



Ingredients Division Project Update

The new Casein plant project is moving forward and is on schedule. The main super structure of the Casein plant is now complete. The building is divided into two areas, the wet process and dry process area. In the wet process area, internal finishes are underway with tiling now complete on both ground floor and first floor levels. This project milestone enables the mechanical and electrical team to commence works on the process plant installation. The wet process equipment installation has commenced with all large-scale equipment to be in position by month end. On the dry side of the plant, the powder storage silos and bag filter have been installed prior to roof closure. The dryer and remaining ancillary equipment are scheduled for installation in August.



Bag Filter and Powder silos in the dry processing Area



Process Tanks and Coagulation Tubes in the Wet Processing Area

Save the date!

Arrabawn Open Day

August 22nd.
Gurteen Agricultural College
11.00 am - 3.00 pm

Don't miss this year's Arrabawn Open Day on 22nd August.

Catch up on all the latest technology and research with the excellent range of companies and presenters attending on the day.

CONGRATULATIONS

Congratulations to Our Own Paddy Purcell who captained the Joe McDonagh Cup winning Laois team. Paddy is known to most of our milk suppliers as the coordinator of our Milk for Profit joint program with Teagasc and also as our Agricultural Advisor on the ASSAP program and is available to advise everyone on



how to ensure that their farm is doing everything possible to help improve the environment.

No lame excuses for autumn 2019

The cost of dairy cow lameness could be up to €300 per case, not to mention reduced animal welfare and the hassle factor of lame cows. Recent research by Teagasc Moorepark has shown a lameness rate of 4% in spring, and over 7% in autumn across a group of dairy herds. Cows with problems in the spring were 10 times more likely to re-appear as lame in the autumn.

The main lameness causes (Figure 1) for these grazing herds were mechanical (bruising, white line disease, ulcers, overgrown digits), as opposed to infectious (Mortellaro, foul in the foot) in nature. The priorities for grazing herds are therefore related to surfaces and managing cow flow around milking times. Now is a good time to address issues on the farm before we move into the high-risk time of year. Some things to implement are as follows.

- Problem spots: seemingly small problem areas like standing water, poorly drained corners, broken surfaces, shading by overgrown tree branches, etc., can cause major lameness problems; identify and fix these as a first step.
- Road surfaces: are they good enough? Small pebbles and grit are the main cause of white line disease. If this is being seen at hoof trimming then there is an issue to be fixed. Surfaces should be smooth and finished with a well compacted surface material. Take an hour or two to walk the farm roads and note the quality of surface, getting a second opinion if possible.
- Interface area: the step from roadway to concrete can often be a cause of lameness due to pebbles being dragged onto the hard surface. Laying 8-10m of material like AstroTurf at yard or tunnel entrances/exits has worked very well for many farms.
- Road verges: a common problem is build-up of grass/sods along the road over time, which impedes drainage. Remove these or at least break regular openings to provide drainage.
- Cow flow in and out of the parlour: are there simple modifications that could be made? For example, removing sharp turns and providing matting on narrow parlour exits. Check the size of your collecting yard - providing more than 1.5m² per cow reduces stress on cows' feet.
- Hoof trimming: lameness is a repeat-offender problem. All cows that were treated during spring or have previous history should be drafted for selective trimming before mid August. Check all cows for rear hoof condition at milking. Trim overgrown digits before clinical lameness emerges.
- Foot bath: for infectious disease control (where identified) and prevention; follow a clear protocol for product use and schedule of treatment

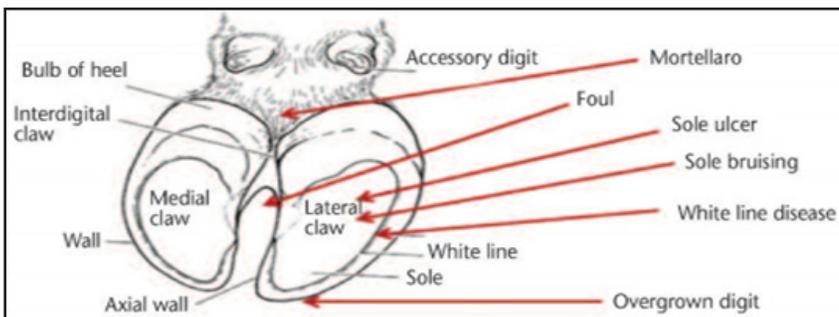


Figure 1. Normal hoof and sites of common lameness problems

Smarter Milking Event

bringing Efficiencies back to your Farm

Friday 19th July

Tom & Anne Hogan,
Clooneen Upper,
Cloughjordan, Co. Tipperary
Eircode E53 YW63

Topics covered :-

- **GETTING COWS IN and OUT**
- **DOING THE JOB RIGHT**
- **SAVING ENERGY and MONEY**
- **PRODUCING HIGH QUALITY MILK**
- **SAVING TIME ON MILKING**

THIS FREE EVENT STARTS AT 11am

CELLCHECK TIP OF THE MONTH

Don't risk it - time for a change!

CellCheck recommends that liners are changed every 2,000 milkings, or every 6 months whichever comes first. This is to help prevent mastitis and ensure that maximum milk yields are being harvested. Cluster liners are designed to flex and squeeze the teat during each pulsation cycle. This massages teats and maintains blood supply. While liners are working they begin to lose tension, absorb fat and hold bacteria. After too many milkings this can reduce the speed and completeness of milking, resulting in a loss in milk yield. It also increases teat end damage and increase the spread of mastitis bacteria. Fatigued rubber can also hold bacteria and this can increase the total bacterial count (TBC) if dirt is being trapped. To calculate how many days it takes to reach 2,000 milkings, see page 52 of the CellCheck Farm Guidelines for Mastitis

Control. For example, for the average Irish milk recording herd of 102 cows, if the full herd has been milking since March 1st in a 12 unit swing over parlour, the milking liners will have clocked up over 2,600 milkings by 31st July. These liners had completed 2,000 milkings by June 26th! Alternatively, estimate how often you should change your liners, based on the number of rows you're milking:

- So, if you're milking 8 rows of cows, you should be changing your liners every 125 days, which is approx every 4 months
- And if you're milking 11 rows of cows, you should be changing your liners every 91 days, which is approx 3 months

No. of rows	Days between changes (twice a day milking)
6	167
7	143
8	125
9	111
10	100
11	91
12	83
13	77
14	71

Garda Message



Telecommunications Fraud (phone scams)

Gardaí appeal to all business owner to review

their business phone systems -

Hackers exploit poor security in a business phone system causing it to generate large numbers of calls to international and premium rate numbers. **Typically the hack will occur when the business is closed (early morning, weekends, holiday periods*)**. The Hacker receives money from the calls, the hacked business foots the bill which can be many thousands of Euros.

Prevention of phone fraud - PBX IRSF

- Get expert advice. Keep Phone System software up to date. Include Phone System in IT security reviews.
- Review Phone System security regularly especially before holiday periods (Christmas, Easter, Bank Holiday Weekends).
- Set strong Admin passwords. Do not use defaults (1234, 0000, 1111).
- Set strong Voicemail passwords. Do not use password 7865 for extension 7865.

- Block Calls to premium rate numbers.
- Block calls to international destinations other than those needed. (Start with all blocked then unblock as needed).
- Turn off remote access features unless absolutely necessary (remote voicemail access for example)
 - Limit Admin access to the Phone System and also physical access if possible. Keep a log of who has access (both Admin access and physical).
- Hackers look for easy targets and will only spend a few minutes trying to gain access to a system before moving on. A few simple steps can be enough to put them off.

If you are hacked -

- Contact your phone service provider to report the incident.
- Contact your Phone System maintainer to have your system security reviewed.
- Report the incident to the Gardai. Give the Pulse number to your phone service provider.
- * The holiday periods mentioned include bank holidays, Easter, Christmas etc

Revenue Scam Warning

Gardaí have been made aware of a recent telephone scam where a male/female caller states they are from Revenue and seeks immediate payment of a tax bill over the phone. They may also give you a telephone number to call back to give your credit card details. This caller is not calling from Revenue. This is a scam and An Garda Síochána would like to remind the public to be wary of any contact from an unsolicited source, whether it is by telephone or email. Do not give out your credit/debit card, bank account, or PPS Number to anyone who makes contact with you over the phone. An Garda Síochána, Revenue, nor any Financial Institution will ever call you and ask for your PPS number or bank account details. If a member of the public receives a call from anyone requesting any personal or financial information, they should end the call and report the matter to their local Garda Station, to any Garda station, or to the Garda Confidential line on 1800-666-111.

Think ahead of Reduced Grass Growth and challenging milk solids

Recent times have led to stunted grass growth rates throughout the Arrabawn catchment. It has been reflected in some cases in milk solids and other cases in milk yield. Certainly with milk yield it's important to note most cows have peaked for your early spring calved cows almost 6-8 weeks now. Milk yield can drop up to 0.25%/week post peak so its important monitor the diet consistently to keep cows averaging for a long as possible and as high as possible. Firstly, try to maintain grass ahead of the cows or if the latter is slowing down on rotation, the option of topping up total dry matter intake with concentrates is the easiest available option coupled with long fibre in the form of silage, hay or straw if its practical that is in severe cases!

Arrabawn have options, in cases of grass supply shortening Arrabawn **Energymax 14%** with high levels of Maize, Barley & Beetpulp provides a good source of starch for maintaining Lactose levels in the cow and balanced with good sources of digestible fibre in Beet Pulp. To counteract rich grass or control LAB in the rumen Acidbuff and a live yeast are included to give a balance and help butterfat levels.

In terms of milk solids, if one is having issues, Arrabawn have a **Grass Max Fibre** Nut balanced with

high fibre through B.Pulp, Soya Hulls and includes high Maize to help Milk Protein ratio to Butterfat . Ruminant Acidosis has been an ongoing issue this grass year in a number of cases as a result of grass coming in abundance and growth coming in spurges which led to grazing covers or targeting the ideal grass covers that more difficult . For this reason, this 14% product includes rumen buffers & De-oderase which adjusts pH and reduces the risk of SARA and in turn BF drop. **Extending rotation & upping your total DM in the diet** will buy you time in cases of scarcity of grass & milk solid issues. In Arrabawn we can assess your diet i.e. sample fresh grass and look at your solids and see where the issue is. This is vital so talk to your local Arrabawn representative. 2018 was an extremely difficult year - 2019 in most cases has been a recovery year as such for those high risk drought farms so maintaining high milk output and high solids for as long as possible is essential through the next few rotations.

For more info on Energymax, **High Fibre Grassmax**, adequate feeding rates, and other nutritional matters, consult your local Dan O'Connor Feeds representative or any branch of Arrabawn Co-op

Lime – the key to an effective soil fertility programme

Fertiliser is a major spend on most Irish farms and is often not exploited for the best results. Obviously, the timing of fertiliser applications is crucial. The choice of fertiliser is also an issue as many farmers depend on straight Nitrogen to drive on grass during the summer months when in actual fact, they should be using an NPK combination such as 27 2.5 5 - despite the fact that there may have been P and K applied earlier in the spring.

Of course, one of the main issues why fertiliser may not be working could be Soil pH or soil acidity. It is normal for soil acidity to build up on the soil surface as a result of decaying vegetation and animal waste. These acid conditions will affect how fertiliser reacts with the soil and also how quickly a grass seed will germinate and get established when reseeded.

Applying lime should be based on a recent soil sample analysis - this will indicate whether the soil needs lime and how much. Over-liming should be avoided as it can lead to trace element problems in some parts.

How does pH affect nutrient uptake? This table shows how soil pH can affect the availability of the main soil nutrients.

pH	4.5	5.0	5.5	6	7
Nitrogen	30%	43%	77%	89%	100% available
Phosphorus	23%	31%	48%	52%	100% available
Potassium	33%	52%	77%	100%	100% available

Lime will correct the soil pH and improve the performance of your fertilizer.

Mid summer or autumn are the best times to spread lime .

Apply slurry or Urea 3 months after lime spreading or
Apply lime 10-14 days after slurry or Urea application to avoid nitrogen loss from slurry.

Allow 4 - 7days between slurry and nitrogen application, apply slurry first.

Do not apply more than 2-2.5 tonnes lime in one application - if more is required, apply the balance after approx. 2 years. Over-liming can lead to trace element imbalances.

Contact your local Arrabawn branch for further details.

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Summer Mastitis

Summer mastitis is a common condition we can see especially in pregnant cows and heifers but can also occur in non-pregnant animals.

The first sign to watch is that the animal may be standing apart from the others and walking stiffly.

Then closer examination of the animal can show that one or more of the quarters is hard, hot, swollen and, especially in a heifer, it will be very painful.

Yellow, custardy material is produced which in most cases has a foul smell.

In the quarter affected by summer mastitis the teat seems thicker, as if it has a fibrous cord through the teat cistern and heifers are especially affected in this way.

It is very important to treat it as untreated cases may abort or even die, others may develop a permanent arthritis.

Also calves of affected animals are born alive but they probably have a reduced viability.

Treatment of summer mastitis is challenging as by the time we notice it the quarter has usually already been lost and treatment is mainly aimed at reducing the illness in the animal. However occasional quarters do recover.

Prevention consist of two parts , dry cow therapy and fly control.

Fly control has several advantages in addition to prevent summer mastitis.

By far the best method of fly control for summer mastitis is to apply insecticide directly onto the udder every one to two weeks.

More popular are pour-on which is applied along the animals back and is absorbed and spreads all over the skin.

The fly is attracted by any discharge and very large numbers will be seen on the end of an affected teat and for that reason it is simply not sufficient to spray insecticide over the animals backs. We have to include animals' abdomen and on its udder.

Using Headstart GP with Garlic Licks has been found to be effective in repelling flies around cows and heifers during the summer months. Making one bucket available to 10 animals over a two week period will help ensure sufficient intake. Suitable for replacement heifers and dry cows.

The other option of fly control is ear tag which contains insecticide.

Another method of keeping flies away from the teat is to cover the ends with a permeable teat tape.

Finally, try to avoid grazing heifers and dry cows near woody or wet areas during summer months.



Arrabawn

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AUGUST 3RD 2019**



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Summer Dairy Farm Walk 2019 – Trevor & Steven Cole

On June 27th, Trevor & Steven Cole hosted a summer dairy farm walk on their home farm in Aghancon just outside Roscrea County Tipperary. Trevor & Steven are part of the milk for profit programme and hosted their second and last farm walk as part of the programme. They joined the 3 year programme in 2017.

There were over 50 farmers in attendance on the day and we covered milk quality, Labour efficiencies, TAMS/Shed design and the nitrates mid-term review. The speakers on the day were David Gleeson (Milk Quality Researcher), Martina Gormley (Teagasc Dairy Specialist), Tim Hyde (Environment Knowledge Transfer Specialist) and James Moyles (Teagasc advisor Offaly).

Trevor & Steven Cole are milking 138 cows on a 52ha milking block. The current stocking rate on the milking platform is 4.13 with second cut silage (12ha) and reseeded (3ha) taken place. The Coles farm 80.5ha in total. Last year the farm sold to 434kg MS per cow to Arrabawn Co Op. Trevor and Steven have focused on improving soil fertility and reseed annually. Last year they reseeded just 8 acres on the out farm. No reseeding took place on the milking platform last year due to the difficult weather conditions, however this year they plan to reseed up to 10% of the milking platform. Soil fertility is improving every year but some paddocks still require build-up of Ps and Ks. Muriate of potash was applied at the back end of last year to improve the K levels.

Since the Milk for Profit programme began in 2016 cow numbers have increased and the Coles aim to milk up over 150 cows in the near future. Focusing on soil fertility will be a key objective

for the coming years in order to improve grass production and utilisation on the farm. Milk solids per cow has increased over the course of the programme through selective breeding and improved grassland management. The Coles set a target of reaching 450kg MS/cow at the beginning of the programme. In 2018, the Coles sold 434kg MS/cow to the Co Op. However all the calves were fed whole milk for 8 weeks so the Coles came very close to their target of 450kg + MS per cow.

Currently, a new cubicle shed is being constructed on the farm to house the cows and heifers over the winter months. A new milking parlour is also in the plans for the future.

Martina Gormley spoke about labour efficiencies on the Coles farm. Martina outlined then main labour issues on dairy farms being spring workload, managing time off, Facilities, communication and sourcing labour. Martina then moved on to speak about labour efficiencies practised on this farm. The Coles have a breeding season less than 13 weeks, parlour closed over the winter, calves fed milk once a day, calves out to grass before March 17th and working handling facilities on all land parcels. However there is always room for improvement and Martina threw out some ideas which may help reduce labour on dairy farms. These include start milking before 4.30pm & finish at 6pm, a working drafting facility, up fewer than 15 nights during calving, greater than 50% of slurry & fertiliser contracted out, three grazing's per paddock in summer and less than 15 mins scraping yards/day. David Gleeson spoke about the importance milk

quality and gave a few tips on how to improve milk quality within your herd. David spoke about minimizing thermoduric numbers in bulk tank milk. Thermoduric bacteria can withstand pasteurisation temperatures and can negatively impact on the quality of dairy products. A good thermoduric level of <200 while a penalty will incur if you are over >1000 cfu/ml. The critical points are cow management (clean and dry teats, trim cow tails x 3 yearly), clean environment (collecting yards and roadways) and an effective wash routine (hot water 75 °C, acid washes and sufficient volume of detergent). Chlorine free products to be used on all farm by 2021. David's take home message on chlorine free was that chlorine free wash routines will maintain plant cleanliness if the recommended guidelines are followed.

Tim Hyde spoke about applying for TAMS II and outlined the protocol and who was eligible. The Coles new shed was also discussed which will hold up to 150 cows easily. Tim outlined the costings of different sized slurry storage tanks and there was a good discussion around this amongst the farmers. Tim also spoke about the nitrates derogation mid-term review which is due to rolled out in the coming weeks. Here the main take home messages were the use of protected urea and low emission slurry spreading. We would like to thank all our speakers and farmers for attending the farm walk. We would also like to thank the Coles - Trevor, Anne and Steven for participating in the Milk for Profit programme and we wish them every success in the future.



Martina Gormley (Teagasc Dairy Specialist) speaking about Labour efficiencies at Coles farm walk.

STUBBLE CULTIVATION

Extend the grazing season by sowing a catch crop such as Rape, Kale or Stubble-turnip into the cereal ground after the crop has been removed. By now it will be too late to sow kale, but rape could be a good option. Such a crop could be used to extend the grazing season, reduce the requirement for slurry storage and also reduces the need to house cattle while they are grazing the crop. Some local authorities recognise winter grazing such crops, on suitable land, as an alternative to housing cattle over the winter. In the seventies, it was normal to broadcast seed into the standing crops a few weeks before harvest.

By the time the harvest arrived, the seeds were germinated and the crop was established.

It may suit a tillage farmer to come to an arrangement with a local livestock farmer. Something to think about!