

Notice of variation and consolidation with introductory note

The Environmental Permitting (England & Wales) Regulations 2016

Arla Foods Limited
Taw Valley Creamery
North Tawton
Okehampton
Devon
EX20 2DA

Variation application number

EPR/NP3638NN/V005

Permit number

EPR/NP3638NN

Taw Valley Creamery

Permit number EPR/NP3638NN

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 4th 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 main features of the permit are as follows.

Taw Valley Creamery, located 1km West of North Tawton, NGR SS6532501433, has a capacity of 1,850 tonnes per day. It produces cheddar cheese and other types of cheeses from raw milk, including whey powder, whey protein concentrate, cream, and butter. The incoming milk is first pasteurised and then processed into the desired dairy product which is kept in refrigerated storage prior to dispatch. The whey powder is produced in drying towers.

During the production process, wastewaters generated from manufacturing processes, cleaning (CIP) and contaminated surface water from drains are treated in the on-site effluent treatment plant (ETP) through biological treatment consisting of fat removal, primary screening, chemical dosing, flocculation, sedimentation, sludge dewatering, tertiary treatment through sand filtration and discharged to River Taw through discharge point W1. Uncontaminated surface waters from roofs and yards is discharged to the same river via emission point W2. Resulting sludge from the ETP process is dewatered and exported from the site for land spreading purposes.

For production purposes, medium combustion plants (MCPs) with a combined capacity of 26.8 MWth for the purpose of generating steam and electrical energy; these are Boiler 1 with a capacity of 10.9 MWth, Boiler 2 with a capacity of 11.3 MWth, and a combined heat and power (CHP) with a capacity of 4.6 MWth, all fuelled by natural gas. During the combustion process, there are air emissions released through emission point A2 for Boiler 1, A3 for Boiler 2, and A7 for the CHP. Other air emission points are A4 and A5 associated with drying of whey permeate powder, and a range of vents servicing CIP, steam valves vents, and condensate valves. The air abatement method used for emission points A4 and A5 are bag filters.

The site is located at less than 10Km from Dartmoor SAC.

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

Status log of the permit		
Description	Date	Comments
Application received EPR/BX0857IN	Duly made 14/03/2005	Application received for the treatment and processing of milk
Permit EPR/BX0857IN/V001 issued	17/06/2005	Permit issued to The Cheese Company, commencement of regulation under IPPC.
Variation Application BX0857IN/V002	17/10/2008	Environment Agency initiated variation issued to amend emissions tables for particulate matter.
Variation Application BX0857IN/V003	Duly made 06/07/2011	Application variation following changes to the operating techniques.
Variation Application BX0857IN/V003	25/07/2011	Variation issued.
Application Transfer EPR/NP3638NN/T001	Duly made 07/05/2013	Full transfer of permit EPR/BX0857IN
Variation Application NP3638NN issued	18/06/2013	Transfer of Permit from The Cheese Company to Arla Foods Limited.
Variation Application NP3638NN/V002	19/02/2015	Environment Agency initiated variation to implement regulatory changes arising from IED.
Variation Application EPR/NP3638NN/V003	Duly made 17/06/2020	Application to replace some combustion plant and install a combined heat and power unit.
Variation Application EPR/NP3638NN/V004	21/12/2021	Pre-application
Application EPR/NP3638NN/V005 (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.
Request for Further Information	13/02/2023	Information provided in relation to Reg.61 Response BATcs, site plan, emission points, ETP.
Variation determined and consolidation issued EPR/NP3638NN (Billing ref. GP3747JM).	28/04/2023	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/NP3638NN

Issued to

Arla Foods Limited (“the operator”)

whose registered office is

**Arla House
4 Savannah Way
Leeds Valley Park
Leeds
LS10 1AB**

company registration number 02143253

to operate a regulated facility at

**Taw Valley Creamery
North Tawton
Okehampton
Devon
EX20 2DA**

to the extent set out in the schedules.

The notice shall take effect from 28/04/2023.

Name	Date
Marcus Woodward	28/04/2023

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/NP3638NN

This is the consolidated permit referred to in the variation and consolidation notice for application EPR/NP3638NN/V005 authorising,

Arla Foods Limited (“the operator”),

whose registered office is

**Arla House
4 Savannah Way
Leeds Valley Park
Leeds
LS10 1AB**

company registration number 02143253

to operate an installation at

**Taw Valley Creamery
North Tawton
Okehampton
Devon
EX20 2DA**

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

Name	Date
Marcus Woodward	28/04/2023

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 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.

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

2.4 Improvement programme

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

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

3 Emissions and monitoring

3.1 Emissions to water, air or land

3.1.1 There shall be no point source emissions to water, air or land except from the sources and emission points listed in schedule 3 tables S3.1 and S3.2.

3.1.2 The limits given in schedule 3 shall not be exceeded.

- 3.1.3 Periodic monitoring shall be carried out at least once every 5 years for groundwater and 10 years for soil, unless such monitoring is based on a systematic appraisal of the risk of contamination.
- 3.1.4 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.
- 3.3.2 The operator shall:
- (a) if notified by the Environment Agency that the activities are giving rise to pollution outside the site due to odour, submit to the Environment Agency for approval within the period specified, an odour management plan which identifies and minimises the risks of pollution from odour;
 - (b) implement the approved odour management plan, from the date of approval, unless otherwise agreed in writing by the Environment Agency.

3.4 Noise and vibration

- 3.4.1 Emissions from the activities shall be free from noise and vibration at levels likely to cause pollution outside the site, as perceived by an authorised officer of the Environment Agency, unless the operator has used appropriate measures, including, but not limited to, those specified in any approved noise and vibration management plan to prevent or where that is not practicable to minimise the noise and vibration.
- 3.4.2 The operator shall:
- (a) if notified by the Environment Agency that the activities are giving rise to pollution outside the site due to noise and vibration, submit to the Environment Agency for approval within the period specified, a noise and vibration management plan which identifies and minimises the risks of pollution from noise and vibration;
 - (b) implement the approved noise and vibration management plan, from the date of approval, unless otherwise agreed in writing by the Environment Agency.

3.5 Monitoring

- 3.5.1 The operator shall, unless otherwise agreed in writing by the Environment Agency, undertake the monitoring specified in the following tables in schedule 3 to this permit:
- (a) point source emissions specified in tables S3.1 and S3.2.
- 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 and S3.2 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

Table S1.1 activities			
Activity reference	Activity listed in Schedule 1 of the EP Regulations	Description of specified activity	Limits of specified activity
AR1	Section 6.8 Part 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 products including cheese, whey powder, whey protein concentrate, cream, and butter. Production capacity is limited to 1850 tonnes per day.
AR2	Section 5.4 Part A1 (a) (i)	Biological treatment of non-hazardous wastewater.	From generation of waste water to discharge to River. Taw following ETP treatment consisting of fat removal, primary screening, chemical dosing, flocculation, sedimentation, sludge dewatering, tertiary treatment through sand filtration and discharge. Contaminated surface water is treated in ETP prior to discharge.
Directly Associated Activity			
AR3	Steam and electrical power supply	Medium Combustion plants: 26.8 MWth combined power, natural gas-fired. Boiler 1: 10.9 MWth Boiler 2: 11.3 MWth CHP 1: 6.1 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.
AR7	Waste storage and handling	Storage and handling of waste materials	From generation of waste to storage pending removal for disposal or recovery.
AR8	Process cooling waters	Operation of 4 cooling towers	From operation of cooling towers, including chemical dosing.

Table S1.1 activities			
Activity reference	Activity listed in Schedule 1 of the EP Regulations	Description of specified activity	Limits of specified activity
AR9	Surface water drainage	Collection of uncontaminated site surface waters	Handling and storage of site drainage until discharge to the site surface water system and discharge to River Taw.

Table S1.2 Operating techniques		
Description	Parts	Date Received
Original permit application	The response given to questions 2.1 and 2.2 given in pages 12 to 39 of the application and the response given in question 2.10 on pages 59 to 61 of the application.	14/03/2005
Application BX0857IN/V003	Part C3: response to question 3a	17/06/2011
Additional information	Email correcting the source of emission point A6	21/07/2011
Application NP3638NN/V003	Response to further information – site combustion capacity	10/11/2020
Regulation 61 (1) Notice – Responses to questions dated 25/03/2023	All parts	22/07/2022
Request for further information dates 13/02/2023	Request for information regarding the installation's capacity, BATcs 1, 4, 6(a), 9, 11, 12, ETP process, BAT-AELs, effluent characteristics, MCP, cooling towers, RHS, description of primary activity, non-technical summary.	27/02/2023

Table S1.3 Improvement programme requirements		
Reference	Requirement	Date
IC19	<p>The operator shall submit, for approval by Environment Agency, a report setting out progress to achieving the 'Narrative' BAT is currently not achieved but will be achieved before 4 December 2023. The report shall include, but not be limited to, the following:</p> <ol style="list-style-type: none"> 1) Methodology for achieving BAT 2) Associated targets /timelines for reaching compliance by 4 December 2023 3) Any alterations to the initial plan (in progress reports). <p>The report shall address the BAT Conclusions for Food, Drink and Milk Industries with respect to BAT 4 and 6.</p> <p>Refer to BAT Conclusions for a full description of the BAT requirement.</p>	04/12/2023
IC20	<p>The operator shall use refrigerants without ozone depletion potential and with a low global warming potential (GWP) in accordance with BAT 9 from the Food, Drink and Milk Industries BATCs.</p> <p>To demonstrate compliance against BAT 9, the operator shall develop a replacement plan for the refrigerant system(s) at the installation. This shall be</p>	04/12/2023

Table S1.3 Improvement programme requirements		
Reference	Requirement	Date
	<p>incorporated within the existing environmental management system by the specified date.</p> <p>The plan should include, but not be limited to, the following:</p> <ul style="list-style-type: none"> • Where practicable, retro filling systems containing high GWP refrigerants e.g. R-404A with lower GWP alternatives as soon as possible. • An action log with timescales, for replacement of end-of-life equipment using refrigerants with the lowest practicable GWP. 	
IC21	<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"> 1) Current performance against the BAT-AELs. 2) Methodology for reaching the BAT-AELs. 3) Associated targets /timelines for reaching compliance by 4 December 2023. 4) Any alterations to the initial plan (in progress reports). <p>The report shall address the BAT Conclusions for Food, Drink and Milk industries with respect to the following:</p> <ul style="list-style-type: none"> • BAT 12 Table 1 (compliance with BAT-AELs for direct discharges to a receiving water body). • BAT 23 Table 4 (compliance with BAT-AELs for channelled dust emissions to air from grinding and pellet cooling in compound feed manufacture) <p>Refer to BAT Conclusions for a full description of the BAT requirement.</p> <ul style="list-style-type: none"> • BAT 23 Table 10 (compliance with BAT-AEL for channelled dust emissions to air from drying). 	04/12/2023
IC22	<p>The operator shall submit as climate change adaptation plan to the Environment Agency for approval.</p> <p>The plan shall include, but not be limited to:</p> <ul style="list-style-type: none"> • Details of how the installation has or could be affected by severe weather; • The scale of the impact of severe weather on the operations within the installation; • An action plan and timetable for any improvements to be made to minimise the impact of severe weather at the installation. <p>The Operator shall implement any necessary improvements to a timetable agreed in writing with the Environment Agency.</p>	12 months from permit issue
IC23	<p>The Operator shall undertake a survey of the site effluent treatment plant (ETP) and milk silos primary, secondary and tertiary containment and review measures against relevant standard including:</p> <ul style="list-style-type: none"> • CIRIA Containment systems for the prevention of pollution (C736) – Secondary, tertiary, and other measures for industrial and commercial premises, • EEMUA 159 - Above ground flat bottomed storage tanks <p>The operator shall submit a written report to the Environment Agency approval which outlines the results of the survey and the review of standard and provide details of</p> <ul style="list-style-type: none"> • current containment measures • any deficiencies identified in comparison to relevant standards, • improvements proposed • time scale for implementation of improvements. <p>The operator shall implement the proposed improvements in line with the timescales agreed by 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
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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
A2 [Point A2 on site plan in Schedule 7]	Boiler Plant Boiler 2: 10.9 MWth Natural gas fired	Oxides of Nitrogen (NO and NO ₂ expressed as NO _x)	From 01/01/2025 100 mg/m ³	Periodic	Every three years	BS EN 14792
		Carbon monoxide	From 01/01/2025 No Limit	Periodic	Every three years	MCERTS BS EN15058
A3 [Point A3 on site plan in Schedule 7]	Boiler Plant Boiler 1: 11.3 MWth Natural gas fired	Oxides of Nitrogen (NO and NO ₂ expressed as NO _x)	100 mg/m ³	Periodic	Every three years	BS EN 14792
		Carbon monoxide	No limit set	Periodic	Every three years	MCERTS BS EN15058
A4 [Point A4 on site plan in Schedule 7]	Baghouse fan outlet via bag filter	Particulate matter (PM)	Until 03/12/2023: 50 mg/m ³	Average over sampling period	Annually	EN 13284-1
			From 04/12/2023 20 mg/m ³			
			--	--	Continuous	BS EN 15267-3 [Note 1]
A5 [Point A5 on site plan in Schedule 7]	Receiving baghouse vent	Particulate matter (PM)	Until 03/12/2023: 50 mg/m ³	Average over sampling period	Annually	EN 13284-1
			From 04/12/2023 20 mg/m ³			
A6 [Point A6 on site plan in Schedule 7]	Cooling, Crystallisation, Concentrator (CCC) exhaust	Water vapour	No limit set	--	--	--
A7 [Point A7 on site plan in Schedule 7]	CHP 1: 6.1 MWth Natural gas fired	Oxides of Nitrogen (NO and NO ₂ expressed as NO _x)	95 mg/m ³	Periodic	Every three years	BS EN 14792

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
		Carbon monoxide	No limit set	Periodic	Every three years	MCERTS BS EN15058
A8 [Point S on site plan 2 in Schedule 7]	Steam safety valve	No parameters set	No limit set	--	--	--
A9 to A21 [shown as C on site plan 2 in Schedule 7]	CIP tank vents	No parameters set	No limit set	--	--	--
A22 to A27 [shown as V on site plan 2 in Schedule 7]	Condensate valves	No parameters set	No limit set	--	--	--

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

Table S3.2 Point Source emissions to water (other than sewer) and land – emission limits and monitoring requirements						
Emission point ref. & location	Source	Parameter	Limit (incl. unit)	Reference Period	Monitoring frequency	Monitoring standard or method
W1 on site plan in schedule 7 emission to River Taw	Effluent treatment plant	Total daily volume of discharge-dry weather flow	2500 m ³ /day	24 hour total	Continuous	MCERTS self-monitoring of effluent flow scheme
W1 on site plan in schedule 7 emission to River Taw	Effluent Treatment Plant	Chemical Oxygen Demand (COD)	From 04/12/2023 125 mg/l	24 hour flow proportional sample	Daily	--
W1 on site plan in schedule 7 emission to River Taw	Effluent Treatment plant	Total suspended solids (TSS)	14 mg/l	24 hour flow proportional sample	Daily	BS EN 872
W1 on site plan in schedule 7 emission to River Taw	Effluent Treatment Plant	Total Nitrogen (TN)	From 04/12/2023 20 mg/l	24 hour flow proportional sample	Daily	EN 12260, EN ISO 11905-1.
W1 on site plan in schedule 7 emission to River Taw	Effluent Treatment Plant	Total Phosphorus (TP)	2 mg/l	24 hour flow proportional sample	Daily	EN ISO 6878, EN ISO 15681-1 and -2, ENISO 11885.
W1 on site plan in schedule 7 emission to River Taw	Effluent Treatment Plant	Chloride (Cl ⁻)	No limit set	24 hour flow proportionate sample	Monthly	EN ISO 10304-1, EN ISO 15682

Table S3.2 Point Source emissions to water (other than sewer) and land – emission limits and monitoring requirements						
Emission point ref. & location	Source	Parameter	Limit (incl. unit)	Reference Period	Monitoring frequency	Monitoring standard or method
W1 on site plan in schedule 7 emission to River Taw	Effluent Treatment Plant	Biochemical oxygen demand (BOD)	9 mg/l	24 hour flow proportional sample	Monthly	BS EN 1899-1 [Note 1]
W1 on site plan in schedule 7 emission to River Taw	Effluent Treatment Plant	Ammoniacal nitrogen as N	5 mg/l	24 hour flow proportional sample	Monthly	BS EN ISO 11732
W1 on site plan in schedule 7 emission to River Taw	Effluent Treatment Plant	pH	6 – 9	--	Continuous	BS6068-2.50 ISO 10523
W1 on site plan in schedule 7 emission to River Taw	Effluent Treatment Plant	Temperature	30 °C	--	Continuous	--
W2 on site plan in schedule 7 emission to River Taw	Uncontaminated surface water via interceptor	No parameters set	No limit set	--	--	--
Note 1: The BOD analysis is carried out after suppression of nitrification using allylthiourea						

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	A4 and A5	Every 12 months	1 January
	A2 – MCPD Boiler 2 A3 – MCPD Boiler 1 A7 – MCPD CHP	Every 3 years.	1 January
Point source emissions to water (other than sewer) Parameters as required by condition 3.5.1	W1	Quarterly	1 January, 1 April, 1 July & 1 October

Parameter	Units
Cream despatched	tonnes
Whey powder	tonnes
Whey protein concentrate	tonnes
Butter	tonnes
Cheese	tonnes

Parameter	Frequency of assessment	Units
Water usage	Annually	m ³
Energy usage	Annually	MWh
Waste	Annually	tonnes
Food waste	Annually	tonnes
COD efficiency	Annually*	COD te/te product

*COD efficiency to be calculated on a weekly frequency, reported annually

Parameter	Reporting form	Form version number and date
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

Table S4.4 Reporting forms		
Parameter	Reporting form	Form version number and date
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	

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

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

Time periods for notification following detection of a breach of a limit	
Parameter	Notification period

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

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

Part B – to be submitted as soon as practicable

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

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

Name*	
Post	
Signature	
Date	

* authorised to sign on behalf of the operator

Schedule 6 – Interpretation

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

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

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

“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.

“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.

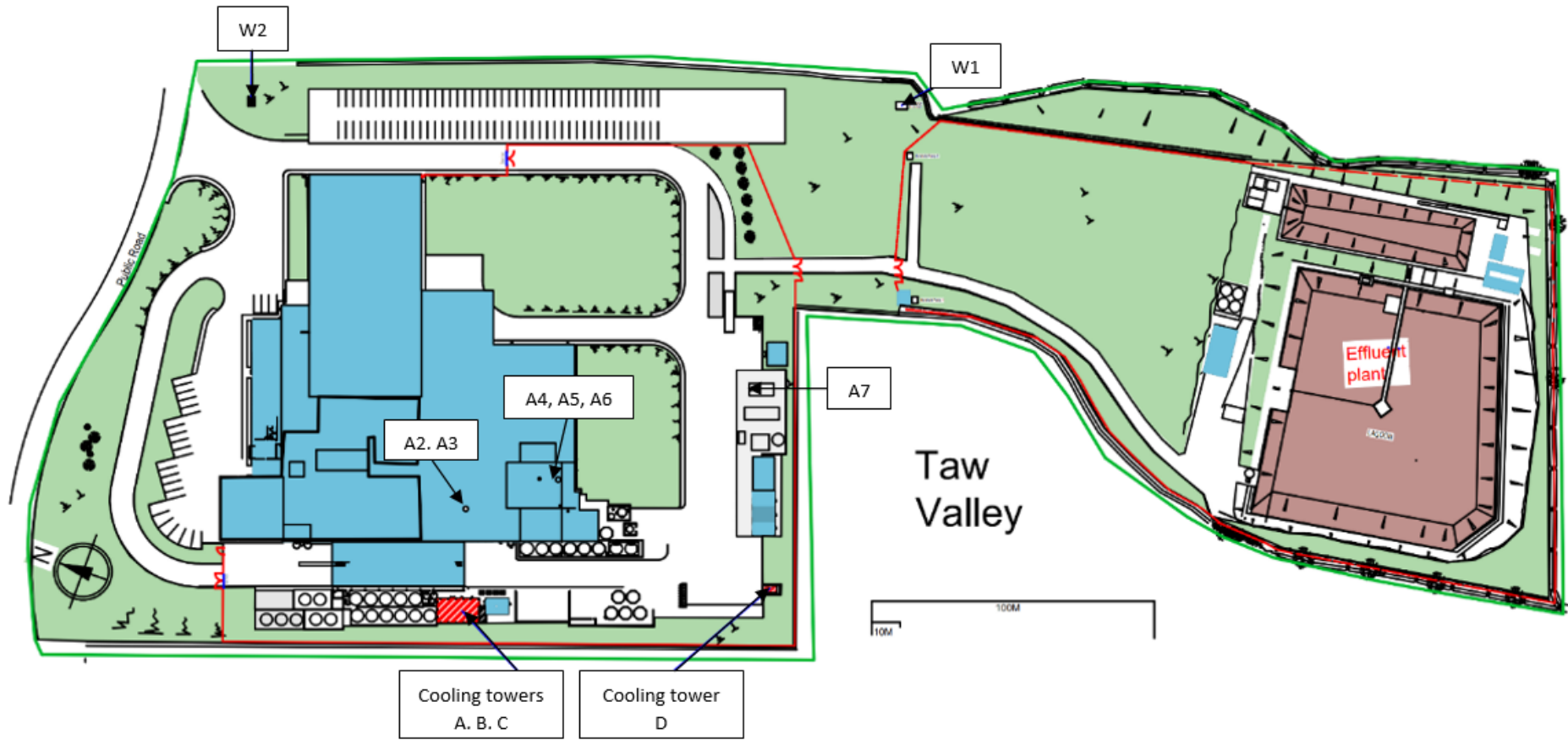
Unless otherwise stated, any references in this permit to concentrations of substances in emissions into air means:

- 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

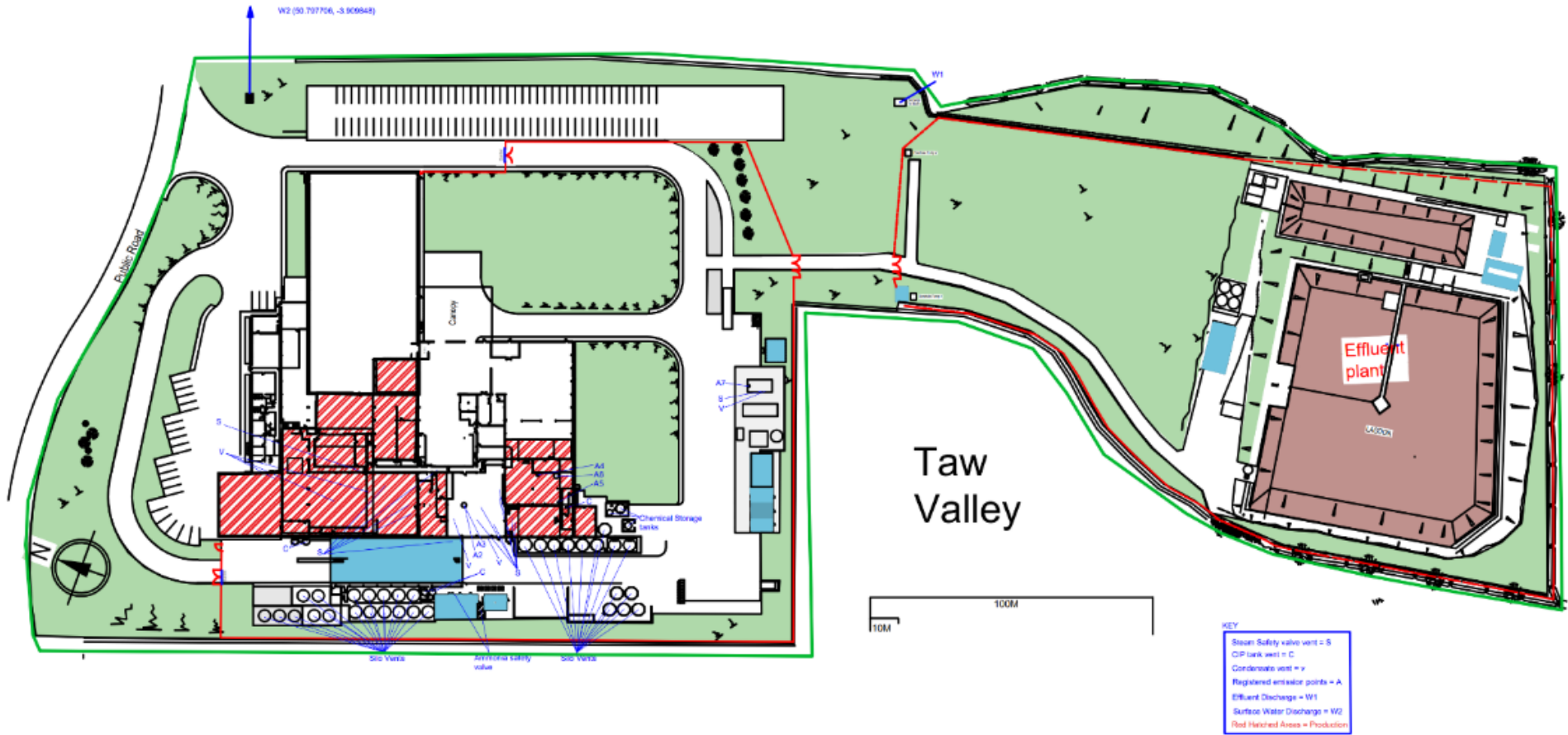
- in relation to emissions from non-combustion sources, the concentration at a temperature of 273K and at a pressure of 101.3 kPa, with no correction for water vapour content

“year” means calendar year ending 31 December.

Schedule 7 – Site plan 1



Site plan 2



END OF PERMIT