

# Notice of variation and consolidation with introductory note

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

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Meadow Foods Limited  
Station Lane Dairy  
Station Lane  
Holme-on-Spalding Moor  
York  
North Yorkshire  
YO43 4AN

**Variation application number**

EPR/KP3437PG/V003

**Permit number**

EPR/KP3437PG

# Station Lane Dairy

## Permit number EPR/KP3437PG

### 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.

The schedules specify the changes made to the permit.

The main features of the permit are as follows.

Meadow Foods Limited is located in Holme-on-Spalding Moor, approximately 7.5km southwest of Market Weighton at National Grid Reference SE7967138924. The installation with a capacity of approximately 60,000 tonnes of milk per year, process raw milk to produce market milk, cream, liquid skimmed milk, skimmed milk concentrate, soft cheese, mascarpone, Crème Fraiche, sour cream, Greek style yoghurt, buttermilk, condensed milk, chocolate crumb, and caramelised crumb.

The dairy process consists of three main operations: the cream plant, the evaporation plant, and the chocolate crumb plant, which are housed within a complex of two main buildings. In addition to the main dairy operations and the ETP, the Installation has the following facilities: milk reception area, material / product storage, chemical, oil and solvent storage, an engineering workshop and maintenance facility, chillers, cooling tower, and water storage; four dual fuel boilers, waste storage and wash-down areas. Raw materials (primarily milk, sugar, and cocoa liquor) are delivered to the site by road tanker and stored in their respective silos / tanks. Prior to tanker unloading, raw milk is tested for antibiotic content, freezing point, taste, and smell; any tanker containing milk that does not pass these tests is rejected and turned away from the site. From the silos, the raw milk is distributed to the various processing facilities as required.

Where possible, waste products and intermediates are recycled back into the process. Where recycling is not possible, waste liquid materials containing a high level of butterfat are sold on for other use and low-fat content liquid waste is processed in the ETP. Solid (powder) waste products / intermediates are bagged and sold, typically to animal feed manufacturers.

The Installation operates a biological Effluent Treatment Plant (ETP) where process water and wastewater from cleaning activities is treated prior to discharge to river Foulness. The treatment process consists of equalisation, physical separation, aerobic and anaerobic treatment, nitrification and denitrification, filtration, coagulation, and flocculation. Sludge resulting from the treatment of water is sent off-site to anaerobic digestors. Some of the water treated in the ETP is recycled and reused in the CIP or other cleaning activities. Surface water run-off is collected by the site surface water drainage system and is discharged to the surface water drainage ditch on the southern boundary of the site. There are seven release points (W2-W8) to the drainage ditch. A sluice gate is located downstream of these release points which, in the event of an emergency, can be closed.

Steam needed for production processes is generated by two natural gas fired boilers of 9.2 MWth input capacity each. The exhaust gases resulted from the combustion of fuel are released into the atmosphere via the air emission points A1 and A2. Although the boilers are dual fuel designed, natural gas and gas oil, only natural gas is used at this site as energy source for the boilers.

There are no Sites of Special Scientific Interest (SSSI) within 2km of the site. There are also four European sites, River Derwent – Special Area of Conservation (SAC) and the Lower Derwent Valley SAC, Special Protection Area (SPA) and Ramsar, the Humber Estuary SAC and the Humber Flats, Marshes and Coast SPA and Ramsar.

The Operator uses an Environmental Management System (EMS) accredited to ISO 14001 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>
Application received EPR/JP3437PG/A001	18/03/2005	Application received for the treatment and processing of milk.
Request to extend determination	30/09/2005	Request accepted 30/09/2005.
Request for further information	15/07/2005	Responses received on 22/07/2005, 25/07/2005, 27/07/2005, and 29/07/2005.
Permit determined EPR/JP3437PG	16/11/2005	Permit issued to Meadow Foods Limited.
Variation determined EPR/JP3437PG/V002	18/02/2014	Agency led variation to implement the changes introduced by IED.
Application EPR/KP3437PG/V003 (variation and consolidation)	Regulation 61 Notice response received 24/07/2022	Environment Agency initiated variation and consolidation following the Food, Drink & Milk Industries sector permit review.
Request for further information (dated 02/10/2023)	16/10/2023 20/10/2023	Information provided in relation to BATcs 1, 6(a), 9, 11, Boiler 3, cooling towers, updated site plan.
Variation determined and consolidation issued EPR/KP3437PG (Billing ref. GP3847QZ).	28/11/2023	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/KP3437PG

### Issued to

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

whose registered office is

**Rough Hill**

**Marlston-Cum-Lache**

**Chester**

**Cheshire**

**CH4 9JS**

company registration number 02720823

to operate a regulated facility at

**Station Lane Dairy**

**Station Lane**

**Holme-on-Spalding Moor**

**York**

**North Yorkshire**

**YO43 4AN**

to the extent set out in the schedules.

The notice shall take effect from 28/11/2023.

<b>Name</b>	<b>Date</b>
Marcus Woodward	28/11/2023

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/KP3437PG**

This is the consolidated permit referred to in the variation and consolidation notice for application EPR/KP3437PG/V003 authorising,

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

whose registered office is

**Rough Hill**

**Marlston-Cum-Lache**

**Chester**

**Cheshire**

**CH4 9JS**

company registration number 02720823

to operate an installation at

**Station Lane Dairy**

**Station Lane**

**Holme-on-Spalding Moor**

**York**

**North Yorkshire**

**YO43 4AN**

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

Name	Date
Marcus Woodward	28/11/2023

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 and AR2) 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 and S3.2.
- 3.1.2 The limits given in schedule 3 shall not be exceeded.
- 3.1.3 Periodic monitoring shall be carried out at least once every 5 years for groundwater and 10 years for soil, unless such monitoring is based on a systematic appraisal of the risk of contamination.
- 3.1.4 For the following activities referenced in schedule 1, table S1.1 (AR3) the first monitoring measurements shall be carried out within four months of 01/01/2025 or of the date when the MCP is first put into operation, whichever is later.

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

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

### **3.3 Odour**

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

### **3.4 Noise and vibration**

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

3.4.2 The operator shall:

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

## **3.5 Monitoring**

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

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

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

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

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

## **3.6 Pests**

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

3.6.2 The operator shall:

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

# **4 Information**

## **4.1 Records**

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

- (a) be legible;
- (b) be made as soon as reasonably practicable;
- (c) if amended, be amended in such a way that the original and any subsequent amendments remain legible, or are capable of retrieval; and

(d) be retained, unless otherwise agreed in writing by the Environment Agency, for at least 6 years from the date when the records were made, or in the case of the following records until permit surrender:

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

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

## 4.2 Reporting

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

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

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

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

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

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

## 4.3 Notifications

4.3.1 In the event:

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

- (c) of a breach of permit condition which poses an immediate danger to human health or threatens to cause an immediate significant adverse effect on the environment, the operator must immediately suspend the operation of the activities or the relevant part of it until compliance with the permit conditions has been restored.

4.3.2 Any information provided under condition 4.3.1 shall be confirmed by sending the information listed in schedule 5 to this permit within the time period specified in that schedule.

4.3.3 Where the Environment Agency has requested in writing that it shall be notified when the operator is to undertake monitoring and/or spot sampling, the operator shall inform the Environment Agency when the relevant monitoring and/or spot sampling is to take place. The operator shall provide this information to the Environment Agency at least 14 days before the date the monitoring is to be undertaken.

4.3.4 The Environment Agency shall be notified within 14 days of the occurrence of the following matters, except where such disclosure is prohibited by Stock Exchange rules:

Where the operator is a registered company:

- (a) any change in the operator's trading name, registered name or registered office address; and
- (b) any steps taken with a view to the operator going into administration, entering into a company voluntary arrangement or being wound up.

Where the operator is a corporate body other than a registered company:

- (a) any change in the operator's name or address; and
- (b) any steps taken with a view to the dissolution of the operator.

In any other case:

- (a) the death of any of the named operators (where the operator consists of more than one named individual);
- (b) any change in the operator's name(s) or address(es); and
- (c) any steps taken with a view to the operator, or any one of them, going into bankruptcy, entering into a composition or arrangement with creditors, or, in the case of them being in a partnership, dissolving the partnership.

4.3.5 Where the operator proposes to make a change in the nature or functioning, or an extension of the activities, which may have consequences for the environment and the change is not otherwise the subject of an application for approval under the Regulations or this permit:

- (a) the Environment Agency shall be notified at least 14 days before making the change; and
- (b) the notification shall contain a description of the proposed change in operation.

4.3.6 The Environment Agency shall be given at least 14 days' notice before implementation of any part of the site closure plan.

4.3.7 Where the operator has entered into a climate change agreement with the Government, the Environment Agency shall be notified within one month of:

- (a) a decision by the Secretary of State not to re-certify the agreement;
- (b) a decision by either the operator or the Secretary of State to terminate the agreement; and
- (c) any subsequent decision by the Secretary of State to re-certify such an agreement.

## **4.4 Interpretation**

4.4.1 In this permit the expressions listed in schedule 6 shall have the meaning given in that schedule.

4.4.2 In this permit references to reports and notifications mean written reports and notifications, except where reference is made to notification being made “immediately, in which case it may be provided by telephone.

# Schedule 1 – Operations

<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 market milk, cream, liquid skimmed milk, skimmed milk concentrate, soft cheese, mascarpone, Crème Fraiche, sour cream, Greek style yoghurt, buttermilk, condensed milk, chocolate crumb, and caramelised crumb.  Production capacity is limited to 548 tonnes per day.
AR2	Section 5.4 Part A1 (a) (i)	Biological treatment of non-hazardous waste water.	From generation of waste water to discharge to river Foulness following treatment in the ETP consisting of equalisation, physical separation, aerobic and anaerobic treatment, nitrification and denitrification, filtration, coagulation, and flocculation.
<b>Directly Associated Activity</b>			
AR3	Steam supply	Medium Combustion plants: 2 x 9.2MWth Boilers Dual fuel fired: natural gas and light fuel oil.	From receipt of fuel to release of products of combustion to air.
AR4	Raw material storage and handling	Storage and handling of raw materials at the installation	From receipt of raw materials to dispatch of final product.
AR5	Use of refrigerants	Use of refrigerants in cooling, chilling and/or freezing systems at the installation.	From receipt of raw materials to dispatch of final product.
AR6	Storage and use of chemicals and oils	Storage and use of chemicals and oils at the installation.	From receipt of chemicals and oils to disposal of wastes arising.
AR7	Waste storage and handling	Storage and handling of waste materials	From generation of waste to storage pending removal for disposal or recovery.
AR8	Process cooling waters	Operation of two cooling towers	From operation of cooling towers, including chemical dosing.

<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>
AR9	Surface water drainage	Collection of uncontaminated site surface waters	Handling and storage of site drainage until discharge to the site surface water system leading to the foul sewer.
AR10	Vehicles fuelling and washing	Refuelling of vehicles with diesel fuel. Washing of vehicles.	Refuelling point and vehicle washing area only.
AR11	Cleaning and maintenance	CIP cleaning systems and general maintenance.	Cleaning activities during/after production runs, including disposal of waste arising.

<b>Table S1.2 Operating techniques</b>		
<b>Description</b>	<b>Parts</b>	<b>Date Received</b>
Regulation 61 (1) Notice – Responses to questions dated 25/03/2022	All parts	Received 24/07/2022
Request for further information dates 02/10/2023	Information provided in relation to BATcs 1, 6(a), 9, 11, Boiler 3, cooling towers, updated site plan.	16/10/2023 20/10/2023

<b>Table S1.3 Improvement programme requirements</b>		
<b>Reference</b>	<b>Requirement</b>	<b>Date</b>
IC8	<p>The operator shall submit, for approval by Environment Agency, a report setting out progress to achieving the 'Narrative' BAT where BAT is currently not achieved but will be achieved before 4 December 2023. The report shall include, but not be limited to, the following:</p> <ol style="list-style-type: none"> <li>1) Methodology for achieving BAT</li> <li>2) Associated targets/timelines for reaching compliance by 4 December 2023.</li> </ol> <p>The report shall address the BAT Conclusions for Food, Drink and Milk Industries with respect to BAT 4 and 6.</p> <p>Refer to BAT Conclusions for a full description of the BAT requirement.</p>	04/12/2023
IC9	<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"> <li>• Where practicable, retro filling systems containing high GWP refrigerants e.g., R-404A with lower GWP alternatives as soon as possible.</li> </ul>	04/12/2023

<b>Table S1.3 Improvement programme requirements</b>		
<b>Reference</b>	<b>Requirement</b>	<b>Date</b>
	<ul style="list-style-type: none"> <li>An action log with timescales, for replacement of end-of-life equipment using refrigerants with the lowest practicable GWP.</li> </ul>	
IC10	<p>The operator shall submit, for approval by the Environment Agency, a report demonstrating achievement of the Best Available Techniques Conclusion Associated Emission Levels (BAT-AELs) where BAT is currently not achieved but will be achieved before 4 December 2023.</p> <p>The report shall include, but not be limited to, the following:</p> <p>Methodology applied for reaching the BAT-AELs.</p> <p>Performance against the BAT-AELs.</p> <p>The report shall address the BAT Conclusions for Food, Drink and Milk industries with respect to the following:</p> <ul style="list-style-type: none"> <li>BAT 12 Table 1 (compliance with BAT-AELs for direct discharges to a receiving water body).</li> </ul> <p>Refer to BAT Conclusions for a full description of the BAT requirement.</p>	04/12/2023
IC11	<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> <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>	12 months from permit issue or other date as agreed in writing with the Environment Agency.
IC12	<p>The Operator shall undertake a survey of the primary, secondary and tertiary containment and review measures against relevant standard including:</p> <ul style="list-style-type: none"> <li>CIRIA Containment systems for the prevention of pollution (C736) – Secondary, tertiary and other measures for industrial and commercial premises,</li> <li>EEMUA 159 - Above ground flat bottomed storage tanks</li> </ul> <p>The operator shall submit a written report to the Environment Agency approval which outlines the results of the survey and the review of standard and provide details of</p> <ul style="list-style-type: none"> <li>current containment measures</li> <li>any deficiencies identified in comparison to relevant standards,</li> <li>improvements proposed</li> <li>time scale for implementation of improvements.</li> </ul> <p>The operator shall implement the proposed improvements in line with the timescales agreed by the Environment Agency.</p>	12 months from permit issue or other date as 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
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## Schedule 3 – Emissions and monitoring

Emission point ref. & location	Source	Parameter	Limit (including unit)	Reference period	Monitoring frequency	Monitoring standard or method
A1 [Point A1 on site plan in Schedule 7]	Boiler Plant 9.2MWth Natural gas and light fuel oil [Note 1]	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
		Carbon monoxide	No Limit	Periodic	Every three years	MCERTS BS EN15058
A2 [Point A2 on site plan in Schedule 7]	Boiler Plant 9.2MWth Natural gas light fuel oil [Note 1]	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
		Carbon monoxide	No Limit	Periodic	Every three years	MCERTS BS EN15058
A5 [Point A5 on site plan in Schedule 7]	Chocolate crumb and lactose milling via bag filter	No parameters set	No limit set	--	--	

Note 1: This emission limit and/or monitoring requirement applies from 01 January 2025, unless otherwise advised by the Environment Agency.

Emission point ref. & location	Source	Parameter	Limit (incl. unit)	Reference Period	Monitoring frequency	Monitoring standard or method
W1 on site plan in schedule 7 emission to River Foulness	Effluent treatment plant	Hourly volume discharge	60m <sup>3</sup> /day	Hourly	Continuous	MCERTS self-monitoring of effluent flow scheme
		Total daily volume of discharge	1140 m <sup>3</sup> /day	24-hour total	Continuous	
		Biological Oxygen Demand (BOD)	40mg/l	Average	Monthly	EN 1899-1
		Chemical Oxygen Demand (COD) [Note1]	125 mg/l [Note 2]	24-hour flow proportional sample	Daily [Note 3]	[Note 5]
		Total suspended solids (TSS)	60mg/l [Note 4]	24-hour flow	Daily [Note 3]	ISO 11929:1997 EN872

<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>
			50 mg/l [Note 2]	proportional sample		BS EN 872
		Total Nitrogen (TN)	20 mg/l [Note 2]	24-hour flow proportional sample	Daily [Note 3]	EN 12260, EN ISO 11905-1.
		Ammoniacal nitrogen	6.0 mg/l	Daily flow proportional composite	Daily	BS 6068: Section 2.11:1987
		Total Phosphorus (TP)	4.0 mg/l [Note 2]	24-hour flow proportional sample	Daily [Note 3]	EN ISO 6878, EN ISO 15681-1 and -2, ENISO 11885.
		pH	6 – 8.5	Daily flow proportional composite	Daily	BS6068-2.50
W2 to W8 on site plan in schedule 7 emission to municipal drainage system leading to River Foulness	Uncontaminated surface water from water run-off from blue surface water/storm water drains	No parameters set	No limit set	--	--	--
<p>Note 1: TOC and COD are alternatives. TOC is the preferred option because it does not rely upon the use of very toxic chemicals.</p> <p>Note 2: Emission limits and monitoring requirement applies from 04/12/2023.</p> <p>Note 3: if the emission levels are proven to be sufficiently stable, a lower monitoring frequency can be adopted, but in any case at least every month.</p> <p>Note 4: Emission limit and monitoring requirement applies until 04/12/2023.</p> <p>Note 5: Monitoring standard to be agreed in writing with the Environment Agency</p>						

## Schedule 4 – Reporting

Parameter	Emission or monitoring point/reference	Reporting period	Period begins
Point source emissions to air Parameters as required by condition 3.5.1	A1 and 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
Point source emissions to water (other than sewer) Parameters as required by condition 3.5.1	W1	Quarterly	1 January, 1 April, 1 July & 1 October

Parameter	Units
Market milk produced.	tonnes
Cream despatched	tonnes
Skimmed milk	tonnes
Skimmed milk concentrate	tonnes
Soft cheese	tonnes
Mascarpone	tonnes
Crème Fraiche	tonnes
Greek style yogurt	tonnes
Buttermilk	tonnes
Condensed milk	tonnes
Chocolate crumb	tonnes
Caramelised crumb	tonnes

Parameter	Frequency of assessment	Units
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

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

<b>Table S4.4 Reporting forms</b>		
<b>Parameter</b>	<b>Reporting form</b>	<b>Form version number and date</b>
Point source emissions to air	Emissions to Air Reporting Form, or other form as agreed in writing by the Environment Agency	Version 1, 08/03/2021
Point source emissions to water (other than sewer)	Emissions to Water Reporting Form, or other form as agreed in writing by the Environment Agency	Version 1, 08/03/2021
Water usage	Water Usage Reporting Form, or other form as agreed in writing by the Environment Agency	Version 1, 08/03/2021
Energy usage	Energy Usage Reporting Form, or other form as agreed in writing by the Environment Agency	Version 1, 08/03/2021
Food Waste	Food waste Reporting Form, or other form as agreed in writing by the Environment Agency	Version 1 06/02/2023
Other performance parameters	Other Performance Parameters Reporting Form, or other form as agreed in writing by the Environment Agency	Version 1, 08/03/2021

# Schedule 5 – Notification

These pages outline the information that the operator must provide.

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

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

## Part A

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

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

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

<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.

“emissions to land” includes emissions to groundwater.

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

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

“Food waste” reporting: Reporting of food waste to use a methodology such as the global Food Loss and Waste Accounting and Reporting Standard (FLW standard) , WRAP’s Target Measure Act initiative or similar.

“groundwater” means all water, which is below the surface of the ground in the saturation zone and in direct contact with the ground or subsoil.

“Industrial Emissions Directive” means DIRECTIVE 2010/75/EU OF THE EUROPEAN PARLIAMENT AND OF THE COUNCIL of 24 November 2010 on industrial emissions, as read in accordance with Schedule 1A to the Environmental Permitting (England and Wales) Regulations 2016.

“MCERTS” means the Environment Agency’s Monitoring Certification Scheme.

“Medium Combustion Plant” or “MCP” means a combustion plant with a rated thermal input equal to or greater than 1 MW but less than 50 MW. An “existing medium combustion plant” is combustion plant operating before 20 December 2018.

“Medium Combustion Plant Directive” or “MCPD” means Directive 2015/2193/EU of the European Parliament and of the Council on the limitation of emissions of certain pollutants into the air from medium combustion plants, as read in accordance with Schedule 1A to the Environmental Permitting (England and Wales) Regulations 2016.

Pests” means Birds, Vermin and Insects.

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

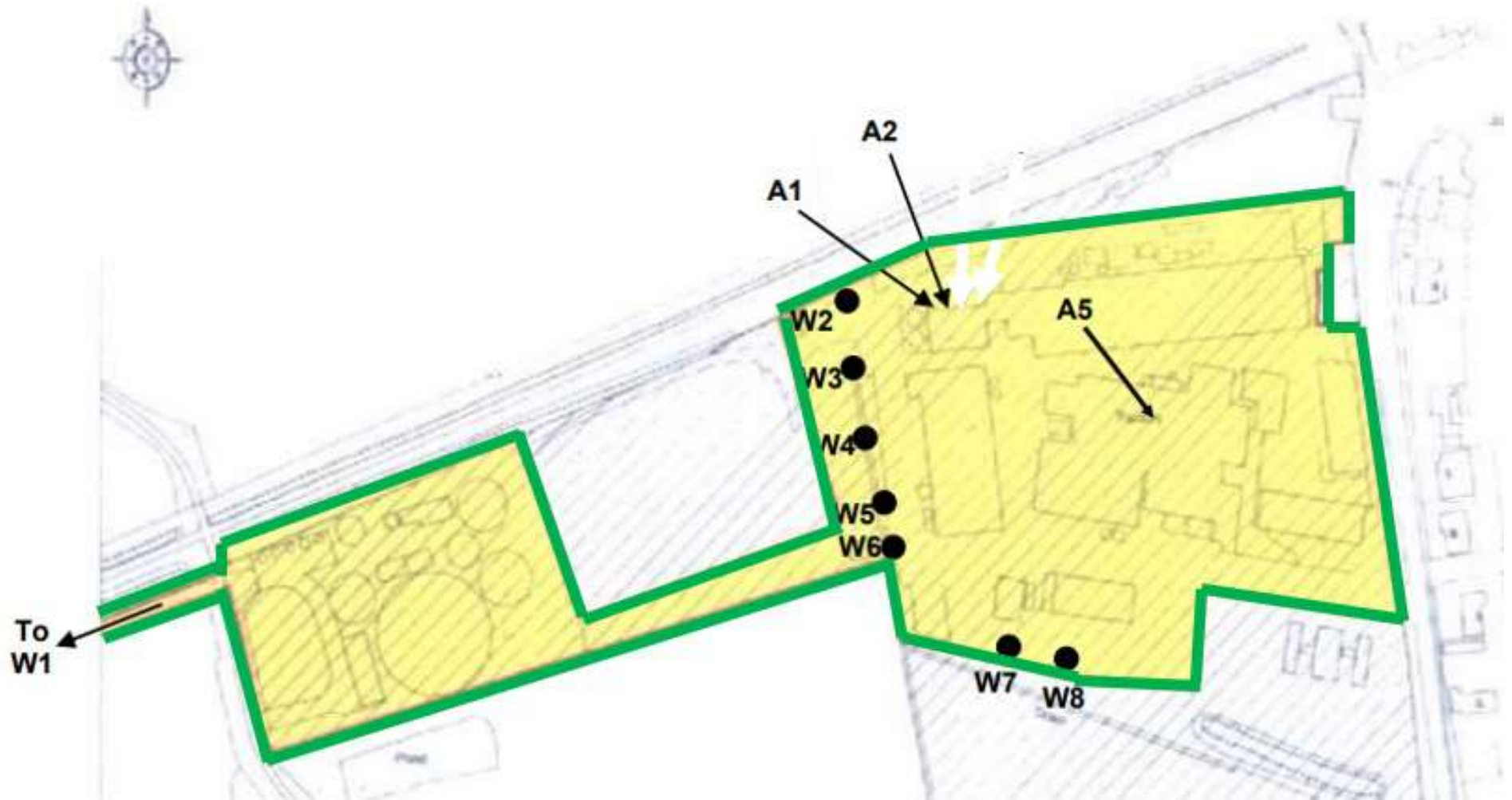
Unless otherwise stated, any references in this permit to concentrations of substances in emissions into air means:

- in relation to emissions from combustion processes, the concentration in dry air at a temperature of 273K, at a pressure of 101.3 kPa and with an oxygen content of 3% dry for liquid and gaseous fuels other than gas engines or gas turbines, 6% dry for solid fuels; and/or
- in relation to emissions from gas engines or gas turbines, the concentration in dry air at a temperature of 273K, at a pressure of 101.3 kPa and with an oxygen content of 15% dry for liquid and gaseous fuels ; and/or

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

“year” means calendar year ending 31 December.

# Schedule 7 – Site plan



END OF PERMIT