

# Notice of variation and consolidation with introductory note

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

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Muller UK & Ireland Group LLP

Sevenside Dairies  
Oldends Lane  
Stonehouse  
Gloucestershire  
GL10 2DG

**Variation application number**

EPR/TP3838RM/V004

**Permit number**

EPR/TP3838RM

# Sevenside Dairies

## Permit number EPR/TP3838RM

### 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 for boilers numbered F3, F4 and F5 commissioned in 1978. Boilers numbered F1 and F2 have been commissioned in 2021. All boilers have a capacity greater than 5 MWth.

The schedules specify the changes made to the permit.

The main features of the permit are as follows:

Sevenside Dairy has a process capacity of 2,064 tonnes of raw milk per day that is stored in nine raw milk silos of 250 tonnes each. This is used to produce bottled pasteurised milk, potted cream, flavoured milks, skimmed milk, buttermilk powder, and butter. The site operates 24-hour per day, 365 days per year. The installation is located in Stonehouse town in the Stroud District of Gloucestershire in southwestern England. The town centre is 2.5 miles east of the M5 motorway, junction 13. National Grid Reference (NGR) SO 79622 05802.

From the delivery of raw milk and storage in silos, the milk is pumped to different processing areas including milk separation, cream processing, butter churning, skim concentrate, evaporation and drying, and flavoured milk. The manufacturing process involves filtering, heating, pasteurisation, homogenisation, evaporation, churning, drying, chilling, and packaging with further processes such as the addition of ingredients for flavoured milk.

For the manufacturing process, 5 natural gas fired boilers are used to generate steam; 3 of these boilers with the capacity of, Boiler F3 – 11.2 MWth, Boiler F4 and F5 – 7.4 MWth each, are considered “existent” medium combustion plants (MCP) under the Medium Combustion Plant Directive (MCPD) having been commissioned in 1978. Boilers F1 and F2, with an individual capacity of 8.7 MWth each, are considered “new” MCPs under MCPD, having been commissioned in 2021. The associated emissions to air from these boilers are emitted through emission points A1 for boilers F1 and F2, A4 for boiler F3, A5 for boiler F4, and A6 for boiler F5. A back up diesel generator is positioned on site for use in emergencies only, to ensure continued operation of the effluent treatment plant. The generator has a self-contained tank to enable a few hours run time, this tank is topped up manually as necessary from the diesel store on site.

The site effluent treatment plant handles all the waste water produced by the installation. All of the foul water collected at the site arrives in the in the fall pit where it is screened before being sent to the Dissolved Air Filtration (DAF) unit to remove non soluble material. From there it can either be discharged to the Severn Trent sewer through discharge point S1 or moved on for further processing. Further processing includes Bio reactors, membrane screening, ultra-filtration, PH balancing and reverse osmosis before being sent back to process as recycled water of discharged through emission point W1 as clean water to the Frome River.

Part of the effluent comes from clean in place systems (CIP), of which 14 are automatic and 9 manually operated, and 5 deluge systems. CIP systems allow the use of high temperature washes and strong cleaning solutions to clean enclosed systems such as tanks and pipework. Deluge systems clean the outside areas of fillers and conveyors that come in contact with milk.

There are a number of sensitive receptors in the form of Local Wildlife sites, River Frome and Stroudwater Canal within 100 metres; SACs Cotswold Beechwoods 9.8km, Rodborough Common 5.4km, and Severn Estuary 5.6km; SPAs Walmore Common 1.1km and Severn Estuary 5.6km; RAMSARs Walmore Common 10.1km, Severn Estuary 5.6km, 9 Local Wildlife sites within 2.1km, and 4 Ancient Woodlands within 1.7km radius.

The installation operations are governed by an ISO:14001 accredited EMS.

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>
Agency variation determined EPR/BP3532SW/V003	22/11/2013	Agency variation to implement the changes introduced by the IED.
Application EPR/BP3532SW/V004	Duly made 01/09/2015	Application to update effluent treatment plant and recovery of process waters.
Variation determined EPR/BP3532SW/V004	27/11/2015	Varied permit issued.
Application EPR/TP3838RM/T001 (full transfer of permit EPR/BP3532SW)	Duly made 26/11/2015	Application to transfer the permit in full to Muller UK & Ireland Group LLP.
Transfer determined EPR/TP3838RM	27/12/2015	Full transfer of permit complete.
Application EPR/TP3838RM/V002	12/04/2021	Application withdrawn.
Application EPR/TP3838RM/V003	Duly made 20/01/2022	Application to add combustion plant.
Additional information received Application EPR/TP3838RM/V003	13/06/2022	Confirmation of boiler sizes and operational management arrangements for the CHP.
Variation determined EPR/TP3838RM/V003 (billing ref: RP3003LE)	06/09/2022	Notice of variation issued
Application EPR/TP3838RM/V004 (variation and consolidation)	Regulation 61 Notice response received 22/07/2022	Environment Agency initiated variation and consolidation following the Food, Drink & Milk Industries sector permit review.
Additional information received Application EPR/TP3838RM/V004	17/01/2023	Further information request concerning MCPs, SCR, capacity, non-technical description
Additional information received Application EPR/TP3838RM/V004	30/01/2023	Further information request concerning OMP, BATc 4 and total nitrogen.
Variation determined and consolidation issued EPR/TP3838RM (Billing ref. GP3720PA).	29/03/2023	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/TP3838RM

### Issued to

**Muller UK & Ireland Group LLP** (“the operator”)

whose registered office is

**Tern Valley Business Park**

**Shrewsbury Road**

**Market Drayton**

**Shropshire**

**TF9 3SQ**

limited liability partnership number OC384928

to operate a regulated facility at

**Sevenside Dairies**

**Oldends Lane**

**Stonehouse**

**Gloucestershire**

**GL10 2DG**

to the extent set out in the schedules.

The notice shall take effect from 29/03/2023.

Name	Date
Marcus Woodward	29/03/2023

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/TP3838RM**

This is the consolidated permit referred to in the variation and consolidation notice for application EPR/TP3838RM/V004 authorising,

**Muller UK & Ireland Group LLP** (“the operator”),

whose registered office is

**Tern Valley Business Park**

**Shrewsbury Road**

**Market Drayton**

**Shropshire**

**TF9 3SQ**

limited liability partnership number OC384928

to operate an installation at

**Sevenside Dairies**

**Oldends Lane**

**Stonehouse**

**Gloucestershire**

**GL10 2DG**

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

Name	Date
Marcus Woodward	29/03/2023

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 The first monitoring measurements shall be carried out within four months of 01/01/2025 or 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.

### **3.4 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 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.
- 3.5.3 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:

- (c) the death of any of the named operators (where the operator consists of more than one named individual);
- (d) any change in the operator's name(s) or address(es); and
- (e) 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

Table S1.1 activities			
Activity reference	Activity listed in Schedule 1 of the EP Regulations	Description of specified activity	Limits of specified activity
AR1	S6.8 A1 (e)	Treating and processing milk with the quantity of milk received being more than 200 tonnes per day (average value on annual basis)	From receipt of raw milk delivered to the site to the dispatch of processed packaged milk, cream, butter, skimmed milk powder, flavoured milk drinks, and Buttermilk powder.  Production capacity is limited to 2064 tonnes per day.
AR2	S5.4 A1 (a)	Disposal of non-hazardous waste with a capacity exceeding 50 tonnes per day involving -  (ii) physico-chemical treatment	From generation of waste water to discharge. Effluent treatment plant – treatment of waste process waters by screening, balancing, chemical dosing, flocculation, DAF – discharge to Severn Trent Water Works,  Or, biological treatment, sludge thickener, MBR, ultrafiltration, and reverse osmosis – discharge to River Frome.
<b>Directly Associated Activity</b>			
AR3	Steam supply	Medium Combustion plants fuelled by natural gas only: <b>Boiler F1:</b> 8.7 MWth <b>Boiler F2:</b> 8.7 MWth <b>Boiler F3:</b> 11.2 MWth <b>Boiler F4:</b> 7.4 MWth <b>Boiler F5:</b> 7.4 MWth	From receipt of fuel to release of products of combustion to air.
AR4	Raw material storage and handling	Storage and handling of raw materials at the installation	From receipt of raw materials to dispatch of final product.
AR5	Use of refrigerants	Use of refrigerants in cooling, chilling and/or freezing systems at the installation.	From receipt of raw materials to dispatch of final product.
AR6	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>
AR7	Waste storage and handling	Storage and handling of waste materials	From generation of waste to storage pending removal for disposal or recovery.
AR8	Surface water drainage	Collection of uncontaminated site surface waters and treated effluent	Handling and storage of site drainage until discharge to River Frome following reverse osmosis treatment.
AR9	Process cooling waters	Operation of ten cooling towers	From operation of cooling towers, including chemical dosing.

<b>Table S1.2 Operating techniques</b>		
<b>Description</b>	<b>Parts</b>	<b>Date Received</b>
Application EPR/BP3532SW/A001	The responses to questions 2.1.13-14, 2.2.6, 2.2.13, 2.2.19, 2.2.24, 2.2.46-49, 2.2.54, 2.10.1-2, B2.10.4-5, 2.10.9-10, 2.10.12-13 and 2.10.19 of the application.	29/03/2005
Application for Variation EPR/BP3532SW/V004 (received 01/09/2015)	The responses to questions in Form C2, 1a, 3d, 5a, 5c and 6. The responses to questions in Form C3, 3a, 4a, 6b, 6d and 6e.	Duly made 01/09/2015
Application EPR/TP3838RM/V003 (received 03/02/2021)	Parts C2 and C3 of the application and all referenced supporting documentation.	Duly made 20/01/2022
Regulation 61 (1) Notice – Responses to questions dated 24/03/2022	All parts	22/07/2022
Regulation 61(1) Notice – request for further information dated 13/01/2023	Additional information received in relation to BATcs 5, 6, 11, 12, EPL for energy and wastewater discharge, capacity, SCR, MCPs, air emissions, refrigerant gases, updated site plan, non-technical description,	17/01/2023
Additional information 26/01/2023	OMP, BATc 4 and total nitrogen values	30/01/2023

<b>Table S1.3 Improvement programme requirements</b>		
<b>Reference</b>	<b>Requirement</b>	<b>Date</b>
IC14	The operator shall submit, for approval by Environment Agency, a report setting out progress to achieving the 'Narrative' BAT 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: 1) Methodology for achieving BAT 2) Associated targets /timelines for reaching compliance by 4 December 2023	04/12/2023

Table S1.3 Improvement programme requirements		
Reference	Requirement	Date
	<p>3) Any alterations to the initial plan (in progress reports). The report shall address the BAT Conclusions for Food, Drink and Milk Industries with respect to BAT 4, 5 and 15. Refer to BAT Conclusions for a full description of the BAT requirement.</p>	
IC15	<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 BATc 12 and 23 are 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 12 Table 1 (compliance with BAT-AELs for direct discharges to a receiving water body)</li> <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>	04/12/2023
IC16	<p>The Operator shall submit an updated Odour Management Plan to the Environment Agency for technical assessment and approval, demonstrating compliance against BAT 15 for the FDM industries. Further guidance on OMPs can be found on our website Odour management: environmental permits - GOV.UK (<a href="http://www.gov.uk">www.gov.uk</a>)</p> <p>The updated plan must include the following elements:</p> <ul style="list-style-type: none"> <li>• a protocol containing actions and timelines;</li> <li>• a protocol for conducting odour emissions monitoring;</li> <li>• a protocol for response to identified odour events, eg complaints;</li> <li>• an odour reduction programme designed to identify the source(s), to measure/estimate odour exposure, to characterise the contributions of the sources and to implement prevention and/or reduction measures.</li> </ul> <p>The odour management plan should be reviewed at least annually to ensure continued compliance against BAT 15 as described above.</p> <p>You must implement the plan as agreed, and from the date stipulated by the Environment Agency.</p>	04/12/2023

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

<b>Table S2.1 Raw materials and fuels</b>	
<b>Raw materials and fuel description</b>	<b>Specification</b>
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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 – Shared stack servicing Boilers F1 and F2 [Point A1 on site plan in Schedule 7]	Boiler Plant Boiler F1: 8.7 MWth Natural Gas fired	Oxides of Nitrogen (NO and NO <sub>2</sub> expressed as NO <sub>2</sub> )	100 mg/m <sup>3</sup>	Periodic	Annually	BS EN 15267-3 [Note 1]
		Carbon monoxide (CO)	No Limit	Periodic	Annually	MCERTS BS EN15058
A1 – Shared stack servicing Boilers F1 and F2 [Point A1 on site plan in Schedule 7]	Boiler Plant Boiler F2: 8.7 MWth Natural Gas fired	Oxides of Nitrogen (NO and NO <sub>2</sub> expressed as NO <sub>2</sub> )	100 mg/m <sup>3</sup>	Periodic	Annually	BS EN 15267-3
		Carbon monoxide (CO)	No Limit	Periodic	Annually	MCERTS BS EN15058
A4 – Boiler stack [Point A4 on site plan in Schedule 7]	Boiler Plant Boiler F3: 11.2 MWth Natural Gas fired	Oxides of Nitrogen (NO and NO <sub>2</sub> expressed as NO <sub>2</sub> )	175 mg/m <sup>3</sup>	Periodic	Annually	BS EN 15267-3
		Carbon monoxide (CO)	No Limit	Periodic	Annually	MCERTS BS EN15058
A5 – Boiler stack [Point A5 on site plan in Schedule 7]	Boiler Plant Boiler F4: 7.4 MWth Natural Gas fired	Oxides of Nitrogen (NO and NO <sub>2</sub> expressed as NO <sub>2</sub> )	175 mg/m <sup>3</sup>	Periodic	Annually	BS EN 15267-3
		Carbon monoxide (CO)	No Limit	Periodic	Annually	MCERTS BS EN15058
A6 – Boiler stack [Point A6 on site plan in Schedule 7]	Boiler Plant Boiler F5: 7.4 MWth Natural Gas fired	Oxides of Nitrogen (NO and NO <sub>2</sub> expressed as NO <sub>2</sub> )	175 mg/m <sup>3</sup>	Periodic	Annually	BS EN 15267-3
		Carbon monoxide (CO)	No Limit	Periodic	Annually	MCERTS BS EN15058
A7 – Spray dryer	Niro scrubber –	Particulate matter	From <b>04/12/2023</b>	Average over	Annually	EN 13284-1

<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>
[Point A7 on site plan in Schedule 7]	cyclone and wet scrubber		10 mg/m <sup>3</sup>	sampling period		
A8 – Drying bed [Point A8 on site plan in Schedule 7]	Niro scrubber – cyclone and wet scrubber	Particulate matter	From <b>04/12/2023</b> 10 mg/m <sup>3</sup>	Average over sampling period	Annually	EN 13284-1
A5 – Domestic boiler [Point not shown on site plan in Schedule 7]	Central heating Boiler under 1 MWth capacity Natural Gas fired	No parameter set	No Limit set	--	--	--

Note 1: certification to the MCERTS performance standards indicates compliance with BS EN 15267-3

<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) [Note 3]</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 Frome	Effluent treatment plant	Total daily volume of discharge	1800 m <sup>3</sup> /day	24-hour total	Continuous	MCERTS self-monitoring of effluent flow scheme
W1 on site plan in schedule 7 emission to River Frome	Effluent Treatment Plant	pH	6-9	Average	Monthly	--
W1 on site plan in schedule 7 emission to River Frome	Effluent Treatment Plant	Ammoniacal nitrogen as N	5 mg/l	Average	Monthly	BS EN ISO 11732
	Effluent Treatment Plant	Biochemical oxygen demand (BOD)	25 mg/l	Average	Monthly	BS EN 1899-1
W1 on site plan in schedule 7 emission to River Frome	Effluent Treatment Plant	Total suspended solids (TSS)	45 mg	Average	Monthly	BS EN 872:1996, BS 6068-2.54:1996
W1 on site plan in schedule 7 emission to River Frome	Effluent Treatment Plant	Chemical Oxygen Demand (COD) <sup>Note1</sup>	125 mg/l	Average	Daily	--

<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) [Note 3]</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 Frome	Effluent Treatment plant	Total Nitrogen (TN)	20 mg/l	Average	Daily	EN 12260, EN ISO 11905-1.
W1 on site plan in schedule 7 emission to River Frome	Effluent Treatment Plant	Total Phosphorus (TP)	4 mg/l	Average	Daily	EN ISO 6878, EN ISO 15681-1 and -2, ENISO 11885.
W1 on site plan in schedule 7 emission to River Frome	Surface water via interceptors	No parameters set	No limit set	--	--	--

Note 1: TOC and COD are alternatives. TOC is the preferred option because it does not rely upon the use of very toxic chemicals.

Note 2: if the emission levels are proven to be sufficiently stable, a lower monitoring frequency can be adopted, but in any case at least every month.

Note 3: Emission limit applies from 4 December 2023, unless otherwise advised by the Environment Agency.

<b>Table S3.3 Point source emissions to sewer, effluent treatment plant or other transfers off-site– 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>
S1 [Point S1 on site plan in schedule 7] emission to Severn Trent Sewage Treatment Works	Treated process effluent from onsite effluent treatment plant and foul water	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.

Parameter	Emission or monitoring point/reference	Reporting period	Period begins
Point source emissions to air Parameters as required by condition 3.5.1	<b>A1</b> - MCPD Boiler F1 emission point <b>A2</b> - MCPD Boiler F2 emission point <b>A3</b> - MCPD Boiler F3 emission point <b>A4</b> - MCPD Boiler F4 emission point <b>A5</b> - MCPD Boiler F5 emission point	Annually	1 January
Point source emissions to water (other than sewer) Parameters as required by condition 3.5.1	<b>W1</b> – River discharge emission point	Quarterly	1 January, 1 April, 1 July & 1 October

Parameter	Units
Pasteurised milk	tonnes
Cream	tonnes
Butter	tonnes
Flavoured milk drinks	tonnes
Skimmed milk powder	tonnes
Buttermilk powder	tonnes

Parameter	Frequency of assessment	Units
Water usage	Annually	m <sup>3</sup>
Total non-hazardous waste/Tonne total product	Annually	Tonne waste/Tonne product
Specific water usage (yearly average)	Annually	m <sup>3</sup> /tonne of products
Energy usage	Annually	MWh
Specific energy consumption (yearly average)	Annually	MWh/ tonne of products
Food waste	Annually	tonnes
COD efficiency	Annually*	COD te/te product

<b>Table S4.3 Performance parameters</b>		
<b>Parameter</b>	<b>Frequency of assessment</b>	<b>Units</b>
*COD efficiency to be calculated on a weekly frequency, reported annually		

<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
Point source emissions to water (other than sewer)	Emissions to Water Reporting Form, or other form as agreed in writing by the Environment Agency	Version 1, 08/03/2021
Point source emissions to sewer	Emissions to Sewer 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	
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.	
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<b>(d) Notification requirements for the detection of any significant adverse environmental effect</b>	
<b>To be notified within 24 hours of detection</b>	
Description of where the effect on the environment was detected	
Substances(s) detected	
Concentrations of substances detected	
Date of monitoring/sampling	

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

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

Name*	
Post	
Signature	
Date	

\* authorised to sign on behalf of the operator

## Schedule 6 – Interpretation

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

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

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

“emissions to land” includes emissions to groundwater.

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

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

“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.

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:

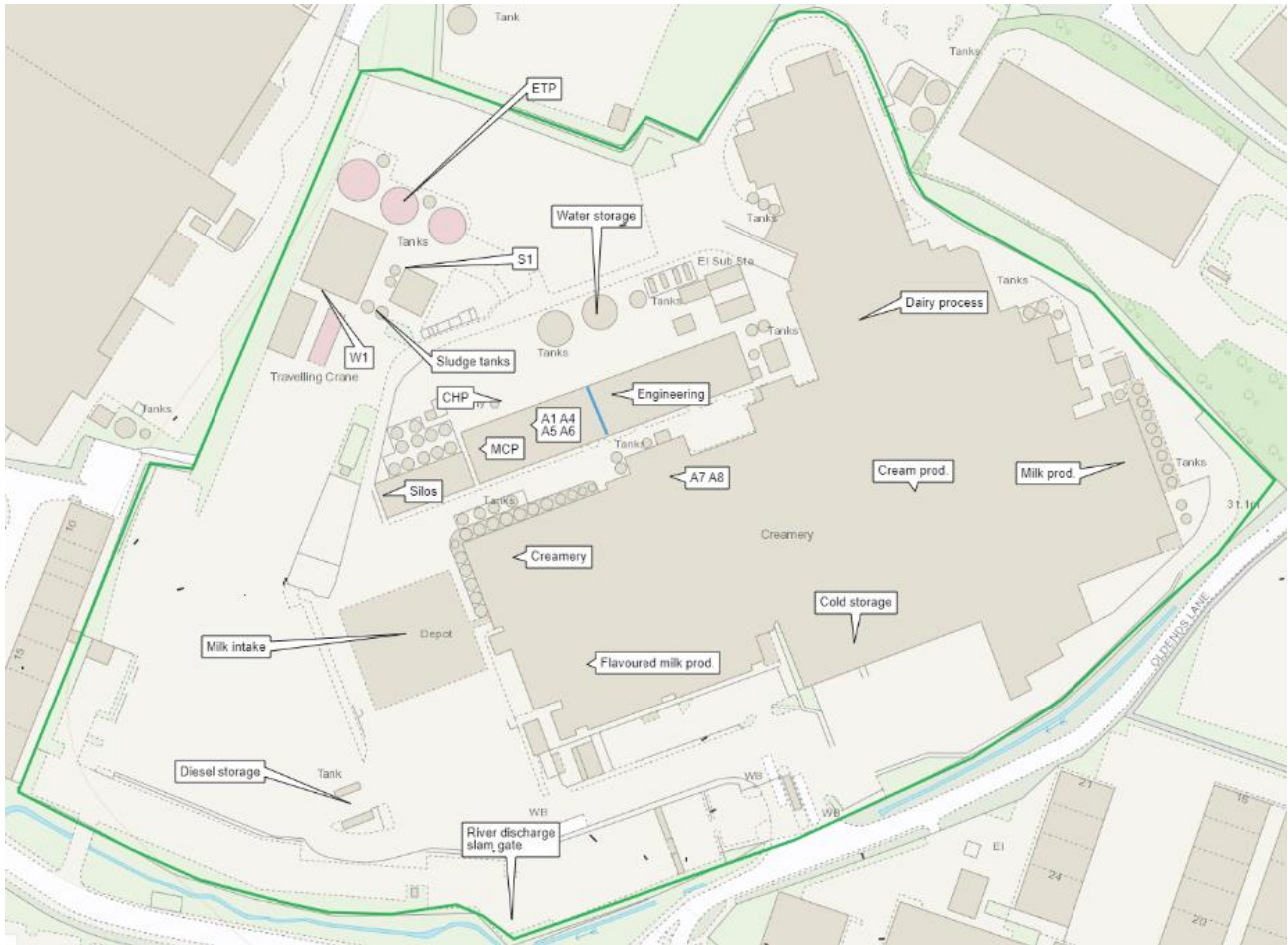
- in relation to emissions from combustion processes, the concentration in dry air at a temperature of 273K, at a pressure of 101.3 kPa and with an oxygen content of 3% dry for liquid and gaseous fuels other than gas engines or gas turbines, 6% dry for solid fuels; and/or



- 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



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END OF PERMIT