DRAFT v.4

POULTRY WELFARE MODULE

POULTRY WELFARE MODULE (PW)

This module is applicable to sites slaughtering chickens, broilers, turkeys and ducks

AIM: Birds are treated and handled in a way to avoid unnecessary pain, distress or suffering at all times, in accordance with current legislation

POULTRY WELFARE MODULE (PW)

STANDARDS	HOW YOU WILL BE MEASURED	
POULTRY WELFARE POLICY, WELFARE OFFICERS AND TRAINING		
AIM: Poultry welfare is managed by competent people in accordance with company policies		
PW.a (REVISED) **A poultry welfare policy for the site is documented and communicated**	■ A documented policy outlines the sites objectives with regards to achieving and delivering standards of bird welfare and conforming to the scheme standard and relevant legislation ■ Policy signed off by relevant senior management ■ Policy communicated to persons associated with live birds including catchers, drivers of all types of vehicles, lairage staff and slaughterers e.g. through training posters, work instructions, staff handbook ■ The policy is reviewed annually (demonstrated with a signed and dated review) and kept up-to-date	■ Policy
PW.a.1 (REVISED) **Animal Welfare Officer(s) (AWO) must be on-site during operational hours and hold overall responsibility for poultry welfare on the site**	■ A documented management structure identifies those fulfilling the role ■ A documented procedure details the responsibilities of the AWO ■ AWO(s): – hold appropriate Certificates of Competence for the species and operations they are responsible for – have sufficient authority and competence to provide guidance to personnel that manage poultry on-site – have sufficient authority to make decisions and take actions to safeguard bird welfare	■ Management structure/ organogram
PW.a.2 **There must be a sufficient number of competent persons working within the lairage and slaughter areas during operational hours to care for and handle birds**	■ During operational hours, competent persons oversee/ undertake unloading, lairaging, ante-mortem inspections and slaughter ■ Competent persons may include deputies to the AWO ■ Arrangements are in place to ensure sufficient people are present during holidays/ sick leave	
PW.a.2.1 (NEW) **Standard Operating Procedures (SOP) must be in place for each operation from animal intake to confirmation of death**	■ Checks must be made that procedures are followed ■ Updates are introduced when new or changes to processes or procedure are introduced ■ Includes the maximum line speed at which birds can be put through to stun/kill or stun point, humanely slaughtered and checks carried out	
PW.a.3 **All staff involved in the care, handling and monitoring of birds must be trained and competent**	■ As required by legislation, persons that are responsible for, monitor or undertake the following roles, hold a Certificate of Competence relevant to the species: – the unloading of birds (or crates) – the handling and care of birds before they are restrained – the restraint of birds for stunning or killing – the shackling of birds – the stunning of birds – the assessment of effective stunning – the bleeding of live birds and monitoring the absence of signs of life ■ Staff have been trained to procedures relevant to their roles. Training may include Certificate of Competence training delivered in house by an official training provider or by external training providers	■ Training records

PW.a.3.1 (NEW) **An external source of training must be demonstrated for Animal Welfare Officer(s)**	▪ External training is in addition to Certificate of Competence training ▪ An example of external training is the Bristol University Poultry Welfare Officer course	
PW.a.4 (REVISED) **The ongoing performance of staff who care for and handle birds must be internally monitored and training updates or refresher training given as required**	▪ Training needs and assessment for each role are established ▪ Employee training needs are reviewed on a risk assessed frequency and where necessary additional training is given and competency assessed	▪ Training records
PW.a.5 **Systems must be in place to ensure appropriate, competent persons are contactable out of operational hours**	▪ Person(s) contactable in the event of a problem/ emergency ▪ The point of contact is an AWO or is a competent member of staff who can contact an AWO at any time	▪ Signs/contact numbers

STANDARDS	HOW YOU WILL BE MEASURED	
PW.a.6 **The AWO(s) must have access to or hold a copy of the most up-to-date regulations and recommendations relating to protecting the welfare of animals at the time of killing**	▪ Up-to-date copies of industry codes of practice relevant to stunning and killing system held (such as those produced by the British Poultry Council or the Humane Slaughter Association)	
PW.a.7 (REVISED) **You must contact Red Tractor andyour Certification Body immediately if a serious incident or emergency situation affects or threatens to affect the welfare of birds e.g. line breakdown**	▪ Serious incidences or emergencies which may impact on the capacity to slaughter birds include: - Breakdown of factory equipment - Staff availability - Emergency/disaster e.g. fire, flood - Lack of gas supply e.g. carbon dioxide ▪ Where a serious incident or emergency results in a breach of a standard/s in any of the RT schemes and legislative requirements, Red Tractor is immediately informed if product from affected birds is destined to be packed with a Red Tractor claim. Examples of breaches to scheme standards and legislative requirements include: - Exceeding maximum lairage time (6 hours) - Exceeding 12 hours withdrawal of feed and/or water - Exceeding farm stocking density requirements	
PW.a.7.1 (NEW) **Welfare incidents/poor performance relating to a Red Tractor Assured farm and/or catching or transport member is reported to Red Tractor**	▪ Poor performance includes birds received (reoccurring incident) which are: - dirty - dead on arrival (exceeding limits outlined in PW.f.2) - poor condition - injured/open wounds - trappages ▪ Reporting of poor performance is via the Red Tractor Checkers and Services website www.checkers.redtractor.org.uk ▪ Further details can be found in the Appendix	
PW.a.8 (REVISED) **Welfare Outcome scoring must be undertaken and recorded on Red Tractor Assured chicken, turkey and ducks (as applicable)**	▪ For Ducks: – Welfare Outcome scoring is undertaken as per the Red Tractor Protocol detailed in the Appendix – Welfare Outcomes for a farm are reported back to the grower of that farm – Welfare Outcomes are reported to Red Tractor *Possible guidance to be included to aid those chicken & turkey members who don't currently record Welfare Outcomes (although many do) - this standard is proposing that chicken & turkey members simply record Welfare Outcomes and not, at this stage, to any defined Protocol.*	▪ Duck Welfare Outcome scoring records

PW.a.9 (NEW) (Recommendation) **Welfare Outcome scoring is undertaken on Red Tractor Assured chicken and turkey (as applicable) as per the Red Tractor Protocol**	(Red Tractor Protocol will be available in an Appendix once it has been developed)	
THE LAIRAGE		
AIM: Facilities are fit for purpose; well designed, constructed, maintained and operated to protect the welfare of birds. (Note: A lairage is defined as an on-site controlled environment for birds. The definition includes covered buildings and lorries held on-site and excludes uncovered, uncontrolled areas)		
PW.b (REVISED) **The lairage must be designed and constructed to meet the thermal requirements of birds**	▪ The lairage provides protection in adverse weather and birds are screened from direct sunlight ▪ The lairage is ventilated to minimise high humidity and to maintain temperature. The lairage is designed to encourage air flow ▪ The lairage design avoids birds getting wet from the lorry wash	
PW.b.1 **Ventilation systems must be maintained and alarms regularly tested**	▪ Ventilation systems maintained and effective ▪ Where ventilation is controlled mechanically, alarms and emergency backup systems are in place to notify failures ▪ Alarms are tested every seven days	
PW.b.1.1 **In the event of ventilation equipment failure, contingency plans and corrective actions must be implemented**	▪ When contingency criteria have been met, emergency back-up systems are implemented ▪ Corrective actions may include repairs	
PW.b.2 **Systems for forecasting risks of temperature stress to birds in the lairage environment must be used**	▪ Forecasting or horizon scanning for weather extremes, adverse climatic conditions enabled preventative action to be undertaken	
PW.b.2.1 **Systems must be in place to regularly monitor and record the temperature and humidity of the lairage and birds' environment**	▪ Monitoring applies to both the lairage environment and thebirds' immediate environment within crates ▪ Monitoring includes cross-checking the recorded temperaturesagainst a species specific (e.g. chicken, turkey and duck) thermal comfort zone chart at the time the temperature is taken ▪ Monitoring is undertaken at a frequency as defined by adocumented procedure (but at least daily)	▪ Temperature records. ▪ Thermal comfort zone chart

STANDARDS	HOW YOU WILL BE MEASURED	
PW.b.2.2 **Where forecasting or monitoring identifies a risk of humidity or temperature stress, preventative or corrective action must be implemented to protect bird welfare**	▪ Documented procedures/ contingency plans detail preventative actions (in the case of forecasting) or corrective actions (in the case of monitoring) ▪ The documented procedures clearly identify the critical limits/ trigger points at which action needs to be taken to safeguard welfare ▪ Actions may include (but are not limited to): – reducing or increasing the stocking rate of crates – the use of additional fans to increase air flow – curtaining the sides of the lairage – use of heaters – driving of lorries to encourage air flow ▪ Where forecasting predicts a risk, the preventative actions undertaken are recorded ▪ Where monitoring identifies a risk, the root cause must be determined and corrective actions implemented, recorded and reported to the AWO	▪ Documented procedures
PW.c (REVISED) **The lairage must be designed to allow ease of movement of crates and modules**	• The floor is well maintained to prevent bouncing and jarring • Driving is smooth and of a speed that allows birds to remain calm at rest	
PW.c.1 **Birds must not be subjected to avoidable, excessive or sudden noises**	▪ Noises may be caused by people, equipment or ventilation systems ▪ Sharp/ sudden or hissing noises are eliminated from the lairage environment	
PW.c.2 **The lairage must be suitably lit**	▪ The lairage lighting is subdued to allow birds to rest, but is capable of being lit allowing inspection of birds required	
PW.d (REVISED) **The lairage must be constructed and maintained in a manner that enables effective cleansing and disinfection**	▪ Applicable to buildings (washing of lorries and crates are covered under Transport Wash Facilities) ▪ Lairage walls and floors are complete with a washable finishNo pooling of water	
PW.d.1 (REVISED) **The lairage must be cleansed and disinfected regularly to minimise contamination**	▪ Applicable to buildings when no birds are present (washing of lorries and crates are covered underTransport Wash Facilities) ▪ Dedicated facilities are available in the lairage area to do this ▪ The lairage is thoroughly cleansed and disinfected at least weekly ▪ No evidence of dried or built up faecal matter	
PW.e **A daily, visual check of the facilities used for live birds must be carried out by a competent member of staff, prior to the start of the day's kill**	▪ A visual check of the lairage, shackling and stunning/ slaughter system ▪ Visual check of lairage may be undertaken at clean-down ▪ If the visual check identifies an issue, corrective action is implemented – where there is a risk to bird welfare the issue is addressed immediately, recorded and reported to an animal welfare officer – where necessary production is halted until the problem is resolved or the affected area is not used	
POULTRY INTAKE		
AIM: Birds are checked and their welfare managed (Note: see Lairage section for a definition of the term 'lairage')		
PW.f **Systems must be in place to ensure that birds are held in the lairage for the minimum time possible**	▪ Birds are placed in the lairage as soon as possible and are held in the lairage for a maximum of six hours ▪ Applies to birds held in transport vehicles on-site or in the lairage building ▪ The order in which birds are unloaded/ killed ensures the time is not exceeded ▪ In emergency situations (e.g. line breakdown) where the time is likely to be exceeded, the emergency procedures are implemented ▪ Turkeys are given a period of acclimatisation (minimum 30 minutes) in order to settle prior to stunning and killing. The acclimatisation period never exceeds the maximum lairage time of six hours ▪ Emergency procedures: – have sought advice from AWO & OVS on the best course of action during a line breakdown – has considered possible postponement of catching to prevent further birds arriving during a breakdown period – has considered provision of feed and water for birds if withdrawal of feed exceeds 12 hours	

STANDARDS	HOW YOU WILL BE MEASURED	
PW.f.1 (REVISED) **A record of information for each load of birds is documented**	■ A record for each load is held and includes: - Date and time of bird arrival - Time of hanging or entry into a gas system - Dead on Arrivals (DOAs) - Birds culled on arrival/whilst resident in the lairage - Daily cumulative mortality rate - House number - Breed type - Journey time (first bird caught on farm to last bird killed at the factory) - Number of non-stuns/kills, reasons and actions taken if necessary - Time catch on farm started ■ Information recorded allows for feed and water withdrawal times to be easily calculated ■ Information recorded on the Animal Transport Certificate, Food Chain Information (FCI) or similar ■ The record is visible/ easily accessible to relevant staff	■ Flock arrival and killing records
PW.f.1.1 (NEW) **A system must be in place to check Animal Transport Certificates (ATCs) and Food Chain Information (FCI) are complete and contain all required information**	■ Missing information is investigated	
PW.f.2 (REVISED) **If DOA numbers exceed 1% for chickens, 0.2% for turkeys and 0.3% for ducks in a single load of birds, the root cause is established and corrective action undertaken**	■ A record of the issue, root cause and correction action taken is kept	
ANTE MORTEM CHECKS		
PW.g (REVISED) **A system must be in place to check the health and welfare of poultry that come onto site**	■ Food chain information and veterinary documentation is assessed for each flock ■ A sample of crates are inspected to check bird condition, behaviour and stocking density on arrival ■ A sample of crates are inspected for bird condition and behaviour regularly during a flock's time in the lairage. The inspection equipment allows for observation of birds at the top of vehicles ■ Records of checks are kept	■ Crate inspection records, Food Chain Information
PW.g.1 (REVISED) **Systems must be in place to check birds for signs of injury and fitness before stunning and killing**	■ All birds electrically stunned or killed are visually checked at hanging on	
PW.g.2 **Prompt appropriate action is undertaken in the event of health or welfare concerns being identified in the poultry checks**	■ Appropriate action taken to reduce stress, pain and suffering ■ Action may include culling of individual birds, prioritising of a flock for slaughter, adjustment to ventilation systems ■ Actions to be taken are agreed with the AWO ■ Relevant staff understand the actions to be taken in the event of birds arriving unfit or becoming unfit whilst on-site	
PW.g.3 **Birds that require emergency killing must be dealt with immediately by a competent person according to the sites documented procedure**	■ The site has documented procedure for: – culling of individual birds that need culling e.g. as a result of being trapped – culling of modules or whole flocks ■ The procedure outlines the action to be undertaken in relevant circumstances, identifies any equipment to be used and confirms birds are not placed on the processing line until after stunning ■ The methods used are as defined in the appendix	

HANDLING OF BIRDS	
AIM: Birds are handled in a welfare friendly and hygienic manner	
PW.h **Staff handling birds must be trained and competent**	▪ Applies to direct handling of birds and those handling containers of birds ▪ Staff have been trained to understand the good welfare practices relevant to their role ▪ Staff use handling techniques that reduce stress, including wing flapping at hanging on
PW.i **Modules and crates are unloaded in a careful manner**	▪ Modules and crates are handled with care – forklifts move smoothly and do not brake suddenly – modules are not tilted, dropped or overturned – modules are lowered/ raised gently
PW.i.1 **Modules and crates are positioned or stacked appropriately**	▪ Modules and crates are stable ▪ Modules are positioned in such a way ventilation is not reduced ▪ Only crates of suitable design are stacked on top of one another i.e. the design limits faecal matter dropping onto birds beneath
PW.j **Systems must be in place to minimise the risk of birds escaping**	▪ Systems minimise escape from the lairage, hanging on area or shackles ▪ Escaped birds are recaptured immediately, handled appropriately and re-hung (where appropriate) or humanely culled if injured
PW.j.1 (NEW) **Red Tractor Enhanced Welfare Assured birds must not be electrically stunned/killed where live inversion is practiced**	▪ All Red Tractor Enhanced Welfare Assured birds are stunned/killed by controlled atmospheric stunning using inert gas or multi-phase systems in accordance with the scheme standards ▪ Electrical stunning is only permitted without live inversion

STANDARDS	HOW YOU WILL BE MEASURED
ELECTRICAL STUNNING/ KILLING OF POULTRY	
AIM: Birds are effectively stunned and killed in a manner that ensures birds feel no pain or discomfort	
PW.k (REVISED) **Birds must be handled appropriately atelectrical stunning and killing points**	▪ Line speeds enable staff to handle birds correctly ▪ The system used is appropriate to the size of the bird e.g. small birds thatcould fall/ miss the stunning bath are not shackled. ▪ Large birds weighing more than 15kg liveweight are not shackled whilst conscious. ▪ Shackles used are of the correct type and size for the birds being hung on – birds are located properly into the shackle and hung by both legs – shackles are wet – shackle lines are fitted with breast comforters (rubber or plastic curtain) atthe point of hang on through to the stun bath ▪ The shackle line to the stun bath is smooth, has no sharp turns or obstructions, the shackles do not jolt ▪ The maximum live bird hang on time is: – 60 seconds for chicken – 120 seconds for turkeys – 120 seconds for ducks ▪ The hang on area is lit with blue or green lighting ▪ The feet from the previous bird are removed prior to a new bird being hung on ▪ If the slaughter line is stopped for longer than 120 seconds, birds between the point of shackling and the stunning point must be humanely killed immediately using a permitted back-up method (as detailed in the relevant appendix)
PW.k.1 **Bleeding without prior stunning is prohibited**	▪ For birds to retain their Red Tractor assurance status, they are stunned and then exsanguinated (bled) in accordance with current legislation, best practice guidelines and the site's standard operating procedures ▪ Stunning is effective in ensuring unconsciousness until death supervenesthrough exsanguination ▪ The sites procedures outline the stunning and killing requirements for all types and weights of birds ▪ The methods outlined in the **Appendix** are used

	▪ For each method used, specific parameters outlined in the relevant **Appendix** are adhered to RECORD: Standard Operating Procedures *Guidance to include definition of stunning as any intentionally induced process which causes loss of consciousness and sensibility without pain, including any process resulting in instantaneous death*

STANDARDS	HOW YOU WILL BE MEASURED	
PW.k.3 (REVISED) **Electrical stunning equipment is designed to ensure an effective stun**	■ Stunning equipment checked prior to each kill and problems preventing effective stun rectified prior to the start of slaughter ■ The voltage and current is clearly visible to those operating or monitoring the process and a warning must be easily seen and heard ■ In the case of electric waterbaths: – where birds are stunned in groups, the voltage and current are sufficient to ensure all birds are adequately stunned – the electrode that is immersed in the water extends the length of the waterbath – the design and set up prevents birds receiving pre-stun shocks, prevents flying over the water bath so un-stunned and results in the bird's head only (no other part of the body) entering the water first – for ducks, there is a steeply inclined flat ramp bolted onto the entrance of the waterbath and/ or a neck extender; – if a ramp is in operation, it extends over the water so the birds get drawn up the ramp by the shackle line and then swing down into the water in one smooth movement. Birds must not receive pre-stun shock from the ramp itself – if a neck extender is in operation, it does not obscure viewing for the assessment of the immediacy of stunning and the absence of pre-stun shocks. Neck extenders are monitored to ensure all birds' heads are pushed below the neck extender (and not trapped above it) – an ammeter is fitted to accurately monitor current flow through the bath when loaded with birds ■ The waterbath is adjustable so it is of suitable size and depth for the type of bird – the water height is set such that the heads of all birds are fully immersed in the water – the water level is of sufficient depth to cover the heads of the birds ■ Where required by legislation, the system records voltages and currents. Records are kept for at least 1 year	■ Electrical stunning/ killing records
PW.k.4 **Birds must be checked for signs of an effective stun or kill before neck cutting**	■ A competent person visually assesses every bird on exit of the waterbath stunner / stunning equipment ■ Any birds showing signs of an ineffective stun or kill are humanely killed without delay using a permitted back-up method (as detailed in the relevant **appendix**), before the blood vessels in the neck are cut. Neck cut occurs immediately after killing	
PW.k.5 **A suitable alternative method of stunning/ killing is available and ready for immediate useshould the primary stunning equipment fail**	■ The method is as outlined in the **appendix** ■ The method is ready for immediate use	
PW.k.6 **Where there is a recurring need to use the stun back-up method, the line must be stopped immediately, the root cause established and corrective action undertaken**	■ A record of the issue, root cause and corrective action taken is kept	
PW.k.7 **Birds must be exsanguinated without delay after stun by severing of both carotid arteries and both jugular veins achieving a free and rapid flow of blood**	■ Stun to neck cut/ decapitation times are as short as possible (but long enough to allow an assessment of stun effectiveness), and as a maximum, do not exceed 10 seconds for electrically stunned birds ■ As a minimum the two carotid arteries and the two jugular veins on both sides of the neck are completely severed ■ Where automatic neck cutters are used, every bird is checked immediately after the point of neck cutting to verify a correct cut and rapid bleed out	
PW.k.8 (REVISED) **Birds must be left to bleed and no further dressing procedures (including scalding) undertaken until suspended for a time that has been verified as sufficient to ensure death has intervened.**	■ Chickens and ducks are left to bleed for a minimum period of 90 seconds.Turkeys are left to bleed for a minimum period of 120 seconds ■ Line speed and access allows for verification that the birds are showing no signs of life prior to dressing	

STANDARDS	HOW YOU WILL BE MEASURED

PW.k.9 **Equipment used to shackle, stun and kill must be maintained in good repair and effective working order**	▪ All equipment used (including back up equipment) is maintained to be effective and parts replaced as necessary ▪ Equipment replaced as necessary if faults cannot be rectified, or recurring issues impacting on welfare occur ▪ Maintenance is undertaken in accordance with maintenance clauses in the Food Safety Module, and includes complete records of all maintenance which are kept for a minimum one year ▪ Manufacturer instructions are held/ accessible to the responsible person and followed	▪ Maintenance records
PW.k.10 **Electrical stunning and killing equipment must be calibrated or verified to ensure it works effectively**	▪ The current and frequency are calibrated in accordance with the manufacturers recommendations ▪ A documented procedure identifies frequencies of calibration and critical limits that are required ▪ At least annually, equipment is calibrated by an independent party ▪ Records of calibration, including any corrective actions are kept	▪ Calibration records
CONTROLLED ATMOSPHERE STUNNING (GAS) OF POULTRY		
AIM: Birds are effectively stunned and killed in a manner that ensures birds feel no pain or discomfort		
PW.l **Birds must be handled appropriately at the stunning and killing points**	▪ Where gas, stun/ kill methods are used, crates are placed on conveyors etc. with due care	
PW.l.1 (REVISED) **Birds must be stunned and killed in accordance with legal requirements, best practice guidelines and the sites standard operating procedures**	▪ Each bird is exposed to gas for long enough to ensure it is killed ▪ No birds are shackled before they are dead ▪ The procedures outline the stunning and killing requirements for birds ▪ Only the methods outlined in the appendix are used ▪ Carbon dioxide at high concentration (exposure to minimum 40% carbon dioxide) is prohibited as a method of stunning and killing ▪ For each method used, specific parameters outlined in the relevant appendix are adhered to	▪ Documented procedures
PW.l.2 (NEW) **Carbon dioxide must not exceed an average maximum concentration of 30% until birds have lost consciousness**	▪ Applies to bi-phasic and multi-phase gas stunning systems killing chickens and turkeys ▪ An absolute maximum concentration of 33% is not exceeded until birds have lost consciousness ▪ The induction to unconsciousness is calm i.e. no excessive wing flapping or escape behaviour observed	
PW.l.3 **Gas stunning equipment used for poultry is designed to maintain welfare and ensure an effective stun and kill**	▪ The equipment: – measures, displays and records gas concentrations and the time of exposure – maintains gas concentration – allows birds to be monitored in the stunner and accessed without delay – allows atmospheric air to be promptly flushed through the stunner ▪ A monitoring device is in place which visibly and audibly alerts an operator to drops in gas concentration below the legal limit and equipment failure ▪ Records are kept for at least one year	▪ Gas concentration and exposure records
PW.l.4 **Birds must be checked for signs of an effective kill, immediately upon leaving the gas system**	▪ Any birds showing signs of life are humanely killed without delay using a back-up method before the neck is cut. Neck cut occurs immediately after killing	

PW.I.4.a **A contingency plan must be drawn up to include details of what action would be taken if a breakdown occurred while birds were still in the gas system, to avoid prolonged delays**	▪ In the event of a breakdown, where live birds have remained in the gas system for longer than 2 minutes: – the system must be flushed with atmospheric air to remove the remaining gases – birds must be immediately removed for slaughter using a permitted back-up method
PW.I.5 (REVISED) **A suitable back-up method of stunning or killing must be readily available at the exit to the gas system and bleed points or in the event of a CAS system breakdown**	▪ The method used is as outlined in the **Appendix** or can be live inversion with electrical stunning if this is deemed the most humane and available alternative to stun/kill birds ▪ For large birds weighing more than 15kg liveweight, live inversion with electrical stunning is permitted as a back-up method if recommended by the official veterinarian ▪ The method is ready for immediate use

STANDARDS	HOW YOU WILL BE MEASURED	
PW.I.6 **Where there is a recurring need to use the back-up method, the line must be stopped immediately, the root cause established and corrective action undertaken**	▪ A record of the issue, root cause and corrective action taken is kept	
PW.I.7 **Birds must be exsanguinated or bled without delay**	▪ There must be sufficient time after exiting the gas system and prior to anyother procedure (e.g. neck cutting) to assess the effectiveness of the kill ▪ As a minimum the two carotid arteries and jugular veins in both sides of theneck are completely severed ▪ Where automatic neck cutters are used, every bird is checked immediatelyafter the point of neck cutting to verify an effective cut	
PW.I.8 **Birds must be left to bleed and no further dressing procedures (including scalding) undertaken until it has been verified that the bird has no signs of life**	▪ Chickens and ducks are left to bleed for a minimum period of 90 seconds.Turkeys are left to bleed for a minimum period of 120 seconds ▪ Line speed allows for verification that the bird is showing no signs of life priorto dressing	
PW.I.9 **Equipment used to stun and kill birds must be maintained in good repair and effective working order**	▪ All equipment used (including back up equipment) is maintained to beeffective and parts replaced as necessary ▪ Maintenance is undertaken in accordance with maintenance clauses in theFood Safety Module ▪ Manufacturer instructions are held/ accessible to relevant staff and followed	
PW.I.10 **Gas stunning and killing equipment must be calibrated or verified to ensure it works effectively**	▪ Gas levels and timings are verified, sensors are calibrated,in accordance with manufacturer recommendations ▪ The sites documented procedure identifies frequencies of verification or calibration and critical limits that are required ▪ At least annually, equipment is verified/ calibrated by anindependent party ▪ Records of verification/ calibration, including any correctiveactions are kept	▪ Calibration/ verification records
CONTROLLED ATMOSPHERE STUNNING (GAS) OF POULTRY (NEW SECTION)		
AIM: Chickens up to 4kgs live weight are stunned/killed without pain or distress		
PW.I.11 (NEW) **Crates containing live birds must be moved carefully to the vacuum system ensuring birds remain calm**	▪ No sudden movement, tipping or dropping of crates	

PW.l.12 (NEW) **LAPS stunning equipment must have a vacuum chamber enabling slow gradual decompression with reduction in available oxygen**	▪ Phase one is measured and recorded and a reduction of not more that 760 to 250 Torr in not less than 50 seconds is achieved ▪ Phase two is measured and recorded and a further reduction to 160Torr within 120 seconds is achieved ▪ The time pressure curve can be adjusted to ensure all birds are irreversibly stunned with the cycle time ▪ The oxygen level is reduced to below 5% ▪ The chamber is leak tested and pressure gauges calibrated before each session and at least daily ▪ Records of vacuum pressure, time exposure temperature and humidity in the chamber are continuously recorded and kept for 1 year ▪ The birds are visible within the chamber	
PW.l.13 (NEW) **Birds must be checked for signs of an effective kill, immediately upon leaving the vacuum chamber**	▪ Any birds showing signs of life are humanely killed without delay using a permitted back-up method before the neck is cut ▪ Neck cut occurs immediately after killing	
PW.l.14 (NEW) **A contingency plan must be drawn up to include details of what action would be taken if a breakdown occurred while birds were still in the LAPS system, to avoid prolonged delays**	▪ In the event of a breakdown where live birds have remained in the LAPS system for longer than 2 minutes: – the system must be flushed with atmospheric air – birds must be immediately removed for slaughter using a permitted back-up method	
PW.l.15 (NEW) **Where there is a recurring need to use the back-up method, the line must be stopped immediately, the root cause established and corrective action undertaken**	▪ A record of the issue, root cause and corrective action taken is kept	
PW.l.16 (NEW) **On exiting the chamber broilers must be bled out without delay**	▪ Both carotid arteries and both jugular veins must be cut and a rapid bleed out achieved	
TRANSPORT WASH FACILITIES		
AIM: Transport facilities are cleaned and disinfected and don't pose a biosecurity risk		
PW.m **All crates, modules and transport vehicles must be effectively cleansed and disinfected prior to leaving the site**	▪ Applies to crates, modules, vehicle curtain sides and any other equipmentbirds may come into contact with ▪ The wash phase is effective and removes visible debris	
PW.m.1 **Suitable disinfectants are used**	▪ Disinfectants used are approved by Defra (or equivalent) ▪ Disinfectants are diluted in accordance with manufacturer's instructions andwhere applicable at General Orders Rates ▪ Chemical datasheets for disinfectants on-site are easily accessible to relevant staff	
PW.m.2 (REVISED) **The washing facilities must be available and useable during all times of the year that the site is operated**	▪ Available and useable during the times of year the site is operated (i.e. year-round operating sites are able to offer wash facilities during winter and normalfreezing conditions) ▪ Facility available for use at all times or at times pre-arranged to users	
PW.m.3 (REVISED) **The washing facility must be well-managed and maintained**	▪ The location of the facility poses no risk of cross contamination (i.e. by waterspray or run off) to poultry or clean lorries; or a welfare challenge to the birds ▪ Automated machines must be inspected daily to ensure all nozzles and spray heads are working and operating in the correct direction ▪ Soak systems and water agitation systems must be operating to standard ▪ Responsible person contactable during the hours the facility is open ▪ Area left clean and tidy after use	

	▪ There are systems in place to investigate issues raised by users RECORD: Automated machine Inspection records
PW.m.4 **Users of the wash facility must be competent**	▪ If the facility is on-site, crates are washed by site staff, who have received appropriate training; lorries/ curtain sides are washed by drivers or site staff

STANDARDS	HOW YOU WILL BE MEASURED	
PW.m.5 (REVISED) **All crates, modules and transport vehicles must be checked for cleanliness, against the sites documented protocols, before leaving the site**	■ Visual check undertaken in daylight (or artificial equivalent to) ■ Checks made against the site's clean lorry protocols, that includes pictures of acceptable and unacceptable cleanliness as a guide ■ Post cleaning, cleanliness of crates, modules and transport vehicles meet the site's documented standards of acceptability ■ Cleanliness checks must be documented	■ Site protocols and cleanliness check records
PW.m.6 **Where the check identifies incomplete cleaning, the issue is rectified**	■ Crate and/ or module/ vehicle are re-cleaned and disinfected ■ Where the issue reoccurs, a root cause analysis is undertaken and where necessary improvements made to the wash facility	
PW.m.7 **All crates and modules must be checked for damage, against the sites documented protocols, before leaving the site**	■ Visual check undertaken in daylight (or artificial equivalent to)	
PW.m.8 **Where the check identifies damage that could pose a risk of injury to birds, the crate/ module must be removed**		
PW.m.9 **Wastes from the transport washing facility are stored and disposed of appropriately**	■ Dirty water is stored in a non-permeable tank and disposed of via a waste contractor, or where appropriate disposed of to mains systems	
INTERNAL AUDITING		
PW.n **A CCTV system must be in operation which is used to review practices and behaviours around key welfare activities**	■ A CCTV system with a complete and clear view of all the following areas where there are live birds: – unloading – the lairage – handling/ shackling/ restraining – stunning – sticking and bleeding ■ CCTV operational and recording at all times when and where there are live birds in the abattoir ■ CCTV maintained and in good working order ■ CCTV capable of constant recording so that images can be produced for inspection without stopping the overall operation of the system ■ Documented procedures detail how the footage will be reviewed and used to review practices and behaviours around key welfare activities ■ CCTV footage is kept securely for a minimum of 90 days and is only accessible by nominated staff ■ CCTV system capable of storing, processing and transmitting (for example moving to removable storage devices or showing on a television monitor) images and information of the same quality as the original recording ■ CCTV images are made available on request ■ Employees are informed that CCTV is in use and sign to say that they understand it is in use	■ Staff understanding that CCTV is in use; documented procedures

Appendix Poultry Welfare

STUNNING AND KILLING METHODS

The manufacturer's recommendations must be adhered to for each method used

Simple Stunning Methods						
Electric Methods	**Minimum frequency (Hz) per bird**	**Minimum current (mA) per bird**			**Exposure time (seconds)**	**Time from stun to neck cut (seconds)**
		Chickens	Turkeys	Ducks		
Head only electrical stun		240	400	Not permitted	10	Immediate
Electric water bath	51- 199	100	250	130	4	10
	200- 400	150	400	Not legally permitted	4	10
	400- 1500 (Recommended – max 800Hz)	200	400	Not legally permitted	4	10

Stun Kill Methods						
Electric Methods	**Frequency (Hz)**	**Minimum current (mA)**			**Exposure time (seconds)**	**Time from stun to neck cut (seconds)**
Electric water bath	50 and less	Chicken	Turkey	Duck	4	N/A
		120	150	130		
Controlled Atmosphere Methods	Type of exposure	Concentration (%)			Exposure time (minutes)	Time from stun to neck cut (seconds)
CO^2 in two phases	Progressive exposure to a rising concentration of CO^2 up to maximum 33% then a higher concentration, once the birds are unconscious	Maximum 33% phase 1 (Average max 30%) phase 2 = higher			Depends on the rate of the progressive increase in CO^2 to which the birds are exposed, which will vary with different systems	N/A
CO^2 and inert gas mix	Direct or progressive	Maximum 30% CO^2 , O^2 2% or less			≥3	N/A
Inert gases	Direct or progressive	Less than 2% O^2			≥3	N/A
LAPS		▪ Phase one must be measured and recorded and achieve a reduction not more that 760 to 250 Torr in not less than 50 seconds ▪ Phase two must be measured and recorded a further reduction to 160Torr within 120 seconds ▪ The time pressure curve can be				

		adjusted to ensure all birds are irreversibly stunned with the cycle time ■ The oxygen level must be reduced to below 5% ■ The chamber must be leak tested and pressure gauges calibrated before each session and at least daily ■ Records of vacuum pressure, time exposure temperature and humidity in the chamber shall be continuously recorded and kept for 1 year. ■ The birds must be visible within the chamber			

EMERGENCY KILLING METHODS

Method	Parameters/ limitations
Cervical dislocation (including assisted cervical dislocation)	Maximum bird weight limit of 3kg. Maximum of 70/birds per day
Captive Bolt (e.g. Cash Poultry Killer or similar)	Manufacturer's instructions are followed. The stun is followed by bleeding or neck dislocation
Electric hand held stunner	Not permitted for ducks. Manufacturer's instructions are followed. Parameters as required forits use as a stunning/ killing method are followed
Gas killing	Systems are in place to ensure birds requiring emergency killing are managed separately to non-emergency. Parameters as required for its use as a killing method are followed

Appendix PW.a.8 – Protocol for duck welfare outcome scoring

GUIDANCE AND SAMPLING

Measures in the lairage	
1. Ocular Health	**50 animals per house, sampled randomly at the lairage area. 10 animals from 5 different crates should be assessed.**
2. Nostril Health	
Measures at the processing line	
1. Feather cleanliness 2. Feather coverage 3. Feet Health	100 animals per house, sampled randomly at the processing line. These indicators may not be able to be assessed all at the same time. If that is the case 100 animals should be assessed at one point for feather cleanliness and coverage and 100 animals should be assessed for feet health at another point in the line. The locations of the assessment should be chosen based on good access to the ventral side of the duck for feather cleanliness and for the feather coverage, and the dorsal side of the duck for the feet health assessment. Also, feet should be assessed before removal of the skin. The 100 sample can be assessed continuously.

1. Ocular Health

Sample: 50 ducks selected randomly.
Assess using the CIWF scoring. Observe ducks at the lairage area. 10 animals from 5 different crates.
Observe the right and left eye and score according to the worst score.

Scoring:
0= Healthy eye
Eyes are clear, clean and bright

1 = Slightly affected eye
Presence of presence of crust around the eye and/or feather loss around the eye

2= Inflamed and/or infected eye
eyes are wet and weepy, or red rimmed
There may be active infection and in extreme cases the eyes stay closed

2. Nostril Health

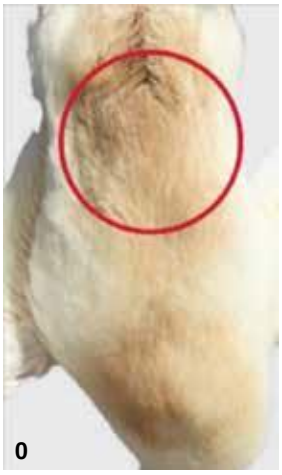
Sample: 50 ducks selected randomly.
Assess using the CIWF scoring. Observe ducks at the lairage area. 10 animals from 5 different crates.
Observe the right and left nostrils and score according to the worst score.

Scoring:
0= Clear and clean nostril
Clear and clean nostril. May be able to see through the beak. Some dirt may be present on the beak.

2 = Blocked nostrils
Moderate blockage, or severe blockage and dirt. Ducks may be with their beak open (difficulty breathing due to blockage)

3. Feather Cleanliness

Sample: 100 ducks selected randomly.
Assess using the CIWF scoring. Observe ducks on the slaughter line, in a location where the ventral side of the ducks' torso is visible. 100 animals per house.



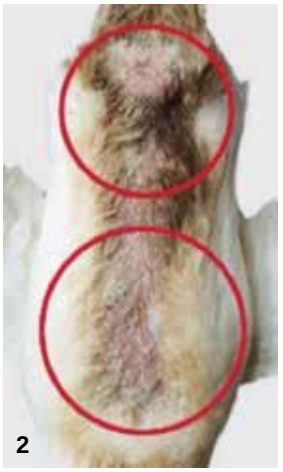
Scoring:
0= Clean ventral feathers
Feathers are dry with no or minor discoloration (soiling) on the surface of the feathers

1 = Slightly dirty ventral feathers
Soiling is moderate with the dirt beginning to penetrate the upper layer of the feathers

2= Very dirty ventral feathers
Soiling is heavy with dirt penetrating the underlayer of the feathers with some clumps forming. Feathers are wet

4. Feather Coverage

Sample: 100 ducks selected randomly.
Assess using the CIWF scoring. Observe ducks on the slaughter line, in a location where the ventral side of the ducks' torso is visible. 100 animals per house.



Scoring:
0= Good feather coverage
Feather cover is full and even.
No broken feathers or bare patches (except for 1 or 2 small (<2cm) patches)

1 = Moderate feather coverage
Feather cover is uneven.
Some broken feathers and several or extended bare patches.

2= Bad feather coverage
Feather cover is poor.
Extended areas totally devoid of feathers (usually along the midline from the breast to the cloaca region).

5. Feet Health

Sample: 100 ducks selected randomly.
Assess using the CIWF scoring. Observe ducks on the slaughter line, in a location where the plantar side of the ducks' feet is visible. 100 animals per house. Observe the right and left feet and score according to the worst score.

Scoring:
0= No lesions
No lesions or very small and superficial lesions, slight discolouration, mild hyperketosis, old scars.

1 = Mild lesion(s)
Substantial discolouration of the footpad, superficial lesion, dark papillae, raising of papillae.

2= Severe lesions
Ulcers or scabs of significant size, signs of haemorrhages or severely swollen footpad.