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a) If a company was expanding they would have to consider the amount of pollution they are contributing to the environment. Solid, liquid & air pollution are a ~~common~~ ^{common} by product of industry. Recycling is another consideration. It is important that the company improves its recycling capabilities whilst ~~expanding~~ ^{expanding}, for example using materials that ~~are~~ can be re-used for future manufacturing. Another environmental consideration is the process of sustainable development. It is important that the company ~~and~~ adopts certain sustainable technologies such as hydro electricity & ~~sun~~ ^{solar} power when expanding to implement sustainable development & ~~ensure~~ ^{ensure} that current production doesn't harm future generations. The impact the expansion will have on ^{the} local environment is extremely important such as the effect expansion will have on ecology, flora & fauna.

b) Change is inevitable in an industry. To survive a company must make profit & to do so it takes time, patience & decisions that ~~will~~ affect the whole company. ~~efficiency & productivity of the company is a direct result of~~ ~~the~~ ~~cost~~ ~~control~~ planning Re-location & expansion is generally the change a company chooses to increase profitability. As a result many issues arise & it is important for ^{higher} ~~manager~~ management to address these issues & come ^{up} ~~out~~ strategies to ~~address~~ ^{solve or manage} them before making any large scale decisions.

Structural issues are a direct result of moving a company. It is important for managers to consider the ~~or the~~ ^{working} ~~force~~ workforce under them as certain groups are affected by the structure of a new workplace. A common structural issue is handicap accessibility ie wheelchair access. It is important that managers consider placing ~~up~~ ^{rap} ramps so that a disabled citizen ~~or~~ ^{or} staff can ~~get~~ access to ~~build~~ buildings. Another structural issue is the amount of car parks available for staff. If there ~~isn't~~ ^{isn't} enough space for everyone then it isn't equitable to choose that site for a new location. The final structural issue is the companies office itself. If the working area is too small then employees ~~will~~ ^{will} feel cramped & reluctant to do their job. Once again management might want to consider a new location.

Technical issues relate to the amount of technology, ~~that~~ ^{electrical,} internet ~~is~~ ^{availability} ~~available~~ ^{or} power that is available at the new site. A common technical issue is electrical supply. If there aren't enough power points to plug in all the ~~electronic~~ ^{electronic} ~~equipment~~ devices ie computers ~~then~~ ^{then} productivity & efficiency will be reduced. Another technical problem is internet availability. In some areas, such as rural, there aren't any land lines where ~~internet~~ ^{internet} can be hooked up into. This causes the problem of not being ~~up~~ ^{able} to set up a network in the office & will require specialists to either fix the problem or set up a wireless network which

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cost time & money. The final technical issue is the availability of technology. In the new site the office may be too big resulting in more computers needed which means ~~the~~ expensive ~~programs~~ ^{programs} like AutoCAD will need to be re-bought. Technical issues can be "very expensive to fix ~~but~~ ^{& can significantly} ~~it~~ ^{it} ~~is~~ ^{it} ~~may~~ ^{may} effect the productivity at a new site which once again cost the company more money.

The final issues that arise when considering a relocation are personal issues such as the size of the workforce, the training of the workforce & the attitude of the workforce towards moving. When a company expands it is common that they will need to increase the size of their workforce. Expanding personnel can cost a lot of time & money due to ~~time~~ ^{having} ~~to~~ ^{to} finding the right people to hire. It is important that management considers the amount of personnel the future company will need to continue to gain profit. Training the new workforce ~~is~~ ^{is} also a relevant issue that takes time & money for example training employees to use AutoCAD can take a lot of time & money & is a common issue in an expanding Architectural firm. A workers attitudes to the move or expansion is also an important consideration. Due to the company expanding they may have to 'cutback' on wages for a little while. This cutback can instigate a negative response in workers as most have families to provide for.

A common solution

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EXAMINATION
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Examination

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To personal issue it is to train employees to become multi-skilled. By an employee becoming multi-skilled they are able to cover for ad absent workers or do two jobs at once at a new location. ~~Any~~ Another factor that contributes to an employee's attitude towards re-locating is the location of the new ~~exp~~ office / worksite. If a company is relocated further away from an employees home they could respond negatively. It is important that management appeals to all workers or as many as possible when considering expansion or relocation.

It is important for company's to gain profit & continue to improve their services but it is even more important for the management inside the company to address each issues that arises before making a decision.

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