

Review of an Environmental Permit for an Installation subject to Chapter II of the Industrial Emissions Directive under the Environmental Permitting (England & Wales) Regulations 2016 (as amended)

Decision document recording our decision-making process following review of a permit

The Permit number is: EPR/BP9811IE
The Operator is: ForFarmers UK Limited
The Installation is: Selby Animal Feed Mill
This Variation Notice number is: EPR/BP9811IE/V005

What this document is about

Article 21(3) of the Industrial Emissions Directive (IED) requires the Environment Agency to review conditions in permits that it has issued and to ensure that the permit delivers compliance with relevant standards, within four years of the publication by the European Commission of updated decisions on best available techniques (BAT) Conclusions.

We have reviewed the permit for this installation against the BAT Conclusions for the Food, Drink and Milk Industries published on 4th December 2019 in the Official Journal of the European Union. In this decision document, we set out the reasoning for the consolidated variation notice that we have issued.

It explains how we have reviewed and considered the techniques used by the Operator in the operation and control of the plant and activities of the installation. It is our record of our decision-making process and shows how we have taken into account all relevant factors in reaching our position.

As well as considering the review of the operating techniques used by the Operator for the operation of the plant and activities of the installation, the consolidated variation notice takes into account and brings together in a single document all previous variations that relate to the original permit issue. Where this has not already been done, it also modernises the entire permit to reflect the conditions contained in our current generic permit template.

The introduction of new template conditions makes the Permit consistent with our current general approach and with other permits issued to Installations in this sector. Although the wording of some conditions has changed, while others have been deleted because of the new regulatory approach, it does not reduce the level of environmental protection achieved by the Permit in any way. In this document, we therefore address only our determination of substantive issues relating to the new BAT Conclusions.

We try to explain our decision as accurately, comprehensively and plainly as possible. Achieving all three objectives is not always easy, and we would welcome any feedback as to how we might improve our decision documents in future.

How this document is structured

1. Our decision
2. How we reached our decision
3. The legal framework
4. Annex 1 – Review of operating techniques within the Installation against BAT Conclusions.
5. Annex 2 – Review and assessment of changes that are not part of the BAT Conclusions derived permit review
6. Annex 3 – Improvement Conditions

1 Our decision

We have decided to issue the Variation Notice to the Operator. This will allow the Operator to continue to operate the Installation, subject to the conditions in the Consolidated Variation Notice that updates the whole permit.

We consider that, in reaching our decision, we have taken into account all relevant considerations and legal requirements and that the varied permit will ensure that a high level of protection is provided for the environment and human health.

The Consolidated Variation Notice contains many conditions taken from our standard Environmental Permit template including the relevant annexes. We developed these conditions in consultation with industry, having regard to the legal requirements of the Environmental Permitting Regulations and other relevant legislation. This document does not therefore include an explanation for these standard conditions. Where they are included in the Notice, we have considered the techniques identified by the operator for the operation of their installation, and have accepted that the details are sufficient and satisfactory to make those standard conditions appropriate. This document does, however, provide an explanation of our use of “tailor-made” or installation-specific conditions, or where our Permit template provides two or more options.

2 How we reached our decision

2.1 Requesting information to demonstrate compliance with BAT Conclusion techniques

We issued a Notice under Regulation 61(1) of the Environmental Permitting (England and Wales) Regulations 2016 (a Regulation 61 Notice) on 05/05/2021 requiring the Operator to provide information to demonstrate where the operation of their installation currently meets, or how it will subsequently meet, the revised standards described in the relevant BAT Conclusions document.

The Notice required that where the revised standards are not currently met, the operator should provide information that:

- describes the techniques that will be implemented before 4 December 2023, which will then ensure that operations meet the revised standards, or
- justifies why standards will not be met by 4 December 2023, and confirmation of the date when the operation of those processes will cease within the Installation or an explanation of why the revised BAT standards are not applicable to those processes, or
- justifies why an alternative technique will achieve the same level of environmental protection equivalent to the revised BAT standards described in the BAT Conclusions.

Where the Operator proposed that they were not intending to meet a BAT standard that also included a BAT Associated Emission Level (BAT-AEL) described in the BAT Conclusions Document, the Regulation 61 Notice required that the Operator make a formal request for derogation from compliance with that BAT-AEL (as provisioned by Article 15(4) of IED). In this circumstance, the Notice identified that any such request for derogation must be supported and justified by sufficient technical and commercial information that would enable us to determine acceptability of the derogation request.

The Regulation 61 Notice response from the Operator was received on 15/07/2021.

We considered it was in the correct form and contained sufficient information for us to begin our determination of the permit review.

The Operator made no claim for commercial confidentiality. We have not received any information in relation to the Regulation 61 Notice response that appears to be confidential in relation to any party.

3 The legal framework

The Consolidated Variation Notice will be issued under Regulations 18 and 20 of the EPR. The Environmental Permitting regime is a legal vehicle which delivers most of the relevant legal requirements for activities falling within its scope. In particular, the regulated facility is:

- an *installation* as described by the IED;
- subject to aspects of other relevant legislation which also have to be addressed.

We consider that, in issuing the Consolidated Variation Notice, it will ensure that the operation of the Installation complies with all relevant legal requirements and that a high level of protection will be delivered for the environment and human health.

We explain how we have addressed specific statutory requirements more fully in the rest of this document.

Annex 1: decision checklist regarding relevant BAT Conclusions

BAT Conclusions for the Food, Drink and Milk Industries, were published by the European Commission on 4 December 2019.

There are 37 BAT Conclusions.

BAT 1 – 15 are General BAT Conclusions (Narrative BAT) applicable to all relevant Food, Drink and Milk Installations in scope.

BAT 16 – 37 are sector-specific BAT Conclusions, including Best Available Techniques Associated Emissions Levels (BAT-AELs) and Associated Environmental Performance Levels (BAT-AEPLs):

BAT 16 & 17	BAT Conclusions for Animal Feed
BAT 18 – 20	BAT Conclusions for Brewing
BAT 21 – 23	BAT Conclusions for Dairies
BAT 24	BAT Conclusions for Ethanol Production
BAT 25 & 26	BAT Conclusions for Fish and Shellfish Processing
BAT 27	BAT Conclusions for Fruit and Vegetable Processing
BAT 28	BAT Conclusions for Grain Milling
BAT 29	BAT Conclusions for Meat Processing
BAT 30 – 32	BAT Conclusions for Oilseed Processing and Vegetable Oil Refining
BAT 33	BAT Conclusions for Soft Drinks and Nectar/Fruit Juice Processed from Fruit and Vegetables
BAT 34	BAT Conclusions for Starch Production
BAT 35 – 37	BAT Conclusions for Sugar Manufacturing

This annex provides a record of decisions made in relation to each relevant BAT Conclusion applicable to the installation. This annex should be read in conjunction with the Consolidated Variation Notice.

The overall status of compliance with the BAT conclusion is indicated in the table as:

NA – Not Applicable

CC – Currently Compliant

FC – Compliant in the future (within 4 years of publication of BATCs)

NC – Not Compliant

BATC No.	Summary of BAT Conclusion requirement for Food, Drink and Milk Industries	Status NA/ CC / FC / NC	Assessment of the installation capability and any alternative techniques proposed by the operator to demonstrate compliance with the BAT Conclusion requirement
	GENERAL BAT CONCLUSIONS (BAT 1 – 15)		
1	<p>Environmental Management System - Improve overall environmental performance.</p> <p>Implement an EMS that incorporates all the features as described within BATc 1.</p>	CC	<p><u>Environment Agency assessment</u></p> <p>The operator has provided information to support compliance with BATc 1.</p> <p>The operator has an EMS which is externally accredited to the ISO14001 standard.</p> <p>We have assessed the information provided and we are satisfied that the operator has demonstrated compliance with BATc 1.</p>
2	<p>EMS Inventory of inputs & outputs. Increase resource efficiency and reduce emissions.</p> <p>Establish, maintain and regularly review (including when a significant change occurs) an inventory of water, energy and raw materials consumption as well as of waste water and waste gas streams, as part of the environmental management system (see BAT 1), that incorporates all of the features as detailed within the BATcs.</p>	CC	<p><u>Environment Agency assessment</u></p> <p>The operator has provided information to support compliance with BATc 2.</p> <p>The site undertakes inventories for water, energy, raw material consumption, waste water & waste gas streams which form part of their National & Site EMS system, therefore will be certified within ISO audits. These are reviewed at least 6 monthly as part of the Site EMS/EnMS reviews. The site has a full EMS & EnMS system which is accredited to ISO 14001 & ISO 50001 standards.</p> <p>We have assessed the information provided and we are satisfied that the operator has demonstrated compliance with BATc 2.</p>

BATC No.	Summary of BAT Conclusion requirement for Food, Drink and Milk Industries	Status NA/ CC / FC / NC	Assessment of the installation capability and any alternative techniques proposed by the operator to demonstrate compliance with the BAT Conclusion requirement
3	<p>Monitoring key process parameters at key locations for emissions to water. For relevant emissions to water as identified by the inventory of waste water streams (see BAT 2), BAT is to monitor key process parameters (e.g. continuous monitoring of waste water flow, pH and temperature) at key locations (e.g. at the inlet and/or outlet of the pre-treatment, at the inlet to the final treatment, at the point where the emission leaves the installation).</p>	CC	<p><u>Environment Agency assessment</u> The operator has provided information to support compliance with BATc 3.</p> <p>The site does not operate an effluent treatment plant on site.</p> <p>Discharge to sewer comprise vehicle wash, boiler blowdown & site drainage to sewer via a 3 stage interceptor, which separates out any solids.</p> <p>A due diligence spot sample is taken from the vehicle wash & Boiler blowdown effluents annually (PH, COD, Suspended Solids & Oil & Greases) and results are compared to the Trade Effluent Consent issued by YWS. These annual samples have not indicated any issues to date, effluent rates & levels we would not expect to vary significantly.</p> <p>We have assessed the information provided and we are satisfied that the operator has demonstrated compliance with BATc 3.</p>
4	<p>Monitoring emissions to water to the required frequencies and standards. BAT is to monitor emissions to water with at least the frequency given and in accordance with EN standards. If EN standards are not available, BAT is to use ISO, national or other international standards that ensure the provision of data of an equivalent scientific quality.</p>	NA	<p>No process effluent is discharged directly to surface water.</p> <p>For the discharges to sewer; chloride is not a parameter of concern for this installation.</p>

BATC No.	Summary of BAT Conclusion requirement for Food, Drink and Milk Industries	Status NA/ CC / FC / NC	Assessment of the installation capability and any alternative techniques proposed by the operator to demonstrate compliance with the BAT Conclusion requirement
5	<p>Monitoring channelled emissions to air to the required frequencies and standards. BAT is to monitor channelled emissions to air with at least the frequency given and in accordance with EN standards.</p>	<p>CC for Coolers</p> <p>FC for Grinders</p>	<p><u>Environment Agency assessment</u> The operator has provided information to support compliance with BATc 5.</p> <p>Coolers (emission points A1 – A5) Monitoring is currently undertaken for particulate emissions from the product coolers to MCERTS standards, as per the extant permit conditions.</p> <p>Grinders (emission points A6 & A7) The operator has stated that they will install monitoring equipment to MCERTS standards prior to the compliance deadline, to enable them undertake monitoring of particulate emissions from the grinders.</p> <p>We have assessed the information provided and we are satisfied that the operator has demonstrated compliance with BATc 5 on the basis of the permit conditions and the improvement programme (IC6) imposed.</p>
6	<p>Energy Efficiency In order to increase energy efficiency, BAT is to use an energy efficiency plan (BAT 6a) and an appropriate combination of the common techniques listed in technique 6b within the table in the BATc.</p>	<p>CC</p>	<p><u>Environment Agency assessment</u> The operator has provided information to support compliance with BATc 6.</p> <p>The site has an energy management system accredited to ISO 50001 which is externally audited, and gives full compliance with this BAT requirement.</p>

BATC No.	Summary of BAT Conclusion requirement for Food, Drink and Milk Industries	Status NA/ CC / FC / NC	Assessment of the installation capability and any alternative techniques proposed by the operator to demonstrate compliance with the BAT Conclusion requirement
			We have assessed the information provided and we are satisfied that the operator has demonstrated compliance with BATc 6.
7	<p>Water and wastewater minimisation</p> <p>In order to reduce water consumption and the volume of waste water discharged, BAT is to use BAT 7a and one or a combination of the techniques b to k given below.</p> <p>(a) water recycling and/or reuse (b) Optimisation of water flow (c) Optimisation of water nozzles and hoses (d) Segregation of water streams</p> <p>Techniques related to cleaning operations:</p> <p>(e) Dry cleaning (f) Pigging system for pipes (g) High-pressure cleaning (h) Optimisation of chemical dosing and water use in cleaning-in-place (CIP) (i) Low-pressure foam and/or gel cleaning (j) Optimised design and construction of equipment and process areas (k) Cleaning of equipment as soon as possible</p>	CC	<p><u>Environment Agency assessment</u></p> <p>The operator has provided information to support compliance with BATc 7.</p> <p>Animal Feed Manufacture is essentially a dry process, with low water usage and limited potential for water saving & application of BAT techniques.</p> <p>The site recovers steam condensate via a condensate returns system to the hotwell tank, 6 monthly steam trap surveys are also undertaken to ensure the system is working efficiently (thus reducing the potential for condensate return going off site as an effluent), along with dry cleaning of manufacturing site via central vacuum system, interior of vehicles are blown off into a bin with a cyclone</p> <p>We have assessed the information provided and we are satisfied that the operator has demonstrated compliance with BATc 7.</p>
8	<p>Prevent or reduce the use of harmful substances</p> <p>In order to prevent or reduce the use of harmful substances, e.g. in cleaning and disinfection, BAT is to use one or a combination of the techniques given below.</p> <p>(a) Proper selection of cleaning chemicals and/or disinfectants (b) Reuse of cleaning chemicals in cleaning-in-place (CIP)</p>	CC	<p><u>Environment Agency assessment</u></p> <p>The operator has provided information to support compliance with BATc 8.</p>

BATC No.	Summary of BAT Conclusion requirement for Food, Drink and Milk Industries	Status NA/ CC / FC / NC	Assessment of the installation capability and any alternative techniques proposed by the operator to demonstrate compliance with the BAT Conclusion requirement
	<p>(c) Dry cleaning</p> <p>(d) Optimised design and construction of equipment and process areas</p>		<p>No priority Hazardous Substances / Specific Pollutants used at Selby.</p> <p>All materials go through an appropriate material selection process and materials are selected where feasible with low risk of environmental contamination. The work instruction for each material incorporates environmental controls.</p> <p>The site holds relevant SDS for each material in use and has an emergency action plan which includes a list of key harmful substances and emergency procedures.</p> <p>The site detergent does not contain Triclosan.</p> <p>Removal of as much residual material as possible from raw materials and equipment, e.g. by using vacuum systems</p> <p>The site also has emergency procedures in place for materials used during animal health pandemics eg. Virkon S.</p> <p>We have assessed the information provided and we are satisfied that the operator has demonstrated compliance with BATc 8.</p>
9	<p>Refrigerants</p> <p>In order to prevent emissions of ozone-depleting substances and of substances with a high global warming potential from cooling and freezing, BAT is to use</p>	NA	<p>Refrigerants are not used at the site for the purposes of the permitted activities.</p>

BATC No.	Summary of BAT Conclusion requirement for Food, Drink and Milk Industries	Status NA/ CC / FC / NC	Assessment of the installation capability and any alternative techniques proposed by the operator to demonstrate compliance with the BAT Conclusion requirement
	refrigerants without ozone depletion potential and with a low global warming potential.		
10	<p>Resource efficiency In order to increase resource efficiency, BAT is to use one or a combination of the techniques given below:</p> <ul style="list-style-type: none"> (a) Anaerobic digestion (b) Use of residues (c) Separation of residues (d) Recovery and reuse of residues from the pasteuriser (e) Phosphorus recovery as struvite (f) Use of waste water for land spreading 	CC	<p>Environment Agency assessment</p> <p>The operator has provided information to support compliance with BATc 10.</p> <p>Residues are re-used within the site processes such as reworks (FDM Waste Hierachy 1).</p> <p>The site uses Former Foodstuffs such as molasses, syrup, wheatfeed and biscuit meal (FDM Waste Hierachy 3).</p> <p>Residues from liquid deliveries are captured within drip trays, monitored regularly and removed via appropriate waste streams.</p> <p>Wherever feasible waste streams are recycled (currently 92.5%).</p> <p>ForFarmers Waste hierarchy – Reduce ->Reuse-> Repair -> Recycle-> Recover (energy from waste) -> Disposal to Landfill (last resort) is used.</p> <p>Waste Reduction Targets are set & monitored monthly. Waste KPI's are set and monitored monthly</p> <p>Waste which cannot be re-used within the manufacturing process is sent as feed waste for anaerobic digestion equating to circa 0.02% / annum of total production</p>

BATC No.	Summary of BAT Conclusion requirement for Food, Drink and Milk Industries	Status NA/ CC / FC / NC	Assessment of the installation capability and any alternative techniques proposed by the operator to demonstrate compliance with the BAT Conclusion requirement
			<p>The process uses residues in the form of remix equating to <1% of yield, which is re- included back into the process at a set %. The site is focussed on maximum yield and averages >99%</p> <p>Feed waste is segregated from remix</p> <p>We have assessed the information provided and we are satisfied that the operator has demonstrated compliance with BATc 10.</p>
11	<p>Waste water buffer storage In order to prevent uncontrolled emissions to water, BAT is to provide an appropriate buffer storage capacity for waste water.</p>	NA	The discharge volumes from this installation are low, and no process effluent is produced.
12	<p>Emissions to water – treatment In order to reduce emissions to water, BAT is to use an appropriate combination of the techniques given in BATc 12.</p>	NA	The discharge volumes from this installation are low, and no process effluent is produced.
13	<p>Noise management plan In order to prevent or, where that is not practicable, to reduce noise emissions, BAT is to set up, implement and regularly review a noise management plan, as part of the environmental management system (see BAT 1), that includes all of the following elements:</p> <ul style="list-style-type: none"> - a protocol containing actions and timelines; - a protocol for conducting noise emissions monitoring; - a protocol for response to identified noise events, eg complaints; - a noise reduction programme designed to identify the source(s), to measure/estimate noise and vibration exposure, to characterise the contributions of the sources and to implement prevention and/or reduction measures. 	NA	<p>BAT 13 is only applicable to cases where a noise nuisance at sensitive receptors is expected and/or has been substantiated, or if forms part of an existing permit requirement.</p> <p>There is no existing permit requirements and the site has no recent history of noise complaints therefore a noise management plan is not required.</p> <p>The Site undertakes daily noise monitoring checks as part of its EMS, machinery is maintained using a planned maintenance system, wherever possible windows & doors are kept shut. Vibration monitoring on key plant. One way system, Enclosed Loading Areas</p>

BATC No.	Summary of BAT Conclusion requirement for Food, Drink and Milk Industries	Status NA/ CC / FC / NC	Assessment of the installation capability and any alternative techniques proposed by the operator to demonstrate compliance with the BAT Conclusion requirement
	Note: BAT13 is only applicable where a noise nuisance at sensitive receptors is expected and/or has been substantiated.		Root cause analysis system to investigate any complaints received.
14	<p>Noise management</p> <p>In order to prevent or, where that is not practicable, to reduce noise emissions, BAT is to use one or a combination of the techniques given below.</p> <p>(a) Appropriate location of equipment and buildings</p> <p>(b) Operational measures</p> <p>(c) Low-noise equipment</p> <p>(d) Noise control equipment</p> <p>(e) Noise abatement</p>	CC	<p><u>Environment Agency assessment</u></p> <p>The operator has provided information to support compliance with BATc 14.</p> <p>The Operator has a number of operational controls in place such as: windows & doors are kept shut, vibration monitoring is in place, maintenance routines, daily EMS checks and training & work Instructions are employed. The operator ensures loading areas are enclosed and vehicles are switched off when loading.</p> <p>We have assessed the information provided and we are satisfied that the operator has demonstrated compliance with BATc 14.</p>
15	<p>Odour Management</p> <p>In order to prevent or, where that is not practicable, to reduce odour emissions, BAT is to set up, implement and regularly review an odour management plan, as part of the environmental management system (see BAT 1), that includes all of the elements set out in BATc 15.</p> <p>Note: BAT 15 is only applicable to cases where an odour nuisance at sensitive receptors is expected and/or has been substantiated.</p>	NA	<p>BAT 15 is only applicable to cases where odour nuisance at sensitive receptors is expected and/or has been substantiated, or if forms part of an existing permit requirement.</p> <p>There has been no substantiated odour nuisance from the site, there are no sensitive receptors close to the site.</p> <p>The company has a full EMS system which includes daily site environmental monitoring and an incident and complaint reporting system with root cause analysis.</p>

BATC No.	Summary of BAT Conclusion requirement for Food, Drink and Milk Industries	Status NA/ CC / FC / NC	Assessment of the installation capability and any alternative techniques proposed by the operator to demonstrate compliance with the BAT Conclusion requirement															
ANIMAL FEED BAT CONCLUSIONS (BAT 16 – 17)																		
16	<p>Energy efficiency – Green fodder only</p> <p>In order to increase energy efficiency in green fodder processing, BAT is to use an appropriate combination of the techniques specified in BAT 6 and of the techniques given in BATc 16.</p>	NA	The site does not process green fodder.															
17	<p>Emissions to air – particulates</p> <p>In order to reduce channelled dust emissions to air, BAT is to use one of the techniques given; a. bag filter, b. cyclone.</p> <table border="1" data-bbox="277 722 1232 967"> <thead> <tr> <th rowspan="2">Parameter</th> <th rowspan="2">Specific process</th> <th rowspan="2">Unit</th> <th colspan="2">BAT-AEL (average over the sampling period)</th> </tr> <tr> <th>New plants</th> <th>Existing plants</th> </tr> </thead> <tbody> <tr> <td rowspan="2">Dust</td> <td>Grinding</td> <td rowspan="2">mg/Nm³</td> <td><2-5</td> <td><2-10</td> </tr> <tr> <td>Pellet cooling</td> <td colspan="2"><2-20</td> </tr> </tbody> </table>	Parameter	Specific process	Unit	BAT-AEL (average over the sampling period)		New plants	Existing plants	Dust	Grinding	mg/Nm ³	<2-5	<2-10	Pellet cooling	<2-20		CC for Coolers	<p><u>Environment Agency assessment</u></p> <p>The operator has provided information to support compliance with BATc 17.</p> <p>We have assessed the information provided and we are satisfied that the operator has demonstrated compliance with BATc 17 either now, or before the compliance deadline, as follows:</p> <p>Pellet coolers (emission points A1 – A5)</p> <p>The previous emission limit value (ELV) for the pellet coolers was 50mg/m³ for particulate emissions. However, because this is existing plant we believe it is appropriate to set the new ELV at the top of the BAT-AEL range. On that basis, a new ELV of 20mg/Nm³ has been included in the varied permit to ensure compliance with the BAT-AEL from date of permit issue.</p> <p>There have been 3 occasions in the last 4 years where a result was >20mgm³. 2 of these were due to incorrect</p>
Parameter	Specific process				Unit	BAT-AEL (average over the sampling period)												
		New plants	Existing plants															
Dust	Grinding	mg/Nm ³	<2-5	<2-10														
	Pellet cooling		<2-20															

BATC No.	Summary of BAT Conclusion requirement for Food, Drink and Milk Industries	Status NA/ CC / FC / NC	Assessment of the installation capability and any alternative techniques proposed by the operator to demonstrate compliance with the BAT Conclusion requirement
		FC for Grinders	<p>re-fitting of the cyclone cartridges and 1 was due to a product issue.</p> <p>Some investment is expected in relation to cooler exhausts in the next few years.</p> <p>Monitoring data suggests the operator can comply with the revised ELV of 20 mg/Nm³ now, therefore we are including this limit within the permit from date of issue and are choosing to not future date this BAT-AEL.</p> <p>Grinders (emission points A6 & A7) Capital expenditure to install sampling points & platforms to the grinder exhausts ducting planned for 2021/2022, once ducts suitably installed MCERTS testing will be organised during 2022/2023 to ensure compliance before 03.12.2023</p> <p>Evidence from other ForFarmers sites which have undertaken grinder emission testing as part of their permit requirements indicate that there should be no issue with site achieving BAT AEL</p> <p>We consider that the operator will be future compliant with BATc 17. Improvement condition IC5 have been included in the permit to achieve compliance.</p>

BATC No.	Summary of BAT Conclusion requirement for Food, Drink and Milk Industries	Status NA/ CC / FC / NC	Assessment of the installation capability and any alternative techniques proposed by the operator to demonstrate compliance with the BAT Conclusion requirement													
EPL	<p>Environmental Performance Level – Energy Consumption for Animal Feed</p> <table border="1" data-bbox="277 421 1232 788"> <thead> <tr> <th data-bbox="277 421 595 523">Product</th> <th data-bbox="595 421 913 523">Unit</th> <th data-bbox="913 421 1232 523">Specific energy consumption (yearly average)</th> </tr> </thead> <tbody> <tr> <td data-bbox="277 523 595 568">Compound food</td> <td data-bbox="595 523 913 657" rowspan="3">MWh/tonne of products</td> <td data-bbox="913 523 1232 568">0.01-0.10 ⁽¹⁾⁽²⁾⁽³⁾</td> </tr> <tr> <td data-bbox="277 568 595 612">Dry pet food</td> <td data-bbox="913 568 1232 612">0.39-0.50</td> </tr> <tr> <td data-bbox="277 612 595 657">Wet pet food</td> <td data-bbox="913 612 1232 657">0.33-0.85</td> </tr> <tr> <td colspan="3" data-bbox="277 657 1232 788"> <p>(1) The lower end of the range can be achieved when pelleting is not applied.</p> <p>(2) The specific energy consumption level may not apply when fish and other aquatic animals are used as raw material.</p> <p>(3) The upper end of the range is 0.12 MWh/tonne of products for installations located in cold climates and/or when teat treatment is used for Salmonella decontamination.</p> </td> </tr> </tbody> </table>	Product	Unit	Specific energy consumption (yearly average)	Compound food	MWh/tonne of products	0.01-0.10 ⁽¹⁾⁽²⁾⁽³⁾	Dry pet food	0.39-0.50	Wet pet food	0.33-0.85	<p>(1) The lower end of the range can be achieved when pelleting is not applied.</p> <p>(2) The specific energy consumption level may not apply when fish and other aquatic animals are used as raw material.</p> <p>(3) The upper end of the range is 0.12 MWh/tonne of products for installations located in cold climates and/or when teat treatment is used for Salmonella decontamination.</p>			CC	<p>Environment Agency assessment</p> <p>The operator has provided information to support compliance with the EPL. We have assessed the information provided and we are satisfied that the operator has demonstrated compliance with the energy consumption environmental performance level for Animal Feed.</p> <p>The compound food figure of 0.01-0.10 MWh/t is appropriate for this installation.</p> <p>The measured range between 2014 and 2020 was 0.056 to 0.061 MWh/t. This is well within the benchmark range, reflecting the good energy management in place at this installation.</p>
	Product	Unit	Specific energy consumption (yearly average)													
	Compound food	MWh/tonne of products	0.01-0.10 ⁽¹⁾⁽²⁾⁽³⁾													
	Dry pet food		0.39-0.50													
Wet pet food	0.33-0.85															
<p>(1) The lower end of the range can be achieved when pelleting is not applied.</p> <p>(2) The specific energy consumption level may not apply when fish and other aquatic animals are used as raw material.</p> <p>(3) The upper end of the range is 0.12 MWh/tonne of products for installations located in cold climates and/or when teat treatment is used for Salmonella decontamination.</p>																
EPL	<p>Environmental performance level – Waste water discharge for Animal Feed</p> <table border="1" data-bbox="277 903 1232 1021"> <thead> <tr> <th data-bbox="277 903 595 973">Product</th> <th data-bbox="595 903 913 973">Unit</th> <th data-bbox="913 903 1232 973">Specific waste water discharge (yearly average)</th> </tr> </thead> <tbody> <tr> <td data-bbox="277 973 595 1021">Wet pet food</td> <td data-bbox="595 973 913 1021">m3/tonne of products</td> <td data-bbox="913 973 1232 1021">1.3-2.4</td> </tr> </tbody> </table>	Product	Unit	Specific waste water discharge (yearly average)	Wet pet food	m3/tonne of products	1.3-2.4	NA	<p>N/A – The installation is not permitted to produce wet pet food.</p>							
	Product	Unit	Specific waste water discharge (yearly average)													
Wet pet food	m3/tonne of products	1.3-2.4														

Annex 2: Review and assessment of changes that are not part of the BAT Conclusions derived permit review

Updating permit during permit review consolidation

We have updated permit conditions to those in the current generic permit template as a part of permit consolidation. The conditions will provide the same level of protection as those in the previous permit.

This included some other changes to the permit to ensure cross-sector consistency, including:

- An updated introductory note
- Updated site plans in Schedule 7
- Update to the listed activity in Table S1.1
- The addition of finished product production capacity in Table S1.1
- Standardisation of the directly associated activities (DAAs) in Table S1.1
- Standardisation of reporting parameters.

Listed activity reference

In the Regulation 61 response, the Operator identified that they use a small proportion of animal raw materials as part of their permitted activities.

On that basis, we have updated the listed activity from a Section 6.8 Part (A)1 (d) (ii) activity (vegetable raw materials only) to a Section 6.8 Part A (1) (d) (iii) activity (animal and vegetable raw materials).

The proportion of animal raw material ("A") is 0.11%, giving a calculated site specific threshold of 297.5t/day as per (bb) below:

*Treatment and processing of animal and vegetable raw materials (other than milk only), both in combined and separate products, with a finished product production capacity in tonnes per day greater than (aa) 75 if A is equal to 10 or more; or (bb) **300-(22.5 x A) in any other case, where 'A' is the proportion of animal material in percent of weight of the finished product production capacity.***

Capacity Threshold

The Environment Agency is looking to draw a "line in the sand" for permitted production capacity; a common understanding between the Operator and regulator for the emissions associated with a (maximum) level of production, whereby the maximum emissions have been demonstrated as causing no significant environmental impact.

We have included a permitted production level (capacity) within table S1.1 of the permit for the section 6.8 listed activity and we need to be confident that the level of emissions associated with this production level have been demonstrated to be acceptable.

The Operator has done an H1 assessment of emissions for typical figures of production at the time of permitting. The H1 assessment is not valid for the maximum capacity or if production is now higher. We have included an improvement condition within the permit (IC8) which requires the operator to revisit their H1 risk assessment for particulate emissions to air at the capacity limit figure that is now stated within table S1.1 of the permit.

Emissions to Air

We asked the operator to list all emission points to air from the installation in the Regulation 61 notice. And to provide a site plan indicating the locations of all air emission points.

The operator has provided an up to date air emissions plan.

Implementing the requirements of the Medium Combustion Plant Directive

We asked the Operator to provide information on all combustion plant on site in the Regulation 61 Notice as follows:

- Number of combustion plant (CHP engines, back-up generators, boilers);
- Size of combustion plant – rated thermal input (MWth);
- Date each combustion plant came into operation.

The Operator provided the information in the table below:

1. Rated thermal input (MW) of the medium combustion plant.	2.7 MWth
2. Type of the medium combustion plant (diesel engine, gas turbine, dual fuel engine, other engine or other medium combustion plant).	Boiler
3. Type and share of fuels used according to the fuel categories laid down in Annex II.	Natural gas
4. Date of the start of the operation of the medium combustion plant or, where the exact date of the start of the operation is unknown, proof of the fact that the operation started before 20 December 2018.	December 2004

We have reviewed the information provided and we consider that the declared combustion plant qualify as “existing” medium combustion plant.

For existing MCP with a rated thermal input of less than or equal to 5 MW, the emission limit values set out in tables 1 and 3 of Part 1 of Annex II MCPD shall apply from 1 January 2030.

We have included the appropriate emission limit values and monitoring requirements for existing medium combustion plant as part of this permit review in Table S3.1 of the permit.

We have also included a new condition 3.1.4 within the permit which specifies the monitoring requirements for the combustion plant in accordance with the MCPD.

Particulate Emissions

BAT-AELs are derived for those substances identified as key environmental issues during the BREF review process.

If the operator has identified current compliance against BAT-AELs we will implement the relevant emission limit value (ELV) from the date of permit issue. This is relevant for emission points A1 – A5 against BAT 17 for particulate emissions from the pellet coolers.

We have added an improvement condition (IC7) for size fractionation of particulate emissions because a BAT-AEL applies for dust emissions to air. The justification for this IC is that there are a number of activities within the FDM sector which may result in release of particulates to air e.g. drying, milling and grinding. Overall there is little available information on how much fine particulates are released. This IC is a one-off exercise requiring operators to monitor and report on the fractions of fine particulate (PM₁₀ and PM_{2.5}) emissions and increase our understanding of potential health effects. Where BAT-AELs apply to multiple emission points e.g. grain milling, we may accept limited representative monitoring rather than expecting them to monitor every single emission point.

Emissions to Water and Water Framework Directive

We asked the Operator to provide information on all emissions to water at the installation in the Regulation 61 Notice as follows:

- Identify any effluents which discharge directly to surface or groundwater;
- Provide an assessment of volume and quality, including results of any monitoring data available;
- and for any discharges to water / soakaway whether a recent assessment of the feasibility of connection to sewer has been carried out.

In this case, there are no direct discharges of process effluent to surface or ground water. There are emissions of vehicle wash and boiler blowdown to sewer.

However, due to the low volumes and the disposal route, we are satisfied that the discharge will not impact on the WFD requirements, and demonstrate BAT.

Soil & groundwater risk assessment (baseline report)

The IED requires that the operator of any IED installation using, producing or releasing “relevant hazardous substances” (RHS) shall, having regarded the possibility that they might cause pollution of soil and groundwater, submit a “baseline report” with its permit application. The baseline report is an important reference document in the assessment of contamination that might arise during the operational lifetime of the regulated facility and at cessation of activities. It must enable a quantified comparison to be made between the baseline and the state of the site at surrender.

At the definitive cessation of activities, the Operator has to satisfy us that the necessary measures have been taken so that the site ceases to pose a risk to soil or groundwater, taking into account both the baseline conditions and the site’s current or approved future use. To do this, the Operator has to submit a surrender application to us, which

we will not grant unless and until we are satisfied that these requirements have been met.

The Operator submitted a copy of the site condition report reference 406.05827.00002.012, dated July 2017 as part of the Regulation 61 Notice response. The site condition report includes a desk-top study of the historic soil and groundwater contamination. This states that from 1938 the previously undeveloped site was labelled as Olympia Mills (Cake and Oil) and by 1963 the Site was labelled as a Mill, with further development in the 1990s, taking the Site to much the same layout as it is today.

Based on the site history, it was deemed that intrusive sampling was not required. We have reviewed the report and consider that it adequately describes the condition of the soil and groundwater, and the operator accepts this as their baseline.

Hazardous Substances

Hazardous substances are those defined in Article 3 of Regulation (EC) No. 1272/2008 on classification, labelling and packaging of substances and mixtures.

The operator has provided a short risk assessment on the hazardous substances stored and used at the installation. The risk assessment was a stage 1-3 assessment as detailed within EC Commission Guidance 2014/C 136/03.

The stage 1 assessment identified the hazardous substances used / stored on site. The stage 2 assessment identified if hazardous substances are capable of causing pollution. If they are capable of causing pollution they are then termed Relevant Hazardous Substances (RHS). The Stage 3 assessment identified if pollution prevention measures are fit for purpose in areas where hazardous substances are used / stored. This includes drains as well.

The outcomes of the three stage assessment identified that pollution of soil and/or groundwater to be unlikely. Therefore, we consider the generic condition 3.1.3 for periodic monitoring of soil and groundwater to be appropriate for this site, no additional monitoring is required at this time.

Climate Change Adaptation

The operator has stated that the installation is not likely to be or has previously been affected by climate change.

However, the operator has submitted a climate change adaptation plan, which considers, as a minimum the impact of severe weather on the operations within the installation.

We consider the climate change adaptation plan to be appropriate for the installation.

Underground Structures

The operator has confirmed there are no underground structures at the installation.

Annex 3: Improvement Conditions

Based on the information in the Operator's Regulation 61 Notice response and our own records of the capability and performance of the installation at this site, we consider that we need to set improvement conditions so that the outcome of the techniques detailed in the BAT Conclusions are achieved by the installation. These improvement conditions are set out below - justifications for them is provided at the relevant section of the decision document (Annex 1 or Annex 2).

Reference	Improvement condition	Deadline for submission(s)
IC4	<p>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 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"> 1) Current performance against the BAT-AELs. 2) Methodology for reaching the BAT-AELs. 3) Associated targets /timelines for reaching compliance by 4 December 2023. 4) Any alterations to the initial plan (in progress reports). <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"> • BAT 17 Table 4 (compliance with BAT-AELs for channelled dust emissions to air from grinding in compound feed manufacture) <p>Refer to BAT Conclusions for a full description of the BAT requirement.</p>	13/05/2023
IC5	The operator shall submit, for approval by the Environment Agency, a report demonstrating compliance against BAT17 Table 4 for channelled dust emissions to air from grinding for emission points A6 & A7.	By 04/12/2023
IC6	<p>The Operator shall submit a report, for approval in writing by the Environment Agency, demonstrating the ability to comply with BAT 5 for monitoring of particulates from the grinder emissions points (A6 & A7) in accordance with the MCERTS standard.</p> <p>The report shall include, but not be limited to, the installation of the sampling ports and platforms to enable particulate monitoring in accordance with table S3.1.</p>	By 04/12/2023
IC7	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 to A7, 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.	31/12/2023 or other date as agreed in writing with the Environment Agency

IC8	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.	13/05/2023
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Note: Previous Improvement Conditions IC1 – IC3 have been marked as complete.