescale for completion**
OCU		Odour control of Imported Sludge tank, Screened sludge pumping station, Inter Site import tank, mixer buffer tanks and PFT.	Refurbish /replace media in odour control scrubbing tower	Quote gained, funding granted via APS risk system. Risk 114816 on APS	Run odour control plant with existing media	AMP8
OCU		Install a visual liquid flowmeter	To confirm the FE flow into the biofilter, a visual liquid flowmeter should be installed	Waiting for quotes to be delivered from Framework contractor	Risk 114816 on APS	AMP8
OCU		Action recommendations laid out by monthly health checks	Action recommendations laid out by monthly health checks	Funding		Ongoing
Sniff testing		Implement sniff testing procedure	Procedure written for sniff testing, in order to achieve effective sniff testing personnel needs to be identified to carry out the procedure who are not acclimatised to smells on site.	Resource	Site Round, Monthly health checks	6 months from permit issues

Appendix 3. Customer Communications Plan

Complaints Process

All locally received complaints are re-directed to the Customer Centre. Please see below for details.



IMPORTANT NOTE:
Any communications received from the local Member of Parliament or senior council officers need to be forwarded to the Local/Regional Government Liaison person: Name: Miles Evans Telephone: (07747) 647304

Communications

Level 1	Stable operations: Compliant with Operational Asset Standards.			
Communications Approach	Standard regular proactive contact with key stakeholders.			
Stakeholders External	**Frequency of Contact**	**Method of Contact**	**Aim of Contact**	**TW Contact/Level**
Local council(s) Environmental Health Department	As required but at least quarterly	Telephone / email / meeting	Update on operational activity on site	Performance Manager/Customer & Stakeholder Manager
Environment Agency	As required	Telephone / email / meeting	Update on operational activity on site	Performance Manager and environmental permitting team
Local residents associations (if applicable)	As required but at least annually	Telephone / email / meeting	Update on operational activity on site	Performance Manager/Customer & Stakeholder Manager
Stakeholders Internal	**Frequency of Contact**	**Method & Level of Contact**	**Aim of Contact**	**TW Contact/Level**
Press Office	As required	Report sent out by operations to the business	Update the business on operational activity on site	Duty Manager
Customer Centre (Swindon)	As required	Report sent out by operations to the business	Update the business on operational activity on site	Duty Manager

Level 2	Unstable operations: • Non-compliant with Operational Asset Standards on one or more sub-processes leading to increased odour risk.			
Communications Approach	As Level 1 plus: • Use of Contact Centre Bulletin Boards / Briefing Contact Centre agents / Briefing statement with Q&A prepared for the press office (to use reactively). • Monthly discussions with, and quarterly visits from, the EHO. • Commence proactive communications with other stakeholders.			
Stakeholders External	**Frequency of Contact**	**Method & Level of Contact**	**Aim of Contact**	**TW Contact/Level**
Local council(s) Environmental Health Department	Immediately then monthly	Telephone / email / meeting	Report unstable operation with action plan	Performance Manager and Customer & Stakeholder Manager
Environment Agency	Potential for notification procedure	As required as per notification procedure	As required as per notification procedure	Pollution desk
Local residents associations (if applicable)	Immediately then monthly	Telephone / email / meeting	Report unstable operation with action plan	Performance Manager and Customer & Stakeholder Manager
Stakeholders Internal	**Frequency of Contact**	**Method of Contact**	**Aim of Contact**	**TW Contact/Level**
Press Office	Immediately then weekly	Q&A prepared for press office by Operations	To enable the press office to deal with queries from the press (reactive only).	Duty Manager
Customer Centre (Swindon)	Immediately then weekly	Telephone / email	To enable the Customer Centre to deal with queries from the press (reactive only).	Duty Manager
Other areas/stakeholders outside Didcot STW potentially impacted				
Stakeholder	**Frequency of Contact**	**Method of Contact**	**Aim of Contact**	**TW Contact/Level**
Local businesses (If required)	Immediately then monthly	Telephone / email / meeting	Report unstable operation with action plan	Performance Manager and Customer & Stakeholder Manager

Level 3	Emergency • Temporary or transient activities not deemed to be compliant with Operational Asset Standards. High risk of odour emitting plant.			
Communications Approach	As level 2 plus: • Odour event set up internally (including OOH's cover from OMC (Kemble Court)). • Weekly discussions with EHO. • Monthly Stakeholder meetings, (internal and external – include MPs, Councillors, schools, businesses etc.). • Press release may be required.			
Stakeholder External	**Frequency of Contact**	**Method of Contact**	**Aim of Contact**	**TW Contact/Level**
Local council(s) Environmental Health Department	Immediately then weekly	Telephone / email / meeting	Report emergency event with action plan and update with progress	Level 5 Manager (Operations Manager) / Level 4 Manager (Regional Operations Manager)
Environment Agency	As required as per notification procedure	As required as per notification procedure	As required as per notification procedure	Pollution desk
Local residents associations (if applicable)	Immediately then monthly	Telephone / email / meeting	Report emergency event with action plan and update with progress	Performance Manager and Customer & Stakeholder Manager
Councillors / MPs for local areas	Immediately then monthly	Telephone / email / meeting	Report emergency event with action plan and update with progress	Level 5 Manager (Operations Manager) / Level 4 Manager (Regional Operations Manager)
Stakeholders Internal	**Frequency of Contact**	**Method of Contact**	**Aim of Contact**	**TW Contact/Level**
Press Office	Immediately then daily	Q&A and press release prepared by press office	To enable the press office to deal with reactive queries from the press and prepare a media strategy if required.	Duty Manager
Customer Centre (Swindon)	Immediately then daily	Telephone / email	To enable the Customer Centre to deal with queries from customers (reactive only)	Duty Manager
Other areas/stakeholders outside Didcot STW potentially impacted				

Stakeholder	Frequency of Contact	Method of Contact	Aim of Contact	TW Contact/Level
Local businesses (If required)	Immediately then monthly	Telephone / email / meeting	Report emergency event with action plan and update with progress	Process / Site Manager

Appendix 4. Site Drawings

Didcot STW

Figure A1 - Site Location Map

Figure A2 - Site Location Map with nearby receptors see list in Table 2.1.


11
10
4
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12
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Figure B - Site Plan of Didcot STW

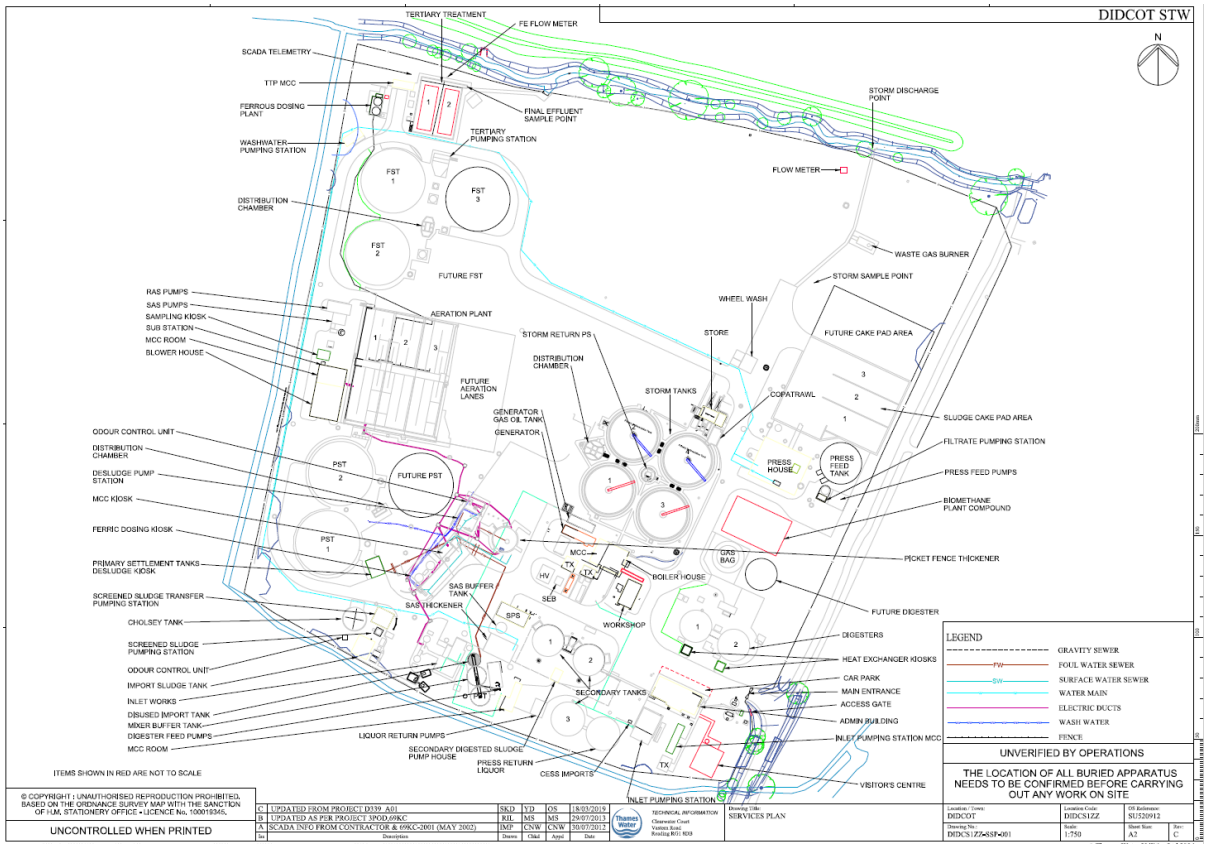
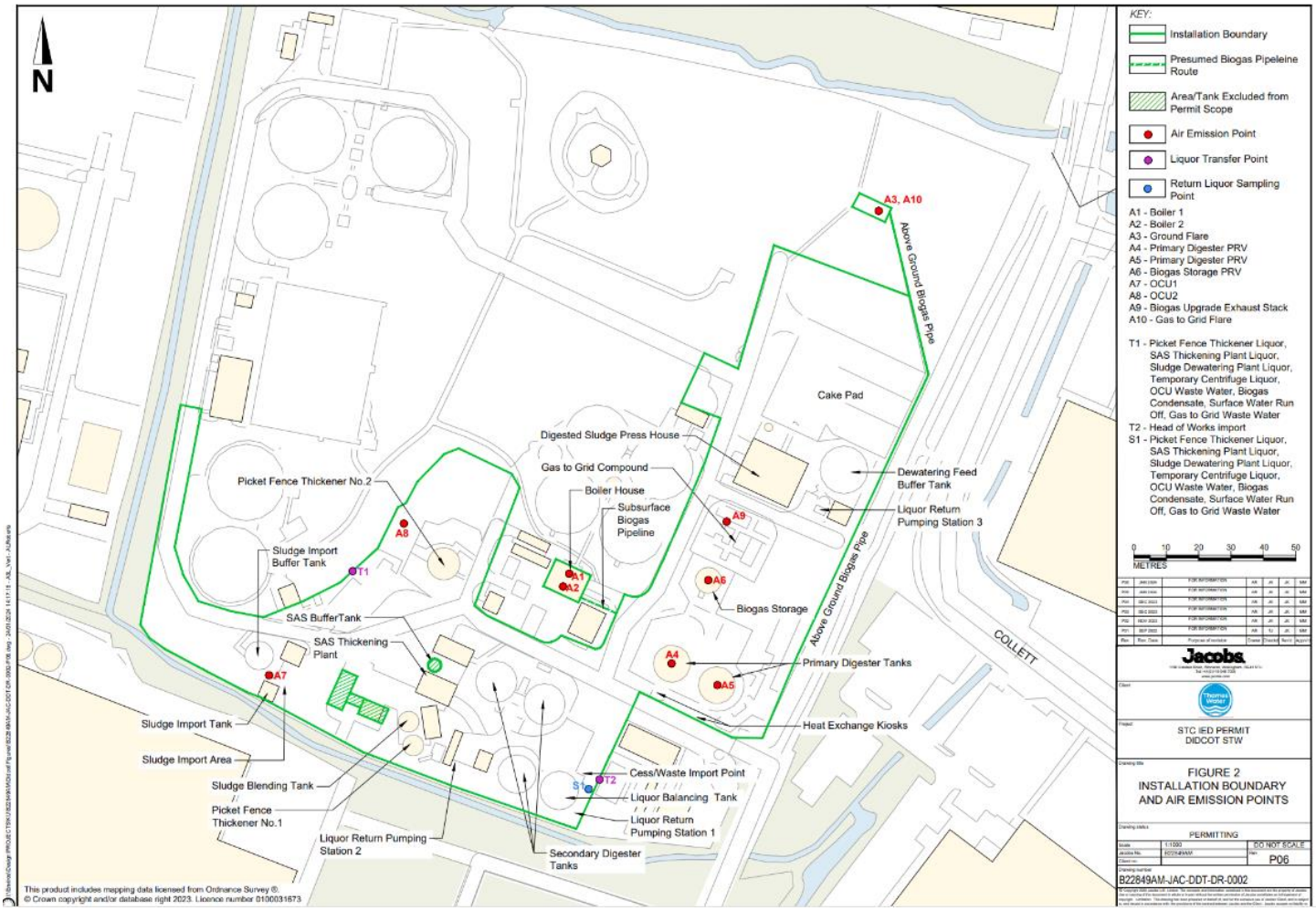


Figure C - Area Permitted under Sludge Treatment Centre Permit


N
A3, A10
Above Ground Biogas Pipe
Cake Pad
Digested Sludge Press House
Gas to Grid Compound
Boiler House
Subsurface Biogas Pipeline
Picket Fence Thickener No.2
A8
A9
Dewatering Feed Buffer Tank
Liquor Return Pumping Station 3
Sludge Import Buffer Tank
T1
A1
A2
A6
Biogas Storage
SAS BufferTank
SAS Thickening Plant
A4
A5
Primary Digester Tanks
A7
Above Ground Biogas Pipe
COLLETT
Sludge Import Tank
Heat Exchange Kiosks
Sludge Import Area
Cess/Waste Import Point
T2
S1
Sludge Blending Tank
Liquor Balancing Tank
Picket Fence Thickener No.1
Liquor Return Pumping Station 1
Liquor Return Pumping Station 2
Secondary Digester Tanks
This product includes mapping data licensed from Ordnance Survey ®.
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KEY:
Installation Boundary
Presumed Biogas Pipeleine Route
Area/Tank Excluded from Permit Scope
Air Emission Point
Liquor Transfer Point
Return Liquor Sampling Point
A1 - Boiler 1
A2 - Boiler 2
A3 - Ground Flare
A4 - Primary Digester PRV
A5 - Primary Digester PRV
A6 - Biogas Storage PRV
A7 - OCU1
A8 - OCU2
A9 - Biogas Upgrade Exhaust Stack
A10 - Gas to Grid Flare
T1 - Picket Fence Thickener Liquor, SAS Thickening Plant Liquor, Sludge Dewatering Plant Liquor, Temporary Centrifuge Liquor, OCU Waste Water, Biogas Condensate, Surface Water Run Off, Gas to Grid Waste Water
T2 - Head of Works import
S1 - Picket Fence Thickener Liquor, SAS Thickening Plant Liquor, Sludge Dewatering Plant Liquor, Temporary Centrifuge Liquor, OCU Waste Water, Biogas Condensate, Surface Water Run Off, Gas to Grid Waste Water
0 10 20 30 40 50
METRES
Jacobs
STC IED PERMIT
DIDCOT STW
FIGURE 2
INSTALLATION BOUNDARY AND AIR EMISSION POINTS
PERMITTING
1:1000
DO NOT SCALE
P06
B22849AM-JAC-DDT-DR-0002

Figure D1 - Process Block Diagram for Whole Site

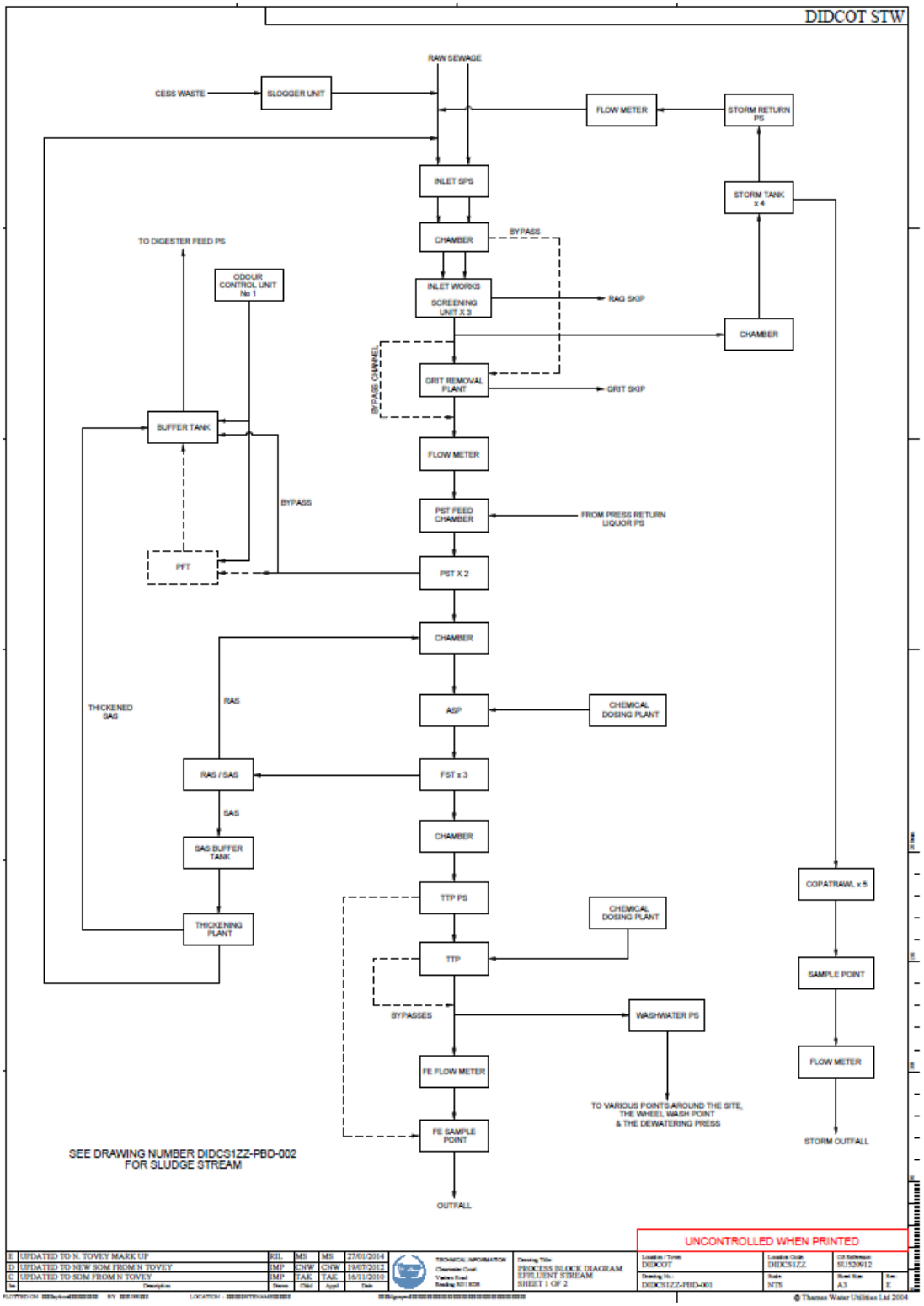
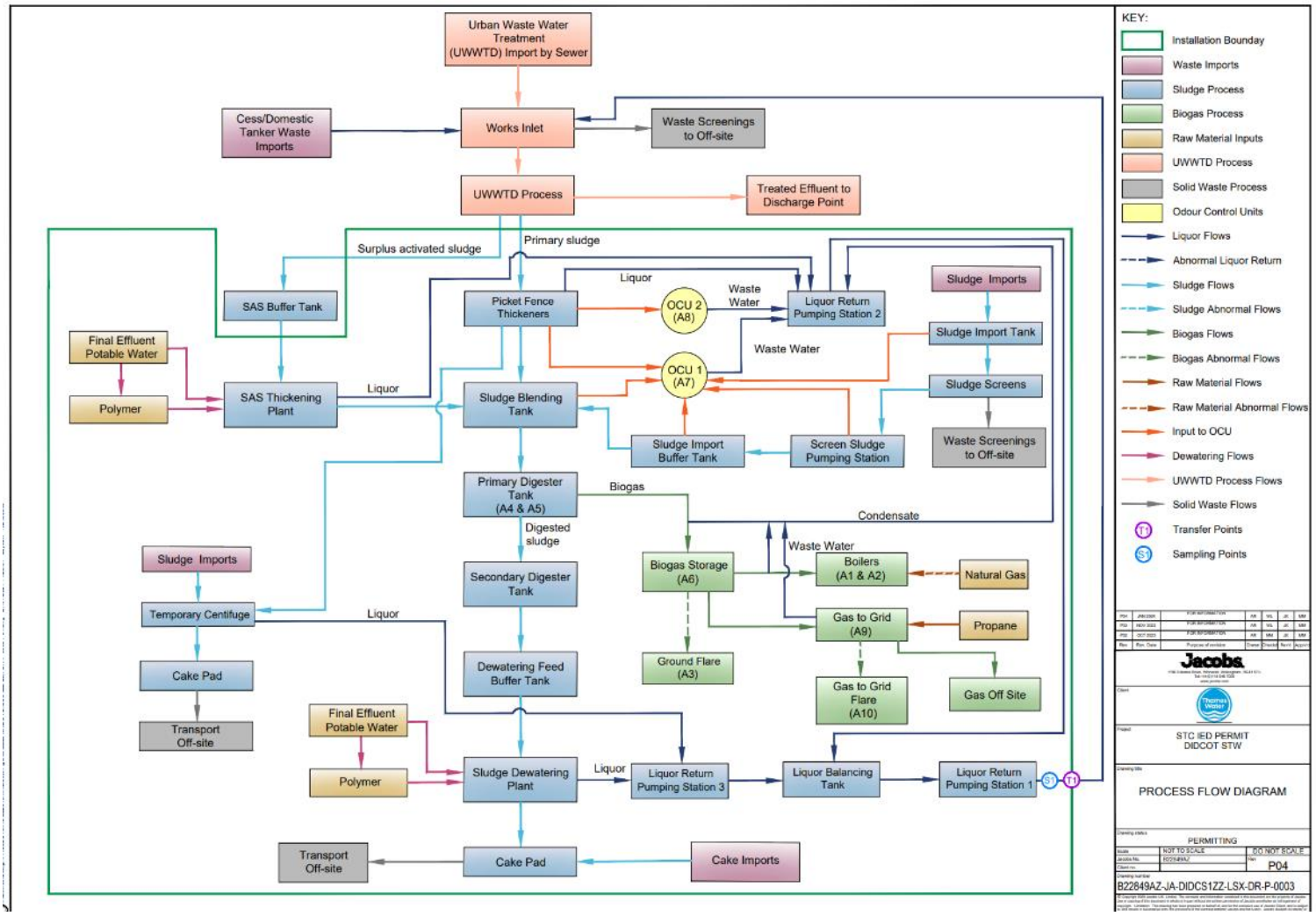


Figure D2 - Process Block Diagram for Sludge Treatment Centre



Appendix 5. Site Rounds

ID	Instruction	Daily	Weekly
1	**Final Effluent**		
a)	Check the effluent quality at the sample point. Sample (ammonia, phosphorus, temperature & turbidity) in accordance with SOM. Record in site log book & via Direct Text.	**X**	
b)	Check final effluent sampling point is accessible.	**X**	

ID	Instruction	Daily	Weekly
	Highlight to manager if need to clean inline monitor, channel/chamber.		
c)	Check storm sampling point is accessible. Highlight to manager if need to clean inline monitor, channel/chamber.	X	
d)	Visual check on point of discharge to the watercourse if accessible. Check operability of outfall flap valve if fitted.	X	
e)	Check storm discharge point, if shared & if accessible.	X	
f)	Compensation water pumps. Check and clear ultrasonic head of cobwebs etc.	X	
g)	Check data and operation of inline monitor. Check inline monitor installation for damage, take appropriate action where required.	X	
h)	Remove and clean inline monitor probe.		X
i)	Check flow meter & flume is clear of debris. Take appropriate action.	X	
2	**Preliminary Treatment**	Daily	Weekly
a)	Check Crude sewage appearance. Does it look normal for the site?	X	
2.1	**Cess Waste Reception Point**		
a)	Note any suspicious activity or discharges as required	x	
b)	Check logger system is operating correctly	x	
c)	Check all pipework is in good condition	x	
d)	Where a macerator is fitted, check operation and oil reservoir	x	
e)	Where a manual stone trap is fitted, clear of accumulated material	x	
f)	Check grit bins are available and stocked with grit for winter	x	
g)	Carry out general housekeeping, remove litter, clear debris, washdown any spillages, empty bins	x	
h)	Ensure all signage is in good condition, clean and legible	x	
i)	Check washdown equipment is operating correctly	x	
2.2	**Inlet / storm pumping station**	Daily	Weekly
a)	Check Ammeter reading, Too high could indicate a blockage. Too low could indicate an air lock or impeller damage. Where reading is unusual ensure appropriate action is taken.	X	

ID	Instruction	Daily	Weekly
b)	Check the well level is within the normal operating limits taking into account the flow conditions at the time (such as storm conditions & peak flow to site). If level is too low or high, this could indicate control issues or pumping issues.	**X**	
c)	Check condition of the wet well. Does it have more than the usual scum or debris floating on top that will indicate the need for a wet well clean?	**X**	
d)	Check fault light(s) are not on, take appropriate action as required.	**X**	
e)	Check flow rate (where meter is fitted); is it within the normal operating range?	**X**	
f)	Inspect buildings, kiosks and control/switchgear panels for general condition, damage and that they are securely locked. Clean and tidy the interior of the buildings and/or Kiosks. Remove rubbish from site or if large volume arrange for collection.	x	
g)	Listen for undue pump noise and check for undue vibration by safely touching the lifting chain or guide rail.	**X**	
h)	Check non-return valve is operating correctly Non return valves prevent water from flowing back through the pump when it is not in operation. If a weighted arm is fitted is it at the usual angle? If it is low and chattering it could indicate the pump is blocked.	**X**	
i)	Check operation of the ultrasonic level control. Is it reading correctly? Compare the well level with the normal readout from the display. Check hard wired control floats, clean as required. Are floats weighed down with rag or debris preventing them from lifting if the water level rises?	**X**	
j)	Check pumps, pipelines and couplings for leaks where possible.		**X**
k)	Start the cleaning cycle manually where required.	**X**	
l)	Pumps - Log hours run		**X**
m)	Pumps - Log kWhrs		**X**
2.3	**Screen(s) / macerator(s)**	Daily	Weekly
a)	Check inlet channel level is normal taking into account the flow conditions at the time (such as storm conditions & peak flow to site).	**X**	
b)	Check screen operation and check for screenings carryover. Check for blockages and blinding (hairpinning) on screen panels and remove where necessary. Check for rag rolling or rag balls upstream of the screen and remove where necessary.	**X**	

ID	Instruction	Daily	Weekly
	Check for any grit build up in front of screen		
c)	Inspect debris disposal mechanism for correct operation and verify screenings are being removed. Check & clean any obstructions impeding the operation of screen mechanisms.	**X**	
d)	Check screens bypass is available and clean	**X**	
e)	Clean area around screen. Check & clean screen panels of any obstructions.		**x**
f)	Visually check auto lubrication systems (grease pot) are functioning correctly, take appropriate action to replace them if needed. Inspect grease pots and fill them when level is below the standard. Use grease nipples to lubricate required parts of screen.	**X**	
g)	Visually check unit and its associated equipment for the following: Safety & security with all panels locked & guards secure and in good condition. Excessive noise or vibration Overheating External damage, leaks, missing fixings Where applicable, ensure main and brush drives turn and that brushes are spinning	**X**	
h)	Check operation of wash water system for screens Ensure wash water pressure of spray bar is correct. Check the inline filter is present, clean and feeding the spray bars (where applicable). Check the spray bar pattern and clean the spray bar nozzles as required.	**X**	
i)	Check & clean accumulation of screenings and fat from debris disposal mechanism Check & clean launder chutes and channels for accumulation of grit, sand, rag, fat,	**X**	
j)	Check the lip, labyrinth or other seals between the screen and the channel wall are making an effective seal.	**X**	
k)	Visual check on the screenings removal brushes for blinding and wear. Clean the brushes as required. Ensure the brushes are in correct contact with the screen and that screenings are being removed.	**X**	
l)	Check and clean instrumentation probes, floats and ultrasonic heads (where applicable).	**X**	
2.4	**Screenings handling**	Daily	Weekly
a)	Check control system and amps on panel for normal levels / operation, take appropriate action as required. Jumping amps indicates a blockage.	**X**	
b)	Where installed, visual check for normal operation of macerator.	**X**	

ID	Instruction	Daily	Weekly
	Look for visible blockages/build up on unit, high flows in front of macerator. Listen for unusual noise. Take appropriate action as required.		
c)	Where installed, check and empty stone trap.	**X**	
d)	Clean area around screenings handling units and skips.		**X**
e)	Check operation of wash water system for screenings handling. Check the inline wash water filter is present, clean and feeding the spray bars (where applicable Ensure wash water pressure of spray bar is correct. Check the inline filter is present, clean and feeding the spray bars (where applicable). Check the spray bar pattern and clean the spray bar nozzles as required.	**X**	
f)	Check screenings product quality and quantity, Check level of screenings in skip and change skip when full.	**X**	
g)	Check operation of auto drain.		**x**
h)	Where installed check operation of the trough desludge system. Check for grit build-up in trough - hose out where required.		**x**
i)	Visual check on condition and operation of brushes (ensure trough is being cleaned). If blinding occurs regularly have wear on screw brushes checked.		**x**
j)	Check screw conveyor and brushes for wear and central running.		**x**
k)	Clean and check mesh for blinding and hairpinning.		**x**
2.5	**Grit removal**	Daily	Weekly
a)	Check mechanical plant is operating correctly. Check equipment– Compressor, Rake, Detritor & Pista grit.	**X**	
b)	Check manually de-gritted constant velocity channels for build-up of grit, take appropriate action as required.	**X**	
c)	Check inflow and outflow for normal rate of flow and correct distribution.	**X**	
d)	Check volume, dryness and quality of grit produced.	**X**	
e)	Remove rag from the areas around baffles and mechanical equipment	**X**	
f)	Log manual de-gritting operations where required.	**X**	
g)	Log abnormal grit volumes.	**X**	
h)	Clean grit channel as required. Check grit build up in inlet channels and clean out if necessary.		**X**
i)	Check operation of wash water system and check the inline filter is present, clean and feeding the spray bars (where applicable)	**X**	

ID	Instruction	Daily	Weekly
j)	Check aerated grit channels for air flow and bubble pattern (where applicable).	**X**	
2.5	Skips	Daily	Weekly
a)	Check skip capacity is adequate, and inform contractor when skip is full.	**X**	
b)	Rake skip where required.	**X**	
c)	Remove excess water if there is a facility to do so.	**X**	
d)	Ensure only prescribed material is in the skip. Remove any materials not prescribed.	**X**	
2.6	**Storm separation and treatment**	Daily	Weekly
a)	Check Flow To Full Treatment penstock is set at correct level.	**X**	
b)	Check storm return system is operational, manually return storm contents where required.	**X**	
c)	Check storm tanks cleaning system, check level sensors, check tanks are clean and empty outside of storm conditions.	**X**	
d)	Check and clear storm screens where required. (automatic clearance and manual clearance linked to safe system of work)	**X**	
e)	Check screens bypass is available and clean	**X**	
f)	Check and clear/replace any outlet screening sacks		**X**
g)	Check separation weirs and clean where required.		**X**
h)	During storm check that the flow to treatment is normal. (Treating Flow To Full Treatment)		**X**
i)	Log abnormal flows. Log storm discharge flows. Log storm flows in dry weather conditions.		**X**
j)	Log storm events.		**X**
k)	Remove any debris in the system.		**X**
l)	Storm LTA – Visually check area is clean and operating within site parameters. Remove any debris.		**X**
m)	Storm LTA – Check for short circuiting during operation. Inspect banks for leakage		**X**
2.7	**Flow measurement**	Daily	Weekly
a)	Check site is within flow permit (treating Flow To Full Treatment before going to storm). Check that flow is going through site as expected.	**X**	
b)	Check flow meter and flume and clean where required	**X**	
c)	MCERTS – Log & record flow meter readings	**X**	

ID	Instruction	Daily	Weekly
d)	Check EDM (Event Duration Monitor) sensor is clean and weir is free of debris	X	
3	Primary Treatment- Primary Settlement Tanks	Daily	Weekly
a)	Check and log sludge level by dipping tanks (Mon/Wed/Fri)	X	
b)	Check bridge/scraper operation	X	
c)	Check de-sludge pump(s) and timer for normal operation	X	
d)	Check scum boards for breaks or carry under	X	
e)	Check scum trap for normal operation and clean/hose out	X	
f)	Check settled sewage quality (visual check only)	X	
g)	Check stilling chamber for rag, clear as necessary	X	
4	Secondary Treatment		
4.1	Secondary Treatment – Activated Sludge	Daily	Weekly
a)	Check air filters indicators for normal readings. Check blower control panel. Check the blowers for normal operation. Check there are no illuminated fault lights.	X	
b)	Check and record dissolved oxygen (D.O) readings, where probes are installed.	X	
c)	Sample, measure and record Mixed Liquor Suspended Solids (MLSS) /RASS concentration and sludge settleability (Stirred Specific Volume Index) (SSVI), (Monday/Wednesday/Friday)	X	
d)	Vent condensate from air lines		X
e)	Check SAS pump(s) are operating correctly	X	
f)	Check and record sludge return from the final settlement tanks (RAS rate)	X	
g)	Check D.O probe and / or timers are carrying out the correct control functions. Aeration control function.	X	
h)	Check flow distribution to aeration lanes if more than one lane present	X	
i)	Log changes to RAS rate, Log flows (where meters are fitted), Log KWh, Log SAS Rate.	X	
j)	Check and record bubble pattern and size of the bubbles	X	
k)	Check mixers for rotation in anoxic (un-aerated) zones	X	
l)	Check recycle pumps are running, as required (Biological Nutrient Removal -BNR plants)		X
m)	Check redox monitor is operating correctly (BNR plants)		X
n)	Check VFA / liquor return (BNR plants)		X

ID	Instruction	Daily	Weekly
o)	Check and record rate and frequency of SAS removal	**X**	
p)	Withdraw the D/O probe from the tank and remove clean		**X**
4.2	**Secondary Treatment – Biological Filters**	Daily	Weekly
a)	Visually check for correct flow distribution across the filter (radial distribution)	**X**	
b)	Keep filter surface clear of all debris and any significant moss or weed growth. Deal with ponding as appropriate.	**X**	
c)	Where recirculation is installed, check for normal operation at the correct flow rate	**X**	
d)	Check all air vents and under drains are clear and not flooded	**X**	
e)	Clear distribution arm orifices and or weir plates of debris	**X**	
f)	Remove end caps and rod/flush arms - clear debris from open channel arms	**X**	
g)	Check for appropriate flow distribution between filters to suit filter size	**X**	
h)	Check operation of distributor arms (uniform speed of rotation)	**X**	
i)	Check for leakage at the centre column seals and end caps. Short circuiting etc.	**X**	
j)	Check rotation timer. Check alignment of rotation alarm sensor and target plate	**X**	
5	**Secondary Settlement – Humus Tanks / Final Settlement Tanks**	Daily	Weekly
a)	Check correct operation of desludging pump(s) or valve(s)	**X**	
b)	Check scraper/bridge operation where installed	**X**	
c)	Check and log blanket level with portable blanket meter where detectors not fitted. (Monday, Wednesday, Friday)	**X**	
d)	Check tank surface for buildup of floating debris. Visually check effluent quality over the weir for solids carry over	**X**	
e)	Check RAS pump(s) are operating correctly (FSTs only)	**X**	
f)	Check Bellmouth and de-rag where required	**X**	
g)	Check effectiveness of weir brushes, chains, “other systems” where fitted	**X**	
h)	Check scum boards for breaks or carry under	**X**	
i)	Check scum removal system for correct operation, clear any fouling where necessary	**X**	
j)	Check flow of recirculation bleed back/constant draw off where used	**X**	

ID	Instruction	Daily	Weekly
k)	Check operation of fixed blanket detectors and alarms		X
l)	Check operation of Mallard pump by test running in hand, where installed		X
m)	Clear overflow weirs and launder channels of any build-up that will affect the tanks or effluent performance	X	
6	**Chemical Dosing**	Daily	Weekly
a)	Check that chemical is discharging, rather than dosing pump running dry (any nozzles blocked?)	X	
b)	Check chemical storage tank level - reorder as required. Log level in storage tank, Log discharge rate.		2 days a week
c)	Check for excessive vibration in the dosing pump		2 days a week
d)	Check the level in the internal bund and empty as required. Report any abnormalities.		2 days a week
e)	Visual check for leaks on tanks and visible chemical lines		2 days a week
f)	Check the trace heating system		2 days a week
g)	Check external storage tank bund for rainwater and/or chemical. Empty as appropriate.		X
7	**Tertiary Treatment**		
7.1	**Low Head Sand Filter**	Daily	Weekly
a)	Check smooth movement of bridge, unusual sounds and vibrations, and abnormal flow patterns	X	
b)	Check water level in each filter, compare with other units and relate to flow rate, and last backwash	X	
c)	Check unit isn't in bypass	X	
d)	Check for evidence of chemical leaks	X	
e)	Check cleanliness of carriage & filter area	X	
f)	Check sodium hypochlorite level in the bridge tanks where fitted and fill from bulk tank	X	
g)	Check sodium hypochlorite bulk tank level	X	
h)	Check the amount of sand in the wash water	X	
i)	Check the colour of the backwash water	X	
j)	Check the correct amount of hypochlorite is being dosed	X	
k)	Check water level in each filter, compare with other units and relate to flow rate, and last backwash	X	
l)	Log backwash timer settings and head loss	X	

ID	Instruction	Daily	Weekly
m)	Log flows and flow rate, where meters are fitted	**X**	
n)	Clean the level sensor head		**X**
o)	Log clarity of feed (compare with final effluent)	**X**	
7.2	**Disc Filter**	Daily	Weekly
a)	Log backwash pressure	**X**	
b)	Check frequency of backwash is within correct range		**X**
c)	Check bypass is not working during normal operations	**X**	
d)	Check depth in and out of the drum for normal operation	**X**	
e)	Check drum is rotating in correct mode and sounds normal	**X**	
f)	Check all ancillaries are operating normally	**X**	
g)	Log flows and flow rate where meters are fitted	**X**	
h)	Sample and record turbidity on feed (compare with final effluent)	**X**	
i)	Inspect inside filter for large pieces of debris		**X**
j)	Check for accumulation of weed in backwash trough		**X**
k)	Check and clean backwash water strainer.		**X**
l)	Check for soundness of mesh panels by lifting inspection panels		**X**
m)	Check wash water pressure and nozzles for normal operation		**X**
8	**Raw Sludge Holding & Thickening**		
8.1	**Sludge Holding Tanks**	Daily	Weekly
a)	Check mixing regime is correct	**X**	
b)	Log levels in tank(s)	**X**	
c)	Decant liquors	**X**	
d)	Check tank(s) for ragging and blockages and clear or remove (where safe access is possible)	**X**	
e)	Check that holes on sludge cage(s) are clear where fitted, Clean sludge cage(s) dewatering holes (where safe access is possible)	**X**	
f)	Log tanker movements and compare with schedule	**X**	
g)	Ensure any crust build up does not interfere with any control equipment/alarm floats	**X**	
8.2	**Picket Fence Thickener**	Daily	Weekly
a)	Check fence is rotating & “stop, look, listen,” for mechanical issues.	**X**	
b)	Check weir overflow quality and the surface of the unit. Clear any buildup of debris	**X**	
c)	Log blanket measurements / pump timers	**X**	

ID	Instruction	Daily	Weekly
d)	Sample from discharge pump (run manually if necessary) and assess product quality. Sample, analyse and record % dry solids entering the PFT. Sample, analyse and record % dry solids out (Monday, Wednesday, Friday)	**X**	
e)	Check control system is operating normally	**X**	
f)	Log any changes to settings or duty	**X**	
g)	Log sludge flows in (where meters fitted) and out	**X**	
h)	Visually assess the dry solids & flow entering the PFT	**X**	
i)	Log hours run meters	**X**	
j)	Remove buildup of debris on the rake	**X**	
8.3	**Belt Thickeners**	Daily	Weekly
a)	Check for good floc formation. Check sludge on the top belt and assess the conditioning of the sludge. Check belt drainage and filtrate quality	**X**	
b)	Check product quality & quantity. Check condition of hopper	**X**	
c)	Visually check auto lubrication systems (grease pot) are functioning correctly, take appropriate action.	**X**	
d)	Sample, analyse & record % Dry Solids on feed and sludge/cake (Monday, Wednesday, Friday)	**X**	
e)	Check sludge feed rate and log	**X**	
f)	Check poly dosing system. Log polymer usage, note each bag change/delivery. Make adjustments to optimise	**X**	
g)	Ensure wash water pressure is available at a minimum of 6 bar	**X**	
h)	Clean belt steering paddles and check they are functioning correctly	**X**	
i)	Clean hopper level probes and check they are functioning correctly	**X**	
j)	Wash Station - Check formation of spraying fans, rotate internal brush to clean spray nozzles. (Minimum twice daily)	**X**	
k)	Visual Check - Hydraulic Power Pack - Check oil level and top up using clean equipment and fresh oil as required, maintain as close to full level as possible. Oil level must not be allowed to fall below 3/4 as this will cause serious damage	**X**	
l)	Jet wash clean the belt filter.	**X**	
m)	Use low pressure water hose to clean complete machine, frame, rollers and hoppers.	**X**	
n)	Check condition of Belt Filter for blinding / blockages / good filtration	**X**	
o)	High pressure steam clean the belt from underside.		**X**

ID	Instruction	Daily	Weekly
p)	High pressure steam clean complete machine, frame rollers and hoppers avoiding all electrical and instrumentation equipment		X
q)	Check condition of Belt Filter for wear i.e. Creasing / condition of seam to avoid failure / breakage and damage to other components		X
8.4	Drum Thickeners	Daily	Weekly
a)	Check for good floc formation. Check sludge feed rate. Check product thickness (visually). Check filtrate quality	X	
b)	Visually check auto lubrication systems (grease pot) are functioning correctly, take appropriate action.	X	
c)	Sample for % dry solids analysis and record (Monday, Wednesday, Friday)	X	
d)	Check spray bar nozzles to ensure they are clear and spraying correctly. Check spray bar wash water pressure	X	
e)	Clean probes in discharge hopper, hose down and carry out cleaning duties	X	
f)	Log polyelectrolyte used – each drum/bag change	X	
g)	Log sludge inlet flow meter, monitor throughput	X	
h)	Check & clean flocculator tanks		X
i)	Check appearance of mesh, adjust cleaning and cleaning pause intervals if necessary.	X	
j)	Clean dry solids monitors sensors		X
k)	Clean foot valves on washwater suction lines		X
l)	Clean mechanical filter on washwater booster set		X
m)	Clean washwater booster secondary screen in channel		X
n)	Jet/remove fat deposits from thickened sludge discharge pipework		X
o)	Log hours run		X
9	Odour Control	Daily	Weekly
	Tasks for all Odour Control Units		
a)	Check covers, hatches and doors are closed	X	
b)	Confirm duty fan running and standby fan availability	X	
c)	Check damper position to ensure they have not been tampered with	X	
d)	Check ductwork for any signs of damage or leaks	X	
	Specific tasks for Biofilter OCU		
e)	Check the spray pattern from the irrigation nozzles and clean nozzles where required. (If possible)	X	

ID	Instruction	Daily	Weekly
f)	Check for free discharge of effluent water to drain	**X**	
g)	Check for free discharge on any condensate removal points	**X**	
	Specific tasks for Chemical Scrubber OCU		
h)	Check water softener availability, check salt reservoir level, and top up if required.	**X**	
i)	Check stocks in bulk chemical tanks and reorder if required – tanker delivery	**X**	
j)	Check that the Redox and pH are within the agreed range – on dosing skid	**X**	
k)	Check duty and standby dosing pumps are available for each bulk chemical	**X**	
l)	Check the duty scrubber liquor recirculation pump is running and the standby is available in auto	**X**	
m)	Check that there is free drainage of scrubber blow-down liquor to drain	**X**	
n)	Check differential pressure gauges are within design range (if fitted)	**X**	
o)	General check for leaks in the scrubber liquor recirculation and dosing system – raise follow on work if any defects are identified	**X**	
	Specific tasks for Carbon OCU		
p)	Examine ductwork for any signs of damage or leaks and check trapped condensate drains are free flowing. If a manual drain valve is provided, operate the valve until the flow of condensate ceases and leave valve in closed position.	**X**	
q)	Check differential pressure gauge for over-pressure (if provided) – indicates media fouling	**X**	
10	**On Site Pumping**	Daily	Weekly
a)	Pumping System(s) (Drainage, Interstage, Washwater, Recirculation, Return Liquors etc.) operating correctly?	**X**	
b)	Check Ammeter reading - too high could indicate a blockage. Too low could indicate an air lock or impeller damage.	**X**	
c)	Check the well level is within the normal operating limits - taking into account the flow conditions at the time. If level is too low or high, this could indicate control issues or pumping issues.		
d)	Check condition of the wet well- does it have more than the usual scum or debris floating on top that will indicate the need for a wet well clean?		
e)	Check fault light(s) are not on	**X**	

ID	Instruction	Daily	Weekly
f)	Check flow rate (where meter is fitted); is it within the normal operating range?	**X**	
g)	Check for undue pump noise and vibration by safely touching the lifting chain or guide rail.	**X**	
h)	Check non-return valve. Non return valves prevent water from flowing back through the pump when it is not in operation. If a weighted arm is fitted, is it at the usual angle? If it is low and chattering it could indicate the pump is blocked	**X**	
i)	Check operation of the ultrasonic level gauge. Is it reading correctly? Compare the well level with the normal readout from the display.	**X**	
j)	Check pumps, pipelines and couplings for leaks. Check for visible leaks.	**X**	
k)	Start the cleaning cycle manually where required	**X**	
l)	Pumps - Log hours run	**X**	
m)	Pumps - Log kWhrs	**X**	
n)	Check hard wired control floats - are floats weighed down with rag or debris preventing them from lifting if the water level rises.	**X**	
o)	**Washwater Pumping** - Check the pipe line pressure from a gauge (where installed) on the pressure vessel or the pipe line manifold. Possible indication of strainer blockage	**X**	
p)	**Washwater Pumping** - Check operation of surge vessels (where installed).	**X**	
q)	**Washwater Pumping** - Check the strainers. If necessary, put automatic strainers in manual clean and inspect the manual strainers where local conditions allow.	**X**	
r)	**Washwater Pumping** - Check automatic filters are operating correctly	**X**	
11	**Distribution Chambers**	Daily	Weekly
a)	Inspect all weirs and brush clean. Remove any debris, scum, algal growth, blanket weed, grit, etc. from the chamber. Check flow split is correct.	**X**	
b)	Ensure any rag is removed, especially from around the penstocks, gate valves and their spindles. Ensure none of this passes over the weir.	**X**	
c)	Check that all valve, penstock and weir operating positions are correctly set.	**X**	
d)	Check chamber for any visible leaks	**X**	

Appendix 6. Sludge Rounds

	Instruction	Daily	Weekly
1	**Liquid Sludge Import Facilities**	Daily	Weekly
a)	Check sludge logger device is fully operational	**X**	
b)	Check that the pattern of imports is in line with site requirements/agreement with tanker operators.	**X**	
c)	Check general area is clean and tidy	**X**	
d)	Check reception tank for rag/grit build up		**X**
2	**Sludge Screen**	Daily	Weekly
a)	Check sludge screen operation	**X**	
b)	Check screened sludge quality	**X**	
c)	Check / clean moisture sensor	**X**	
d)	Visually check unit and its associated equipment for the following: Safety & security with all panels locked & guards secure and in good condition. Excessive noise or vibration Overheating External damage, leaks, missing fixings	**X**	
e)	Visually check auto lubrication systems (grease pot) are functioning correctly, take appropriate action to replace them if needed. Inspect grease pots and fill them when level is below the standard. Use grease nipples to lubricate required parts of screen.	**X**	
f)	Carry out checks on cold weather operation systems before frost sets in	**X**	
g)	Check screenings quality & quantity		**X**
h)	Check general area is clean and tidy		**X**
i)	Check washwater is operating correctly during period of sludge discharge Ensure wash water pressure of spray bar is correct. Check the inline filter is present, clean and feeding the spray bars (where applicable). Check the spray bar pattern and clean the spray bar nozzles as required.		**X**
j)	Clean steel probes on rotamat screen		**X**

	Instruction	Daily	Weekly
3	**Sludge Buffer & Blending Tanks** "Sludge Blending Tank" refers to a tank, into which more than one type of sludge is fed, requiring mixing: normally immediately prior to sludge digestion or dewatering. It may on some sites be referred to as a sludge holding tank or digester feed tank.	Daily	Weekly
a)	Check that mixer is operating correctly. Mixers are normally inhibited if the sludge level falls below a set level to protect the impellor, pump or blower.	**X**	
b)	Check for signs of stratification or poor mixing and rectify where necessary	**X**	
c)	Check pH and if less than 5 attempt to reduce septicity and freshen sludge	**X**	
d)	Check for ragging and blockages and clear or remove (where safe access is possible)	**X**	
e)	Check amps on mixer motor		**X**
f)	Check tank control system		**X**
4	**Sludge Treatment Inter Process Pumping**	Daily	Weekly
a)	Check Ammeter reading, Too high could indicate a blockage. Too low could indicate an air lock or impeller damage. Where reading is unusual ensure appropriate action is taken.	**X**	
b)	Check flow rate (where meter is fitted); Is it within the normal operating range?	**X**	
c)	Check the well level is within the normal operating limits taking into account the flow conditions at the time. If level is too low or high, this could indicate control issues or pumping issues.	**X**	
d)	Check operation of the ultrasonic level gauge. Is it reading correctly? Compare the well level with the normal readout from the display.	**X**	
e)	Listen for undue pump noise and check for undue vibration by safely touching the lifting chain or guide rail.	**X**	
f)	Check pumps, pipelines and couplings for visible leaks	**X**	
g)	Check non-return valve is operating correctly Non return valves prevent water from flowing back through the pump when it is not in operation. If a weighted arm is fitted is it at the usual angle?	**X**	

	Instruction	Daily	Weekly
	If it is low and chattering it could indicate the pump is blocked.		
5	**Pasteurisation**	Daily	Weekly
a)	Check batch rates according to sludge levels	**X**	
b)	Check digester temperatures in relation to pasteurisation plant	**X**	
c)	Check hmi panel	**X**	
d)	Check operation of biotherm reactor aeration blower package.	**X**	
e)	Check heat exchanger performance	**X**	
f)	Check digested sludge buffer tanks	**X**	
g)	Check blended sludge buffer tanks	**X**	
h)	Check operation of biotherm reactor mixer	**X**	
i)	Check operation of heat exchanger mixer	**X**	
j)	Check operation of scum cutter	**X**	
k)	Check pump and valve operation	**X**	
l)	Log and record flows, pressures and temperatures	**X**	
m)	Check % ds of feed sludge to pasteurisation plant (Monday, Wednesday, Friday)	**X**	
n)	Check, remove and clean temperature probe		**X**
6	**Primary Sludge Digestion**	Daily	Weekly
a)	Check sludge discharge to limpet chambers, where installed. Clear any blockages	**X**	
b)	Check digester feed system is working Clear any blockages	**X**	
c)	Check digester heating system is working & temperatures are within HACCP range.	**X**	
d)	Check digester mixing system is operating correctly	**X**	
e)	Log digester temperatures (HACCP) Log inlet and outlet temperatures of each boiler Log inlet and outlet temperatures of sludge and water in heat exchangers	**X**	
f)	Log sludge feed volumes into each digester and establish the retention time (HACCP)	**X**	
g)	Check operation of sludge and water recirculation pumps Check pumps, pipelines and couplings for leaks where possible.	**X**	

	Instruction	Daily	Weekly
h)	Monitor water supply where glycol is not used to heat exchanges that are exposed to elements, Ensure water is drained when heat exchanges are not in use.	X	
i)	Log use of secondary fuel within boilers.	X	
j)	Sample sludge into and out of digester. Analyse and record % dry solids. (Monday, Wednesday, Friday.) Analyse and record % volatile matter. (3 times a week Monday – Thursday)	X	
k)	Check digesters for foaming on the top.		X
l)	Remove grit from base of digester if facility is provided. **Do not** leave grit removal operation unattended and ensure valve is fully closed before leaving task.		X
m)	Sample, measure and record pH of digested sludge		X
7	**Secondary Sludge Digestion**	Daily	Weekly
a)	Check mixing system, for short-circuiting or separation, Mix before transfer to the next process, where facilities exist	X	
b)	Decant supernatant liquor when required	X	
c)	Log status of each tank	X	
d)	Record number of day's storage	X	
8	**Biogas Handling, Storage, & Utilisation.**	Daily	Weekly
a)	Check all condensate traps manually and drain or top up if necessary. This check is required **twice daily** in prolonged periods of warm weather. Check automatic u-tubes visually, to ensure that there are no gas leaks or freezing Check automatic drain traps working correctly. Use manual drains if automatic drains not working, report defects	X	
b)	Check glycol pressure relief valve and ensure liquid level visible in sight glass	X	
c)	Check pressure/vacuum relief (whessoe) valves are not passing biogas. Listen for gas passing, note any unusual smell, visual check of valve.	X	
d)	Check for genuine operation of flare stack / waste gas burner, e.g. chp is at full power and there is excessive gas make	X	
e)	Check and record dehumidifier temperature	X	
f)	Log gas volumes: produced, flared, to chp, to boilers	X	

	Instruction	Daily	Weekly
g)	Sample, monitor & record methane composition of biogas	X	
h)	Manually check gas isolation valve handle operation by closing & opening valve.		X
9	**CHP & Biogas Power Management**	Daily	Weekly
a)	Check automatic drain traps working correctly. Use manual drains if automatic drains not working, report defects	X	
b)	Check for genuine operation of flare stack / waste gas burner, e.g. CHP is at full power and there is excessive gas make	X	
c)	Check glycol pressure relief valve and ensure liquid level visible in sight glass	X	
d)	Check & log hours run	X	
e)	Check & log kwh exported (where relevant)	X	
f)	Check & log kwh generated	X	
g)	Check & log kwh used on site	X	
h)	Check & log use of secondary fuel	X	
i)	Check & log gas used	X	
j)	Check & log heat liberated from engine, heat dumped, heat liberated from boilers	X	
k)	Check & log engine temperatures and pressures, by exception	X	
l)	Check & log gas stream for methane composition		X
m)	Check automatic u-tubes to ensure that there are no gas leaks or freezing		X
n)	Check pressure/vacuum relief (whessoe) valves are not passing biogas. Listen for gas passing, note any unusual smell, visual check of valve.	X	
10	**Liquor Treatment**	Daily	Weekly
a)	Check return liquors and return rate	X	
11	**Chemical Dosing**	Daily	Weekly
a)	Check that chemical is discharging, not just dosing pump running (any nozzles blocked?)	X	
b)	Check chemical storage tank level - reorder as required	X	
c)	Check for excessive vibration in the dosing pump	X	
d)	Check the level in the internal bund and empty as required	X	
e)	Check for leaks on visible chemical lines	X	

	Instruction	Daily	Weekly
f)	Check the trace heating system	X	
g)	Check external storage tank bund for rainwater and/or chemical. Empty as appropriate.		X
h)	Check the correct amount of chemical is being delivered for the conditions		X
i)	Check storage tank can take delivery before delivering		X
12	**Sludge Dewatering – Belt Press**	Daily	Weekly
a)	Check poly dosing system, Log polymer usage, note each bag change/delivery, Make adjustments to optimize	X	-
b)	Check sludge feed rate and log	X	
c)	Check sludge on the top belt and assess the conditioning of the sludge, Check belt drainage and filtrate quality	X	
d)	Check product quality & quantity, Check condition of stockpile	X	
e)	Visually check auto lubrication systems (grease pot) are functioning correctly, take appropriate action.	X	
f)	Ensure wash water pressure is available at a minimum of 6 bar	X	
g)	Clean belt steering paddles and check they are functioning correctly	X	
h)	Clean hopper level probes and check they are functioning correctly	X	
i)	Wash station - check formation of spraying fans, rotate internal brush to clean spray nozzles. (minimum twice daily)	X	
j)	Visual Check - Hydraulic power pack - check oil level top up using clean equipment and fresh oil as required, maintain as close to full level as possible. Oil level must not be allowed to fall below 3/4 as this will cause serious damage	X	
k)	Jet wash clean the belt filter.	X	
l)	Use low pressure water hose to clean complete machine, frame, rollers and hoppers.	X	
m)	Check condition of belt filter for blinding / blockages / good filtration	X	
n)	Steering flaps - check condition and correct operation for activation of the hydraulic steering mechanism and check for wear and replace as required	X	
o)	Sample, analyse & record % dry solids on feed and cake, (Monday, Wednesday, Friday)	X	

	Instruction	Daily	Weekly
p)	High pressure steam clean the belt from underside.		X
q)	High pressure steam clean complete machine, frame rollers and hoppers avoiding all electrical and instrumentation equipment		X
r)	Check condition of belt filter for wear i.e. Creasing / condition of seam to avoid failure / breakage and damage to other components		X
13	**Sludge Dewatering – Centrifuge**	Daily	Weekly
a)	Check condition of stockpile, Check quality of product	X	
b)	Check kwh, amps and hours run	X	
c)	Check poly dosing system	X	
d)	Check quality of centrate	X	
e)	Check sludge feed rate, Check quality of product in feed	X	
f)	Visually check auto lubrication systems (grease pot) are functioning correctly, take appropriate action.	X	
g)	Log hours run	X	
h)	Log kwh hours run	X	
i)	Log polymer usage, note each bag change/delivery	X	
j)	Log sludge flow rate	X	
k)	Log volume of cake produced	X	
l)	Make adjustments to get optimum throughput, product quality and poly dosing	X	
m)	Sample, analyse & record % dry solids on feed and cake (Monday, Wednesday, Friday)	X	
14	**Poly Make Up, Storage, & Dosing – Liquid**	Daily	Weekly
a)	Poly make up storage & dosing – liquid - check supply of polymer held in IBC; Top up, replace, order as appropriate	X	
b)	Liquid - check dosing pumps & settings	X	
c)	Liquid - check dilution water is available	X	
d)	Liquid - clean up any spillages of liquid	X	
e)	Liquid - log usage of polymer i.e. IBCs level	X	
f)	Liquid - log settings of dosing pumps	X	
g)	Liquid - log type of polymer	X	

	Instruction	Daily	Weekly
h)	Liquid - check polymer flowmeter pressure – if above 3 bar clean filter and mixer		X
i)	Liquid - check made up solution appears ok	X	
j)	Liquid - check bunded area for spillages	X	
15	**Poly Make Up, Storage, & Dosing – Powder**	Daily	Weekly
a)	Dry powder - check dosing pumps & settings	X	
b)	Dry powder - check supply of polymer held in silo; Top up, replace, order as appropriate	X	
c)	Dry powder - check bunded area for spillages	X	
d)	Dry powder - check dilution water	X	
e)	Dry powder - check dry room / silo is heated, dry and doors are closed	X	
f)	Dry powder - check made up solution appears ok	X	
g)	Dry powder - check polymer is dry and flowing, look at screw drive and discharge to wetted head – “JETWET”	X	
h)	Dry powder - clean up any spillages	X	
i)	Dry powder - log settings of dosing pumps	X	
j)	Dry powder - log type of polymer, check using correct polymer.	X	
k)	Dry powder - log usage of polymer i.e. bags used	X	
l)	Dry powder - check polymer flowmeter pressure – if above 3 bar clean filter and mixer		X
16	**Sludge Cake Transfer**	Daily	Weekly
a)	Visually check auto lubrication systems (grease pot) are functioning correctly, take appropriate action.	X	
b)	Check conveyor rollers & keep clear	X	
c)	Check drive bearings for wear & operation	X	
d)	Check electric trip wire emergency stop wire	X	
e)	Keep general area clean. Clear up any spillages	X	
f)	Check belt condition	X	
17	**Sludge Cake Storage**	Daily	Weekly
a)	Ensure silo not filled above 70% capacity. Inform Bio-recycling of any changes to sludge production.	X	
b)	Keep general area clean to minimise odour	X	

	Instruction	Daily	Weekly
c)	Log & record each storage pad bay activity and status if applicable	X	
d)	Check wheel wash is operational	X	

Appendix 7 Odour sniff testing protocol

Purpose

Sniff testing is conducted to assist in managing odours to prevent or minimise the risk of adverse odour impact offsite.

Frequency

The procedure is to be undertaken in response to complaints or if a risk of odour nuisance at sensitive receptors is expected and/or has been substantiated.

Pre-requisites for the assessor

The assessment is undertaken by a member of staff trained in the procedure. The assessment in response to complaints will be carried out by someone not based on site. The member of staff will normally be office based rather than operations based. This means that their senses are less likely to become affected by any site odours.

Assessors must comply with the following:

- They should not consume strongly flavoured food or drink (this includes coffee) at least half an hour before conducting the assessment.
- They should not smoke at least half an hour before conducting the assessment.
- They should not consume confectionary or soft drinks must be avoided for the duration of the assessment.
- Scented toiletries including perfume, deodorant or aftershave should not be applied less than an hour before conducting the assessment.
- If the assessment requires travelling between locations in a vehicle, this vehicle must not contain deodorises / air fresheners.
- If the assessor has a cold, sore throat, or sinus trouble they should not conduct the assessment.

Prior to the commencement of the inspection, the operator shall check the weather data including the wind direction, wind speed, temperature and rainfall.

Odour complaint investigation

Where possible, odour complaints will be actively investigated by an assessor. Timely receipt of a complaint is essential if such investigations are to have any value.

At each location the following procedure is undertaken:

a. The assessor will stand facing the wind and breathe deeply, for a period of 3-5 minutes.

b. The following information is recorded using the odour monitoring form.

   i. Time, wind speed and direction, temperature, precipitation.

   ii. The type of any odour(s) detected.

   iii. The intensity of any odours detected on a scale of 0 to 6.

   iv. The persistence of the any odours detected i.e. constant or intermittent.

   v. The likely source of any odours detected (e.g. a specified onsite IED source, a specified non IED sources, offsite odour source, etc).

   vi. Any abnormal conditions on site that may account for the odour e.g. broken duct, open door, unusual operation, spillage etc.

The pre-requisites for assessors and monitoring approach are as defined in the sniff testing procedure with the following exceptions:

- The first assessment should be conducted at the complainant's location.
- If site odours are detected, the assessor shall move back towards the site, assessing potential odour sources within the Urban Waste Water Treatment (UWWT) and Sludge Treatment Centre (STC) processes and attempt to trace the odour to its source.
- On site operations shall also be reviewed to identify any abnormal site operations or activities that could be responsible for elevated odour levels.
- The sensitivity of the offsite location to odours should be recorded as a comment.

The findings of the investigation should be reported back to the Thames Customer Services Centre so that feed-back can be provided to the complainant.

Odour monitoring form

Date: _____ Assessor name: _____

Time	Location	Receptor sensitivity (off site locations only)	Wind speed & direction	Temperature (degrees)	Rainfall (y/n)	Odours detected (description)	Intensity (0 – 6)	Persistence (intermittent / constant)	Perceived source	Other comments

Intensity			**Receptor Sensitivity**
1 Very faint odour	3 Distinct odour	5 Very strong odour	Low (e.g. footpath, road)
2 Faint odour	4 Strong odour	6 Extremely strong odour	Medium (e.g. industrial or commercial workplace)
			High (e.g. housing, pub/hotel etc.)

---- End of OMP ---