



**Standard for the management of animal  
welfare at time of slaughter**

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## 1. Introduction

Food producers, consumers, retailers, processors and other stakeholders have a high degree of interest in Animal Welfare. The drivers of this are from the widely held view that animals are sentient and possess an emotional and cognitive level of understanding. On this premise, animals feel physical pain and also stress. The consequence of this is that pain and stress must be managed so that it is eliminated / minimised in animal handling and processing. This view has been reflected through enhanced awareness of the issue and the desire to ensure a high standard of animal welfare is practiced in the food chain. This desire has been manifested within legislation via the introduction of the Council Regulation (EC) No 1099/2009 on the protection of animals at the time of killing. This voluntary standard captures the requirements of the legislation and takes into account adoption of best practices for animal welfare issues from loading and transport up to the time of killing.

## 2. Scope

This standard lays down the requirements for the welfare of animals from loading up at farm, transport to the abattoir up to the time of slaughter using stunning methods approved by EC 1099/2009, and how these issues are managed at each stage in accordance with the requirements of this legislation. The standard also takes into account current best practice for relevant steps. It is intended that this standard will be continuously amended and updated in line with new technological developments and latest research. The standard is also intended to be used as a supportive aid to good practice and does not purport to be an alternative to current legislative requirements.

The species covered include bovine, ovine, porcine, poultry and equine animals. The activities covered include all relevant slaughter plant activities specified in Council Regulation (EC) No 1099/2009.

In particular, the following activities are covered by this standard:

- The promotion of animal welfare at farm level and during transport
- The loading and transport of animals to the abattoir, including the catching of live poultry
- The handling and care of animals before they are restrained, including unloading and lairaging.
- The restraint of animals for the purpose of stunning or killing. (Hanging on in case of poultry stunned by electric water-bath)
- The stunning of animals by various commonly used methods, as follows:

Animal	Stunning Method
Bovine/Cattle, Equine/Horses	Penetrative Captive Bolt Gun
Ovine /Sheep	Tong Electric Head Shock
Porcine/Pigs	High Concentration CO <sub>2</sub>
Poultry/Birds	Water-Bath Electric Shock
Equine/Horses	Penetrative Captive Bolt Gun

- The assessment of effective stunning.
- The shackling or hoisting of live animals.
- The bleeding of live animals.

For any animal product purchased from another supplier and sold explicitly or implicitly as compliant with this standard, the sub contracted producer must comply with these requirements.

Note: as other approved stunning methods evolve these will also be added in further updates and amendments of this standard.

### 3. Terms, Definitions and Abbreviations

For the purposes of this Standard, the following definitions shall apply:

**‘Abattoir’** means a slaughterhouse which is any establishment used for slaughtering terrestrial animals which falls within the scope of Regulation (EC) No 853/2004.

**‘Animal’** means any vertebrate animal, including poultry, and excluding reptiles and amphibians.

**‘Animal Welfare Quality Management System’** means all documents and records internal and external which form part of the animal welfare system as specified in this standard.

**‘Animal Welfare Officer (AWO)’** means the designated person in the business operators business who has ultimate responsibility for animal welfare in the facility.

**‘Business Operator’** means any natural or legal person having under its control an undertaking carrying out the killing of animals or any related operations falling within the scope of regulation (EC) No 1099/2009.

**‘Balk or Balking’** means where an animal stops short, interrupts movement, hesitates or flinches, stubbornly refuses to move, or change direction unexpectedly due to a perception of fear, or level of discomfort due to any causative factor.

**‘Competent Authority’** means the central authority, or delegated body of a Member State, competent to ensure compliance with the requirements of Regulation (EC) No 1099/2009 or any other authority to which that central authority has delegated that competence.

**‘Critical Animal Welfare Issues’** are issues which relate exclusively to the animal rather than inputs (e.g. Structure, facilities) or procedural issues (e.g. records, documentation) and focus on animal comfort, pain or suffering, ill health, lameness, injury, vocalisation and anything which compromises the animal.

**‘Critical breach of animal welfare’** means any issue or circumstance which will very likely or definitely cause severe pain, injury or stress to an animal.

**‘Emergency killing’** means the killing of animals which are injured or have a disease associated with severe pain or suffering and where there is no other practical possibility to alleviate this pain or suffering.

**‘Hot Wanding’** means the application of electrical tongs to an animal while charged.

**‘Killing’** means any intentionally induced process which causes the death of an animal.

**‘Lairaging’** means keeping animals in stalls, pens, covered areas or fields associated with or part of slaughterhouse operations.

**‘Major breach of animal welfare’** means any issue which is likely to cause pain, a modicum of minor suffering or stress to an animal.

**‘Minor breach of animal welfare’** means any issues which may or has the potential to cause minor stress or discomfort to an animal, and include quality system issues such as paperwork, records etc. where the likelihood of causing an animal welfare issue is considered minimal.

**‘Negative vocalisation’** means where an animal vocalises in a manner interpreted as notifying aggression, stress, fear or pain rather than normal animal communication.

**‘Poultry’** means farmed birds, including birds that are not considered to be domestic birds but which are farmed as domestic animals, with the exception of ratites.

**‘Related operations’** means operations such as handling, lairaging, restraining, stunning and bleeding of animals taking place in the context and at the location where they are to be killed.

**‘Restraint’** means the application to an animal of any procedure designed to restrict its movements sparing any avoidable pain, fear or agitation in order to facilitate effective stunning and killing.

**‘Slaughtering’** means the killing of animals intended for human consumption.

**‘Slaughterhouse’** means any establishment used for slaughtering terrestrial animals which falls within the scope of Regulation (EC) No 853/2004.

**‘Standard Operating Procedure’** means a set of written instructions aimed at achieving uniformity of the performance of a specific function or standard.

**‘Stunning’** means any intentionally induced process which causes loss of consciousness and sensibility without pain, including any process resulting in instantaneous death.

**‘Welfare Assessment Control Points System’** means a plan in an abattoir which specifies all steps in the process from animal loading up to the point of killing in the form of a flow diagram and specifies all monitoring and control points of relevance to animal welfare which are implemented in the abattoir.

**For the purposes of this Standard, the following abbreviations shall apply where relevant:**

**‘AW’** Animal Welfare.

**‘AWO’** Animal Welfare Officer.

**‘AWQMS’** Animal Welfare Quality Management System.

**‘SOP’** Standard Operating Procedure.

**‘WACPS’** Welfare Assessment Control Point System.

**FAWAC** Farm Animal Welfare Advisory Council.

#### **4. Animal Welfare Objectives**

The role of this document is to specify protocols for a business operator to comply with animal welfare requirements as specified in legislation and best practices for slaughter and related activities. Compliance with these requirements will ensure that animals are handled and slaughtered in a humane fashion and spared any avoidable distress, pain or suffering.

These requirements are intended as a useful guide stipulating required controls at all relevant animal welfare control points to be implemented by business operators. This provides a framework for independent assessment of animal welfare activities.

This standard endeavours to make animal welfare issues for animals destined for humane slaughter central to the operation of the slaughter facility

#### **5. Animal Welfare Quality Management System (AWQMS) Requirements**

##### **5.1 Company Animal Welfare Related Commitment, Resources and Welfare Assessment Control Points System (WACPS)**

The Company Management, with the support of the Company owners as appropriate, shall operate an animal welfare management system and welfare policy which enables them to demonstrate that:

5.1.1 At the highest level they shall provide leadership, commitment and actively promote a positive animal welfare culture both within the company, company suppliers of animals, handlers, and animal transporters.

5.1.2 The Management takes account of the expectations of interested parties / stakeholders including customers, regulatory bodies, suppliers of animals and societal expectations.



5.1.3 The Company shall operate a proactive active system to increase the awareness of animal welfare issues at farm level and amongst farmers, and report to relevant stakeholders on a periodic basis.

5.1.4 The Company undertakes to provide adequate resources to implement an effective Animal Welfare standard and to promote improvement.

5.1.5 The Company shall appoint an AWO and ensure that a qualified AWO (as per EC 1099/2009 Article 17.4) is on site during times of slaughter.

5.1.6 The AWO shall have sufficient authority and responsibility to as necessary prevent any critical breaches of animal welfare from occurring, up to and including the stoppage of processing until the issue is resolved.

5.1.7 The Company complies with all relevant clauses, sub clauses and annexes of EC 1099/2009, as it provides a basis for welfare management at the time of slaughter and establishes welfare requirements for “Trade” both nationally and internationally.

**The Company is committed to providing resources as follows;**

5.1.7 The Company shall provide and maintain the infrastructure and environment, including equipment, plant and structures necessary to maintain and improve animal welfare.

5.1.8 The Company is committed to staff training (Section 6 Training) and provide sufficient trained, competent personnel for all animal welfare related activities.

**Documenting the Animal Welfare Quality Management System (AWQMS)**

5.1.9 The Company shall have a comprehensive, documented animal welfare system of policies, procedures, and monitoring plans in place consistent with the requirements of this standard. The system in place must cover all relevant steps impinging on animal welfare.

5.1.10 Exclusions to this standard must be justified where necessary, if for example the requirement does not apply for species or technological reasons e.g. where a method of stunning is not in use.

5.1.11 The documented animal welfare system must be based on this standard and as a minimum include the following:

- Standard operating procedures (SOPs) of sufficient detail for all relevant tasks for process operations, monitoring and verification of animal welfare controls
- The SOPs will specify the records to be completed and necessary reporting to initiate action as required. Relevant procedures will specify how follow up of issues are conducted such that they get addressed with due urgency based on impact
- Personnel adhering to SOPs will include process operators, process supervisors, the AWO and all other staff with assigned Animal Welfare duties

- As a minimum all records, as appropriate, must be in use except where excluded by species processed or technology used

5.1.12 The animal welfare system of SOPs and records (AWQMS) must be subject to document control for coherent control of such documents.

5.1.13 Document control must consist of the following as a minimum:

- All documents subject to document control must be clearly listed
- All documents must be uniquely identified with a name, and coded number
- All documents and records where appropriate must be paginated stating page 1 of 2 etc. as appropriate, to specify sequence and number of pages in a document, with the date of issue to reflect implementation
- Records must also be controlled as above but the control is required on the template or structure of the record
- All SOPs and record templates must be approved by specified individuals, however all changes must be approved from an animal welfare perspective before implementation
- A master set of QMS documents (SOPs and record templates) must be kept which has the signature of the approver on all documents and records. This is retained solely for reference purposes. An electronic equivalent of this is acceptable provided control is documented, without ambiguity and demonstrating equivalent effectiveness
- The document control system must ensure that document circulation is controlled via a listing of circulation for all documents. Only up to date documents must be in use and obsolete documents must be promptly removed to prevent inadvertent use.
- Documents must be retained for a minimum period of 5 years or longer as required by customer or regulatory issues
- In addition all relevant external documents of relevance to the system such as legislation, codes of practice, published research and equipment manuals must be listed on a controlled list of documents. Listed materials must be maintained and be readily accessible
- Where the animal welfare system is retained on a computer, access to the computer must be password controlled and periodically changed, and the system be backed up with a specified frequency and method which will engender control
- A designated individual must be assigned to ensure coherent document control
- Details of document control must of itself be stipulated in an SOP

### **Welfare Assessment Control Points System (WACPS)**

The WACPS is an integral part of the animal welfare focussed Quality Management System (AWQMS) and must comply with the following requirements;

5.1.14 A detailed flow diagram must be in place showing all steps from animal catching in case of poultry to killing in the abattoir. The flow diagram must be kept up to date and verified with a periodic frequency.

5.1.15 Animal welfare monitoring and verification control plans must be in place which specify the monitoring and verification controls, stating type of control, method where appropriate, monitoring frequency, who is responsible and associate SOPs and records, for each relevant step in the food business operator process flow diagram.

5.1.16 The monitoring and verification controls must be risk based taking into account all pertinent risks that may affect animal welfare. Frequency and timing of controls must assure efficient detection of issues and take into account risks associated with changes / changeover in process, line speed, animal type or grade and timing during the day. Guidance provided in this standard on monitoring and verification controls must be seen as the minimum acceptable, and altered as necessary to assure efficacy.

5.1.17 All WACPS checks must be monitored and verified by suitably qualified / competent persons as defined by regulation 1099/2009.

5.1.18 All WACPS checks are monitored for conformance to specified criteria in the relevant monitoring and verification plans.

5.1.19 Specified criteria for each WACPS must be stated in objective terms to allow clear determination of compliance and non-compliance. Indicative examples of objective criteria may include, but not limited to, number of negative vocalisations, misuse of handling aids during movement, slip rate, fall rate, re-stuns, bleed rate, hang-on and fall rate for poultry, equipment measurement gas or current, stun to stick times. All criteria must be based on number of events and related time interval, animal number percentage etc. for meaningful comparison.

5.1.19 All issues identified as not meeting stated criteria are categorised according to the designations Critical, Major or Minor animal welfare issue as defined in the Terms, Definitions and Abbreviations section.

5.1.20 Relevant non compliances where a criterion is not or partially met must be subject to a documented root cause analysis in order to determine the underlying cause. The methodology used must be documented. Where the underlying cause is patently obvious, root cause methodology may not be required, however the determined cause must be documented.

5.1.21 The animal welfare policy and the welfare assessment control points are communicated to all staff within the company, and form the basis for training of all relevant staff.

5.1.22 The animal welfare system is reviewed annually to evaluate performance and promote Animal Welfare system improvement with objective criteria documented for each calendar / financial year.

5.1.23 Improvement objectives must be specific, measurable, achievable, realistic and time-bound. Responsibility for achievement is assigned to relevant staff and progress is monitored with appropriate records kept.

5.1.24 Where changes are made to the animal welfare system in place, such changes are reviewed, to assess risks to animal welfare, identify mitigating controls to minimise animal welfare impact, and planned to ensure adequacy. These are monitored on implementation to ensure efficacy.

### **Purchased or Sub Contracted Product**

5.1.25 For any animal, carcase or product purchased from another supplier and sold as explicitly or implicitly compliant with this standard, all relevant requirements of this standard must be met.

5.1.26 The Company bears responsibility for ensuring compliance and has a system in place to verify this. Documented monitoring and verification plans and related records must be in place.

### **5.2 Animal Welfare related Responsibilities and Organisational Structure**

5.2.1 The Company management structure is documented showing the responsibilities and inter-relationship of key staff and their responsibilities relative to Animal Welfare issues.

5.2.2 Responsibilities and inter relationship of relevant staff is clearly understood within the Company.

5.2.3 The animal welfare responsibilities of the Animal Welfare Officer (AWO) are set out in section **5.3** and as required, documented in relevant animal welfare system documents.

5.2.4 The animal welfare responsibilities for operational staff must be documented in relevant system procedures.

5.2.5 Certified, competent staff must be in place for all relevant roles, including AWO and certified competent deputies must be nominated, documented and available for all relevant roles which impact on animal welfare. Certification must comply with the requirements of 1099/2009.

### **5.3 Role and Competency of Animal Welfare Officer**

The Company must appoint an Animal Welfare Officer (AWO) who shall operate under the direct authority of the business operator and report to top Management. The AWO is in place to assist the Business Operator in complying with requirements of animal welfare legislation and this standard. The AWO bears responsibility for the following;

5.3.1 The AWO must have sufficient authority to set out animal welfare policies and procedures and to alter / remediate / improve these as required, including the stopping of production as required for rectification of critical animal welfare issues. The role of the AWO must be known to all relevant staff

5.3.2 The AWO shall have sufficient authority and technical competence to provide relevant guidance to animal handling and relevant slaughter line personnel.

5.3.3 The AWO retains full responsibility for the implementation of the animal welfare system in the facility and report the results to top management

5.3.4 The AWO may delegate certain animal welfare tasks to other competent staff, however this delegation must be documented in their responsibilities and such staff shall report directly to the AWO on animal welfare issues.

5.3.5 The AWO retains responsibility for the implementation of monitoring and verification of all animal welfare related activities according to a documented plan in order to ensure that such activities are implemented correctly and are effective. That remedial action where identified is implemented, and that the monitoring plan is effective.

5.3.5 In particular the AWO is responsible for the following

- insuring root cause methodology is used for all relevant breaches of animal welfare requirements
- Risk assessing all changes to facility, practices, throughput or AWQMS from an animal welfare perspective and identifying mitigation strategies
- Approving all changes in facility, practices and AWQMS from an animal welfare perspective
- Generating reports or other materials for communication to stakeholders.

5.3.6 The AWO is responsible for retaining records of any improvements to the animal welfare system and their progression to completion.

## **5.4 Maximum Capacity of the Facility**

5.4.1 The types of animal processed by the facility must be stated and be in accordance with regulatory requirements.

5.4.2 The categories of animals and weights for which the restraining and /or stunning equipment available may be used must be identified.

5.4.3 The maximum capacity of the slaughter facility for each species must be stated as follows; number of animal processed per hour and stating the maximum speed or speed setting of the line where automated.

5.4.4 The maximum speed / capacity must be set such that all animal welfare targets are capable of being met.

5.4.5 The maximum capacity of the lairage areas enclosures and facilities for overnight retention of animals must be stated.

5.4.6 The calculations employed must be based on animal size, duration of stay i.e. during the day or overnight and be available for review

## **5.5 Methods of Slaughter in use in the Facility**

5.5.1 All methods of slaughter in use in the facility must be stated for all species processed. Circumstances where methods are used must be explained as necessary.

5.5.2 Any variations in stunning or other procedures imposed by animal size, grade or weight as applicable must be identified.

5.5.3 The procedure for emergency slaughter and dealing with non-ambulatory animals must be incorporated into the WACP plan

## **5.6 The promotion of Animal Welfare at Supplier Farms**

5.6.1 The business operator promotes animal welfare at farm level, and encourages attendance at relevant animal welfare training. This is considered a necessity where breaches of animal welfare occur.

5.6.2 The business operator's policy on animal welfare is provided in writing to all animal suppliers.

5.6.3 The business operator provides information on the five freedoms and relevant FAWAC publications to animal suppliers.

5.6.4 Advice is provided on request or as required, for animal suppliers to illustrate good animal welfare practice and as an aid in addressing animal welfare issues requiring improvement.

5.6.5 All animal intake lots from farms, are assessed at each intake from an animal welfare perspective and provides feedback to the animal supplier on any issues requiring improvement. Records are maintained.

5.6.6 Animal suppliers with recurrent animal welfare issues or exhibit poor animal welfare practices will be provided with mentoring or training support. Records of this are maintained.

5.6.7 Animal suppliers with persistent animal welfare issues and are not improving shall be subject to sanction such as an economic penalty or delisting as a supplier, if appropriate. A policy shall be in place stating requirements for renewal of animal supplier status.

## **5.7 Transport Approval, Catching of Live Poultry, Loading and Transport of Animals to the Abattoir**

5.7.1 The business operator promotes animal welfare practices during animal transport with animal suppliers and hauliers.

5.7.2 The business operator's policy on animal welfare is provided in writing to all animal suppliers.

5.7.3 The business operator provides information on the five freedoms and relevant FAWAC publications to all of those transporting animals to the slaughter facility that exceed stated limits.

5.7.4 Advice is provided on request or as required, for those transporting animals to illustrate good animal welfare practice and as an aid in addressing animal welfare issues requiring improvement.

5.7.5 All animal hauliers and animal owners transporting animals above the threshold level must have received training in Animal welfare and have their transport infrastructure inspected for suitability. Threshold levels which apply are as follows:

Animal Type	Threshold level
Beef Animals	4
Horses	2
Pigs	6
Sheep	8
Birds	N/A

5.7.6 Transport suitability includes the following:

- Must be suitably clean
- Designed , constructed and fitted appropriately for the species, their size and weight range
- Designed with no protrusions, sharp edges to avoid injury, bruising etc.
- Floors on containers must be undamaged, suitable and as far as practicable non-slip
- Smooth secure fittings free from sharp protrusions
- Minimise the risk of animal escape
- Suitable access and egress platforms
- Provide protection from adverse weather conditions
- Have adequate ventilation
- Maintained in a sound mechanical and structural condition
- Where a higher level exists that provision is made to prevent faeces, urine and other materials showering onto the animals in the lower area or entering the water dispensers

5.7.7 Records of approved animal hauliers / transporters must be maintained, showing licence (applicable to hauliers only), and registration of animal transport vehicle / enclosure.

5.7.8 Re-inspection must occur yearly and where transport / animal enclosure is changed. Records must be maintained.

5.7.9 Transport enclosures for road use must have adequate capacity using the table below as a guideline;

Category of Animal	Approx. Weight (Kg)	Area m <sup>2</sup> / Animal During Transport
<b>Cattle</b>		
Medium cattle	Up to 325	0.95
Heavy cattle	325-699	0.95 -1.6
Very heavy cattle	>700	>1.6
		Adapted from Regulation (EC) 1 2005 / FAWAC Guideline
<b>Pigs</b>		
	< 100	< 0.42-0.5 (Depending on temperature and pig type) Adapted from Regulation (EC) 1 2005 / FAWAC Guideline
	100	0.42 – 0.5 (Depending on temperature and pig type) Adapted from Regulation (EC) 1 2005 / FAWAC Guideline
	> 100	> 0.42- 0.5 (Depending on temperature and pig type) Adapted from Regulation (EC) 1 2005 / FAWAC Guideline
	All sizes	Room to stand up and lie down (FAWAC)
<b>Sheep</b>		
Shorn sheep	26-55	0.2-0.3
	>55	> 0.3
Unshorn sheep	<55	0.3-0.4
	>55	>0.4
		Adapted from Regulation (EC) 1 2005 / FAWAC Guideline
<b>Poultry (In modules)</b>		<b>Ground Space in module</b>
All Poultry	1.6 - <3.0	160 cm <sup>2</sup> / Kg, 256cm <sup>2</sup> – 480cm <sup>2</sup>
	3.0 - <5.0	115 cm <sup>2</sup> /Kg, 345cm <sup>2</sup> – 575cm <sup>2</sup>
	>5	105 cm <sup>2</sup> / Kg, >525cm <sup>2</sup>
		Adapted from Regulation (EC) 1 2005
<b>Horses</b>		
Young horses (6-24 months)	350-749	1.2-2
Adult horses	>750	>2
		Adapted from Regulation (EC) 1 2005

The loading of animals must comply with the following:

5.7.10 All animals must be systematically assessed as suitable for loading and travel.

5.7.11 All animals must be moved and loaded in an unhurried manner, and in a manner consistent with their natural behaviour. Reference may be made here to Temple Grandins guidelines on animal



movement 'Understanding flight zone and point of balance for low stress handling of cattle sheep and pigs'.

5.7.12 Use of appropriate techniques for moving includes use of contactless stimuli, and contact stimuli used as a last resort.

5.7.13 Movement and loading must be performed so that slips, trips, falls and negative vocalisation is minimised.

5.7.14 Loading onto transport must take place so that the possibility of animal injury is minimised. Appropriate ramps must be at an appropriate angle and designed for sure footing to minimise slipping.

5.7.15 In terms of handling animal handling the following must be complied with:

### **Movement of Animals**

- Animals must be moved in small groups
- Animals must have a clear unobstructed passageway
- Using contactless methods of encouraging movement
- Electrical shocks may be used strictly as a last resort and in accordance with 1099/2009

It is prohibited to:

- Strike or kick the animals;
- Apply pressure to any particularly sensitive part of the body in such a way as to cause animals avoidable pain or suffering;
- Lift or drag the animals by the head, ears, horns, legs, tail or fleece, or handle them in such a way as to cause them pain or suffering, however, the prohibition on lifting animals by their legs shall not apply to poultry,
- Use prods or other implements with pointed ends
- Twist, crush or break the tails of animals or grasp the eyes of any animal.
- Any activity which might cause bruising or unnecessary fright or pain.

5.7.15 Good practices include vocal or non-contact stimuli, a light slap with the flat of the hand, rattlers with a minimum of contact. Other means may be used as a last resort for fractious, excitable or dangerous animals.

5.7.16 Electrical prods may only be used as a last resort for difficult animals as in 5.7.15. Use of contact stimuli must be recorded and reported to the receiving Company. Information on difficult or fractious animals must be reported to receiving staff prior to unloading.

5.7.17 Where possible animals that originate together should be kept together during transport.

5.7.18 The following categories of animals are transported separately (if from different social groups), animals with significant size or age differences, mature female and male animals, horned, dangerous or fractious animals.

## **Catching and Loading of Poultry**

5.7.19 Poultry catching must be performed using correct animal welfare techniques i.e. performed in a calm manner, and gently so as not to cause undue pain, stress or damage or bruising. Catching must be performed by competent staff and under the supervision of an officially certified animal welfare operative.

5.7.20 Containers for poultry, must be of sufficient size (see 5.7.10) and provide for ventilation.

5.7.21 Containers for poultry shall be handled with care and must not be thrown, dropped, or knocked over.

5.7.22 Poultry must be inserted into cages for transport with due care so as not to cause injury.

5.7.23 Containers shall be loaded horizontally and mechanically if applicable.

5.7.24 When containers are put one on top of the other, the necessary precautions shall be taken:

- To limit urine and faeces falling on the animals placed underneath;
- To ensure stability of the containers;
- To ensure that ventilation is not impeded.

## **5.8 The Unloading, Handling and Care of Animals before they are Restrained**

### **5.8.1 Facilities and Resources**

The facilities and handling must prevent avoidable pain or injury so that the animals do not exhibit fear or abnormal behaviour. The facilities of necessity must prevent avoidable interaction with other animals that could adversely affect animal welfare.

5.8.1.1 Lairage facilities shall be designed and constructed so as to facilitate the inspection of the animals. Adequate fixed or portable lighting shall be provided to enable the inspection of animals at any time, if necessary.

5.8.1.2 The illumination pattern / blue colour lighting in intake / storage area must be suitable for the animal species handled

5.8.1.3 Facilities shall be designed and constructed to minimise risk of animal injury, slips, trips or falls, bruising or stress to animals and comply with the following:

- Must be suitably clean
- Designed, constructed and fitted appropriately for the species, their size and weight range
- Designed with no protrusions, sharp edges on parts potentially coming into contact with animals to avoid injury, bruising etc. Where unavoidable protrusions (gates, posts, corners etc.) occur that animals can rub against that these are covered with a suitable material e.g. rubber or other protective material to prevent harm

- Floors must be undamaged, suitable and as far as practicable non-slip
- Smooth secure fittings
- Minimise the risk of animal escape
- Suitable access and egress platforms to all areas
- Provide protection from adverse weather conditions
- Have adequate ventilation
- Maintained in a sound mechanical and structural condition
- Designed to prevent the occurrence of unacceptable sudden noises, pneumatic or other noises that might stress animals. Pneumatic devices should be fitted with airflow directed away from animals
- Floors shall be built and maintained in such a way as to minimise the risk of animals slipping, falling or injury. Where necessary, concrete must be ribbed or grooved (ideally 2.5 cm) to provide a non-slip surface. Where necessary, appropriate matting may be used.
- There should be sufficient levels of drainage to avoid “pooling” in pens and passageways.
- All drains must be securely fitted and of appropriate design to ensure animals are not injured or stressed

5.8.1.4 Lairage and intake areas / facilities must have adequate capacity to so that animal welfare requirements can be complied with at peak times.

5.8.1.5 Stated capacities in lairages, must be based on best practice and as a minimum allow animals to turn around (exception for animals kept singly), have access to water and lie down. Minimum size of enclosures must be adequate and the following table, together with the judgement and expertise of the trained animal welfare officer, may be referred to as a general guideline for space allocation.

Category of Animal	Approx. Weight (Kg)	Area m <sup>2</sup> / Animal	
		Day	Night (or >12hours) Increase 15%
Cattle			
	Up to 325	< 1.36	< 1.56
	325 – 699	1.36 – 2.26	1.56 – 2.6
	>700	> 2.26	> 2.6
	Adapted from Industry Animal Welfare Standards Australian Meat Industry Council 2 <sup>nd</sup> Edition		
Pigs			
	<100	< 0.64	<0.74
	100	0.64	0.74
	>100	> 0.64	>0.74
	All Sizes	More space may be required in hot conditions	
	Adapted from Industry Animal Welfare Standards Australian Meat Industry Council 2 <sup>nd</sup> Edition		

Category of Animal	Approx. Weight (Kg)	Area m <sup>2</sup> / Animal	
		Day	Night (or >12hours) Increase 15%
<b>Sheep</b>			
Shorn Sheep	26-55	<0.33	<0.35
	>55	>0.33	>0.35
Unshorn Sheep	<55	<0.44	<0.51
	>55	>0.44	>0.51
	Adapted from Council Regulation (EC) NO 1/2005		
<b>Horses</b>			
Young horses	350 - 749	1.3-2.2	1.5-2.5
Adults	>750	>2.2	>2.5
	Adapted from Personal Communication		
	All animals must be able to stand up, lay down, access water and feed as appropriate and leave space for staff access and move in pen		

5.8.1.6 A lairage plan must be in place showing all animal storage areas, including overnight facilities with stock densities stated for day and overnight storage. The numbers in lairage enclosures / cages must be complied with at all times.

5.8.1.7 The water supply system in pens shall be designed, constructed and maintained so as to allow all animals at all times access to clean water without being injured or limited in their movements.

5.8.1.8 Ramps and bridges in the facility shall be equipped with lateral protection to ensure that animals cannot fall off.

5.8.1.9 When a waiting pen is used, it shall be constructed with a level floor and solid sides, between the holding pens and the race leading to the point of stunning and designed so that animals cannot be trapped or trampled.

5.8.1.10 An appropriately designed holding pen must be available for injured animals or those requiring specific veterinary inspection and clearance. Holding pens must be ready for use when animals are being received.

5.8.1.11 For pigs, rectangular pens with solid walls are recommended as they provide a greater area of wall for pigs to lie against. Pig lairages should have a system in place for cooling of pigs e.g. overhead misting or equivalent.

5.8.1.12 Lairage facilities shall be designed and constructed so as to facilitate the inspection of the animals. Adequate fixed or portable lighting shall be provided to enable the inspection of animals at any time, if necessary.

5.8.1.13 Lairage areas must have adequate facilities to protect animals from inclement weather, maintain animal comfort.

5.8.1.14 Adequate natural or mechanical ventilation must be in place, to prevent build-up of odour.

5.8.1.15 Where mechanical ventilation is in place it must be constructed so that the welfare of the animals is constantly assured, taking into account the expected range of weather conditions. Mechanical ventilation must have an alarm and emergency backup facilities in the event of breakdown.

5.8.1.16 Where slaughterhouses have field lairages without natural shelter or shade, appropriate protection from adverse weather conditions shall be provided. In the absence of such protection, these lairages shall not be used under adverse weather conditions. In the absence of a natural source of water, drinking facilities shall be provided.

5.8.1.17 Crowd pens and chutes should have solid sides (to restrict the vision and distraction of animals) with more light towards the front of the stun box to encourage them forwards

5.8.1.18 The distance from the lairage to the stun/ slaughter area should be as short as possible to minimise unnecessary movement and stress.

5.8.1.19 Pens, passageways and races shall be designed and constructed to allow animals to move freely in the required direction using their behavioural characteristics and without distraction. In the case of pigs or sheep to walk side by side, except in the case of races leading to the restraining equipment.

5.8.1.20 The race design must comply with good animal welfare practice and have lighting pattern conducive to animals moving towards restraint equipment. Blue lighting shall be in place for poultry.

5.8.1.21 For cattle the “race” shall be inclined upwards, curved, escape proof, not allow animals to turn and have a facility to allow animals to be removed and returned to the lairage if necessary.

5.8.1.22 For sheep and pigs the “race” should be inclined upwards (ideally not more than 20 degrees for pigs), wide enough to allow two animals walk side by side for as long as possible (a calming effect) where the race becomes narrower it shall be in such a manner that avoids the animals “bunching” together.

5.8.1.23 Animals in the lairage, race or stun box, or entering the water bath in the case of poultry must not be able to see any subsequent activities in the abattoir including stunning, bleeding hoisting.

#### **Operational issues**

5.8.1.24 Poultry in modules at intake area must not spend excessive time in crates awaiting hang-on on the line, a specified maximum time should be in place based on a risk assessment and validation. Poultry must not be kept overnight.

5.8.1.25 All pens, including the detention pen must be clean and readied for use prior to intake.

5.8.1.26 Lairage, animal feed and water facilities must be kept clean to a standard consistent with good animal welfare practice, and to ensure animals do not get dirty. Facilities must be cleaned daily after use as a minimum.

5.8.1.27 Each pen shall have a visible sign stating the date and time of arrival and, except for cattle kept individually, the maximum number of animals to be kept.

5.8.1.28 Animals must be slaughtered without undue delay.

5.8.1.29 Where animals are being kept overnight or longer than 12 hours, suitable feed must be made available. It shall be provided in suitable feeding equipment, e.g. racks and mangers, (circular feeders may also be used for field lairage) that are designed and sited to avoid the possibility of fouling. Such equipment shall make food easily available to animals. Drinking water shall be constantly available in drinkers, which the animals can easily reach and are unlikely to foul.

5.8.1.30 In such overnight cases, the animals shall be provided with an appropriate type and quantity of bedding or equivalent material that guarantees a level of comfort appropriate to the species and the number of animals concerned. This material shall guarantee an efficient drainage or ensure adequate absorption of urine and faeces. The company shall be able to demonstrate that where animals were slaughtered more than 12 hours from their arrival that they had been supplied with appropriate food and bedding.

5.8.1.31 Records of animals kept for longer than 12 hours must be maintained including fodder type and quantity used.

## 5.8.2 Equipment and Facility Maintenance – The Unloading, Handling and Care of Animals Before they are Restrained

The following maintenance requirements must be complied with:

Equipment	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Documents
Floors / Ramps / bridges	Intact and Clean	Visual	Monthly	Designated person	Repair, replace and clean as appropriate	Record
	Finish conducive to good footing	Visual	Monthly	Designated person	Repair, replace and clean as appropriate	Record
Floor drains	Secure / undamaged	Visual	Daily / Monthly	Designated person daily / Supervisor monthly	Repair / replace	Record
Water supply	System functioning/ Suitably clean water in	Visual	Daily / Weekly	Designated person daily /supervisor weekly	Repair, replace and clean as appropriate	Record

Equipment	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Documents
	every pen					
All pens, passageways and race	Good condition / permit free movement /clean	Visual	Daily / Monthly	Designated person daily / supervisor monthly	Repair, replace and clean as appropriate	Record
Protection from inclement weather	Roof intact no leaks	Visual	Monthly	Designated person	Repair	Record
Lighting / colour	Functioning, brightness and colour appropriate	Visual	Monthly	Designated person	Replace with correct colour and light intensity rating	Record
Mechanical Ventilation	Operating correctly and alarm functioning	Check operation and alarm capacity	Monthly	Designated person	Investigate, repair, replace	Record
Feed Storage	Appropriate, dry and clean, no rodent or pest infestation. Feed shall be in date	Visual and sample inspection as required	Monthly	Designated person	Correct fault if any, replace feed as required	Record

### 5.8.3 The Receipt and Unloading of Animals - The Unloading, Handling and Care of Animals Before they are Restrained

5.8.3.1 All animal intake lots are systematically assessed from an animal welfare perspective and provide feedback to the animal haulier / transporter on any issues where welfare requires improvement. Records are maintained.

5.8.3.2 Animal suppliers with recurrent animal welfare issues or exhibit poor animal welfare practices will be provided with mentoring or training support. Records are maintained.

5.8.3.3 Unloading ramps must be aligned in a manner that avoids gaps in which animals might injure themselves or attempt to escape or be forced to jump.

5.8.3.4 Unloading facilities, including floor of transport container, must have anti-skid finish with non-slip solid flooring, free of holes or any deficiencies which could injure or cause animals to slip or fall.

5.8.3.5 Vehicle checks must include:

- Manure levels in cattle trailers are not above the hoof hairline junction
- Where trailers have “decks” there should not be any soiling of the animals on the lower deck
- The condition of the vehicles and transport containers must enable proper, effective cleaning and disinfection (with supporting record logs)
- There should be specific plans for extreme weather conditions (e.g. severe frost where slips are more likely or extreme heat where heat exhaustion is likely)
- The method of unloading and equipment used should be consistent with good animal welfare practice. This must be monitored, particularly noting handling aids usage and how animals were encouraged off the vehicle.
- In particular, the handling of animals during unloading must comply with section 5.8.4.

5.8.3.5 Animals shall be unloaded as quickly as possible after arrival. All arrivals must be recorded in compliance with legal requirements and traceable back to owner.

5.8.3.6 Levels of negative vocalisation, slips, trips, falls and handling aid usage as a minimum should be monitored during unloading and movement into pens.

5.8.3.7 Animals on unloading must be:

- Checked on both sides of the animal during unloading
- Assessed for signs of good health such as absence of lameness, swellings, discharges, and exhibit head up, ears up, alertness, listening, smooth coat etc.
- Assessed for signs of ill health which could include lameness, restless, visible swellings or prolapses, discharge from nose, head down, drooping ears, not responsive to sounds or activity, open wounds, damaged skin or dull coat, tight skin, rapid breathing or gasping, nasal discharge or dry nose, discharge from the eyes or sunken eyes, too much salivation, failure to stand or abnormal lying position, keeping away from others in the group, does not eat or drink, or present with “udder” conditions which cause discomfort or affect mobility
- Checked to show absence of signs of avoidable pain, stress or fear or exhibit abnormal behaviour
- Checked for level of aggression and tail biting in pigs
- Visually checked for condition of poultry (cleanliness, condition of wings legs, bruising) mortality as observed in cages and stress level

5.8.3.8 The following animal welfare parameters must be monitored and measured / recorded in addition to those stated above:

- General condition of animals
- Animal level of cleanliness
- Any casualty animals must be recorded showing the reason for casualty status, how the issue was addressed from an animal welfare perspective and the fate of the animal.  
Casualty animals must be handled humanely and slaughtered according to an animal



casualty slaughter SOP, which minimise any pain or suffering (see casualty slaughter section).

- Condition of transport enclosure
- Density of animals relative to space in compartment(s). Cage size in case of poultry. The latter must be verified by count on a sample of cages at hang on
- Number of animals suffering stress or ill health, recording incidence
- Any animals detained, or held requiring Animal Welfare Officer and / or veterinary inspection, including reason and outcome of this inspection
- Any inappropriate handling at unloading by factory or haulier / delivery personnel (section see 5.8.4)
- Any avoidable damage, bruising, pain or stress caused by unloading, facilities or handling.
- Any goad usage and reason for use
- Vocalization level score
- Slip rate
- All falls that occur
- General condition of poultry must be recorded including any issues apparent prior to hang on e.g. vocalisation, damage, condition
- Any other pertinent animal welfare issue

5.8.3.9 Where possible, animals which originate together should be kept together in the lairage, mixing of groups is likely to upset the equilibrium and cause stress and possibly bruising, injury and unnecessary suffering.

5.8.3.10 Containers in which animals are transported shall be kept in good order, handled with care, in particular, if they have a perforated or flexible bottom, and:

- Containers for poultry shall not be thrown, dropped, or knocked over
- Where possible, containers shall be unloaded horizontally and mechanically

When containers are put one on top of the other, the necessary precautions shall be taken:

- Ensure stability of the containers
- To limit urine and faeces falling on the animals placed underneath
- To ensure that ventilation is not impeded

#### **5.8.4 The Handling and Moving of Animals - The Unloading, Handling and Care of Animals Before they are restrained**

5.8.4.1 Animals are handled and housed taking into consideration their normal behaviour.

5.8.4.2 Monitoring shall be consistent with requirements stated in the previous section 5.8.3.

5.8.4.3 The movement must also comply with the following:

- Animals must be moved in small groups

- Animals must have a clear unobstructed passageway
- Using contactless methods of encouraging movement
- Use of electrical shocks used strictly as a last resort and in accordance with 1099/2009

5.8.4.4 It shall be prohibited to:

- Strike or kick the animals
- Apply pressure to any particularly sensitive part of the body in such a way as to cause animals avoidable pain or suffering
- Lift or drag the animals by the head, ears, horns, legs, tail or fleece, or handle them in such a way as to cause them pain or suffering; however, the prohibition on lifting animals by their legs shall not apply to poultry
- Use prods or other implements with pointed ends
- Twist, crush or break the tails of animals or grasp the eyes of any animal
- Use instruments, which administer electric shocks, except in the case of instruments that have been approved for, use on adult bovine animals and adult pigs which refuse to move, and only when they have room ahead of them in which to move without impedance. The shocks shall last no longer than one second, be adequately spaced and shall only be applied to the muscles of the hindquarters of cattle and pigs. Shocks shall not be used repeatedly if the animal fails to respond. "Electric shock" / Goad usage must be monitored
- Drag animals, which are unable to walk to the place of slaughter. Such animals must be killed humanely using the casualty slaughter protocol
- Any activity that might cause bruising or undue fright or pain.

5.8.4.5 While animals must be moved without undue hurry, a steady supply of animals for stunning and killing shall be ensured in order to prevent animal handlers rushing animals from the holding pens.

#### 5.8.5 Standard of Operation and Monitoring of Activities – The Unloading, Handling and Care of Animals Before they are restrained

The following operations and monitoring requirements must be complied with. The process step / activity must be identified in a detailed flow diagram, which covers all relevant steps where animal welfare can be impacted upon.

Process Step Number / Activity	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Documents
Animal Receipt	Correct density in transfer vehicle storage area	Visual	Every delivery	Intake Operator	Record issue, inform haulier / animal supplier.	Record

Process Step Number / Activity	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Documents
					Rectify the issue.	
	Journey time complies with requirements < 8 hours (DAFM type 1 authorisation)	Cross check documents	Every delivery	Intake Operator	Record issue, inform haulier / animal supplier. Requiring action. Rest animals if required.	Record
	Haulier truck / storage rig / transport approved.	Cross check Name and licence plate against approved list	Every delivery	Intake Operator	Inform AWO, review truck / storage and animals. Accept or reject animals as necessary inform animal owner Initiate approval of haulier.	Recorded where corrective action required
	Farmer delivery, trailer density and standard of finish acceptable (Limited to visual observation during unloading)	Visual	Every delivery	Intake Operator	Inform AWO, Inform farmer of issue, accept and or rest animals or reject as required.	Record
	Containers used for transport conform to standard (Limited to visual observation during unloading)	Visual	Every unloading	Operator	Inform AWO, inform haulier / farmer as appropriate	Record
Animal Unloading	Animals unloaded in a manner conducive to good animal welfare practice and must be performed	Visual	Every unloading	Intake Operator	Any issues raised are addressed and operative re-trained as required	Recorded where corrective action required

Process Step Number / Activity	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Documents
	under the supervision of the abattoir					
	Both sides of animal observed. Animals in good condition free from stress or injury or ill health	Visual check every animal during unloading	Every animal	Intake Operator	Animal(s) segregated, issue recorded and AWO and veterinarian informed. Outcome reported to animal supplier	As above
	Animals checks as per detail in Sections 5.8.3.7, to 5.8.3.10 and 5.8.4 Slips, trips, falls, negative vocalisation, stress indicators handling and movement Tail biting aggression (Pigs) etc.	Visually check every animal during unloading	Every animal	Intake Operator	Animal (s) segregated and processed last if required, or alternatively rejected. Issue recorded and outcome reported to animal supplier, requiring action	As above
	Check as above	Visual check	2 animal lots Unloading /day	Supervisor	Corrective action recorded and taken as appropriate	Record
Poultry receipt	Poultry stress level condition broken legs/wings and mortality	Check at hang on	Every bird	Hang on operator	Mortality rate and AWO issues reported to supplier requiring action where necessary	Record where issue arises
	Time in cages at lairage before hang-on < 5 hours	Intake Operator	Each batch	Intake Supervisor	Use as soon as possible, review mortality figures	Record
	Poultry stress level checked	Intake Operator	Each batch resident in cage for = / > 5 hours	Intake Supervisor	Adjust ventilation to minimise stress and hang on as	Record

Process Step Number / Activity	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Documents
					soon as practicable	

## 5.9 The Restraint of Animals for the Purpose of Stunning

As a variety of animals are restrained and different methods of stunning exist, restraint methods should be adjusted to accommodate this.

### 5.9.1 Facilities and Resources

5.9.1.1 Restraining equipment (including manufacturer's instructions which should be in place and available) and facilities shall be designed, built and maintained to:

- Optimise the application of the stunning or killing method
- Be suitable for all grades, weight and type of animal processed
- Prevent discomfort, bruising or injury to the animals
- Not to trigger a 'balking reaction' in case of animals approaching or entering restraint equipment
- Minimise struggle and vocalisation when animals are approaching and are restrained
- Be narrow enough to prevent animals turning around
- Minimise the time of restraint.
- The species, categories, quantities and / or weights of animals for which equipment is designed to be used must be stated and available

5.9.1.2 For injured animals, restraint equipment must not be used in a manner that would cause unnecessary pain. In the case of injured poultry this requires killing by an alternative method.

5.9.1.12 Poultry must be hung correctly at the bottom of the shackle for effective stun.

5.9.1.12 Maintenance of restraining must be carried out by qualified, competent persons, records of all maintenance must be maintained.

### 5.9.2 Equipment, Facility Maintenance and Calibration – The Restraint of Animals for the Purpose of Stunning

The following maintenance requirements must be complied with:

Equipment	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Documents
Stunning Box (Bovines) Chamber (Pigs)	No protrusions or sharp edges. Suitable floor minimising	Visual	Monthly	Designated person	Repair, replace and clean as appropriate	Record

Equipment	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Documents
	slips / falls					
	Noise level of restraining equipment and installation must be acceptable	Measured during use	On installation and after any relevant changes	Maintenance	Take corrective action to reduce noise to acceptable level	Record
Belt V- Restrainer and Pigs	Correct size, shape, no protrusions or sharp edges. Adequate room for feet	Visual	Weekly	Designated person	Repair, replace and clean as appropriate	Record
	Speed standard set and stated. Speed of both belts consistent. Note time piece or other speed measuring device in use which must be calibrated.	Speed of operation	Weekly	Designated person	Re-adjust, repair as appropriate	Record

### 5.9.3 Standard of Operation and Monitoring of Activities - The Restraint of Animals for the Purpose of Stunning

The following operations and monitoring requirements must be complied with. The process step / activity must be identified in a detailed flow diagram which covers all relevant steps where animal welfare can be impacted upon.

Process Step / Activity	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Document /s
Stun Box / V shape Restrainer / Chamber	Operating correctly	Visual	All animals during use	Operator	Record issue, inform maintenance and supervisor	Record
	Lighting in box / end of V restrainer / chamber conducive to movement towards stunning area	Visual	Daily	Designated Operator	Any deficiency report and repaired	Record
	Residence in restrainer / hang-on (poultry) prior to stunning not to exceed as a guideline (poultry exception)	Measured time	Weekly	Supervisor	Investigate and take action to correct.	Record

Process Step / Activity	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Document /s
	<b>Animal</b>					
	<b>Seconds</b>					
	Bovines					
	60					
	Sheep					
	60					
	Pigs					
	60					
	Poultry					
	120, legal limit, (ducks, geese, turkeys)					
	60 (chicken)					
	Horses					
	60					
	Residence time minimised	All facilities and next process step ready	Every animal	Operator	Not allow animals to enter until matter resolved	N/A
Chamber	Correct number and grade of pigs allowed into chamber	Visual	Every load	Operator	Remove pig if possible	Record
	Lag time limit 60 seconds prior to exposure to gas complied with	Measured time	1/day or as required	Operator	Investigate cause, stop production if necessary repair	Record
Hang-on Poultry	Small birds not placed correctly on shackle (heads will not fully immerse in bath)	Visual	Every bird	Operator	Remove from line and slaughter by alternative means	Record
	Bird fall off	Count / 50 birds	2 / day / operator	Supervisor	Establish cause, retrain operator as necessary	Record
	Placed on lowest part of shackle	Visual	Every bird	Operator	Remove and re shackle correctly	
	Correct number of birds / cage	Count	5 cages /hang-on operator / load	Operator	Inform supervisor, who records issue	Record
	Correct number of birds / cage	Mass balance total birds / total cages	1 load / day plus any reported by operator	Supervisor	Inform AWO	Record

## **5.10 The Stunning of Animals - General Requirements.**

Animals are in practice stunned via a variety of methods. The facilities, methods and controls are covered in this section. It is a requirement that all stunning equipment be maintained according to manufacturer's specification or more frequently as required to assure effective operation of equipment.

5.10.0.1 All maintenance of stunning equipment must be performed by qualified, competent personnel.

5.10.0.2 Equipment must be used in compliance with manufacturer's recommendation and limited to use on animals of size, grade and numbers as designed for intended use.

5.10.0.3 Any modifications to such equipment must be:

- Risk assessed for potential impact on Animal Welfare
- Appropriate mitigation controls instituted to achieve Animal Welfare objectives
- Use validated and accepted by the Regulatory Authority prior to ongoing use. Records must be maintained
- The AWO must be informed in advance of any modification work so that animal welfare issues are assessed and managed, if applicable, on completion of modification and prior to routine use

5.10.0.4 Appropriate back up stunning equipment fully maintained and ready for use must be available at point of use.

5.10.0.5 Back up stunning equipment, which must be available at point of stunning / stunning evaluation, is subject to the controls stated above.

### **5.10.1 The Stunning of Animals (Including Equine) Using a Penetrative Captive Bolt Gun**

#### **5.10.1.1 Facilities, Resources and Calibration**

5.10.1.1.1 The stunning of animals must be performed by a competent operator and following a detailed SOP in a consistent fashion.

5.10.1.1.2 The SOP must stipulate clearly:

- The make, type of gun to be used
- The type of bullet strength and cap colour to be used clearly stating the type and grade of animal they are used on. The underlying table provides a minimum standard that must be complied with
- The bullet strength and type used must be suitable for the type and grade of animal, as per manufacturers specified requirements and conform to the manufacturers specification
- The gun location and direction / angle of the to the animals head must be stated and illustrated
- Maintenance of the gun between shots including cleaning



- The checks required to assess unconscious and insensibility in animals
- Location for second stun

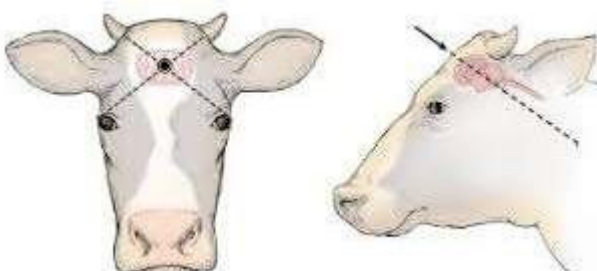
5.10.1.1.3 A current specification must be in place for the guns in use and all types of caps. The manufacturer's specification must clearly state the suitability characteristics of the gun such as bolt diameter, effective penetration length and concussive force. A current specification for the bullet cap for the range of animals handled. Guns and caps must be purchased from an approved manufacturer.

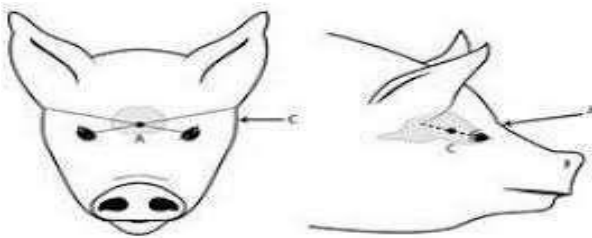


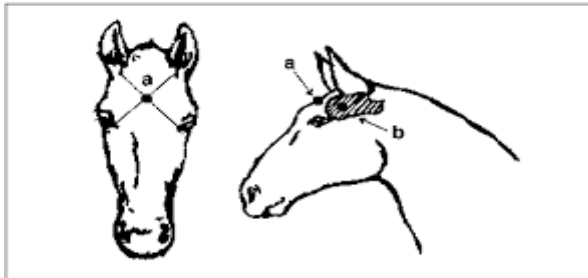
5.10.1.1.4 The manufacturer's specification or other document must specify the maintenance required on the guns and also indicate their effective life while in use. Maintenance staff performing maintenance on guns must be competent and have received training from the manufacturer, with records maintained.

5.10.1.1.5 Bullet caps must be stored, handled and used so that they are protected from dampness, damage or any other circumstance that would impair efficacy.

5.10.1.1.6 Bullet caps must be rotated on a first in first used basis, and care taken to ensure overlap on daily issue to the slaughter line is prevented.

5.10.1.1.7 The placement and direction of the captive bolt gun for each species for first and second stuns must be as follows:

Animal	Explanation Stating acceptable Tolerance as Applicable	Picture location for First Stun	Location Second Stun
Cattle	The stun gun must be placed in the cross section point on the forehead between base of horns and the top of eyes. Held perpendicular to skull and in contact with head		As close as possible to the first aperture and aimed in the same direction i.e. perpendicular to the skull bone
Pigs	The stun gun must be placed in the cross section point on the forehead between the base of the ears and the middle of the eyes.		As close as possible to the first aperture and aimed in the same direction i.e. perpendicular to the skull bone

	Held perpendicular to skull and in contact with head		
<b>Sheep and Lamb</b>	At the highest part of the head, on the midline behind the eye, direction towards the base of the tongue / jaw bone hinge Held in contact with the head		As close as possible to the first aperture and aimed in the same direction
<b>Horned Sheep</b>	At the back of the ridge between the horns, on the midline and aimed at the base of the tongue jaw bone hinge. Held in contact with the head		As close as possible to the first aperture and aimed in the same direction
<b>Horses</b>	The stun gun must be placed in the cross section point on the forehead between base of the ears and the front of eyes. Held perpendicular to skull and in contact with head		As close as possible to the first aperture and aimed in the same direction i.e. perpendicular to the skull bone

5.10.1.1.8 Any deviations or second stuns must be recorded, giving reason for issue arising.

5.10.1.1.9 Use of bullet caps must be recorded, and reconciled at the end of each day when in use.

5.10.1.1.10 Guns must not be subject to persistent heavy use in a manner likely to impair function. Where necessary based on stated number of uses the gun shall be swapped around. In addition a separate standby must be in place at the stunning location.

5.10.1.1.11 Guns must be legibly marked with a unique code. Records of specific guns in use must be maintained.

#### 5.10.1.2 Equipment, Facility Maintenance and Calibration - The Stunning of Animals (Including Equine) Using a Penetrative Captive Bolt Gun

The following maintenance requirements must be complied with:

Equipment	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Document /s
Penetrative Captive Bolt Guns	Equipment functioning correctly	Visual while in use	Every Use	Gun Operator	Repair, replace as appropriate, standby must be maintained	Record where issue arises
	Guns must be subject to scheduled maintenance complying with or exceeding manufacturer/s specification	Buffers and other moving parts / damage etc. / cleaning	Daily after use	Designated operator	Replace any parts as required	Record
		Gun breakdown with cleaning and assessment of all parts	Weekly	Maintenance	Replace any parts as required, retain gun for further maintenance as required	Record
		Full maintenance	Yearly or after a designated number of shots consistent with gun specification	Maintenance / Manufacturer	Replace or repair gun if applicable	Record
		Speed of penetrative bolt	As above	Maintenance / Manufacturer	Replace or repair gun if applicable	Record
Velocity measuring equipment	Must be calibrated according to a schedule	Check on Calibration date	Prior to upcoming calibration event	Maintenance Manager	Initiate calibration as soon as possible	Record

Equipment	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Document /s
	consistent with gun specification					
Bullet Caps	Stored in a secure location in dry condition protected from moisture	Visual	Designated person	Designated supervisor	Correct issue, discard questionable stock and fix rotation if applicable	Record
Back-up Stunning equipment	Maintained as is appropriate to equipment	Monitored as stated in this standard	As applicable to equipment	Maintenance	Replace, correct and ascertain reason	SOP Record

#### 5.10.1.3 Standard of Operation and Monitoring of Activities – The Stunning of Animals (Including Equine) Using a Penetrative Captive Bolt Gun

The following operations and monitoring requirements must be complied with. The process step / activity must be identified in a detailed flow diagram which covers all relevant steps where animal welfare can be impacted upon.

Process Step Number / Activity	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Documents
Stunning / Assessment of Effective Stunning	Animal stunned correctly first time, $\geq 99.5\%$ of the time	Visual	Every Animal	Gun Operator	Perform second stun (if applicable), Investigate cause, correct , record issue and findings. If standard is not met report to AWO.	SOP Record
	Assessment of effective stunning	Visual animal after shot	Every animal	Gun operator or Shackler as appropriate	As above, Shackler may re-stun as required and inform gun operator. If any issues apparent report to AWO.	SOP Record
	Correct stun location, correct bullet caps and	Visual check	The square root of the total kill number,	Supervisor	Take action as appropriate, re-train operators if	SOP Record

Process Step Number / Activity	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Documents
	effective stunning		with 10 animals as a minimum		applicable	
	Records maintained and reconciliation correct and recorded	Cross check records and Co-sign	Daily	Supervisor	Instruct operator record any issues on record	SOP Record
Back-up Stunning Equipment	Available where used in good condition and working	Visual and test operation for first stun of the day	Start of every day's kill	Stunning Operator	Obtain working spare before production	SOP Record

## 5.10.2 The Stunning of Pigs Using High Concentration CO<sub>2</sub> Gas

### 5.10.2.1 Facilities and Resources

5.10.2.1.1 Gas stunners, including conveyor belts, shall be designed and built to:

- Cater for types and size of animals
- Optimise the application of stunning by gas
- Prevent injury to the animals
- Minimise struggle and vocalisation when animals are restrained

5.10.2.1.2 The gas stunner shall be equipped to:

- Measure, display and continuously record the gas concentration
- Ensure correct time of exposure, and to give a clearly visible and audible warning if the concentration of gas falls below the set or required level.
- The device shall be placed so as to be clearly visible to the personnel.

5.10.2.1.3 A manufacturer's specification / operating manual must be in place and must specify the maintenance requirements.

5.10.2.1.4 The maximum throughput of the equipment must be stated allowing for space in enclosure chamber.

5.10.2.1.5 The gas stunner shall be designed in a manner that, even at the maximum permitted throughput, the animals are able to lie down without being stacked on each other.

- 5.10.2.1.6 Residence time in the chamber prior to gas exposure must be minimised, and maximum time clearly stated.
- 5.10.2.1.7 Any modifications to the equipment are risk assessed to take into account any animal welfare issues and a plan in place to mitigate these if required.
- 5.10.2.1.8 Any modifications must be performed by qualified competent maintenance staff or the manufacturer.
- 5.10.2.1.9 A specification must be in place specifying food grade and appropriate parameters for suitability.
- 5.10.2.1.10 Gas must be purchased from an approved supplier.

#### 5.10.2.2 Equipment, Facility Maintenance and Calibration – The Stunning of Pigs Using High Concentration CO<sub>2</sub> Gas

Note: issues in relation to entry into the enclosure are covered in previous section under restraint. The following maintenance requirements must be complied with:

Equipment	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Documents
Gas Stunning Equipment	Equipment must not be excessively noisy when in motion	Aural	Each Batch	Operator	Inform supervisor, Measure as required, Repair, mitigate issue before continuing	Record
	No damage, sharp protrusions or other issues with potential to cause stress or injury	Visual	Each Batch	Operator	Stop, Inform supervisor Repair, mitigate any residual before continuing	Record
	Gas level > 80% CO <sub>2</sub> and time of exposure > 90 seconds displayed, recorded and complied with	Maintenance Check	1/Week	Maintenance	Repair, adjust to conform with requirement prior to use	SOP Record
	Low gas alarm functioning and initiates at >85% CO <sub>2</sub>	Maintenance check Aural and visual during check	1/Week	Maintenance	Repair, adjust to conform with	SOP Record

Equipment	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Documents
	alarm stops, time delay alarm functioning				requirement prior to use	
	Time delay of < 60 seconds	Maintenance time check during check of operation	1/Week	Maintenance	Repair, adjust to conform with requirement prior to use	SOP Record
	Equipment performing correctly	Visual	1/Week	Maintenance	Repair, adjust to conform with requirement prior to use	Record
	Preventative maintenance check	Visual and checks/tests	Scheduled weekly, monthly and Yearly	Maintenance	Repair, adjust to conform with requirement prior to use	SOP Record
Gas measurement and sensor accuracy	Accurate to specified manufacturers specification	Verified by manufacturers calibrated instrument	1/Year and after repair as required	Manufacturer	Repair, adjust to conform with requirement prior to use	Record
	Overhaul	Overhaul checks	1/year	Manufacturer	Repair, adjust to conform with requirement prior to use	Record
Gas Supply	Food grade gas, of specified quality, suitable for purpose purchased from an approved supplier	Every order on delivery	Every delivery	Supervisor	Hold, investigate cause replace as required	Record Specification ASL
Back-up Stunning equipment	Maintained as is appropriate to equipment type	Monitored as stated in this standard	As applicable to equipment	Maintenance	Replace, correct and ascertain reason	SOP Record

### 5.10.2.3 Standard of Operation and Monitoring of Activities – The Stunning of Pigs Using High Concentration CO<sub>2</sub> Gas

The following operations and monitoring requirements must be complied with. The process step / activity must be identified in a detailed flow diagram which covers all relevant steps where animal welfare can be impacted upon.

Process Step Number / Activity	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Documents
Gas Stunning Equipment	Gas level > 80% CO <sub>2</sub> and time of exposure > 90 seconds displayed, recorded and complied with	Visual Dial / Timing residence time	Each Batch	Operator	Stop, Inform supervisor repair, before continuing	SOP Record
	Equipment performing correctly	Visual	5 Batches during the day	Supervisor	Stop, investigate cause, inform AWO and correct before resumption	Record any issue arising
	Low gas, note level of CO <sub>2</sub> at which alarm stops, time delay, alarm functioning	Aural and visual during line start up	Every start up	Supervisor	Repair / Adjust prior to start up	SOP Record issue and corrective action
Back-up Stunning Equipment	Available where used, in good condition and working	Visual and test operation if required	Start of every day's kill	Stunning Operator	Obtain working spare before production	SOP Record

### 5.10.3 The Stunning of Animals Using Electrical Tongs Equipment

#### 5.10.3.1 Facilities and Resources

5.10.3.1.1 Electrical tong stunners used for head only stunning shall be designed and built to:

- Cater for types and size of animals
- Optimise the application of stunning by electric shock
- Prevent injury or pain caused by preliminary shock prior to correct placement
- Ensure that the electrode of the tongs span the brain

5.10.3.1.2 The electrical tong stunner shall be equipped to:



- Measure, display and record the key parameter readings during each shock application
- Measure the time of tong contact, and to give a clearly visible and audible warning or alternatively automatic cut off when correct contact time is achieved
- Alternatively, the system may give an audible warning if the application time is not sufficient

5.10.3.1.3 A manufacturer's specification / operating manual must be in place and must specify the maintenance requirements.

5.10.3.1.4 The maximum throughput speed of the equipment must be stated allowing for close-down of circuit between each animal.

5.10.3.1.5 Automatic electrical stunning equipment integrated to a restrainer shall deliver a constant current. However, animals must not be subject to unnecessary shocks.

5.10.3.1.6 Tongs must not be damaged and must be handled with care.

5.10.3.1.7 Where sheep are being stunned, the facility must have the capacity to wet the appropriate area of the animal with water to produce good conductivity.

#### 5.10.3.1 Equipment, Facility Maintenance and Calibration – The Stunning of Animals using Electrical Tongs Equipment

The following maintenance requirements must be complied with:

Equipment	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Document /s
Electrical Stunning Equipment	Readings conform to standard ,	Maintenance Check, visual check	1/Week	Maintenance	Repair, adjust to conform with requirement prior to use	SOP Record
	Frequency 50Hz					
	Voltage 250v					
	Current Minimum Pigs 1.4 amps					
	Current Minimum Sheep 1.0 amps					
	Time interval check and duration Interval, tongs not live, time as per specification, alarm functioning	Maintenance check, aural and visual during check	1/Week	Maintenance	Repair, adjust to conform with requirement prior to use	Record
Tongs	Tongs and supply wire clean, working correctly and undamaged	Maintenance Check, visual check	1/Week	Maintenance	Repair, adjust to conform with requirement prior to use	SOP

Equipment	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Document /s
	Equipment performing correctly	Visual	1/ Week	Maintenance	Repair, adjust to conform with requirement prior to use	Record
	Preventative maintenance check	Visual and checks/tests	Scheduled weekly, monthly and Yearly	Maintenance	Repair, adjust to conform with requirement prior to use	SOP Record
	All electrical parameter measurements accurate to manufacturers specification	Verified by manufacturers calibrated instruments	1/Year and after repair as required	Manufacturer	Repair, adjust to conform with requirement prior to use	Record
	Overhaul	Overhaul checks	1/year	Manufacturer	Repair, adjust to conform with requirement prior to use	Record
Back-up Stunning equipment	Maintained as is appropriate to equipment type	Monitored as stated in this standard	As applicable to equipment	Maintenance	Replace, correct and ascertain reason	SOP Record

#### 5.10.3.2 Standard of Operation and Monitoring of Activities - The Stunning of Animals Using Electrical Tongs Equipment

The following operations and monitoring requirements must be complied with. The process step / activity must be identified in a detailed flow diagram which covers all relevant steps where animal welfare can be impacted upon.

Process Step Number / Activity	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Documents
Electrical Stunning Equipment	Readings conform to standard	Visual dial, no alarm	Every animal	Operator	Stop, Inform supervisor Repair, before continuing	SOP Record
	Frequency 50Hz					
	Voltage 250v					
	Current Minimum Pigs 1.4					

Process Step Number / Activity	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Documents
	<div> <div></div> <div>Current Minimum</div> <div>amps Sheep 1.0 amps</div> </div>					
Water jet	Working as required	Visual	Every Animal	Stunning Operator	Stop, Inform supervisor Repair before continuing	SOP
Tongs	Clean and undamaged	Visual	After each animal	Stunning Operator	Clean, repair, replace	Record (repair/replacement)
Electrical Stunning Equipment	Equipment performing correctly. absence of hot wanding and negative vocalisation	Visual / Aural	25 animals spread over the day	Supervisor	Stop, investigate cause, inform AWO and correct before resumption	Record
	Tongs clean and placed correctly	Visual	25 animals spread over the day	Supervisor	Stop, investigate cause, inform AWO and correct before resumption	Record
Back-up Stunning Equipment	Available where used in good condition and working	Visual and test operation if required	Start of every day's kill	Stunning Operator	Obtain working spare before production	SOP

#### 5.10.4 The Stunning of Poultry Using a Water-bath

##### 5.10.4.1 Facilities and Resources

5.10.4.1.1 Water bath stunners and associated line shall be designed and built to:

- Cater for types and size of poultry processed
- Optimise the application of stunning by electric shock
- Prevent injury or pain caused by preliminary shock prior to head placement in the tank
- Have adequate spacing between birds on the line
- Water bath stunning equipment shall be equipped with an electrically insulated entry ramp and designed and maintained so as to prevent overflow of water at the entrance
- Be able to comply with the following electrical requirements based on average values per animal:

Frequency (Hz)	Chickens	Turkeys	Ducks and Geese
<b>Minimum Current in mA</b>			
<200	100	250	130
200 to 400	150	400	Not permitted
400 to 1,500	200	400	Not permitted
		Regulation (EC) No 1099/2009	

- 5.10.4.1.2 The size and shape of the metal shackles shall be appropriate to the size of the legs of poultry to be slaughtered so that electrical contact can be secured without causing pain.
- 5.10.4.1.3 Shackle lines shall be designed and positioned in such a way that birds suspended on them are clear of any obstruction and that disturbance to the animals is reduced to a minimum.
- 5.10.4.1.4 The whole length of the shackle line up to the point of entry into the scald tank shall be easily accessible in case animals have to be removed from the slaughter line.
- 5.10.4.1.5 A plate must be in contact with the breast of the birds (breast comforter) and shall be in place from the point of shackling until the birds enter the water bath stunner in order to calm them down.
- 5.10.4.1.6 Shackle lines shall be designed and operated in such a way that birds suspended on them will not remain hung conscious as follows;

Type of Poultry	Maximum Live Hanging time
Chickens	1 Minute
Ducks, Geese, Turkeys	2 Minutes
	Regulation (EC) No 1099/2009

- 5.10.4.1.7 The water bath shall be designed in such a way that the level of immersion of the birds can be easily adapted.
- 5.10.4.1.8 The electrodes in water bath stunning equipment shall extend the full length of the water bath and maintained in a clean condition. Cleaning method and frequency must be stated.
- 5.10.4.1.9 The water bath shall be designed and maintained in such a way that when the shackles pass over the water, they are in continuous contact with the earthed rubbing bar.
- 5.10.4.1.10 Access to the water bath stunning equipment shall be available to allow the bleeding of birds that have been stunned and remain in the water bath as a result of a breakdown or delay in the line.
- 5.10.4.1.11 The water bath stunner and associated line shall be equipped to:
- Measure display and record the speed of the line

- Measure display and record the key electrical parameters
- Display must be readily visible during line operation
- The system must indicate head immersion time or allow for easy verification of this and must give an audible warning if the application time is not sufficient
- Line must allow for adjustment / alternative settings to cater for differing size of birds

5.10.4.1.12 A manufacturers specification / operating manual must be in place and must specify the maintenance requirements

#### 5.10.4.2 Equipment, Facility Maintenance and Calibration – The Stunning of Poultry Using a Water bath

The following maintenance requirements must be complied with;

Equipment	Standard		Monitoring	Frequency	Responsibility	Corrective Action	Document /s
Water bath stunning equipment and Line	Readings conform to specified electrical parameters to allow for compliance with exposure to correct current		Maintenance Check, visual check	1/Week	Maintenance	Repair, adjust to conform with requirement prior to use	SOP Record
Line Speed	Correct to give minimum retention in bath which is		Maintenance check, visual check	1/Week	Maintenance	Repair, adjust to conform with requirement prior to use	SOP Record
	Animal	Seconds Min					
	Chicken	4 seconds					
Water level	Water level correct in bath		Maintenance Check, visual check	1/Week	Maintenance	Repair, adjust to conform with requirement prior to use	SOP Record
Line set correctly for grade / size of bird	Correctly set for full head immersion		Visual check of line	1/week, after repair	Maintenance	Adjust to conform with requirement prior to use	SOP
Electrical Stunning equipment and line	Equipment performing correctly		Visual	1/ Week	Maintenance	Repair, adjust to conform with requirement prior to use	Record
	Preventative maintenance check		Visual and checks/ tests	Scheduled weekly, monthly and Yearly	Maintenance	Repair, adjust to conform with requirement prior to use	SOP Record
	Readings conform to specified electrical parameters to allow for compliance with exposure to correct current		Verified by manufacturers calibrated instruments	1/Year and after repair as required	Manufacturer	Repair, adjust to conform with requirement prior to use	Record

Equipment	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Document /s
	Overhaul	Overhaul checks	1/year	Manufacturer	Repair, adjust to conform with requirement prior to use	Record
Back-up Stunning equipment	Maintained as is appropriate to equipment	Monitored as stated in this standard	As applicable to equipment	Maintenance	Replace, correct and ascertain reason	SOP Record

#### 5.10.4.3 Standard of Operation and Monitoring of Activities – The Stunning of Poultry Using a Water-bath

The following operations and monitoring requirements must be complied with. The process step / activity must be identified in a detailed flow diagram which covers all relevant steps where animal welfare can be impacted upon.

Process Step Number / Activity	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Document /s						
Water bath Stunning Equipment and Line	Readings conform to standard as stated in electrical parameters stated above	Visual dial, no alarm	Every animal	Operator	Stop, Inform supervisor Repair, before continuing	SOP Record						
Line speed	Correct to permit sufficient residence time in bath	Visual and timing	2 / day AM and PM	Operator	Stop line, Inform Supervisor, AWO and adjust speed, re-check until standard achieved	SOP Record						
	<table><tr><th>Animal</th><th>Seconds Min</th></tr><tr><td>Chicken</td><td>4 seconds</td></tr><tr><td></td><td></td></tr></table>						Animal	Seconds Min	Chicken	4 seconds		
	Animal						Seconds Min					
	Chicken						4 seconds					
Water level	Water level correct in bath, full head immersion. Attention paid to swan neck in case of ducks	Visual check on level	At start and every 2 hours	Operator	Stop line, Inform Supervisor, AWO and adjust level	SOP Record						
Line set correctly for grade / size of bird	Correctly set for full head immersion	Visual check of line	Before start-up and after any change	Operator	Adjust to conform with requirement prior to use or stop line and adjust	SOP						
	Equipment performing correctly. All parameters above	Visual	25 consecutive birds 4 times	Supervisor	Stop, investigate cause,	Record						

Process Step Number / Activity	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Document /s
			/day		inform AWO and correct before resumption	
Back-up Stunning Equipment	Available where used in good condition and working	Visual and 1 test operation	Start of every day's kill	Operator	Obtain working spare before production	SOP

## 5.11 The Assessment of Effective Stunning / Unconscious and Insensible Status of Animals

### 5.11.1 General Requirements

5.11.1.1 All animals must be assessed for unconscious and insensible status. Poultry are assessed periodically to ensure effective control of process.

5.11.1.2 Immediate re-stunning is required using an effective back up method where unconscious and insensible status has not attained after first stun.

5.11.1.3 An SOP must be in place stating in detail all required activities including:

- Which parameters are to be assessed to determine animal status
- Action to be taken when animal is not unconscious and insensible
- Circumstances where Stun Operator, Supervisor and AWO must be informed of any pertinent issues
- Details of the latter must be recorded

5.11.1.3 Signs of unconscious and insensibility for relevant animals are as follows;

Animal	Evidence Unconscious and Insensibility Status	Evidence Conscious or Sensible Status
<b>Bovine Animals and Horses</b>	Immediate collapse	Remains standing
	No effort to get up / righting reflex	Making effort to get up / righting reflex
	No Corneal reflex / pupil dilated	Corneal reflex/ pupil not dilated
	No defensive blink on touching eyeball	Defensive blink on touching eyeball
	No vocalisation	Vocalisation
	No rhythmic breathing	Rhythmic breathing
	Tongue hangs out straight	Tongue retained in mouth cavity
	No response to a nose pinch or needle	Response to a nose pinch or needle
	No coherent movement other than reflexive kicking of limbs	Coherent movement

Animal	Evidence Unconscious and Insensibility Status	Evidence Conscious or Sensible Status
	Head and back are straight in line when animal hung on line	Coherent movement of head, arching of back
	Head floppy	Head / neck stiff
<b>Pigs / Sheep</b>	Immediate collapse	Remains standing
	No effort to get up / righting reflex	Making effort to get up / righting reflex
	No Corneal reflex / pupil dilated	Corneal reflex / pupil not dilated
	No defensive blink on touching eyeball	Defensive blink on touching eyeball
	No vocalisation	Vocalisation
	No rhythmic breathing	Rhythmic breathing
	Tongue hangs out straight	Tongue retained in mouth cavity
	No response to a nose pinch or needle	Response to a nose pinch or needle
	No coherent movement other than reflexive kicking of limbs	Coherent movement
	Head floppy	Head / neck stiff
<b>Poultry</b>	No Corneal reflex / pupil dilated /third eye open	Corneal reflex
	No defensive blink on touching eyeball or movement of head	Defensive blink on touching eyeball /head movement
	Wings held tight to body or hanging limp without movement	Wings moving / flapping
	No vocalisation	Vocalisation
	No rhythmic breathing	Rhythmic breathing
	Head floppy	Head / neck stiff

For head only electrical stunning the stun is reversible and the signs of an effective stun are two phases: tonic and clonic. The animal must be bled as soon as possible and no later than the end of the clonic phase.

#### 5.11.2 Standard of Operation and Monitoring of Activities – The Assessment of Effective Stunning / Unconscious and Insensible Status of Animals

The following operations and monitoring requirements must be complied with. The process step / activity must be identified in a detailed flow diagram which covers all relevant steps where animal welfare can be impacted upon.

Process Step Number / Activity	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Documents
Assessment of Stunning	Readiness of shackler and bleeding operators /	Visual	Every animal	Designated Operator	Communicate with operators as required, do not put animal	SOP



Process Step Number / Activity	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Documents
	stations to receive animal				into restraint until all stations ready to operate	
Assessment of Stunning	Key indicators of unconscious and insensibility present	Visual, aural and touch (eye)	Every animal / At start-up and 25 birds every 30 minutes	Designated Operator	Re-stun, check efficacy, Inform supervisor, stunner and AWO as appropriate. Stop and investigate cause and correct.	SOP Record by exception
Position of skull aperture from penetrative captive bolt for Captive Bolt Stunning	In correct location see above	Visual check location on head	Every animal	Designated Operator	Watch closely for signs of unconscious and insensibility. As necessary, re-stun, check efficacy, Inform stunner, supervisor and AWO if persistent	SOP Record by exception
Assessment of stunning and aperture in skull where applicable	Parameters above are complied with	Observation of practices / observation of birds on line post stunning prior to bleeding	5 consecutive animals 4 times / day. Choice informed by risk basis e.g. change in animal size line speed. In case of birds 100 consecutive birds 3 times / day	Supervisor	Stop and investigate cause, correct before resuming. Inform AWO	Record for each animal / by exception for birds

## 5.12 The Shackling, Hoisting and Hanging of Live Animals

### 5.12.1 General Requirements

5.12.1.1 The shackling and hoisting equipment must be appropriate for the type and size of animal handled.

5.12.1.2 The shackling and hoisting equipment must be secure and designed so that stun to stick time is facilitated.

5.12.1.3 All animals must be assessed for unconscious and insensibility immediately post stunning (with the exception of poultry destined for water-bath stunning) and status prior to shackling, hoisting and hanging.

5.12.1.4 Where an animal is not unconscious and insensible, the animal must be re-stunned using an effective back-up method, and unconscious and insensibility status verified prior to shackling, hoisting and hanging.

#### 5.12.2 Equipment and Facility Maintenance - The Shackling, Hoisting and Hanging of Live Animals

The following maintenance requirements must be complied with:

Equipment	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Documents
Shackling, hoisting, hanging equipment	Equipment performing correctly	Visual	1/ Week	Maintenance	Repair, adjust to conform with requirement prior to use	Record
	Preventative maintenance check	Visual and checks/tests	Scheduled weekly, monthly and Yearly	Maintenance	Repair, adjust to conform with requirement prior to use	SOP
Back-up Stunning equipment	Maintained as is appropriate to equipment	Monitored as stated in this standard	As applicable to equipment	Maintenance	Replace, correct and ascertain reason	SOP

#### 5.12.3 Standard of Operation and Monitoring of Activities - The Shackling, Hoisting and Hanging of Live Animals

The following operations and monitoring requirements must be complied with. The process step / activity must be identified in a detailed flow diagram which covers all relevant steps where animal welfare can be impacted upon.

Process Step Number / Activity	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Documents
Shackling, hoisting and Hanging	Equipment performing correctly	Visual	Every Animal /Bird	Shackling / hang on operator	Inform supervisor / maintenance. Shackles set aside for maintenance as	SOP

Process Step Number / Activity	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Documents
					required	
	Animal achieved unconscious and insensible status prior to shackling / hoisting / hanging. Effective first stun percentage > 99.5%	Visual, aural and touch (eye)	Every animal / Minimum of 5 birds every 30 minutes	Operator	Re-stun, check efficacy, inform supervisor, stunner and AWO as appropriate.	SOP, Record by exception % Calculation
	Animal shackled / hoisted / hung as soon as possible	Attention to this during operation	Every Animal / Bird	Operator	Correct cause of delay, inform supervisor / AWO	SOP, Record by exception
Back-up Stunning Equipment	Available, where used in good condition and working where applicable	Visual and test operation if required	Start of every day's kill	Operator	Obtain working spare before production	SOP
	Shackling carried out as soon as possible, and that unconscious and insensibility is being assessed correctly. No negative vocalisations	Visual	5 consecutive birds 4 times / day	Supervisor	Correct issue immediately	Record
Shackling, hoisting and Hanging	Record fully and correctly completed and co-signing	Visual	Daily end of day	Supervisor	Instruct operator as required Correct any issues	Co- sign record and record any deviations

## 5.13 The Bleeding of Live Animals

### 5.13.1 General Requirements

5.13.1.1 Bleeding must be performed as soon as possible and within set maximum limit for the relevant species, and if performed correctly death should follow within the stated time indication as follows:

Animal	Stun Method	Target /Max. Stun to Stick time seconds	Death Time Indication in Seconds post bleeding cut
Cattle	Penetrative Captive Bolt Gun	As soon as possible / 60	90

<b>Pigs</b>	High CO <sub>2</sub>	N/A	N/A
	Electrical Stunning, Tongs	As soon as possible / 60	20
<b>Sheep</b>	Electrical Stunning, Tongs	As soon as possible / 30	20
<b>Poultry</b>	Electrical Stunning Water bath	As soon as possible / < 15/50Hz < 10/higher frequencies	136+/- 16 (chickens) 172+/- 28 (ducks) (carotid and jugular veins cut)
<b>Horses</b>	Penetrative Captive Bolt Gun	As soon as possible / 60	90

5.13.1.2 Knives used for throat cutting must be straight, twice the width of the throat (i.e. minimum 5 inches / 12.7 cm).

5.13.1.3 Cutting equipment must be kept very sharp and where relevant steeled during use, and a stand-by knife available at point of use. A spare set of blades must be readily available for poultry neck cutter.

5.13.1.4 Correct thoracic bleeding sites are used for cattle, pigs, and sheep where applicable.

5.13.1.5 The position of the cut must be correct for the species.

5.13.1.6 The cut must sever the appropriate blood vessels giving rise to appropriate 'gush' rate of bleeding.

5.13.1.7 In the case of poultry, the cutting equipment must be set to ensure an effective cut, giving rise to an appropriate bleed rate and verified at first use and periodically thereafter.

#### 5.13.2 Equipment and Facility Maintenance – The Bleeding of Live animals

The following maintenance requirements must be complied with;

Equipment	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Document/s
Knives	Must be sharpened at least daily, including back up knives	Check on sample of knives	3 Knives / Day	Supervisor	Re-sharpen and re check, maintenance to investigate and correct as required followed by re-sharpening	Record by exception
	Knife sharpener maintained according to preventative maintenance programme	Frequency / method of maintenance maintained	As per preventative maintenance interval	Maintenance Operator	Institute maintenance as soon as possible	Record

Equipment	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Document/s
Poultry Neck Cutter	Set to specification and giving an adequate cut giving rise to profuse bleeding	Measurement and visual	Start of shift, and after any adjustments	Maintenance	Repair / replace /Correct before start, report to supervisor / AWO as required	SOP Record

### 5.13.3 Standard of Operation and Monitoring of Activities – The Bleeding of Live Animals

The following operations and monitoring requirements must be complied with. The process step / activity must be identified in a detailed flow diagram which covers all relevant steps where animal welfare can be impacted upon.

Process Step Number / Activity	Standard	Monitoring	Frequency	Responsibility	Corrective Action	Documents
Bleeding	Cutting knives sharp	Visual check on cutting	Every Animal	Operator	Sharpen and / or Steel as appropriate	SOP
Poultry Neck Cutter	Adequate cut effectively cutting both blood vessels and giving rise to profuse bleeding	Visual	Start of shift first 5 birds, hourly, end of shift and on changeover of grade of bird	Operator	Stop line, inform supervisor / AWO. Correct before re-start	SOP Record
	Correct area and blood vessels cut giving rise to rapid bleed	Visual location of cut and bleed rate	Every animal	Operator	Re-cut with correct method / location immediately	SOP Record by exception
	Bleeding initiated as soon as possible but complying with maximum limits stated above	Stun to stick time measured	5 animals 2 /day	Supervisor	Investigate cause correct and verify limit met	Record
	Verification of death post bleeding within the designated target time	Death time post bleeding	5 animals, 2 /day	Supervisor	Investigate cause correct and verify target time limit met	Record

## **5.14 The Handling and Humane Slaughter of Casualty Animals**

### **5.14.1 General requirements.**

Where an injured animal is presented or an injury occurs on site, the official veterinarian (OV) and the animal welfare officer (AWO) must be immediately consulted, with a view to ensuring that the animal suffering is minimised. Where an OV is not on site the AWO performs this role and must be competent to do so. Where an OV is not present on site the issue must be reported to the OV as soon as possible.

5.14.2 In consultation with the OV and / or AWO, and under the authorisation of the OV / AWO the injured animal must be slaughtered or killed on the spot, as soon as practicable.

5.14.3 The use of mechanical equipment to remove recumbent animals from transport vehicles is not permitted. The animals are required to be stunned within the transport vehicle and removed to the slaughter entrance by trolley, overhead hoist or forklift, or to be euthanised if they are declared unfit for slaughter for human consumption.

5.14.4 The Food Business Operator must have a SOP detailing how casualty animals are handled and slaughtered.

5.14.5 A record must be maintained for all casualty animals slaughtered and include, the type of injury, the cause of the injury, the lag time between identification of the injury and killing, the method of stunning / killing. The disposition of the carcase must also be recorded.

## **5.15 The Verification of the Efficacy of Animal Welfare Controls**

5.15.1 As stated previously, all animal welfare checks performed by operating personnel, supervisors and verification checks by designated animal welfare staff must be clearly indicated on a detailed flow diagram. This ensures clarity as to where these checks arise. A dedicated animal welfare flow diagram is required for this purpose, with steps numbered and all check / verifications in this standard related to the numbered steps.

5.15.2 The WACPS is verified by the AWO or designated competent personnel assigned by the AWO.

5.15.3 The results of all verification are reported directly to the AWO, who has responsibility and authority to initiate corrective action.

5.15.4 The evidence gathered during the review of reports and review of verification checks are assessed to determine:

- Any trends both positive and negative
- Whether criteria and standards in place require changing

- 5.15.5 These reports must be completed 3 times per year, with results disseminated to company management.
- 5.15.6 Appropriate action must be taken based on these reports with resources and timing being related to impact on animal welfare.
- 5.15.7 The data and evidence mentioned above must be measured objectively and reviewed to provide, where possible, objective target and limits (e.g. % negative vocalisations over time, number and % goad usage, unnecessary goad usage) in order to assess status of compliance and evident trends and where necessary introduce new criteria.
- 5.15.8 A review of the quarterly reports over the current 12 month period and the outcome of the annual audit shall form the basis for:
- Drafting communication with stakeholders
  - Reporting to company management
  - Identifying improvements for agreement, planning and implementation of agreed strategies

The following is a list of process steps and activities (as a minimum) that must be verified to determine the efficacy of animal welfare controls:

Process Step / Activity	Standard for Verification	Monitoring	Frequency	Responsibility	Corrective Action	Documents
All steps/activities from promoting animal welfare issues with animal owners up to point of death.	Compliance with all procedures / policies and recording requirements as per this standard	Formal Audit of system using checklist	All elements of standard once / Year	AWO	Formal reporting to management. All non-compliances reported, and verified as closed out	SOP Audit Audit Schedule RC's Checklist Report NC/CA/ close out report
All AW relevant changes to facilities, methods, line speeds, capacity etc.	Adequate procedures / policies / standard criteria and recording in place	Review	All relevant changes	AWO	Reason for failure ascertained and root cause/fix implemented	New Documents / records as appropriate. Issue recorded
All animal welfare checks	Records authentic, filled out correctly and in real time	Every verification event	During all verification checks	AWO	Bring to attention of operator and supervisor re-train as required	Record co-sign and record of verification result
Animal Unloading / moving and	Compliance with activity relevant	Observation of activities /	1/ Calendar month	AWO	Any deviation or	Record

Process Step / Activity	Standard for Verification	Monitoring	Frequency	Responsibility	Corrective Action	Documents
handling	procedures / policies and recording requirements as per this standard.	Transport containers / Facilities			contravention is recorded and reported for correction	
	Records filled accurately and correctly co-signing of records by supervisor. Standards / targets met. CA taken as required	Visual check / identification of potential trends	1 / Calendar month	AWO	Any deviation recorded and brought to attention of relevant personnel for correction	Record
	Trends identified	All relevant records	3/Year i.e. every 4 months	AWO	Negative trend acted upon	Record
	Absence of Slips, trips, loud noises unnecessary use of goads, negative vocalisation of animals consistent with good practice	Visual aural monitoring Unloading	6 Loads per week	AWO	All instances recorded, Investigate and initiate corrective action as required	Record
Lairage	Absence of Slips, trips, loud noises unnecessary use of goads, negative vocalisation of animals consistent with good practice	Aural monitoring In Lairage	6 Pens /week	AWO	As above	Record
	Absence of Slips, trips, loud noises unnecessary use of goads, negative vocalisation of animals consistent with good practice	Aural monitoring, movement towards restraint	6 groups of animals /week	AWO	As above	Record
	Facility compliant Pen density correct. Absence of negative vocalisation. Overnight handling correct	Visual monitoring	1 /week	AWO	As above	Record
Movement into restraint	Negative vocalisation count absent, good handling, slips / trips etc. minimal stress moving pigs to into enclosure	Visual, Aural	6 consecutive uses 1 / month	AWO	Record all incidences, correct as required communicate with operators retrain as required	Record
Restraint	Residence time in restraint	Measured time	12 animals / week	AWO	All timings recorded. Investigate and initiate corrective action	Record
	<b>Animal</b> <b>Seconds</b>					
	Bovines   60					
	Sheep   60					
	Pigs   60					
	Poultry   120, legal limit, (ducks, geese,					



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		turkeys) 60 (chicken)					
	Horses	60					
	Absence of slips trips		Observation	As above	AWO	All instances	Record

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Process Step / Activity	Standard for Verification	Monitoring	Frequency	Responsibility	Corrective Action	Documents
	and Falls on way to restraint, negative vocalisation, good handling in place	during above checks			Investigate and initiate corrective action recorded	
Hang-on Poultry	Unsuitable birds e.g. injured, damaged or too small are not hung on and slaughtered by alternative means. Negative vocalisation absent	Observation of line, and hang-on operators	Minimum of 100 birds twice /week across operators	Supervisor	Correct issue, retrain staff	Record
	Unsuitable birds e.g. injured, damaged or too small are not hung on and slaughtered by alternative means. Negative vocalisation	Observation of line, and hang-on operators	Minimum of 100 birds 1/week across operators	AWO	Correct issue, inform operators report to supervisor	Record
	Both legs hung on, on the lowest part, no fall offs.	Observation of line, and hang-on operators	Minimum of 100 birds 1/week across operators	AWO	Correct issue, inform operators report to supervisor	Record
Stunning, Penetrative Captive Bolt Gun	Corrective location of Stunning	Observation practice / skull location	10 consecutive animals 2 /week	AWO	Correct gun operator, inform supervisor	Record
	Correct gun type and Bullet caps in use	Observation cap colour	1 Day per week all animal types requiring cap change	AWO	Replace gun, caps as required, investigate cause and extent, take action as appropriate	Record
	Effective unconscious and sensibility checks in place	Observation fallen animal	minimum of 20 animals over 2 days	AWO	Investigate cause, take action as appropriate	Record
	Ensure all records correctly maintained and co-signed	Observation Records	1 / 6 months	AWO	Inform operator / supervisor as required verify correction	Record
	Guns and Bullet Caps supplied from approved source	Cross check supplier against last 2 orders	1/6 months	AWO	Investigate cause and correct, remove guns bullet cap supplies and replace as appropriate	Record
	Gun maintenance and calibration conforming to requirements	Check record evidence and certificates	1/6months	AWO	Investigate cause, take action as appropriate	Record
Entry to CO <sub>2</sub> enclosure	Negative vocalisation count absent, good handling, slips / trips absent, minimal stress moving pigs to into enclosure	Visual, Aural	6 consecutive uses, 1 / month	AWO	Record all incidences, correct as required communicate with operators	Record

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Process Step / Activity	Standard for Verification	Monitoring	Frequency	Responsibility	Corrective Action	Documents
					retrain as required	
Stunning by CO <sub>2</sub>	Gas level > 80% CO <sub>2</sub> and time of exposure > 90 seconds displayed, recorded and complied with	Visual Dial / Timing residence time	6 consecutive uses, 1/month	AWO	Investigate, stop process if necessary, repair /replace/ correct before continuing	Record
	Pig number / Limit of enclosure complied with	Visual count	6 consecutive uses 1/month	AWO	Correct issue, speak to /retrain staff	Record
	Equipment performing correctly	Visual	6 consecutive uses, 1/month	AWO	Investigate, stop process if necessary, repair /replace/ correct before continuing	Record
	Low gas note level of CO <sub>2</sub> alarm stops, time delay alarm functioning	Aural and visual during line start up	1 / month	AWO	Do not use until resolved	Record
Spare Stunning Equipment	Available where used, in good condition and working	Visual and test operation if required	1 / month	AWO	Supply immediately, investigate cause	Record
Shackling, hoisting and Hanging	Equipment performing correctly	Visual	10 Consecutive animals 2 / week	AWO	Communicate with operator, Inform supervisor / maintenance.	Record
	Operator check on animal to ascertain unconscious and insensible status prior to shackling / hoisting / hanging. Re-stunning percentage > 99.5% calculation	Visual, aural and touch (eye)	20 Consecutive animals, 2 / week	AWO	Communicate with operator, re-train as necessary, verify correct procedure in place inform supervisor	Record
	Animal shackled / hoisted / hung as soon as possible	Attention to this during verification	20 consecutive animals, 2 / week	AWO	Communicate with relevant staff as necessary	Record
Bleeding of live animals	Cutting knives sharp	Observation of sharpness check and procedure / check knife as appropriate	10 Consecutive animals 2 / week	AWO	Communicate with operator, re-train as necessary inform supervisor	Record
	Correct area and blood vessels cut giving rise to rapid bleed	Visual location of cut and bleed rate	10 Consecutive animals 2 / week	AWO	Communicate with operator, re-train as necessary inform supervisor	SOP, Record by exception
	Bleeding initiated as soon as possible but complying with maximum limits stated above	Stun to stick time measured	10 Consecutive animals, 2 / week	AWO	Communicate with operator, re-train as necessary inform	Record

Process Step / Activity	Standard for Verification	Monitoring	Frequency	Responsibility	Corrective Action	Documents
					supervisor	
	Verification of death post bleeding within the designated target time	Death time post bleeding	10 consecutive animals 2 /week 30 consecutive birds 2 / week	AWO	Investigate cause correct and verify limit met	Record
Poultry Neck Cutter	Adequate cut giving rise to profuse bleeding	Visual	Start of shift, hourly, end of shift and on changeover of grade of bird	Operator	Stop line, inform supervisor / AWO. Correct before re-start	SOP

## 6. Training

6.1 There shall be in place an operational plan to identify animal welfare training needs in order to maintain and develop welfare competency for AWO and relevant staff.

6.2 Training needs must be assessed yearly as a minimum and as staff turnover requires to ensure an adequate complement of certified staff.

6.3 Staff/ contractors whose activities have the potential to impinge (positively or negatively) on welfare should receive welfare training or refresher training, as a minimum every 2 years and as required by monitoring results. Animal welfare officers should receive formal AWO training from a recognised provider and refresher training should be provided thereafter every 5 years as a minimum or more frequently if legislation or food assurance standards require it.

6.4 The company shall be able to demonstrate that suppliers of animals and animal haulage personnel have received Animal Welfare Awareness training every 3 years as a minimum and as required by monitoring.

6.5 Training plans must be documented and records of training maintained.

6.6 Training of staff must include as a minimum, animal welfare requirements (including the requirements of this standard) pertinent to role(s), use of any equipment including steeling and sharpening of knives as appropriate.

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