

# Notice of variation and consolidation with introductory note

**The Environmental Permitting (England & Wales) Regulations 2016**

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Whitworth Bros.Limited

Victoria Mill  
London Road  
Wellingborough  
Northampton  
NN8 2DT

**Variation application number**

EPR/FP3638SF/V004

**Permit number**

EPR/FP3638SF

# Victoria Mill

## Permit number EPR/FP3638SF

### 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.

The installation is located on the south-eastern edge of Wellingborough centred at National Grid Reference SP 90199 66649, the site is a flour mill which manufactures flour and wheatfeed pellets. The site was originally a corn mill in 1886, the original flour mill still remains but is no longer used, having been superseded by more modern mills.

The key flour milling process operated at the installation are:

- wheat intake – wheat is discharged from road vehicles and then mechanically transferred to storage bins;
- wheat cleaning and conditioning – wheat is dry cleaned using separation by size, shape and other physical measures, water is then added to ensure the wheat is brought to the correct moisture content for milling;
- milling – wheat is milled by a series of grinding and sieving operations to reduce the grain down to particle size suitable for flour; and
- Storage and packaging – flour is pneumatically transported to bulk storage bins for tanker loading, or other process areas for packaging into bags.

The flour processing building is used to pack flour into small bags (0.5kg and 1.5kg) as well as larger bags and sacks, before they are palletised and despatched. Warehouse 2 is a finished product storage facility, which contains an automatic packing line.

The Environmental Permit is for the following scheduled activities:

*Section 6.8 Part A1 d (ii) Treatment and processing of vegetable raw materials for the intended production of food and animal feed at a plant with a finished product capacity greater than 300 tonnes per day.*

Production capacity is 1200 tonne per day, with manufacturing carried out up to 24 hours per day, 7 days per week.

The main releases to air are dust/ particulate matter arising from the production process, all emission points to air are abated by bag filters, other emissions to air are of the products of combustion from the two 1.42MWth natural gas fired boilers.

There are no process effluent emissions to water from the installation, the main emissions to water are discharges of surface water runoff and boiler blowdown to the River Nene. The site also discharges vehicle wash effluent via an oil water interceptor to an Anglian water sewer.

The site is operated in accordance with an ISO14001 accredited Environmental Management System.

There are no European sites within 10km of the facility. The Wollaston Meadow Site of Special Scientific Interest (SSSI) is within 2km of the facility.

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

<b>Status log of the permit</b>		
<b>Description</b>	<b>Date</b>	<b>Comments</b>
Application EPR/FP3638SF/A001	Duly made 07/04/2005	
Additional information received	14/09/2005	
Additional information received	18/10/2005	
Permit determined EPR/FP3638SF	29/11/2005	Original permit issued to Whitworth Bros.Limited.
Application Variation EPR/FP3638SF/V002 (EP3735LQ)	23/02/2006	Consolidated Variation issues to included new pelletising plant.
Application Variation EPR/FP3638SF/V003	Duly made 27/06/2011	Substantial variation to include new Mill 'C'.
Variation determined EPR/FP3638SF	22/12/2011	Varied permit issued.
Application EPR/FP3638SF/V004 (variation and consolidation)	Regulation 61 Notice response received 21/12/2021	Environment Agency initiated variation and consolidation following the Food, Drink & Milk Industries sector permit review.
Additional information received	14/02/2022	Information relating to BATc 1, 2, 5, 6, 13, 14, 28, EPL specific energy consumption, air emissions, climate change adaptation, and relevant hazardous substances.
	23/09/2022	Updated Reg 61 Response Tool Confirmation of air emission points Updated Emissions Point Plan
	06/12/2022	Information relating to containment
	21/03/2023	ISO 14001 certificate
Variation determined and consolidation issued EPR/FP3638SF (Billing ref. AP3342QF).	21/03/2023	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/FP3638SF

### Issued to

**Whitworth Bros.Limited** (“the operator”)

whose registered office is

**Victoria Mills  
Wellingborough  
Northampton  
NN8 2DT**

company registration number 00465899

to operate a regulated facility at

**Victoria Mill  
London Road  
Wellingborough  
Northampton  
NN8 2DT**

to the extent set out in the schedules.

The notice shall take effect from 21/03/2023

Name	Date
Katherine Fisher	21/03/2023

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/FP3638SF**

This is the consolidated permit referred to in the variation and consolidation notice for application EPR/FP3638SF/V004 authorising,

**Whitworth Bros.Limited** (“the operator”),

whose registered office is

**Victoria Mills  
Wellingborough  
Northampton  
NN8 2DT**

company registration number 00465899

to operate an installation at

**Victoria Mill  
London Road  
Wellingborough  
Northampton  
NN8 2DT**

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

Name	Date
Katherine Fisher	21/03/2023

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, 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.
- 3.1.4 For the following activities 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, 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.

## 4.3 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	S6.8 A1 (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 dispatch of final product. Production capacity is limited to 1200 tonnes per day.
<b>Directly Associated Activity</b>			
AR2	Steam supply	Medium Combustion Plants: 2 x 1.42MWth natural gas-fired boiler	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	Surface water drainage	Collection of uncontaminated site surface waters and boiler blowdown	Handling and storage of site drainage until discharge to the River Nene
AR5	Vehicle wash	Provision of vehicle cleaning facilities	Operation of vehicle washing and discharge to Anglian water sewer via an oil water interceptor

<b>Table S1.2 Operating techniques</b>		
<b>Description</b>	<b>Parts</b>	<b>Date Received</b>
Regulation 61 (1) Notice – Responses to questions dated 21/10/2021	All parts	Received 21/12/2021
Request for further information dated 01/02/2022	Regulation 61 response tool v2 Environmental Risk Assessment Diesel Storage Tank Business Systems – Sustainability Principles Site Protection and Monitoring Programme	14/02/2022
Request for further information dated 22/09/2022	Site filter outlets map V2	23/09/2022

**Table S1.3 Improvement programme requirements**

Reference	Requirement	Date
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.	21/03/2024
IC11	<p>The operator shall submit, for approval by the Environment Agency, a monitoring procedure for particulate matter emissions from principal emission points on site. The procedure must describe how the operator will implement a rolling monitoring programme which shall include, but not be limited to the following:</p> <ol style="list-style-type: none"><li>1. Methodology for how representative monitoring will be carried out annually, with a minimum of 3-point sources on a rolling-basis.</li><li>2. Ensuring the key process stages, wheat cleaning, wheat milling and finished product handling including wheatfeed, are prioritised.</li><li>3. Identify any principal emission points excluded from the rolling monitoring programme and provide a justification for this.</li><li>4. Provide a commencement date for the programme which will demonstrate compliance with the permit requirements.</li></ol> <p>The monitoring procedure shall address the requirements of BAT Conclusions for Food, Drink and Milk Industries with respect to BAT 5.</p>	04/06/2023

## 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. & location	Source	Parameter	Limit (including unit)	Reference period	Monitoring frequency	Monitoring standard or method
A1 on 'site filter outlet map V2'	B mill wheat cleaning intake conveyor exhaust with bag filter	Particulate matter	No set limit	-	-	-
A2 on 'site filter outlet map V2'	A mill general ventilation from mill exhaust with bag filter	Particulate matter	No set limit	-	-	-
A3 on 'site filter outlet map V2'	B mill pneumatics (wheat milling) exhaust with bag filter	Particulate matter	5 mg/m <sup>3</sup> [NOTE 1]	Average over sampling period [NOTE 2]	In line with the rolling monitoring procedure [NOTE 3]	BS EN 13284-1
A4 on 'site filter outlet map V2'	A mill pneumatics (wheat milling) exhaust with bag filter	Particulate matter	5 mg/m <sup>3</sup> [NOTE 1]	Average over sampling period [NOTE 2]	In line with the rolling monitoring procedure [NOTE 3]	BS EN 13284-1
A5 A8 – A10 A11a A17 – A20 A21 – A24 on 'site filter outlet map V2'	Finished product storage silos aspiration exhaust with bag filters	Particulate matter	No set limit	-	-	-
A6 on 'site filter outlet map V2'	B mill milling process exhaust with bag filter	Particulate matter	5 mg/m <sup>3</sup> [NOTE 1]	Average over sampling period [NOTE 2]	In line with the rolling monitoring procedure [NOTE 3]	BS EN 13284-1
A7 on 'site filter outlet map V2'	B mill wheat cleaning grinder exhaust with bag filter	Particulate matter	5 mg/m <sup>3</sup> [NOTE 1]	Average over sampling period [NOTE 2]	In line with the rolling monitoring procedure [NOTE 3]	BS EN 13284-1
A11 on 'site filter outlet map V2'	AB flour transfer silo to silo exhaust with bag filter	Particulate matter	No set limit	-	-	-
A12 on 'site filter outlet map V2'	B mill flour blowline finished product handling exhaust with bag filter	Particulate matter	5 mg/m <sup>3</sup> [NOTE 1]	Average over sampling period [NOTE 2]	In line with the rolling monitoring procedure [NOTE 3]	BS EN 13284-1



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

<b>Emission point ref. &amp; location</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>
A13 on 'site filter outlet map V2'	A mill flour blowline finished product handling exhaust with bag filter	Particulate matter	5 mg/m <sup>3</sup> [NOTE 1]	Average over sampling period [NOTE 2]	In line with the rolling monitoring procedure [NOTE 3]	BS EN 13284-1
A14 on 'site filter outlet map V2'	FTR 3 flour transfer internal pneumatics exhaust with bag filter	Particulate matter	5 mg/m <sup>3</sup> [NOTE 1]	Average over sampling period [NOTE 2]	In line with the rolling monitoring procedure [NOTE 3]	BS EN 13284-1
A16 on 'site filter outlet map V2'	FTR 1 flour transfer internal pneumatics exhaust with bag filter	Particulate matter	5 mg/m <sup>3</sup> [NOTE 1]	Average over sampling period [NOTE 2]	In line with the rolling monitoring procedure [NOTE 3]	BS EN 13284-1
A25 – A26 A31 on 'filter outlet map V2'	Wheat cleaning silos exhaust with bag filters	Particulate matter	No limit set	-	-	-
A33 – A41 on 'site filter outlet map V2'	Small packing line exhaust with bag filter	Particulate matter	No limit set	-	-	-
A43 – A52 on 'site filter outlet map V2'	Packing line bin aspirations exhaust with bag filters	Particulate matter	No limit set	-	-	-
A53 on 'site filter outlet map V2'	Packing warehouse 2 BTH1 packer exhaust with bag filter	Particulate matter	5 mg/m <sup>3</sup> [NOTE 1]	Average over sampling period [NOTE 2]	In line with the rolling monitoring procedure [NOTE 3]	BS EN 13284-1
A55 on 'site filter outlet map V2'	Wheat feed storage bin silo exhaust with bag filter	Particulate matter	No limit set	-	-	-
A56 on 'site filter outlet map V2'	Wheatfeed pellet cooler with exhaust with bag filter	Particulate matter	5mg/m <sup>3</sup> [NOTE 1]	Average over sampling period [NOTE 2]	In line with the rolling monitoring procedure [NOTE 3]	BS EN 13284-1
A57 on 'site filter outlet map V2'	Wheatfeed pelleting filter exhaust with bag filter	Particulate matter	5 mg/m <sup>3</sup> [NOTE 1]	Average over sampling period [NOTE 2]	In line with the rolling monitoring procedure [NOTE 3]	BS EN 13284-1

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

<b>Emission point ref. &amp; location</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>
A60 – A61 on 'site filter outlet map V2'	Wheatfeed pellet silos exhaust with bag filters	Particulate matter	No limit set	-	-	-
AF20 on 'site filter outlet map V2'	Heat treatment silo exhaust with bag filter	Particulate matter	No limit set	-	-	-
AF21 on 'site filter outlet map V2'	Heat treatment milling internal transfer exhaust with bag filter	Particulate matter	No limit set	-	-	-
AF36 A37 on 'site filter outlet map V2'	Heat treatment silos exhaust with bag filters	Particulate matter	No limit set	-	-	-
AF41 on 'site filter outlet map V2'	Silo 3 exhaust with bag filter	Particulate matter	No limit set	-	-	-
AF45 on 'site filter outlet map V2'	Debranner wheat cleaning exhaust with bag filter	Particulate matter	5 mg/m <sup>3</sup> [NOTE 1]	Average over sampling period [NOTE 2]	In line with the rolling monitoring procedure [NOTE 3]	BS EN 13284-1
C1 - C2 on 'site filter outlet map V2'	General intake precleaning exhaust with bag filter	Particulate matter	No limit set	-	-	-
C3 – C5 on 'site filter outlet map V2'	MTKB silo aspirations exhaust with bag filters	Particulate matter	No limit set	-	-	-
C6 on 'site filter outlet map V2'	Flour milling main pneumatics exhaust with bag filter	Particulate matter	5 mg/m <sup>3</sup> [NOTE 1]	Average over sampling period [NOTE 2]	In line with the rolling monitoring procedure [NOTE 3]	BS EN 13284-1
C7 on 'site filter outlet map V2'	Flour milling main pneumatics exhaust with bag filter	Particulate matter	5 mg/m <sup>3</sup> [NOTE 1]	Average over sampling period [NOTE 2]	In line with the rolling monitoring procedure [NOTE 3]	BS EN 13284-1
C8 on 'site filter outlet map V2'	Flour milling main pneumatics exhaust with bag filter	Particulate matter	5 mg/m <sup>3</sup> [NOTE 1]	Average over sampling period [NOTE 2]	In line with the rolling monitoring procedure [NOTE 3]	BS EN 13284-1

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

<b>Emission point ref. &amp; location</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>
C9 on 'site filter outlet map V2'	Flour milling aspiration 1 exhaust with bag filter	Particulate matter	5 mg/m <sup>3</sup> [NOTE 1]	Average over sampling period [NOTE 2]	In line with the rolling monitoring procedure [NOTE 3]	BS EN 13284-1
C10 on 'site filter outlet map V2'	Flour milling aspiration 2 exhaust with bag filter	Particulate matter	5 mg/m <sup>3</sup> [NOTE 1]	Average over sampling period [NOTE 2]	In line with the rolling monitoring procedure [NOTE 3]	BS EN 13284-1
C11 – C17 C19 – C21 on 'site filter outlet map V2'	C mill additive tip silo ventilation exhaust with bag filter	Particulate matter	No limit set	-	-	-
C18 on 'site filter outlet map V2'	Finished product gluten bin exhaust with bag filter	Particulate matter	No limit set	-	-	-
C22 – C30 on 'site filter outlet map V2'	Finished product storage four bins exhaust with bag filters	Particulate matter	No limit set	-	-	-
C31 on 'site filter outlet map V2'	Finished product handling pneumatics (redressing aspirations) exhaust with bag filters	Particulate matter	5 mg/m <sup>3</sup> [NOTE 1]	Average over sampling period [NOTE 2]	In line with the rolling monitoring procedure [NOTE 3]	BS EN 13284-1
C32 on 'site filter outlet map V2'	Finished product handling pneumatics (redressing aspirations) exhaust with bag filters	Particulate matter	5 mg/m <sup>3</sup> [NOTE 1]	Average over sampling period [NOTE 2]	In line with the rolling monitoring procedure [NOTE 3]	BS EN 13284-1
C33 on 'site filter outlet map V2'	Finished product handling wheatfeed aspiration with bag filter	Particulate matter	No limit set	-	-	-
C34 on 'site filter outlet map V2'	Finished product handling wheatfeed aspiration with bag filter	Particulate matter	No limit set	-	-	-
C35 on 'site filter outlet map V2'	Finished product handling wheatfeed	Particulate matter	No limit set	-	-	-

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

<b>Emission point ref. &amp; location</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>
	aspiration with bag filter					
C36 and C37 on 'site filter outlet map V2'	Pellet bins aspiration exhaust with bag filter	Particulate matter	No limit set	-	-	-
B1 on site plan in schedule 7	Boiler stack 1	Oxides of Nitrogen (NO and NO2 expressed as NO2)	250 mg/m <sup>3</sup> [NOTE 4]	Periodic	Every three years	EN 14792
		Carbon Monoxide	No limit set [NOTE 4]	Periodic	Every three years	EM 15058
B2 on site plan in Schedule 7	Boiler stack 2	Oxides of Nitrogen (NO and NO2 expressed as NO2)	250 mg/m <sup>3</sup> [NOTE 4]	Periodic	Every three years	EN 14792
		Carbon Monoxide	No limit set [NOTE 4]	Periodic	Every three years	EM 15058

NOTE 1 – The emission limit applies from 4 December 2023.

NOTE 2 – Average value of three consecutive measurements of at least 30 minutes each.

NOTE 3 – The monitoring frequency shall be in line with the rolling monitoring procedure, as agreed in IC11.

NOTE 4 – The emission limit and/or monitoring requirements apply from 1 January 2030, unless otherwise advised by the Environment Agency or the boiler is replaced.

**Table S3.2 Point Source emissions to water (other than sewer) and land – emission limits and monitoring requirements**

<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>
W1 on site plan in schedule 7 emission to River Nene	Uncontaminated surface water runoff and boiler blowdown	No parameters set	No limit set	-	-	-
W2 on site plan in schedule 7 emission to River Nene	Uncontaminated surface water runoff	No parameters set	No limit set	-	-	-
W3 on site plan in schedule 7 emission to River Nene	Uncontaminated surface water runoff	No parameters set	No limit set	-	-	-
W4 on site plan in schedule 7 emission to River Nene	Uncontaminated surface water runoff	No parameters set	No limit set	-	-	-

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

<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>
S1 on site plan in schedule 7 emission to Anglian water sewer	Wastewater from the vehicle external wash discharged via an oil water interceptor	No parameters set	No limit set	-	-	-

## 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 Parameters as required by condition 3.5.1	A3, A4, A6, A7, A12, A13, A14, A16, A53, A56, A57, AF45, C6, C7, C8, C9, C10, C31, C32	Every 12 months (in accordance with the rolling monitoring procedure, as agreed in IC11)	1 January
	B1 & B2	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>
Products produced	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>
Energy usage	Annually	MWh
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	
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>	
To be notified within 24 hours of detection	
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>	
To be notified within 24 hours of detection	
Description of where the effect on the environment was detected	
Substances(s) detected	
Concentrations of substances detected	
Date of monitoring/sampling	

**Part B – to be submitted as soon as practicable**

Any more accurate information on the matters for notification under Part A.	
Measures taken, or intended to be taken, to prevent a recurrence of the incident	
Measures taken, or intended to be taken, to rectify, limit or prevent any pollution of the environment which has been or may be caused by the emission	
The dates of any unauthorised emissions from the facility in the preceding 24 months.	



Name*	
Post	
Signature	
Date	

\* authorised to sign on behalf of the operator

## Schedule 6 – Interpretation

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

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

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

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

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

“groundwater” means all water, which is below the surface of the ground in the saturation zone and in direct contact with the ground or subsoil.

“Industrial Emissions Directive” means DIRECTIVE 2010/75/EU OF THE EUROPEAN PARLIAMENT AND OF THE COUNCIL of 24 November 2010 on industrial emissions, 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.

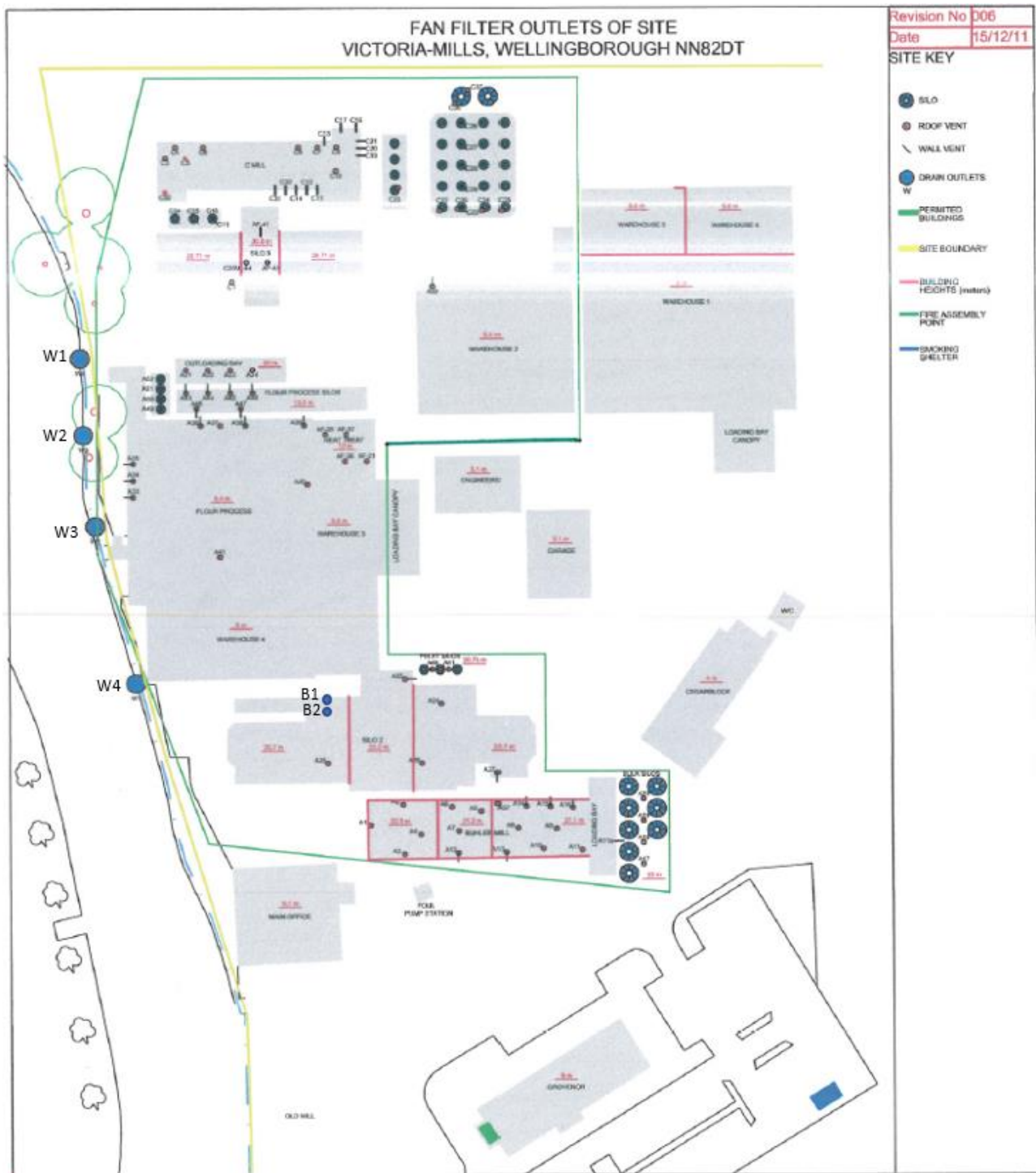
Where a minimum limit is set for any emission parameter, for example pH, reference to exceeding the limit shall mean that the parameter shall not be less than that limit.

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 other than gas engines or gas turbines, 6% dry for solid fuels; and/or
- in relation to emissions from gas engines or gas turbines, the concentration in dry air at a temperature of 273K, at a pressure of 101.3 kPa and with an oxygen content of 15% dry for liquid and gaseous fuels ; and/or
- in relation to emissions from non-combustion sources, the concentration at a temperature of 273K and at a pressure of 101.3 kPa, with no correction for water vapour content

“year” means calendar year ending 31 December.

# Schedule 7 – Site plan



END OF PERMIT