



# Notice of variation and consolidation with introductory note

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

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Mondelez UK Confectionery Production Limited

Bournville Chocolate Works  
Bournville Lane  
Bournville  
Birmingham  
B30 2LU

**Variation application number**

EPR/LP3734FJ/V007

**Permit number**

EPR/LP3734FJ

# Bournville Chocolate Works

## Permit number EPR/LP3734FJ

### 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.

The schedules specify the changes made to the permit.

The main features of the permit are as follows.

The installation manufactures up to 150,000 tonnes per annum of chocolate based confectionery products. These are based on milk chocolate crumb, cocoa liquors, cocoa butters and liquid chocolate mass produced outside the installation. These key ingredients are combined with additional ingredients (centres and inclusions) in recipes to produce brand named products which are wrapped and packaged before distribution offsite.

The activities are permitted under:

- Section 6.8 Part A (1)(d)(iii)(aa) Treatment and processing, other than exclusively packaging of the following raw materials, whether previously processed or unprocessed, intended for the production of food or feed (where the weight of the finished product excludes packaging) animal and vegetable raw materials (other than milk only), both in combination and separate products, with a finished product production capacity greater than 75 tonnes per day.
- Section 5.4 Part A (1)(a)(ii) Disposal of non-hazardous waste with a capacity exceeding 50 tonnes per day involving physico-chemical treatment.

The manufacturing process involves the following:

- Goods intake and raw materials handling and storage
- Chocolate making
- Centre making
- Moulding and shell forming
- Sheet and cut processes
- WIP, finished goods, packaging and dispatch
- Ancillary processes including heating, cooling and cleaning.

Process effluent is generated from cleaning processes on site. Effluent is directed to a treatment plant on site. Continuous monitoring of pH and flow is carried out with chemicals dosed as required to adjust the pH to comply with discharge consent conditions. pH correction is provided via chemical dosing from caustic and acid tanks prior to discharge to public sewer under consent from Severn Trent Water.

Surface rainwater from roads and roofs is discharged at nineteen discharge points to Bourn (Griffins) Brook.

Water used on site is provided by the mains water supply which is used without further treatment. Mondelez also hold a licence to abstract water from Bourn (Griffins) Brook which passes through the site. Whilst not currently used, the water treatment facility for this is retained and comprises filtration followed by treatment with sodium hypochlorite prior to use.

There are 3 point sources to air from 3 dual fuel natural gas/gas oil steam raising boilers, each with a net thermal input of 6.25MWth. These boilers have been derated as part of the variation and review process, halving their capacity from 12.5MWth each. As a result of this change the Part B activity relating to the combustion plant (Section 1.1B(a)) is removed from the permit as the rated thermal input falls below 20MW. The combustion plant is designated as existing medium Combustion Plant (MCP) with the permitting requirements included as detailed above.

A number of Local Wildlife Sites lie within 2km of the site, the nearest being the Worcester and Birmingham canal to the east. There however are no European sites or SSSIs within the statutory screening distance. The nearest SSSI is Edgbaston Pool 2.6km to the North.

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

<b>Status log of the permit</b>		
<b>Description</b>	<b>Date</b>	<b>Comments</b>
Application BN3740IM (EPR/BN3740IM/A001)	26/08/04	
Additional information received	26/10/04	Request a copy of noise report for the installation (received 28/10/04)
Additional information received	23/11/04	Request larger scale installation maps (received 15/12/04)
Additional information received	30/11/04	Request to extend determination to 31/01/05 (request accepted 13/12/05)
Additional information received	17/02/05	Request to extend determination to 31/03/05 (request accepted 22/02/05)
Application BN3740IM determined (EPR/BN3740IM/A001)	10/03/05	Permit issued to Cadbury Limited
Variation application PP3735LH (EPR/BN3740IM/V002)	17/01/06	
Variation determined PP3735LH (EPR/BN3740IM/V002)	04/04/06	Variation determined
Variation application EPR/BN3740IM/V003	06/01/11	
Variation determined EPR/BN3740IM/V003	21/01/11	Variation determined
Transfer application EP/LP3734FJ/T001	16/08/11	Application by Kraft Foods UK Confectionery production Limited for transfer from Cadbury Limited.
Transfer determined EP/LP3734FJ/T001	27/09/11	Full transfer of permit complete
Variation application EPR/LP3734FJ/V002	30/11/11	Application to vary and remove emission point W27
Variation determined EPR/LP3734FJ/V002	25/01/12	Varied permit issued
Variation application EPR/LP3734FJ/V003	25/01/13	Application to remove emission points W2, W17, W30, W32 and W1B.

<b>Status log of the permit</b>		
<b>Description</b>	<b>Date</b>	<b>Comments</b>
Variation determined EPR/LP3734FJ/V003	07/02/13	Varied permit issued
Variation application EPR/LP3734FJ/V004	04/08/14	Notification of change of company name to Mondelez UK Confectionery Production Limited
Variation determined EPR/LP3734FJ/V004	14/08/14	Variation issued
Variation application EPR/LP3734FJ/V005 Surrender application EPR/LP3734FJ/S006	Duly made 01/03/23	Substantial variation and partial surrender to amend the site boundary and remove an area of land, installation of effluent balance tanks and chemical dosing, manufacturing process changes, boiler derating and amend point sources to air, water and sewer.  The variation was assessed in tandem with the Environment Agency initiated variation and consolidation following the Food, Drink & Milk Industries sector permit review.
Application EPR/LP3734FJ/V007 and S006 (variation and consolidation) and partial surrender	Regulation 61 Notice response received 03/02/23	Environment Agency initiated variation and consolidation following the Food, Drink & Milk Industries sector permit review.
Additional information received	26/05/23	Amended plan of point source emission to air. F Gas register. CIP validation procedure.
Additional information received	07/06/23	Revised BAT assessment considering BATc 2,3 and 11.
Additional information received	08/06/23	Effluent discharge management procedure. Spill procedure.
Variation determined and consolidation issued EPR/LP3734FJ (Billing ref. AB1234CD).	07/08/23	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/LP3734FJ

### Issued to

**Mondelez UK Confectionery Production Limited** (“the operator”)

whose registered office is

**PO Box 12  
Bournville Lane  
Bournville  
Birmingham  
B30 2LU**

company registration number 00474310

to operate a regulated facility at

**Bournville Chocolate Works  
Bournville Lane  
Bournville  
Birmingham  
B30 2LU**

to the extent set out in the schedules.

The notice shall take effect from 07/08/2023

Name	Date
Rebecca Brough	07/08/2023

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/LP3734FJ**

This is the consolidated permit referred to in the variation and consolidation notice for application EPR/LP3734FJ/V007 authorising,

**Mondelez UK Confectionery Production Limited** (“the operator”),

whose registered office is

**PO Box 12  
Bournville Lane  
Bournville  
Birmingham  
B30 2LU**

company registration number 00474310

to operate an installation at

**Bournville Chocolate Works  
Bournville Lane  
Bournville  
Birmingham  
B30 2LU**

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

Name	Date
Rebecca Brough	07/08/2023

Authorised on behalf of the Environment Agency

# Conditions

## 1 Management

### 1.1 General management

- 1.1.1 The operator shall manage and operate the activities:
- (a) in accordance with a written management system that identifies and minimises risks of pollution, including those arising from operations, maintenance, accidents, incidents, non-conformances, closure and those drawn to the attention of the operator as a result of complaints; and
  - (b) using sufficient competent persons and resources.
- 1.1.2 Records demonstrating compliance with condition 1.1.1 shall be maintained.
- 1.1.3 Any person having duties that are or may be affected by the matters set out in this permit shall have convenient access to a copy of it kept at or near the place where those duties are carried out.

### 1.2 Energy efficiency

- 1.2.1 The operator shall:
- (a) take appropriate measures to ensure that energy is used efficiently in the activities;
  - (b) review and record at least every four years whether there are suitable opportunities to improve the energy efficiency of the activities; and
  - (c) take any further appropriate measures identified by a review.

### 1.3 Efficient use of raw materials

- 1.3.1 The operator shall:
- (a) take appropriate measures to ensure that raw materials and water are used efficiently in the activities;
  - (b) maintain records of raw materials and water used in the activities;
  - (c) review and record at least every four years whether there are suitable alternative materials that could reduce environmental impact or opportunities to improve the efficiency of raw material and water use; and
  - (d) take any further appropriate measures identified by a review.

### 1.4 Avoidance, recovery and disposal of wastes produced by the activities

- 1.4.1 The operator shall take appropriate measures to ensure that:
- (a) the waste hierarchy referred to in Article 4 of the Waste Framework Directive is applied to the generation of waste by the activities; and
  - (b) any waste generated by the activities is treated in accordance with the waste hierarchy referred to in Article 4 of the Waste Framework Directive; and
  - (c) where disposal is necessary, this is undertaken in a manner which minimises its impact on the environment.
- 1.4.2 The operator shall review and record at least every four years whether changes to those measures should be made and take any further appropriate measures identified by a review.



## **2 Operations**

### **2.1 Permitted activities**

2.1.1 The operator is only authorised to carry out the activities specified in schedule 1 table S1.1 (the “activities”).

### **2.2 The site**

2.2.1 The activities shall not extend beyond the site, being the land shown edged in green on the site plan at schedule 7 to this permit.

### **2.3 Operating techniques**

2.3.1 The activities shall, subject to the conditions of this permit, be operated using the techniques and in the manner described in the documentation specified in schedule 1, table S1.2, unless otherwise agreed in writing by the Environment Agency.

2.3.2 If notified by the Environment Agency that the activities are giving rise to pollution, the operator shall submit to the Environment Agency for approval within the period specified, a revision of any plan or other documentation (“plan”) specified in schedule 1, table S1.2 or otherwise required under this permit which identifies and minimises the risks of pollution relevant to that plan, and shall implement the approved revised plan in place of the original from the date of approval, unless otherwise agreed in writing by the Environment Agency.

2.3.3 Any raw materials or fuels listed in schedule 2 table S2.1 shall conform to the specifications set out in that table.

2.3.4 The operator shall ensure that where waste produced by the activities is sent to a relevant waste operation, that operation is provided with the following information, prior to the receipt of the waste:

- (a) the nature of the process producing the waste;
- (b) the composition of the waste;
- (c) the handling requirements of the waste;
- (d) the hazardous property associated with the waste, if applicable; and
- (e) the waste code of the waste.

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

### **2.4 Improvement programme**

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

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

## **3 Emissions and monitoring**

### **3.1 Emissions to water, air or land**

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

- 3.1.2 The limits given in schedule 3 shall not be exceeded.
- 3.1.3 Periodic monitoring shall be carried out at least once every 5 years for groundwater and 10 years for soil, unless such monitoring is based on a systematic appraisal of the risk of contamination.
- 3.1.4 For the following activities referenced in schedule 1, table S1.1 (AR1 to AR3 boiler emission points) the first monitoring measurements shall be carried out within four months of 01/01/2025 or of the date when the MCP is first put into operation, whichever is later.

## **3.2 Emissions of substances not controlled by emission limits**

- 3.2.1 Emissions of substances not controlled by emission limits (excluding odour) shall not cause pollution. The operator shall not be taken to have breached this condition if appropriate measures, including, but not limited to, those specified in any approved emissions management plan, have been taken to prevent or where that is not practicable, to minimise, those emissions.
- 3.2.2 The operator shall:
  - (a) if notified by the Environment Agency that the activities are giving rise to pollution, submit to the Environment Agency for approval within the period specified, an emissions management plan which identifies and minimises the risks of pollution from emissions of substances not controlled by emission limits;
  - (b) implement the approved emissions management plan, from the date of approval, unless otherwise agreed in writing by the Environment Agency.
- 3.2.3 All liquids in containers, whose emission to water or land could cause pollution, shall be provided with secondary containment, unless the operator has used other appropriate measures to prevent or where that is not practicable, to minimise, leakage and spillage from the primary container.

## **3.3 Odour**

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

## **3.4 Noise and vibration**

- 3.4.1 Emissions from the activities shall be free from noise and vibration at levels likely to cause pollution outside the site, as perceived by an authorised officer of the Environment Agency, unless the operator has used appropriate measures, including, but not limited to, those specified in any approved noise and vibration management plan to prevent or where that is not practicable to minimise the noise and vibration.

## **3.5 Monitoring**

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

- 3.5.2 The operator shall maintain records of all monitoring required by this permit including records of the taking and analysis of samples, instrument measurements (periodic and continual), calibrations, examinations, tests and surveys and any assessment or evaluation made on the basis of such data.
- 3.5.3 Monitoring equipment, techniques, personnel and organisations employed for the emissions monitoring programme and the environmental or other monitoring specified in condition 3.5.1 shall have either MCERTS certification or MCERTS accreditation (as appropriate), where available, unless otherwise agreed in writing by the Environment Agency.
- 3.5.4 Permanent means of access shall be provided to enable sampling/monitoring to be carried out in relation to the emission points specified in schedule 3 tables S3.1, S3.2 and S3.3 unless otherwise agreed in writing by the Environment Agency.

## **3.6 Pests**

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

## **3.7 Fire prevention**

- 3.7.1 The operator shall take all appropriate measures to prevent fires on site and minimise the risk of pollution from them including, but not limited to, those specified in any approved fire prevention plan.
- 3.7.2 The operator shall:
- (a) if notified by the Environment Agency that the activities are giving rise to a risk of fire, submit to the Environment Agency for approval within the period specified, a fire prevention plan which prevents fires and minimises the risk of pollution from fires;
  - (b) implement the fire prevention plan, from the date of approval, unless otherwise agreed in writing by the Environment Agency.

# **4 Information**

## **4.1 Records**

- 4.1.1 All records required to be made by this permit shall:
- (a) be legible;
  - (b) be made as soon as reasonably practicable;
  - (c) if amended, be amended in such a way that the original and any subsequent amendments remain legible, or are capable of retrieval; and
  - (d) be retained, unless otherwise agreed in writing by the Environment Agency, for at least 6 years from the date when the records were made, or in the case of the following records until permit surrender:

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

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

## 4.2 Reporting

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

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

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

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

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

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

## 4.3 Notifications

4.3.1 In the event:

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

immediately suspend the operation of the activities or the relevant part of it until compliance with the permit conditions has been restored.

- 4.3.2 Any information provided under condition 4.3.1 shall be confirmed by sending the information listed in schedule 5 to this permit within the time period specified in that schedule.
- 4.3.3 Where the Environment Agency has requested in writing that it shall be notified when the operator is to undertake monitoring and/or spot sampling, the operator shall inform the Environment Agency when the relevant monitoring and/or spot sampling is to take place. The operator shall provide this information to the Environment Agency at least 14 days before the date the monitoring is to be undertaken.
- 4.3.4 The Environment Agency shall be notified within 14 days of the occurrence of the following matters, except where such disclosure is prohibited by Stock Exchange rules:
- Where the operator is a registered company:
- (a) any change in the operator's trading name, registered name or registered office address; and
  - (b) any steps taken with a view to the operator going into administration, entering into a company voluntary arrangement or being wound up.
- Where the operator is a corporate body other than a registered company:
- (a) any change in the operator's name or address; and
  - (b) any steps taken with a view to the dissolution of the operator.
- In any other case:
- (a) the death of any of the named operators (where the operator consists of more than one named individual);
  - (b) any change in the operator's name(s) or address(es); and
  - (c) any steps taken with a view to the operator, or any one of them, going into bankruptcy, entering into a composition or arrangement with creditors, or, in the case of them being in a partnership, dissolving the partnership.
- 4.3.5 Where the operator proposes to make a change in the nature or functioning, or an extension of the activities, which may have consequences for the environment and the change is not otherwise the subject of an application for approval under the Regulations or this permit:
- (a) the Environment Agency shall be notified at least 14 days before making the change; and
  - (b) the notification shall contain a description of the proposed change in operation.
- 4.3.6 The Environment Agency shall be given at least 14 days' notice before implementation of any part of the site closure plan.
- 4.3.7 Where the operator has entered into a climate change agreement with the Government, the Environment Agency shall be notified within one month of:
- (a) a decision by the Secretary of State not to re-certify the agreement;
  - (b) a decision by either the operator or the Secretary of State to terminate the agreement; and
  - (c) any subsequent decision by the Secretary of State to re-certify such an agreement.

## 4.4 Interpretation

- 4.4.1 In this permit the expressions listed in schedule 6 shall have the meaning given in that schedule.
- 4.4.2 In this permit references to reports and notifications mean written reports and notifications, except where reference is made to notification being made "immediately" in which case it may be provided by telephone.

# Schedule 1 – Operations

<b>Table S1.1 activities</b>			
<b>Activity reference</b>	<b>Activity listed in Schedule 1 of the EP Regulations</b>	<b>Description of specified activity</b>	<b>Limits of specified activity</b>
AR1	S6.8 A1 (d)(iii) (aa)	Treatment and processing of animal and vegetable raw materials (other than milk only), both in combined and separate products, with a finished product production capacity in tonnes per day greater than 75 tonnes per day.	From receipt of raw materials to dispatch of final product of chocolates and confectionery products the majority of which are produced from milk chocolate crumb (milk product).  Production capacity is limited to 500 tonnes per day
AR2	Section 5.4 Part A1 (a) (ii)	Physico-chemical Treatment of non-hazardous waste waters by pH adjustment	From generation of waste water to discharge to foul sewer
<b>Directly Associated Activity</b>			
AR3	Steam supply	Medium Combustion plants: 3 x 6.3MWth natural gas boilers with gas oil as a back up fuel	From receipt of fuel to release of products of combustion to air. Limit of <500 hours per unit per annum when operating on gas oil
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	Surface water drainage	Collection of uncontaminated site surface waters	Handling and storage of site drainage until discharge to the site surface water system
AR9	Water treatment	Filtration of water followed by treatment with sodium hypochlorite prior to use as cooling water	Water used for indirect cooling in production areas and low quality domestic use. Water abstracted from Griffins Brook abstraction point

<b>Table S1.2 Operating techniques</b>		
<b>Description</b>	<b>Parts</b>	<b>Date Received</b>
Application	The response to questions 2.1 and 2.2 and technical descriptions, given in sections 2.1 and 2.2 and pages 178 to 215 of the application.	26/08/04
Regulation 61 (1) Notice – Responses to questions dated 03/02/2023	All parts	Received 03/02/2023
Request for further information dates 28/04/2023	Revised Effluent Treatment Plant BAT assessment with the exception of the emissions data referenced in Table 1.	07/06/2023

<b>Table S1.3 Improvement programme requirements</b>		
<b>Reference</b>	<b>Requirement</b>	<b>Date</b>
IC17	<p>The operator shall produce a climate change adaptation plan. The approved plan will form part of the EMS.</p> <p>The plan shall include, but not be limited to:</p> <ul style="list-style-type: none"> <li>• Details of how the installation has or could be affected by severe weather;</li> <li>• The scale of the impact of severe weather on the operations within the installation;</li> <li>• An action plan and timetable for any improvements to be made to minimise the impact of severe weather at the installation.</li> </ul> <p>The Operator shall implement any necessary improvements to a timetable agreed in writing with the Environment Agency.</p>	03/12/2023 or other date as agreed in writing with the Environment Agency
IC18	The operator shall provide a written statement to the Environment Agency from the Original Equipment Manufacturer (OEM) of the boilers confirming the equipment has been derated to the stated new thermal capacity.	Within 6 months of permit issue
IC19	The operator shall provide a revised noise impact assessment which incorporates all the proposed mitigation measures on site. The assessment shall be carried out in accordance with BS 4142. The noise impacts assessment must consider all the noise resulting from both existing noise sources and those newly installed.	30 November 2023 or other date as agreed in writing with the Environment Agency
IC20	<p>The Operator shall submit a revised Noise Management Plan to the Environment Agency for technical assessment and approval, demonstrating compliance against BAT 13 for the FDM industries. Further guidance on NMPs can be found on our website Noise and vibration 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 noise emissions monitoring;</li> <li>• a protocol for response to identified noise events, eg complaints;</li> <li>• a noise reduction programme designed to identify the source(s), to measure/estimate noise and vibration exposure, to characterise the</li> </ul>	30 November 2023 or other date as agreed in writing with the Environment Agency

<b>Table S1.3 Improvement programme requirements</b>		
<b>Reference</b>	<b>Requirement</b>	<b>Date</b>
	<p>contributions of the sources and to implement prevention and/or reduction measures.</p> <p>The noise management plan should be reviewed at least annually to ensure continued compliance against BAT 13 as described above. You must implement the plan as agreed, and from the date stipulated by the Environment Agency.</p>	
IC21	<p>The Operator shall undertake a survey of the primary, secondary and tertiary containment at the site and review measures against relevant standard including:</p> <ul style="list-style-type: none"> <li>• CIRIA Containment systems for the prevention of pollution (C736) – Secondary, tertiary and other measures for industrial and commercial premises,</li> <li>• EEMUA 159 - Above ground flat bottomed storage tanks</li> </ul> <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"> <li>• current containment measures</li> <li>• any deficiencies identified in comparison to relevant standards,</li> <li>• improvements proposed</li> <li>• time scale for implementation of improvements.</li> </ul> <p>The operator shall implement the proposed improvements in line with the timescales agreed by the Environment Agency.</p>	3 months form permit issue



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

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

## Schedule 3 – Emissions and monitoring

Table S3.1 Point source emissions to air – emission limits and monitoring requirements						
Emission point ref. & location	Source	Parameter	Limit (including unit)	Reference period	Monitoring frequency	Monitoring standard or method
A1 [Point A1 on site plan in Schedule 7]	Existing medium combustion plant fuelled on natural gas 1 x 6.3 MWth boiler	Oxides of Nitrogen (NO and NO <sub>2</sub> expressed as NO <sub>x</sub> )	200 mg/m <sup>3</sup>	Periodic	Every three years	BS EN 14792 [Note 1]
		Carbon monoxide	150 mg/m <sup>3</sup>	Periodic	Every three years	MCERTS BS EN15058
	Existing medium combustion plant fuelled on gas oil 1 x 6.3 MWth boiler	Oxides of Nitrogen (NO and NO <sub>2</sub> expressed as NO <sub>x</sub> )	No limit	Periodic	After 3 times the maximum average annual operating hours have elapsed and no less frequent than every 5 years	BS EN 14792
		Carbon monoxide	No limit	Periodic		MCERTS BS EN15058
A2 [Point A2 on site plan in Schedule 7]	Existing medium combustion plant fuelled on natural gas 1 x 6.3 MWth boiler	Oxides of Nitrogen (NO and NO <sub>2</sub> expressed as NO <sub>x</sub> )	200 mg/m <sup>3</sup>	Periodic	Every three years	BS EN 14792 [Note 1]
		Carbon monoxide	150 mg/m <sup>3</sup>	Periodic	Every three years	MCERTS BS EN15058
	Existing medium combustion plant fuelled on gas oil 1 x 6.3 MWth boiler	Oxides of Nitrogen (NO and NO <sub>2</sub> expressed as NO <sub>x</sub> )	No limit	Periodic	After 3 times the maximum average annual operating hours have elapsed and no less frequent than every 5 years	BS EN 14792
		Carbon monoxide	No Limit	Periodic		MCERTS BS EN15058
A3 [Point A3 on site plan in Schedule 7]	Existing medium combustion plant fuelled on natural gas 1 x 6.3 MWth boiler	Oxides of Nitrogen (NO and NO <sub>2</sub> expressed as NO <sub>x</sub> )	200 mg/m <sup>3</sup>	Periodic	Every three years	BS EN 14792 [Note 1]
		Carbon monoxide	150mg/m <sup>3</sup>	Periodic	Every three years	MCERTS BS EN15058
	Existing medium combustion	Oxides of Nitrogen	No limit	Periodic	After 3 times the maximum average	BS EN 14792

<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>
	plant fuelled on gas oil 1 x 6.3 MWth boiler	(NO and NO <sub>2</sub> expressed as NO <sub>x</sub> )			annual operating hours have elapsed and no less frequent than every 5 years	
		Carbon monoxide	No Limit	Periodic		MCERTS BS EN15058
A4 [Point A4 on site plan in Schedule 7]	M2 sugar silo vent	No parameters set	No limit set	-	-	-
A5 [Point A5 on site plan in Schedule 7]	M2 sugar silo explosion panel	No parameters set	No limit set	-	-	-
A6 [Point A6 on site plan in Schedule 7]	CE sugar hopper vent	No parameters set	No limit set	-	-	-
A7 [Point A7 on site plan in Schedule 7]	CE sugar hopper explosion panel	No parameters set	No limit set	-	-	-
A8 [Point A8 on site plan in Schedule 7]	U block centre sugar silo vent	No parameters set	No limit set	-	-	-
A9 [Point A9 on site plan in Schedule 7]	U block centre sugar silo explosion panel	No parameters set	No limit set	-	-	-
A10 [Point A10 on site plan in Schedule 7]	U1W sugar hopper vent 1	No parameters set	No limit set	-	-	-
A11 [Point A11 on site plan in Schedule 7]	U1W sugar hopper 1 explosion panel	No parameters set	No limit set	-	-	-
A12 [Point A12 on site plan in Schedule 7]	U1W sugar hopper 2 vent	No parameters set	No limit set	-	-	-
A13 [Point A13 on site plan in Schedule 7]	U1W sugar hopper explosion panel	No parameters set	No limit set	-	-	-
A14 [Point A14 on site plan in Schedule 7]	U4W sugar hopper vent	No parameters set	No limit set	-	-	-
A15 [Point A15 on site plan in Schedule 7]	U4W sugar hopper explosion panel	No parameters set	No limit set	-	-	-

<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>
A16 [Point A16 on site plan in Schedule 7]	U6E sugar silo 1 vent	No parameters set	No limit set	-	-	-
A17 [Point A17 on site plan in Schedule 7]	U6E sugar silo 1 explosion panel	No parameters set	No limit set	-	-	-
A18 [Point A18 on site plan in Schedule 7]	U6E sugar silo 2 vent	No parameters set	No limit set	-	-	-
A19 [Point A19 on site plan in Schedule 7]	U6E sugar silo 2 explosion panel	No parameters set	No limit set	-	-	-
A20 [Point A20 on site plan in Schedule 7]	U6E sugar hopper vent	No parameters set	No limit set	-	-	-
A21 [Point A21 on site plan in Schedule 7]	U6E sugar hopper explosion panel	No parameters set	No limit set	-	-	-
A22 [Point A22 on site plan in Schedule 7]	U6E McIntyre mixer 1 vent	No parameters set	No limit set	-	-	-
A23 [Point A23 on site plan in Schedule 7]	U6E McIntyre mixer 1 explosion panel	No parameters set	No limit set	-	-	-
A24 [Point A24 on site plan in Schedule 7]	U6E McIntyre Mixer 2 vent	No parameters set	No limit set	-	-	-
A25 [Point A25 on site plan in Schedule 7]	U6E McIntyre mixer 2 explosion panel	No parameters set	No limit set	-	-	-
A26 [Point A26 on site plan in Schedule 7]	U6E McIntyre mixer 3 vent	No parameters set	No limit set	-	-	-
A27 [Point A27 on site plan in Schedule 7]	U6E McIntyre mixer 3 explosion panel	No parameters set	No limit set	-	-	-
A28 [Point A28 on site plan in Schedule 7]	3kg rotating fluidised bed roaster	No parameters set	No limit set	-	-	-

<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>
A29 [Point A29 on site plan in Schedule 7]	200g rotating fluidised bed roaster	No parameters set	No limit set	-	-	-
A30 [Point A30 on site plan in Schedule 7]	Drum roaster	No parameters set	No limit set	-	-	-
A31 [Point A31 on site plan in Schedule 7]	Alkalisers	No parameters set	No limit set	-	-	-
A32 [Point A32 on site plan in Schedule 7]	LEV extraction from addition of inclusions	No parameters set	No limit set	-	-	-
A33 [Point A33 on site plan in Schedule 7]	Pan wash extraction vent	No parameters set	No limit set	-	-	-
A34 [Point A34 on site plan in Schedule 7]	Mould wash extraction vent	No parameters set	No limit set	-	-	-
A35 [Point A35 on site plan in Schedule 7]	ETP balance tank	No parameters set	No limit set	-	-	-
A36 [Point A36 on site plan in Schedule 7]	High flavour cocoa alkalisiation	No parameters set	No limit set	-	-	-
A37 [Point A37 on site plan in Schedule 7]	Sprinkler pump house	No parameters set	No limit set	-	-	-
A38 [Point A38 on site plan in Schedule 7]	Crumb silo 1 explosion vents	No parameters set	No limit set	-	-	-
A39 [Point A39 on site plan in Schedule 7]	Crumb silo 2 explosion vents	No parameters set	No limit set	-	-	-

Note 1: Monitoring requirements are defined at a temperature of 273.15 K, a pressure of 101.3 kPa and after correction for the water vapour content of the waste gases at a standardised O<sub>2</sub> content of 6% for solid fuels, 15% for engines and gas turbines and 3% all other MCPs

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

<b>Emission point ref. &amp; location</b>	<b>Source</b>	<b>Parameter</b>	<b>Limit (incl. unit)</b>	<b>Reference Period</b>	<b>Monitoring frequency</b>	<b>Monitoring standard or method</b>
W1 to W19 [Points W1 to W19 on site plan in schedule 7] emission to Bourn (Griffins) Brook	Uncontaminated surface runoff	No parameter set	No limit set	--	--	--

<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 Water Minworth Sewage Treatment Works	Treated process effluent from onsite effluent treatment plant	No parameters Set	No limit set	-	-	-
S2 [Point S2 on site plan in schedule 7] emission to Severn Trent Water Minworth Sewage Treatment Works	Untreated process effluent from north west processing block (moulding and cocoa blocks and central power plant)	No parameters Set	No limit set	-	-	-
S3 [Point S3 on site plan in schedule 7] emission to Severn Trent Water Minworth Sewage Treatment Works	Untreated process effluent from north east processing blocks (U,C,L and O)	No parameters Set	No limit set	-	-	-
S4 [Point S4 on site plan in schedule 7] emission to Severn Trent Water Minworth Sewage Treatment Works	Untreated process effluent from moulding blocks and ancillary buildings	No parameters Set	No limit set	-	-	-

## Schedule 4 – Reporting

Parameters, for which reports shall be made, in accordance with conditions of this permit, are listed below.

<b>Table S4.1 Reporting of monitoring data</b>			
<b>Parameter</b>	<b>Emission or monitoring point/reference</b>	<b>Reporting period</b>	<b>Period begins</b>
Point source emissions to air Parameters as required by condition 3.5.1	A1, A2, A3 (boilers fuelled on natural gas)	Every 3 years.	1 January
	A1, A2, A3 (boilers fuelled on gas oil)	After 3 times the maximum average annual operating hours have elapsed and no less frequent than every 5 years.	1 January

<b>Table S4.2: Annual production/treatment</b>	
<b>Parameter</b>	<b>Units</b>
Finished packaged product	tonnes

<b>Table S4.3 Performance parameters</b>		
<b>Parameter</b>	<b>Frequency of assessment</b>	<b>Units</b>
Water usage	Annually	m <sup>3</sup>
Energy usage	Annually	MWh
Waste	Annually	tonnes
Food waste	Annually	Tonnes
COD efficiency	Annually*	COD te/te product

\*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
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



<b>Table S4.4 Reporting forms</b>		
<b>Parameter</b>	<b>Reporting form</b>	<b>Form version number and date</b>
Other performance parameters	Other Performance Parameters Reporting Form, or other form as agreed in writing by the Environment Agency	Version 1, 08/03/2021

# Schedule 5 – Notification

These pages outline the information that the operator must provide.

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

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

## Part A

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

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

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

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

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

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

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

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

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

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

Name*	
Post	
Signature	
Date	

\* authorised to sign on behalf of the operator

## Schedule 6 – Interpretation

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

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

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

“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.

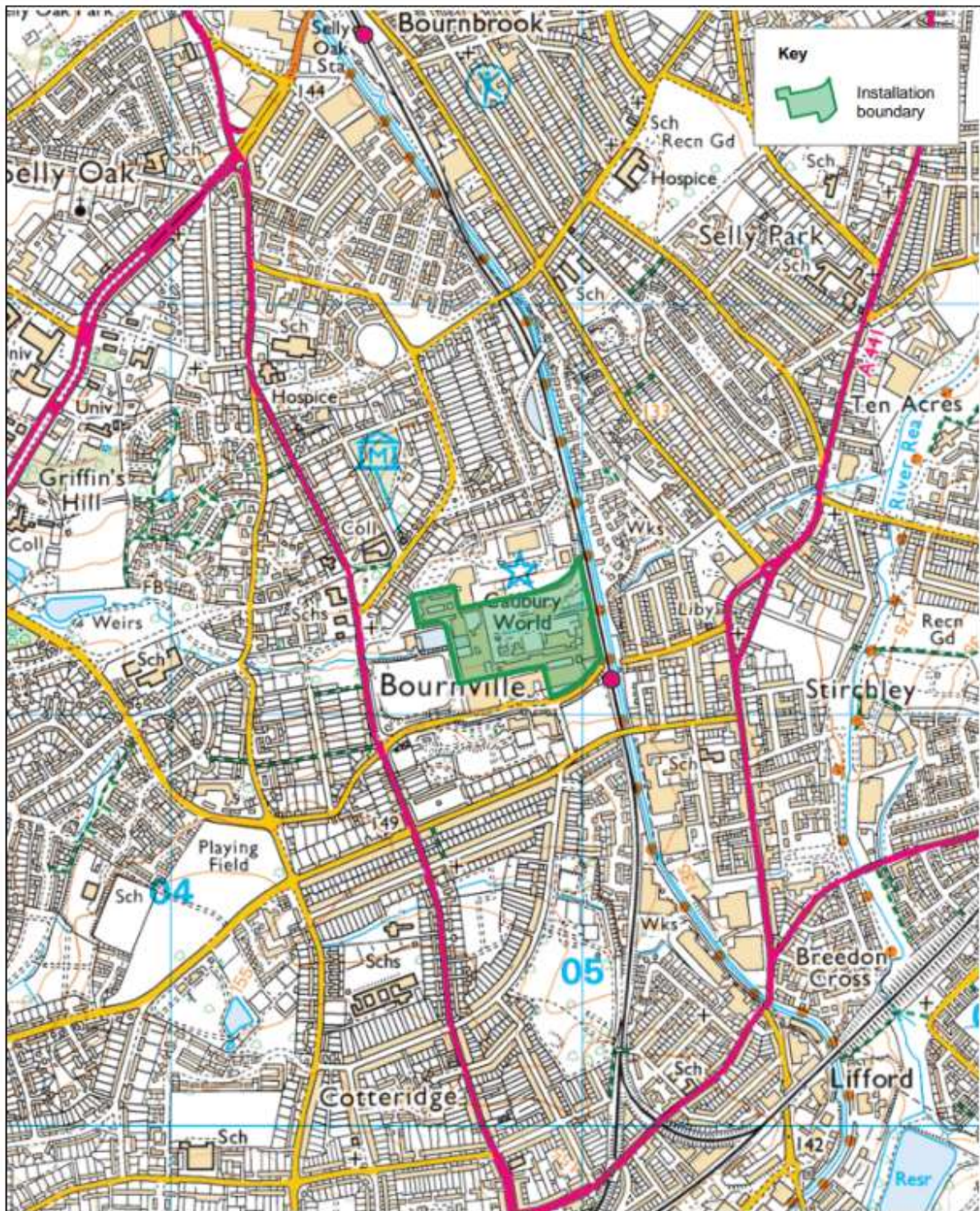
Unless otherwise stated, any references in this permit to concentrations of substances in emissions into air means:



- 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, 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.

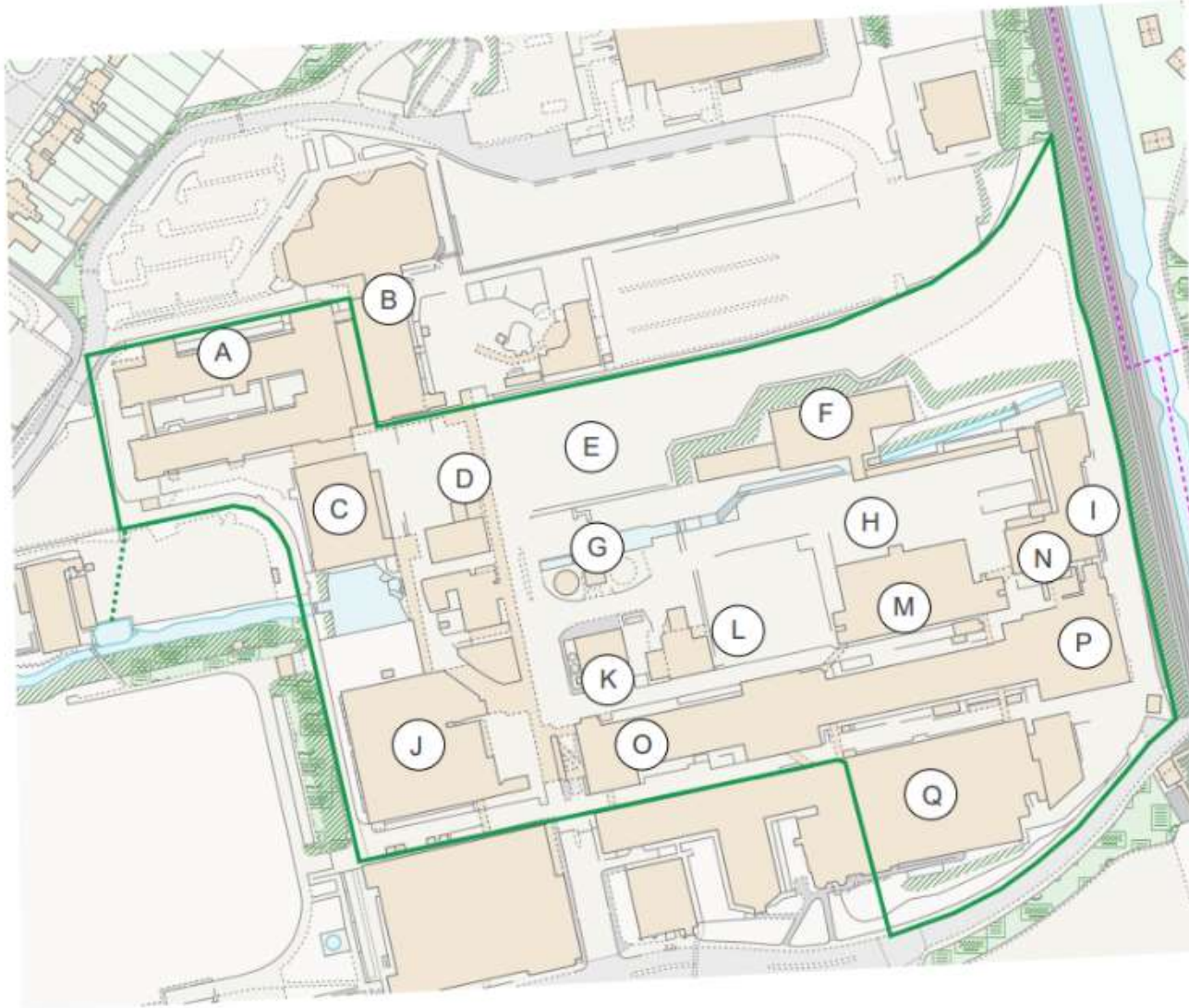


# Schedule 7 – Site plan



Drawing title Figure 1 Site Location Plan	Scale 1:25,000 @ A4	PESTL No. MON.013
Project Mondelez Bournville Permit Variation Application	Version ISSUE	Issue date 27/06/2022
 <p><b>Mondelez</b> International SNACKING MADE RIGHT</p>	 Project Environmental Solutions	





- Installation boundary
- A Moulding 1
- B Cadbury World
- C Chocolate Block
- D Crumb silo
- E Yard
- F WIP stores
- G Sprinkler system
- H Despatch deck
- I L Block
- J Moulding 2
- K Energy Centre
- L Effluent Treatment Plant
- M O Block
- N Flavours store
- O U Block West
- P U Block East
- Q V Block

 Project Environmental Solutions

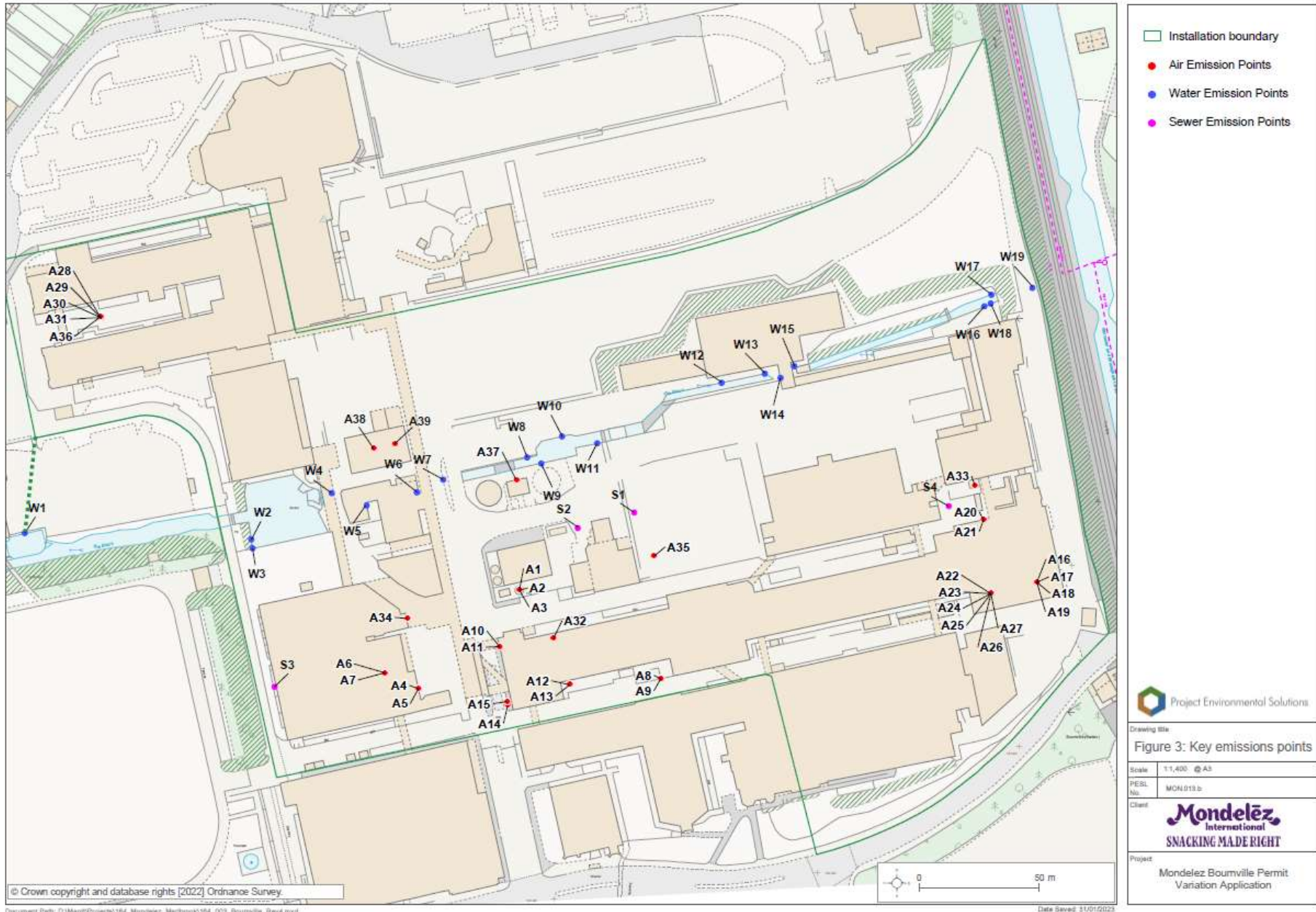
Drawing title

**Figure 2: Installation layout**

Scale	1:1,750 @A3
PESEL No.	MON 212
Client	 <b>SNACKING MADE RIGHT</b>
Project	Mondelēz Bourneville Permit Variation Application

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**Scale**  
 Scale 1:3000  
 0 50 100 200 meters



Date	December 2023
Revision	FINAL (Rev 0)
Scale	1:300 @ A3
PEIS No	WCR 019 a

Project  
 Mondelez UK Confectionery Production Limited  
 Bourville Chocolate Works - EPR/LP3734FJ  
 Drawing No  
 Regulation 61 Notice response tool  
 Site plan showing emission points to water

END OF PERMIT

Permit number  
 EPR/LP3734FJ