

| Activity | Area | Impact | Receptor | Description | Likelihood | Consequence | Risk | Control | Likelihood | Consequence | Residual Risk |
|--------------------|--|---------------|-------------|--|------------|-------------|-------------|---|------------|---------------|---------------|
| Deliveries | Spillage when unloading trucks (external to the building) | Contamination | Land, Water | Materials spilt when bulk ingredients are unloaded into auger pit | Likely | Minor | Medium | Unloading to be carried out by trained staff to minimise risk of incidents Unloading of dry ingredients is under cover and into a pit. Any spillage can be shovelled into the pit. | Possible | Insignificant | Low |
| | Spillage from bulk liquid deliveries | Contamination | Land, Water | Materials spilt during connection, disconnection or pumping of bulk liquids | Possible | Moderate | Medium | Unloading to be carried out by trained staff to minimise risk of incidents Unloading of Tallow is via a pump and connection within a bunded area to minimise possibility of external spillages. | Unlikely | Minor | Low |
| | Contamination due to breakdown or leakage from delivery vehicles | Contamination | Land, Water | Delivery vehicle breaks down leading to vehicle fluids being dropped on surfaces | Unlikely | Minor | Low | Trucks to unload in designated areas where surface washdown or clean-up can be achieved. Designated areas include an interceptor trap prior to entering the drainage system. Spill kit present on site to assist in cleanup | Unlikely | Minor | Low |
| Process Operations | Stoppage in the key production process line | Contamination | Land, Water | Process fails (power outage, equipment breakage) and leads to product being removed from the process | Possible | Minor | Low | Appropriate plant maintenance will be scheduled and conducted Disposal routes established for routine process waste to be utilised for partially processed product. Where possible partially processed ingredients will be reworked into a finished product. | Unlikely | Insignificant | Low |
| | Spillage from liquid digest storage in warehouse | Contamination | Land, Water | Mobile plant damages containers, containers fail, process hoses fail etc | Likely | Moderate | Significant | Physically separate mobile plant from liquid digest storage area (unless deliveries are occurring) Pallecon (IBC) in use to be bunded Deliveries to be carried out by trained staff to minimise risk of incidents Bund digest storage area with sock, boom or similar that allows access | Possible | Minor | Medium |
| Odour Management | Failure of odour control plant causing release of high levels of odour | Odour | Air | Odour control system fails to remove odour (blockage, overload, water supply failure) | Possible | Major | Significant | Appropriate maintenance will be scheduled and conducted. Spare parts (bearings, seals etc.) to be kept on site in case of failure to ensure minimal downtime | Unlikely | Major | Medium |
| | Noticeable fugitive odour emissions from building | Odour | Air | Process failure leads to significant odour release inside building during rectification | Possible | Moderate | Medium | The coating of tallow and digest is done in an enclosed room and within enclosed machinery to ensure that this odorous step is fully contained, minimising the level of odour inside the building. Extraction and treatment of odorous air is included in the design | Unlikely | Moderate | Medium |
| Other ancillaries | Spillage of final product | Contamination | Land, Water | Damage of final product during storage or loading leads to spillage | Possible | Minor | Low | Loading to be carried out by trained staff to minimise risk of incidents | Unlikely | Minor | Low |
| | Spillage of cleaning and maintenance chemicals | Contamination | Land, Water | Stored chemicals leak due to damaged containers, chemicals spilled during usage | Possible | Minor | Low | Chemicals stored in bunded cupboard Cleaning and maintenance to be carried out by trained staff to minimise risk of incidents | Unlikely | Minor | Low |
| | Litter from waste storage area | Contamination | Land | Open waste storage bins leads to windblown or animal dispersed litter | Possible | Minor | Low | Bins stored outside to be lidded and closed at all times Bin collection frequency to be adequate to avoid overfull bins | Unlikely | Minor | Low |
| | Overflow of wastewater due to blockages or pump failure | Contamination | Water | Wastewater pump blocked up due to grit, solids overload, pump failure | Unlikely | Moderate | Medium | All washdown collection pits have grated covers with secondary mesh strainers to capture any solids Wastewater tank in an appropriately bunded area with visible level indicator on the tank. | Unlikely | Minor | Low |