CRESTWOOD ENVIRONMENTAL LTD

www.crestwoodenvironmental.co.uk
Tel: 01902 229 563

Odour Management Plan

Salisbury Poultry, Vulcan Road, Bilston

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Produced by Crestwood Environmental Ltd.

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Crestwood Environmental Limited

Registered Office:
Science, Technology and Prototyping Centre, UoWSP, Glaisher Drive, Wolverhampton, WV10 9RU, UK

Company Reg. no. 06544898
(Registered in England & Wales)

Tel: +44 (0)1902 229 563

Email: info@crestwoodenvironmental.co.uk

Web: www.crestwoodenvironmental.co.uk

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1 INTRODUCTION

1.1 BACKGROUND AND INSTRUCTION

1.1.1 Crestwood Environmental was commissioned by Salisbury Poultry (Midlands) Ltd to produce an Odour Management Plan (OMP) to control potential impacts associated with the Salisbury Poultry facility on land off Vulcan Road, Bilston.

1.1.2 The purpose of this OMP is to:

- Establish the likely sources of odour arising from the site;
- Set out the procedures followed at the site in order to prevent or minimise odour emissions; and,
- Formalise the procedures for dealing with any odour complaints.

1.1.3 In accordance with Environment Agency (EA) 'H4: Odour Management'[1] and European Commission 'Best Available Techniques (BAT) Reference Document for the Food, Drink and Milk Industries'[2], this OMP has been designed to:

- Employ appropriate methods, including monitoring and contingencies, to control and minimise odour pollution;
- Prevent unacceptable odour pollution at all times; and,
- Reduce the risk of odour releasing incidents or accidents by anticipating them and planning accordingly.

1.1.4 This OMP has considered sources, releases and impacts, and used these to identify opportunities for odour management.

1.2 SITE LOCATION AND CONTEXT

1.2.1 The site is located off Vulcan Road, Bilston, at approximate National Grid Reference (NGR): 395810, 296395. Reference should be made to Figure 1 for a map of the site and surrounding area.

1.2.2 The facility receives plucked chicken carcasses for portioning and packaging for commercial and retail markets. These activities are included within Section 6.8 Part A(1) (d) of the Environmental Permitting Regulations (2016):

> *"Treatment and processing, other than exclusively packaging, of the following raw materials, whether previously processed or unprocessed, intended for the production of food or feed (where the weight of the finished product excludes packaging)—*
>
> *(i)only animal raw materials (other than milk only) with a finished product*

[1] H4: Odour Management, EA, 2011.
[2] Best Available Techniques (BAT) Reference Document for the Food, Drink and Milk Industries, European Commission, 2019.

production capacity greater than 75 tonnes per day;"

1.2.3 The operation of the facility may result in odour emissions from a number of activities. As such, suitable measures to ensure impacts are effectively controlled have been formalised within this OMP.

1.3 REPORT UPDATES

1.3.1 Following submission of the original OMP, the site boundary has been amended to include a Breading Plant situated in a separate building on Dale Street. A small volume of the chicken portioned in the main plant is transferred to the breading plant for breading or seasoning. This process has now been included within the OMP.

2 PROCESS DESCRIPTION

2.1 INTRODUCTION

2.1.1 The operational procedures of the facility are briefly summarised in the following Sections. Reference should be made to Figure 2 and Figure 3 for a site layout plan.

2.2 MANAGEMENT

2.2.1 The overall management of the facility lies with the company Director and day to day management with the Health, Safety and Environment Manager. It is confirmed that the facility is run by an experienced operator in accordance with strict management procedures and industry best practice guidance.

2.3 MAIN FACILITY MATERIAL HANDLING

2.3.1 Plucked chicken carcasses packaged in plastic lined Dolavs are transported to site in chilled Heavy Goods Vehicles (HGVs). These are unloaded in the chilled intake area in accordance with the Intake Procedure presented in Appendix 1. The site accepts approximately 950,000 birds per week, which relates to approximately 11 deliveries per day.

2.3.2 Chickens are stored in the chilled intake area for a maximum of 3-days. A rotation system is implemented to ensure stock is used in the correct order.

2.3.3 Carcasses are tipped from the Dolav onto a conveyor. They are then manually picked by Production Operatives and hung onto a shackle as part of a moving line. The plastic Dolav liners are collected and stored as waste prior to removal off site by a licensed waste contractor once per week.

2.3.4 Chicken portioning is predominantly undertaken by automated machines. These select, grade, debone and portion the carcasses. Animal By Product (ABP) is removed via suction using a windline system to the internal chilled storage area. CAT3 waste is stored in Dolavs and CAT2 waste stored in lidded bins. CAT3 waste is removed from site by a licensed waste contractor multiple times per day and sent for onward processing as pet food. CAT2 waste is removed from site by a licensed waste contractor weekly and sent for final disposal. Approximately 15,000 birds are also deboned manually per day, with ABP disposed of in the same manner.

2.3.5 Blood and feathers are not produced or stored on site.

2.3.6 Portioned chicken is retail packed with carbon dioxide (CO_2) in 2.5kg, 5kg or 10kg trays. These are then placed into 10kg or 15kg returnable plastic trays with a liner and covered. Packaged chicken is stored for a maximum of 3-days prior to onward transfer off-site via chilled HGV in accordance with the Despatch Procedure shown in Appendix 1. There are approximately 25 to 30 outward deliveries per day.

2.3.7 All food preparation activities are undertaken in an enclosed building maintained at a temperature of 0°C to 8°C in order to reduce the potential for decay of material and associated odour emissions. Monitoring of ambient temperatures is undertaken in order to ensure that all refrigeration plant is performing effectively. Any deviations from

specified temperature thresholds are reported immediately to a site engineer so that remedial corrective action can be taken.

2.3.8 There are no dedicated ventilation systems for process areas, with extract only provided to domestic rooms, including canteens, changing rooms, toilets and offices.

2.4 BREADING PLANT MATERIAL HANDLING

2.4.1 The facility also contains a separate building which undertakes breading and frying of chicken.

2.4.2 Chilled portioned chicken arrives in trays which are covered in plastic wrap on a pallet. These are received at despatch and placed into the intake chiller.

2.4.3 Chilled chicken mince arrives in Dolavs covered in plastic wrap. This is also received at despatch and placed into the intake chiller.

2.4.4 Chicken is stored for no longer than 12-hours before seasoning is added in batches in the central process room. The seasoned chicken is stored in the chilled room before being formed and coated on the production lines where it is then flash fried.

2.4.5 The flash-fried chicken is stored in the despatch chiller for a maximum of 48-hours, prior to onward transfer off-site via chilled HGV in accordance with the Despatch Procedure shown in Appendix 1

2.4.6 All rejects and waste product are stored chilled in the chiller freezer and collected every Monday.

2.5 CLEANING

2.5.1 The facility is cleaned daily in accordance with the procedure provided in Appendix 2. Wastewater generated by the wash-down process is initially collected in surface drains. These feature covers to collect any solids which are not removed during dry cleaning. The effluent is then discharged to foul sewer.

3 ODOUR MANAGEMENT PLAN

3.1 INTRODUCTION

3.1.1 The OMP follows and addresses the various activities which have the potential to create odour. The following steps were undertaken in order to produce the OMP:

- Identification of odour sources;
- Formalisation of odour control measures;
- Consideration of site location and sensitive locations potentially affected by odour emissions;
- Risk assessment of potential issues and identification of control measures;
- Production of an odour monitoring procedure;
- Production of emergency operating procedures and odour control measures;
- Production of complaints handling procedure; and,
- Production of OMP modification procedure.

3.1.2 The results are detailed in the following Sections.

3.2 SOURCES

3.2.1 The following potential sources of odour emissions were identified during the operation of the facility:

- Chicken carcass processing and packing;
- ABP storage;
- Despatch area; and,
- Fryer stacks.

3.2.2 Emissions from the above sources are likely to be similar to 'blood, raw meat' or ‘oily, fatty’ and therefore have a slightly negative hedonic tone.

3.3 ODOUR CONTROL MEASURES

3.3.1 Appropriate measures are employed during the operation of the facility in order to control and minimise odour pollution. These have been determined with reference to relevant best practice guidance and are summarised as follows:

- All activities and waste storage are undertaken in an enclosed building in order to reduce the potential for fugitive odour emissions;
- The facility is chilled to reduce the potential for decay of material and associated odour emissions;

- The facility only accepts chicken carcasses for processing. These have an inherently low odour generating potential when fresh. Slaughtering, feather removal and evisceration is not undertaken on site;
- The amount of time chicken carcasses are stored on site is strictly limited in accordance with relevant food standards. This reduces the potential for decay of material and associated odour emissions;
- ABP is transferred automatically to waste storage using a windline system to avoid accumulation of material;
- CAT 3 ABP is deposited within Dolavs which are then sealed once full, cleaned down to remove any residual surface contamination and transferred to a dedicated chiller prior to regular removal from site. Cold storage of the materials will help to prevent uncontrolled decay and associated odours;
- CAT 2 ABP is deposited within lidded bins which are then cleaned down once full to remove any residual surface contamination and transferred to a dedicated chiller prior to removal from site. Cold storage of the materials will help to prevent uncontrolled decay and associated odours;
- The fryer stacks contain filters to reduce residual odour emissions;
- The fryer stacks terminate above the roof ridge which is likely to facilitate effective dilution and dispersion of odours;
- Wash-down wastewater is collected in drains and sent to foul sewer. Any solids are removed by a filter and disposed of with ABP waste; and,
- The facility is regularly cleaner down to prevent the accumulation of odorous material.

3.4 LOCATION

3.4.1 The facility is located in a commercial/ industrial setting in Bilson, to the south-east of Wolverhampton. A desk-top study was undertaken in order to identify any sensitive receptor locations in the vicinity of the site that required specific consideration within the OMP. These are summarised in Table 1.

Table 1 Sensitive Receptor Locations

Receptor		**NGR (m)**	
		X	**Y**
R1	Residential - Bissel Street	395607.5	296316.6
R2	Residential - Tame Street	395569.5	296263.1
R3	Residential - Oxford Street	395565.6	296117.6
R4	Residential - Oxford Street	395630.7	296075.8
R5	Residential - Hughes Road	396237.8	296126.4
R6	Residential - Marbury Drive	396022.1	296799.7

Receptor		NGR (m)	
		X	Y
R7	Residential - Lunt Road	395823.3	296620.3
R8	Residential - Lunt Road	395786.2	296587.9
R9	Residential - Lunt Road	395742.2	296555.4
R10	Residential - Hilton Place	395578.8	296450.0
R11	Loxdale Primary School	395664.2	295924.6
R12	Holy Trinity Roman Catholic Primary School	395419.4	296554.2
R13	Field View Primary School	395648.3	296870.5

3.4.2 Reference should be made to Figure 3 for a map of the sensitive receptor locations.

3.4.3 It is noted that there are a number of commercial and industrial units in closer proximity to the site than the receptors identified in Table 1. However, these are less sensitive to potential odour impacts and have therefore not been individually identified for the purpose of the OMP.

3.5 METEOROLOGICAL CONDITIONS

3.5.1 The potential for odour to impact at sensitive locations depends significantly on the meteorology, particularly wind direction, during emissions. In order to consider prevailing conditions at the site review of historical weather data was undertaken. Data was obtained from Birmingham Airport at NGR: 418446, 283594, which is approximately 25.9km south-east of the boundary. It is considered that conditions are likely to be reasonably similar over a distance of this magnitude and the information is a suitable source of data for an assessment of this nature.

3.5.2 Meteorological data over the period 1st January 2016 to 31st December 2020 (inclusive) is shown in Table 2. Reference should be made to Figure 4 for a wind rose of the meteorological data.

Table 2 Wind Frequency Data

Wind Direction (°)	Frequency of Wind (%)
345 - 15	5.1
15 - 45	5.0
45 - 75	4.7
75 - 105	3.4
105 - 135	3.8
135 - 165	11.0
165 - 195	12.2
195 - 225	13.8
225 - 255	10.8
255 - 285	10.1
285 - 315	9.0

Wind Direction (°)	Frequency of Wind (%)
315 - 345	9.1
Sub-Total	97.9
Calms	1.3
Missing/Incomplete	0.8

3.5.3 All meteorological data used in the assessment was provided by Atmospheric Dispersion Modelling Ltd, which is an established distributor of meteorological data within the UK.

3.5.4 As shown in Table 2, the prevailing wind direction is from the south-west. Winds from the north and east are relatively infrequent, which is indicative of conditions throughout the UK.

3.6 RISK ASSESSMENT

3.6.1 The Risk Assessment has been undertaken in accordance with the general principles of EA document 'Horizontal Guidance Note H1: Environmental Risk Assessment for Permits' and associated annexes. This included consideration of the following:

- Receptor - what is at risk? What do I wish to protect?
- Source - what is the agent or process with potential to cause harm?
- Harm - what are the harmful consequences if things go wrong?
- Pathway - how might the receptor come into contact with the source?
- Probability of exposure - how likely is this contact?
- Consequence - how severe will the consequences be if this occurs?
- Magnitude of risk - what is the overall magnitude of the risk? and,
- Justification for magnitude - on what did I base my judgement?

3.6.2 Based on the Risk Assessment outcomes potential mitigation and control options were identified.

3.6.3 Further explanation for the key assessment areas is provided below.

Receptor

3.6.4 The first step was to consider how the activity could harm the environment. This involved identifying 'receptors' that may be affected and included people, property, and the natural and physical environment.

Probability of Exposure

3.6.5 The probability of exposure was defined based on the likelihood of exposure of the specific receptor to the identified source. This depended on several factors, such as:

- Distance between source and receptor;
- Dispersion potential of emission;
- Duration of emission; and,
- Frequency of emission.

Harm

3.6.6 The severity of harm from a risk depends on:

- How much a person or part of the environment is exposed; and,
- How sensitive a person or part of the environment is.

3.6.7 Some parts of the environment can be very sensitive. For example, serious health effects can occur if humans are exposed to certain chemicals for only short periods of time.

Magnitude of Risk

3.6.8 The level of risk is a combination of:

- How likely a problem is to occur; and,
- How serious the harm might be.

3.6.9 Risk is highest where both the likelihood of a problem is high and the potential harm is severe. Risk is lowest where a problem is unlikely to occur and the harm that might result is not serious.

Assessment

3.6.10 The risk assessment of potential odour impact is provided in Table 3.

Table 3 Odour Risk Assessment

Data and Information				**Control Measures**	**Judgement**			
Receptor	**Source**	**Harm**	**Pathway**		**Probability of exposure**	**Consequence**	**Magnitude of risk**	**Justification for magnitude**
What is at risk? What do I wish to protect?	**What is the agent or process with potential to cause harm?**	**What are the harmful consequences if things go wrong?**	**How might the receptor come into contact with the source?**		**How likely is this contact?**	**How severe will the consequences be if this occurs?**	**What is the overall magnitude of the risk?**	**On what did I base my judgement?**
Residential and commercial properties in the vicinity of the site	Chicken carcass processing and packing	Loss of amenity	Wind-blown emissions	Chicken is kept fresh from receipt to despatch through use of chilled environment in accordance with food standards requirements All processing and packing is undertaken in an enclosed building The facility is cleaned down regularly with wastewater directed to foul sewer	Low due to enclosed nature of the source, the inherently low odour potential of the material and the implemented cleaning procedures	Medium if odour can be detected for extended periods at the receptor locations	Negligible	The proposed control measures and distance from source to receptor is considered to result in negligible risk of odour impact occurring
Residential and commercial properties in the vicinity of the site	ABP storage	Loss of amenity	Wind-blown emissions	ABP is stored in sealed containers ABP is chilled to avoid decomposition of material Waste is removed regularly from site The facility is cleaned down regularly with wastewater directed to foul sewer	Low due to enclosed nature of the source, short storage duration and the implemented cleaning procedures	Medium if odour can be detected for extended periods at the receptor locations	Negligible	The proposed control measures and distance from source to receptor is considered to result in negligible risk of odour impact occurring

Data and Information				Control Measures	Judgement			
Receptor	**Source**	**Harm**	**Pathway**		**Probability of exposure**	**Consequence**	**Magnitude of risk**	**Justification for magnitude**
What is at risk? What do I wish to protect?	**What is the agent or process with potential to cause harm?**	**What are the harmful consequences if things go wrong?**	**How might the receptor come into contact with the source?**		**How likely is this contact?**	**How severe will the consequences be if this occurs?**	**What is the overall magnitude of the risk?**	**On what did I base my judgement?**
Residential and commercial properties in the vicinity of the site	Despatch area	Loss of amenity	Wind-blown emissions	Chicken is kept fresh Despatch area is chilled HGVs are loaded via a sealed loading bay The facility is cleaned down regularly with wastewater directed to foul sewer	Low due to enclosed nature of the source, the inherently low odour potential of the material and the implemented cleaning procedures	Medium if odour can be detected for extended periods at the receptor locations	Negligible	The proposed control measures and distance from source to receptor is considered to result in negligible risk of odour impact occurring
Residential and commercial properties in the vicinity of the site	Fryer stacks	Loss of amenity	Wind-blown emissions	Chicken is kept fresh from receipt to despatch through use of chilled environment in accordance with food standards requirements The fryer stacks contain filters to reduce residual odour emissions The fryer stacks terminate above the roof ridge which is likely to facilitate effective dilution and dispersion of odours	Low due to enclosed nature of the source, the inherently low odour potential of the material and the effective dispersion of odours	Medium if odour can be detected for extended periods at the receptor locations	Negligible	The proposed control measures and distance from source to receptor is considered to result in negligible risk of odour impact occurring

3.6.11 As indicated in Table 3, the magnitude of risk as a result of odour emissions from the identified sources was determined to be negligible in all cases. As such, additional control measures are not considered necessary.

3.7 ODOUR MONITORING

3.7.1 To ensure significant odour impacts do not occur as a result of normal operations periodic monitoring will be undertaken in accordance with the following methodology.

Procedure

3.7.2 Sniff testing is a common form of odour monitoring that can be undertaken for relatively low cost with little formal training. While a number of factors need to be taken into account in order to minimise inconsistencies, it can provide good evidence of odour conditions in the vicinity of specific activities.

3.7.3 A sniff test consists of the assessor standing at the monitoring position for a specific period of time and recording any odour experienced at the survey location during this time. Notes on odour frequency, intensity, duration and offensiveness are recorded, as well as the prevailing meteorological conditions. The test is then repeated at a number of monitoring points around the site to determine the extent of odour impact. The results can be analysed in association with operating conditions during the survey to consider the most significant odour sources, how these may affect sensitive receptors around the facility and help inform any necessary mitigation.

3.7.4 Sniff testing will be undertaken on a weekly basis based on the historical operation of the site without odour complaint.

3.7.5 The sniff testing will be undertaken at a number of positions around the boundary of the facility during each survey. The following parameters will be scored by the assessor at each location during each survey:

- Odour detectability / intensity;
- Odour extent and persistence;
- Odour offensiveness; and,
- Meteorological conditions.

3.7.6 Categories for the recording of odour intensity and extent are summarised in Table 4.

Table 4 Odour Intensity Scoring System

Category	Intensity Description
0	No odour
1	Very faint odour
2	Faint odour
3	Distinct odour
4	Strong odour

Category	Intensity Description
5	Very strong odour
6	Extremely strong odour

3.7.7 The offensiveness of any odour will be recorded in accordance with the categories shown in Table 5.

Table 5 Odour Offensiveness Scoring System

Category	Offensiveness Description
1	Less offensive
2	Moderately offensive
3	Most offensive

3.7.8 Meteorological conditions during the surveys, including wind speed and direction, cloud cover, temperature and precipitation will be noted, as well as assessor name, process conditions, any deliveries received and any specific changes to normal operations at the facility.

3.7.9 The surveys will be undertaken by the same individual as far as practicable to minimise errors when comparing results. Consideration will also be provided to the sensitivity of the assessor, with anyone with a poor sense of smell excluded from monitoring.

Reporting

3.7.10 Sniff testing results will be logged using the form provided in Appendix 3.

Remedial Actions

3.7.11 Should significant impacts be noted then the odour source will be investigated and suitable measures put in place to ensure emissions do not cause adverse effects at any sensitive locations in the vicinity of the site. These may include removal or covering of materials, changes to operational procedures or other appropriate actions deemed necessary by the Manager.

3.7.12 Further monitoring and inspection will be undertaken within 1-hour of implementation of any remedial measures in order to ascertain whether control has been restored. Should this process indicate that there is still the potential for significant odour impacts, backstop measures will be considered and if required utilised. These may include:

- Diversion of any waiting deliveries to an alternative facility;
- Diversion of pending deliveries to an alternative facility;
- Instruction of emergency waste collections; and,
- Communication with local residents to inform them of any identified odour issues and the measures that are being undertaken in support of resolution.

3.7.13 Further monitoring and inspection will be undertaken within 1-hour of implementation of any relevant backstop measures in order to determine whether normal operations

can be re-established. Any remedial, contingency or back-stop measures implemented will be recorded using the form provided in Appendix 3.

3.8 PLANT MONITORING AND MAINTENANCE SCHEDULE

3.8.1 The operator will carry out a programme of monitoring and maintenance to ensure that all plant installed at the site performs correctly and does not contribute to additional odour generation. All observations will be recorded to allow comparison with operating parameters specified by suppliers of plant and examination of long-term performance trends. The operator will undertake appropriate maintenance and remedial work as necessary to ensure that optimum performance is achieved.

3.9 ABNORMAL/ EMERGENCY SCENARIOS

3.9.1 There is the potential for increased odour emissions during certain abnormal and emergency scenarios. The relevant actions to limit impacts during these situations are outlined in Table 6.

Table 6 Abnormal and Emergency Response Scenarios

Scenario	Operator Response
Failure of site infrastructure	In the very unlikely event that damage is caused to site infrastructure including but not limited to the processing buildings, there may be an increased potential for fugitive odour emissions. As such, appropriate repair work will be undertaken by site engineers or a specialist contractor. In the event of prolonged failure of site infrastructure, a review of operations will be undertaken and if appropriate, specific activities will be suspended until the relevant remedial work has been undertaken
Failure of waste collection processes	All waste will be removed from the facility by licenced contractors in accordance with the frequencies specified previously in the OMP. The contractors will communicate any potential collection issues to the operator at the earliest possible opportunity in order to allow alternative arrangements to be made for waste removal. The operator will also maintain backup contractors which can be used in the unlikely event that primary contractors are unable to attend the facility to remove materials in line with the required frequencies and alternative arrangements cannot be made In the extremely unlikely event that any solid wastes cannot be removed from the facility, the temporary storage measures for materials (sealed Dolavs stored in chillers) are likely to provide adequate control of odour emissions. However, as a precautionary measure, operations will be suspended as required until the materials can be removed from the site and normal procedures are resumed
Power failure	The risk of prolonged power failure is considered negligible. However, relevant emergency procedures and back-up facilities are in place should this event occur to ensure the process is not affected as far as practicable. This is likely to avoid any unexpected odour emissions with the exception of those already addressed in this Table

Scenario	Operator Response
Fire and/or explosions	A fire on site may lead to exposure of odorous materials to atmosphere, as well as emissions of odorous combustion products Any fire would be extinguished as a matter of urgency by the emergency services. This would reduce the duration of any odour effect as far as practicable Any odorous materials released by fire would be cleaned by a site operative or specialist contractor. If any infrastructure is damaged this would be repaired or replaced as a matter of urgency
Staff unavailability due to industrial action, sickness etc	Staff unavailability may affect facility operations. If this was the case emergency cover would be arranged to ensure the process was not disturbed
Extreme weather events such as prolonged rainfall, lightning strikes, flood etc	The risk of additional odour emissions due to extreme weather events is not considered significant

3.10 ODOUR COMPLAINT PROCEDURE

3.10.1 Any received odour complaints will be dealt with by the Manager in the first instance. The complaints procedure will be followed, responding to the event within 24-hours and investigating the incident to determine the nature of the complaint. Where such an investigation identifies an odour issue, remedial action will promptly be implemented. The exact measures will be determined based on the odour source and likelihood of incident reoccurrence.

3.10.2 If a complaint is made, the form included at Appendix 3 of this OMP will be completed and this will be available for inspection by the regulator.

3.10.3 Information will normally be collected by visiting the complainant, although in some cases, contact may be made by telephone. After details of the complaint have been compiled, the cause(s) will be investigated, with reference to:

- The activities taking place at the plant during the incident;
- The timing of the complaint and whether weekday, weekend etc;
- The prevailing meteorological conditions;
- Likely reasons for the complaint will be added to the form and the complainant will be contacted as appropriate; and,
- The feasibility of making changes to the activities responsible for the complaint will be considered.

3.10.4 If changes are made, Improvement Programmes will be recorded and the OMP amended accordingly.

3.11 NEIGHBOUR AND COMMUNITY ENGAGEMENT

3.11.1 In order to promote neighbour and community engagement, details of how to contact a member of the site management team will be displayed at the entrance to the facility.

This will facilitate direct communication of any concerns or complaints in relation to odour so that prompt and appropriate remedial action can be undertaken.

3.11.2 Any communication received will be dealt with on a case by case basis and in accordance with the complaints procedure detailed in the previous Section. However, review of all communications will be undertaken every month in order to identify any long-term trends and establish whether any additional engagement measures such as organisation of community liaison group meetings or development of website facilities are required.

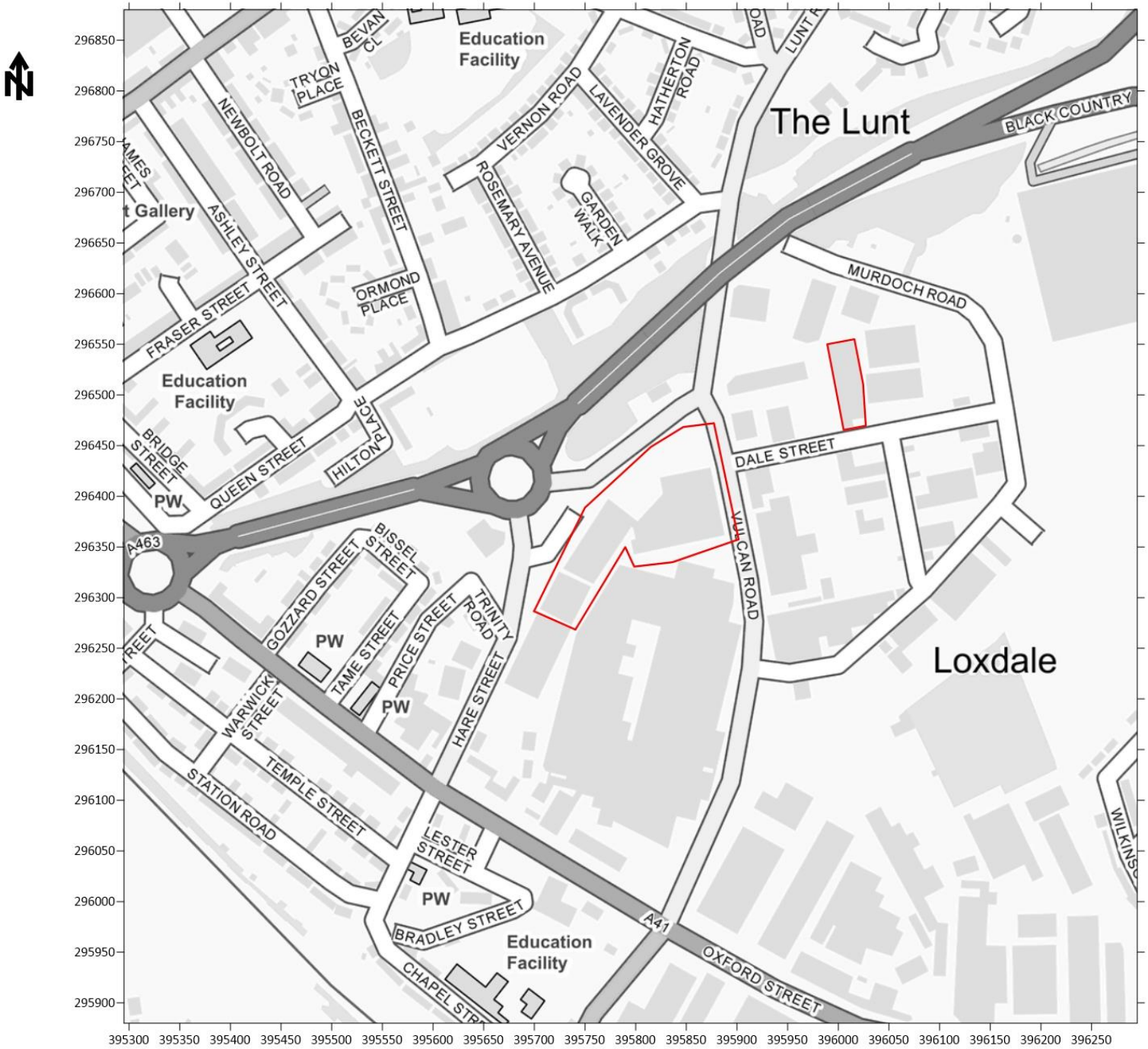
3.11.3 In the event that multiple complaints are received on any operational day, a full inspection of the facility and odour monitoring will be undertaken in accordance with the procedures set out previously.

3.12 ODOUR DIARY

3.12.1 All sniff testing results and associated reporting forms will be filed within an Odour Diary. This will form a permanent record of odour issues associated with the site and can be used should investigation of complaints or other concerns be necessary. Details of any received complaints and associated remedial actions will also be archived. The Odour Diary will be kept on-site at all times and will be available for inspection by the regulator upon request.

3.13 ODOUR MANAGEMENT PLAN REVIEW PROCEDURE

3.13.1 The OMP shall be reviewed at least once every 12-months or as soon as practicable after a complaint is received or modifications are made to any operations at the site (whichever is the earlier). Any changes to the OMP will be recorded.



Legend

Site Boundary

Title

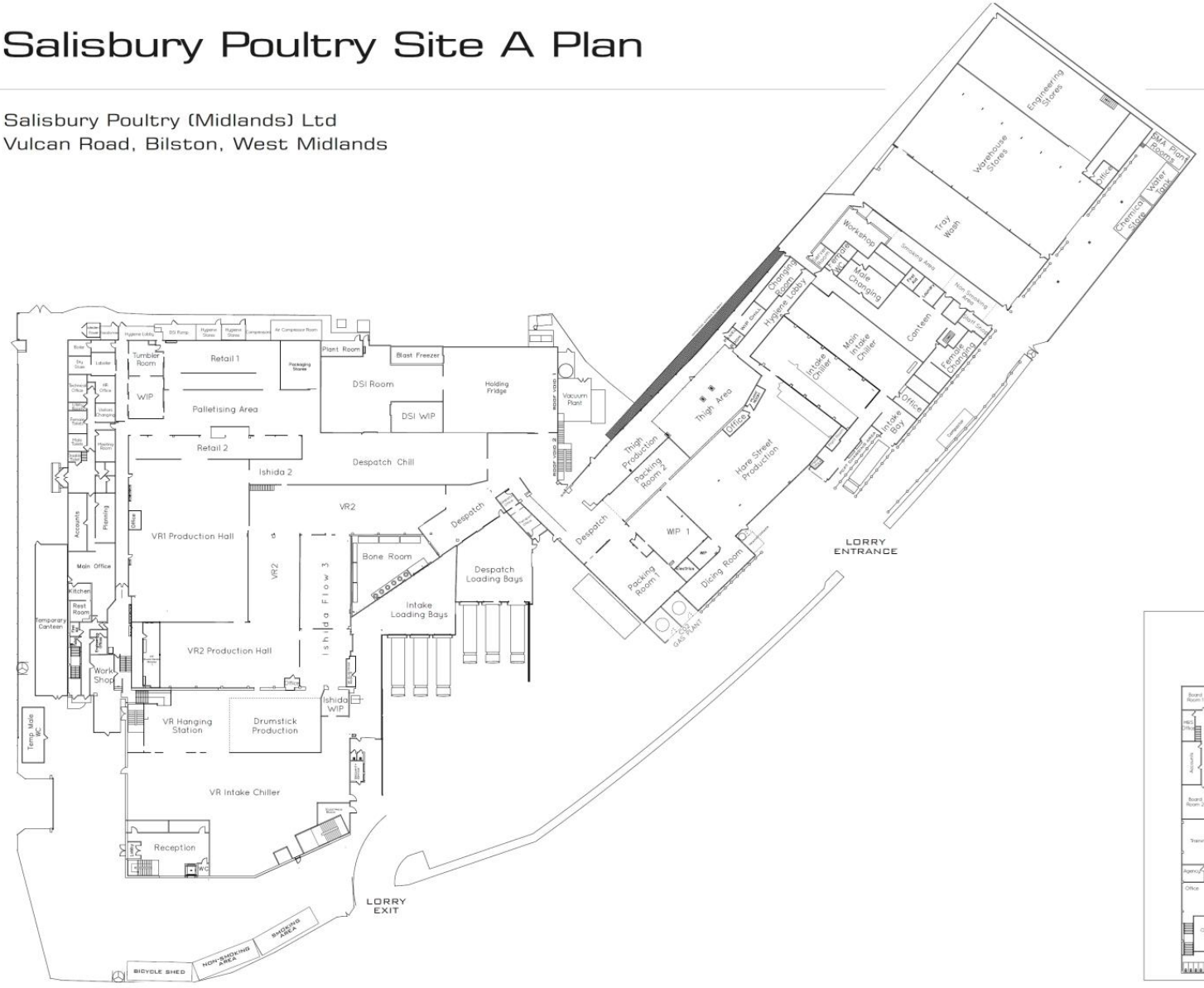
Figure 1 - Site Location

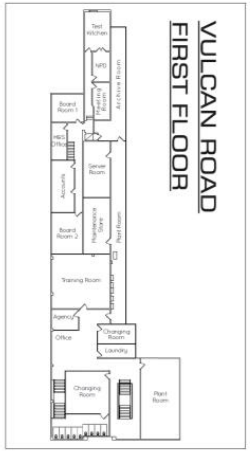
Project

Odour Management Plan
Vulcan Road, Bilston

Salisbury Poultry Site A Plan

Salisbury Poultry (Midlands) Ltd
Vulcan Road, Bilston, West Midlands





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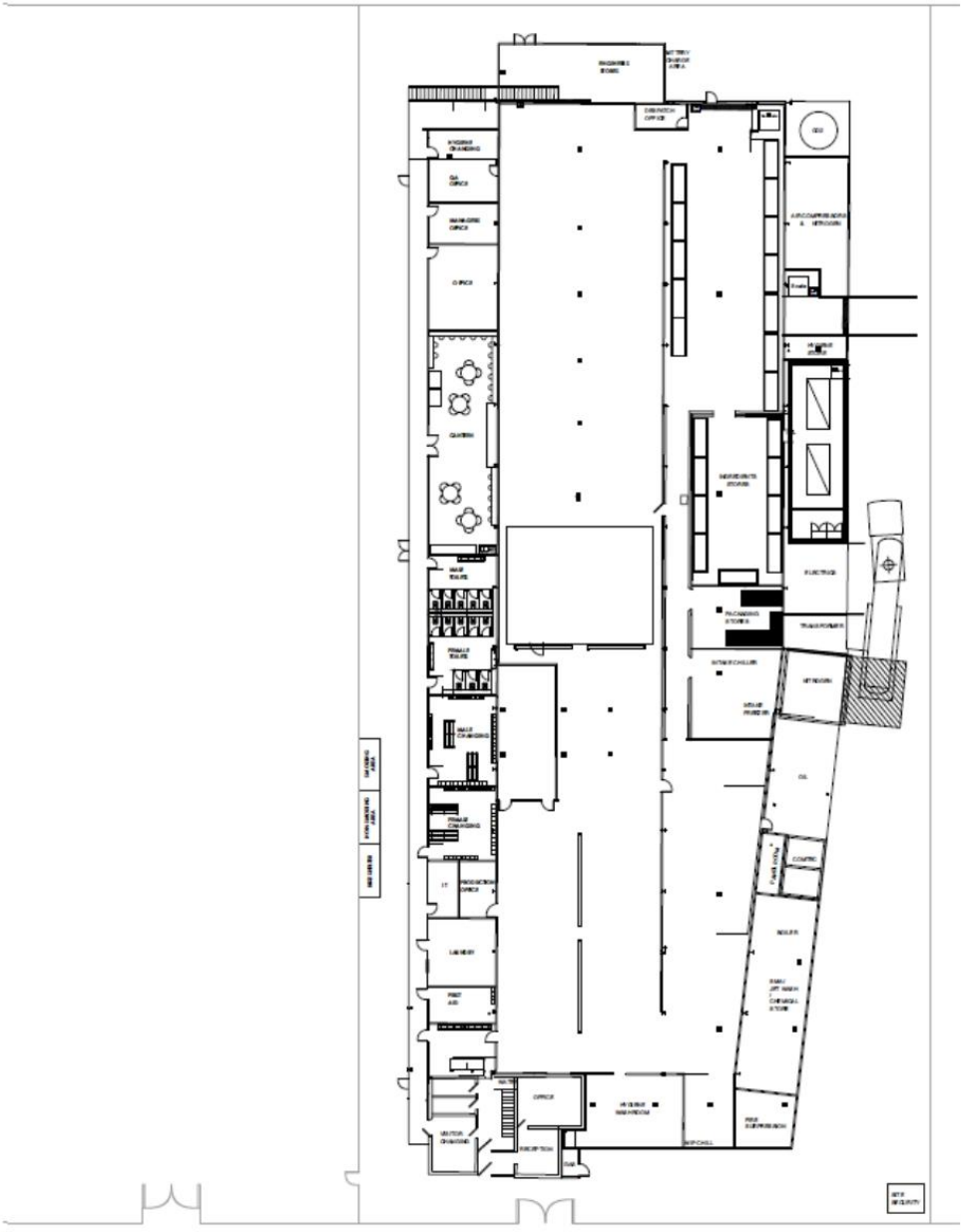
Title
Figure 2 - Site Layout

Project
Odour Management Plan
Vulcan Road, Bilston

Salisbury Poultry - Breaded Site

Salisbury Poultry (Midlands) Ltd, Dale Street, Bilston, West Midlands



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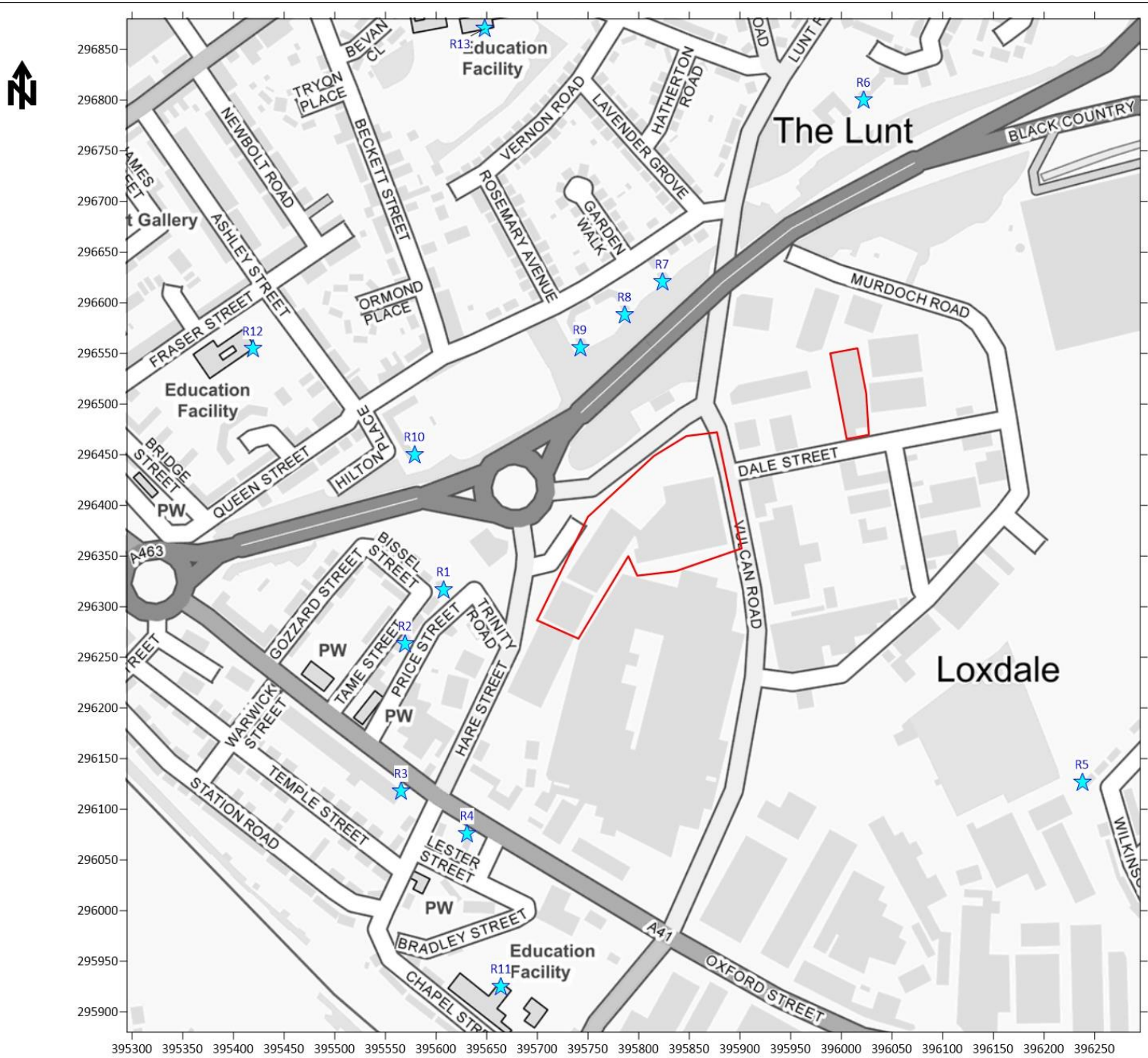
Title
Figure 3 - Site Layout - Breading Plant

Project
Odour Management Plan
Vulcan Road, Bilston



Legend

Site Boundary

Receptor

Title

Figure 4 - Receptor Locations

Project

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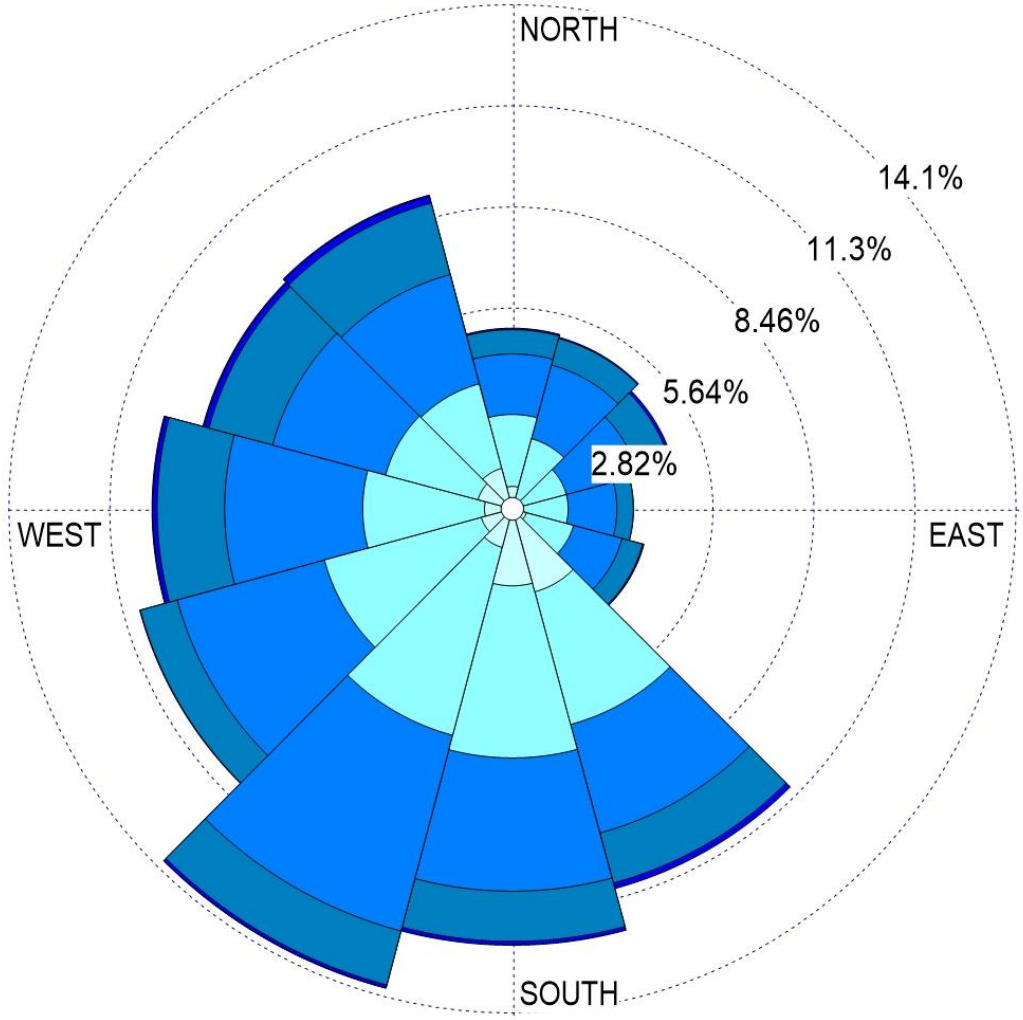

WIND SPEED (m/s)

- >= 11.10
- 8.80 - 11.10
- 5.70 - 8.80
- 3.60 - 5.70
- 2.10 - 3.60
- 0.50 - 2.10

Calms: 1.27%

Legend

Title

Figure 5 - Wind Rose of 2016 to 2020
Birmingham Airport Meteorological Data

Project

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APPENDIX 1 - INTAKE AND DESPATCH PROCEDURES

APPENDIX 2 - CLEANING PROCEDURE

APPENDIX 3 - REPORTING FORMS

REPORTING FORM: ODOUR 1 - AMBIENT SNIFF TESTING

NOTE: This form should be used for recording results from ambient sniff testing surveys. All fields should be completed in full.

Reporting of odour level on (date):.....

Table 1 Ambient Sniff Testing Monitoring Results

Parameter	**Sniff Testing Monitoring Results**					
	Location 1	**Location 2**	**Location 3**	**Location 4**	**Location 5**	**Location 6**
Time of test						
Description of location						
Weather conditions (e.g dry, rain etc)						
Temperature (°C)						
Wind strength (e.g light, strong, gusting etc)						
Wind direction (e.g from NE)						
Odour Intensity (1 to 6)						
Duration of test						
Pervasiveness during test						
Potential odour sources						

Monitoring undertaken by:.....

Additional observations from monitoring personnel during testing:.....

.....

Details of any required amendments to Odour Management Plan or site operation:.....

.....

Signed:..... Date:.....

REPORTING FORM: ODOUR 2 - COMPLAINT REPORTING FORM

NOTE: This form should be used for recording details of any odour complaints. All fields should be completed in full.

Reporting of odour complaint on (date):

Name, telephone number and address of complainant:.....

.....

Details of complaint:.....

Date, time and duration of odour:.....

Description of odour:.....

Meteorological conditions during incident:.....

Potential sources or activities that could give rise to odour during incident:.....

.....

Operating conditions at time of incident:.....

Date and time of complaint follow up call:.....

Action taken:.....

Details of any required amendments to Odour Management Plan or site operation:.....

.....

Signed:..... Date:.....