

Permit with introductory note

The Environmental Permitting (England & Wales) Regulations 2016

Cranswick Country Foods PLC

Yaxley Poultry Processing Plant
Oakmere Business Park
Eye Airfield Industrial Estate
Yaxley
Eye
Suffolk
IP23 8BW

Permit number

EPR/YP3609PS

Yaxley Poultry Processing Plant

Permit number EPR/YP3609PS

Introductory note

This introductory note does not form a part of the permit

The main features of the permit are as follows.

The Installation is in a rural location approximately 250 metres north east of the village of Yaxley and 1 km North West of the village of Eye in Suffolk at grid reference TM12726 74560.

The following Schedule 1 activities are carried out at the installation.

Section 6.8 Part A(1)(b) Slaughtering animals at plant with a carcass production capacity of more than 50 tonnes per day.

Section 6.8 Part A(1)(d)(iii)(aa) Treatment and processing of animal and vegetable raw materials with a finished product production capacity of greater than 75 tonnes per day.

Section 5.4 Part A(1)(a)(i) Disposal of non-hazardous waste with a capacity exceeding 50 tonnes per day by biological treatment. Total influent capacity 1,200 m³ / day

Section 5.4 Part A(1)(a)(ii) Disposal of non-hazardous waste with a capacity exceeding 50 tonnes per day by physico-chemical treatment.

The Installation is designed to process up to 15,000 chickens per hour (1.2 million per week) which is the equivalent to 132,000 tonnes per year. The key processes carried out, are receipt of livestock (lairage), slaughter (stunning and bleeding), AeroScalding, de-feathering, evisceration, chilling and grading, and packaging (a small proportion - up to around 10% - including the addition of further ingredients such as marinades) in readiness for despatch.

The installation includes a waste water treatment plant for the physico-chemical and biological treatment of process derived waste water, the effluent from this is discharged to a purpose built channel prior to flowing to the existing surface water drainage system at TM 12503 74293 which in turn flows to a tributary of River Dove.

The facility also incorporates a natural gas fired combined heat and power plant operating in tandem with traditional gas fired boiler plant to satisfy its hot water, steam and electricity supply requirements. The combustion plant includes a Medium Combustion Plant reference GG12V400A1 which consists of a gas engine and a gas fired boiler with a combined rated thermal input of 5.05MW. The Medium Combustion Plant Directive (EU/2015/2193) applies to these units.

Odours from the Effluent Treatment Plant building are abated through a carbon bed filtration system, and those from the Animal By-Product storage areas using a Bio-Oxygen treatment system.

The site is 8.5 km south east of Waveney and Little Ouse Valley Fens (SAC) and Redgrave and South Lopham Fens (Ramsar), it is also 2 km north of the Major Farm, Braiseworth (SSSI). Emissions from the installation screened out as not significant in relation to these sites.

The Environmental Management System implemented is based on that at sister sites within the group, the site is working towards BS EN ISO 14001 accreditation.

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/YP3609PS/A001	Duly made 25/07/2019	Application for poultry slaughterhouse, and meat processing facility.
Additional Information received	12/12/2019	Updated Odour Management Plan reference OMP 46.904 V03 December 2019.
Additional information received	13/12/2019	Response to Schedule 5 Notice dated 04/11/2019.
Additional information received	16/12/2019	Site plan reference [1] 17_L07-IP02 - PERMITTED SITE AREA
Additional information received	19/12/2019	Updated Raw Material Table
Additional information received	19/12/2019	Updated Extract and emission plan reference 17-L07-IP04B
Additional information received	23/01/2020	Permitted site area plan reference 17-L07-IP02E
Permit determined EPR/YP3609PS (Billing ref. YP3609PS)	30/01/2020	Permit issued to Cranswick Country Foods PLC.

End of introductory note

Permit

The Environmental Permitting (England and Wales) Regulations 2016

Permit number

EPR/YP3609PS

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

Cranswick Country Foods PLC (“the operator”),

whose registered office is

**Crane Court
Hesslewood Office Park
Ferriby Road
Hessle
Kingston upon Hull
HU13 0PA**

company registration number 01803402

to operate an installation at

**Yaxley Poultry Processing Plant
Oakmere Business Park
Eye Airfield Industrial Estate
Yaxley
Eye
Suffolk
IP23 8BW**

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

Name	Date
Claire Roberts	30/01/2020

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 Any raw materials or fuels listed in schedule 2 table S2.1 shall conform to the specifications set out in that table.
- 2.3.3 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.
- 2.3.4 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.

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 and S3.2.
- 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.
- 3.1.4 For the following activities referenced in schedule 1, table S1.1 (AR5) the first monitoring measurements shall be carried out within four months of the issue date of the permit or the date when the MCP is first put into operation, whichever is later.

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.
- 3.2.3 All liquids in containers, whose emission to water or land could cause pollution, shall be provided with secondary containment, unless the operator has used other appropriate measures to prevent or where that is not practicable, to minimise, leakage and spillage from the primary container.

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.

3.4 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, and S3.2.

- 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 and S3.2 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.

4.4 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
AR1	S6.8 A1 (b)	Poultry slaughter: Slaughtering animals at a plant with a carcass production capacity of more than 50 tonnes per day	From receipt of live birds to the delivery of carcasses to the meat processing facility.
AR2	S6.8 A1 (d) (iii) (aa)	Poultry processing: 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 75 tonnes	From receipt of carcasses from slaughter line to despatch of final product.
AR3	S5.4 A1 (a) (i)	Disposal of non-hazardous waste in a facility with a capacity of more than 50 tonnes per day involving biological treatment D 8 Biological treatment which results in final compounds or mixtures which are discarded by means of any of the operations numbered D 1 to D 12	From generation of effluents to discharge to AR4. Effluent treatment plant – treatment of waste waters by dissolved air flotation, chemical dosing to remove phosphorus, denitrification, aeration, membrane bioreactor, and sludge dewatering.
AR4	S5.4 A1 (a) (ii)	Disposal of non-hazardous waste in a facility with a capacity of more than 50 tonnes per day involving physico-chemical treatment. D 9 Physico-chemical treatment which results in final compounds or mixtures which are discarded by means of any of the operations numbered D 1 to D 12	From receipt of treated effluent from AR3 to discharge to tributary of River Dove via W1. Treatment of waste water by ultra violet disinfecting and reverse osmosis following biological treatment.
Directly Associated Activity			
AR5	Electricity and hot water supply	Medium Combustion plant: 3.55 MWth gas-fired CHP	From receipt of natural gas to discharge of exhaust

Table S1.1 activities			
Activity reference	Activity listed in Schedule 1 of the EP Regulations	Description of specified activity	Limits of specified activity
		plus 1 x 1.5MWth gas fired boiler. Generation of electricity for installation and production of hot water and steam for processes including hand washing, wash-down, and AeroScalding.	gases, and the generation of electricity and steam.
AR6	Refrigeration	Refrigeration of raw materials, carcasses and finished products	Refrigeration of raw materials and final packaged product, and operation of refrigeration plant.
AR7	Waste storage and handling	Storage and handling of waste materials	From generation of waste to removal from site for disposal or recovery.
AR8	Raw material storage and handling	Ambient and refrigerated storage of raw materials.	From receipt of raw materials to use in manufacture.
AR9	Storage and use of chemicals	Storage and use of chemicals for cleaning and operation of effluent treatment plant.	Receipt, storage and use of chemicals.

Table S1.2 Operating techniques		
Description	Parts	Date Received
Application	Documents B3.3a Operating Techniques and Technical Standards and B3.1 Activities applied for, provided in response to section 3a – technical standards, of Part B3 of the application form. Excluding the Odour Management Plan.	29/03/2019
Application	Noise monitoring plan reference 46.902 in response to section 3B, Table 3b – General Requirements, Part B3 of the application form.	29/03/2019
Response to Schedule 5 Notice dated 04/11/2019	Response to question 2 updated Accident Management Plan reference 46.010 05-12-2019.	11/12/2019
	Response to question 4 further Best Available Techniques (BAT) description.	09/12/2019
	Response to question 5, Management System implementation.	05/12/2019
	Response to question 6, BAT for 6.8 Part A (1) (d) (iii) processes.	10/12/2019
	Response to question 7, Refrigeration process.	05/12/2019
	Response to question 11, information required by Annex 1 of the Medium Combustion Plant Directive (EU/2015/2193).	13/12/2019
	Responses to questions 12, 13, 14, and 15, secondary containment requirements, design and maintenance programme.	12/12/2019

Table S1.2 Operating techniques		
Description	Parts	Date Received
Additional Information	Odour Management Plan reference OMP 46.904 V03 December 2019 in response to section 3B, Table 3b – General Requirements, of Part B3 of the application form.	12/12/2019
Additional Information	Site plan reference [1] 17_L07-IP02 - PERMITTED SITE AREA provided in response to section 5a Provide a plan or plans for the site, of Part B2 of the application form.	16/12/2019
Additional Information	Effluent Treatment Plant process description reference 16W2454C submitted in response to section 3a – technical standards, of Part B3 of the application form.	16/12/2019
Additional Information	Updated Raw Material document reference B3.3c provided in response to question 3c, table 3c types and amounts of raw materials, of Part B3 of the application form.	19/12/2019
Additional Information	Extract and emission plan reference 17-L07-IP04B Extract and emissions plan and revised document B3.2 Emissions to Air, Water and Land provided in response to section 2, table 2 – emissions to air, water and land of Part B3 of the application form.	19/12/2019
Additional Information	Permitted site area plan reference 17-L07-IP02E - PERMITTED SITE AREA plus points W1 and W2, provided in response to section 2, table 2 – emissions to air, water and land of Part B3 of the application form.	23/01/2020

Table S1.3 Improvement programme requirements		
Reference	Requirement	Date
IC1	<p>The Operator shall develop a monitoring programme to demonstrate the effectiveness of the Bio-Oxygen system used to abate odours from the animal by-products areas 2 and 3.</p> <p>The programme shall explain (but shall not be limited to) how the following information will be established:</p> <ul style="list-style-type: none"> • odour concentration monitoring data for the inlet (within the process area) and outlet gas streams; • monitoring data for all outlet gas streams for volatile organic compounds (VOC's), ammonia and hydrogen sulphide; • system process monitoring data (e.g. volume flow) • evidence that the sample locations and sampling parameters are appropriate; • monitoring will be undertaken at times representative of full operation; • monitoring will be undertaken at intervals throughout the year which are representative of seasonal change; • detail on how a correct balance between odorous materials and treatment capacity will be managed and maintained for this system. <p>This monitoring programme shall be agreed in writing with the Environment Agency.</p>	28/02/2020
IC2	<p>The Operator shall submit a report which address all of the aspects of the agreed monitoring programme in IC1. The report shall review the effectiveness of the Bio-Oxygen system used to abate odours from the animal by-products areas 2 and 3 and shall provide justification supported by evidence to demonstrate the system is effective and why it represents best available techniques (BAT).</p> <p>If it is not possible to demonstrate the bio-oxygen system is effective, the report shall:</p> <ul style="list-style-type: none"> • Identify alternative options available to reduce or eliminate odour from the animal by-product areas 2 and 3; • Summarise the technique(s) and assess them against BAT; • Include a plan with timescales for the implementation of the preferred option(s). <p>The report and any implementation timescales provided shall be agreed in writing by the Environment Agency. The plan shall be implemented in accordance with the Environment Agency's written approval.</p>	31/10/2020
IC3	<p>The Operator shall implement measures to ensure that all liquids that could cause pollution are fitted with adequate secondary containment, these measures shall comply with relevant industry standards, such as CIRIA 736.</p> <p>The Operator shall inform the Environment Agency in writing of the implementation of such measures.</p>	31/07/2020
IC4	<p>The Operator shall develop and implement a programme to monitor the concentration of N (3-aminopropyl)-N-dodecylpropane-1,3-diamine, EDTA, chlorine and dodecan-1-ol, in the final effluent discharge from the</p>	28/02/2020

Table S1.3 Improvement programme requirements		
Reference	Requirement	Date
	<p>Effluent Treatment Plant. This monitoring programme shall be agreed in writing with the Environment Agency.</p> <p>Using the results from this monitoring programme, the Operator shall update and resubmit the impact assessment produced for emissions to surface water to the Environment Agency for approval.</p>	
IC5	<p>If the revised impact assessment submitted in IC4 shows concentrations of N (3-aminopropyl)-N-dodecylpropane-1,3-diamine, EDTA, chlorine or dodecan-1-ol to have a detrimental effect on the receiving water course the Operator shall submit a proposal for the use of alternative materials to the Environment Agency for approval.</p> <p>The proposal shall include (but not be limited to):</p> <ul style="list-style-type: none"> • alternative chemical(s) • associated impact assessment(s) for the alternative chemical(s) • detail any commissioning required for alternative chemical(s) <p>along with a timetable for implementing the changes and this shall be agreed in writing by the Environment Agency prior to implementation.</p>	30/04/2020

Schedule 2 – Waste types, raw materials and fuels

Table S2.1 Raw materials and fuels	
Raw materials and fuel description	Specification
-	-

Schedule 3 – Emissions and monitoring

Emission point ref. & location	Source	Parameter	Limit (including unit)	Reference period	Monitoring frequency	Monitoring standard or method
A1 on site plan. 17_L07-IP04B	Exhaust stack from natural gas fired CHP plant reference GG12V400A1	Oxides of Nitrogen (NO and NO ₂ expressed as NO ₂)	95 mg/m ³	In line with EA TGN M5	Every 3 years	EA TGN M5
		Carbon monoxide	No limit set	In line with EA TGN M5	Every 3 years	EA TGN M5
A2 on site plan. 17_L07-IP04B	Exhaust stack from natural gas fired steam boiler 1 reference GG12V400A1	Oxides of Nitrogen (NO and NO ₂ expressed as NO ₂)	100 mg/m ³	In line with EA TGN M5	Every 3 years	EA TGN M5
		Carbon monoxide	No limit set	In line with EA TGN M5	Every 3 years	EA TGN M5
A3 on site plan. 17_L07-IP04B	Exhaust stack from 350kW natural gas fired boilers 1-3	Combustion gases	No limit set	n/a	n/a	n/a
A4 on site plan. 17_L07-IP04B	Exhaust stack from 350kW natural gas fired boilers 4-9	Combustion gases	No limit set	n/a	n/a	n/a
A5 on site plan. 17_L07-IP04B	Exhaust stack from 350kW natural gas fired boilers 10-15	Combustion gases	No limit set	n/a	n/a	n/a
A8 on site plan. 17_L07-IP04B	Extracted air from ABP waste area treated by Bio-oxygen abatement equipment prior to release	No parameter set	No limit set	n/a	n/a	n/a
A9 on site plan. 17_L07-IP04B	Extracted air from ABP waste area treated by Bio-oxygen abatement equipment	No parameter set	No limit set	n/a	n/a	n/a

Table S3.1 Point source emissions to air – emission limits and monitoring requirements						
Emission point ref. & location	Source	Parameter	Limit (including unit)	Reference period	Monitoring frequency	Monitoring standard or method
	prior to release					
A10 on site plan. 17_L07-IP04B	Extracted air from ABP waste area treated by Bio-oxygen abatement equipment prior to release	No parameter set	No limit set	n/a	n/a	n/a
A11 on site plan. 17_L07-IP04B	Blood tank venting within main building extracted via A 9 or A 10	No parameter set	No limit set	n/a	n/a	n/a
A12 on site plan. 17_L07-IP04B	General air extraction / ventilation from module loading area	No parameter set	No limit set	n/a	n/a	n/a
A13 on site plan. 17_L07-IP04B	General air extraction / ventilation from lorry wash area	No parameter set	No limit set	n/a	n/a	n/a
A14 on site plan. 17_L07-IP04B	General air extraction / ventilation from lorry waiting area	No parameter set	No limit set	n/a	n/a	n/a
A15 on site plan. 17_L07-IP04B	Air extraction / ventilation from lairage	No parameter set	No limit set	n/a	n/a	n/a
A16 on site plan. 17_L07-IP04B	Air extraction / ventilation from lairage	No parameter set	No limit set	n/a	n/a	n/a
A17 on site plan. 17_L07-IP04B	CO ₂ extraction prior to stunning plant cleaning	CO ₂	No limit set	n/a	n/a	n/a
A18 on site plan. 17_L07-IP04B	CO ₂ extraction prior to stunning plant cleaning	CO ₂	No limit set	n/a	n/a	n/a
A19 on site plan. 17_L07-IP04B	General air extraction / ventilation from “hang-on” area	No parameter set	No limit set	n/a	n/a	n/a

Table S3.1 Point source emissions to air – emission limits and monitoring requirements

Emission point ref. & location	Source	Parameter	Limit (including unit)	Reference period	Monitoring frequency	Monitoring standard or method
A20 on site plan. 17_L07-IP04B	Emergency ammonia vent from refrigeration plant room	NH ₃	No limit set	n/a	n/a	n/a
A21 on site plan. 17_L07-IP04B	Emergency ammonia vent from refrigeration plant room	NH ₃	No limit set	n/a	n/a	n/a
A22 on site plan. 17_L07-IP04B	Air extraction from chiller units prior to product despatch.	NH ₃	No limit set	n/a	n/a	n/a
A23 on site plan. 17_L07-IP04B	Air extraction from chiller units prior to product despatch.	NH ₃	No limit set	n/a	n/a	n/a
A24 on site plan. 17_L07-IP04B	Air extraction from chiller units prior to product despatch.	NH ₃	No limit set	n/a	n/a	n/a
A25 on site plan. 17_L07-IP04B	General air extraction / ventilation from module wash area	No parameter set	No limit set	n/a	n/a	n/a
A26 on site plan. 17_L07-IP04B	General air extraction / ventilation from bleed area.	No parameter set	No limit set	n/a	n/a	n/a
A27 on site plan. 17_L07-IP04B	General air extraction / ventilation from bleed area	No parameter set	No limit set	n/a	n/a	n/a
A28 on site plan. 17_L07-IP04B	General air extraction / ventilation from AeroScalding / defeathering	No parameter set	No limit set	n/a	n/a	n/a
A29 on site plan. 17_L07-IP04B	General air extraction / ventilation from AeroScalding /	No parameter set	No limit set	n/a	n/a	n/a

Table S3.1 Point source emissions to air – emission limits and monitoring requirements						
Emission point ref. & location	Source	Parameter	Limit (including unit)	Reference period	Monitoring frequency	Monitoring standard or method
	defeathering area					
A30 on site plan. 17_L07-IP04B	General air extraction / ventilation from inspection / electrostimulation area	No parameter set	No limit set	n/a	n/a	n/a
A31 on site plan. 17_L07-IP04B	General air extraction / ventilation from evisceration room	No parameter set	No limit set	n/a	n/a	n/a
A32 on site plan. 17_L07-IP04B	General air extraction / ventilation from evisceration room	No parameter set	No limit set	n/a	n/a	n/a
A33 on site plan. 17_L07-IP04B	General air extraction / ventilation from inspection / head / foot removal area.	No parameter set	No limit set	n/a	n/a	n/a
A34 on site plan. 17_L07-IP04B	General air extraction / ventilation from Typhoon vacuum room	No parameter set	No limit set	n/a	n/a	n/a
A35 on site plan. 17_L07-IP04B	General air extraction / ventilation from wash room	No parameter set	No limit set	n/a	n/a	n/a
A36 on site plan. 17_L07-IP04B	General air extraction / ventilation from battery charging area / chemical store	No parameter set	No limit set	n/a	n/a	n/a
A37 on site plan. 17_L07-IP04B	General air extraction / ventilation from marinade wash room	No parameter set	No limit set	n/a	n/a	n/a

Table S3.1 Point source emissions to air – emission limits and monitoring requirements

Emission point ref. & location	Source	Parameter	Limit (including unit)	Reference period	Monitoring frequency	Monitoring standard or method
A38 on site plan. 17_L07-IP04B	General air extraction / ventilation from Dolav wash room	No parameter set	No limit set	n/a	n/a	n/a
A39 on site plan. 17_L07-IP04B	General air extraction / ventilation from process building void spaces	No parameter set	No limit set	n/a	n/a	n/a
A40 on site plan. 17_L07-IP04B	General air extraction / ventilation from process building void spaces	No parameter set	No limit set	n/a	n/a	n/a
A41 on site plan. 17_L07-IP04B	General air extraction / ventilation from process building void spaces	No parameter set	No limit set	n/a	n/a	n/a
A42 on site plan. 17_L07-IP04B	General air extraction / ventilation from process building void spaces	No parameter set	No limit set	n/a	n/a	n/a
A43 on site plan. 17_L07-IP04B	General air extraction / ventilation from process building void spaces	No parameter set	No limit set	n/a	n/a	n/a
A44 on site plan. 17_L07-IP04B	General air extraction / ventilation from process building void spaces	No parameter set	No limit set	n/a	n/a	n/a
A45 on site plan. 17_L07-IP04B	General air extraction / ventilation from process building void spaces	No parameter set	No limit set	n/a	n/a	n/a
A46 on site plan. 17_L07-IP04B	General air extraction / ventilation from process building void spaces	No parameter set	No limit set	n/a	n/a	n/a

Table S3.1 Point source emissions to air – emission limits and monitoring requirements						
Emission point ref. & location	Source	Parameter	Limit (including unit)	Reference period	Monitoring frequency	Monitoring standard or method
A47 on site plan. 17_L07-IP04B	General air extraction / ventilation from process building void spaces	No parameter set	No limit set	n/a	n/a	n/a
A48 on site plan. 17_L07-IP04B	Overpressure relief vent on CO ₂ storage tank	CO ₂	No limit set	n/a	n/a	n/a
A49 on site plan. 17_L07-IP04B	Hygiene chemical storage tank vent - Tribac disinfectant	No parameter set	No limit set	n/a	n/a	n/a
A50 on site plan. 17_L07-IP04B	Hygiene chemical storage tank vent – Chlorfoam Plus detergent	No parameter set	No limit set	n/a	n/a	n/a
A51 on site plan. 17_L07-IP04B	Hygiene chemical storage tank vent - TWS detergent	No parameter set	No limit set	n/a	n/a	n/a
A52 on site plan. 17_L07-IP04B	Air extraction / ventilation from effluent treatment plant screening / dewatering area via activated carbon filter.	No parameter set	No limit set	n/a	n/a	n/a

Table S3.2 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 plan 17-L07-IP02E emission to tributary of River Dove	Effluent Treatment Plant	Total suspended solids	15 mg/l	24 hour flow proportionate composite sample	Weekly	BS EN 872
W1 on site plan 17-L07-IP02E emission to	Effluent Treatment Plant	BOD	20 mg/l until 31/05/2020	24 hour flow proportionate composite sample	Weekly	BS EN 1899-2

Table S3.2 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
tributary of River Dove						
W1 on site plan 17-L07-IP02E emission to tributary of River Dove	Effluent Treatment Plant	BOD	10 mg/l from 01/06/2020	24 hour flow proportionate composite sample	Weekly	BS EN 1899-2
W1 on site plan 17-L07-IP02E emission to tributary of River Dove	Effluent Treatment Plant	COD	40 mg/l	24 hour flow proportionate composite sample	Weekly	BS ISO 15705
W1 on site plan 17-L07-IP02E emission to tributary of River Dove	Effluent Treatment Plant	Ammonia	3 mg/l	24 hour flow proportionate composite sample	Weekly	BS EN ISO 11732 or ISO 7150-1 or BS 6068-2.7 or ISO 5664 or BS 6068-2.10 ISO 6778
W1 on site plan 17-L07-IP02E emission to tributary of River Dove	Effluent Treatment Plant	Total Nitrogen	No limit applies	24 hour flow proportionate composite sample	Monthly	BS EN ISO 11905-1 or BS EN 12260 or BS ISO 29441
W1 on site plan 17-L07-IP02E emission to tributary of River Dove	Effluent Treatment Plant	Total Phosphorus	2 mg/l	24 hour flow proportionate composite sample	Weekly	BS EN ISO 15681-1
W1 on site plan 17-L07-IP02E emission to tributary of River Dove	Effluent Treatment Plant	Iron	2 mg/l	24 hour flow proportionate composite sample	Weekly	BS EN ISO 11885 or BS EN ISO 17294-1 or BS EN ISO 17294-2 or BS EN ISO 15586
W1 on site plan 17-L07-IP02E emission to tributary of River Dove	Effluent Treatment Plant	Chloride	250 mg/l	24 hour flow proportionate composite sample	Weekly	BS EN ISO 15682

Table S3.2 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 plan 17-L07-IP02E emission to tributary of River Dove	Effluent Treatment Plant	Sulphate	400 mg/l	24 hour flow proportionate composite sample	Weekly	BS ISO 15923-1
W1 on site plan 17-L07-IP02E emission to tributary of River Dove	Effluent Treatment Plant	Polyacrylamide	0.5 mg/l	24 hour flow proportionate composite sample	Weekly	
W1 on site plan 17-L07-IP02E emission to tributary of River Dove	Effluent Treatment Plant	pH	Range 6-9	24 hour flow proportionate composite sample	Daily	
W1 on site plan 17-L07-IP02E emission to tributary of River Dove	Effluent Treatment Plant	Total daily volume of discharge	1200 m ³ /day	24 hour total	Continuous	MCERTS self-monitoring of effluent flow scheme
W2 on site plan 17-L07-IP02E emission to tributary of River Dove	Effluent treatment plant and domestic outflows combined with surface and roof water	No Parameter set	No limit applies	n/a	n/a	n/a

Schedule 4 – Reporting

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

Parameter	Emission or monitoring point/reference	Reporting period	Period begins
Emissions to air Parameters as required by condition 3.5.1.	A1 and A2	4 months from date of issue of permit then Every 3 years	1 January
Emissions to water Parameters as required by condition 3.5.1	W1	Every quarter	1 January, 1 April, 1 July and 1 October.

Parameter	Units
Weight of chicken processed on site	tonnes

Parameter	Frequency of assessment	Units
Water usage	Annually	m ³ /t
Energy usage	Annually	MWh

Media/parameter	Reporting format	Date of form
Air	Form air 1 or other form as agreed in writing by the Environment Agency	30/01/2020
Water and Land	Form water 1 or other form as agreed in writing by the Environment Agency	30/01/2020
Water usage	Form water usage 1 or other form as agreed in writing by the Environment Agency	30/01/2020
Energy usage	Form energy 1 or other form as agreed in writing by the Environment Agency	30/01/2020
Other performance indicators	Form performance 1 or other form as agreed in writing by the Environment Agency	30/01/2020

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.

“background concentration” means such concentration of that substance as is present in:

- for emissions to surface water, the surface water quality up-gradient of the site; or
- for emissions to sewer, the surface water quality up-gradient of the sewage treatment works discharge.

“D or disposal”. Means any of the operations provided for in Annex I to Directive 2008/98/EC of the European Parliament and of the Council on waste.

“emissions to land” includes emissions to groundwater.

“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.

“Hazardous property” has the meaning in Annex III of the Waste Framework Directive.

“Hazardous waste” has the meaning given in the Hazardous Waste (England and Wales) Regulations 2005 (as amended).

“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.

“Medium Combustion Plant” or “MCP” means a combustion plant with a rated thermal input equal to or greater than 1 MW but less than 50 MW.

“Medium Combustion Plant Directive” or “MCPD” means Directive 2015/2193/EU of the European Parliament and of the Council on the limitation of emissions of certain pollutants into the air from medium combustion plants.

Pests” means Birds, Vermin and Insects.

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

“recovery” means any of the operations provided for in Annex II to Directive 2008/98/EC of the European Parliament and of the Council on waste.

“Waste Framework Directive” or “WFD” means Waste Framework Directive 2008/98/EC of the European Parliament and of the Council on waste

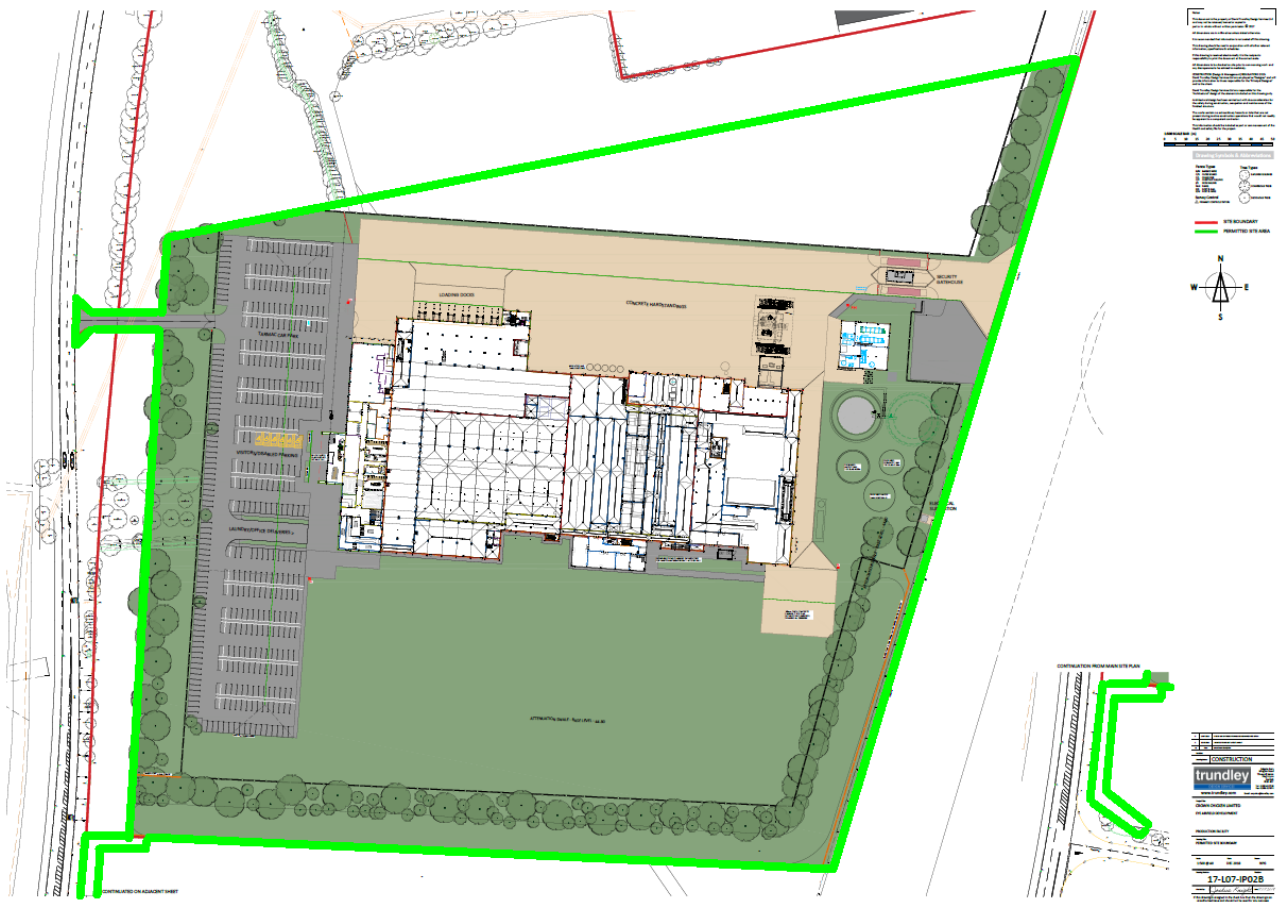
Where a minimum limit is set for any emission parameter, for example pH, reference to exceeding the limit shall mean that the parameter shall not be less than that limit.

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 other than gas engines or gas turbines, 6% dry for solid fuels; and/or
- in relation to emissions from gas engines or gas turbines, the concentration in dry air at a temperature of 273K, at a pressure of 101.3 kPa and with an oxygen content of 15% dry for liquid and gaseous 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