

# Notice of variation and consolidation with introductory note

The Environmental Permitting (England & Wales) Regulations 2016

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AB Agri Limited  
Walsingham Animal Feed Mill  
Bunkers Hill  
Egmere  
Walsingham  
Norfolk  
NR22 6BD

**Variation application number**

EPR/NP3232SQ/V003

**Permit number**

EPR/NP3232SQ

# Walsingham Animal Feed Mill

## Permit number EPR/NP3232SQ

### 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.

This consolidated permit has been issued following a full review against the best available techniques (BAT) conclusions for the Food, Drink and Milk Industries published on 4<sup>th</sup> December 2019 in the official journal of the European Union.

We have implemented the requirements of the Medium Combustion Plant Directive and incorporated post-dated requirements for 2030.

The schedules specify the changes made to the permit.

We consider that in reaching our decision to vary the permit we have taken into account all relevant considerations and legal requirements. We are satisfied that the permit will ensure that a high level of protection is provided for the environment and human health and that the activities will not give rise to any significant pollution of the environment or harm to human health.

The main features of the permit are as follows.

The Environmental Permit is for the main listed activity falling under Section 6.8 Part A(1)(d)(ii) of the Environmental Permitting Regulations: *Treatment and processing of only vegetable raw materials, for the intended production of animal feed, at a plant with a finished product capacity greater than 300 tonnes per day.*

The installation manufactures compound animal feeds that are suitable for consumption by an animal without further processing. The products manufactured are based upon core formulations of cereals (such as wheat and barley), soya, rape seed and sugar beet, plus specific additives, such as mineral supplements. The processing is undertaken to a specific formulation on a batch basis, with the key stages being weighing, grinding, mixing, conditioning, pressing, cooling and coating. There is also a standalone flaking plant in the installation, which produces flakes of cereal grains for use in the process or for direct sale to customers.

Depending upon the specific formulation, the required cereals are weighed out prior to grinding to a uniform grist size. The ground materials are then transferred to the mixing stage of the process, where they are mixed with pre weighed supplements and medicinal feed additives used for prophylactic and therapeutic treatment. Following this, the mix is conditioned through the addition of steam to eliminate any bacteria present and to improve the workability of the mix.

After conditioning the hot mix is conveyed to press lines, where it is extruded through dies to produce pellets. The hot pellets are then passed through a counter flow air cooler to reduce their temperature, causing them to harden and become durable. The majority of the pellets are subsequently coated in fat to produce the finished product, however some of the pellets are crumbed prior to coating with fats. Pelleted product is used as feed for larger animals, such as pigs whilst crumbed product is used as chicken and turkey feed. The finished product is then stored in silos prior to being automatically loaded to bulk vehicles for delivery to customers on an as required basis.

The finished product production plant capacity is 1,440 tonnes per day.

The main emissions to air arise from the raw material grinders and product coolers.

The process uses a low volume of water and generates a small volume of effluent which is discharged along with the vehicle washings to a holding tank. Rainwater and boiler blowdown is collected and discharged via the surface water drainage system to a soakaway.

The installation stores a number of raw materials (molasses, biocide, vegetable fat, soya oil, enzyme, amino acid, choline chloride) and fuel (diesel and gas oil) in bulk.

Other associated activities that take place within the installation are the operation of the boiler plant for steam raising, storage and handling of raw materials and wastes and vehicle washing.

The site participates in a Climate Change Agreement (CCA) and has an accredited environmental management system.

There is human presence within 150m of the installation boundary. There is no SSSI within 2km. The Wash & North Norfolk Coast SPA/SAC is within 10km.

<b>Status log of the permit</b>		
<b>Description</b>	<b>Date</b>	<b>Comments</b>
Application received EPR/NP3232SQ/A001	Duly made 31/03/05	
Additional information received	02/08/05	
Additional information received	01/09/05	
Permit determined EPR/NP3232SQ	04/11/05	Original permit issued to ABNA Limited.
Variation application EPR/NP3232SQ/V002	Duly made 15/03/12	Application to vary the permit to add a new gas boiler, power supply/mains transformer and new heated meal production line.
Additional information received	19/04/12	Amended application with confidential information removed.
Additional information received	19/04/12	Response to Schedule 5 Notice dated 23/03/12.
Variation determined EPR/NP3232SQ	24/05/12	Varied permit issued to AB Agri Limited
Application EPR/NP3232SQ/V003	Regulation 61 response received 23/07/21	Environment Agency initiated variation and consolidation following the Food, Drink & Milk Industries sector permit review.
Variation determined and consolidation issued EPR/NP3232SQ (Billing ref. VP3708MD).	11/05/22	Varied and consolidated permit issued in 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/NP3232SQ

### Issued to

**AB Agri Limited** (“the operator”)

whose registered office is

**Weston Centre**  
**10 Grosvenor Street**  
**London**  
**W1K 4QY**

company registration number 00193800

to operate a regulated facility at

**Walsingham Animal Feed Mill**  
**Bunkers Hill**  
**Egmere**  
**Walsingham**  
**Norfolk**  
**NR22 6BD**

to the extent set out in the schedules.

The notice shall take effect from 11/05/2022

Name	Date
Anne Lloyd	11/05/2022

Authorised on behalf of the Environment Agency

## **Schedule 1**

All conditions have been varied by the consolidated permit as a result of an Environment Agency initiated variation.

## **Schedule 2 – consolidated permit**

Consolidated permit issued as a separate document.

# Permit

## The Environmental Permitting (England and Wales) Regulations 2016

### Permit number

**EPR/NP3232SQ**

This is the consolidated permit referred to in the variation and consolidation notice for application EPR/NP3232SQ/V003 authorising,

**AB Agri Limited** (“the operator”),

whose registered office is

**Weston Centre  
10 Grosvenor Street  
London  
W1K 4QY**

company registration number 00193800

to operate an installation at

**Walsingham Animal Feed Mill  
Bunkers Hill  
Egmere  
Walsingham  
Norfolk  
NR22 6BD**

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

Name	Date
Anne Lloyd	11/05/2022

Authorised on behalf of the Environment Agency

# Conditions

## 1 Management

### 1.1 General management

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

### 1.2 Energy efficiency

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

### 1.3 Efficient use of raw materials

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

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

- 1.4.1 The operator shall take appropriate measures to ensure that:
- (a) the waste hierarchy referred to in Article 4 of the Waste Framework Directive is applied to the generation of waste by the activities; and
  - (b) any waste generated by the activities is treated in accordance with the waste hierarchy referred to in Article 4 of the Waste Framework Directive; and
  - (c) where disposal is necessary, this is undertaken in a manner which minimises its impact on the environment.
- 1.4.2 The operator shall review and record at least every four years whether changes to those measures should be made and take any further appropriate measures identified by a review.

## **2 Operations**

### **2.1 Permitted activities**

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

### **2.2 The site**

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

### **2.3 Operating techniques**

2.3.1 The activities shall, subject to the conditions of this permit, be operated using the techniques and in the manner described in the documentation specified in schedule 1, table S1.2, unless otherwise agreed in writing by the Environment Agency.

2.3.2 If notified by the Environment Agency that the activities are giving rise to pollution, the operator shall submit to the Environment Agency for approval within the period specified, a revision of any plan or other documentation (“plan”) specified in schedule 1, table S1.2 or otherwise required under this permit which identifies and minimises the risks of pollution relevant to that plan, and shall implement the approved revised plan in place of the original from the date of approval, unless otherwise agreed in writing by the Environment Agency.

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

2.3.4 The operator shall ensure that where waste produced by the activities is sent to a relevant waste operation, that operation is provided with the following information, prior to the receipt of the waste:

- (a) the nature of the process producing the waste;
- (b) the composition of the waste;
- (c) the handling requirements of the waste;
- (d) the hazardous property associated with the waste, if applicable; and
- (e) the waste code of the waste.

2.3.5 The operator shall ensure that where waste produced by the activities is sent to a landfill site, it meets the waste acceptance criteria for that landfill.

### **2.4 Improvement programme**

2.4.1 The operator shall complete the improvements specified in schedule 1 table S1.3 by the date specified in that table unless otherwise agreed in writing by the Environment Agency.

2.4.2 Except in the case of an improvement which consists only of a submission to the Environment Agency, the operator shall notify the Environment Agency within 14 days of completion of each improvement.

## **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 and relevant plant referenced in schedule 1, table S1.1: AR2; The first monitoring measurements shall be carried out within four months of 01/01/2030 or of 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.
- 3.3.2 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 and S3.2;
  - (b) process monitoring requirements specified in table 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.

## 4.3 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.
- In any other case:
- (a) the death of any of the named operators (where the operator consists of more than one named individual);
  - (b) any change in the operator's name(s) or address(es); and
  - (c) any steps taken with a view to the operator, or any one of them, going into bankruptcy, entering into a composition or arrangement with creditors, or, in the case of them being in a partnership, dissolving the partnership.
- 4.3.5 Where the operator proposes to make a change in the nature or functioning, or an extension of the activities, which may have consequences for the environment and the change is not otherwise the subject of an application for approval under the Regulations or this permit:
- (a) the Environment Agency shall be notified at least 14 days before making the change; and
  - (b) the notification shall contain a description of the proposed change in operation.
- 4.3.6 The Environment Agency shall be given at least 14 days' notice before implementation of any part of the site closure plan.
- 4.3.7 Where the operator has entered into a climate change agreement with the Government, the Environment Agency shall be notified within one month of:
- (a) a decision by the Secretary of State not to re-certify the agreement;
  - (b) a decision by either the operator or the Secretary of State to terminate the agreement; and
  - (c) any subsequent decision by the Secretary of State to re-certify such an agreement.

## **4.4 Interpretation**

- 4.4.1 In this permit the expressions listed in schedule 6 shall have the meaning given in that schedule.
- 4.4.2 In this permit references to reports and notifications mean written reports and notifications, except where reference is made to notification being made "immediately", in which case it may be provided by telephone.

# Schedule 1 – Operations

<b>Table S1.1 activities</b>			
<b>Activity reference</b>	<b>Activity listed in Schedule 1 of the EP Regulations</b>	<b>Description of specified activity</b>	<b>Limits of specified activity</b>
AR1	Section 6.8 Part A(1)(d)(ii)	Treatment and processing of only vegetable raw materials, intended for the production of food or feed at a plant with a finished product production capacity greater than 300 tonnes per day.	From receipt of raw materials through to storage of final product. Production capacity is limited to 1440 tonnes per day.
<b>Directly Associated Activity</b>			
AR2	Steam raising and water heating plant.	Operation of three boilers on-site, fired by natural gas, with an aggregated net rated thermal input of 4.2 MWth as follows: 1 x 1.4MWth (MCP) 1 x 0.9 MWth 1 x 1.9 MWth (MCP)	From receipt of fuel to release of products of combustion to air.
AR3	Waste storage and handling	Storage and handling of waste materials	From generation of waste to storage pending removal for disposal or recovery.
AR4	Vehicle washing	Washing of vehicles within a designated area of the permitted installation	From operation of vehicle wash facilities to collection of wash waters in a holding tank prior to removal off-site.

<b>Table S1.2 Operating techniques</b>		
<b>Description</b>	<b>Parts</b>	<b>Date Received</b>
Regulation 61 (1) Notice Responses	All parts	Received 23/07/2021

<b>Table S1.3 Improvement programme requirements</b>		
<b>Reference</b>	<b>Requirement</b>	<b>Date</b>
IC1	<p>The Operator shall provide a secondary containment bund to the waste oil storage area. The bunding shall be constructed to the following minimum standard:</p> <ul style="list-style-type: none"> <li>• Any bund shall be impermeable and resistant to the range of oils stored within that storage area;</li> <li>• Any bund shall have no outlet (drain or valve) and drain to a blind collection point;</li> <li>• The bund shall be designed to catch leaks from the containers stored within the area;</li> <li>• The bund shall have a capacity greater than 110% of the largest container or 25% of the total storage capacity; and</li> <li>• The containers shall have fill points within the bund where possible or otherwise additional secondary containment for filling facilities shall be provided.</li> </ul> <p>A written report detailing the construction of the bund together with as built drawings shall be provided to the Agency for approval</p>	Complete
IC2	The Operator shall review the techniques used for the storage of all bulk raw materials, diesel and gas oil, drums and IBCs used within the installation. A written report summarising the findings and timescales for implementation to meet the requirements of section 2.2.5 of Agency Sector Guidance Note IPPC S6.10 shall be submitted to the Agency for approval	Complete
IC3	The Operator shall carry out an assessment of the measures in place within the installation to ensure that the soakaway through emission point WL1 can only receive uncontaminated surface water and cannot be impacted by contaminated firewater, cleaning chemicals and minor spills of polluting liquids from the process. A report detailing the findings of the assessment, recommendations for improvements to the surfacing, kerbing and bunding together with an implementation timetable shall be submitted to the Agency for approval.	Complete
IC4	The Operator shall assess the options for improving the existing control measures on cyclone 5, (e.g. dust monitor or level probe indicator to provide continuous indicative monitoring and interlocking to the process), to ensure that the process is not operated without abatement. A report shall be submitted to the Agency detailing the findings and timescales for implementation	Complete
IC5	The Operator shall assess the options for the minimisation of fugitive losses to air from raw material intake and outloading points. A report shall be submitted to the Agency with details of any further works to be undertaken as well as timescales for implementation	Complete
IC6	The Operator shall submit to the Agency a written report detailing the feasibility of recycling water within the process.	Complete
IC7	The operator shall submit, for approval by the Environment Agency, a report setting out progress to achieving the Best Available Techniques Associated Emission Levels (BAT-AELs) where BAT is currently not	11/05/2023

<b>Table S1.3 Improvement programme requirements</b>		
<b>Reference</b>	<b>Requirement</b>	<b>Date</b>
	<p>achieved but will be achieved before 4 December 2023. The report shall include, but not be limited to, the following:</p> <ol style="list-style-type: none"> <li>1) Current performance against the BAT-AELs.</li> <li>2) Methodology for reaching the BAT-AELs.</li> <li>3) Associated targets /timelines for reaching compliance by 4 December 2023.</li> <li>4) Any alterations to the initial plan (in progress reports).</li> </ol> <p>The report shall address the BAT Conclusions for Food, Drink and Milk industries with respect to the following:</p> <ul style="list-style-type: none"> <li>• BAT 17 Table 4 (compliance with BAT-AELs for channelled dust emissions to air from grinding in compound feed manufacture)</li> </ul> <p>Refer to BAT Conclusions for a full description of the BAT requirement.</p>	
IC8	The operator shall submit, for approval by the Environment Agency, a report demonstrating compliance against BAT 17 Table 4 for channelled dust emissions to air from coolers for emission points A1, A2, A3 & A4.	04/12/2023
IC9	The Operator shall submit a written report to the Environment Agency of monitoring carried out to determine the size distribution of particulate matter in the exhaust gas emissions to air from emission points A1, A2, A3, A4, A5, A6, A7, A8, A9 & A28 identifying the fractions within the PM10 and PM2.5 ranges. The monitoring shall be carried out under representative operating conditions and shall be in accordance with EN ISO 23210 unless otherwise agreed with the Environment Agency.	04/12/2023
IC10	The operator shall review and update the H1 risk assessment for particulate emissions to air at the capacity levels stated within table S1.1 of this permit. The H1 shall be submitted to the Environment Agency for review.	11/05/2023
IC11	The operator shall undertake representative monitoring of the rainwater collected from the liquid raw material bund to better understand it's composition and demonstrate that it is uncontaminated.  If the operator is unable to demonstrate that this rainwater can be deemed to be clean and uncontaminated as per the permit requirements, then alternative method of waste management shall be sought.	11/05/2023
IC12	The Operator shall undertake an assessment, using the Environment Agency's 'Groundwater risk assessment for your environmental permit' taking into consideration the characteristics of the boiler blowdown (temperature, pH, suspended solids, metals and any other potentially polluting substances).  Detail the specific arrangements for disposal of the blowdown associated with annual inspection and servicing.  List the options for disposal, justifying the disposal route (disposals not being treated in an onsite or offsite wastewater treatment plant should be fully justified).  Provide a proposed timetable for completion of any improvement works required.  The Operator shall implement any necessary improvements to a timetable agreed in writing by the Environment Agency.	11/05/2023

## 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. & point on site plan in Schedule 7	Source	Parameter	Limit (including unit)	Reference period	Monitoring frequency	Monitoring standard or method
A1	Mill 1 - Cooler A via Cyclone 1	Particulate matter	50 mg/m <sup>3</sup> until 03/12/2023	Average over sampling period	Annually	EN 13284-1
			20 mg/m <sup>3</sup> from 04/12/2023			
A2	Mill 1 - Cooler B via Cyclone 2	Particulate matter	50 mg/m <sup>3</sup> until 03/12/2023	Average over sampling period	Annually	EN 13284-1
			20 mg/m <sup>3</sup> from 04/12/2023			
A3	Mill 1 - Cooler C via Cyclone 3	Particulate matter	50 mg/m <sup>3</sup> until 03/12/2023	Average over sampling period	Annually	EN 13284-1
			20 mg/m <sup>3</sup> from 04/12/2023			
A4	Mill 2 - Cooler D via Cyclone 4	Particulate matter	50 mg/m <sup>3</sup> until 03/12/2023	Average over sampling period	Annually	EN 13284-1
			20 mg/m <sup>3</sup> from 04/12/2023			
A5	Mill 1 - Grinder 1 via fabric bag filter	Particulate matter	10 mg/m <sup>3</sup>	Average over sampling period	Annually	EN 13284-1
A6	Mill 1 - Grinder 2 via fabric bag filter	Particulate matter	10 mg/m <sup>3</sup>	Average over sampling period	Annually	EN 13284-1
A7	Mill 2 - Grinder 1 via fabric bag filter	Particulate matter	10 mg/m <sup>3</sup>	Average over sampling period	Annually	EN 13284-1
A8	Mill 2 - Grinder 2 via fabric bag filter	Particulate matter	10 mg/m <sup>3</sup>	Average over sampling period	Annually	EN 13284-1

<b>Table S3.1 Point source emissions to air – emission limits and monitoring requirements</b>						
<b>Emission point ref. &amp; point on site plan in Schedule 7</b>	<b>Source</b>	<b>Parameter</b>	<b>Limit (including unit)</b>	<b>Reference period</b>	<b>Monitoring frequency</b>	<b>Monitoring standard or method</b>
A9	Flaking plant	Particulate matter	20 mg/m <sup>3</sup>	Average over sampling period	Annually	EN 13284-1
A10	Lorry wash heater	No parameters set	No limit set	--	--	--
A11	1.4 MWth gas-fired boiler (Boiler 1)	Oxides of nitrogen (NO and NO <sub>2</sub> expressed as NO <sub>2</sub> )	250 mg/m <sup>3</sup> [NOTE 1]	Periodic	Every three years [NOTE 2]	EN 14792
		Carbon monoxide	No limit set [NOTE 1]	Periodic	Every three years [NOTE 2]	EN 15058
A12	0.9 MWth gas-fired boiler (Boiler 2)	No parameters set	No limit set	--	--	--
A13	1.8 MWth gas-fired boiler (Boiler 3)	Oxides of nitrogen (NO and NO <sub>2</sub> expressed as NO <sub>2</sub> )	250 mg/m <sup>3</sup> [NOTE 1]	Periodic	Every three years [NOTE 2]	EN 14792
		Carbon monoxide	No limit set [NOTE 1]	Periodic	Every three years [NOTE 2]	EN 15058
A14	Flaking plant steam exhaust	No parameters set	No limit set	--	--	--
A15	Flaking plant intake LEV	No parameters set	No limit set	--	--	--
A16 – A25	Bulk storage tank breather vents	No parameters set	No limit set	--	--	--
A28	Heated meal production line cooler	Particulate matter	20 mg/m <sup>3</sup>	Average over sampling period	Annually	EN 13284-1
Note 1: The limit shall apply from 01/01/2030, unless the boiler is replaced.						
Note 2: The monitoring requirements shall apply from 01/01/2030 in accordance with condition 3.1.4, unless otherwise advised by the Environment Agency.						

<b>Emission point ref. &amp; location</b>	<b>Source</b>	<b>Parameter</b>	<b>Limit (incl. unit)</b>	<b>Reference Period</b>	<b>Monitoring frequency</b>	<b>Monitoring standard or method</b>
WL1 – Discharge into land via soakaway	Clean and uncontaminated surface water run-off and boiler blowdown <sup>[Note 1]</sup>	No parameters set	No limit set	--	--	--

Note 1: Discharge of boiler blowdown is permitted via this route unless an alternative means is necessary following completion IC12.

<b>Emission point reference or source or description of point of measurement</b>	<b>Parameter</b>	<b>Monitoring frequency</b>	<b>Monitoring standard or method</b>	<b>Other specifications</b>
Level sensors at A1 to A4 and A28, and dust monitor at A4	Dust	Continuous	Not applicable	A level sensor, (and dust monitor where fitted), to detect blockage of the cyclone which is interlocked to the process to immediately shut down the cooler discharge and process line feed in the case of activation of the alarm.
A9	Dust	As specified	Not applicable	Any measures approved in accordance with improvement condition reference IC5.
Visual inspection at A5, A6, A7, and A8.	Dust	Monthly	Not applicable	The outlet of the fabric filter shall be checked monthly for signs that emissions have occurred. The equipment should also be checked for defects in the airflow. If emissions or defects are detected, then corrective action should be taken promptly.

## Schedule 4 – Reporting

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

<b>Table S4.1 Reporting of monitoring data</b>			
<b>Parameter</b>	<b>Emission or monitoring point/reference</b>	<b>Reporting period</b>	<b>Period begins</b>
Point source emissions to air	A1, A2, A3, A4, A5, A6, A7, A8, A9, A28	Every 12 months	1 January
Parameters as required by condition 3.5.1	A11, A13	First monitoring undertaken in accordance with Condition 3.1.4 to be reported within 3 months, and then every 3 years thereafter.	From first monitoring requirements in accordance with Condition 3.1.4

<b>Table S4.2: Annual production/treatment</b>	
<b>Parameter</b>	<b>Units</b>
Compound feed	tonnes

<b>Table S4.3 Performance parameters</b>		
<b>Parameter</b>	<b>Frequency of assessment</b>	<b>Units</b>
Water usage	Annually	m <sup>3</sup>
Specific waste water discharge (yearly average)	Annually	m <sup>3</sup> /tonne of products
Energy usage	Annually	MWh
Specific energy consumption (yearly average)	Annually	MWh/ tonne of products
Waste	Annually	tonnes

<b>Table S4.4 Reporting forms</b>		
<b>Parameter</b>	<b>Reporting form</b>	<b>Form version number and date</b>
Point source emissions to air	Emissions to Air Reporting Form, or other form as agreed in writing by the Environment Agency	Version 1, 08/03/2021
Water usage	Water Usage Reporting Form, or other form as agreed in writing by the Environment Agency	Version 1, 08/03/2021
Energy usage	Energy Usage Reporting Form, or other form as agreed in writing by the Environment Agency	Version 1, 08/03/2021
Other performance parameters	Other Performance Parameters Reporting Form, or other form as agreed in writing by the Environment Agency	Version 1, 08/03/2021

# 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	

<b>(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</b>	
<b>To be notified within 24 hours of detection</b>	
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>(b) Notification requirements for the breach of a limit</b>	
<b>To be notified within 24 hours of detection unless otherwise specified below</b>	
Emission point reference/ source	
Parameter(s)	
Limit	
Measured value and uncertainty	
Date and time of monitoring	

<b>(b) Notification requirements for the breach of a limit</b>	
<b>To be notified within 24 hours of detection unless otherwise specified below</b>	
Measures taken, or intended to be taken, to stop the emission	

<b>Time periods for notification following detection of a breach of a limit</b>	
<b>Parameter</b>	<b>Notification period</b>

<b>(c) Notification requirements for the breach of permit conditions not related to limits</b>	
<b>To be notified within 24 hours of detection</b>	
Condition breached	
Date, time and duration of breach	
Details of the permit breach i.e. what happened including impacts observed.	
Measures taken, or intended to be taken, to restore permit compliance.	

<b>(d) Notification requirements for the detection of any significant adverse environmental effect</b>	
<b>To be notified within 24 hours of detection</b>	
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, as read in accordance with Schedule 1A to the Environmental Permitting (England and Wales) Regulations 2016.

“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. An “existing medium combustion plant” is combustion plant operating before 20 December 2018.

“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, as read in accordance with Schedule 1A to the Environmental Permitting (England and Wales) Regulations 2016.

Pests” means Birds, Vermin and Insects.

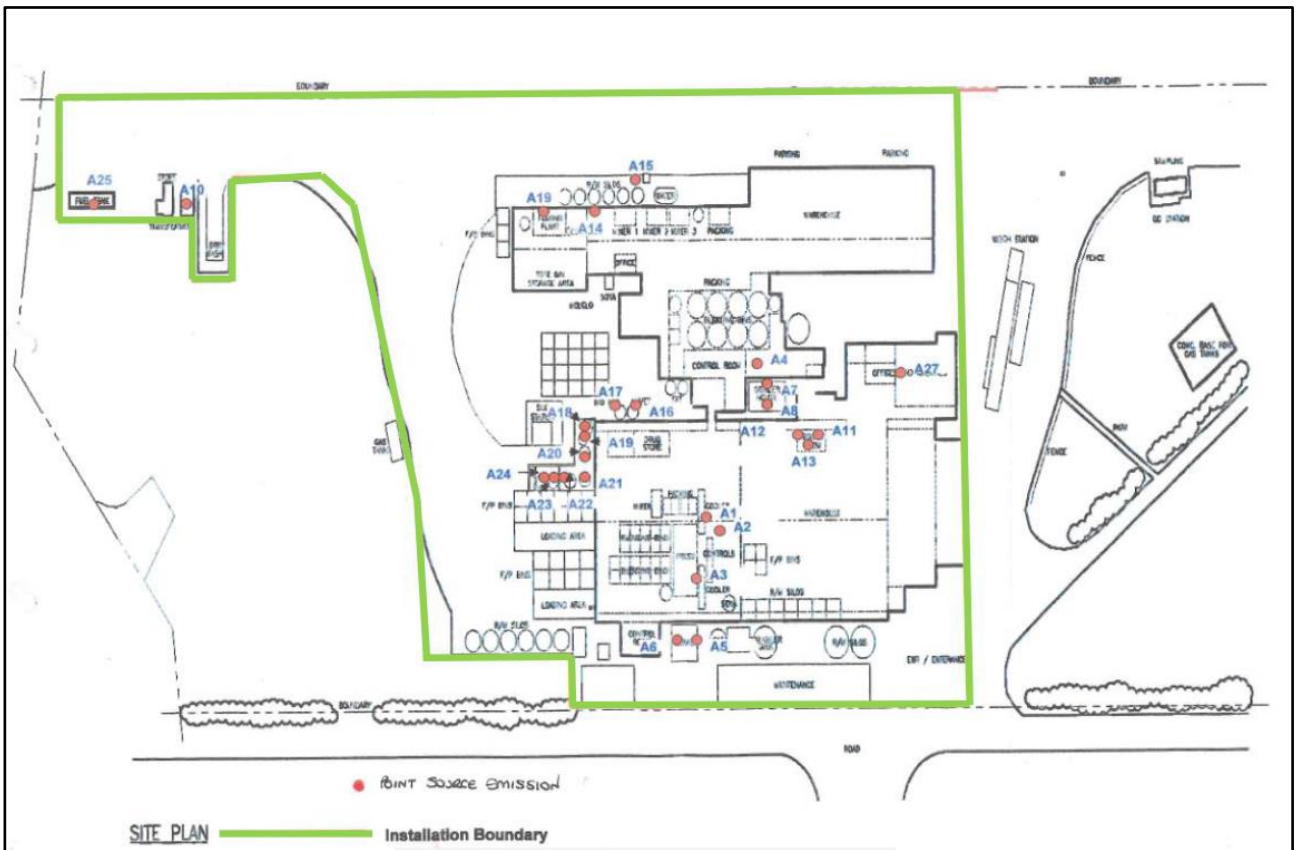
Where a minimum limit is set for any emission parameter, for example pH, reference to exceeding the limit shall mean that the parameter shall not be less than that limit.

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



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END OF PERMIT