



Notice of variation and consolidation with introductory note

The Environmental Permitting (England & Wales) Regulations 2016

Mars Food UK Limited

King's Lynn Site
Hansa Road
King's Lynn
PE30 4JE

Variation application number

EPR/GP3135AS/V006

Permit number

EPR/GP3135AS

Mars Food UK Limited

Permit number EPR/GP3135AS

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.

The schedules specify the changes made to the permit.

The installation is located at Hansa Road, Norfolk. The national grid reference for the centre of the installation is TF 63040 19100. The installation comprises a factory producing finished rice, pasta and sauce based products which are packaged in plastic pouches or pots before being distributed.

Pouches are flushed with nitrogen to provide an inert atmosphere prior to being filled. Dry ingredients are measured and dispensed into pouches or pots prior to adding water and wet ingredients. These containers are pasteurised in steam retorts before being packed. Sauces are prepared by measuring batches of separate dry and wet ingredients before cooking. The sauces are then put into pouches or pots before pasteurisation or sterilisation prior to packaging.

Waste water is treated within the on-site effluent treatment plant which incorporates a screen, dissolved air flotation (DAF) unit and sludge containment prior to discharge to foul sewer under Trade effluent Consent at S1.

The activities are permitted under:

- Section 6.8 A(1)(d)(iii)(bb), the treatment and processing of animal and vegetable raw materials (other than milk only), both in combined and separate products.
- Section 5.4 A(1)(a)(ii), physico-chemical treatment of non-hazardous waste with a capacity exceeding 50 tonnes per day.

Steam is provided by three natural gas fired 5.34 MWth boilers (16.02 MWth total) with emissions via A11, A12 and A13. The boilers were permitted after 20 December 2018 under previous permit variation as new Medium Combustion Plant under the Environmental Permitting (England and Wales) (Amendment) Regulations 2018.

The site operates a Reverse Osmosis (RO) plant within the boiler house. Softened water from the water softening plant is subjected to Reverse Osmosis within two 22m³/hr capacity units prior to storage in the treated water tank.

Surface water from yard areas drains to the adjacent river (Middleton Stop Drain) via three emission points (W1, W2 and W3).

There are two Special Areas of Conservation (The Wash & North Norfolk Coast SAC, Roydon Common & Dersingham Bog SAC), one Special protection Area (The Wash SPA), three Ramsar Sites (The Wash Ramsar, Roydon Common Ramsar and Dersingham Bog Ramsar) within 10km and one Site of Special Scientific Interest (River Nar SSSI within 2km of the facility).

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/GP3135AS/A001	Duly made 25/03/2015	Application received for a food and drink facility with on-site effluent treatment plant
Permit determined	26/02/2016	Permit issued to Mars Food UK Limited
Application EPR/GP3135AS/V002	26/07/2018	Application to decrease stack height of emission points A1 and A2 and make a number of other unrelated modifications to the site/operations
Application EPR/GP3135AS/V002	22/08/2018	Returned to applicant
Application EPR/GP3135AS/V003 (variation)	Duly made 12/11/2018	Application to decrease stack height of emission points A1 and A2 and make a number of other unrelated modifications to the site/operations
Variation determined EPR/GP3135AS/V003	10/01/2019	Varied and consolidated permit issued
Application EPR/GP3135AS/V004 (variation)	Duly made 02/10/2019	Application to permit operation of a new effluent treatment plant and a new point source emission to surface water
Variation determined EPR/GP3135AS/V004	06/05/2020	Varied and consolidated permit issued
Application EPR/GP3135AS/V005 (variation and consolidation)	Duly made 29/01/2021	Application to vary the permit to add three new boilers (replacing two existing boilers), introduce reverse osmosis to the existing boiler water pre-treatment system and add a bulk salt saturation tank to serve the existing water softening process.
Additional information received	25/03/2021	Confirmation that the bulk salt saturator tank bund is existing, and details of the existing brine provision arrangements.
Additional information received	29/04/2021	Response to Schedule 5 notice issued 07/04/2021 including information relating to tank specification and location, secondary containment, raw materials delivery and noise management.
Variation determined and consolidation issued EPR/GP3135AS (Billing reference: AP370LP)	27/05/2021	Varied and consolidated permit issued to Mars Food UK Limited.
Application EPR/GP3135AS/V006 (variation and consolidation)	Regulation 61 Notice response received 08/10/2022	Environment Agency initiated variation and consolidation following the Food, Drink & Milk Industries sector permit review.
Additional information received	11/10/2023	Supporting documentation regarding ISO certification, energy efficiency, water use minimisation, cleaning chemicals, F-Gas register, relative hazardous substances and climate change adaptation.

Status log of the permit		
Description	Date	Comments
Variation determined and consolidation issued EPR/GP3135AS (Billing ref. GP3135AS).	06/11/2023	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/GP3135AS

Issued to

Mars Food UK Limited (“the operator”)

whose registered office is

3d Dundee Road

Slough

Berkshire

SL1 4LG

company registration number 06649971

to operate a regulated facility at

King’s Lynn Site

Hansa Road

King’s Lynn

PE30 4JE

to the extent set out in the schedules.

The notice shall take effect from 06/11/2023.

Name	Date
Beccy Brough	06/11/2023

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/GP3135AS

This is the consolidated permit referred to in the variation and consolidation notice for application EPR/GP3135AS/V006 authorising,

Mars Foods UK Limited (“the operator”),

whose registered office is

**3d Dundee Road
Slough
Berkshire
SL1 4LG**

company registration number 06649971

to operate an installation at

**King’s Lynn Site
Hansa Road
King's Lynn
PE30 4JE**

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

Name	Date
Beccy Brough	06/11/2023

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.

3.2 Emissions of substances not controlled by emission limits

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

3.3 Odour

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

3.4 Noise and vibration

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

3.5 Monitoring

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

3.6 Pests

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

4 Information

4.1 Records

- 4.1.1 All records required to be made by this permit shall:
- (a) be legible;
 - (b) be made as soon as reasonably practicable;
 - (c) if amended, be amended in such a way that the original and any subsequent amendments remain legible, or are capable of retrieval; and
 - (d) be retained, unless otherwise agreed in writing by the Environment Agency, for at least 6 years from the date when the records were made, or in the case of the following records until permit surrender:
 - (i) off-site environmental effects; and
 - (ii) matters which affect the condition of the land and groundwater.
- 4.1.2 The operator shall keep on site all records, plans and the management system required to be maintained by this permit, unless otherwise agreed in writing by the Environment Agency.

4.2 Reporting

- 4.2.1 The operator shall send all reports and notifications required by the permit to the Environment Agency using the contact details supplied in writing by the Environment Agency.
- 4.2.2 For the following activities referenced in schedule 1, table S1.1 (AR1 to AR4 etc.) 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 (d) (iii)	Treatment and processing of animal and vegetable raw materials (other than milk only), both in combined and separate products – rice, pasta and sauce based products.	From receipt of raw materials to production of finished product including storage and dispatch off site. Production capacity is limited to 335 tonnes per day.
AR2	Section 5.4 Part A1 (a) (ii)	Physico-chemical Treatment of non-hazardous waste waters by dissolved air flotation (DAF)	From generation of waste water to discharge to foul sewer.
Directly Associated Activity			
AR3	Steam supply	Medium Combustion plants: 3 x 5.34 MWth natural gas boilers with a combined thermal input of 16.02MWth	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	Surface water drainage	Collection of uncontaminated site surface waters	Handling and storage of site drainage until discharge to the site surface water system.
AR9	Nitrogen generation	Nitrogen gas generation from compressed air using a carbon molecular sieve.	-
AR10	Cooling tower	Operation of cooling tower	-
AR11	Water treatment plant	Water treatment involving de-alkalisation, reverse osmosis and chemical addition prior to use on site	From receipt of mains water to distribution of treated water for use within the installation, including the storage and use of water treatment chemicals.

Table S1.2 Operating techniques		
Description	Parts	Date Received
Application	Parts B2 and B3 of the application form and referenced supporting information including 'Initial Noise Management Plan'.	Duly Made 25/03/15
Application	Email responses to request for information including details on storage and drainage arrangements, noise management, emissions to air and cleaning in place.	19/10/15
	Email response to request for information including details on drainage infrastructure, noise management and emissions to air.	30/10/15
	Updated emission point location plan 'Mars KLN Site Emission Locations' dated 30/10/15	02/11/15
	Email response to request for information including details on product storage and baseline samples.	21/12/15
Improvement Condition IC1	" Mars Noise Management Plan v1.pdf" received 01/06/16	01/06/16
Variation V003	Parts C2 and C3 of the application form and referenced supporting information.	25/09/18
Variation V003	Email response to request for information clarifying various details of the application, including location of proposed changes, risk assessment for modified activities, and confirming that the site boundary is unchanged.	02/11/18
Variation V004	Responses to question in Parts C2 and C3 of the application form and referenced supporting information.	Duly made 02/10/19
Additional information in response to Schedule Notice issued 07/02/2020	Response to questions 1- 8. Information on compliance with BAT conclusions, chemical dosing rates, containment and accident management. Supporting document - Environmental Permit variation application and appendices Doc Ref: 403.07945.00003 V3 March 2020.	05/03/20
Additional information in response to Schedule 5 Notice issued 07/02/2020	Response to questions 1-8. Information on compliance with BAT conclusions, chemical dosing rates, containment and accident management. Supporting document - Environmental Permit variation application and appendices Doc Ref 403.07945.000030 V3 March 2020.	08/03/20
Application EPR/GP3135AS/V005	Application supporting documents including: <ul style="list-style-type: none"> • Main supporting document – Mars Food UK Ltd, King's Lynn – Environmental Permit variation application (dated October 202); • Not duly made written response points 1 to 5, dated 20 January 2021. 	Duly made 29/01/21
Additional information in response to Schedule 5 Notice issued 07/04/2021	Responses to questions 1-7. Information on tank specification and location, secondary containment, raw materials delivery and updated noise management plan.	29/04/21

Table S1.2 Operating techniques		
Description	Parts	Date Received
Regulation 61 (1) Notice – Responses to questions dated 09/06/2022	All parts	Received 08/10/2022
Additional information. Request for further information dated 12/09/2023	Email information response dated 11/10/2023 and associated documents	11/10/2023

Table S1.3 Improvement programme requirements		
Reference	Requirement	Date
IC2	<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 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 existing 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. 	04/12/2023
IC3	<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"> • 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
-	-

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
A3 Diesel motor exhaust [Point A3 on site plan in Schedule 7]	Diesel motor to power the fire sprinkler equipment	Combustion gases	No limit set	-	-	-
A4 Diesel motor exhaust [Point A4 on site plan in Schedule 7]	Diesel motor to power the fire sprinkler equipment	Combustion gases	No limit set	-	-	-
A5 Bay 2,3 Retorts blowdown [Point A5 on site plan in Schedule 7]	Retorts	Water vapour	No limit set	-	-	-
A6 Bay 2,3 Cooling towers as shown [Point A6 on site plan in Schedule 7]	Cooling towers	Water vapour	No limit set	-	-	-
A8 Test retort blowdown [Point A8 on site plan in Schedule 7]	Test retort	Water vapour	No limit set	-	-	-
A9 Bay 4 retorts blow down [Point A9 on site plan in Schedule 7]	Retorts	Water vapour	No limit set	-	-	-
A10 Bay 4 Retorts cooling tower [Point A10 on site plan in Schedule 7]	Cooling tower	Water vapour	No limit set	-	-	-
A11 Boiler 1 stack located at TF 63030 19115 [Point A11 on site plan in Schedule 7]	5.34 MWth input natural gas fired boiler	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	Periodic	Every three years	MCERTS BS EN15058
A12 Boiler 2 stack located at TF 63033 19113	5.34 MWth input natural gas fired boiler	Oxides of Nitrogen (NO and NO ₂)	100 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
[Point A12 on site plan in Schedule 7]		expressed as NO _x)				
		Carbon monoxide	No Limit	Periodic	Every three years	MCERTS BS EN15058
A13 Boiler 3 stack located at TF 63036 19111 [Point A13 on site plan in Schedule 7]	5.34 MWth input natural gas fired boiler	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	Periodic	Every three years	MCERTS BS EN15058

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 [Point W1 on site plan in schedule 7] emission to Middleton Stop Drain	Uncontaminated surface runoff	No visible oil or grease	No significant trace present	Instantaneous (spot sample)	Weekly	Visual assessment
W2 [Point W2 on site plan in schedule 7] emission to Middleton Stop Drain	Uncontaminated surface runoff	No visible oil or grease	No significant trace present	Instantaneous (spot sample)	Weekly	Visual assessment
W3 [Point W3 on site plan in schedule 7] emission to Middleton Stop Drain	Uncontaminated surface runoff	No visible oil or grease	No significant trace present	Instantaneous (spot sample)	Weekly	Visual assessment

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

Emission point ref. & location	Source	Parameter	Limit (incl. Unit)	Reference period	Monitoring frequency	Monitoring standard or method
S1 [Point S1 on site plan in schedule 7] emission to Clenchwarten Sewage Treatment Works	Treated process effluent from onsite effluent treatment plant	No parameters Set	No limit set	--	--	--

Schedule 4 – Reporting

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

Table S4.1 Reporting of monitoring data			
Parameter	Emission or monitoring point/reference	Reporting period	Period begins
Point source emissions to air Parameters as required by condition 3.5.1	A11, A12, A13	Every 3 years	1 January
Point source emissions to water (other than sewer) Parameters as required by condition 3.5.1	W1, W2, W3	Every 6 months	1 January, 1 July

Table S4.2: Annual production/treatment	
Parameter	Units
Total product	tonnes

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

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

Table S4.4 Reporting forms		
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
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

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

“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.

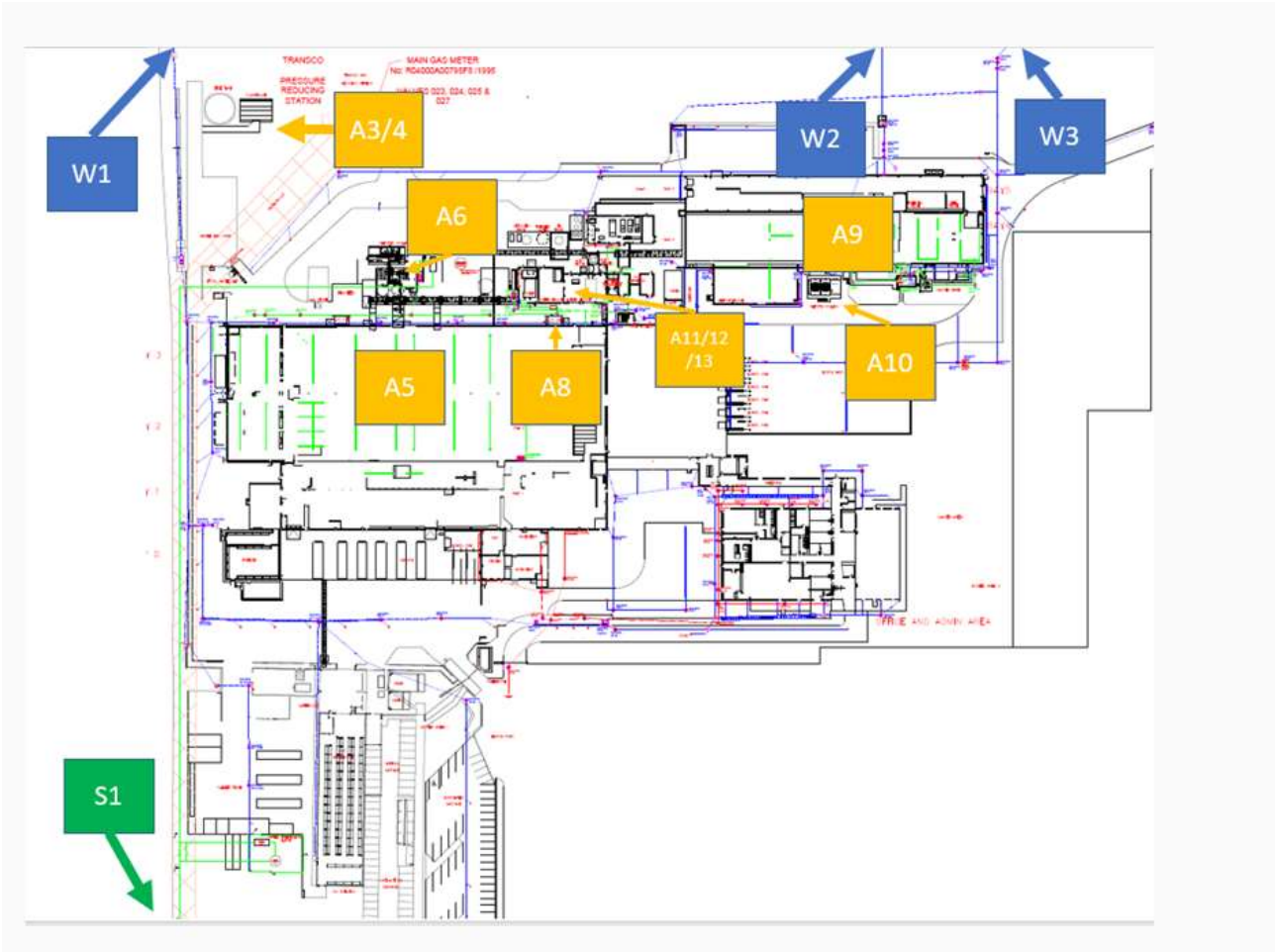
Where a minimum limit is set for any emission parameter, for example pH, reference to exceeding the limit shall mean that the parameter shall not be less than that limit.

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

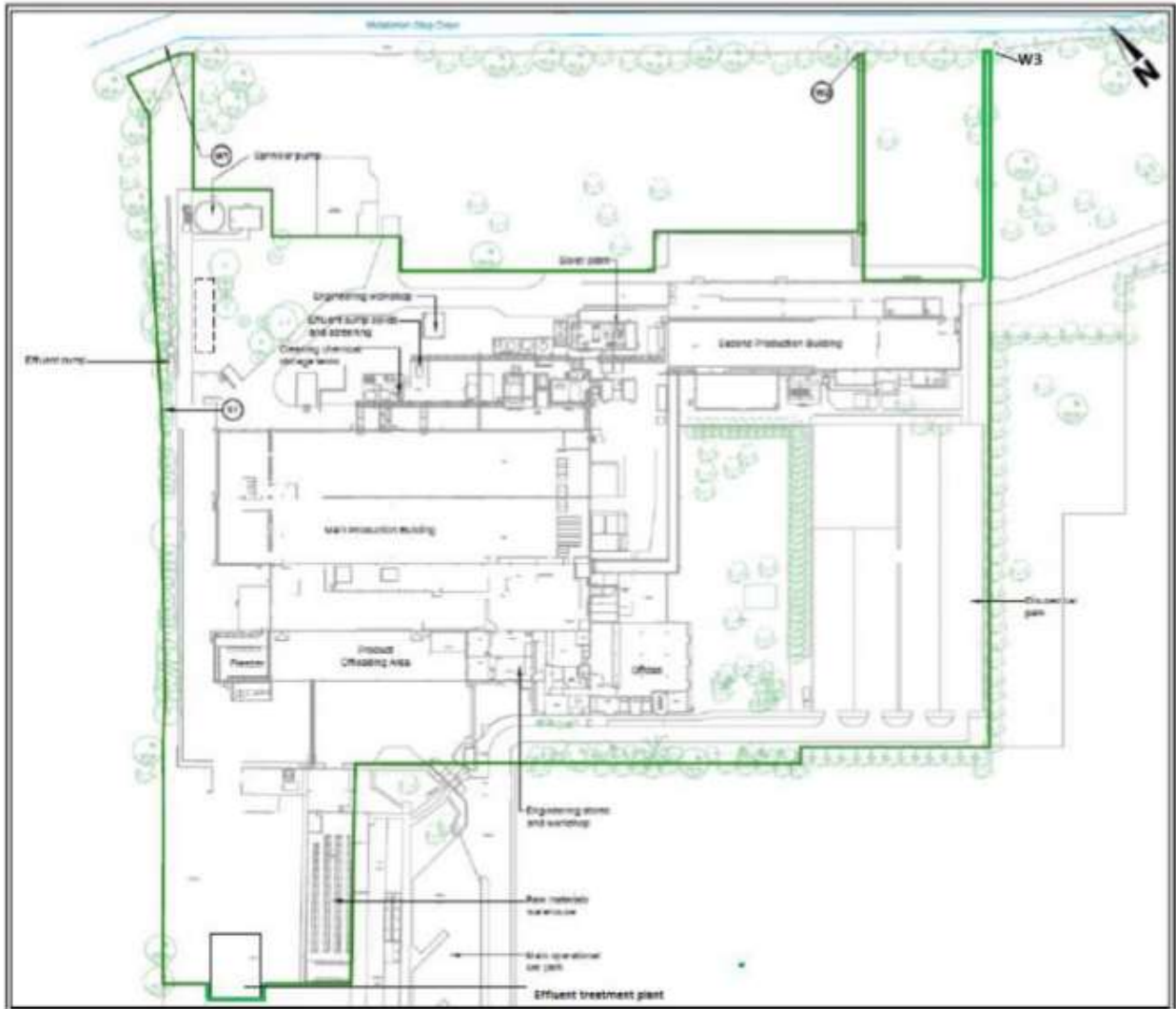
- in relation to emissions from combustion processes, the concentration in dry air at a temperature of 273K, at a pressure of 101.3 kPa and with an oxygen content of 3% dry for liquid and gaseous fuels, 6% dry for solid fuels; and/or
- in relation to emissions from non-combustion sources, the concentration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



Emission point plan



Permit boundary plan

END OF PERMIT

Emissions to Air Reporting Form

Permit number: EPR/GP3135AS

Operator: Mars Foods UK Limited

Facility name: Mars Foods UK Limited

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

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

Emission point	Substance / parameter	Emission Limit Value	Reference period	Test method ¹	Result ²	Sample dates and times ³	Uncertainty ⁴
<i>[e.g. A1]</i>	<i>[e.g. Oxides of nitrogen (NO and NO₂ expressed as NO₂)]</i>	<i>[e.g. 200 mg/m³]</i>	<i>[e.g. daily average]</i>	<i>[e.g. BS EN 14181]</i>	<i>[State result]</i>	<i>[State relevant dates and time periods]</i>	<i>[State uncertainty if not 95% confidence interval]</i>

Signed: *[Name]*

Date: *[DD/MM/YY]*

(Authorised to sign as representative of the operator)

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

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

- ¹ Where an internationally recognised standard test method is used, give the reference number. Where another method that has been formally agreed with the Environment Agency, give the appropriate identifier. In other cases state the principal technique, for example gas chromatography.
- ² Give the result as the maximum value (or the minimum value in the case of a limit that is expressed as a minimum) obtained during the reporting period, expressed in the same terms as the emission limit value. Where the emission limit value is expressed as a range, give the result as the 'minimum to maximum' of the measured values.
- ³ For non-continuous measurements give the date and time of the sample that produced the result. For continuous measurements give the percentage of the process operating time covered by the result.
- ⁴ Complete if the uncertainty associated with the result is not a 95% confidence interval. Leave blank for 95% confidence intervals.

Emissions to Water Reporting Form

Permit number: EPR/GP3135AS

Operator: Mars Foods UK Limited

Facility name: Mars Foods UK Limited

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

Reporting of emissions to water (other than to sewer) for the period from *[DD/MM/YY]* to *[DD/MM/YY]*

Emission point	Substance / parameter	Emission Limit Value	Reference period	Test method ¹	Result ²	Sample dates and times ³	Uncertainty ⁴
<i>[e.g. W1]</i>	<i>[e.g. Total suspended solids]</i>	<i>[e.g. 30 mg/l]</i>	<i>[e.g. For 95% of all measured values of periodic samples taken over one month]</i>	<i>[e.g. BS EN 872:2005]</i>	<i>[State result]</i>	<i>[State relevant dates and time periods]</i>	<i>[State uncertainty if not 95% confidence interval]</i>

Signed: *[Name]*

Date: *[DD/MM/YY]*

(Authorised to sign as representative of the operator)

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

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

- ¹ Where an internationally recognised standard test method is used, give the reference number. Where another method that has been formally agreed with the Environment Agency, give the appropriate identifier. In other cases state the principal technique, for example gas chromatography.
- ² Give the result as the maximum value (or the minimum value in the case of a limit that is expressed as a minimum) obtained during the reporting period, expressed in the same terms as the emission limit value. Where the emission limit value is expressed as a range, give the result as the 'minimum to maximum' of the measured values.
- ³ For non-continuous measurements give the date and time of the sample that produced the result. For continuous measurements give the percentage of the process operating time covered by the result.
- ⁴ Complete if the uncertainty associated with the result is not a 95% confidence interval. Leave blank for 95% confidence intervals.

Water Usage Reporting Form

Permit number: EPR/GP3135AS

Operator: Mars Foods UK Limited

Facility name: Mars Foods UK Limited

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

Reporting of water usage for the year [YYYY]

Water source	Water usage (m³)	Specific water usage (m³/tonne of product) ²
Mains water	<i>[insert annual usage in m³ where mains water is used]</i>	Not Applicable
Site borehole	<i>[insert annual usage in m³ where water is used from a site borehole]</i>	Not Applicable
River abstraction	<i>[insert annual usage in m³ where abstracted river water is used]</i>	Not Applicable
Other – <i>[specify other water source where applicable. Add extra rows where needed]</i>	<i>[insert annual usage in m³ where applicable]</i>	Not Applicable
Total water usage	<i>[insert total annual water usage in m³]</i>	<i>[insert total water use per tonne of product produced m³/t]</i>

Operator's comments

Operator's comments

Signed: *[Name]*

Date: *[DD/MM/YY]*

(Authorised to sign as representative of the operator)

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

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

Energy Usage Reporting Form

Permit number: EPR/GP3135AS

Operator: Mars Foods UK Limited

Facility name: Mars Food UK Limited

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

Reporting of energy usage for the year [YYYY]

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

Operator's comments

Signed: *[Name]*

Date: *[DD/MM/YY]*

(Authorised to sign as representative of the operator)

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

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

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

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

Food Waste Reporting Form

Permit number: EPR/GP3135AS

Operator: Mars Foods UK Limited

Facility name: Mars Foods UK Limited

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

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

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

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

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

Signed: [Name]

Date: [DD/MM/YY]

(Authorised to sign as representative of the operator)

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

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

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

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

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

Other Performance Parameters Reporting Form

Permit number: EPR/GP3135AS

Operator: Mars Foods UK Limited

Facility name: Mars Foods UK Limited
08/03/2021

Other Performance Parameters Reporting Form: version 1,

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

Parameter	Units
<i>[e.g. Total raw material usage]</i>	<i>[e.g. tonnes per production unit]</i>
Total raw material used	tonnes
Compound feed production	tonnes
Dry pet food production	tonnes
Wet pet food production	tonnes
Effluent treated	m3
Waste sent for recovery (specify route)	tonnes
Waste sent for recycling (specify route)	tonnes
Total product waste sent for disposal (specify route)	tonnes

Operator's comments

Signed: *[Name]*

Date: *[DD/MM/YY]*

(Authorised to sign as representative of the operator)

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