

Notice of variation and consolidation with introductory note

The Environmental Permitting (England & Wales) Regulations 2016

Cargill PLC

Gladstone Dock Vegetable Extraction and Refining Plant
2 Gladstone Dock
Seaforth
Merseyside
L20 1BG

Variation application number

EPR/BN4169IZ/V007

Permit number

EPR/BN4169IZ

Gladstone Dock Vegetable Extraction and Refining Plant

Permit number EPR/BN4169IZ

Introductory note

This introductory note does not form a part of the notice

Under the Environmental Permitting (England & Wales) Regulations 2016 (schedule 5, part 1, paragraph 19) a variation may comprise a consolidated permit reflecting the variations and a notice specifying the variations included in that consolidated permit.

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

The Gladstone Dock installation operated by Cargill PLC is permitted to process 700,000 tonnes of soya beans per annum to extract 120,000 tonnes of crude oil per year. The installation produces crude oil, hulls pellets and meal for animal feed from imported Soya beans.

Changes introduced by this variation made by the operator (V007)

This variation authorises the following:

- Increase in annual process throughput of soya beans from 700,000 tonnes to 1,000,000 tonnes.
- Relocation of emission point A5 and a net reduction in the number of emission points to air from 19 to 18.
- Lower new emission limit values for particulate emissions from emission points A3 to A18, except A14. The new emission limit values are in line with Best Available Techniques for the sector. Whilst the operator is currently compliant with the hexane BAT-AEL, we have not introduced a new limit at this stage as that will be updated as part of the FDM sector permit review.
- Extension of the existing site boundary to accommodate two new buildings – The Bean and Hull Building and the Meal Sifting and Grinding Building.

This variation will not change the overall process onsite, however, new equipment will be installed within the new buildings to accommodate the increase in soya bean processing capacity. There are no new point source emissions to surface water and sewer from this variation. The variation does not introduce any new chemicals to be used onsite and does not involve any change to the Refinery activity.

Brief description of the process

Soya beans are received at the neighbouring grain silos and enter the site via a transfer conveyor and into storage Silos. The beans are then drawn into the process, screened, cleaned and heated to control the moisture content before being passed into a bean cracking process to split the beans and remove the hulls. The hulls are then separated through aspiration and cyclones, prepared and pelletised for onward sale as animal feed.

The surface of the cracked bean is then increased in a flaker so that the efficiency of the solvent extraction stage is increased. A portion of the flaked bean is also expanded before being passed to the extractor. The flaked beans are washed with hexane to dissolve the oil. The products from the extraction stage are a hexane/oil mixture called miscella and a soya bean meal containing hexane.

The solvent is removed from the soya bean meal by the direct and indirect application of steam in a desolventiser toaster. The resulting de-natured meal is dried, cooled, screened further and ground in a new process building before being stored and subsequently sold on as animal feed.

The miscella is passed through a series of evaporative steps to remove the solvent from the oil. The solvent is recovered for re-use through condensers and a mineral oil absorption system. The solvent-free oil is passed to a degumming process to leave a crude oil. The gums will no longer be dried and sold but added back to the meal in the desolventiser toaster. The crude oil is passed on to the adjacent refinery.

The schedules specify the changes made to the permit.

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

Status log of the permit		
Description	Date	Comments
Application received EPR/BN4169IZ/A001	Duly Made 22/03/2005	
Additional information received	28/09/2005	
Additional information received	02/12/2005	
Permit determined EPR/BN4169IZ	24/03/2006	Original permit issued to Cargill PLC
Application EPR/BN4169IZ/V002	Duly Made 26/03/2009	
Application EPR/BN4169IZ/V002	Withdrawn	
Application EPR/BN4169IZ/V003 (Variation and consolidation)	Duly made 07/02/2011	Application to vary and update the permit to modern conditions.
Variation determined EPR/BN4169IZ	28/03/2011	Variation permit issued
Application EPR/BN4169IZ/V004	Duly made 14/10/2013	Application to incorporate a second Deodorizer, boiler replacement and associated equipment upgrades
Variation determined EPR/BN4169IZ	23/12/2013	Varied permit issued
Notified of change of company registered office address	27/01/2016	Registered office address changed to Velocity V1, Brooklands Drive, Weybridge, Surrey, KT13 0SL
Variation issued EPR/BN4169IZ/V005	02/02/2016	Varied permit issued
Application EPR/BN41669IZ/V006	Withdrawn 14/08/2019	Application withdrawn.
Application EPR/BN4169IZ/V007 (variation and consolidation)	Duly made 14/09/2020	Variation to increase soya bean processing capacity of the plant, extend the site boundary, relocate some emission points to air and change the emission limit values for particulate emission points to air in line with BAT.
Additional information received	20/10/2020	Revised permit application report - 8548-G018-011001 – 2.
Schedule 5 Notice response received.	09/06/2021	Response to questions 1 to 4 of Information Notice dated 03/12/2020. Associated documents include:

Status log of the permit		
Description	Date	Comments
		<ul style="list-style-type: none"> - 43148-WOOD-XX-XX-RP-O-0009_A_C1 Air Quality Assessment - BAT Assessment - Finished oil tank bund assessment (summary) - R9889 Environmental Noise Assessment
Additional information received	21/07/2021	43148-WOOD-XX-XX-RP-O-0010_A_C1 Air quality addendum submitted in response to questions regarding how the emission rates from the point source emissions to air were calculated for the existing and proposed sources.
Additional information received	08/09/2021	Updated site plan.
Variation determined and consolidation issued EPR/BN4169IZ (Billing Ref: EP3602BS)	16/12/2021	Varied and consolidated permit issued in a modern format.

End of introductory note

Notice of variation and consolidation

The Environmental Permitting (England and Wales) Regulations 2016

The Environment Agency in exercise of its powers under regulation 20 of the Environmental Permitting (England and Wales) Regulations 2016 varies

Permit number

EPR/BN4169IZ

Issued to

Cargill PLC (“the operator”)

whose registered office is

Velocity V1

Brooklands Drive

Weybridge

Surrey

KT13 0SL

company registration number 01387437

to operate a regulated facility at

Gladstone Dock Vegetable Extraction and Refining Plant

2 Gladstone Dock

Seaforth

Merseyside

L20 1BG

to the extent set out in the schedules.

The notice shall take effect from 16/12/2021

Name	Date
Claire Roberts	16/12/2021

Authorised on behalf of the Environment Agency

Schedule 1

All conditions have been varied by the consolidated permit EPR/BN4169IZ/V007

Schedule 2 – consolidated permit

Consolidated permit issued as a separate document.

Permit

The Environmental Permitting (England and Wales) Regulations 2016

Permit number

EPR/BN4169IZ

This is the consolidated permit referred to in the variation and consolidation notice for application EPR/BN4169IZ/V007 authorising,

Cargill PLC (“the operator”),

whose registered office is

Velocity V1

Brooklands Drive

Weybridge

Surrey

KT13 0SL

company registration number 01387437

to operate an installation at

Gladstone Dock Vegetable Extraction and Refining Plant

2 Gladstone Dock

Seaforth

Merseyside

L20 1BG

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

Name	Date
Claire Roberts	16/12/2021

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 Pre-operational conditions

- 2.4.1 The operations specified in schedule 1 table S1.3 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 and S3.3.

- 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.
- 3.2.3 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.
- 3.3.2 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 and S3.3.
- 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.
- 4.2.5 The operator shall submit an annual solvent management plan in order to demonstrate compliance with the requirements of the Industrial Emissions Directive, by 31 January each year in respect of the previous year.

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 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.
- 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

Activity listed in Schedule 1 of the EP Regulations	Description of specified activity	Limits of specified activity
Section 6.8 Part A(1)(d)(ii) Treatment and processing vegetable raw materials intended for the production of food or feed with a finished product production capacity greater than 300 tonnes per day.	Processing of soya beans for extraction of oil content of bean, production of soya meal from extraction, production of hulls pellets, production of Lecithin, refining of crude oil from extraction.	From receipt of raw materials to despatch of finished product.
Directly Associated Activity		
Steam generation	Generation of steam using 1 x 0.467MWth and 1 x 0.233MWth gas fired high pressure refinery boilers.	Combustion of natural gas in 2 boilers with a rated thermal input of less than 1MWth.
Waste storage and disposal	Storage and disposal of wastes.	Receipt of raw materials to disposal of waste products.

Table S1.2 Operating techniques		
Description	Parts	Date Received
Application	The response to questions 2.1 and 2.2 given in pages 11 to 43 of the Application.	22/03/2005
Request for further information	A description of air emission point A18; details of mercury and cadmium concentrations present in sodium hydroxide; a copy of the site installation drainage and site emission points.	29/09/2005
Request for further information	Information on the following: releases from the Bean Conditioning Solvent Extraction Process; the pre-desolventising deck; emissions from the Dryer Cooler; fines from the Distillation process; water used for cooling in Hexane recovery; the handling of rapeseed oil and palm oil; operation of the reverse jet bag filters; the use of the contact water in the condensers; the required temperature range of oil in the neutralising process; a description of the scrubbing system for the Deodorising plant; controls within the skim pit; Loading/Unloading area controls for rainwater; the new cooling systems; abatement plant for VOC emissions; method of abatement for Emission Point Air 55; tonnage of hexane released from the plant.	02/12/2005
Application for variation	Response to 2b of part C2 of the application and supporting documents 1 and 2.	07/02/2011
Application for variation	Non-technical Summary and supporting document 23143-Addendum	14/10/2013
Response to Schedule 5 Notice dated 03/12/2020	<ul style="list-style-type: none"> - Finished oil Tank bund assessment summary - BAT Assessment - Compliance and operating techniques identified in response to BAT Conclusions 	09/06/2021

Table S1.2 Operating techniques		
Description	Parts	Date Received
	5, 6, 17, 30, 31 and 32 in the Food and Drink BAT conclusions published in 2019.	

Table S1.3 Pre-operational measures for future development		
Reference	Operation	Pre-operational measures
1	Treatment at the new capacity of 1,000,000 tonnes per annum and operation of all new equipment within the new Bean and Hull Building as well as the Meal Sifting and Grinding Building, including the new grinders and hulls pellet cooler exhaust fan	<p>Prior to the commencement of treatment at the new capacity of 1,000,000 tonnes per annum and operation of all new equipment within the new buildings, the operator shall demonstrate that the impact of noise emissions from the installation are insignificant by submitting a report to the Environment Agency for approval.</p> <p>This report shall include but not be limited to:</p> <p>Details of the improvements that have been made to operations, plant and equipment in line with the recommendations under section 9 of the submitted Environmental Noise Assessment, with Report Number – R9889, dated 3 June 2021.</p> <p>A comprehensive noise impact assessment for the whole site undertaken by an experienced and suitably qualified person (i.e. a noise consultant with an appropriate qualification accredited by the Institute of Acoustics), in accordance with BS4142:2014 (Rating industrial noise affecting mixed residential and industrial areas). The report must demonstrate that no significant noise pollution is caused by the operation of the site (all site operations) at local sensitive receptors.</p> <p>Details demonstrating that noise attenuation measures and procedures are in compliance with the requirements of BAT for this type of installation. These measures and procedures will be implemented in accordance with Environment Agency’s written approval.</p> <p>The operator shall submit the report to the Environment Agency with at least fourteen days’ notice before the planned operation of the new plants and the proposed increase in processing capacity.</p> <p>No increase in processing capacity or operation of new plant will be carried out at the facility unless the Environment Agency has given prior written permission under this condition.</p>
2	Treatment at the new capacity of 1000000 tonnes per annum and operation of all new equipment within the new Bean and Hull Building as well as the Meal Sifting and Grinding Building, including the new grinders and hulls pellet cooler exhaust fan	<p>Prior to the commencement of treatment at the new capacity of 1000000 tonnes per annum and operation of all new equipment within the new buildings, the operator shall produce a comprehensive Noise Management Plan (NMP) in accordance with our <u>Noise and vibration management: environmental permits guidance</u>, for approval in writing by the Environment Agency.</p> <p>The operator shall implement the approved NMP and regularly review the plan in accordance with our guidance.</p>

Table S1.3 Pre-operational measures for future development		
Reference	Operation	Pre-operational measures
		<p>Our Noise and Vibration guidance can be found via the link:https://www.gov.uk/government/publications/noise-and-vibration-management-environmental-permits</p> <p>The operator shall submit the Noise Management Plan to the Environment Agency with at least fourteen days' notice before the planned operation of the new plants and the proposed increase in processing capacity.</p> <p>No increase in processing capacity or operation of new plant will be carried out at the facility unless the Environment Agency has given prior written permission under this condition.</p>

Schedule 2 – Waste types, 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						
Emission point ref. & location	Source	Parameter ²	Limit (including unit)	Reference period	Monitoring frequency	Monitoring standard or method
A3 as reflected in the Proposed Emission Point Plan submitted with Application EPR/BN4169IZ/V007	Preparation Main Filter Exhaust	Particulate Matter	5 mg/m ³	Average over sampling period	Once every year	BS EN 13284-1 (unless otherwise agreed in writing with the Environment Agency).
A4 as reflected in the Proposed Emission Point Plan submitted with Application EPR/BN4169IZ/V007	Pelletising Mill Cooler Exhaust		20 mg/m ³			
A5 as reflected in the Proposed Emission Point Plan submitted with Application EPR/BN4169IZ/V007	Meal Grinding Aspiration Filter Exhaust		5 mg/m ³			
A6 as reflected in the Proposed Emission Point Plan submitted with Application EPR/BN4169IZ/V007	Extraction Air Break		5 mg/m ³			
A7 as reflected in the Proposed Emission Point Plan submitted with Application EPR/BN4169IZ/V007	Vertical Seed Conditioner Exhaust		20 mg/m ³			
A8 as reflected in the Proposed Emission Point Plan submitted with Application EPR/BN4169IZ/V007	Secondary de-hulling Aspiration Filter		5 mg/m ³			
A9 as reflected in the Proposed Emission Point Plan submitted with Application EPR/BN4169IZ/V007	Expander Aspiration Fan		20 mg/m ³			
A10 as reflected in the Proposed Emission Point Plan submitted with Application EPR/BN4169IZ/V007	Hot DC Exhaust fan from drying deck		20 mg/m ³			
A11 as reflected in the Proposed Emission Point Plan	Hot DC Exhaust fan from drying deck		20 mg/m ³			

Table S3.1 Point source emissions to air – emission limits and monitoring requirements						
Emission point ref. & location	Source	Parameter²	Limit (including unit)	Reference period	Monitoring frequency	Monitoring standard or method
submitted with Application EPR/BN4169IZ/V007						
A12 as reflected in the Proposed Emission Point Plan submitted with Application EPR/BN4169IZ/V007	Hot DC Exhaust fan from drying deck		20 mg/m ³			
A13 as reflected in the Proposed Emission Point Plan submitted with Application EPR/BN4169IZ/V007	Hot DC Exhaust fan from cooling deck		20 mg/m ³			
A15 as reflected in the Proposed Emission Point Plan submitted with Application EPR/BN4169IZ/V007	Hulls Grinding Aspiration Filter Exhaust		5 mg/m ³			
A16 as reflected in the Proposed Emission Point Plan submitted with Application EPR/BN4169IZ/V007	Flaker Aspiration Cyclone Exhaust		20 mg/m ³			
A17 as reflected in the Proposed Emission Point Plan submitted with Application EPR/BN4169IZ/V007	Cascade Dryer Exhaust		20 mg/m ³			
A18 as reflected in the Proposed Emission Point Plan submitted with Application EPR/BN4169IZ/V007	Cascade Conditioner Exhaust		20 mg/m ³			
A14 as reflected in the Proposed Emission Point Plan submitted with Application EPR/BN4169IZ/V007	Extraction Final Vent	Hexane	2kg/hour	Rolling monthly average	Continuous	Infrared transmitter
Installation	Installation	Hexane	0.8kg/tonne of soya beans processed.	Yearly average	Annual	Solvent Management Plan

Table S3.2 Point Source emissions to water (other than sewer) and land – emission limits and monitoring requirements					
Emission point ref. & location	Parameter	Limit (incl. unit)	Reference Period	Monitoring frequency	Monitoring standard or method
W1	Endosulphan	200 ng/l above the inlet dock water concentration	Rolling annual average	Monthly ⁽²⁾	BS EN ISO 6468:1997
	Aldrin	15 ng/l above the inlet dock water concentration	Rolling annual average	Monthly ⁽²⁾	BS EN ISO 6468:1997
	Lindane (hexachlorocyclohexane)	30 ng/l above the inlet dock water concentration	Rolling annual average	Monthly ⁽²⁾	BS EN ISO 6468:1997
	DDT (Dichlorodiphenyltrichloro ethane)	10 ng/l above the inlet dock water concentration	Rolling annual average	Monthly ⁽²⁾	BS EN ISO 6468:1997
	Chemical Oxygen Demand	125 mg/l above the inlet dock water concentration	Spot sample or flow-proportional composite sample	Monthly ⁽¹⁾	ISO 6060
	Suspended Solids	45 mg/l above the inlet dock water concentration	Spot sample or flow-proportional composite sample	Monthly ⁽¹⁾	ISO 11929
	pH	Maximum - 9 Minimum - 6	---	Continuous	BS6068- 2.50: 1995
W1, W2 & W3	Temperature	Maximum 30°C	---	Continuous	Temperature Probe

Note (1): Analysis shall be undertaken on a weekly composite sample from the automatic sampler

Note (2): An analysis for the specified parameter shall be carried out once per month on a weekly composite sample taken from the automatic sampler

Table S3.3 Point source emissions to sewer, effluent treatment plant or other transfers off-site– emission limits and monitoring requirements						
Emission point ref. & location¹	Source	Parameter	Limit (incl. Unit)	Reference period	Monitoring frequency	Monitoring standard or method
S1 – Emission to Rimrose Brook Sewer	Refinery Plant	No parameters set	---	---	---	---
S2 - Emission to Rimrose Brook Sewer	Crush Plant	No parameters set	---	---	---	---

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
Emissions to air Parameters as required by condition 3.5.1.	A3 to A13 and A15 to A18	Every 12 months	1 January
Emissions to water and land Parameters as required by condition 3.5.1.	W1, W2 and W3	Quarterly	1 January, 1 April, 1 July, 1 October
Hexane kg/hr	A14	Quarterly	1 January, 1 April, 1 July, 1 October

Table S4.2: Annual production/treatment	
Parameter	Units
Production of finished product (crude oil, edible vegetable oil, lecithin and animal feed)	tonnes
Input of Soya Bean	tonnes

Table S4.3 Performance parameters		
Parameter	Frequency of assessment	Units
Water usage	Annually	tonnes
Energy usage	Annually	MWh
Total raw material used	Annually	tonnes
Waste disposed and recovered	Annually	tonnes

Table S4.4 Reporting forms		
Media/parameter	Reporting format	Date of form
Air	Form air 1 or other form as agreed in writing by the Environment Agency	28/03/2011
Water and Land	Form water 1 or other form as agreed in writing by the Environment Agency	28/03/2011
Water usage	Form water usage 1 or other form as agreed in writing by the Environment Agency	28/03/2011
Energy usage	Form energy 1 or other form as agreed in writing by the Environment Agency	28/03/2011
Other performance indicators	Form performance 1 or other form as agreed in writing by the Environment Agency	28/03/2011

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.

“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.

“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.

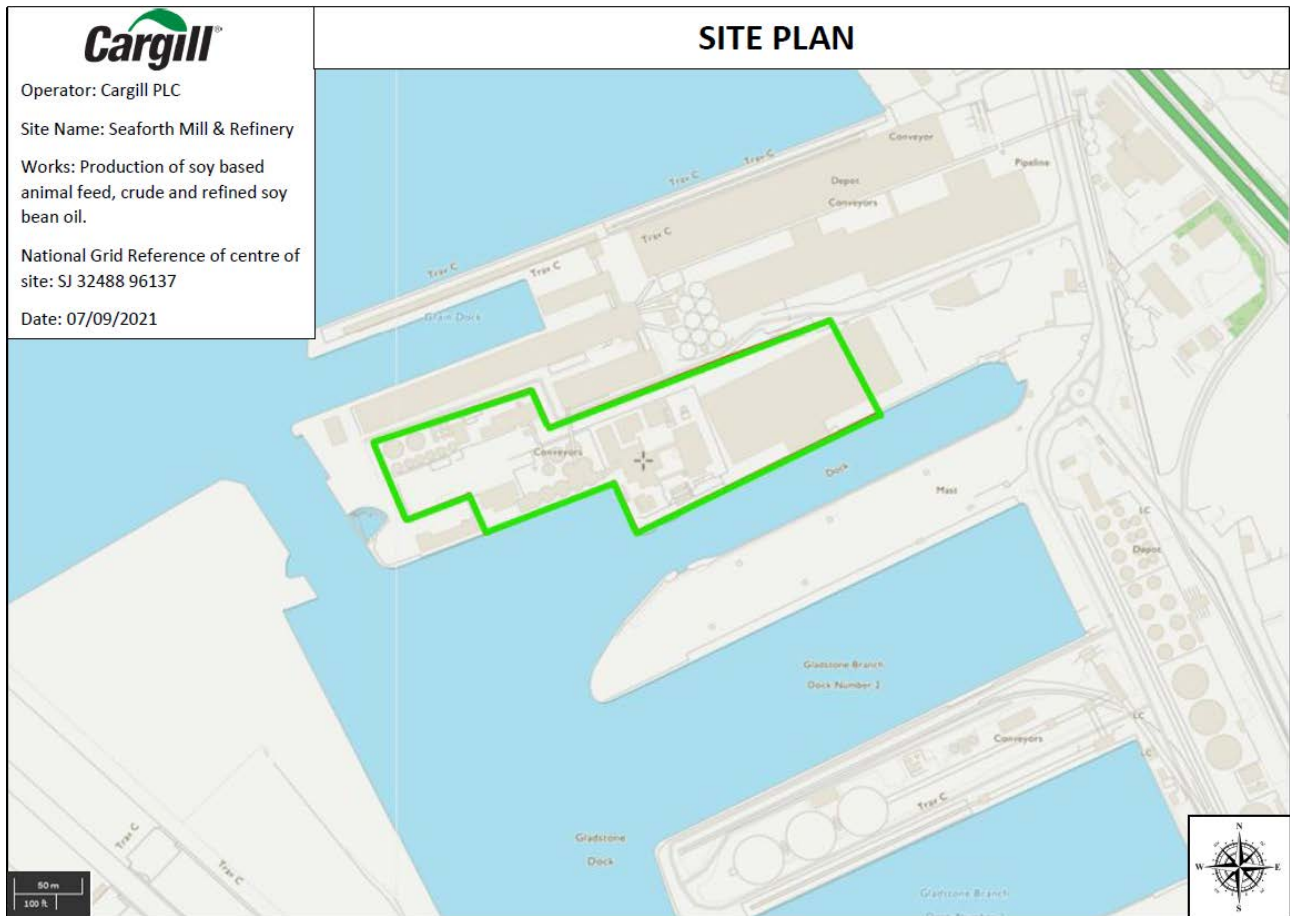
Where a minimum limit is set for any emission parameter, for example pH, reference to exceeding the limit shall mean that the parameter shall not be less than that limit.

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.