



Notice of variation and consolidation with introductory note

The Environmental Permitting (England & Wales) Regulations 2010

Oakthorpe Dairy
Chequers Way
Palmers Green
London
N13 6DA

Variation application number

EPR/BN0465IG/V003

Permit number

EPR/BN0465IG

Oakthorpe Dairy

Permit number EPR/BN0465IG

Introductory note

This introductory note does not form a part of the notice.

Under the Environmental Permitting (England & Wales) Regulations 2010 (schedule 5, part 1, paragraph 19) a variation may comprise a consolidated permit reflecting the variations and a notice specifying the variations included in that consolidated permit.

Schedule 1 of the notice specifies the conditions that have been varied and schedule 2 comprises a consolidated permit which reflects the variations being made.

The site covers an area of 8.5 hectares and is predominantly covered by buildings and concrete hardstanding. The roughly rectangular shaped site is located in an urban area in North London. The southern and eastern boundaries of the site are formed by Pymmes Brook, beyond which is a school and residential properties to the south and playing fields to the east. The western boundary of the site is formed by Chequers Way, beyond which are residential properties. The northern boundary of the site is formed by the fence line of residential properties.

There are no Areas of Outstanding Natural Beauty or Environmentally sensitive receptors which could be affected by the Installation. The nearest is Walthamstow Reservoirs, 3.6km from the Installation.

The dairy receives approximately 300 million litres of raw milk per year from farms by dedicated road tanker. The milk is unloaded in the milk reception area located at the western end of the main building and pumped into storage silos ready for processing. The raw milk is then processed and pasteurised, cooled and then transferred to the finished milk silos. The steam required for these processes is raised by three natural gas fuelled boilers. Products comprise of skimmed milk, semi-skimmed milk, full cream milk and cream which is packaged on site and delivered to stores or distributed to other sites for further processing. The finished milk and cream is packaged into plastic containers that are blow moulded in an on-site facility. This blow moulding facility is outside the scope of the PPC permit application. The packaged milk and cream is then loaded onto heavy goods vehicles for distribution to regional distribution centres or direct to the customer. Refuelling facilities are available on-site for the distribution vehicles and comprises of two above ground storage tanks containing red and white diesel, connected to distribution pumps (red diesel is used in the refrigeration units on the HGVs).) A reverse osmosis plant recovers milk from rise water.

Emissions to air comprise combustion products from the boiler operation, discharged via a single stack. There are three boilers in use, all fired on an uninterruptible natural gas supply, with a combined thermal input of 7.85MW.

The drainage network onsite is divided into two categories: surface water drainage and combined process effluent and foul water. Surface water runoff is discharged to Pymmes Brook and process effluent is discharged to the public sewerage system under a trade effluent discharge consent issued by Thames Water Utilities Ltd (Ref: TDEE0501

The installation is party to an underlying climate change levy agreement – facility number DIF/043/01.

This variation permits the installation and operation of a Physico-Chemical Effluent treatment plant using DAF (dissolved air flotation) technology under Section 5.4 A(1)(a)(ii) of the EPR regulations. The sites general effluent currently discharges into the public sewer for treatment by Thames Water at the local sewage treatment works (STW). The operator has had difficulty in meeting the restrictions of the discharge consent issued for the site by Thames Water for chemical oxygen demand (COD) and fats oil and grease (FOG) and this plant represents a significant upgrade to the operational process allowing discharge consent limits to be met. The plant will have a maximum treatment capacity of 1,100m³/day.

This variation also incorporates the changes required by the Industrial Emissions Directive. This includes the amendment of the wording of several permit conditions relating to notifications, and also includes the addition of a condition relating to a requirement for monitoring of groundwater and soil.

The schedules specify the changes made to the permit.

The status log of a permit sets out the permitting history, including any changes to the permit reference number.

Status log of the permit		
Description	Date	Comments
Application received EPR/BN0465IG	Received 29/03/05	
Permit determined EPR/BN0465IG	06/03/06	Permit issued to Arla Foods Limited.
Application EPR/BN0465IG/V002 (variation)	Duly made 01/02/10	Variation to include a reverse osmosis plant and installation boundary extension.
Further Information received	01/02/10	Revised Site Plan
Variation determined EPR/BN0465IG (Billing ref: AP3431KM)	17/02/10	Varied permit issued.
Application EPR/BN0465IG/V003 (variation and consolidation)	Duly made 07/07/15	Application to vary the permit to include a new effluent treatment plant.
Response to Schedule 5 request for further information	28/09/15	Site condition report clarifications, revised pollution risk assessment and management plan, revised noise/vibration managing plan, effluent and odour monitoring and abnormal operating conditions and action plan.
E-mail providing further information.	05/10/15	Confirmation of odour emission points to air, emission points to sewer and in process monitoring.
Response to Schedule 5 request for further information	27/10/15	Confirmation and comparison of installed equipment and noise abatement control measures against original BS4142:2104 impact assessment, together with updated NVMP tables.
Variation determined EPR/BN0465IG (Billing ref: QP3234NB)	19/11/2015	Varied and consolidated permit issued.

End of introductory note

Notice of variation and consolidation

The Environmental Permitting (England and Wales) Regulations 2010

The Environment Agency in exercise of its powers under regulation 20 of the Environmental Permitting (England and Wales) Regulations 2010 varies and consolidates

Permit number

EPR/BN0465IG

Issued to

Arla Foods Limited (“the operator”)

whose registered office is

**4 Savannah Way
Leeds Valley Park
Leeds
LS10 1AB**

company registration number 02143253

to operate a regulated facility at

**Oakthorpe Dairy
Chequers Way
Palmers Green
London
N13 6DA**

to the extent set out in the schedules.

The notice shall take effect from 19/11/2015

Name	Date
J Linton	19/11/2015

Authorised on behalf of the Environment Agency

Schedule 1

The following conditions were varied as a result of an Environment Agency initiated variation to reflect the new requirements of the Environmental Permitting Regulations introduced by the Industrial Emissions Directive.

2.10.4 (IED condition requirement)

5.1.1 (IED Condition requirement)

5.1.2 (IED Condition requirement)

6.1.1 (Add IED interpretation)

Schedule 1 (Updated reporting Form)

The following conditions were varied as a result of the application made by the operator:

1.2.1 (Amended to exclude area not covered by the extent of the installation)

2.2.6.1 (Amended to include modern odour condition wording)

Table 1.1.1 (Amend permitted activities table to include new Schedule 1 activity)

Table 1.4.1 (Amend Improvement Programme table to show completed and include IP5)

Table 2.1.1 (Amend Operating techniques to include variation)

Table 2.2.1 (Amend to include odour emission point)

Table 2.2.7 (Amend emission point reference and add additional monitoring)

Table S2 (Amend emission point references)

Table 2.10.1 (Amend emission point reference and add monitoring requirements)

Table S3 (Amend date/version of PI reporting Form)

Table S4.2 (Amended to include fate and route of precipitated waste from the effluent treatment plant)

6.1.1 (Amend 'Daily' and 'Weekly' interpretation)

The following conditions were added as a result of the application made by the operator:

2.2.6.2 (Second part of new odour condition wording)

Schedule 2 – consolidated permit

Consolidated permit issued as a separate document.

Permit

The Environmental Permitting (England and Wales) Regulations 2010

Permit number

EPR/BN0465IG

This is the consolidated permit referred to in the variation and consolidation notice for application EPR/BN0465IG/V003 authorising,

Arla Foods Limited (“the operator”),

whose registered office is

**4 Savannah Way
Leeds Valley Park
Leeds
LS10 1AB**

company registration number 02143253

to operate an installation at

**Oakthorpe Dairy
Chequers Way
Palmers Green
London
N13 6DA**

to the extent authorised by and subject to the conditions of this permit.

Name	Date
J Linton	19/11/2015

Authorised on behalf of the Environment Agency

Conditions

1 General

1.1 Permitted activities

1.1.1 The Operator is authorised to carry out the activities and the associated activities specified in Table 1.1.1.

Table 1.1.1 Permitted activities		
Activity listed in Schedule 1 of the PPC Regulations / Associated Activity	Description of specified activity	Limits of specified activity
6.8 Part A(1)(e) Treating and processing milk, the quantity of milk received being more than 200 tonnes per day.	Milk Processing. Treating and Processing Milk	From receipt of raw materials to the despatch of finished product.
Section 5.4 Part A (1) (a) (ii) Disposal of non-hazardous waste with a capacity exceeding 50 tonnes per day involving physico-chemical treatment, and excluding activities covered by Council Directive 91/271/EEC concerning urban waste-water treatment	Primary effluent treatment D9 Physico-chemical treatment resulting in final compounds or mixtures which are discarded by any of the operations numbered D1 to D12	From the receipt of effluent generated on site to the treatment on site in a DAF plant followed by the discharge of treated effluent to sewer.
Unlisted Directly Associated Activity	Steam and Heat Generation	From the three steam raising boilers to supply steam to the production processing lines
Unlisted Directly Associated Activity	Refrigeration	Receipt and storage of raw materials and products
Unlisted Directly Associated Activity	Waste Management	Storage of process wastes
Unlisted Directly Associated Activity	Filtration of milk rinse effluent	Filtration of milk rinse effluent in a reverse osmosis unit and holding rinse effluent in a balancing tank.
Unlisted Directly Associated Activity	Precipitated waste storage	Temporary storage of precipitated DAF waste solids pending removal off site.

1.2 Site

1.2.1 The activities authorised under condition 1.1.1 shall not extend beyond the Site, being the land shown edged in green on the Site Plan at Schedule 5 to this Permit, excluding the area edged in red on the site plan that represents the edge of the extent of the installation covered by this permit.

1.3 Overarching management condition

- 1.3.1 Without prejudice to the other conditions of this Permit, the Operator shall implement and maintain a management system, organisational structure and allocate resources that are sufficient to achieve compliance with the limits and conditions of this Permit.

1.4 Improvement programme

- 1.4.1 The Operator shall complete the improvements specified in Table 1.4.1 by the date specified in that table, and shall send written notification of the date of completion of each requirement to the Agency within 14 days of the completion of each such requirement.

Table 1.4.1: Improvement programme

Reference	Requirement	Date
1	<p>The Operator shall submit a written report to the Agency assessing the feasibility of methods to reduce chemical oxygen demand (COD) emissions from the installation. The assessment shall include, but not be limited to:</p> <p>A study into the use of membrane technology to remove waste and recycle water,</p> <p>A review of treatment options available along with their associated benefits.</p>	06/01/07
2	<p>The Operator shall implement secondary containment measures for the storage of antifreeze and lubrication oil. The Operator shall inform the Agency in writing of the measures undertaken.</p>	06/03/07
3	<p>The Operator shall investigate options for preventing or minimising noise emitted from the Installation, having regard to Section 2.9 of the Agency Guidance Note IPPC S6.13. The investigation shall pay particular attention to HGV movements around the site.</p> <p>A written report shall be submitted to the Agency for approval detailing the options available, the preferred option and timetable for implementation of any work.</p>	06/11/06
4	<p>The Operator shall propose, in writing to the Environment Agency, a monitoring and reporting programme to demonstrate the effectiveness of the reverse osmosis plant. The proposal shall identify the parameters to be monitored, the period of the monitoring, and arrangements for reporting monitoring results as well as reporting on the end uses of the recovered milk, in order to demonstrate that these end uses are as high up the waste hierarchy as practicable. On receiving written acceptance of these proposals from the Environment Agency, the Operator shall undertake the monitoring programme and report results as agreed in writing with the Environment Agency.</p>	Propose monitoring and reporting programme 25/03/10
5	<p>The operator shall ensure that a review of the design, construction and integrity of the sites secondary and tertiary containment is carried out by a qualified structural engineer. The review shall compare the sites constructed secondary containment and catchment areas against the standards set out in CIRIA C736 - Containment Systems for the Prevention of Pollution - secondary, tertiary and other measures for industrial and commercial premises.</p> <p>The review shall include but not be limited to:</p> <ul style="list-style-type: none"> - design specification including calculations, suitability and integrity of the sites secondary and tertiary containment - movement of liquid over the surface of the site in accordance with site topography and identification of at risk areas such as permeable land/water courses that could be impacted by containment loss. - the suitability for providing containment and protection of controlled waters when subjected to the dynamic and static loads caused by catastrophic tank failure; - any work required to ensure compliance with the standards set out in CIRIA C736. <p>A written report of the review shall be submitted to the Environment Agency for approval detailing the review's findings and recommendations including a timetable to implement any measures identified.</p> <p>The notification requirements of condition 1.4.1 will be deemed to have been complied with on submission of the assessment.</p>	25/03/16

6 Submit a report to the Environment Agency for approval. The report must contain a review of spill prevention, containment and incident response procedures for the protection of controlled waters in accordance with Environment Agency PPG21 and PPG22 guidance. The report must contain dates for the implementation of individual measures. 27/06/16

The notification requirements of condition 1.4.1 will be deemed to have been complied with on submission of the plan.

You must implement the plan as approved, and from the date stipulated by the Environment Agency.

7 Submit a written report to the Environment Agency for approval. The report must contain a mass balance of the process and process losses and the results of a review of operating techniques and systems employed identifying high product loss areas. The report must contain dates for the implementation of individual measures to reduce product loss where identified. 23/09/16

The notification requirements of condition 1.4.1 will be deemed to have been complied with on submission of the plan.

You must implement the plan as approved, and from the date stipulated by the Environment Agency.

1.4.2 Where the Operator fails to comply with any requirement by the date specified in Table 1.4.1 the Operator shall send written notification of such failure to the Agency within 14 days of such date.

1.5 Minor operational changes

1.5.1 The Operator shall seek the Agency's written agreement to any minor operational changes under condition 2.1.1 of this Permit by sending to the Agency: written notice of the details of the proposed change including an assessment of its possible effects (including waste production) on risks to the environment from the Permitted Installation; any relevant supporting assessments and drawings; and the proposed implementation date.

1.5.2 Any such change shall not be implemented until agreed in writing by the Agency. As from the agreed implementation date, the Operator shall operate the Permitted Installation in accordance with that change, and relevant provisions in the Application shall be deemed to be amended.

1.5.3 When the qualification "unless otherwise agreed in writing" is used elsewhere in this Permit, the Operator shall seek such agreement by sending to the Agency written notice of the details of the proposed method(s) or techniques.

1.5.4 Any such method(s) or techniques shall not be implemented until agreed in writing by the Agency. As from the agreed implementation date, the Operator shall operate the Permitted Installation using that method or technique, and relevant provisions in the Application and the Site Protection and Monitoring Programme, as the case may be shall be deemed to be amended.

1.6 Pre-operational conditions

1.6.1 There are no pre-operational conditions

1.7 Off-site conditions

1.7.1 There are no off-site conditions

2 Operating conditions

2.1 In-process Controls

- 2.1.1 The Permitted Installation shall, subject to the conditions of this Permit, be operated using the techniques and in the manner described in the documentation specified in Table 2.1.1, or as otherwise agreed in writing by the Agency in accordance with conditions 1.5.1 and 1.5.2 of this Permit.

Table 2.1.1: Operating techniques		
Description	Parts	Date received
Application	The response to questions 2.2 of the Application, as detailed in sections 2.2.1 to 2.2.6 (emissions control), 2.3 (management) 2.5 (waste handling) 2.8 (accidents) of the application, Enclosure A (Site Drawings) and enclosure C ("Oakthorpe Technical Descriptions").	29 th March 2005
Variation application AP3431KM	Sections 1 (variation description), Section 2 (substantial change criteria), Sections 3-5 (Application Forms) and Section 6 (H1 Pollution risk assessment and management plan).	15/01/10
Variation Application EPR/BN0465IG/V003	The response to questions in section 3, form EPC – Part C3 of the application form and Sections 6, 7, 8, 9 and 15 of the application document.	02/06/15
Response to Schedule 5 request for further information dated 08/09/15	Response to questions 4, 5, 6.1, 6.2, 6.3 and 7.	13/10/15
E-mail containing further information 08/09/15	Confirmation of odour emission points to air, emission points to sewer and In process monitoring.	05/10/15
Response to Schedule 5 request for further information dated 15/10/15	Amended BS4142:2014 noise risk assessment MDS/8370/1123/02 dated 23/09/15, updated NVMP tables Doc ref: 5401-004 issue 4 and confirmation of installed plant/equipment.	27/10/15

- 2.1.2 The Permitted Installation shall, subject to the other conditions of this Permit, be operated using the techniques and in the manner described in the Site Protection and Monitoring Programme submitted under condition 4.1.7 of this Permit (as amended from time to time under condition 4.1.7), or as otherwise agreed in writing by the Agency.

2.2 Emissions

2.2.1 Emissions to air, (including heat, but excluding odour, noise or vibration) from specified points

2.2.1.1 This Part 2.2.1 of this Permit shall not apply to releases of odour, noise or vibration.

2.2.1.2 Emissions to air from the emission points in Table 2.2.1 shall only arise from the source(s) specified in that Table.

Table 2.2.1 : Emission points to air

Emission point reference or description	Source	Location of emission point
A1	Steam raising boiler	A1 on the 'site emission points' plan. Ref: Enclosure A:4 to the application refers
A2	Steam raising boiler	A2 on the 'site emission points' plan. Ref: Enclosure A:4 to the application refers
A3	Steam raising boiler	A3 on the 'site emission points' plan. Ref: Enclosure A:4 to the application refers
A27	Odour Abatement Exhaust (Post double carbon filters)	Point A27 on plan drawing 000-084 dated 01/05/2015 (EPR/QP3234NB/V003)
Bin enclosure – Effluent screen.	Single air displacement carbon filter.	Enclosed bin fed from the effluent screen process.

2.2.1.3 No condition applies.

2.2.1.4 No condition applies.

2.2.2 Emissions to water (other than groundwater), including heat, from specified points

2.2.2.1 This Part 2.2.2 of this Permit shall not apply to releases of odour, noise or vibration or to releases to groundwater.

2.2.2.2 Conditions 2.2.2.3 - 2.2.2.6 shall not apply to emissions to sewer.

2.2.2.3 Emissions to water from the emission point(s) specified in Table 2.2.4 shall only arise from the source(s) specified in that Table

Table 2.2.4: Emission point to water

Emission point reference or description	Source	Receiving water
S1: Ref: Enclosure A:4 'site emissions points' appended to the application refers	Uncontaminated surface water from site roofs and surfaces.	Pymmes Brook
S2: Ref: Enclosure A:4 'site emissions points' appended to the application refers	Uncontaminated surface water from site roofs and surfaces.	Pymmes Brook

2.2.2.4 No condition applies.

2.2.2.5 No condition applies.

2.2.2.6 No condition applies.

Emissions to sewer

2.2.2.7 Emissions to sewer from the specified emission points in Table 2.2.7 shall only arise from the source(s) specified in that Table.

Table 2.2.7 Emission points to sewer

Emission point reference or description	Source	Sewer
Point E2 as shown on plan drawing 000-084 dated 01/05/2015 (EPR/QP3234NBV003)	Discharge of all sites process effluent	Deephams Sewerage Treatment Works

2.2.3 Emissions to groundwater

2.2.3.1 No emission from the Permitted Installation shall give rise to the introduction into groundwater of any substance in List I (as defined in the Groundwater Regulations 1998 (S.I. 1998 No. 2746)).

2.2.3.2 No emission from within the Permitted Installation shall give rise to the introduction into groundwater of any substance in List II (as defined in the Groundwater Regulations 1998 (S.I. 1998 No. 2746)) so as to cause pollution (as defined in the Groundwater Regulations 1998 (S.I. 1998 No. 2746)).

2.2.3.3 For substances other than those in List I or II (as defined in the Groundwater Regulations 1998 (SI 1998 No.2746)), the Operator shall use BAT to prevent or where that is not practicable to reduce emissions to groundwater from the Permitted Installation provided always that the techniques used by the Operator shall be no less effective than those described in the Application.

2.2.4 Fugitive emissions of substances to air

2.2.4.1 The Operator shall use BAT so as to prevent or where that is not practicable to reduce fugitive emissions of substances to air from the Permitted Installation in particular from:

- storage areas
- buildings
- pipes, valves and other transfer systems
- open surfaces

provided always that the techniques used by the Operator shall be no less effective than those described in the Application, where relevant.

2.2.5 Fugitive emissions of substances to water and sewer

2.2.5.1 Subject to condition 2.2.5.2 below, the Operator shall use BAT so as to prevent or where that is not practicable to reduce fugitive emissions of substances to water (other than Groundwater) and sewer from the Permitted Installation in particular from:

- all structures under or over ground

- surfacing
- bunding
- storage areas

provided always that the techniques used by the Operator shall be no less effective than those described in the Application, where relevant.

2.2.5.2 There shall be no release to water that would cause a breach of an EQS established by the UK Government to implement the Dangerous Substances Directive 76/464/EEC.

2.2.6 Odour

2.2.6.1 Emissions from the activities shall be free from odour at levels likely to cause pollution outside the site, as perceived by an authorised officer of the Environment Agency, unless the operator has used appropriate measures, including, but not limited to, those specified in any approved odour management plan, to prevent or where that is not practicable to minimise the odour.

2.2.6.2 The operator shall:

- (a) if notified by the Environment Agency that the activities are giving rise to pollution outside the site due to odour, submit to the Environment Agency for approval within the period specified, an odour management plan which identifies and minimises the risks of pollution from odour;
- (b) implement the approved odour management plan, from the date of approval, unless otherwise agreed in writing by the Environment Agency.

2.2.7 Emissions to land

2.2.7.1 This Part 2.2.7 of this Permit shall not apply to emissions to groundwater.

2.2.7.2 No emission from the Permitted installation shall be made to land.

2.2.7.3 No condition applies

2.3 Management

2.3.1 A copy of this Permit and those parts of the application referred to in this Permit shall be available, at all times, for reference by all staff carrying out work subject to the requirements of the Permit.

Training

2.3.2 The Permitted Installation shall be supervised by staff who are suitably trained and fully conversant with the requirements of this Permit.

2.3.3 All staff shall be fully conversant with those aspects of the Permit conditions which are relevant to their duties and shall be provided with adequate professional technical development and training and written operating instructions to enable them to carry out their duties.

2.3.4 The Operator shall maintain a record of the skills and training requirements for all staff whose tasks in relation to the Permitted Installation may have an impact on the environment and shall keep records of all relevant training.

Maintenance

2.3.5 All plant and equipment used in operating the Permitted Installation, the failure of which could lead to an adverse impact on the environment, shall be maintained in good operating condition.

2.3.6 The Operator shall maintain a record of relevant plant and equipment covered by condition 2.3.5 and for such plant and equipment:

2.3.6.1 a written or electronic maintenance programme; and

2.3.6.2 records of its maintenance.

Incidents and complaints

2.3.7 The Operator shall maintain and implement written procedures for:

2.3.7.1 taking prompt remedial action, investigating and reporting actual or potential non-compliance with operating procedures or emission limits; and

2.3.7.2 investigating incidents, (including any malfunction, breakdown or failure of plant, equipment or techniques, down time, any short term and long term remedial measures and near misses) and prompt implementation of appropriate actions; and

2.3.7.3 ensuring that detailed records are made of all such actions and investigations.

2.3.8 The Operator shall record and investigate complaints concerning the Permitted Installation's effects or alleged effects on the environment. The record shall give the date and nature of complaint, time of complaint, name of complainant (if given), a summary of any investigation and the results of such investigation and any actions taken.

2.4 Efficient use of raw materials

2.4.1 The Operator shall -

2.4.1.1 maintain the raw materials table or description submitted in Section 2.4 of the Application and in particular consider on a periodic basis whether there are suitable alternative materials to reduce environmental impact;

2.4.1.2 carry out periodic waste minimisation audits and water use efficiency audits. If such an audit has not been carried out in the 2 years prior to the issue of this Permit, then the first such audit shall take place within 2 years of its issue. The methodology used and an action plan for increasing the efficiency of the use of raw materials or water shall be submitted to the Agency within 2 months of completion of each such audit and a review of the audit and a description of progress made against the action plan shall be submitted to the Agency at least every 4 years thereafter; and

2.4.1.3 ensure that incoming water use is directly measured and recorded.

2.5 Waste Storage and Handling

2.5.1 The Operator shall design, maintain and operate all facilities for the storage and handling of waste on the Permitted installation such that there are no releases to water or land during normal operation and that emissions to air and the risk of accidental release to water or land are minimised.

2.6 Waste recovery or disposal

2.6.1 Waste produced at the Permitted Installation shall be:

2.6.1.1 recovered to no lesser extent than described in the Application; and

2.6.1.2 Where not recovered, disposed of while avoiding or reducing any impacts on the environment provided always that this is not done in any way that would have a greater effect on the environment than that described in the Application.

2.6.2 The Operator shall maintain the waste recovery or disposal table or description submitted in Section 2.6 of the Application and in particular review the available options for waste recovery and disposal for the purposes of complying with condition 2.6.1 above.

2.6.3 The Operator shall maintain and implement a system which ensures that a record is made of the quantity, composition, origin, destination (including whether this is a recovery or disposal operation) and where relevant removal date of any waste that is produced at the Permitted Installation.

2.7 Energy efficiency

2.7.1 The Operator shall produce a report on the energy consumed at the Permitted Installation over the previous calendar year, by 31 January each year, providing the information required by condition 4.1.2.

2.7.2 The Operator shall maintain and update annually an energy management system which shall include, in particular, the monitoring of energy flows and targeting of areas for improving energy efficiency.

2.7.3 The Operator shall design, maintain and operate the Permitted Installation so as to secure energy efficiency, taking into account relevant guidance including the Agency's Energy Efficiency Horizontal Guidance Note as from time to time amended. Energy efficiency shall be secured in particular by:

- ensuring that the appropriate operating and maintenance systems are in place;
- ensuring that all plant is adequately insulated to minimise energy loss or gain;
- ensuring that all appropriate containment methods, (e.g. seals and self-closing doors) are employed and maintained to minimise energy loss;
- employing appropriate basic controls, such as simple sensors and timers, to avoid unnecessary discharge of heated water or air;
- where building services constitute more than 5% of the total energy consumption of the Permitted Installation, identifying and employing the appropriate energy efficiency techniques for building services, having regard in particular to the Building services part of the Agency's Energy Efficiency Horizontal Guidance Note H2; and

maintaining and implementing an energy efficiency plan which identifies energy saving techniques that are applicable to the activities and their associated environmental benefit and prioritises them, having regard to the appraisal method in the Agency's Energy Efficiency Horizontal Guidance Note H2.

2.8 Accident prevention and control

2.8.1 The Operator shall maintain and implement when necessary the accident management plan submitted or described in Section 2.8 of the Application. The plan shall be reviewed at least every 2 years or as soon as practicable after an accident, whichever is the earlier, and the Agency notified of the results of the review within 2 months of its completion.

2.9 Noise and vibration

2.9.1 The Operator shall use BAT so as to prevent or where that is not practicable to reduce emissions of noise and vibration from the Permitted Installation, in particular by:

- equipment maintenance, eg. of fans, pumps, motors, conveyors and mobile plant;
- use and maintenance of appropriate attenuation, eg. silencers, barriers, enclosures;
- timing and location of noisy activities and vehicle movements;
- periodic checking of noise emissions, either qualitatively or quantitatively; and
- maintenance of building fabric,

provided always that the techniques used by the Operator shall be no less effective than those described in the Application, where relevant.

2.10 On-site monitoring

2.10.1 No condition applies.

2.10.2 The Operator shall carry out environmental or other specified substance monitoring to the frequencies and methods described in Table 2.10.1

Table 2.10.1 : Other monitoring requirements

Emission point reference or source or description of point of measurement	Substance or parameter	Monitoring frequency	Monitoring method	Other specifications
Point E2 as shown on plan drawing 000-084 dated 01/05/2015 (EPR/QP3234NB/V/003)	Chemical Oxygen Demand (mg/m ³)	Quarterly	Oxidation with dichromate (ISO 6060:1989)	UKAS accredited laboratory testing
	Chemical Oxygen Demand (mg/m ³)	Daily	As agreed in writing with the Environment Agency	As agreed in writing with the Environment Agency
	Total effluent flow (m ³)	Quarterly	Continuous flow meter	MCERTS
	Total Phosphorus	Monthly	BS EN ISO 11885:2009	UKAS accredited laboratory testing
	Sulphide	Monthly	As agreed in writing with the Environment Agency	UKAS accredited laboratory testing
	Colour	Daily	Visual	As agreed in writing with the Environment Agency
	Temperature	Continuous	-	-

- 2.10.3 No condition applies.
- 2.10.4 Periodic monitoring shall be carried out at least once every 5 years for groundwater and 10 years for soil, unless such monitoring is based on a systematic appraisal of the risk of contamination.
- 2.10.5 The Operator shall notify the Agency at least 14 days in advance of undertaking monitoring and/ or spot sampling, where such notification has been requested in writing by the Agency.
- 2.10.6 The Operator shall maintain records of all monitoring taken or carried out (this includes records of the taking and analysis of samples instrument measurements (periodic and continual), calibrations, examinations, tests and surveys) and any assessment or evaluation made on the basis of such data.
- 2.10.7 Monitoring equipment, techniques, personnel and organisations employed for the emissions monitoring specified in condition 2.10.2 shall have either MCERTS certification or MCERTS accreditation (as appropriate) unless otherwise agreed in writing.
- 2.10.8 There shall be provided:
- 2.10.8.1 safe and permanent means of access to enable sampling/monitoring to be carried out in relation to the emission points specified in Schedule 2 to this Permit, unless otherwise specified in that Schedule; and
 - 2.10.8.2 safe means of access to other sampling/monitoring points when required by the Agency.
- 2.10.9 The Operator shall carry out the on-going monitoring identified in the Site Protection and Monitoring Programme submitted under condition 4.1.7, unless otherwise agreed in writing by the Agency.
- 2.10.10 The Operator shall, within 6 months of the issue of this Permit, in accordance with and using the format given in the Land Protection Guidance:
- 2.10.10.1 collect the site reference data identified in the Site Protection and Monitoring Programme submitted under condition 4.1.7, and
 - 2.10.10.2 report that site reference data to the Agency,
 - unless otherwise agreed in writing by the Agency.

2.11 Closure and decommissioning

- 2.11.1 The Operator shall maintain and operate the Permitted Installation so as to prevent or minimise any pollution risk, including the generation of waste, on closure and decommissioning in particular by:-
- 2.11.1.1 attention to the design of new plant or equipment;
 - 2.11.1.2 the maintenance of a record of any events which have, or might have, impacted on the condition of the site along with any further investigation or remediation work carried out; and
 - 2.11.1.3 the maintenance of a site closure plan to demonstrate that the Permitted Installation can be decommissioned avoiding any pollution risk and returning the site of operation to a satisfactory state.
- 2.11.2 Notwithstanding condition 2.11.1 of this Permit, the Operator shall carry out a full review of the Site Closure Plan at least every 4 years.
- 2.11.3 The site closure plan shall be implemented on final cessation or decommissioning of the Permitted activities or part thereof.
- 2.11.4 The Operator shall give at least 30 days written notice to the Agency before implementing the site closure plan.

2.12 Multiple operator installations

- 2.12.1 This is not a multi-operator installation

2.13 Transfer to effluent treatment plant

2.13.1 No transfer from the Permitted Installation shall be made to effluent treatment plant.

3 Records

- 3.1 The Operator shall ensure that all records required to be made by this Permit and any other records made by it in relation to the operation of the Permitted Installation shall:-
- 3.1.1 be made available for inspection by the Agency at any reasonable time;
 - 3.1.2 be supplied to the Agency on demand and without charge;
 - 3.1.3 be legible;
 - 3.1.4 be made as soon as reasonably practicable;
 - 3.1.5 indicate any amendments which have been made and shall include the original record wherever possible;
 - 3.1.6 be retained at the Permitted Installation, or other location agreed by the Agency in writing, for a minimum period of 4 years from the date when the records were made, unless otherwise agreed in writing; and
 - 3.1.7 where they concern the condition of the site of the Installation or are related to the implementation of the Site Protection and Monitoring Programme, be kept at the Permitted Installation, or other location agreed by the Agency in writing, until all parts of the Permit have been surrendered.

4 Reporting

- 4.1.1 All reports and written and or oral notifications required by this Permit and notifications required by Regulation 16 of the PPC Regulations shall be made or sent to the Agency using the contact details notified in writing to the Operator by the Agency.
- 4.1.2 The Operator shall, unless otherwise agreed in writing, submit reports of the monitoring and assessment carried out in accordance with the conditions of this permit, as follows:-
- 4.1.2.1 in respect of the parameters and emission points specified in Table S2 to Schedule 2;
 - 4.1.2.2 for the reporting periods specified in Table S2 to Schedule 2 and using the forms specified in Table S3 to Schedule 3;
 - 4.1.2.3 giving the information from such results and assessments as may be required by the forms specified in those Tables; and
 - 4.1.2.4 to the Agency within 28 days of the end of the reporting period.
- 4.1.3 The Operator shall submit to the Agency a report on the performance of the Permitted Installation over the previous year, by 31 January each year, providing the information listed in Tables S4.1 and S4.2 of Schedule 4, assessed at any frequency specified therein, and using the form specified in Table S3 to Schedule 3.
- 4.1.4 The Operator shall review fugitive emissions, having regard to the application of Best Available Techniques, on an annual basis, or such other period as shall be agreed in writing by the Agency, and a summary report on this review shall be sent to the Agency detailing such releases and the measures taken to reduce them within 3 months of the end of such period.
- 4.1.5 Where the Operator has a formal environmental management system applying to the Permitted Installation which encompasses annual improvement targets the Operator shall, not later than 31 January in each year, provide a summary report of the previous year's progress against such targets.
- 4.1.6 The Operator shall, within 6 months of receipt of written notice from the Agency, submit to the Agency a report assessing whether all appropriate preventive measures continue to be taken against pollution, in particular through the application of the best available techniques, at the installation. The report shall consider any relevant published technical guidance current at the time of the notice which is either supplied with or referred to in the notice, and shall assess the costs and benefits of applying techniques described in that guidance, or otherwise identified by the Operator, that may provide environmental improvement.
- 4.1.7 The Operator shall, within two months of the date of this permit, submit a detailed Site Protection and Monitoring Programme, in accordance with and using the appropriate template format given in the Land Protection Guidance. The Operator shall implement and maintain the Site Protection and Monitoring Programme (SPMP) submitted under this condition, and shall carry out regular reviews of it at a minimum frequency of every 2 years. The results of such reviews and any changes made to the SPMP shall be reported to the Agency within 1 month of the review or change.

5 Notifications

5.1.1 In the event:

- (a) that the operation of the activities gives rise to an incident or accident which significantly affects or may significantly affect the environment, the operator must immediately—
 - (i) inform the Environment Agency,
 - (ii) take the measures necessary to limit the environmental consequences of such an incident or accident, and
 - (iii) take the measures necessary to prevent further possible incidents or accidents;
- (b) of a breach of any permit condition the operator must immediately—
 - (i) inform the Environment Agency, and
 - (ii) take the measures necessary to ensure that compliance is restored within the shortest possible time;
- (c) of a breach of permit condition which poses an immediate danger to human health or threatens to cause an immediate significant adverse effect on the environment, the operator must immediately suspend the operation of the activities or the relevant part of it until compliance with the permit conditions has been restored.

5.1.2 Any information provided under condition 5.1.1 (a)(i) or 5.1.1 (b)(i) shall be confirmed by sending the information listed in schedule 1 to this permit within the time period specified in that schedule.

5.1.3 The Operator shall give written notification as soon as practicable prior to any of the following:-

5.1.3.1 permanent cessation of the operation of part or all of the Permitted Installation;

5.1.3.2 cessation of operation of part or all of the Permitted Installation for a period likely to exceed 1 year; and

5.1.3.3 resumption of the operation of part or all of the Permitted Installation after a cessation notified under condition 5.1.3.2.

5.1.4 The Operator shall notify the Agency, as soon as reasonably practicable, of any information concerning the state of the Site which adds to that provided to the Agency as part of the Application or to that in the Site Protection and Monitoring Programme submitted under condition 4.1.7 of this Permit.

5.1.5 The Operator shall notify the following matters to the Agency in writing within 14 days of their occurrence:-

5.1.5.1 where the Operator is a registered company:-

- any change in the Operator's trading name, registered name or registered office address;
- any change to particulars of the Operator's ultimate holding company (including details of an ultimate holding company where an Operator has become a subsidiary)
- any steps taken with a view to the Operator going into administration, entering into a company voluntary arrangement or being wound up;

5.1.5.2 where the Operator is a corporate body other than a registered company:

- any change in the Operator's name or address;
- any steps taken with a view to the dissolution of the Operator.

5.1.5.3 In any other case: -

- the death of any of the named Operators (where the Operator consists of more than one named individual);
- any change in the Operator's name(s) or address(es);
- any steps taken with a view to the Operator, or any one of them, going into bankruptcy, entering into a composition or arrangement with creditors, or, in the case them being in a partnership, dissolving the partnership;

5.1.6 Where the Operator has entered into a Climate Change Agreement with the Government, the Operator shall notify the Agency within one month of:-

- 5.1.6.1 a decision by the Secretary of State not to re-certify that Agreement.
 - 5.1.6.2 a decision by either the Operator or the Secretary of State to terminate that agreement.
 - 5.1.6.3 any subsequent decision by the Secretary of State to re-certify such an Agreement.
- 5.1.7 Where the Operator has entered into a Direct Participant Agreement in the Emissions Trading Scheme which covers emissions relating to the energy consumption of the activities, the Operator shall notify the Agency within one month of:-
- 5.1.7.1 a decision by the Operator to withdraw from or the Secretary of State to terminate that agreement.
 - 5.1.7.2 a failure to comply with an annual target under that Agreement at the end of the trading compliance period.
- 5.1.8 The Operator shall notify the Agency in writing, of any known or planned introduction or material emission from the permitted installation to water or sewer, that may increase the concentration of any "dangerous substance", as defined in List I and List II of the Dangerous Substances Directive, 76/464/EEC, and its daughter directives.

6 Interpretation

6.1.1 In this Permit, the following expressions shall have the following meanings:-

“Application” means the application for this Permit, together with any response to a notice served under Schedule 4 to the PPC Regulations and any operational change agreed under the conditions of this Permit.

“BAT” means best available techniques means the most effective and advanced stage of development of activities and their methods of operation which indicates the practical suitability of particular techniques to prevent and where that is not practicable to reduce emissions and the impact on the environment as a whole. For these purposes: *“available techniques”* means “those techniques which have been developed on a scale which allows implementation in the relevant industrial sector, under economically and technically viable conditions, taking into consideration the cost and advantages, whether or not the techniques are used or produced inside the United Kingdom, as long as they are reasonably accessible to the operator”; *“best”* means “in relation to techniques, the most effective in achieving a high general level of protection of the environment as a whole” and *“techniques”* “includes both the technology used and the way in which the installation is designed, built, maintained, operated and decommissioned”. In addition, Schedule 2 of the PPC Regulations has effect in relation to the determination of BAT.

“Fugitive emission” means an emission to air or water (including sewer) from the Permitted Installation which is not controlled by an emission or background concentration limit under conditions 2.2.1.3, 2.2.2.4, 2.2.2.5, 2.2.2.8 or 2.2.2.9 of this Permit.

“Groundwater” means all water which is below the surface of the ground in the saturation zone and in direct contact with the ground or subsoil.

“Industrial Emissions Directive” means DIRECTIVE 2010/75/EU OF THE EUROPEAN PARLIAMENT AND OF THE COUNCIL of 24 November 2010 on industrial emissions

“Land Protection Guidance” means the version of the Agency guidance note *“H7 - Guidance on the Protection of Land under the PPC Regime: Application Site Report and Site Protection and Monitoring Programme”*, including its appended templates for data reporting, which is current at the time of issue of the Permit.

“MCERTS” means the Environment Agency’s Monitoring Certification Scheme.

“Monitoring” includes the taking and analysis of samples, instrumental measurements (periodic and continual), calibrations, examinations, tests and surveys.

“Permitted Installation” means the activities and the limits to those activities described in Table 1.1.1 of this Permit.

“PPC Regulations” means the Pollution, Prevention and Control (England and Wales) Regulations SI 2000 No.1973 (as amended) and words and expressions defined in the PPC Regulations shall have the same meanings when used in this Permit save to the extent they are specifically defined in this Permit.

“Sewer” means sewer within the meaning of section 219(1) of the Water Industry Act 1991.

“Staff” includes employees, directors or other officers of the Operator, and any other person under the Operator’s direct or indirect control, including contractors.

“Year” means calendar year ending 31 December.

“Quarterly” for reporting/sampling means after/during each 3 month period, January to March; April to June; July to September and October to December and, when sampling, with at least 4 weeks between each sampling date.

“6 monthly” for reporting/sampling means after/during each 6 month period, January to June; July to December and, when sampling, with at least 8 weeks between each sampling date.

“Annual” for reporting/sampling means after/during each year and, when sampling, with at least 4 months between each sampling date.

“Daily” means, for sampling purposes, a 24 hour period starting at 00:00am.

“*Daily composite sample*” means a sample obtained by continually taking a sample of 50 millilitre from the effluent every 5 minutes.

“*Week*” means, for sampling purposes, a period of 7 days starting each Monday at 00:00am.

“*Weekly composite sample*” means a blend of 500 millilitre aliquots taken from each daily composite sample.

“*Biochemical Oxygen Demand*” means biochemical oxygen demand measured after 5 days at 20°C with nitrification suppressed by the addition of allyl-thiourea.

“*Chemical Oxygen Demand*” means chemical oxygen demand from a settled sample determined in the presence of acidified potassium dichromate.

“*Suspended Solids*” means those suspended solids measured after drying at 105°C.

“*mg/m³*” means milligramme per cubic metre.

“*g/s*” means gramme per second.

“*kg/h*” means kilogramme per hour.

“*µg/l*” means microgramme per litre.

“*mg/l*” means milligramme per litre.

“*g/l*” means gramme per litre.

“*kg*” means kilogramme.

“*t*” means tonne.

“*MWh*” means megawatt hour.

6.1.2 Where a minimum limit is set for any emission parameter, for example pH, reference to exceeding the limit shall mean that the parameter shall not be less than that limit.

6.1.3 Unless otherwise stated, any references in this Permit to concentrations of substances in emissions into air means:-

6.1.3.1 in relation to gases from combustion processes, the concentration in dry air at a temperature of 273K, at a pressure of 101.3 kPa and with an oxygen content of 3% dry for liquid and gaseous fuels, 6% dry for solid fuels; and/or

6.1.3.2 in relation to gases from non-combustion sources, the concentration at a temperature of 273K and at a pressure of 101.3 kPa, with no correction for water vapour content

6.1.4 Where any condition of this Permit refers to the whole or parts of different documents, in the event of any conflict between the wording of such documents, the wording of the document(s) with the most recent date shall prevail to the extent of such conflict.

Schedule 1 - Notification of abnormal emissions

This page outlines the information that the Operator must provide to satisfy conditions 5.1.1 and 5.1.2 of this Permit.

Units of measurement used in information supplied under Part A and B requirements shall be appropriate to the circumstances of the emission. Where appropriate, a comparison should be made of actual emissions and authorised emission limits.

If any information is considered commercially confidential, it should be separated from non-confidential information, supplied on a separate sheet and accompanied by an application for commercial confidentiality under the provisions of the PPC Regulations.

Part A

Permit Number	
Name of operator	
Location of Facility	
Time and date of the detection	

(a) Notification requirements for any malfunction, breakdown or failure of equipment or techniques, accident, or emission of a substance not controlled by an emission limit which has caused, is causing or may cause significant pollution

To be notified within 24 hours of detection

Date and time of the event	
Reference or description of the location of the event	
Description of where any release into the environment took place	
Substances(s) potentially released	
Best estimate of the quantity or rate of release of substances	
Measures taken, or intended to be taken, to stop any emission	
Description of the failure or accident.	

(b) Notification requirements for the breach of a limit

To be notified within 24 hours of detection unless otherwise specified below

Emission point reference/ source	
Parameter(s)	
Limit	
Measured value and uncertainty	
Date and time of monitoring	
Measures taken, or intended to be taken, to stop the emission	

Time periods for notification following detection of a breach of a limit	
Parameter	Notification period

(c) Notification requirements for the detection of any significant adverse environmental effect	
To be notified within 24 hours of detection	
Description of where the effect on the environment was detected	
Substances(s) detected	
Concentrations of substances detected	
Date of monitoring/sampling	

Part B - to be submitted as soon as practicable

Any more accurate information on the matters for notification under Part A.	
Measures taken, or intended to be taken, to prevent a recurrence of the incident	
Measures taken, or intended to be taken, to rectify, limit or prevent any pollution of the environment which has been or may be caused by the emission	
The dates of any unauthorised emissions from the facility in the preceding 24 months.	

Name*	
Post	
Signature	
Date	

* authorised to sign on behalf of the operator

Schedule 2 - Reporting of monitoring data

Parameters for which reports shall be made, in accordance with conditions 4.1.2 and 4.1.3 of this Permit, are listed below.

Table S2: Reporting of monitoring data			
Parameter	Emission point	Reporting period	Period begins
Effluent Flow	E2	Quarterly	01/04/06
Chemical Oxygen Demand mg/l	E2	Quarterly	01/04/06
Water usage	Permitted Installation	Annually	01/04/06
Energy usage	Permitted Installation	Annually	01/04/06
Waste disposal and/or recovery.	Permitted Installation	Annually	01/04/06
Recovered milk from reverse osmosis plant	Permitted Installation	Annually	01/01/11
Precipitated waste from effluent treatment plant	Permitted Installation	Annually	01/01/16

Schedule 3 - Forms to be used

Table S3: Reporting Forms		
Media / parameter	Form number	Date of form (Note 1)
Sewer	S1	06/03/06
Energy	E1	06/03/06
Waste Return	R1	06/03/06
Water usage	WU1	06/03/06
Performance indicators	P11	16/11/15

Note 1 or as amended by the Environment Agency

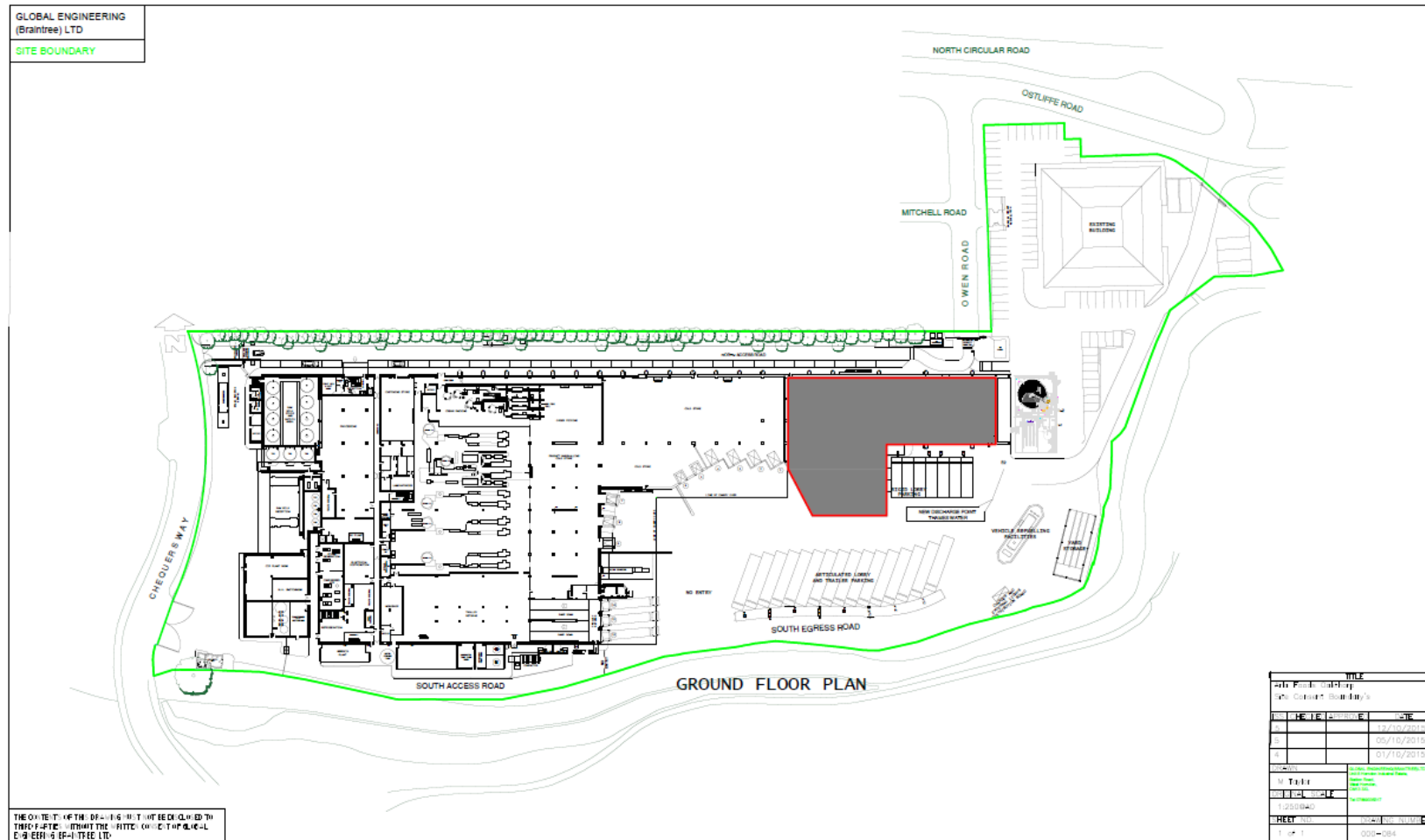
Schedule 4 - Reporting of performance data

Data required to be recorded and reported by Condition 4.1.3. The data should be assessed at the frequency given and reported annually to the Agency.

Table S4.1: Annual Production/Treatment	
Production of milk products	x (tonnes)
Amount of recovered product from the reverse osmosis plant	y (tonnes)

Table S4.2: Performance parameters		
Parameter	Frequency assessment	of Performance indicator
Chemical Oxygen Demand (COD)	Quarterly	COD/t
Water use per unit output	Annually	m ³ /t
Energy consumed per unit output	Annually	kW/ t
Fate and route of recovered product from the reverse osmosis plant	Annually	z (tonnes) sent for disposal z (tonnes) sent for recovery/re-use
Fate and route of precipitated waste from the effluent treatment plant	Annually	z (tonnes) sent for land spreading z (tonnes) sent for anaerobic digestion z (tonnes) sent for – please state final disposal or recovery route if different from the above

Schedule 5 - Site plan



END OF PERMIT

Variation and consolidation
 application number
 EPR/BN0465IG/V003