

Permit with introductory note

The Environmental Permitting (England & Wales) Regulations 2016

Samworth Brothers Limited
Kettleby Foods & Melton Foods
1 & 3 Samworth Way
Leicester
Melton Mowbray
LE13 1GA

Permit number

EPR/CP3630WD

Kettleby Foods & Melton Foods

Permit number EPR/CP3630WD

Introductory note

This introductory note does not form a part of the permit

The main features of the permit are as follows.

The Industrial Emissions Directive (IED) was transposed in England and Wales by the Environmental Permitting (England and Wales) (Amendment) Regulations 2013 on 27 February 2013. This application implements the changes brought about by the IED for “existing facilities operating newly prescribed activities” and completes the transition of this to an IED Installation.

Samworth Brothers Limited operate two food production facilities called Kettleby Foods and Melton Foods near Melton Mowbray, Leicestershire. The two food production facilities operate independently from one another, but are situated at the same geographical location approximately SK 73244 17999.

As these are existing food production sites, Samworth Brothers Limited have applied for a bespoke environmental permit. As the sites’ operate independently of one another, each will be classed as separate installation activities but are contained within the same permit document. At both sites, the scheduled listed activity under the Environmental Permitting Regulations is as follows; *S6.8 Part A(1) (d) (iii) Treatment and processing, other than exclusively packaging, of the following raw materials, whether previously processed or unprocessed, intended for the production of food or feed (where the weight of the finished product excludes packaging) – animal and vegetable raw materials (other than milk only), both in combined and separate products, with a finished product production capacity in tonnes per day greater than (aa) 75 if A is equal to 10 or more (where ‘A’ is the portion of animal material in percent of weight of the finished product production capacity).*

The Kettleby Foods site produces ready meals and includes the following processes and activities; the preparation of raw ingredient inputs (mincing and mixing), cooking (through cook pans and ovens), blast chilling, packing and distribution. The site has the capacity to produce up to 67 tonnes of cooked food products per day (with 15 tonnes consisting of animal product).

The Melton Foods site produces sandwiches and other bread based products. The site undertakes the following activities; salad preparation, sanitisation of ingredients, toasting, decanting of ingredients, preparation of ingredients (chopping, slicing, dicing and mixing), filling, chilling, packaging and despatch of finished products. The site also cooks ingredients in an oven on site in preparation for sandwich making. The site has the capacity to produce up to 97.6 tonnes of cold food products per day (with 26.3 tonnes consisting of animal product).

There are a number of combustion and emission sources across both sites including boilers, ovens and a tray washer which use natural gas as a fuel. The main point source emissions identified are nitrogen oxides and carbon monoxide. The total thermal input for all the combustion plant is 14.36 MW.

The site discharges all process water and post cleaning water at Kettleby Foods to an effluent treatment plant (ETP) and subsequently to foul sewer. At Melton Foods, each process area is fitted with catch pots to capture solids, fats and oils. Effluent is then released to foul sewer under a trade effluent consent with Severn Trent Water.

Uncontaminated site surface water is directed to an onsite lagoon and then discharged to storm water drainage.

There are no SSSIs or European statutory sites within the relevant proximity to the site. There are two sensitive local ecological receptors approximately 220m from the installation; Leicester Road Grassland and Melton Mowbray Railway Sidings Local Wildlife Sites. Our assessment of the impact from the installation activities shows that no exceedance of the relevant environmental standards were found. There are no further statutory or European ecological sites within the relevant proximity to the site.

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

Status log of the permit		
Description	Date	Comments
Application EPR/CP3630WD/A001	Duly made 24/03/2015	Application for a newly prescribed activity permit under the Industrial Emissions Directive. Site is an existing food production operation.
Additional information received	16/09/2016	Schedule 5 notice (1) response including a revised non-technical summary, amended risk assessments, Climate Change Agreement, cleaning procedures and details relating to effluent treatment.
Additional information received	30/11/2016 14/12/2016	Schedule 5 notice (2) response including air quality modelling input files and revised air quality assessment report.
Additional information received	05/01/2017 11/01/2017	Schedule 5 notice (1) response addendum including, spillage procedures, clarification of thermal inputs from combustion plant, effluent screening plant details, procedure for isolating the lagoon, Kettleby Foods drainage plan, bulk tank storage details, monitoring report for combustion plant at Melton and Kettleby Foods, review of emission points and plans and waste storage details.
Additional information received	27/02/2017	Email response including a revised Melton Foods drainage plan and monitoring reports for combustion plant at Kettleby Foods.
Permit determined EPR/CP3630WD (PAS Billing ref. CP3630WD).	04/07/2017	Permit issued to Samworth Brothers Limited.

End of introductory note

Permit

The Environmental Permitting (England and Wales) Regulations 2016

Permit number

EPR/CP3630WD

The Environment Agency hereby authorises, under regulation 13 of the Environmental Permitting (England and Wales) Regulations 2016

Samworth Brothers Limited ("the operator"),

whose registered office is

**Chetwode House
1 Samworth Way
Melton Mowbray
Leicestershire
LE13 1GA**

company registration number 03116767

to operate an installation at

**Kettleby Foods & Melton Foods
1 & 3 Samworth Way
Leicester
Melton Mowbray
LE13 1GA**

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

Name	Date
Rebecca Warren	04 July 2017

Authorised on behalf of the Environment Agency

Conditions

1 Management

1.1 General management

- 1.1.1 The operator shall manage and operate the activities:
- (a) in accordance with a written management system that identifies and minimises risks of pollution, including those arising from operations, maintenance, accidents, incidents, non-conformances, closure and those drawn to the attention of the operator as a result of complaints; and
 - (b) using sufficient competent persons and resources.
- 1.1.2 Records demonstrating compliance with condition 1.1.1 shall be maintained.
- 1.1.3 Any person having duties that are or may be affected by the matters set out in this permit shall have convenient access to a copy of it kept at or near the place where those duties are carried out.

1.2 Energy efficiency

- 1.2.1 The operator shall:
- (a) take appropriate measures to ensure that energy is used efficiently in the activities;
 - (b) review and record at least every four years whether there are suitable opportunities to improve the energy efficiency of the activities; and
 - (c) take any further appropriate measures identified by a review.

1.3 Efficient use of raw materials

- 1.3.1 The operator shall:
- (a) take appropriate measures to ensure that raw materials and water are used efficiently in the activities;
 - (b) maintain records of raw materials and water used in the activities;
 - (c) review and record at least every four years whether there are suitable alternative materials that could reduce environmental impact or opportunities to improve the efficiency of raw material and water use; and
 - (d) take any further appropriate measures identified by a review.

1.4 Avoidance, recovery and disposal of wastes produced by the activities

- 1.4.1 The operator shall take appropriate measures to ensure that:
- (a) the waste hierarchy referred to in Article 4 of the Waste Framework Directive is applied to the generation of waste by the activities; and
 - (b) any waste generated by the activities is treated in accordance with the waste hierarchy referred to in Article 4 of the Waste Framework Directive; and
 - (c) where disposal is necessary, this is undertaken in a manner which minimises its impact on the environment.

- 1.4.2 The operator shall review and record at least every four years whether changes to those measures should be made and take any further appropriate measures identified by a review.

2 Operations

2.1 Permitted activities

- 2.1.1 The operator is only authorised to carry out the activities specified in schedule 1 table S1.1 (the “activities”).

2.2 The site

- 2.2.1 The activities shall not extend beyond the site, being the land shown edged in green on the site plan at schedule 7 to this permit.

2.3 Operating techniques

- 2.3.1 The activities shall, subject to the conditions of this permit, be operated using the techniques and in the manner described in the documentation specified in schedule 1, table S1.2, unless otherwise agreed in writing by the Environment Agency.
- 2.3.2 If notified by the Environment Agency that the activities are giving rise to pollution, the operator shall submit to the Environment Agency for approval within the period specified, a revision of any plan or other documentation (“plan”) specified in schedule 1, table S1.2 or otherwise required under this permit which identifies and minimises the risks of pollution relevant to that plan, and shall implement the approved revised plan in place of the original from the date of approval, unless otherwise agreed in writing by the Environment Agency.
- 2.3.3 Any raw materials or fuels listed in schedule 2 table S2.1 shall conform to the specifications set out in that table.
- 2.3.4 The operator shall ensure that where waste produced by the activities is sent to a relevant waste operation, that operation is provided with the following information, prior to the receipt of the waste:
- (a) the nature of the process producing the waste;
 - (b) the composition of the waste;
 - (c) the handling requirements of the waste;
 - (d) the hazardous property associated with the waste, if applicable; and
 - (e) the waste code of the waste.
- 2.3.5 The operator shall ensure that where waste produced by the activities is sent to a landfill site, it meets the waste acceptance criteria for that landfill.

2.4 Improvement programme

- 2.4.1 The operator shall complete the improvements specified in schedule 1 table S1.3 by the date specified in that table unless otherwise agreed in writing by the Environment Agency.
- 2.4.2 Except in the case of an improvement which consists only of a submission to the Environment Agency, the operator shall notify the Environment Agency within 14 days of completion of each improvement.

2.5 Pre-operational conditions

- 2.5.1 The operations specified in schedule 1 table S1.4A shall not commence until the measures specified in that table have been completed.

3 Emissions and monitoring

3.1 Emissions to water, air or land

- 3.1.1 There shall be no point source emissions to water, air or land except from the sources and emission points listed in schedule 3 tables S3.1, S3.2, S3.3 and S3.4.
- 3.1.2 The limits given in schedule 3 shall not be exceeded.
- 3.1.3 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.

3.2 Emissions of substances not controlled by emission limits

- 3.2.1 Emissions of substances not controlled by emission limits (excluding odour) shall not cause pollution. The operator shall not be taken to have breached this condition if appropriate measures, including, but not limited to, those specified in any approved emissions management plan, have been taken to prevent or where that is not practicable, to minimise, those emissions.
- 3.2.2 The operator shall:
- (a) if notified by the Environment Agency that the activities are giving rise to pollution, submit to the Environment Agency for approval within the period specified, an emissions management plan which identifies and minimises the risks of pollution from emissions of substances not controlled by emission limits;
 - (b) implement the approved emissions management plan, from the date of approval, unless otherwise agreed in writing by the Environment Agency.

3.3 Odour

- 3.3.1 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.
- 3.3.2 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.

3.4 Noise and vibration

- 3.4.1 Emissions from the activities shall be free from noise and vibration 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 noise and vibration management plan to prevent or where that is not practicable to minimise the noise and vibration.
- 3.4.2 The operator shall:

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

3.5 Monitoring

- 3.5.1 The operator shall, unless otherwise agreed in writing by the Environment Agency, undertake the monitoring specified in the following tables in schedule 3 to this permit:
 - (a) point source emissions specified in tables S3.1, S3.2, S3.3 and S3.4;
- 3.5.2 The operator shall maintain records of all monitoring required by this permit including 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.
- 3.5.3 Monitoring equipment, techniques, personnel and organisations employed for the emissions monitoring programme and the environmental or other monitoring specified in condition 3.5.1 shall have either MCERTS certification or MCERTS accreditation (as appropriate), where available, unless otherwise agreed in writing by the Environment Agency.
- 3.5.4 Permanent means of access shall be provided to enable sampling/monitoring to be carried out in relation to the emission points specified in schedule 3 tables S3.1, S3.2 and S3.3 unless otherwise agreed in writing by the Environment Agency.

3.6 Pests

- 3.6.1 The activities shall not give rise to the presence of pests which are likely to cause pollution, hazard or annoyance outside the boundary of the site. The operator shall not be taken to have breached this condition if appropriate measures, including, but not limited to, those specified in any approved pests management plan, have been taken to prevent or where that is not practicable, to minimise the presence of pests on the site.
- 3.6.2 The operator shall:
 - (a) if notified by the Environment Agency, submit to the Environment Agency for approval within the period specified, a pests management plan which identifies and minimises risks of pollution from pests;
 - (b) implement the pests management plan, from the date of approval, unless otherwise agreed in writing by the Environment Agency.

4 Information

4.1 Records

- 4.1.1 All records required to be made by this permit shall:
 - (a) be legible;
 - (b) be made as soon as reasonably practicable;
 - (c) if amended, be amended in such a way that the original and any subsequent amendments remain legible, or are capable of retrieval; and

(d) be retained, unless otherwise agreed in writing by the Environment Agency, for at least 6 years from the date when the records were made, or in the case of the following records until permit surrender:

- (i) off-site environmental effects; and
- (ii) matters which affect the condition of the land and groundwater.

4.1.2 The operator shall keep on site all records, plans and the management system required to be maintained by this permit, unless otherwise agreed in writing by the Environment Agency.

4.2 Reporting

4.2.1 The operator shall send all reports and notifications required by the permit to the Environment Agency using the contact details supplied in writing by the Environment Agency.

4.2.2 A report or reports on the performance of the activities over the previous year shall be submitted to the Environment Agency by 31 January (or other date agreed in writing by the Environment Agency) each year. The report(s) shall include as a minimum:

- (a) a review of the results of the monitoring and assessment carried out in accordance with the permit including an interpretive review of that data;
- (b) the annual production /treatment data set out in schedule 4 table S4.2; and
- (c) the performance parameters set out in schedule 4 table S4.3 using the forms specified in table S4.4 of that schedule.

4.2.3 Within 28 days of the end of the reporting period the operator shall, unless otherwise agreed in writing by the Environment Agency, submit reports of the monitoring and assessment carried out in accordance with the conditions of this permit, as follows:

- (a) in respect of the parameters and emission points specified in schedule 4 table S4.1;
- (b) for the reporting periods specified in schedule 4 table S4.1 and using the forms specified in schedule 4 table S4.4 ; and
- (c) giving the information from such results and assessments as may be required by the forms specified in those tables.

4.2.4 The operator shall, unless notice under this condition has been served within the preceding four years, submit to the Environment Agency, within six months of receipt of a written notice, a report assessing whether there are other appropriate measures that could be taken to prevent, or where that is not practicable, to minimise pollution.

4.3 Notifications

4.3.1 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.
- 4.3.2 Any information provided under condition 4.3.1 (a)(i), or 4.3.1 (b)(i) where the information relates to the breach of a limit specified in the permit, shall be confirmed by sending the information listed in schedule 5 to this permit within the time period specified in that schedule.
- 4.3.3 Where the Environment Agency has requested in writing that it shall be notified when the operator is to undertake monitoring and/or spot sampling, the operator shall inform the Environment Agency when the relevant monitoring and/or spot sampling is to take place. The operator shall provide this information to the Environment Agency at least 14 days before the date the monitoring is to be undertaken.
- 4.3.4 The Environment Agency shall be notified within 14 days of the occurrence of the following matters, except where such disclosure is prohibited by Stock Exchange rules:
- Where the operator is a registered company:
- (a) any change in the operator's trading name, registered name or registered office address; and
 - (b) any steps taken with a view to the operator going into administration, entering into a company voluntary arrangement or being wound up.
- Where the operator is a corporate body other than a registered company:
- (a) any change in the operator's name or address; and
 - (b) any steps taken with a view to the dissolution of the operator.
- In any other case:
- (a) the death of any of the named operators (where the operator consists of more than one named individual);
 - (b) any change in the operator's name(s) or address(es); and
 - (c) 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 of them being in a partnership, dissolving the partnership.
- 4.3.5 Where the operator proposes to make a change in the nature or functioning, or an extension of the activities, which may have consequences for the environment and the change is not otherwise the subject of an application for approval under the Regulations or this permit:
- (a) the Environment Agency shall be notified at least 14 days before making the change; and
 - (b) the notification shall contain a description of the proposed change in operation.
- 4.3.6 The Environment Agency shall be given at least 14 days notice before implementation of any part of the site closure plan.
- 4.3.7 Where the operator has entered into a climate change agreement with the Government, the Environment Agency shall be notified within one month of:
- (a) a decision by the Secretary of State not to re-certify the agreement;
 - (b) a decision by either the operator or the Secretary of State to terminate the agreement; and
 - (c) any subsequent decision by the Secretary of State to re-certify such an agreement.

4.4 Interpretation

- 4.4.1 In this permit the expressions listed in schedule 6 shall have the meaning given in that schedule.

4.4.2 In this permit references to reports and notifications mean written reports and notifications, except where reference is made to notification being made “immediately”, in which case it may be provided by telephone.

Schedule 1 – Operations

Table S1.1 activities			
Activity reference	Activity listed in Schedule 1 of the EP Regulations	Description of specified activity	Limits of specified activity
A1	S6.8 Part A(1) (d) (iii) Treatment and processing, other than exclusively packaging, of the following raw materials, whether previously processed or unprocessed, intended for the production of food or feed (where the weight of the finished product excludes packaging) – animal and vegetable raw materials (other than milk only), both in combined and separate products, with a finished product production capacity in tonnes per day greater than (aa) 75 if A is equal to 10 or more (where 'A' is the portion of animal material in percent of weight of the finished product production capacity).	Production of cooked and cold foods (Melton Foods site)	From receipt of raw materials to despatch of finished product. Production of up to 97.6 tonnes of cold food products per day.
A2	S6.8 Part A(1) (d) (iii) Treatment and processing, other than exclusively packaging, of the following raw materials, whether previously processed or unprocessed, intended for the production of food or feed (where the weight of the finished product excludes packaging) – animal and vegetable raw materials (other than milk only), both in combined and separate products, with a finished product production capacity in tonnes per day greater than (aa) 75 if A is equal to 10 or more (where 'A' is the portion of animal material in percent of weight of the finished product production capacity).	Production of cooked foods (Kettleby Foods site)	From receipt of raw materials to despatch of finished product. Production of up to 67 tonnes of cooked food products per day.

Table S1.1 activities			
Activity reference	Activity listed in Schedule 1 of the EP Regulations	Description of specified activity	Limits of specified activity
A3	S5.4 Part A(1) (a) (ii) Disposal of non-hazardous waste with a capacity exceeding 50 tonnes per day involving physico-chemical treatment.	Operation of the effluent treatment plant (ETP) at the Kettleby Foods site for the control of releases to sewer.	Collection and treatment of process effluent prior to discharge to sewer.
Directly Associated Activity			
A4	Combustion Plant.	Operation of boilers to generate steam.	Combustion of natural gas in 3 boilers at the Kettleby Foods site and 1 boiler at the Melton Foods site with a combined thermal input of 11.26 MW.
A5	Combustion Plant.	Operation of a hot water boiler.	Combustion of natural gas in 1 boiler at the Melton Foods site with a thermal input of 1.17 MW.
A6	Ovens.	Operation of ovens for the production of cooked foods.	Combustion of natural gas in 4 ovens at the Kettleby Foods site and 1 oven and 1 bar maker at Melton Foods with a combined thermal input of 1.72 MW.
A7	Tray wash.	Operation of automated tray wash processes.	Combustion of natural gas in 1 tray wash at the Melton Foods site with a thermal input of 0.21 MW.
A8	Waste and by-product storage.	Storage of waste and by-products from the production of processed foods.	From receipt of waste and by-products to despatch off-site.

Table S1.2 Operating techniques		
Description	Parts	Date Received
Application	Application form Part B3 Section 3a – Technical Standards (refers to EPR 6.10). All application supporting documents except those superseded by the information request responses below.	Duly Made 24/03/2015
Response to Schedule 5 notice dated 29/06/2017	Schedule 5 response including the following operating techniques: <ul style="list-style-type: none"> BAT Statement (Section 9 of the revised Non-Technical Summary), <i>Non-Technical Summary: Melton Foods.</i> 	16/09/2017

Table S1.2 Operating techniques		
Description	Parts	Date Received
	<ul style="list-style-type: none"> • BAT Statement (Section 9 of the revised Non-Technical Summary), <i>Non-Technical Summary: Kettleby Foods</i>. • Accident Management Plan, Melton Foods. <i>Environmental Accident Management Plan</i>. • Spillage policy, <i>Kettleby Foods. Hazardous Material Spillage Policy</i>. Reference ENV-P017 • Spillage policy, <i>Kettleby Foods. Hazardous Material Spillage Procedure</i>. Reference ENV-P017A • Cleaning procedures (unislicer, drain cleaning, scales and turbo depositor). • Containment equipment inventory, <i>Melton Foods Chemical Containment</i>. • Effluent treatment plant process. Schematic document. • Effluent treatment plant report. <i>Engineering Development Report. Kettleby Foods Effluent Treatment Plant Review</i>. Reference ED01/15. 	
Additional information	<p>Additional information received via email including the following operating techniques:</p> <ul style="list-style-type: none"> • Spillage procedure, <i>Melton Foods, Hazardous Substance Spillage External Areas</i>. Reference RAH2. • Effluent screening process at Melton Foods, <i>Melton Foods Screening Plant</i>. • Lagoon penstock procedures, <i>Engineering. Isolate Lagoon Penstock Valve</i>. Reference Version 1. • Bulk tank review, <i>Bulk Tank Data</i>. • Waste storage statement, <i>EA Schedule 5 additional information required no.4 – Waste Storage</i>. 	11/01/2017

Table S1.3 Improvement programme requirements		
Reference	Requirement	Date
IC1	<p>The operator shall submit a revised written odour management plan to the Environment Agency for approval. The plan shall incorporate all the required detailed information as specified in the Environment Agency's guidance, <i>How to comply with your environmental permit. Additional guidance for: The Food and Drink Sector (EPR 6.10) and Horizontal Guidance H4 – Odour Management</i>.</p> <p>Including but not restricted to the following sections:</p> <ul style="list-style-type: none"> • Details of sensitive receptors (dwellings and workplaces). • A map showing the installation in relation to the sensitive receptors. • Odour sources. • Odour pathways. • Odour management and control measures. • Process monitoring of potentially odorous sources. • Odour complaints procedure. • Odour monitoring. • Community engagement. • Abnormal operations and contingency measures. 	04/01/18
IC2	<p>The operator shall submit a revised written noise management plan to the Environment Agency for approval. The plan shall incorporate the relevant detailed information as specified in Section 3 of the Environment Agency's <i>Horizontal Guidance H3 – Noise Assessment and Control</i>.</p>	04/01/18
IC3	<p>The operator shall provide a revised accident management plan to the Environment Agency for approval. It shall include specified contingency actions outlining how each abnormal operational activity will be managed. The revised accident management plan shall meet the requirements specified in the section, <i>Accident prevention and management plan</i> as specified in the Environment Agency's web guidance, <i>Develop a management system: environmental permits</i> and <i>How to comply with your environmental permit. Additional guidance for: The Food and Drink Sector (EPR 6.10)</i>.</p>	04/01/18
IC4	<p>The operator shall submit a written plan to the Environment Agency for approval that includes proposals to undertake representative monitoring of point source air emissions listed in table S3.1.</p> <p>The proposals shall include the following monitoring requirements:</p> <ul style="list-style-type: none"> • The emission points to be monitored; • Monitoring for oxides of nitrogen, carbon monoxide and volatile organic compounds; • Monitoring frequency; • Reference period of 1 hour average; and • Methods to be used. <p>Monitoring shall be either MCerts certification or MCerts accreditation, where available, and test standards shall be standards referenced in Technical Guidance note (monitoring) M2 Monitoring of stack emissions to air.</p>	04/01/18

Table S1.3 Improvement programme requirements		
Reference	Requirement	Date
IC5	<p>The operator shall submit a report to the Environment Agency for approval that includes:</p> <ul style="list-style-type: none"> • Updated air dispersion modelling that includes the point source air emissions data obtained in IC4 above; and • Proposals for appropriate measures to mitigate the impact of the emissions where the air dispersion modelling determines they are significant, including emission limits and monitoring frequencies and methods, and dates for implementation of individual measures. 	Within 3 months of completion of IC4
IC6	<p>The operator shall submit a report to the Environment Agency for approval outlining how effluent generated from the food production process is monitored. The plan shall incorporate the requirements of Section 3 and the parameters specified in Table 4B of the Environment Agency's Guidance, <i>How to comply with your environmental permit. Additional guidance for: The Food and Drink Sector (EPR 6.10).</i></p>	04/01/18
IC7	<p>The operator shall submit a plan of improvements to the Environment Agency for approval outlining how bulk storage tanks; 'Fat Tank', 'Sludge Tank' and Sludge Tank from Effluent' will be bunded. The containment tanks shall meet the requirements from the Environment Agency's web guidance, <i>Control and monitor emissions for your environmental permit</i> section, <i>Leaks from containers</i> https://www.gov.uk/guidance/control-and-monitor-emissions-for-your-environmental-permit#leaks-from-containers.</p> <p>The plan shall contain dates for implementation of individual measures.</p>	04/01/18

Table S1.4A Pre-operational measures for future development		
Reference	Operation	Pre-operational measures
PO1	Tray wash	Prior to commissioning the Tray wash (emission point TP5 in Table S3.2), the operator shall complete the requirements of IC4 and IC5.

Schedule 2 – Raw materials and fuels

Table S2.1 Raw materials and fuels	
Raw materials and fuel description	Specification
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Schedule 3 – Emissions and monitoring

Table S3.1 Point source emissions to air – emission limits and monitoring requirements (Kettleby Foods)						
Emission point ref. & location	Source	Parameter ³	Limit (including unit) ⁴	Reference period ⁴	Monitoring frequency ⁵	Monitoring standard or method ⁵
A1 ¹	Steam boiler No.1	NO _x	--	--	--	--
		CO	--			--
A2 ¹	Steam boiler No.2	NO _x	--	--	--	--
		CO	--			--
A3 ¹	Steam boiler No.3	NO _x	--	--	--	--
		CO	--			--
A4 ¹	Travelling oven No.1	NO _x	--	--	--	--
		CO	--			--
		VOC	--			--
A5 ¹	Travelling oven No.2	NO _x	--	--	--	--
		CO	--			--
		VOC	--			--
A6 ¹	Double D rack oven No.1	NO _x	--	--	--	--
		CO	--			--
		VOC	--			--
A7 ¹	Double D rack oven No.2	NO _x	--	--	--	--
		CO	--			--
		VOC	--			--
7&8 ²	Ammonia Plant safety vents	--	--	--	--	--
12 ²	Steam extraction	--	--	--	--	--
19 ²	Steam release vents and canopy extraction from Double D rack ovens	--	--	--	--	--
25 ²	Wet scrubber odour extraction point from cook pans and Double D rack oven vapour	--	--	--	--	--

Table S3.1 Point source emissions to air – emission limits and monitoring requirements (Kettleby Foods)

Emission point ref. & location	Source	Parameter³	Limit (including unit)⁴	Reference period⁴	Monitoring frequency⁵	Monitoring standard or method⁵
26 ²	Steam boiler No.2 pressure release valve	--	--	--	--	--
27 ²	Steam boiler No.1 pressure release valve	--	--	--	--	--
29 ²	Steam extraction from tray wash	--	--	--	--	--
32 ²	Steam extraction	--	--	--	--	--
33 ²	High care steam room extraction point	--	--	--	--	--
59 ²	Cook house canopy pans 8 & 9 cooking vapour extraction	--	--	--	--	--
62 ²	Bin wash steam extraction	--	--	--	--	--
64 ²	Bin wash steam extraction	--	--	--	--	--
65 ²	Tray wash steam extraction	--	--	--	--	--
66 ²	Rack wash steam extraction	--	--	--	--	--
72 ²	Odour abatement (ozone and UV system) extraction point	--	--	--	--	--
76 ²	Unit steam extraction	--	--	--	--	--
81A – F ²	Boiler, Hotwell and Blow down vessel	--	--	--	--	--

Table S3.1 Point source emissions to air – emission limits and monitoring requirements (Kettleby Foods)

Emission point ref. & location	Source	Parameter ³	Limit (including unit) ⁴	Reference period ⁴	Monitoring frequency ⁵	Monitoring standard or method ⁵
	safety valve and steam vents					

¹ Point source emissions to air from the Kettleby Foods site are shown on drawing *Kettleby Foods site plan – Emission points*.
² Point source emissions to air from the Kettleby Foods site are shown on drawing *Rooftop Emission Points*.
³ NO_x = Oxides of nitrogen (expressed as NO₂) in mg/m³
CO = Carbon monoxide in mg/m³
VOC = Volatile organic compounds (expressed as carbon) in mg/m³
⁴ Limits and reference to be confirmed following completion of monitoring programme as per IC4.
⁵ Monitoring frequency and standards to be reviewed following completion of monitoring programme as per IC4.

Table S3.2 Point source emissions to air – emission limits and monitoring requirements (Melton Foods)

Emission point ref. & location ¹	Source	Parameter ²	Limit (including unit) ³	Reference period ³	Monitoring frequency ⁴	Monitoring standard or method ⁴
TP1	Hot water boiler	NO _x	--	--	--	--
		CO	--			--
TP2	Hot water boiler no.3	NO _x	--	--	--	--
		CO	--			--
TP3	Oven	NO _x	--	--	--	--
		CO	--			--
		VOC	--			--
TP4	Bar Maker	NO _x	--	--	--	--
		CO	--			--
		VOC	--			--
TP5	Traywash	NO _x	--	--	--	--
		CO	--			--

¹ Point source emissions to air from the Melton Foods site are shown on drawing *Factory/Site Emission Point Locations*. Ref MF-17-1091
² NO_x = Oxides of nitrogen (expressed as NO₂) in mg/m³
CO = Carbon monoxide in mg/m³
VOC = Volatile organic compounds (expressed as carbon) in mg/m³
³ Limits and reference to be confirmed following completion of monitoring programme as per IC4.
⁴ Monitoring frequency and standards to be reviewed following completion of monitoring programme as per IC4.

Table S3.3 Point source emissions to sewer, effluent treatment plant or other transfers off-site– emission limits and monitoring requirements.

Emission point ref. & location	Source	Parameter	Limit (incl. Unit)	Reference period	Monitoring frequency	Monitoring standard or method
S1 on site drainage plan (KF-23-1026) emissions to an off-site Severn Trent Water bulk tank. Emission subsequently passes to a Severn Trent sewage treatment works	Kettleby Foods Site effluent treatment plant	--	--	--	--	--
S2 on site drainage plan (MF-17-1026) emissions to a Severn Trent Water bulk tank. Emission subsequently passes to a Severn Trent sewage treatment works	Melton Foods site effluent drainage	--	--	--	--	--

Table S3.4 Point Source emissions to water (other than sewer) and land – emission limits and monitoring requirements

Emission point ref. & location	Source	Parameter	Limit (incl. unit)	Reference Period	Monitoring frequency	Monitoring standard or method
W1 on site drainage plan (KF-12-1026) to a tributary of the River Wreake to the west of the site.	Uncontaminated surface water from the Kettleby Foods site run-off from the on-site lagoon	Visible oils, fats and grease	Non visible	--	Monthly	Visual inspection
W2 leading to W1 on the site drainage plans (KF-12-1026 and MF-17-1026) to a tributary of the River Wreake to the west of the site	Uncontaminated surface water from the Melton Foods site run-off from the on-site lagoon	Visible oils, fats and grease	Non visible	--	Monthly	Visual inspection

Schedule 4 – Reporting

Parameters, for which reports shall be made, in accordance with conditions of this permit, are listed below.

Table S4.1 Reporting of monitoring data			
Parameter	Emission or monitoring point/reference	Reporting period	Period begins
--	--	--	--

Table S4.2: Annual production/treatment	
Parameter	Units
Cooked and cold food produced (finished products) – Melton Foods site	tonnes
Cooked and cold food produced (finished products) – Kettleby Foods site	tonnes

Table S4.3 Performance parameters		
Parameter	Frequency of assessment	Units
Water usage	Annually	tonnes
Energy usage	Annually	MWh
Final product produced	Annually	tonnes
Waste disposed	Annually	tonnes

Table S4.4 Reporting forms		
Media/parameter	Reporting format	Date of form
Water usage	Form water usage 1 or other form as agreed in writing by the Environment Agency	04/07/17
Energy usage	Form energy 1 or other form as agreed in writing by the Environment Agency	04/07/17
Other performance indicators	Form performance 1 or other form as agreed in writing by the Environment Agency	04/07/17

Schedule 5 – Notification

These pages outline the information that the operator must provide.

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 EP 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	

(b) Notification requirements for the breach of a limit	
To be notified within 24 hours of detection unless otherwise specified below	
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 6 – Interpretation

“accident” means an accident that may result in pollution.

“application” means the application for this permit, together with any additional information supplied by the operator as part of the application and any response to a notice served under Schedule 5 to the EP Regulations.

“authorised officer” means any person authorised by the Environment Agency under section 108(1) of The Environment Act 1995 to exercise, in accordance with the terms of any such authorisation, any power specified in section 108(4) of that Act.

“EP Regulations” means The Environmental Permitting (England and Wales) Regulations SI 2016 No.1154 and words and expressions used in this permit which are also used in the Regulations have the same meanings as in those Regulations.

“emissions of substances not controlled by emission limits” means emissions of substances to air, water or land from the activities, either from the emission points specified in schedule 3 or from other localised or diffuse sources, which are not controlled by an emission limit.

“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

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

“Pests” means Birds, Vermin and Insects.

“quarter” means a calendar year quarter commencing on 1 January, 1 April, 1 July or 1 October.

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.

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

- in relation to emissions 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
- in relation to emissions 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.

“year” means calendar year ending 31 December.

Schedule 7 – Site plan



END OF PERMIT

Permit Number: **EPR/CP3630WD**

Operator: **Samworth Brothers Limited**

Facility: **Kettleby Foods and Melton Foods**

Form Number: **WaterUsage1 / 04/07/17**

Reporting of Water Usage for the year

Water Source	Usage (m³/year)	Specific Usage (m³/unit output)
Mains water		
TOTAL WATER USAGE		

Operator's comments:

Signed

Date.....

(authorised to sign as representative of Operator)

