

# Notice of variation and consolidation with introductory note

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

---

Arla Foods Limited  
Settle Creamery  
Sowarth Fields Industrial Estate  
Settle  
North Yorkshire  
BD24 9AF

**Variation application number**

EPR/BN0473IM/V007

**Permit number**

EPR/BN0473IM

# Settle Creamery

## Permit number EPR/BN0473IM

### Introductory note

#### **This introductory note does not form a part of the notice**

Under the Environmental Permitting (England & Wales) Regulations 2016 (schedule 5, part 1, paragraph 19) a variation may comprise a consolidated permit reflecting the variations and a notice specifying the variations included in that consolidated permit.

Schedule 1 of the notice specifies the conditions that have been varied and schedule 2 comprises a consolidated permit which reflects the variations being made. All the conditions of the permit have been varied and are subject to the right of appeal.

This consolidated permit has been issued following a full review against the best available techniques (BAT) conclusions for the Food, Drink and Milk Industries published on 4<sup>th</sup> December 2019 in the official journal of the European Union.

We have implemented the requirements of the Medium Combustion Plant directive and incorporated post-dated requirements for 2025 and 2030.

The schedules specify the changes made to the permit.

The main features of the permit are as follows.

Settle Creamery is an installation that undertakes the treatment and processing of milk under Section 6.8 A(1)(e) of the Environmental Permitting (England and Wales) Regulations 2016 – *Treating and processing milk, the quantity of milk received being more than 200 tonnes per day (average value on an annual basis)*.

The installation also operates an effluent treatment plant (ETP) under section 5.4 A(1)(a)(ii) of the Environmental Permitting (England and Wales) Regulations 2016 - *Disposal of non-hazardous waste with a capacity exceeding 50 tonnes per day involving physico-chemical treatment*.

The site is located in Sowarth Field Industrial Estate, Settle, North Yorkshire, National Grid Reference (NGR) SD 81429, 63520. The boundary of the site runs adjacent to the river Ribble on its western side and several other commercial and industrial sites. The closest residential sensitive receptor is 50 metres away.

This is a dairy installation with a production capacity of 757 tonnes per day, including UHT, skimmed, semi-skimmed, whole milk, lactose-free, and organic milk. The raw milk is delivered to site by road tankers and stored in milk silos. The milk is then processed through various stages depending on the product specifications and can include pasteurisation, separation of cream, reworking of pasteurised material, homogenisation, cooling, bottling, storing, and dispatch of the final product. The site operates reverse osmosis as part of the production process to dewater partially treated milk. The water that is removed is sent to the effluent treatment plant.

For the scope of producing hot water and steam utilised in the production process and cleaning activities, the site operates three Boilers with an aggregated input of approximately 21 MWth inclusive of Boiler 1 – 4.4 MWth, Boiler 2 – 7.4 MWth, and Boiler 3 – 9.8 MWth. Combustion gases resulted from the operation of Boilers 1 and 2 fired on natural gas and Boiler 3 fired on liquefied petroleum gas (LPG) are released into the atmosphere via air emission points A1, A2, and A3. Boiler blowdown from all boilers is routed to the onsite effluent treatment plant for processing.

The site operates a physico-chemical effluent treatment plant to treat the process effluent generated during production, cleaning activities, and boilers blowdown before it is released to sewer under consent via sewer emission point S1. The effluent treatment process consists of separation, equalisation, neutralisation,

chemical dosing, direct air flotation (DAF), coagulation and flocculation and sedimentation treatment. Dewatering of sludge before being sent to off-site. Uncontaminated run-off water from roofs, carpark, and yards is discharged to River Ribble via emission points W1, W2, and W3.

There are statutory ecological receptors within the relevant distances of the site. These consist of a Ramsar site (Malham Tarn), two Special Areas of Conservation (Craven Limestone Complex and Ingleborough Complex) within 10km and five Sites of Special Scientific Interest (Attermire, river Ribble – Long Preston Deeps, Lords Wood and Pasture, Giggleswick Scar and Kinsey Cave, and Langcliffe Scars and Jubilee, Albert and Victoria Caves), five Ancient Woodlands (Cleatop Park, Hanging Scar, Lords/Kelcow, Scaither Plantation and Springs), and Local Wildlife Site (Huntsworth Common) within 5km of the site.

The operator has an EMS externally accredited to the ISO14001 standard.

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>
Permit determined EPR/BN0473IM	04/11/05	Original permit issued to Arla Foods Plc
Application received EPR/BN0473IM/V002	19/03/13	Name change to Arla Foods Limited.
Variation issued EPR/BN0473IM/V002	25/04/13	Varied permit issued to Arla Foods Limited.
Agency variation determined EPR/BN0473IM/V003	06/01/14	Agency variation to implement the changes introduced by IED
Application EPR/BN0473IM/V004 (variation and consolidation)	Duly made 17/06/20	Application to vary and update the permit to modern conditions and include the following changes: <ul style="list-style-type: none"> <li>• The removal of butter production</li> <li>• The addition of production of lacto-free (90Million Litres) and organic milk (30Million Litres);</li> <li>• New CIP systems to serve the new process plant;</li> <li>• New energy centre to the site, new 9.8MWth boiler, refrigeration plant and compressors;</li> <li>• A new chill store in the despatch bay;</li> <li>• Upgrades to the effluent treatment plant with the potential addition of acid cracking if required;</li> <li>• Decommissioning of the existing fuel oil boiler and associated fuel storage tanks;</li> <li>• Installation of a reverse osmosis plant</li> </ul>
Additional information received	11/11/20	Response to Schedule 5 dated 12/10/20 detailing effluent monitoring, noise impact and attenuation measures, disposal routes for process waters, monitoring, BATc, chloride monitoring, homogeniser details and details relating to updated trade effluent discharge consent.
Additional information received	08/12/20	E-Mail confirming implementation of acoustic barrier designs at construction stage, relating to steam sterilisation plant and roof mounted cooling plant.
Variation determined EPR/BN0473IM	02/02/21	Varied and consolidated permit.

<b>Status log of the permit</b>		
<b>Description</b>	<b>Date</b>	<b>Comments</b>
Application EPR/BN0473IM/V005 (variation and consolidation)	Duly made 08/10/21	Application to add gas fired back up boiler to the list of permitted activities.
Variation determined and consolidation issued EPR/BN0473IM	10/11/21	Varied and consolidated permit issued in modern format.
Application EPR/BN0473IM/V006 (variation and consolidation)	Duly made 17/03/23	Application to add a new Dissolved Air Flotation System
Variation determined and consolidation issued EPR/BN0473IM	11/05/23	Varied and consolidated permit issued in modern format.
Application EPR/BN0473IM/V007 (variation and consolidation)	Regulation 61 Notice response received 22/07/22	Environment Agency initiated variation and consolidation following the Food, Drink & Milk Industries sector permit review.
Variation determined and consolidation issued EPR/BN0473IM/V007 (Billing ref. JP3505MJ).	08/11/23	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/BN0473IM**

### Issued to

**Arla Foods Limited** (“the operator”)

whose registered office is

**Arla House**

**4 Savannah Way**

**Leeds Valley Park**

**Leeds**

**Yorkshire**

**LS10 1AB**

company registration number 02143253

to operate a regulated facility

**Settle Creamery**

**Sowarth Fields Industrial Estate**

**Settle**

**North Yorkshire**

**BD24 9AF**

to the extent set out in the schedules.

The notice shall take effect from 08/11/2023.

<b>Name</b>	<b>Date</b>
<b>Marcus Woodward</b>	<b>08/11/2023</b>

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/BN0473IM**

This is the consolidated permit referred to in the variation and consolidation notice for application EPR/BN0473IM/V007 authorising,

**Arla Foods Limited** (“the operator”),

whose registered office is

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

company registration number 02143253

to operate an installation at

**Settle Creamery  
Sowarth Fields Industrial Estate  
Settle  
North Yorkshire  
BD24 9AF**

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

Name	Date
Marcus Woodward	08/11/2023

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 For the following activities referenced in schedule 1, table S1.1 (AR1 to AR9) 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.

### **2.4 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 (AR3 – Medium Combustion Plant) the first monitoring measurements shall be carried out within four months of 01/01/2025 for Boilers 2 and 3, and 01/01/2030 for Boiler 1, or of the date when the MCP is first put into operation, whichever is later.

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

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

### **3.3 Odour**

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

### **3.4 Noise and vibration**

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

approved noise and vibration management plan to prevent or where that is not practicable to minimise the noise and vibration.

3.4.2 The operator shall:

- (a) if notified by the Environment Agency that the activities are giving rise to pollution outside the site due to noise and vibration, submit to the Environment Agency for approval within the period specified, a noise and vibration management plan which identifies and minimises the risks of pollution from noise and vibration;
- (b) implement the approved noise and vibration management plan, from the date of approval, unless otherwise agreed in writing by the Environment Agency.

### **3.5 Monitoring**

3.5.1 The operator shall, unless otherwise agreed in writing by the Environment Agency, undertake the monitoring specified in the following tables in schedule 3 to this permit:

- (a) point source emissions specified in tables S3.1, S3.2 and S3.3.

3.5.2 The operator shall maintain records of all monitoring required by this permit including records of the taking and analysis of samples, instrument measurements (periodic and continual), calibrations, examinations, tests and surveys and any assessment or evaluation made on the basis of such data.

3.5.3 Monitoring equipment, techniques, personnel and organisations employed for the emissions monitoring programme and the environmental or other monitoring specified in condition 3.5.1 shall have either MCERTS certification or MCERTS accreditation (as appropriate), where available, unless otherwise agreed in writing by the Environment Agency.

3.5.4 Permanent means of access shall be provided to enable sampling/monitoring to be carried out in relation to the emission points specified in schedule 3 tables S3.1, S3.2, S3.3 unless otherwise agreed in writing by the Environment Agency.

### **3.6 Pests**

3.6.1 The activities shall not give rise to the presence of pests which are likely to cause pollution, hazard or annoyance outside the boundary of the site. The operator shall not be taken to have breached this condition if appropriate measures, including, but not limited to, those specified in any approved pests management plan, have been taken to prevent or where that is not practicable, to minimise the presence of pests on the site.

3.6.2 The operator shall:

- (a) if notified by the Environment Agency, submit to the Environment Agency for approval within the period specified, a pests management plan which identifies and minimises risks of pollution from pests;
- (b) implement the pests management plan, from the date of approval, unless otherwise agreed in writing by the Environment Agency.

## 4 Information

### 4.1 Records

4.1.1 All records required to be made by this permit shall:

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

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

### 4.2 Reporting

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

4.2.2 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

<b>Table S1.1 activities</b>			
<b>Activity reference</b>	<b>Activity listed in Schedule 1 of the EP Regulations</b>	<b>Description of specified activity</b>	<b>Limits of specified activity</b>
AR1	Section 6.8 Part A1 (e)	Treating and processing milk with the quantity of milk received being more than 200 tonnes per day (average value on annual basis)	From receipt of raw milk delivered to the site to the dispatch of processed packaged milk, including UHT, skimmed, semi-skimmed, whole milk, lactose-free, and organic milk.  Production capacity is limited to 757 tonnes per day.
AR2	Section 5.4 Part A1 (a) (ii)	Physico-chemical Treatment of non-hazardous waste waters with a capacity exceeding 50 tonnes per day by dissolved air flotation/pH adjustment.	From generation of waste water to discharge to sewer following treatment in the ETP consisting of equalisation, neutralisation, chemical dosing, DAF, coagulation and flocculation, sedimentation and dewatering of sludge.  The DAF plant has a capacity to treat up to 960m <sup>3</sup> /day (24 hours) this equates to 40m <sup>3</sup> /hour.
<b>Directly Associated Activity</b>			
AR3	Steam and heat generation	Medium Combustion plants: Boiler A1: 4.4 MWth Natural gas fired Boiler A2: 7.4 MWth Natural gas fired Boiler A3: 9.8 MWth LPG	From receipt of fuel to release of products of combustion to air.  Boilers 1 and 2 are operated in alternation and not permitted to run simultaneously.
AR4	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.
AR5	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.
AR6	Waste storage, handling, and despatch	Storage and handling of waste materials.	From generation of waste produced at installation to temporary storage pending removal for disposal or recovery.

<b>Table S1.1 activities</b>			
<b>Activity reference</b>	<b>Activity listed in Schedule 1 of the EP Regulations</b>	<b>Description of specified activity</b>	<b>Limits of specified activity</b>
AR7	Surface water drainage	Collection of uncontaminated site surface waters	Collection and handling of the site drainage until discharge to River Ribble.

<b>Table S1.2 Operating techniques</b>		
<b>Description</b>	<b>Parts</b>	<b>Date Received</b>
Variation Application EPR/BN0473IM/V006	Document entitled Application to vary Environmental Permit EPR/BN0473IM/V005 Document reference 202122033 dated 07 February 2023 in support of variation application	Duly made 17/03/2023
Additional Information	Document entitled Updated Site reference plan as Site Plan 2207011146-001 New ETP in support of variation application	29/03/2023
Regulation 61 (1) Notice – Responses to questions dated 24/03/22	All parts	Received 22/07/22
Regulation 61(1) Notice – request for further information dated 06/07/23	Responses to buffer capacity and use of penstocks; bunding; boiler blowdown questions.	Received 18/07/23
Request for further clarification dated 08/08/23	Responses to process flow; BATc9 F Gas; solid waste from effluent treatment plant questions.	Received 10/08/23

<b>Table S1.3 Improvement programme requirements</b>		
<b>Reference</b>	<b>Requirement</b>	<b>Date</b>
IP7	<p>The operator shall undertake a comprehensive assessment of the secondary and tertiary containment provisions onsite by a suitable qualified person against CIRIA C736.</p> <p>The operator shall submit a written report to the Environment Agency for approval which outlines the results of the assessment and provides details of:</p> <ul style="list-style-type: none"> <li>• Current secondary/tertiary containment measures</li> <li>• Any deficiencies identified in comparison to the relevant standards</li> <li>• Improvements proposed</li> <li>• Timescale for implementation of Improvements</li> </ul> <p>The operator shall implement the proposed improvements in line with the timescales agreed by the Environment Agency and incorporate an ongoing routine inspection and maintenance programme as part of the EMS.</p>	10/05/2024
IP8	<p>The operator shall produce a climate change adaptation plan, which will form part of the EMS.</p> <p>The plan shall include, but not be limited to:</p>	12 months from permit issue or other date as



<b>Table S1.3 Improvement programme requirements</b>		
<b>Reference</b>	<b>Requirement</b>	<b>Date</b>
	<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>	agreed in writing with the Environment Agency

## 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

<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>
Boiler A1 [Point A1 on site plan in Schedule 7]	Boiler 1 4.4MWth Natural gas	Oxides of Nitrogen (NO and NO <sub>2</sub> expressed as NO <sub>x</sub> )	189 mg/m <sup>3</sup>	Periodic	Every three years	BS EN 14792
		Carbon monoxide	No limit set	Periodic	Every three years	MCERTS BS EN15058
Boiler A2 [Point A2 on site plan in Schedule 7]	Boiler 2 7.4MWth Natural gas	Oxides of Nitrogen (NO and NO <sub>2</sub> expressed as NO <sub>x</sub> )	100 mg/m <sup>3</sup>	Periodic	Every three years	BS EN 14792
		Carbon monoxide	No limit set	Periodic	Every three years	MCERTS BS EN15058
Boiler A3 [Point A3 on site plan in Schedule 7]	Boiler 3 9.8MWth LPG	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
		Sulphur Dioxide	35mg/m <sup>3</sup>	Periodic	Every three years	BS EN 14792
		Carbon monoxide	No limit set	Periodic	Every three years	MCERTS BS EN15058

<b>Table S3.2 Point Source emissions to water (other than sewer) and land – emission limits and monitoring requirements</b>						
<b>Emission point ref. &amp; location</b>	<b>Source</b>	<b>Parameter</b>	<b>Limit (incl. unit)</b>	<b>Reference Period</b>	<b>Monitoring frequency</b>	<b>Monitoring standard or method</b>
W1, W2 & W3 on site plan in schedule 7 emission to river Ribble	Uncontaminated surface water from site roofs and surfaces	No parameters set	No limit set	--	--	--

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

<b>Emission point ref. &amp; location</b>	<b>Source</b>	<b>Parameter</b>	<b>Limit (incl. Unit)</b>	<b>Reference period</b>	<b>Monitoring frequency</b>	<b>Monitoring standard or method</b>
S1 on site plan in Schedule 7 emission to United Utilities wastewater treatment works, Bridge End, Settle	Site effluent treatment plant	No parameters set.	No limit set	--	--	--

## Schedule 4 – Reporting

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

<b>Table S4.1 Reporting of monitoring data</b>			
<b>Parameter</b>	<b>Emission or monitoring point/reference</b>	<b>Reporting period</b>	<b>Period begins</b>
Point source emissions to air Parameters as required by condition 3.5.1	A3	Every 3 years	1 January
	A1 & A2	First monitoring undertaken in accordance with Condition 3.1.4 to be reported within 3 months, and then every 3 years thereafter.	From first monitoring requirements in accordance with Condition 3.1.4

<b>Table S4.2: Annual production/treatment</b>	
<b>Parameter</b>	<b>Units</b>
All pasteurised milk produced.	tonnes
Amount of recovered water from the reverse osmosis plant	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
COD efficiency	Annually*	COD te/te product
Food waste	Annually	tonnes
Fate and route of recovered product from the reverse osmosis plant	Annually	tonnes
Fate and route of waste from the effluent treatment plant	Annually	tonnes

\*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

<b>Table S4.4 Reporting Forms</b>		
<b>Parameter</b>	<b>Reporting form</b>	<b>Form version number and date</b>
Energy usage	Energy Usage Reporting Form, or other form as agreed in writing by the Environment Agency	Version 1, 08/03/2021
Food Waste	Food waste Reporting form, or other form as agreed in writing by the Environment Agency	Version 1 06/02/2023
Other performance parameters	Other Performance Parameters Reporting Form, or other form as agreed in writing by the Environment Agency	Version 1, 08/03/2021

# Schedule 5 – Notification

These pages outline the information that the operator must provide.

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

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

## Part A

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

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

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

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

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

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

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

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

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



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

Name*	
Post	
Signature	
Date	

\* authorised to sign on behalf of the operator

## Schedule 6 – Interpretation

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

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

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

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

“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.

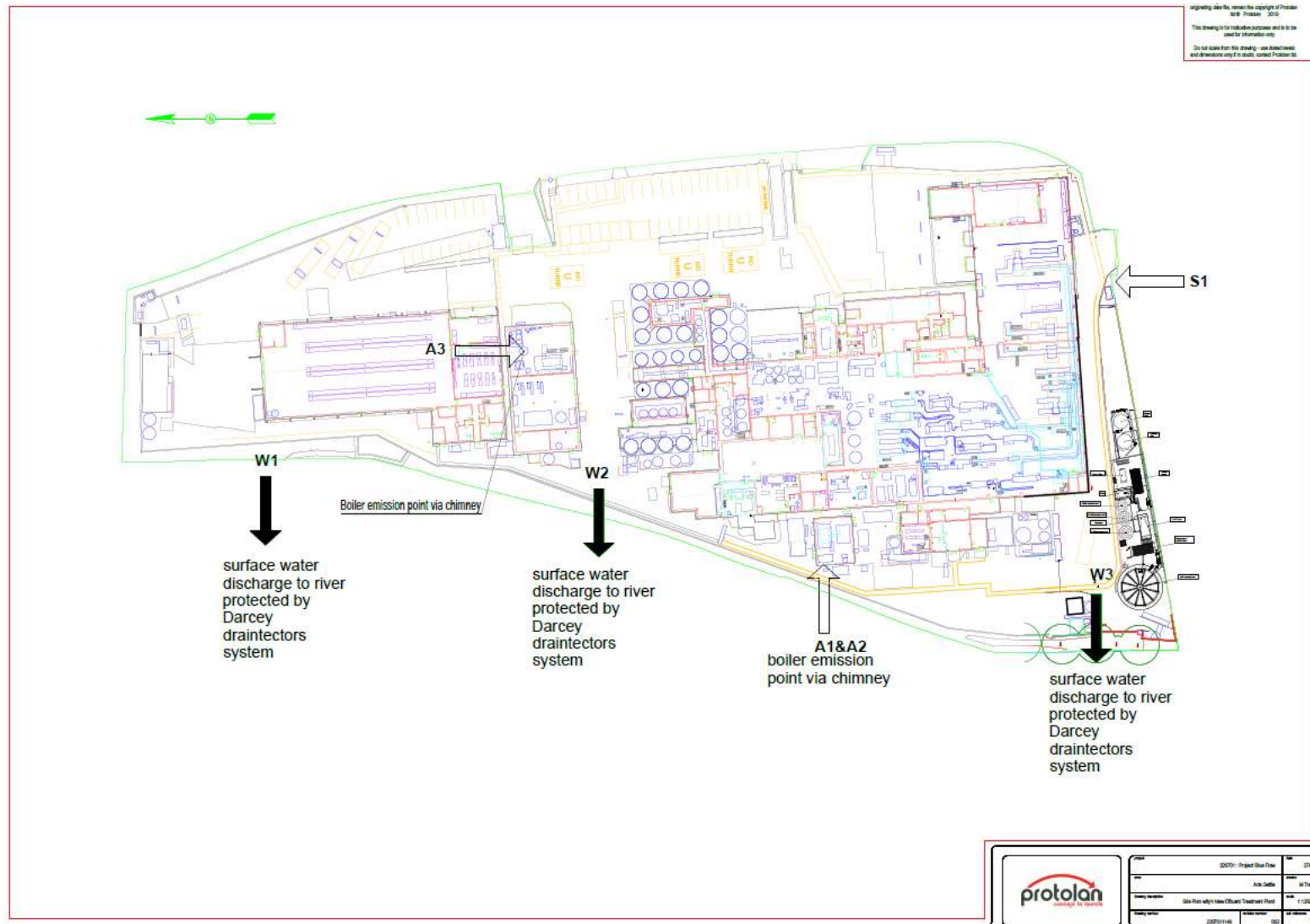
Where a minimum limit is set for any emission parameter, for example pH, reference to exceeding the limit shall mean that the parameter shall not be less than that limit.

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



END OF PERMIT

Permit number  
 EPR/BN0473IM