



Environment  
Agency

# Notice of variation and consolidation with introductory note

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

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Nestle UK Limited

Nestle UK Limited

Dalston

Carlisle

Cumbria

CA5 7NH

## **Variation application number**

EPR/BO9310IB/V007

## **Permit number**

EPR/BO9310IB

# Nestle UK Limited

## Permit number EPR/BO9310IB

### 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 2025.

The schedules specify the changes made to the permit.

The installation is located in Dalston, 4 miles south west of Carlisle. The installation was built in 1962 and is operated by Nestle UK Limited. From the fresh milk delivered to the factory dairy milk powder, coffee mate, cappuccino, hot chocolate and variants are produced, and cream is sold off as a by-product. All products leaving the site are powders, except for the cream.

The fresh milk is initially subjected to evaporation, pasteurisation and homogenisation. The condensate from the evaporation system is used for boiler feed water and Clean in Place (CIP) system pre-rinse. The product is dried by two spray driers which are powered by two high efficiency natural gas fired air heaters; each of the heaters is fitted with low NO<sub>x</sub> burners. To minimise dust emissions bag filters have been fitted to improve cyclone abatement on both spray driers. The product is then subjected to chilling through the use of a single cooling tower with three fan units and two hydrocarbon cooling units. Prior to dispatch the various final products are mixed and blended and packaged.

The site has management and housekeeping procedures in place including the use of dry clean up techniques to reduce on site water usage. The Clean In Place system is controlled by PLC (Programmable Logic Control) to maximise efficiency and reduce effluent volumes.

The installation has emissions to air, sewer and to the River Caldew.

The emissions to air consist of combustion gases from the boiler plant and spray drier air heaters, and particulates from the spray drier and associated equipment. The onsite effluent treatment plant, commissioned in 2006, discharges to Dalston WWTW (Waste Water Treatment Works) which is owned and operated by United Utilities for further treatment prior to discharge to the River Caldew. Surface water from the installation is discharged directly into the River Caldew.

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 received	Duly made 30/05/2006	Application for a dairy site.
Permit determined BO9310IB	04/09/2007	Permit issued Nestle UK Ltd
Application EPR/BO9310IB/V002 (variation)	Duly made 06/12/2013	Application to vary the permit to include two new air heaters, addition of bag filters and address a number of minor error corrections.
Schedule 5 response EPR/B09310IB/V002	05/02/2014	'H1' risk assessment for emissions of NOx and CO from new indirect air heaters Egron 1 and Egron 2.
Schedule 5 response EPR/B09310IB/V002	05/03/2014	Plan drawing showing water abstraction, emission and monitoring points to controlled waters.
Variation determined EPR/BO9310IB	15/04/2014	Varied permit issued.
Application received EPR/BO9310IB/V007 (variation and consolidation)	Duly made 20/09/2017	Application to vary and update the permit to modern conditions.
Additional information received	12/01/2018	Information received in response to a Schedule 5 request made 24/11/2017: <ul style="list-style-type: none"> <li>Operational Sound Model report and calibration data.</li> <li>Raw noise model data</li> </ul>
Variation determined EPR/BO9310IB (PAS Billing Ref: DP3433JH)	04/05/2018	Varied permit issued to Nestle UK Ltd.
Application EPR/BO9310IB/V004 Received	10/04/19	Application returned.
Application EPR/BO9310IB/V005	Duly made 09/07/19	Application to correct permit error.
Variation determined EPR/BO9310IB (PAS Billing Ref. RP3801PG)	16/08/19	Varied permit issued.
Application EPR/BO9310IB/V006	26/03/21	Application withdrawn.
Application EPR/BO9310IB/V007 (Variation and consolidation)	Regulation 61 notice response received 12/09/2022	Environment Agency initiated variation and consolidation following the Food, Drink & Milk Industries sector permit review.
Request for further information dated 21/03/23	13/04/2023	Further information provided regarding the following BATc: 6, 9, 11, 13 and clarification regarding the appropriate scheduled activity type, MCPD emission points, site capacity effluent treatment and emission points plan.
Variation determined and consolidation issued EPR/BO9310IB (Billing ref. RP3801PG)	17/05/2023	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/BO9310IB

### Issued to

**Nestle UK Limited** (“the operator”)

whose registered office is

**1 City Place  
Beehive Ring Road  
Gatwick  
RH6 0PA**

company registration number 00051491

to operate a regulated facility at

**Nestle UK Limited  
Dalston  
Carlisle  
Cumbria  
CA5 7NH**

to the extent set out in the schedules.

The notice shall take effect from 16/05/2023.

Name	Date
Rebecca Brough	17/05/2023

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/BO9310IB**

This is the consolidated permit referred to in the variation and consolidation notice for application EPR/BO9310IB/V007 authorising,

**Nestle UK Limited** (“the operator”),

whose registered office is

**1 City Place  
Beehive Ring Road  
Gatwick  
RH6 0PA**

company registration number 00051491

to operate an installation at

**Nestle UK Limited  
Dalston  
Carlisle  
Cumbria  
CA5 7NH**

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

<b>Name</b>	<b>Date</b>
<b>Rebecca Brough</b>	<b>17/05/2023</b>

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 (AR1 boiler 1 and 2 emission point) the first monitoring measurements shall be carried out within four months of 01/01/2025 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 & S3.3 unless otherwise agreed in writing by the Environment Agency.

### **3.6 Pests**

- 3.6.1 The activities shall not give rise to the presence of pests which are likely to cause pollution, hazard or annoyance outside the boundary of the site. The operator shall not be taken to have breached this condition if appropriate measures, including, but not limited to, those specified in any approved pests management plan, have been taken to prevent or where that is not practicable, to minimise the presence of pests on the site.
- 3.6.2 The operator shall:
  - (a) if notified by the Environment Agency, submit to the Environment Agency for approval within the period specified, a pests management plan which identifies and minimises risks of pollution from pests;
  - (b) implement the pests management plan, from the date of approval, unless otherwise agreed in writing by the Environment Agency.

## **4 Information**

### **4.1 Records**

- 4.1.1 All records required to be made by this permit shall:
  - (a) be legible;
  - (b) be made as soon as reasonably practicable;
  - (c) if amended, be amended in such a way that the original and any subsequent amendments remain legible, or are capable of retrieval; and

(d) be retained, unless otherwise agreed in writing by the Environment Agency, for at least 6 years from the date when the records were made, or in the case of the following records until permit surrender:

- (i) off-site environmental effects; and
- (ii) matters which affect the condition of the land and groundwater.

4.1.2 The operator shall keep on site all records, plans and the management system required to be maintained by this permit, unless otherwise agreed in writing by the Environment Agency.

## 4.2 Reporting

4.2.1 The operator shall send all reports and notifications required by the permit to the Environment Agency using the contact details supplied in writing by the Environment Agency.

4.2.2 A report or reports on the performance of the activities over the previous year shall be submitted to the Environment Agency by 31 January (or other date agreed in writing by the Environment Agency) each year. The report(s) shall include as a minimum:

- (a) a review of the results of the monitoring and assessment carried out in accordance with the permit including an interpretive review of that data;
- (b) the annual production/treatment data set out in schedule 4 table S4.2; and
- (c) the performance parameters set out in schedule 4 table S4.3 using the forms specified in table S4.4 of that schedule.

4.2.3 Within 28 days of the end of the reporting period the operator shall, unless otherwise agreed in writing by the Environment Agency, submit reports of the monitoring and assessment carried out in accordance with the conditions of this permit, as follows:

- (a) in respect of the parameters and emission points specified in schedule 4 table S4.1;
- (b) for the reporting periods specified in schedule 4 table S4.1 and using the forms specified in schedule 4 table S4.4; and
- (c) giving the information from such results and assessments as may be required by the forms specified in those tables.

4.2.4 The operator shall, unless notice under this condition has been served within the preceding four years, submit to the Environment Agency, within six months of receipt of a written notice, a report assessing whether there are other appropriate measures that could be taken to prevent, or where that is not practicable, to minimise pollution.

## 4.3 Notifications

4.3.1 In the event:

- (a) that the operation of the activities gives rise to an incident or accident which significantly affects or may significantly affect the environment, the operator must immediately—
  - (i) inform the Environment Agency,
  - (ii) take the measures necessary to limit the environmental consequences of such an incident or accident, and
  - (iii) take the measures necessary to prevent further possible incidents or accidents;
- (b) of a breach of any permit condition the operator must immediately—
  - (i) inform the Environment Agency, and
  - (ii) take the measures necessary to ensure that compliance is restored within the shortest possible time;

- (c) of a breach of permit condition which poses an immediate danger to human health or threatens to cause an immediate significant adverse effect on the environment, the operator must immediately suspend the operation of the activities or the relevant part of it until compliance with the permit conditions has been restored.

4.3.2 Any information provided under condition 4.3.1 shall be confirmed by sending the information listed in schedule 5 to this permit within the time period specified in that schedule.

4.3.3 Where the Environment Agency has requested in writing that it shall be notified when the operator is to undertake monitoring and/or spot sampling, the operator shall inform the Environment Agency when the relevant monitoring and/or spot sampling is to take place. The operator shall provide this information to the Environment Agency at least 14 days before the date the monitoring is to be undertaken.

4.3.4 The Environment Agency shall be notified within 14 days of the occurrence of the following matters, except where such disclosure is prohibited by Stock Exchange rules:

Where the operator is a registered company:

- (a) any change in the operator's trading name, registered name or registered office address; and
- (b) any steps taken with a view to the operator going into administration, entering into a company voluntary arrangement or being wound up.

Where the operator is a corporate body other than a registered company:

- (a) any change in the operator's name or address; and
- (b) any steps taken with a view to the dissolution of the operator.

In any other case:

- (a) the death of any of the named operators (where the operator consists of more than one named individual);
- (b) any change in the operator's name(s) or address(es); and
- (c) any steps taken with a view to the operator, or any one of them, going into bankruptcy, entering into a composition or arrangement with creditors, or, in the case of them being in a partnership, dissolving the partnership.

4.3.5 Where the operator proposes to make a change in the nature or functioning, or an extension of the activities, which may have consequences for the environment and the change is not otherwise the subject of an application for approval under the Regulations or this permit:

- (a) the Environment Agency shall be notified at least 14 days before making the change; and
- (b) the notification shall contain a description of the proposed change in operation.

4.3.6 The Environment Agency shall be given at least 14 days' notice before implementation of any part of the site closure plan.

4.3.7 Where the operator has entered into a climate change agreement with the Government, the Environment Agency shall be notified within one month of:

- (a) a decision by the Secretary of State not to re-certify the agreement;
- (b) a decision by either the operator or the Secretary of State to terminate the agreement; and
- (c) any subsequent decision by the Secretary of State to re-certify such an agreement.

## 4.4 Interpretation

4.4.1 In this permit the expressions listed in schedule 6 shall have the meaning given in that schedule.

4.4.2 In this permit references to reports and notifications mean written reports and notifications, except where reference is made to notification being made “immediately”, in which case it may be provided by telephone.

# Schedule 1 – Operations

<b>Table S1.1 activities</b>			
<b>Activity reference</b>	<b>Activity listed in Schedule 1 of the EP Regulations</b>	<b>Description of specified activity</b>	<b>Limits of specified activity</b>
AR1	Section 6.8 Part A1 (d) (iii) (aa)	Treating and processing milk for the production of cappuccino, milk powder, hot chocolate, whiteners and cream.	From receipt of raw materials to manufacture, storage and dispatch of finished product, cleaning of process plant and the storage, handling and dispatch of waste arising from the production process.  Production capacity is limited to 160 tonnes per day.
AR2	Section 5.4 Part A1 (a) (i)	Disposal of non-hazardous waste with a capacity exceeding 50 tonnes per day involving biological treatment.  D8: Biological treatment of waste waters for the purposes of disposal.	From collection of effluent from all process areas to the effluent treatment plant to the discharge to public sewer.
<b>Directly Associated Activity</b>			
AR3	Steam Generation	Medium Combustion plants: 1 x 8.1 MWth natural gas boiler 1 x 12.7 MWth natural gas boiler	From receipt of fuel to release of products of combustion to air.
AR4	Heat Generation	Two air heaters used for generating heat for the spray driers	Indirect air heaters for Egron 1 (1.85MWth) and Egron 2 (4.27MWth). Receipt of natural gas from burning of fuel in appliances to release of air emissions.
AR5	Cooling plant	Hydrocarbon (R1270 - Propylene) cooling systems used to generate cooling for the process	From receipt of raw materials to cooling for the process. Also includes oil receipt and storage, and demineralised water plant.
AR6	Cooling plant	Ammonia (R717) cooling systems used to generate cooling for the process	From receipt of raw materials to cooling of water
AR7	Cooling tower	Evaporative cooling towers using flow of air (R729) across a cooling pack to generate cooling water for the process	From receipt of raw materials to cooling of water
AR8	Storage and use of chemicals and oils	Storage and use of chemicals and oils at the installation.	From receipt of chemicals and oils to disposal of wastes arising.

<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>
AR9	Waste storage and handling	Storage and handling of waste materials	From generation of waste to storage pending removal for disposal or recovery.
AR10	Surface water drainage	Collection of uncontaminated site surface waters	Handling and storage of site drainage until discharge to the site surface water system.

<b>Table S1.2 Operating techniques</b>		
<b>Description</b>	<b>Parts</b>	<b>Date Received</b>
Application	The response to section 2.1, excluding 2.1.3 and 2.1.5, and 2.2 in the Application.	25/05/2006
Variation Application EPR/BO9310IB/V002	The response to questions in Section 3 of application form EPC-Part C3	31/10/2013
Variation Application EPR/BO9310IB/V003	Part C2 and C3 of the Application and all referenced supporting documentation.	Duly Made 20/09/2017
Regulation 61 (1) Notice – Responses to questions dated 24/03/22	All parts	Received 12/09/22
Regulation 61(1) Notice – request for further information dated 24/03/23	Further information regarding the following BATc: 6, 9, 11, 13 and clarification regarding the appropriate scheduled activity type, MCPD emission points, site capacity and effluent treatment	Received 13/04/2023

<b>Table S1.3 Improvement programme requirements</b>		
<b>Reference</b>	<b>Requirement</b>	<b>Date</b>
IC8	<p>The operator shall submit, for approval by the Environment Agency, a report setting out progress to achieving the Best Available Techniques Conclusion 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"> <li>1) Current performance against the BAT-AELs.</li> <li>2) Methodology for reaching the BAT-AELs.</li> <li>3) Associated targets /timelines for reaching compliance by 4 December 2023.</li> <li>4) Any alterations to the initial plan (in progress reports).</li> </ol> <p>The report shall address the BAT Conclusions for Food, Drink and Milk industries with respect to the following:</p> <ul style="list-style-type: none"> <li>• BAT 23 Table 10 (compliance with BAT-AELs for channelled dust emissions to air from drying)</li> </ul> <p>Refer to BAT Conclusions for a full description of the BAT requirement.</p>	04 Dec 2023
IC9	<p>The operator shall submit, for approval by the Environment Agency, a report setting out progress to achieving the Best Available Techniques Conclusion Associated Emission Levels (BAT-AELs) where BAT is currently not achieved (emission point A8) but will be achieved before 4</p>	4 Dec 2025

<b>Table S1.3 Improvement programme requirements</b>		
<b>Reference</b>	<b>Requirement</b>	<b>Date</b>
	<p>December 2025. The report shall include, but not be limited to, the following:</p> <ol style="list-style-type: none"> <li>1) Current performance against the BAT-AELs.</li> <li>2) Methodology for reaching the BAT-AELs.</li> <li>3) Associated targets /timelines for reaching compliance by 4 December 2023.</li> <li>4) Any alterations to the initial plan (in progress reports).</li> </ol> <p>The report shall address the BAT Conclusions for Food, Drink and Milk industries with respect to the following:</p> <ul style="list-style-type: none"> <li>• BAT 23 Table 10 (compliance with BAT-AELs for channelled dust emissions to air from drying)</li> </ul> <p>Refer to BAT Conclusions for a full description of the BAT requirement.</p>	
IC10	<p>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 point A4, A5 and A8, 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.</p>	12 months from permit issue



## Schedule 2 – Waste types, raw materials and fuels

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

## Schedule 3 – Emissions and monitoring

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 [Point A1 on site plan in Schedule 7]	Existing medium combustion fuelled on natural gas 1 x 12.7 MWth boiler 1 x 8.1 MWth boiler	Oxides of Nitrogen (NO and NO <sub>2</sub> expressed as NO <sub>x</sub> )	200 mg/m <sup>3</sup> Limit applies from 01/01/2025	Periodic	Annually from date of acceptance of first monitoring measurements under condition 3.1.4.	MCERTS BS EN 14792 [Note 1]
		Carbon monoxide	No Limit	Periodic	Annually from date of acceptance of first monitoring measurements under condition 3.1.4.	MCERTS BS EN15058
A2 [Point A2 on site plan in Schedule 7]	Egron 1 Spray drier – indirect air heating exhaust (1.85 MWth)	No parameters set	No limit set	.	.	-
A3 [Point A3 on site plan in Schedule 7]	Egron 2 Spray drier – indirect air heating exhaust (4.27 MWth)	No parameters set	No limit set	--	--	-
A4 [Point A4 on site plan in schedule 7]	Egron 1 spray drier bag filter	Particulate matter	10 mg/m <sup>3</sup> [Note 3]	Average over sampling period	Annually	BS EN 13284-1
A5 [Point A5 on site plan in Schedule 7]	Egron 2 spray drier bag filter	Particulate matter	20 mg/m <sup>3</sup> [Note 2]	Hourly average	Continuous	BS EN 13284-1
		Particulate matter	10 mg/m <sup>3</sup> [Note 3]	Average over sampling period	Annually	BS EN 13284-1
A6 [Point A6 on site plan in Schedule 7]	Egron 2 Hot Air Stack Valve (start up only)	-	-	-	-	-

<b>Table S3.1 Point source emissions to air – emission limits and monitoring requirements</b>						
<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>
A7 [Point A7 on site plan in schedule 7]	Egron 1 Hot Air Stack Valve (start up only)	-	-	-	-	-
A8 [Point A8 on site plan in schedule 7]	Air cooler Discharge Egron 2 Double cyclone	Particulate matter	10 mg/m <sup>3</sup> [Note 4]	Average over sampling period	Annually	BS EN 13284-1

**Note 1:**

Monitoring requirements are defined at a temperature of 273.15 K, a pressure of 101.3 kPa and after correction for the water vapour content of the waste gases at a standardised O<sub>2</sub> content of 6% for solid fuels, 15% for engines and gas turbines and 3% all other MCPs

Note 2 – This emission limit applies until 3 December 2023. (Existing plant only).

Note 3 – This emission limit applies from 4 December 2023, unless otherwise advised by the Environment Agency. (Existing plant only).

Note 4 - This emission limit applies from 4 December 2025, unless otherwise advised by the Environment Agency. (New plant only).

<b>Table S3.2 Point Source emissions to water (other than sewer) and land – emission limits and monitoring requirements</b>						
<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>
W3 [Point W3 on site plan in schedule 7] emission to River Caldeu	Uncontaminated surface water runoff	No parameter 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 [Point S1 on site plan in schedule 7] emission to United Utilities Dalston Waste Water Treatment Works]	Treated process effluent from onsite effluent treatment plant	No parameters set	No limit set	--	--	--
S2 [Point S2 on site plan in schedule 7] emission to United Utilities Dalston Waste Water Treatment Works]	Treated process effluent from onsite effluent treatment plant	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	A4, A5, A8	Every 12 months	1 January
	A1 (MCPD Boiler emission point)	First monitoring undertaken in accordance with Condition 3.1.4 to be reported within 3 months, and then annually 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>
Final product	tonnes
Cream despatched	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
Food 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
Food Waste	Food waste Reporting Form, or other form as agreed in writing by the Environment Agency	Version 1 06/02/2023
Other performance parameters	Other Performance Parameters Reporting Form, or other form as agreed in writing by the Environment Agency	Version 1, 08/03/2021

# Schedule 5 – Notification

These pages outline the information that the operator must provide.

Units of measurement used in information supplied under Part A and B requirements shall be appropriate to the circumstances of the emission. Where appropriate, a comparison should be made of actual emissions and authorised emission limits.

If any information is considered commercially confidential, it should be separated from non-confidential information, supplied on a separate sheet and accompanied by an application for commercial confidentiality under the provisions of the EP Regulations.

## Part A

Permit Number	
Name of operator	
Location of Facility	
Time and date of the detection	

<b>(a) Notification requirements for any malfunction, breakdown or failure of equipment or techniques, accident, or emission of a substance not controlled by an emission limit which has caused, is causing or may cause significant pollution</b>	
<b>To be notified within 24 hours of detection</b>	
Date and time of the event	
Reference or description of the location of the event	
Description of where any release into the environment took place	
Substances(s) potentially released	
Best estimate of the quantity or rate of release of substances	
Measures taken, or intended to be taken, to stop any emission	
Description of the failure or accident.	

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

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

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

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

<b>(d) Notification requirements for the detection of any significant adverse environmental effect</b>	
<b>To be notified within 24 hours of detection</b>	
Description of where the effect on the environment was detected	
Substances(s) detected	
Concentrations of substances detected	
Date of monitoring/sampling	

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

Any more accurate information on the matters for notification under Part A.	
Measures taken, or intended to be taken, to prevent a recurrence of the incident	



Measures taken, or intended to be taken, to rectify, limit or prevent any pollution of the environment which has been or may be caused by the emission	
The dates of any unauthorised emissions from the facility in the preceding 24 months.	

Name*	
Post	
Signature	
Date	

\* authorised to sign on behalf of the operator

## Schedule 6 – Interpretation

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

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

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

“average over the sampling period” means the average value of three consecutive measurements of at least 30 minutes each, unless otherwise stated, as defined in the General Considerations section of the Food, Drink & Milk Industries BAT Conclusions.

“disposal” means any of the operations provided for in Annex I to the Water framework Directive.

“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.

“Food waste” reporting: Reporting of food waste to use a methodology such as the global Food Loss and Waste Accounting and Reporting Standard (FLW standard) , WRAP’s Target Measure Act initiative or similar.

“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.

“recovery” means any of the operations provided for in Annex II to the Waste Framework Directive.

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

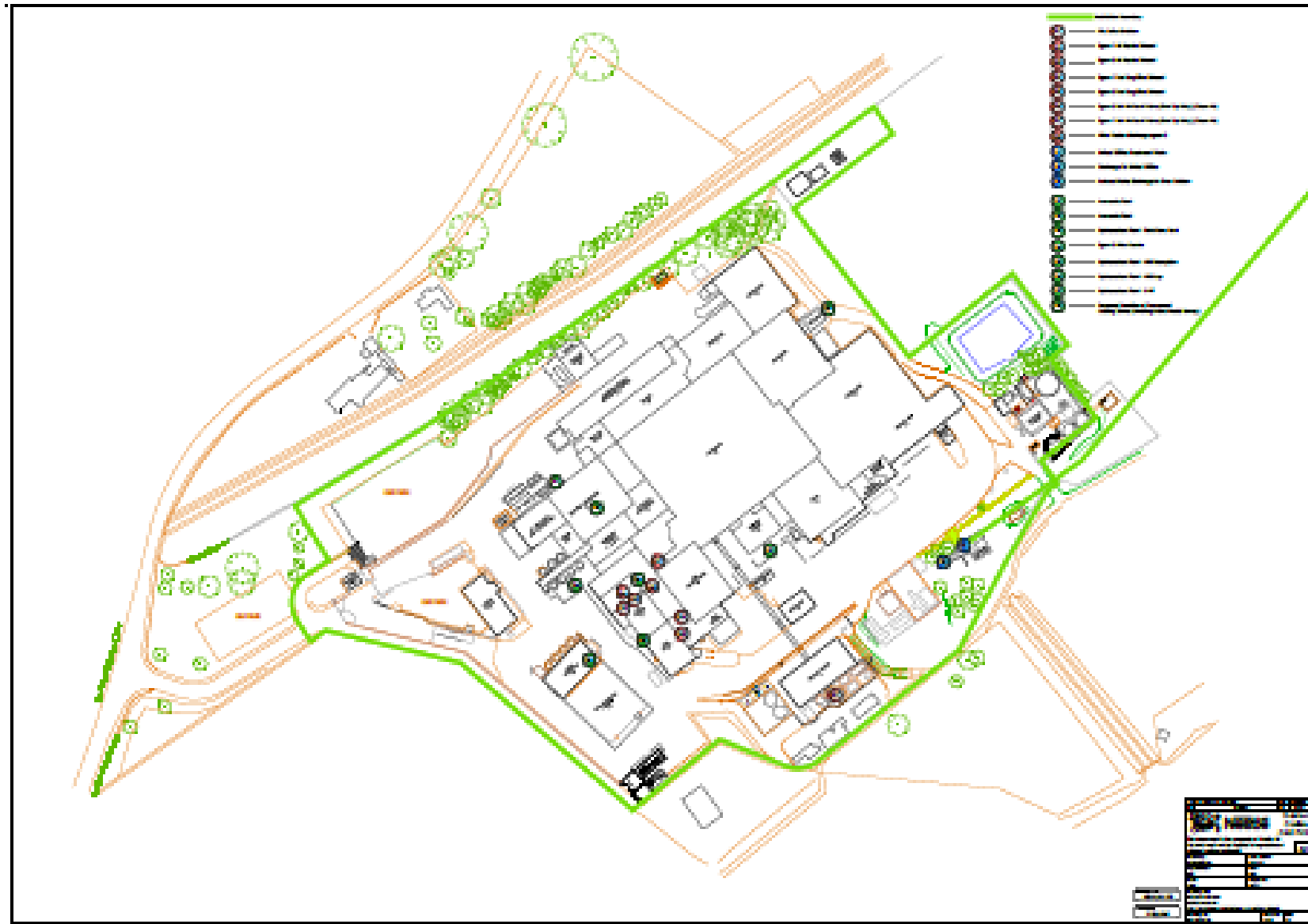
Unless otherwise stated, any references in this permit to concentrations of substances in emissions into air means:

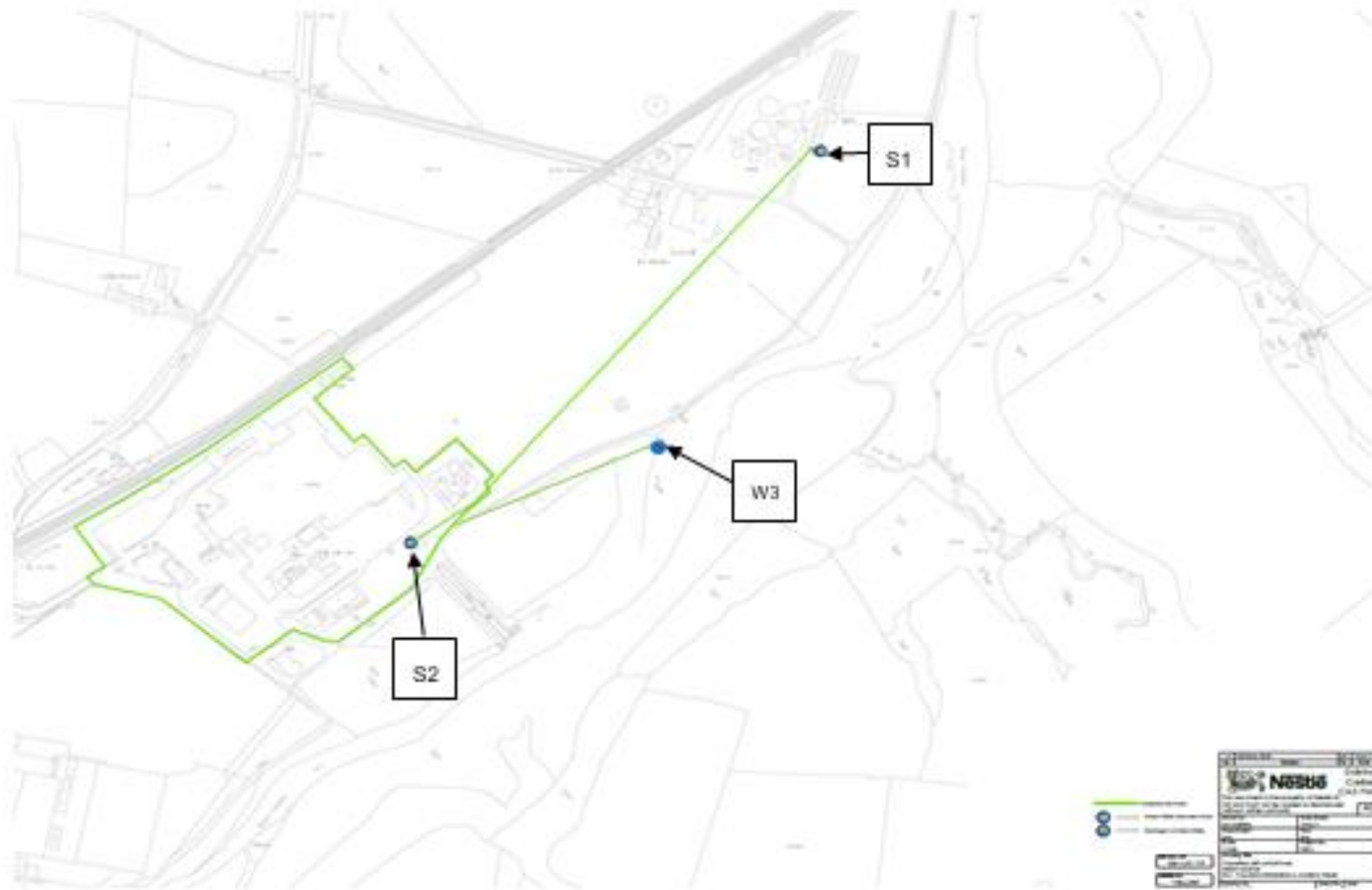
- in relation to emissions from combustion processes, the concentration in dry air at a temperature of 273K, at a pressure of 101.3 kPa and with an oxygen content of 3% dry for liquid and gaseous fuels, 6% dry for solid fuels; and/or

- in relation to emissions from 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





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END OF PERMIT

Permit number  
EPR/BO9310IB

## Emissions to Air Reporting Form

**Permit number:** EPR/BO9310IB

**Operator:** Nestle UK Limited

**Facility name:** Nestle UK - Dalston

**Emissions to Air Reporting Form: version 1, 08/03/2021**

Reporting of emissions to air for the period from [DD/MM/YY] to [DD/MM/YY]

<b>Emission point</b>	<b>Substance / parameter</b>	<b>Emission Limit Value</b>	<b>Reference period</b>	<b>Test method <sup>1</sup></b>	<b>Result <sup>2</sup></b>	<b>Sample dates and times <sup>3</sup></b>	<b>Uncertainty <sup>4</sup></b>
<i>[e.g. A1]</i>	<i>[e.g. Oxides of nitrogen (NO and NO<sub>2</sub> expressed as NO<sub>2</sub>)]</i>	<i>[e.g. 200 mg/m<sup>3</sup>]</i>	<i>[e.g. daily average]</i>	<i>[e.g. BS EN 14181]</i>	<i>[State result]</i>	<i>[State relevant dates and time periods]</i>	<i>[State uncertainty if not 95% confidence interval]</i>

**Signed:** [Name]

**Date:** [DD/MM/YY]

(Authorised to sign as representative of the operator)

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**Guidance for use:** Use this form to report your monitoring results.

Example text is shown in bracketed grey italics. Replace the example text by entering your own site specific information. Complete columns 1 to 5 using the information from schedule 3 of your permit. Complete columns 6 to 8 with your monitoring data. Add additional rows as necessary.

<sup>1</sup> Where an internationally recognised standard test method is used, give the reference number. Where another method that has been formally agreed with the Environment Agency, give the appropriate identifier. In other cases state the principal technique, for example gas chromatography.

- <sup>2</sup> Give the result as the maximum value (or the minimum value in the case of a limit that is expressed as a minimum) obtained during the reporting period, expressed in the same terms as the emission limit value. Where the emission limit value is expressed as a range, give the result as the 'minimum to maximum' of the measured values.
- <sup>3</sup> For non-continuous measurements give the date and time of the sample that produced the result. For continuous measurements give the percentage of the process operating time covered by the result.
- <sup>4</sup> Complete if the uncertainty associated with the result is not a 95% confidence interval. Leave blank for 95% confidence intervals.

## Water Usage Reporting Form

**Permit number:** EPR/BO9310IB

**Operator:** Nestle UK Limited

**Facility name:** Nestle UK - Dalston

**Water Usage Reporting Form: version 1, 08/03/2021**

Reporting of water usage for the year [YYYY]

Water source	Water usage (m <sup>3</sup> )	Specific water usage (m <sup>3</sup> /tonne of product) <sup>2</sup>

**Operator's comments**

**Signed:** [Name]

**Date:** [DD/MM/YY]



(Authorised to sign as representative of the operator)

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**Guidance for use:** Use this form to report your annual water usage.

Example text is shown in bracketed grey italics. Replace the example text by entering your own site specific information. Add additional rows as necessary.

## Energy Usage Reporting Form

Permit number: EPR/BO9310IN

Operator: Nestle UK Limited

Facility name: Nestle UK - Dalston

Energy Usage Reporting Form: version 1, 08/03/2021

Reporting of energy usage for the year [YYYY]

Energy source	Energy consumption / production (MWh)	Specific energy consumption (MWh/tonne of product) <sup>2</sup>
Total	<i>[insert total energy use in MWh]</i>	<i>[insert total energy use per tonne of product MWh/tonne of product]</i>

<b>Operator's comments</b>

**Signed:** *[Name]*

**Date:** *[DD/MM/YY]*

(Authorised to sign as representative of the operator)

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**Guidance for use:** Use this form to report your annual energy usage.

Example text is shown in bracketed grey italics. Replace the example text by entering your own site specific information. Add additional rows as necessary.

<sup>1</sup> Multiply delivered electricity by 2.4 to convert to primary energy where the electricity is supplied from the national grid. If the electricity is supplied from another source, specify the conversion factor used. Add additional rows as needed if electricity is imported from multiple sources.

<sup>2</sup> Divide energy consumption by an appropriate unit of raw material processed or product output.

## Food Waste Reporting Form

Permit number: EPR/BO9310IB

Operator: Nestle UK Limited

Facility name: Nestle UK - Dalston

Food Waste Reporting Form: version 1, 06/02/2023

Reporting of food waste for the period from [DD/MM/YY] to [DD/MM/YY]

<b>Overall food waste (tonnes)</b>	
<b>Food waste as % of product</b>	
<b>Food waste disposal routes</b>	<i>As specified below</i>

<b>Source</b>	<b>Tonnage</b>
<b>Redistribution for human consumption</b>	
<b>Animal feed</b>	
<b>Bio-based materials/biochemical processing (e.g. feedstock for other industrial products)</b>	
<b>Anaerobic digestion/codigestion</b>	
<b>Composting/aerobic processes</b>	
<b>Incineration/controlled combustion</b>	

<b>Land application</b>	
<b>Landfill</b>	
<b>Sewer/wastewater treatment (e.g. as COD)</b>	
<b>Other (Please specify)</b>	

**Signed:** [Name]

**Date:** [DD/MM/YY]

(Authorised to sign as representative of the operator)

**Guidance for use:** Use this form to report your food waste metrics.

Example text is shown in bracketed grey italics. Replace the example text by entering your own site specific information.

**Rationale:** Avoidance of food waste is a key issue for the sector, both nationally and globally, and is subject to a United Nations Sustainable Development Goal: SDG 12.3: “By 2030, halve per capita global food waste at the retail and consumer levels and reduce food losses along production and supply chains, including post-harvest losses”.

This complements Defra’s Food and drink waste hierarchy: deal with surplus and waste - GOV.UK (www.gov.uk) and WRAP’s Target Measure Act Initiative.

Reporting of food waste should be to a set methodology such as the global Food Loss and Waste Accounting and Reporting Standard (FLW standard).

# Other Performance Parameters Reporting Form

Permit number: **EPR/BO9310IB**

Operator: **Nestle UK Limited**

Facility name: **Nestle UK - Dalston**  
**08/03/2021**

**Other Performance Parameters Reporting Form: version 1,**

Reporting of other performance parameters for the period from *[DD/MM/YY]* to *[DD/MM/YY]*

Parameter	Units
<i>[e.g. Total raw material usage]</i>	<i>[e.g. tonnes per production unit]</i>

<b>Operator's comments</b>

<b>Operator's comments</b>

**Signed:**     *[Name]*

**Date:**       *[DD/MM/YY]*

(Authorised to sign as representative of the operator)

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**Guidance for use:** Use this form to report the performance parameters (other than water and energy) required by your permit. Example text is shown in bracketed grey italics. Replace the example text by entering your own site specific information. The parameters to report and units to be used can be found in the 'Performance parameters' table in schedule 4 of your permit. Add additional rows as necessary.