

Notice of variation and consolidation with introductory note

The Environmental Permitting (England & Wales) Regulations 2016

Refresco Beverages UK Limited

Express Park Facility
Bristol Road
Bridgwater
Somerset
TA6 4RN

Variation application number

EPR/RP3430BH/V008

Permit number

EPR/RP3430BH

Express Park Facility

Permit number EPR/RP3430BH

Introductory note

This introductory note does not form a part of the notice

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

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

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

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

The schedules specify the changes made to the permit.

The main features of the permit are as follows.

The Express Park facility is situated circa 2km north of the centre of the town of Bridgwater, Somerset, and can be located at National Grid Reference ST 30630 39550. The site is bounded to the west by the River Parrett, and to the east by the A38 trunk road occupying an area of approximately 15 hectares.

The installation will have an installed capacity to produce approximately 3,582 tonnes per day, operating under the following EPR sections:

Section 6.8 Part A(1) (d) (ii) – Treatment and processing, other than exclusively packaging, of the following raw materials, whether previously processed or unprocessed, intended for the production of food or feed (where the weight of the finished product excludes packaging - only vegetable raw materials with a finished product production capacity greater than 300 tonnes per day or 600 tonnes per day where the installation operates for a period of no more than 90 consecutive days in any year;

Section 6.8 A (1) (d)(iii) (aa) – Animal and vegetable raw materials (other than milk only), both in combined and separate products, with a finished product production capacity in tonnes per day greater than— 75 if A is equal to 10 or more.

Section 5.4 Part A1 (a) (ii) – Disposal of non-hazardous waste with a capacity exceeding 50 tonnes per day (or 100 tonnes per day if the only waste treatment activity is anaerobic digestion) involving one or more of the following activities, and excluding activities covered by Council Directive 91/271/EEC concerning urban waste-water treatment – physico-chemical treatment.

The manufacturing process for the juice is based on three primary concentrate flavours, orange, apple and cranberry. The process includes the addition of liquid sugar and glucose to produce juice drinks from the primary flavours. Concentrate and sugars are tankered to the site, and the contents are then pumped into bulk storage tanks. Minor ingredients and other concentrates (e.g. grapefruit, tomato, etc.) contained in drums are stored in a chilled room prior to use. When required the ingredients are either drawn from the bulk tanks or called off from stores and decanted into the mixing tank. The incoming mains water is passed through a carbon filter to remove chlorine, UV sterilised and then is mixed with the other ingredients. The low acid beverages are milk based and are mixed with cream and powdered flavourings to produce the final product.

The site operates an effluent treatment plant (ETP) consisting of neutralisation and primary physical separation. The treated process effluent is discharged under consent to Wessex Sewage Treatment Works for further processing. Uncontaminated runoff water from roofs and yards is discharged to the on-site pond.

For the production of steam, the site operates three Boilers of 17.2 MWth combined input, fired on natural gas. For abnormal operation conditions such as emergencies, the Operator uses gas oil.

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 RP3430BH received (EPR/RP3430BH/A001)	30/09/2004	Application received for the production of soft drinks.
Additional information received	04/01/2005	--
Permit determined	01/06/2005	Permit issued to Gerber Foods Soft Drinks Ltd.
Operator name change	28/06/2006	Name change without registration number or registered address change.
Variation Application EPR/RP3430BH/V002	30/09/2008	Includes of the phase 3 and 4 expansion program and production increased from 600 to 1200 million litres.
Variation determined EPR/RP3430BH/V002	27/02/2009	Varied permit issued.
Variation Application EPR/RP3430BH/V003	Duly made 17/04/2012	A new sugar silo and mixing tank are introduced along with associated equipment.
Schedule 5 response	22/05/2012	Noise management and bag filters characteristics
Variation determined EPR/RP3430BH/V003	24/05/2023	Varied permit issued.
Agency variation determined EPR/RP3430BH/V004	21/02/2014	Agency variation to implement the changes introduced by IED
Variation Application (combined normal and administrative) EPR/RP3430BH/V005	30/04/2015	Normal variation to include nitrogen gas tank and administrative variation to change company name, and correct errors in previous permit and also to update PI's.
Variation determined EPR/RP3430BH/V005	13/05/2015	Varied permit issued.
Variation Application EPR/RP3430BH/V006	Duly made 04/11/2015	Application to add two CO2 tanks, add three spring water tanks and extend the site's permitted boundary.
Variation determined EPR/RP3430BH/V006	03/12/2015	Varied permit issued.
Variation Application EPR/RP3430BH/V007 (variation and consolidation)	Duly made 11/04/2017	Application to add a line to produce low acid beverages that falls under Section 6.8 Part A(1)(d)(iii)(aa) of the EPR regulations 2016, and update the permit to modern conditions.
Schedule 5 response	24/04/2017 28/04/2017 08/05/2017	BAT assessment, operating procedures, IMS manual. Confirmation of permit consolidation. Further BAT assessment.
Schedule 5 response	18/05/2017 14/07/2017 16/08/2017 20/12/2023	Tanker unloading procedure. Underground tank responsibilities. Trade effluent consent. Containment

Status log of the permit		
Description	Date	Comments
Variation determined EPR/RP3430BH/V007	06/09/2017	Varied and consolidated permit issued in modern condition format.
Application EPR/RP3430BH/V008 (variation and consolidation)	Regulation 61 Notice response received 01/10/2021	Environment Agency initiated variation and consolidation following the Food, Drink & Milk Industries sector permit review.
Additional information received (dated 20/10/2023)	04/12/2023	Noise assessment, chemical register, updated Reg.61 Response, site drains, energy monitoring, removing of air emission points A4, A20, A21, A45, A54, A62, A81, A82, A83, A84, A85, and A97.
	05/12/2023	Spill control
	08/12/2023	Verbal confirmation of details regarding BATcs 5, 9, 11, discharge pond, boilers emergency fuel.
	15/12/2023	Ventilation Plant Report.
	20/12/2023	Containment, air emissions, ETP, site plan.
Variation determined and consolidation issued EPR/RP3430BH (Billing ref. KP3806MG).	23/02/2024	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/RP3430BH

Issued to

Refresco Beverages UK Limited (“the operator”)

whose registered office is

Citrus Grove Side Ley

Kegworth

Derby

England

DE74 2FJ

company registration number 00161079

to operate a regulated facility at

Express Park Facility

Bristol Road

Bridgwater

Somerset

TA6 4RN

to the extent set out in the schedules.

The notice shall take effect from 23/02/2024.

Name	Date
Marcus Woodward	23/02/2024

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/RP3430BH

This is the consolidated permit referred to in the variation and consolidation notice for application EPR/RP3430BH/V008 authorising,

Refresco Beverages UK Limited (“the operator”),

whose registered office is

Citrus Grove Side Ley

Kegworth

Derby

England

DE74 2FJ

company registration number 00161079

to operate an installation at

Express Park Facility

Bristol Road

Bridgwater

Somerset

TA6 4RN

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

Name	Date
Marcus Woodward	23/02/2024

Authorised on behalf of the Environment Agency

Conditions

1 Management

1.1 General management

1.1.1 The operator shall manage and operate the activities:

- (a) in accordance with a written management system that identifies and minimises risks of pollution, including those arising from operations, maintenance, accidents, incidents, non-conformances, closure and those drawn to the attention of the operator as a result of complaints; and
- (b) using sufficient competent persons and resources.

1.1.2 Records demonstrating compliance with condition 1.1.1 shall be maintained.

1.1.3 Any person having duties that are or may be affected by the matters set out in this permit shall have convenient access to a copy of it kept at or near the place where those duties are carried out.

1.2 Energy efficiency

1.2.1 The operator shall:

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

1.3 Efficient use of raw materials

1.3.1 The operator shall:

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

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

1.4.1 The operator shall take appropriate measures to ensure that:

- (a) the waste hierarchy referred to in Article 4 of the Waste Framework Directive is applied to the generation of waste by the activities; and
- (b) any waste generated by the activities is treated in accordance with the waste hierarchy referred to in Article 4 of the Waste Framework Directive; and
- (c) where disposal is necessary, this is undertaken in a manner which minimises its impact on the environment.

- 1.4.2 The operator shall review and record at least every four years whether changes to those measures should be made and take any further appropriate measures identified by a review.

2 Operations

2.1 Permitted activities

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

2.2 The site

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

2.3 Operating techniques

- 2.3.1 The activities shall, subject to the conditions of this permit, be operated using the techniques and in the manner described in the documentation specified in schedule 1, table S1.2, unless otherwise agreed in writing by the Environment Agency.
- 2.3.2 If notified by the Environment Agency that the activities are giving rise to pollution, the operator shall submit to the Environment Agency for approval within the period specified, a revision of any plan or other documentation (“plan”) specified in schedule 1, table S1.2 or otherwise required under this permit which identifies and minimises the risks of pollution relevant to that plan, and shall implement the approved revised plan in place of the original from the date of approval, unless otherwise agreed in writing by the Environment Agency.
- 2.3.3 Any raw materials or fuels listed in schedule 2 table S2.1 shall conform to the specifications set out in that table.
- 2.3.4 The operator shall ensure that where waste produced by the activities is sent to a relevant waste operation, that operation is provided with the following information, prior to the receipt of the waste:
- (a) the nature of the process producing the waste;
 - (b) the composition of the waste;
 - (c) the handling requirements of the waste;
 - (d) the hazardous property associated with the waste, if applicable; and
 - (e) the waste code of the waste.
- 2.3.5 The operator shall ensure that where waste produced by the activities is sent to a landfill site, it meets the waste acceptance criteria for that landfill.

2.4 Improvement programme

- 2.4.1 The operator shall complete the improvements specified in schedule 1 table S1.3 by the date specified in that table unless otherwise agreed in writing by the Environment Agency.
- 2.4.2 Except in the case of an improvement which consists only of a submission to the Environment Agency, the operator shall notify the Environment Agency within 14 days of completion of each improvement.

3 Emissions and monitoring

3.1 Emissions to water, air or land

- 3.1.1 There shall be no point source emissions to water, air or land except from the sources and emission points listed in schedule 3 tables S3.1, S3.2 and S3.3.
- 3.1.2 The limits given in schedule 3 shall not be exceeded.
- 3.1.3 Periodic monitoring shall be carried out at least once every 5 years for groundwater and 10 years for soil, unless such monitoring is based on a systematic appraisal of the risk of contamination.
- 3.1.4 For the following activities referenced in schedule 1, table S1.1 (AR3 – Boilers 1, 2, and 3) 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, 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 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

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 A(1) (d) (ii)	Treating and processing for the production of food from only vegetable raw materials with a finished product production capacity greater than 300 tonnes per day.	From receipt of raw materials to dispatch of finished products of carbonated and flavoured drinks. Production capacity is limited to 3,582 tonnes per day.
AR2	Section 6.8 Part A(1) (d)(iii) (aa)	Treatment and processing, other than exclusively packaging, of the following raw materials, whether previously processed or unprocessed, intended for the production of food or feed (where the weight of the finished product excludes packaging) – animal and vegetable raw materials (other than milk only), both in combined and separate products, with a finished product production capacity in tonnes per day greater than—75 tonnes.	From receipt of raw milk delivered to the site to the dispatch of processed packaged milk. Production capacity is limited to 76 tonnes per day.
AR3	Section 5.4 Part A1 (a) (ii)	Physico-chemical Treatment of non-hazardous waste waters by pH adjustment.	From generation of wastewater to discharge to Wessex Water sewer following on-site ETP treatment consisting of neutralisation and primary physical separation.
Directly Associated Activity			
AR4	Steam supply	Medium Combustion plants: Boiler 1: 5.6 MWth Boiler 2: 5.6 MWth Boiler 3: 6.0 MWth Natural gas fired	From receipt of fuel to release of products of combustion to air. Boilers 1, 2, and 3 permitted to burn gas-oil for up to 500 hours per year in case of emergency or maintenance only.
AR5	Raw material storage and handling	Storage and handling of raw materials at the installation	From receipt of raw materials to dispatch of final product.
AR6	Use of refrigerants	Use of refrigerants including ammonia in cooling, chilling	From receipt of raw materials to dispatch of final product.

Table S1.1 activities			
Activity reference	Activity listed in Schedule 1 of the EP Regulations	Description of specified activity	Limits of specified activity
		and/or freezing systems at the installation.	
AR7	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.
AR8	Waste storage and handling	Storage and handling of waste materials	From generation of waste to storage pending removal for disposal or recovery.
AR9	Surface water drainage	Collection of uncontaminated site surface waters	Handling and storage of site drainage until discharge to the balancing pond, leading to River Parrett.
AR10	Nitrogen storage	The supply of nitrogen gas and liquid nitrogen	Use of nitrogen gas and liquid nitrogen to fill head space in bottle to pressurise bottles.
AR11	Carbon dioxide storage	The supply of carbon dioxide gas	Use of carbon dioxide to produce carbonated drinks.

Table S1.2 Operating techniques		
Description	Parts	Date Received
Application RP3430BH (EPR/RP3430BH/A001)	The response to questions 2.1 and 2.2 in the application.	11/11/2004
Schedule 4 notice dated 30/11/04	The response given in sections 3, 4 and 5 of the response to the schedule 4 notice.	04/01/2005
Variation EPR/RP3430BH/V002	Parts C2.1 and C2.2.	30/09/2008
Variation EPR/RP3430BH/V003	Form C3 and response to question 3d) plus report REF01 and duly making responses	Duly made 17/04/2012
Schedule 5 response related to fugitive management, noise abatement and particulate atmospheric abatement.	All	22/05/2012
Variation EPR/RP3430BH/V006	Form C3, supporting documents	04/11/2015
Additional information request	Accident and Environment Risk Assessment Operating techniques	04/11/2015
Variation EPR/RP3430BH/V007	Energy Management, Ref. REFUK_C3(6)_Energy Management – Oct 2016 Raw Materials, Ref. REFUK_C3(6d)_Raw Materials – Oct 2016 Waste Management, Ref. REFUK_C3(6e)_Waste Management – Oct 2016	02/11/2016

Table S1.2 Operating techniques		
Description	Parts	Date Received
Not Duly Made Response	Odour and Noise Management, Ref. REFUK_Add_Odour & Noise Management - Feb 2017	17/02/2017
Schedule 5 Notice response	Environmental Non-Conformance, Ref. EVP-0403 – March 2017 Emergency Plan, Ref. EVP-0406 – March 2017 Spill Control, Ref. EVW-0001 – March 2017 Receipt of Bulk Tankers on Site, Ref. GHW-0030 – March 2017 Integrated Systems Manual, Ref. QGQ-0001, May 2016	24/04/2017
Email correspondence	Containment Systems – S3A, S6 & S7, Ref. EVP-0085 – August 2017	05/09/2017
Regulation 61 (1) Notice – Responses to questions dated 22/06/2021	All parts	Received 01/10/2021
Request for further information dates 20/10/2023	Noise assessment, chemical register, updated Reg.61 Response, site drains, energy monitoring.	04/12/2023
	Spill control	05/12/2023
	Verbal confirmation of details regarding BATcs 5, 9, 11, discharge pond, boilers emergency fuel.	08/12/2023
	Ventilation Plant Report	15/12/2023
	Containment and air emissions	20/12/2023

Table S1.3 Improvement programme requirements		
Reference	Requirement	Date
IC26	The operator shall confirm, achievement of the 'Narrative' BAT conclusions as identified in the Food, Drink and Milk Bref published on 4 December 2019 where BAT is currently not demonstrated or achieved with respect to BATc 6. Refer to BAT Conclusions for a full description of the BAT requirement.	3 months from permit issue
IC27	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. To demonstrate compliance against BAT 9, the operator shall produce a plan for the onsite refrigerant system(s) at the installation. The plan is to be assessed by the Environment Agency and shall be incorporated within the existing environmental management system. The plan should include, but not be limited to, the following: <ul style="list-style-type: none"> Where practicable, retro filling systems containing high GWP refrigerants e.g. R-404A with lower GWP alternatives as soon as possible. An action log with timescales, for replacement of end-of-life equipment using refrigerants with the lowest practicable GWP. 	3 months from permit issue
IC28	The Operator shall produce a Site Condition Report (SCR) in line with our H5 Guidance. The report shall contain the information necessary to determine the state of soil and groundwater and	12 months from permit issue

Table S1.3 Improvement programme requirements		
Reference	Requirement	Date
	ensure this is maintained throughout the life of the permit by using the results to better inform the SPMP. The report shall be submitted to the Environment Agency for review.	
IC29	<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"> • Details of how the installation has or could be affected by severe weather; • The scale of the impact of severe weather on the operations within the installation; • An action plan and timetable for any improvements to be made to minimise the impact of severe weather at the installation. <p>The Operator shall implement any necessary improvements to a timetable agreed in writing with the Environment Agency.</p>	12 months from permit issue or other date as agreed in writing with the Environment Agency
IC30	<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
IC31	The operator shall update the site closure plan when phases 3 and 4 are completed.	12 months following completion of phase(s) or as agreed
IC32	The operator shall review the accident management plan for the site when phases 3 and 4 are completed.	3 months following completion of phase(s) or as agreed
IC33	The operator shall update the SPMP (Site protection and monitoring programme) when phase 3 and 4 are completed.	12 months following completion of

Table S1.3 Improvement programme requirements		
Reference	Requirement	Date
		phase(s) or as agreed
IC34	The operator shall inform the Environment agency in writing confirming the completion dates of phase 3 and phase 4 developments.	1 month following completion of phase(s)

Schedule 2 – Waste types, raw materials and fuels

Table S2.1 Raw materials and fuels	
Raw materials and fuel description	Specification
Gas oil	Less than 0.1 % sulphur content.

Schedule 3 – Emissions and monitoring

Table S3.1 Point source emissions to air – emission limits and monitoring requirements						
Emission point ref. & location	Source	Parameter	Limit (including unit)	Reference period	Monitoring frequency	Monitoring standard or method
A1 [Point A1 on site plan in Schedule 7]	Boiler Plant 5.6 MWth Natural gas	Oxides of Nitrogen (NO and NO ₂ expressed as NO ₂)	140 mg/m ³	Periodic	Every three years	BS EN 14792
		Carbon monoxide (CO)	100 mg/m ³	Periodic	Every three years	MCERTS BS EN15058
		Sulphur dioxide (SO ₂)	35 mg/m ³	Periodic	Annually	TGN M21
		Particulate matter (PM)	5 mg/m ³	Average over sampling period	Annually	BS EN 13284-1
A1 [Point A1 on site plan in Schedule 7]	Boiler Plant 5.6 MWth Gas oil	No parameters set	No limit set	-	-	-
A2 [Point A2 on site plan in Schedule 7]	Boiler Plant 5.6 MWth Natural gas	Oxides of Nitrogen (NO and NO ₂ expressed as NO ₂)	140 mg/m ³	Periodic	Every three years	BS EN 14792
		Carbon monoxide (CO)	100 mg/m ³	Periodic	Every three years	MCERTS BS EN15058
		Sulphur dioxide (SO ₂)	35 mg/m ³	Periodic	Annually	TGN M21
		Particulate matter (PM)	5 mg/m ³	Average over sampling period	Annually	BS EN 13284-1
A3 [Point A3 on site plan in Schedule 7]	Boiler Plant 6.0 MWth Natural gas	Oxides of Nitrogen (NO and NO ₂ expressed as NO ₂)	140 mg/m ³	Periodic	Every three years	BS EN 14792
		Carbon monoxide (CO)	100 mg/m ³	Periodic	Every three years	MCERTS BS EN15058
		Sulphur dioxide (SO ₂)	35 mg/m ³	Periodic	Annually	TGN M21
		Particulate matter (PM)	5 mg/m ³	Average over sampling period	Annually	BS EN 13284-1
A5, A14, A15, A18, A19, A27,	Various air handling units (AHU)	No parameter set	No limit set	--	--	--

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
A46, A50, A51, A52, A55, A108, A109, A110 [Points shown on site plan in Schedule 7]	for facility areas, production, and storage.					
A6 to A13, A22 to A25, A29 to A33, A38, A39, A41 to A44, A49, A53, A66 to A68, A74, A91 to A93, A96, A98 [Points shown on site plan in Schedule 7]	Various process and storage vents	No parameter set	No limit set	--	--	--
A16, A17, A28, A47, A48, A61, A63, A64, A78, A79, A86, A99 [Points shown on site plan in Schedule 7]	Various process and storage exhausts	No parameter set	No limit set	--	--	--
A26 [Point A26 on site plan in Schedule 7]	Standby generator vent	Combustion gases	No limit set	--	--	--
A34 to A37, A69, A70, A71, A75, A77, A87, A94, A95, A100 to A107 [Points A34 to A37 on site plan in Schedule 7]	Various process and storage hydrogen peroxide vents	Hydrogen peroxide (H ₂ O ₂)	No limit set	--	--	--
A56 to A60, A65, A88 to A90 [Points shown on site plan in Schedule 7]	Various process and storage emergency or intermittent emission points	No parameter set	No limit set	--	--	--

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
W2A, W2C, W2D, W2E, W3, W4, SW5, W6, W7 [Points on site plan in schedule 7] emission to onsite pond leading to River Parrett	Uncontaminated surface runoff	No parameter set	No limit set	--	--	--
W2A, W2B, W2E, W3, W4, W5, W6, W7 [Points on site plan in schedule 7] emission to onsite pond leading to River Parrett	Uncontaminated surface runoff	No visible oil or grease	No limit set	--	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 Wessex 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	A1, A2, A3 MCPs	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

Table S4.2: Annual production/treatment	
Parameter	Units
Juice based beverages	hectolitres
Low acid based beverages	hectolitres
Wastewater treated	tonnes
Other non-specified beverages	hectolitres

Table S4.3 Performance parameters		
Parameter	Frequency of assessment	Units
Water usage	Annually	m ³
Energy usage	Annually	MWh
Waste – recovery/disposal routes	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
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.

“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.

