

A. Air

- **Combustion gases and volatile compounds**

It has been considered that the risk of fugitive emissions to air is minimal. There have been 6 reportable incidents during 2020 of refrigerant released to air.

The gas boilers undergo an annual scheduled maintenance test to identify faults that could lead to abnormal releases.

The majority of the chemicals used at the site are of low volatility, so if a spillage occurred there would be no significant releases to air.

The status of the refrigeration system is monitored continuously via the RDM refrigeration management system and any leaks will be detected quickly. The software was installed in early 2010, with the implementation of a procedure to assist advanced warning of potential leaks of refrigerant. On a weekly basis, the outlet valve of the liquid receivers will be closed, "pumping down" the system. The liquid level will be recorded.

In 2020 the site has carried out refrigeration upgrades and have more upgrades awaiting approval. The site has also been changing out the gas from R404a and upgrading it to R448.

A refrigeration project which will include the tightening of controls within the system and the addition of the installation of automatic gas leak detection is scheduled for early 2021.

- **Odours**

There were 8 unsubstantiated odour complaints received during 2020 in relation to odour complaints that had been received by Natural Resources Wales (NRW). The complaints are part of an ongoing issue in reference to Welsh Water's sewage system downstream of the Kepak Group Limited's Merthyr site.

- **Odour abatement**

Some of the operations carried out on site are odorous by nature. The plant was designed taking this into consideration and these operations are confined in buildings where possible and located in the North or West end of the site, away from nearby receptors.

The site bought in a consultant to advise and assist in providing solutions to further reduce odour from the ETP discharge. In 2020 the site began the trialling of preventative odour neutraliser technology in the effluent ahead of treatment in the ETP.

The main operations that could lead to odour releases are:

a) Waste disposal /Animal By-Product Transfers

The main control measure to avoid the generation of odour is frequent collections and adequate storage. Table 1 below summarises the site arrangements for the different types of potentially odorous waste or animal by products.

Table 1: Waste disposal arrangements

Contractor	Description of Waste	Service/Disposal Route	Transport
Waste Contractor / Transport			
GP Services	Gut content / lairage waste/ DAF sludge/ Ovine blood	Transport/AD	Bulk/Tanker
Forward Waste	Mixed Waste, Hazardous Waste, WEEE Waste, Waste Oil, Recycled Cardboard, Plastic Metal	Transport/ Sorting, Recycling and Landfill	Various
Disposal			
APC	Bovine Blood	Transport/Further processing	Tanker
NCT Leather WJ & W Lang Exeter Hides Crest Leather Rino Mastrotto Gruppo Mastrotto	Hides/Skins	Tanning	Lorries
Sarval / Advanced Proteins	Lambs Heads/Feet	Transport/Rendering	Bulker
Saria /Advanced Proteins	Bones/SRM Incineration	Transport/Rendering/Incineration	Bulker
Forward Waste	Wood	Transfer	Skip

Blood Storage and disposal

The site procedures are:-

- The refrigerated bovine blood storage system has run well during its sixth year of use. Collection occurs daily and the nature of the system has eliminated all odours.

- Blood tankers collections are supervised by Engineering, Security, or a Yardman.
- Blood tanker driver training records are supplied by contractors.
- Copies of relevant procedures are available inside the blood storage room for reference.
- The active carbon filters are inspected every 2 months and changed every 6 months.
- Hygiene and housekeeping standards have been maintained and the blood storage room and associated areas are cleaned daily.

b) Lairage

The build-up of odours in this area is minimised by the constant movement of air by means of air fans, air extraction and adherence to Cleaning Schedules and Company procedures:

- The lairage works on a clean-as-you-go basis and as soon as the pens are emptied the dung is removed and the pen cleaned. Further to this, the lairage is cleaned on a daily basis. Deep cleaning of the Lairage is controlled by a site policy, whereby NRW will be informed in advance, in order to be aware of potential odour issues.
- We work a clean livestock policy and suppliers are requested to present clean animals for slaughter. Additionally, we recommend suppliers not to feed the animals from the night prior to delivery.

The above procedures are independently monitored by the FSA as they are to ensure the hygiene of the operation and hence safe products.

c) Effluent Treatment Plant

The Effluent Treatment Plant (ETP) is located in a self-contained building and maintained to work at its optimum performance. The housekeeping and maintenance measures in place also help to limit to the installation boundary potential odour emissions, among these measures:

- Effluent sludge is removed daily, or every other day, depending on levels of production.
- Doors are kept closed when not in use.
- The ETP is cleaned daily and 'deep cleaned' once a week.
- Dedicated staff monitor the functioning of the plant continuously to ensure optimum performance and tackle any problems that may arise.
- Both effluent holding tanks are sealed and are fitted with active carbon filters.

An odour neutraliser system is fitted to the coarse screen pit and the compactor room in order to neutralise any odours generated. Site procedures will continue to be monitored and reviewed, in order to minimise the potential for odour generation prior to this.

d) Drainage system

The drainage system is served by a series of pumping pits fitted with dual pumps, failure alarms, high and low level controls and high and low level alarms. ETP staff will immediately be alerted of any failure that could lead to effluent build up, and hence potential spillages and bad odours, so that immediate action can be taken. This system is undergoing a gradual update by bypassing the pumping pits to discharge direct to sewer. This is in order to give a more controlled and constant flow and to prevent build-up of deposits and the associated costs of cleaning of the pumping pits.

e) Livestock transport cleaning

Livestock delivery vehicles are cleaned in a dedicated area before leaving site. All the waste collected during cleaning is stored in dolav bins and disposed of with dung and

straw from the lairage. Waste liquid generated by the cleaning process enters the coarse screen pit and is treated by the ETP. Interceptors are regularly cleaned, and the screened material disposed of as above.

f) Slaughter hall and meat processing operations

Adherence to hygiene cleaning schedules prevents the generation of odours in these areas. All operations areas undergo a deep clean after production, using foam and sanitiser. The operations in these areas are independently supervised by the FSA. The generation of odours due to poor hygiene conditions would imply an obvious food safety and quality risk and the site would not be allowed to operate.

g) Incinerator

The Incinerator has been removed from site.

Water

The risk of emissions from other points than those specified in the environmental permit is considered to be very low and there are no new activities on site that will increase the risk.

The drainage system, diesel tank and associated pipe work are the only underground structures.

The integrity of the drainage system sumps is inspected regularly, and no faults have been found that could lead to fugitive emissions.

All areas where potential contaminants are handled and stored are hard surfaced and preventive measures, like spill containment kerbs, have been built in where necessary. Surface water from dirty areas is collected by the foul drainage system so that it can be treated before releasing it to the sewer.

A dip test of the diesel storage tank followed by a reconciliation exercise is carried out every week to monitor their integrity.

The dosing system has been installed on a permanent basis at PP11, this pumps Hydrogen Peroxide into effluent leaving site in order to neutralise Hydrogen Sulphide gas, and therefore, reduce odour issues from Welsh Water's sewers downstream of the Kepak Merthyr site. Pumping pits have also been bypassed or filled in, in an attempt to reduce odours by smoothing out effluent flow.

- **Spillages**

There has been 0 fuel spillages in 2020.

B. Land

All factory waste is stored in appropriate containers on hard surfaced areas and collected and disposed offsite by licensed contractors. We believe that the risk of fugitive emissions to land is minimal.