

Attachment N^o D.1

Attachment D.1: Operational Information Requirements

The Green Pasture Meat Processors Ltd. abattoir in Drumlish Village, Longford has been operational since the 1940's. The abattoir was upgraded in 1995 and today it slaughters 3,500-4,000 pigs/sows per week. It currently employs approximately 48 people.

From a review of the OSI historic mapping (c.1911) the site appears to be a Greenfield site at the beginning of the 20th century. An overview of the sites historic operations is outlined below:

- Philip Davis operated a beef and lamb abattoir from the 1920's to 1950's onsite.
- John Davis operated a multiple species abattoir from 1950's to April 1989 onsite.
- Davis Meats Ltd. operated an abattoir from April 1989 to 1995. This multiple species abattoir processed beef, lamb and pork at a scale of approximately 40MT per week.
- Green Pasture Meat Processors Ltd. commenced operations on site in 1995. Prior to 1997, the abattoir was multiple species and processed beef, lamb and pigs at a scale of approximately 40MT per week. Slaughtering of pigs commenced on-site in the 1970's to present.

Green Pastures Meat Processors Ltd. abattoir is approved by Department of Agriculture Fisheries and Food (DAFF); the site implements the BRC Global Standard for Food Safety and operates a HACCP Food Safety Management System.

Unit Process Operations

The Green Pastures Meat Processors Ltd. unit process operations are detailed below with process flow diagrams. Green Pastures Meat Processors Ltd. produces sow sides, pork sides and primal cuts for the home and export markets.

1. Intake

Pigs scheduled for slaughter are delivered to the site by hauliers by road. On arrival, the delivery vehicles are weighed and the documentation for the animals is checked; only those animals having the necessary documentation are accepted. The pigs are then unloaded and the Ante-Mortem Inspection is conducted by the veterinary inspector on all incoming pigs. After unloading, the pig delivery vehicles are taken to the truck wash area for washing before leaving the site.

2. Penning (lairage)

Pigs passed as fit for slaughter are transferred to their designated pens. Sows/boars and pigs are penned separately. Where necessary, a fine water spray is applied to the pigs to prevent heat stress and to remove excess dirt.

The animals are placed in livestock holding pens in the lairage. This is carried out at intake or during their hold in the lairage. Pigs are either passed as fit for slaughter, condemned ante-mortem or detained pending further inspection.

3. Loading the stun box

The pigs are loaded into the stun box cage and the door is shut. The cage is then lowered into the CO₂ chamber.

4. Stunning

For stunning by CO₂ the pig is exposed to greater than 80% CO₂ to induce anesthesia. The pig is kept in the cage until stunned. The operator checks that there is no movements before raising the cage.

5. Shackling

When stunning is complete the cage is emptied, pigs are shackled and suspended over the bleed bath.

6. Sticking/bleeding

The carcass is stuck without any delay after stunning in accordance with EU animal welfare legislation dictates that bleeding must be started as soon as possible after stunning and be carried out in such a way so as to bring about rapid, profuse and complete bleeding. The carcass is bled over a bath, to collect the blood for CAT 3 disposal. Blood is collected regularly and sent to Regal Processors Ltd. for further processing.

7. Scalding

When fully bled the carcass are released into the scalding tank (between 58 °C and 65 °C) for 6-8 minutes which loosens and removes the bristles and toenails.

An automatic de-hairing machine is used to remove bristles and toenails from pig carcasses. This comprises a number of rotating rubber flails, which brush or scrape the surface of the carcass. Hair and toenails are sent for rendering.

8. Inserting gambrel hook

Gambrel hooks are inserted into the hindlegs and the carcass is suspended.

9. Scraping

Scraping of the carcass is carried out to remove any hair left behind by the dehairing machine.

10. Singeing

The carcass proceeds through a singer which burns off the stubble from the carcass. The unit uses propane fired gas burners. The degree of singeing is controlled by the amount of energy supplied. Singeing temperatures are around 900 - 1000 °C.

11. Polishing

The carcass then passes through a continuous row of polishing poles which removes particles of hair still remaining on the carcass after singeing.

12. De-bunging

A bung is inserted into the anus and the anus is separated from the rest of the carcass.

13. Evisceration

The mid-line is opened and the viscera are removed from the carcass. This involves the manual removal of the respiratory, pulmonary and digestive organs. This is done by pulling out the bladder and the uterus, the intestines and mesenteries; the rumen and other parts of the stomach. The resulting green offal is loaded into pans for inspection, it is separated into CAT & Cat 3 material and removed to the relevant trailer.

14. Pluck Removal

The breast bone is split and after cutting through the diaphragm, the plucks, i.e. the heart, liver, lungs and trachea. The plucks are hung on hooks for inspection and sent to the offal processing area. Trichinella samples are then taken. These plucks are sent for chilling.

15. Veterinary Inspection

Plucks, heads and viscera are inspected by the veterinary inspector. Where necessary these are condemned to CAT 1.

16. Dis-articulation of front feet

Front feet are cut so that they can remain connected only by a piece of flesh.

17. Backmarking

The pig carcasses are backmarked.

18. Carcass splitting

Carcass are split from the tail end down to the skull. Water is sprayed onto the blade to remove any bone dust which is generated.

19. Head separation

The head is separated at the atlantal joint without removing it.

20. Veterinary inspection

Carcasses are inspected by the veterinary inspector. Carcasses or part carcasses are condemned at this point if deemed necessary to CAT 1.

21. Cord Tying

The cord is attached to each hind leg (pigs) to allow suspension of the carcass when loading out.

22. Stamping

The EU Health Mark is applied to carcass.

23. Carcass weighing

Carcasses are weighed and the slap mark is recorded.

24. Carcass washing

Carcasses are washed to remove any bone dust.

25. Jowl & stick mark trim

The jowl and stick mark are trimmed.

26. Kidney and flare fat removal

Kidney and flare fat are removed. Kidney and flare fat is sent for chilling.

27. Final inspection

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Carcasses are inspected for the presence of faecal matter, hair or physical contaminants. Carcasses which show any sign of contamination are directed towards the detention rail.

28. Spinal Cord Removal

Spinal cords are removed and the carcass is inspected for the presence of faecal matter, hair or physical contaminants in the lower regions. Carcasses which show any sign of contamination are directed towards the detention rail.

29. Chilling

Carcass are directed to the chill where they are chilled to achieve a temperature of $<7^{\circ}\text{C}$ in the deep and round muscle within 24 hours.

30. Head, jowl and feet trim

When chilling is complete heads and feet are removed and jowls are trimmed prior to dispatch.

31. Pre-shipping Inspection

Sows, boars and full pig's carcasses are inspected to ensure a temperature of $<7^{\circ}\text{C}$ and that they are free of contamination.

32. Dispatch

Carcasses are moved to either the dispatch area on site or boning hall.

33. Carcass enter the boning hall

The carcasses are moved to the boning hall on site via Chill No. 3.

34. Fillet removed

As the carcass enters the boning hall the fillet is removed and trimmed.

35. Gambrel removal

The gambrel is removed from the carcass and placed on the rack.

36. Carcass placed on conveyor

The carcass is then positioned on the conveyor belt and moves automatically towards the laser saw.

37. Laser saw

The laser saw splits the carcasses into legs, middles and fore-ends.

38. Legs- remove foot

The feet are then removed from the hindlegs to give long cut legs hind. The hindlegs and feet are boxed.

39. Oyster removal

Full or partial removal of oyster results in square cut or gammon cut or 1203 legs.

40. H-bone removal

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The H-Bone may be removed depending on customer requirements.

41. Tail bone removal

The tail bone may be removed depending on customer requirements.

42. Splitting of middles

The middles are then spilt into loins and bellies. They may be derinded depending on customer requirements. The rind is placed into pallet boxes.

43. - 48. Loins- de-rinded or sheet ribbed

The loins may be de-rinded or sheet-ribbed depending on customer requirements.

49. Back

The back may be derinded depending on customer requirements.

50. & 51. Bellies

The bellies may then be sheet-ribbed or single ribbed depending on customer requirements.

52. Packing

Packaging is stored in the packaging store on intake, and then transferred to the packing area as required. The product is placed in lined dolavs or cardboard boxes and sealed. Alternatively, product may be thermoform packed.

53. Dispatch Chill

Product is moved to the dispatch chill if not being dispatched immediately.

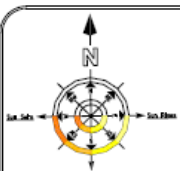
54. Dispatch

Product is moved via a forklift to the loading bay. There it is weighed, recorded and a label is printed and attached to the packaging. The product is then removed by a forklift into a refrigerated container.

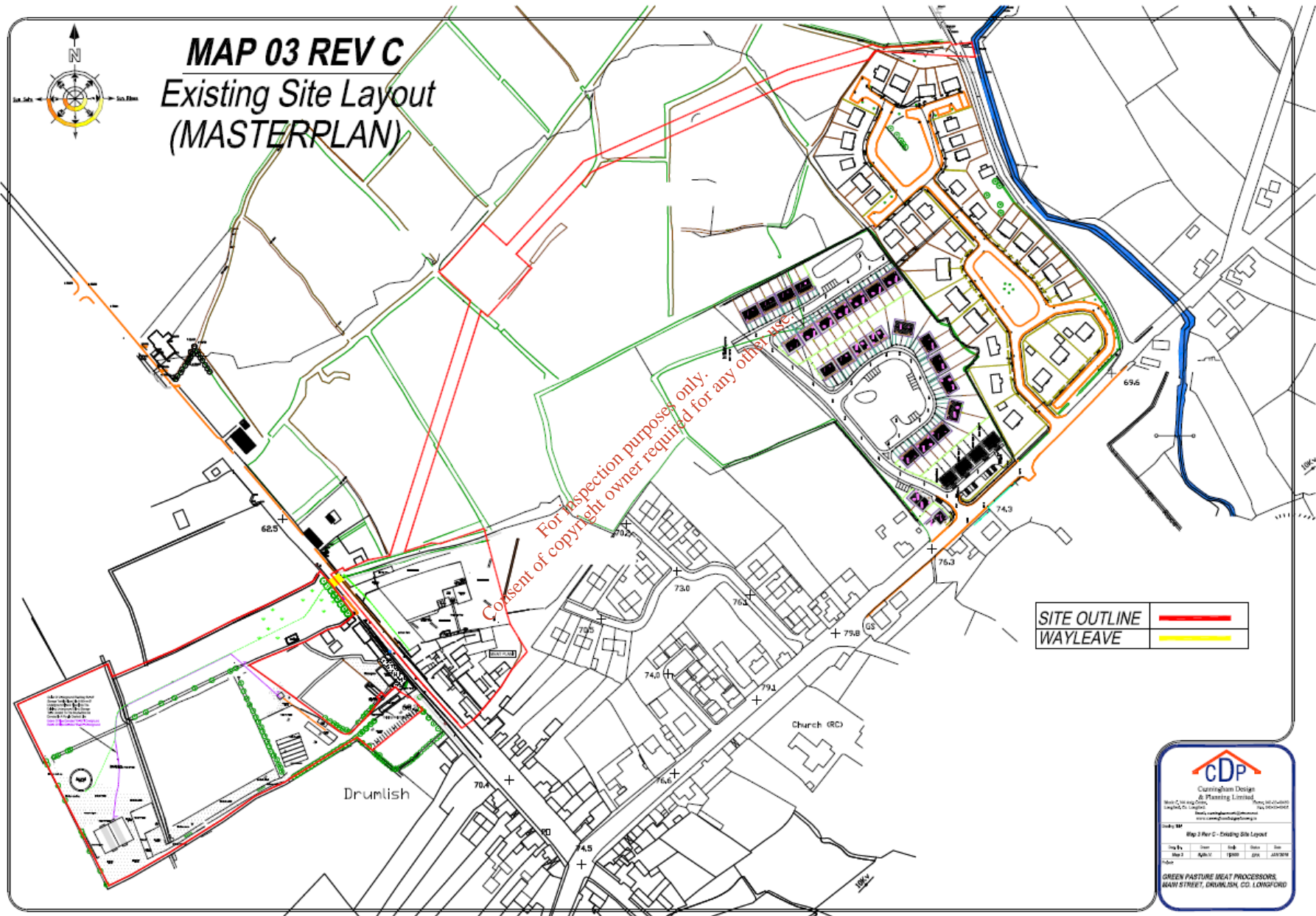
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Attachment D2: Map 3 Rev. C - Site Layout Map

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MAP 03 REV C Existing Site Layout (MASTERPLAN)



SITE OUTLINE	
WAYLEAVE	

CDP
Cunningham Design
& Planning Limited
100, The Regency, 100, The Regency, 100, The Regency
100, The Regency, 100, The Regency, 100, The Regency
100, The Regency, 100, The Regency, 100, The Regency
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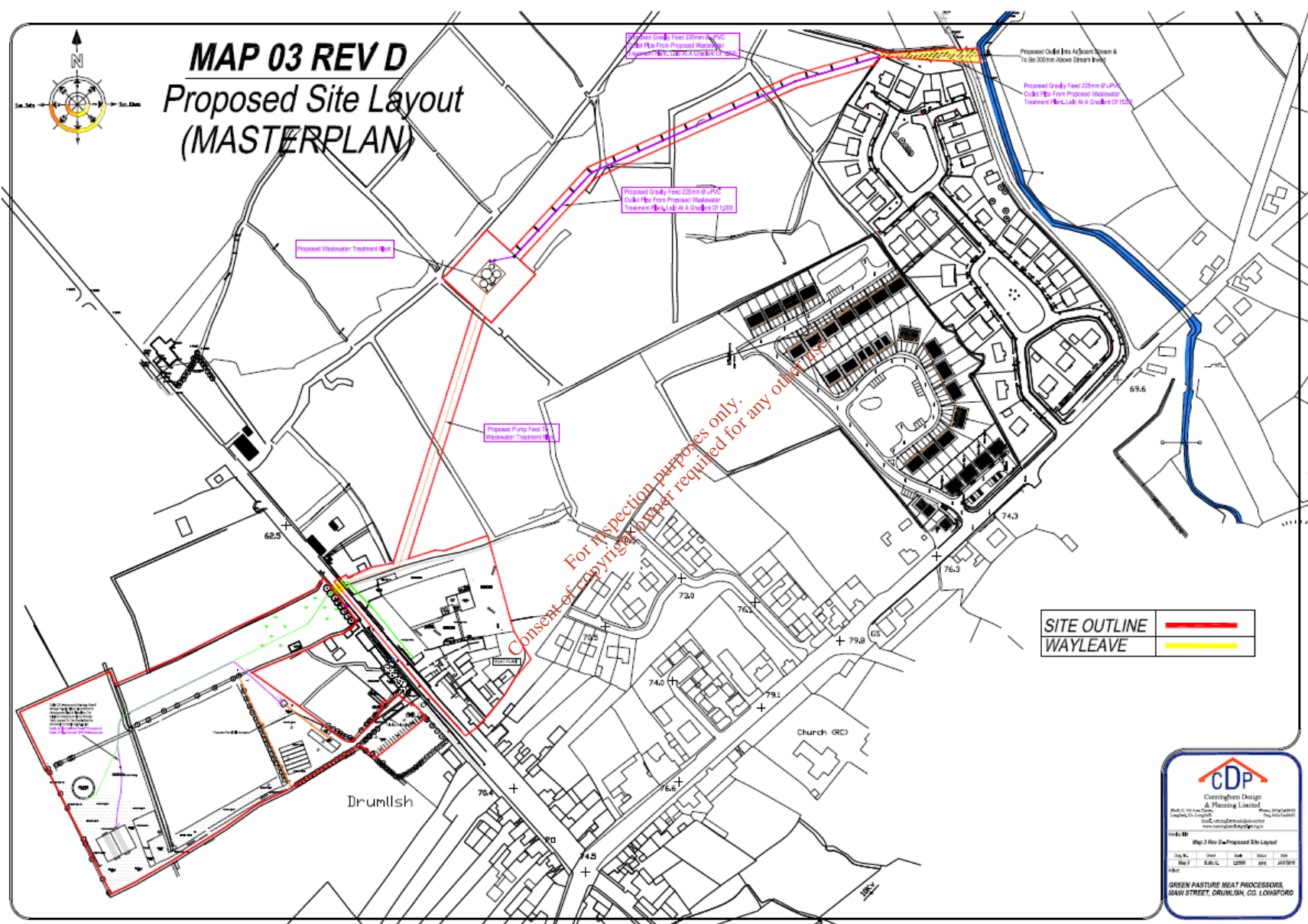
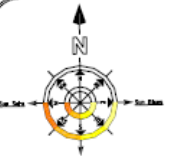
Rev	1	2	3	4	5	6	7	8	9	10
Date	10/10/14	10/10/14	10/10/14	10/10/14	10/10/14	10/10/14	10/10/14	10/10/14	10/10/14	10/10/14

GREEN PASTURE MEAT PROCESSORS,
BANK STREET, DRUMLISH, CO. LONGFORD

Map 3 Rev. D - Site Layout Map

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MAP 03 REV D Proposed Site Layout (MASTERPLAN)



Proposed Wastewater Treatment Plant

Proposed Pump Field To Wastewater Treatment Plant

Proposed Gravity Feed 225mm Ø UPVC Ductile Pipe From Proposed Wastewater Treatment Plant At A Gradient Of 1:100

Proposed Gravity Feed 225mm Ø UPVC Ductile Pipe From Proposed Wastewater Treatment Plant At A Gradient Of 1:100

Proposed Ductile Iron Access Manhole To Be 300mm Above Street Level

Proposed Gravity Feed 225mm Ø UPVC Ductile Pipe From Proposed Wastewater Treatment Plant At A Gradient Of 1:100

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SITE OUTLINE	
WAYLEAVE	

Drumlish

Church (RD)

Cunningham Design & Planning Limited
 100, C/O The Old Mill, Mill Lane, Drumlish, Co. Longford
 Tel: 0432 851111 Fax: 0432 851112
 Email: info@cdp.ie www.cdp.ie

Map 03 Rev D-Proposed Site Layout
 Date: 18/02/2016
 Author: JAYSH

GREEN PASTURE MEAT PROCESSORS,
 BAW STREET, DRUMLISH, CO. LONGFORD