



# Notice of variation and consolidation with introductory note

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

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H J Heinz Manufacturing UK Limited

Kitt Green Manufacturing Site

Walthew House Lane

Kitt Green

Wigan

Lancashire

WN5 0JL

### **Variation application number**

EPR/BL8392IX/V007

### **Permit number**

EPR/BL8392IX

# Kitt Green Manufacturing Site

## Permit number EPR/BL8392IX

### 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 also implemented the requirements of the relevant BAT Conclusions from the Large Combustion Plant BAT reference document (BREF).

The schedules specify the changes made to the permit.

H J Heinz Manufacturing UK Limited is a heat preserved food manufacturer and canner. The Kitt Green site is located in a suburb of the town of Wigan in Greater Manchester at National Grid Reference (NGR) SD 54730 06330. The factory was opened in 1959 and comprises both the food manufacturing activity and associated can making and boiler plant. The manufacturing site is one of the largest food production sites in Europe, with an approximate finished production capacity of 3,199 tonnes per day.

The food manufacturing activity is divided, for management purposes into four manufacturing cost centres- beans, soups, pasta and variants. The manufacturing centres all follow a similar process in that they receive pre prepared ingredients, blend in batch processes and pre-cook to 90 degrees Celsius (°C). The product is then filled into cans and sterilised at an average of 125°C, then cooled to 40°C using a re-circulatory cooling system. The cans are then labelled, packaged and moved to storage for distribution. The effluents arising from the plant are treated on-site prior to discharge to United Utilities Wigan waste water treatment works (WWTW), with final discharge to the River Douglas. The other significant impact of this activity is the production of waste for disposal.

The can-making centre supports the manufacturing, producing and distributing of steel cans, over 1 billion per annum. The cans are formed from flat tin-coated sheets and pre formed ends. A proportion of the cans produced have an internal lacquer coating; these are produced from a pre lacquered steel sheet, but require repair over the welded side seam once formed. This repair is called 'side striping' and is undertaken by one of two methods. The majority, approximately 90%, will utilise a powder side stripe with the remaining 10% using a liquid lacquer. This lacquer is sprayed on and force dried through a gas fired oven. This process is the source of emissions of volatile organic compounds (VOCs). This process must meet the requirements of the Industrial Emissions Directive if the annual solvent usage exceeds the threshold of five tonnes. The powder side stripe will meet the Best Available Techniques as defined in 'Surface Treatment using Organic Solvents including Wood and Wood Products Preservation with Chemicals' BREF Document 2020.

The boiler plant supports the manufacturing by providing steam and consists of four steam raising boilers, each rated at 24 megawatt (MW), fired on natural gas. The permitted backup fuel is gas oil, or another equivalent substitute fuel to be agreed in writing with the Environment Agency. The four boilers exhaust either through a condensing economiser or through individual flues. All flues are contained within one windshield 51 metres high. As the boilers' aggregated thermal input of the shared windshield is above 50 MW, the site is classed as operating Large Combustion Plant (LCP) as defined by articles 28 and 29 of the Industrial Emissions Directive (IED). The DEFRA LCP reference number is LCP 174.

Effluent is treated by passing through a 'Fats, Oils & Greases' (FOG) separator followed by a 1.5mm screen to remove gross solids and then by a Dissolved Air Flotation (DAF) unit and ancillary equipment after the screening plant. The unit is capable of treating between 60% and 100% of the daily flow rate from the process. The screenings are either macerated and sent off-site for bio-processing, or sent off-site for composting. DAF sludge is tankered off-site for bio-processing. A coagulant (liquid lime), and a polymer, are added to the effluent stream to manage suspended solids, oils and greases.

The water is then discharged to public sewer for treatment at a municipal WWTW (Wigan WWTW at Hoscar Moss).

The site operates an environmental management system which is certified to the ISO 14001 standard.

There are no European habitat sites within 10 km of the installation.

The schedules specify the changes made to the permit.

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 EPR/BL8392IX/A001 received	20/09/2004	Application duly made
Permit EPR/BL8392IX determined	20/01/2005	Permit issued
Variation application EPR/XP3031UU received	07/08/2007	
Further information received electronically assessing the impact of particulate releases to air	25/09/2007	No previous assessment of particulates had been made for the canning line
Variation EPR/XP3031UU determined	30/10/2007	Variation issued
Variation application EPR/HP3130GQ received	05/08/2008	Variation to remove emission points A1 to A4 and introduce requirements of the Sulphur Content of Liquid Fuels Regulations, the Large Combustion Plant Directive and Solvent Emissions Directive
Variation EPR/XP3031GQ determined	01/09/2008	Variation issued
Agency variation determined EPR/BL8392IX/V004	07/01/2014	Agency variation to implement the changes introduced by the Industrial Emissions Directive (IED)
Regulation 60 Notice sent to the Operator	31/10/2015	Issue of a Notice under Regulation 60(1) of the EPR. Environment Agency Initiated review and variation to vary the permit under IED to implement the special provisions for LCP under Chapter III, introducing new Emission Limit Values (ELVs) applicable to LCP, referred to in Article 30(2) and set out in Annex V. The permit is also updated to modern conditions
Regulation 60 Notice response	27/03/2015	Response received from the Operator
Additional information received	10/06/2015	Response to request for further information (RFI) dated 19/05/2015
Variation determined EPR/BL8392IX/V005	22/12/2015	Varied and consolidated permit issued in modern condition format. Variation effective from 01/01/2016
Enhanced pre-application advice provided EPR/BL8392IX/V006	29/07/2021	Pre-application review of Environmental Impact Assessment ahead of planned variation

<b>Status log of the permit</b>		
<b>Description</b>	<b>Date</b>	<b>Comments</b>
Application EPR/BL8392IX/V007 (variation and consolidation)	Regulation 61 Notice response received 09/10/2022	Environment Agency initiated variation and consolidation following the Food, Drink & Milk Industries sector permit review. Change of registered company address
Enhanced pre-application advice provided EPR/BL8392IX/P001	09/04/2024	Pre-application advice provided regarding a variation application to replace the existing process hot water plant with heat pump technology
Additional information received	15/04/2024	Response to RFI including updated Environmental Management System certificate, finished daily production capacity, confirmation of registered office address, industrial heating oil technical specification sheet and percentage net efficiency of LCP (regarding LCP BATc 40)
Variation determined and consolidation issued EPR/BL8392IX	05/06/2024	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/BL8392IX

#### Issued to

**H J Heinz Manufacturing UK Limited** (“the operator”)

whose registered office is

**The Shard**  
**32 London Bridge Street**  
**London**  
**SE1 9SG**

company registration number 00147624

to operate a regulated facility at

**Kitt Green Manufacturing Site**  
**Walthew House Lane**  
**Kitt Green**  
**Wigan**  
**Lancashire**  
**WN5 0JL**

to the extent set out in the schedules.

The notice shall take effect from 05/06/2024.

Name	Date
Sandra Cavill	05/06/2024

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/BL8392IX**

This is the consolidated permit referred to in the variation and consolidation notice for application EPR/BL8392IX/V007 authorising,

**H J Heinz Manufacturing UK Limited** (“the operator”),

whose registered office is

**The Shard**  
**32 London Bridge Street**  
**London**  
**SE1 9SG**

company registration number 00147624

to operate an installation at

**Kitt Green Manufacturing Site**  
**Walthew House Lane**  
**Kitt Green**  
**Wigan**  
**Lancashire**  
**WN5 0JL**

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

Name	Date
Sandra Cavill	05/06/2024

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) take appropriate measures to ensure the efficiency of energy generation at the permitted installation is maximised;
- (c) review and record at least every four years whether there are suitable opportunities to improve the energy efficiency of the activities; and
- (d) 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 For the following activities referenced in schedule 1, table S1.1: LCP174. Without prejudice to condition 2.3.1, the activities shall be operated in accordance with the “Electricity Supply Industry IED Compliance Protocol for Utility Boilers and Gas Turbines” dated May 2021 or any later version unless otherwise agreed in writing by the Environment Agency.
- 2.3.3 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.
- 2.3.4 Any raw materials or fuels listed in schedule 2 table S2.1 shall conform to the specifications set out in that table.
- 2.3.5 For the following activities referenced in schedule 1, table S1.1: LCP 174. Standby fuel (gas oil or other equivalent substitute to be agreed in writing with the Environment Agency) may be used for periods of up to 10 days during times of interruption to the gas supply.
- 2.3.6 For the following activities referenced in schedule 1, table S1.1: LCP 174. The end of the start up period and the start of the shutdown period shall conform to the specifications set out in Schedule 1, tables S1.2 and S1.5.
- 2.3.7 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.
- 2.3.8 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.

## 2.5 Pre-operational conditions

- 2.5.1 The operations specified in schedule 1 table S1.4 shall not commence until the measures specified in that table have been completed.

## 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 S3.1A, S3.1B, S3.2 and S3.3.
- 3.1.2 The limits given in schedule 3 shall not be exceeded.
- 3.1.3 Periodic monitoring shall be carried out at least once every 5 years for groundwater and 10 years for soil, unless such monitoring is based on a systematic appraisal of the risk of contamination.

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

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

### 3.3 Odour

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

- (b) implement the approved odour management plan, from the date of approval, unless otherwise agreed in writing by the Environment Agency.

### 3.4 Noise and vibration

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

### 3.5 Monitoring

- 3.5.1 The operator shall, unless otherwise agreed in writing by the Environment Agency, undertake the monitoring specified in the following tables in schedule 3 to this permit:
  - (a) point source emissions specified in tables S3.1A, S3.1B, S3.2 and S3.3; and
  - (b) process monitoring specified in table S3.4.
- 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 S3.1A, S3.1B, S3.2 and S3.3 unless otherwise agreed in writing by the Environment Agency.

### 3.6 Monitoring for Large Combustion Plant

- 3.6.1 All monitoring required by this permit shall be carried out in accordance with the provisions of Annex V of the Industrial Emissions Directive.
- 3.6.2 If the monitoring results for more than 10 days a year are invalidated within the meaning set out in condition 3.6.7, the operator shall:
  - (a) within 28 days of becoming aware of this fact, review the causes of the invalidations and submit to the Environment Agency for approval, proposals for measures to improve the reliability of the continuous measurement systems, including a timetable for the implementation of those measures; and
  - (b) implement the approved proposals.
- 3.6.3 Continuous measurement systems on emission points from the LCP shall be subject to quality control by means of parallel measurements with reference methods at least once every calendar year.

- 3.6.4 Unless otherwise agreed in writing by the Environment Agency in accordance with condition 3.6.5 below, the operator shall carry out the methods, including the reference measurement methods, to use and calibrate continuous measurement systems in accordance with the appropriate CEN standards.
- 3.6.5 If CEN standards are not available, ISO standards, national or international standards which will ensure the provision of data of an equivalent scientific quality shall be used, as agreed in writing with the Environment Agency.
- 3.6.6 Where required by a condition of this permit to check the measurement equipment, the operator shall submit a report to the Environment Agency in writing, within 28 days of the completion of the check.
- 3.6.7 Where Continuous Emission Monitors are installed to comply with the monitoring requirements in schedule 3, table S3.1A; the Continuous Emission Monitors shall be used such that:
- a) for the continuous measurement systems fitted to the LCP release points defined in Table S3.1A the validated hourly, monthly and daily averages shall be determined from the measured valid hourly average values after having subtracted the value of the 95% confidence interval;
  - b) the 95% confidence interval for nitrogen oxides and sulphur dioxide of a single measured result shall be taken to be 20%;
  - c) the 95% confidence interval for dust releases of a single measured result shall be taken to be 30%;
  - d) the 95% confidence interval for carbon monoxide releases of a single measured result shall be taken to be 10%;
  - e) an invalid hourly average means an hourly average period invalidated due to malfunction of, or maintenance work being carried out on, the continuous measurement system. However, to allow some discretion for zero and span gas checking, or cleaning (by flushing), an hourly average period will count as valid as long as data has been accumulated for at least two thirds of the period (40 minutes). Such discretionary periods are not to exceed more than 5 in any one 24-hour period unless agreed in writing. Where plant may be operating for less than the 24-hour period, such discretionary periods are not to exceed more than one quarter of the overall valid hourly average periods unless agreed in writing; and
  - f) any day, in which more than three hourly average values are invalid shall be invalidated.

### **3.7 Pests**

- 3.7.1 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.
- 3.7.2 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 S4.3A and S4.3B 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.

4.2.5 The operator shall submit an annual solvent management plan in order to demonstrate compliance with the requirements of the Industrial Emissions Directive, by 31 January each year in respect of the previous year.

## 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.
- 4.3.8 The operator shall inform the Environment Agency in writing of the closure of any LCP within 28 days of the date of closure.

## **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 A(1)(d)(ii)	Treating and processing materials intended for the production of food products from vegetable raw materials at plant with a finished product production capacity of more than 300 tonnes per day	From receipt of ingredients delivered to the site to the despatch of beans, soups, pasta and other food products  Production capacity is limited to 3,199 tonnes per day
AR2	Section 1.1 Part A(1)(a)	Burning any fuel in an appliance with a rated thermal input of 50 megawatts or more. <b>LCP 174:</b> Boilers for production of steam	From receipt of fuel to release of products of combustion to air, wastes, and the generation of steam
AR3	Section 6.4 Part B(a)(iv)	A manufacturing process which involves the use of more than 5 tonnes of organic solvent in any 12 month reporting period. Forming and welding of un-made cans, lacquering of some of the welded seams and product code printing	Can making facility and product coding
AR4	Section 5.4 Part A(1)(a)(ii)	Disposal of non-hazardous waste in a facility with a capacity exceeding 50 tonnes per day by physico-chemical treatment	From generation of waste water from on-site processes, to treatment by screening, dissolved air flotation and the addition of a coagulant and polymer; prior to discharge to the foul to sewer
<b>Directly Associated Activity</b>			
AR5	Fuel storage	Storage of gas oil (or other equivalent substitute to be agreed in writing with the Environment Agency)	From receipt of raw materials to despatch for use
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	Use of refrigerants	Use of refrigerants in cooling and chilling systems at the installation	From receipt of raw materials to despatch of final product
AR8	Water treatment	Boiler water treatment plant	From receipt of raw materials to despatch to effluent treatment system



<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	Raw material storage and handling	Storage and handling of raw materials at the installation	From receipt of raw materials to despatch of final product
AR10	Waste storage and handling	Storage and handling of waste materials	From generation of waste to storage pending removal for disposal or recover
AR11	Surface water drainage	Collection of uncontaminated site surface waters	Handling and storage of site drainage until discharge to the site surface water system

<b>Table S1.2 Operating techniques</b>		
<b>Description</b>	<b>Parts</b>	<b>Date Received</b>
Permit Application EPR/BL8392IX/A001	The response to questions 2.1 and 2.2 given in pages 9-46 of the main permit application	20/09/2004
Variation Application EPR/XP3031UU	Filter bag failure detection given in page 8 and Appendix 5 of the variation application (XP3031UU) boiler house operation given in pages 11 to 12 of the variation application (XP3031UU)	07/08/2007
Variation Application HP3130GQ	Document reference PPCVAR 2 (non-technical Summary)	05/08/2008
Response to regulation 60(1) Notice – request for information dated 31/10/2014	Compliance route and operating techniques identified in response to questions 2 (compliance route), 4 (configuration), 5 net rated thermal input), 6 (minimum start up load and minimum shut down load), 9 (ELVs), 10 (monitoring derogation) and 11 (monitoring requirements)	Received 27/03/2015
Receipt of additional information to the regulation 60(1) Notice. requested by letter dated 19/05/2015	Operating techniques identified in response to questions 4 (configuration), 5 (net rated thermal input), 6 (minimum start up load and minimum shut down load) and 9 (ELVs)	Received 10/06/2015
Regulation 61 (1) Notice – Responses to questions dated DD/MM/YYYY	All parts	Received 09/10/2022
Regulation 61(1) Notice – request for further information dated 08/06/2022	Technical standards in relation to BAT as described in BAT conclusions under Directive 2010/75/EU of the European Parliament and of the council on establishing BAT conclusions for the food, drink and milk industries, BAT conclusion Numbers 1-17, and LCP BAT conclusions	Received 09/10/2022
Request for further information dated 20/03/2024	Updated Environmental Management System certificate, finished daily production capacity, confirmation of registered office address, industrial heating oil technical specification sheet and percentage net efficiency of LCP (regarding LCP BAT conclusion 40)	15/04/2024

<b>Table S1.3 Improvement programme requirements</b>		
<b>Reference</b>	<b>Requirement</b>	<b>Date</b>
IC7	The operator shall submit, for approval by the Environment Agency, an energy efficiency plan. This shall address the BAT Conclusions for Food, Drink and Milk Industries with respect to BAT 6, to demonstrate compliance for the 'Narrative' BAT previously not achieved.	3 months from permit issue or as agreed in writing with the Environment Agency
IC8	<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 systems 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> <li>• An action log with timescales, for replacement of end-of-life equipment using refrigerants with the lowest practicable GWP.</li> </ul>	3 months from permit issue or as agreed in writing with the Environment Agency
IC9	The operator shall review and update the H1 risk assessment for particulate emissions to air at the capacity levels stated within table S1.1 of this permit. The H1 shall be submitted to the Environment Agency for review.	3 months from permit issue or as agreed in writing with the Environment Agency
IC10	<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 as agreed in writing with the Environment Agency
IC11	<p>The Operator shall undertake a survey of the primary, secondary and tertiary containment at the site and review measures against relevant standard including:</p> <ul style="list-style-type: none"> <li>• CIRIA Containment systems for the prevention of pollution (C736) – Secondary, tertiary and other measures for industrial and commercial premises,</li> <li>• EEMUA 159 - Above ground flat bottomed storage tanks</li> </ul> <p>The operator shall submit a written report to the Environment Agency approval which outlines the results of the survey and the review of standard and provide details of</p> <ul style="list-style-type: none"> <li>• current containment measures</li> <li>• any deficiencies identified in comparison to relevant standards,</li> <li>• improvements proposed</li> <li>• time scale for implementation of improvements.</li> </ul> <p>The operator shall implement the proposed improvements in line with the timescales agreed by the Environment Agency.</p>	12 months from permit issue or as agreed in writing with the Environment Agency

<b>Table S1.4 Pre-operational measures</b>	
<b>Reference</b>	<b>Pre-operational measures</b>
PO1	At least 2 weeks before operation of the effluent treatment plant (capable of treating all process effluent), the Operator shall submit a report demonstrating that the necessary procedures are in place for the operation and maintenance of the equipment and that staff have received the necessary training. Written agreement shall be received from the Environment Agency prior to operation of the effluent treatment plant.

<b>Table S1.5 Start-up and Shut-down thresholds</b>		
<b>Emission Point and Unit Reference</b>	<b>“Minimum start up load” Load in MW and as percent of rated thermal output (%)</b>	<b>“Minimum shut-down load” Load in MW and as percent of rated thermal output (%)</b>
A20, A21, A22, A23 and A24	4.4 MW; 4.9% (corresponding to one boiler on minimum firing rate)	4.4 MW; 4.9% (corresponding to one boiler on minimum firing rate)
LCP174		

## Schedule 2 – Raw materials and fuels

<b>Table S2.1 Raw materials and fuels</b>	
<b>Raw materials and fuel description</b>	<b>Specification</b>
Gas oil or equivalent substitute to be agreed in writing with the Environment Agency	Not exceeding 0.1% w/w sulphur content

## Schedule 3 – Emissions and monitoring

Emission point ref. & location <sup>[Note 1]</sup>	Parameter	Source	Limit (including unit)-these limits do not apply during start up or shut down	Reference period	Monitoring frequency	Monitoring standard or method
A20, A21, A22, A23 and A24	Oxides of Nitrogen (NO and NO <sub>2</sub> expressed as NO <sub>2</sub> )	LCP 174 Boiler plant fired on natural gas	100 mg/m <sup>3</sup> <sup>[Note 2]</sup>	Yearly average	Continuous	BS EN 14181
			100 mg/m <sup>3</sup> <sup>[Note 2]</sup>	Monthly mean of validated hourly averages		
			100 mg/m <sup>3</sup> <sup>[Note 2]</sup>	Daily mean of validated hourly averages		
			200 mg/m <sup>3</sup> <sup>[Note 2]</sup>	95% of validated hourly averages within a calendar year		
A20, A21, A22, A23 and A24	Carbon Monoxide	LCP 174 Boiler plant fired on natural gas	40 mg/m <sup>3</sup> <sup>[Note 2]</sup>	Yearly average	Continuous	BS EN 14181
			100 mg/m <sup>3</sup> <sup>[Note 2]</sup>	Monthly mean of validated hourly averages		
			100 mg/m <sup>3</sup> <sup>[Note 2]</sup>	Daily mean of validated hourly averages		
			100 mg/m <sup>3</sup> <sup>[Note 2]</sup>	95% of validated hourly averages within a calendar year		

<b>Table S3.1A Point source emissions to air from gas boilers – LCP 174</b>						
<b>Emission point ref. &amp; location</b> <sup>[Note 1]</sup>	<b>Parameter</b>	<b>Source</b>	<b>Limit (including unit)-these limits do not apply during start up or shut down</b>	<b>Reference period</b>	<b>Monitoring frequency</b>	<b>Monitoring standard or method</b>
A20, A21, A22, A23 and A24	Sulphur dioxide	LCP 174 Boiler plant fired on natural gas	35 mg/m <sup>3</sup> <sup>[Note 2]</sup>	-	At least every 6 months	Concentration by calculation as agreed in writing with the Environment Agency
A20, A21, A22, A23 and A24	Particulate matter	LCP 174 Boiler plant fired on natural gas	5 mg/m <sup>3</sup> <sup>[Note 2]</sup>	-	At least every 6 months	Concentration by calculation as agreed in writing with the Environment Agency
A20, A21, A22, A23 and A24	Stack gas temperature	LCP 174 Boiler plant fired on natural gas	-	-	Continuous As appropriate to reference	Traceable to national standards
A20, A21, A22, A23 and A24	Stack gas pressure	LCP 174 Boiler plant fired on natural gas	-	-	Continuous As appropriate to reference	Traceable to national standards
A20, A21, A22, A23 and A24	Oxygen	LCP 174 Boiler plant fired on natural gas	-	-	Periodic As appropriate to reference	BS EN 14789
A20, A21, A22, A23 and A24	Water Vapour	LCP 174 Boiler plant fired on natural gas	-	-	Periodic As appropriate to reference	BS EN 14790
A20, A21, A22, A23 and A24	As required by the Method Implementation Document for BS EN 15259	LCP No. 174 Boiler plant fired on natural gas	-	-	Pre-operation and when there is a significant operational change	BS EN 15259

<b>Table S3.1A Point source emissions to air from gas boilers – LCP 174</b>						
<b>Emission point ref. &amp; location</b> <sup>[Note 1]</sup>	<b>Parameter</b>	<b>Source</b>	<b>Limit (including unit)-these limits do not apply during start up or shut down</b>	<b>Reference period</b>	<b>Monitoring frequency</b>	<b>Monitoring standard or method</b>
A20, A21, A22, A23 and A24	Oxides of Nitrogen (NO and NO <sub>2</sub> expressed as NO <sub>2</sub> )	LCP 174 Boiler plant fired on gas oil or equivalent substitute to be agreed in writing with the Environment Agency	-	-	Concentration by calculation every 4380 operational hours or 2 years whichever is sooner	Agreed in writing with the Environment Agency
A20, A21, A22, A23 and A24	Carbon Monoxide		-	-	Concentration by calculation every 4380 operational hours or 2 years whichever is sooner	Agreed in writing with the Environment Agency
A20, A21, A22, A23 and A24	Sulphur dioxide		-	-	Concentration by calculation every 4380 operational hours or 2 years whichever is sooner	Agreed in writing with the Environment Agency
A20, A21, A22, A23 and A24	Particulate matter				Concentration by calculation every 4380 operational hours or 2 years whichever is sooner	Agreed in writing with the Environment Agency
<p>Note 1: As shown on site plan in Schedule 7</p> <p>Note 2: The limit does not apply when standby fuels are used under condition 2.3.5</p>						

<b>Table S3.1B Point source emissions to air from non-LCP plant</b>						
<b>Emission point ref. &amp; location</b> <small>[Note 1]</small>	<b>Parameter</b>	<b>Source</b>	<b>Limit (including unit)</b>	<b>Reference period</b>	<b>Monitoring frequency</b>	<b>Monitoring standard or method</b>
A5	Total VOC (as carbon)	Can making Line-Lacquer Spray LEV	100 mg/m <sup>3</sup> <small>[Note 2]</small>	2 hour monitoring period	<small>[Note 3]</small>	BS EN 13526
	Total Class B VOC (as carbon)	Line No 2	2 kg/hr <small>[Note 4]</small>	2 hour monitoring period	<small>[Note 3]</small>	BS EN 13526
	Fugitive emission value		25% of solvent input <small>[Note 2]</small>	-	Annually	Calculation
	Particulate		5mg/m <sup>3</sup>	1 hour monitoring period	<small>[Note 3]</small>	BS EN 13284
A6	Total VOC (as carbon)	Can making Line-Lacquer Drying Oven LEV	100 mg/m <sup>3</sup> <small>[Note 2]</small>	2 hour monitoring period	<small>[Note 3]</small>	BS EN 13526
	Total Class B VOC (as carbon)	Line No 2	2 kg/hr <small>[Note 4]</small>	2 hour monitoring period	<small>[Note 3]</small>	BS EN 13526
	Fugitive emission value		25% of solvent input <small>[Note 2]</small>	-	Annually	Calculation
	Particulate		5mg/m <sup>3</sup>	1 hour monitoring period	<small>[Note 3]</small>	BS EN 13284
A7	Total VOC (as carbon)	Can making Line-Lacquer Spray LEV Line No 4	100 mg/m <sup>3</sup> <small>[Note 2]</small>	2 hour monitoring period	<small>[Note 3]</small>	BS EN 13526
	Total Class B VOC (as carbon)		2 kg/hr <small>[Note 4]</small>	2 hour monitoring period	<small>[Note 3]</small>	BS EN 13526
	Fugitive emission value		25% of solvent input <small>[Note 2]</small>	-	Annually	Calculation
	Particulate		5mg/m <sup>3</sup>	1 hour monitoring period	<small>[Note 3]</small>	BS EN 13284



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A8	Total VOC (as carbon)	Can making Line-Lacquer Drying Oven LEV Line No 4	100 mg/m <sup>3</sup> [Note 2]	2 hour monitoring period	[Note 3]	BS EN 13526
	Total Class B VOC (as carbon)		2 kg/hr [Note 4]	2 hour monitoring period	[Note 3]	BS EN 13526
	Fugitive emission value		25% of solvent input [Note 2]	-	Annually	Calculation
	Particulate		5mg/m <sup>3</sup>	1 hour monitoring period	[Note 3]	BS EN 13284
A9	Total VOC (as carbon)	Can making Line-Lacquer Spray LEV Line No 8	100 mg/m <sup>3</sup> [Note 2]	2 hour monitoring period	[Note 3]	BS EN 13526
	Total Class B VOC (as carbon)		2 kg/hr [Note 4]	2 hour monitoring period	[Note 3]	BS EN 13526
	Fugitive emission value		25% of solvent input [Note 2]	-	Annually	Calculation
	Particulate		5mg/m <sup>3</sup>	1 hour monitoring period	[Note 3]	BS EN 13284
A10	Total VOC (as carbon)	Can making Line-Lacquer Drying Oven LEV Line No 8	100 mg/m <sup>3</sup> [Note 2]	2 hour monitoring period	[Note 3]	BS EN 13526
	Total Class B VOC (as carbon)		2 kg/hr [Note 4]	2 hour monitoring period	[Note 3]	BS EN 13526
	Fugitive emission value		25% of solvent input [Note 2]	-	Annually	Calculation
	Particulate		5mg/m <sup>3</sup>	1 hour monitoring period	[Note 3]	BS EN 13284
A11	Total VOC (as carbon)		100 mg/m <sup>3</sup> [Note 2]	2 hour monitoring period	[Note 3]	BS EN 13526

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	Total Class B VOC (as carbon)	Can making Line-Lacquer Spray LEV Line No 9	2 kg/hr [Note 4]	2 hour monitoring period	[Note 3]	BS EN 13526
	Fugitive emission value		25% of solvent input [Note 2]	-	Annually	Calculation
	Particulate		5mg/m <sup>3</sup>	1 hour monitoring period	[Note 3]	BS EN 13284
A12	Total VOC (as carbon)	Can making Line-Lacquer Drying Oven LEV Line No 9	100 mg/m <sup>3</sup> [Note 2]	2 hour monitoring period	[Note 3]	BS EN 13526
	Total Class B VOC (as carbon)		2 kg/hr [Note 4]	2 hour monitoring period	[Note 3]	BS EN 13526
	Fugitive emission value		25% of solvent input [Note 2]	-	Annually	Calculation
	Particulate		5mg/m <sup>3</sup>	1 hour monitoring period	[Note 3]	BS EN 13284
A13 (includes release points A13, A13a to A13b)	Particulate	Powder handling-main production building	No limit set	-	-	-
A14 (includes release points A14, A14a to A14d)			No limit set	-	-	-
A15 (includes release points A15, A15a to A15g)			No limit set	-	-	-
A16 (includes release points A16, A16a to A16g)	Particulate	Dust extraction-south wall of main production building	No limit set	-	-	-
A17 (includes release points A17, A17a to A17b)	Particulate	Powder handling and dust extraction-warehouse 1	No limit set	-	-	-

A18	Particulate	Powder handling internal pasta	No limit set	-	-	-
A19 (includes release points A19, A19a to A19c and A19f)	Particulate	Powder handling building (internal)	No limit set	-	-	-
A25	Particulate	Powder handling-silo room	No limit set	-	-	-
A26	Particulate		No limit set	-	-	-

Note 1: As shown on site plan in Schedule 7

Note 2: Limit applies if solvent usage is greater than 5 tonnes per annum but less than 15 tonnes. The 100 mg/m<sup>3</sup> limit is the average measured during the monitoring period

Note 3: One line (spray and oven LEV) to be monitored every six months

Note 4: Limit applies if solvent usage is less than 5 tonnes per annum

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

Emission point ref. & location	Parameter	Source	Limit (incl. unit)	Reference period	Monitoring frequency	Monitoring standard or method
W1 Described in application. Located at 354750E, 406760	No parameter set	Uncontaminated surface water draining to Ackhurst Brook	No limit set	--	--	--
W2 Described in application. Located at 354750E, 406760	No parameter set	Uncontaminated surface water draining to Ackhurst Brook	No limit set	--	--	--
W3 Described in application. Located at 354464E, 406656N	No parameter set	Uncontaminated surface water draining to Ackhurst Brook	No limit set	--	--	--

<b>Table S3.3 Point source emissions to sewer, effluent treatment plant or other transfers off-site– emission limits and monitoring requirements</b>						
<b>Emission point ref. &amp; location</b>	<b>Parameter</b>	<b>Source</b>	<b>Limit (incl. Unit)</b>	<b>Reference period</b>	<b>Monitoring frequency</b>	<b>Monitoring standard or method</b>
S1 [on Site Drainage Plan 37183] to foul sewer and Wigan waste water treatment works (WWTW)	No parameters Set	Treated process effluent from onsite effluent treatment plant	No limit set	--	--	--
S2 [on Site Drainage Plan 37183] to foul sewer and Wigan WWTW	No parameters Set	Treated process effluent from onsite effluent treatment plant	No limit set	--	--	--

<b>Table S3.4 Process monitoring requirements</b>				
<b>Emission point reference or source or description of point of measurement</b>	<b>Parameter</b>	<b>Monitoring frequency</b>	<b>Monitoring standard or method</b>	<b>Other specifications</b>
Particulate filters	Differential pressure	Weekly	Not applicable	--
Effluent treatment plant	Monitoring regime for the key process operating parameters	To be agreed with the Environment Agency	To be agreed with the Environment Agency	--

## Schedule 4 – Reporting

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

<b>Table S4.1 Reporting of monitoring data</b>			
<b>Parameter</b>	<b>Emission or monitoring point/reference</b>	<b>Reporting period</b>	<b>Period begins</b>
Oxides of nitrogen	A20, A21, A22, A23, A24	Every 3 months for continuous monitoring	1 January, 1 April, 1 July, 1 October
		Every 6 months for periodic monitoring	1 January, 1 July
		Every year where there is an annual average	1 January
		Every 2 years for concentration by calculation	1 January
Carbon Monoxide	A20, A21, A22, A23, A24	Every 3 months for continuous monitoring	1 January, 1 April, 1 July, 1 October
		Every 6 months for periodic monitoring	1 January, 1 July
		Every year where there is an annual average	1 January
		Every 2 years for concentration by calculation	1 January
Sulphur dioxide	A20, A21, A22, A23, A24	Every 6 months	1 January 1 July
Particulate matter	A20, A21, A22, A23, A24	Every 6 months	1 January 1 July
Total VOC as carbon	A5 to A12	Every 6 months	1 January 1 July
Fugitive emissions of solvent (SED)	Canning line	Annually	1 January
Particulate	A5 to A12	Every 6 months	1 January 1 July
Solvent usage	Permitted installation	Annually	1 January

<b>Table S4.1 Reporting of monitoring data</b>			
<b>Parameter</b>	<b>Emission or monitoring point/reference</b>	<b>Reporting period</b>	<b>Period begins</b>
Water usage	Permitted installation	Annually	1 January
Waste disposal and/or recovery	Permitted installation	Annually	1 January
Process monitoring requirements	As specified by Table S3.4	Annually	1 January unless otherwise specified

<b>Table S4.2 Annual production/treatment</b>	
<b>Parameter</b>	<b>Units</b>
Total finished product produced	tonnes
Heat exported from LCP	GWh

<b>Table S4.3A Large combustion plant performance parameters for reporting to DEFRA</b>		
<b>Parameter</b>	<b>Frequency of assessment</b>	<b>Units</b>
Thermal input capacity for each LCP	Annually	MW
Annual fuel usage for each LCP	Annually	TJ
Total emissions to air of NO <sub>x</sub> for each LCP	Annually	t
Total emissions to air of SO <sub>2</sub> for each LCP	Annually	t
Total emissions to air of dust for each LCP	Annually	t
Operating hours for each LCP (load factor)	Annually	hr
Operating hours for each LCP, using standby fuel during interruptions to the natural gas supply	Quarterly for each quarter the standby fuel is used.	hr

<b>Parameter</b>	<b>Frequency of assessment</b>	<b>Units</b>
Water usage	Annually	m <sup>3</sup>
Energy usage	Annually	MWh
Specific energy usage	Annually	MWh/tonne of finished product
Power generated	Annually	GWh
Waste	Annually	tonnes
COD loss efficiency	Annually*	COD te/te product
Food waste	Annually	tonnes

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

<b>Media/ parameter</b>	<b>Reporting format</b>	<b>Agency recipient</b>
<b>LCP</b>		
Air & Energy	Form IED AR1 – SO <sub>2</sub> , NO <sub>x</sub> and dust mass emission and energy Form as agreed in writing by the Environment Agency For all LCPs	National and Area Office
LCP	Form IED HR1 – operating hours Form as agreed in writing by the Environment Agency For all LCPs	National and Area Office
Air	Form IED CON 1 – continuous monitoring Form as agreed in writing by the Environment Agency CEMs reporting for all LCPs	Area Office
Air	Form IED PM1 – discontinuous monitoring and load Form as agreed in writing by the Environment Agency Only for sites with periodic monitoring requirements	Area Office

<b>Table S4.4 Reporting forms</b>		
<b>Media/ parameter</b>	<b>Reporting format</b>	<b>Agency recipient</b>
CEMs	Form IED CEM – Invalidation Log Form as agreed in writing by the Environment Agency Only for LCPs with CEMs	Area Office
LCP	Form IED HR2 – standby fuel operating hours Form as agreed in writing by the Environment Agency For all LCPs	Area Office
<b>OTHER</b>		
Air emissions	Emissions to Air Reporting Form, or other form as agreed in writing by the Environment Agency	Area Office
Air emissions	Form SC1-Solvent usage	Area Office
Water emissions	Water1 Reporting Form, or other form as agreed in writing by the Environment Agency	Area Office
Point source emissions to sewer	Emissions to Sewer Reporting Form, or other form as agreed in writing by the Environment Agency	Area Office
Water usage	Water Usage Reporting Form, or other form as agreed in writing by the Environment Agency	Area Office
Energy usage	Energy Usage Reporting Form, or other form as agreed in writing by the Environment Agency	Area Office
Food Waste	Food waste Reporting Form, or other form as agreed in writing by the Environment Agency	Area Office
Other performance indicators	Form performance 1 or other form as agreed in writing by the Environment Agency	Area Office



## 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.

“background concentration” means such concentration of that substance as is present in:

- for emissions to surface water, the surface water quality up-gradient of the site; or
- for emissions to sewer, the surface water quality up-gradient of the sewage treatment works discharge.

“base load” means: (i) as a mode of operation, operating for >4000hrs pa; and (ii) as a load, the maximum load under ISO conditions that can be sustained continuously, i.e. maximum continuous rating.

“calendar monthly mean” means the value across a calendar month of all validated hourly means.

“CEN” means Comité Européen de Normalisation.

“Combustion Technical Guidance Note” means IPPC Sector Guidance Note Combustion Activities, version 2.03 dated 27th July 2005 published by Environment Agency.

“disposal” means any of the operations provided for in Annex I to Directive 2008/98/EC of the European Parliament and of the Council on waste.

“DLN” means dry, low NO<sub>x</sub> burners.

“Energy efficiency” the annual net plant energy efficiency means the value calculated from the operational data collected over the year.

“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.

“hazardous property” has the meaning in Annex III of the Waste Framework Directive.

“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.

“large combustion plant” or “LCP” is a combustion plant or group of combustion plants discharging waste gases through a common windshield or stack, where the total thermal input is 50 MW or more, based on net calorific value. The calculation of thermal input, excludes individual combustion plants with a rated thermal input below 15MW.

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

“MCR” means maximum continuous rating.

“MSDL” means minimum shut-down load as defined in Implementing Decision 2012/249/EU.

“MSUL” means minimum start-up load as defined in Implementing Decision 2012/249/EU.

“Natural gas” means naturally occurring methane with no more than 20% by volume of inert or other constituents.

“ncv” means net calorific value.

“operational hours” are whole hours commencing from the first unit ending start up and ending when the last unit commences shut down.

Pests” means Birds, Vermin and Insects.

“quarter” means a calendar year quarter commencing on 1 January, 1 April, 1 July or 1 October.

“recovery” means any of the operations provided for in Annex II to Directive 2008/98/EC of the European Parliament and of the Council on waste.

“Standby fuel” means alternative liquid fuels that are used in emergency situations when the gas fuel which is normally used, is not available.

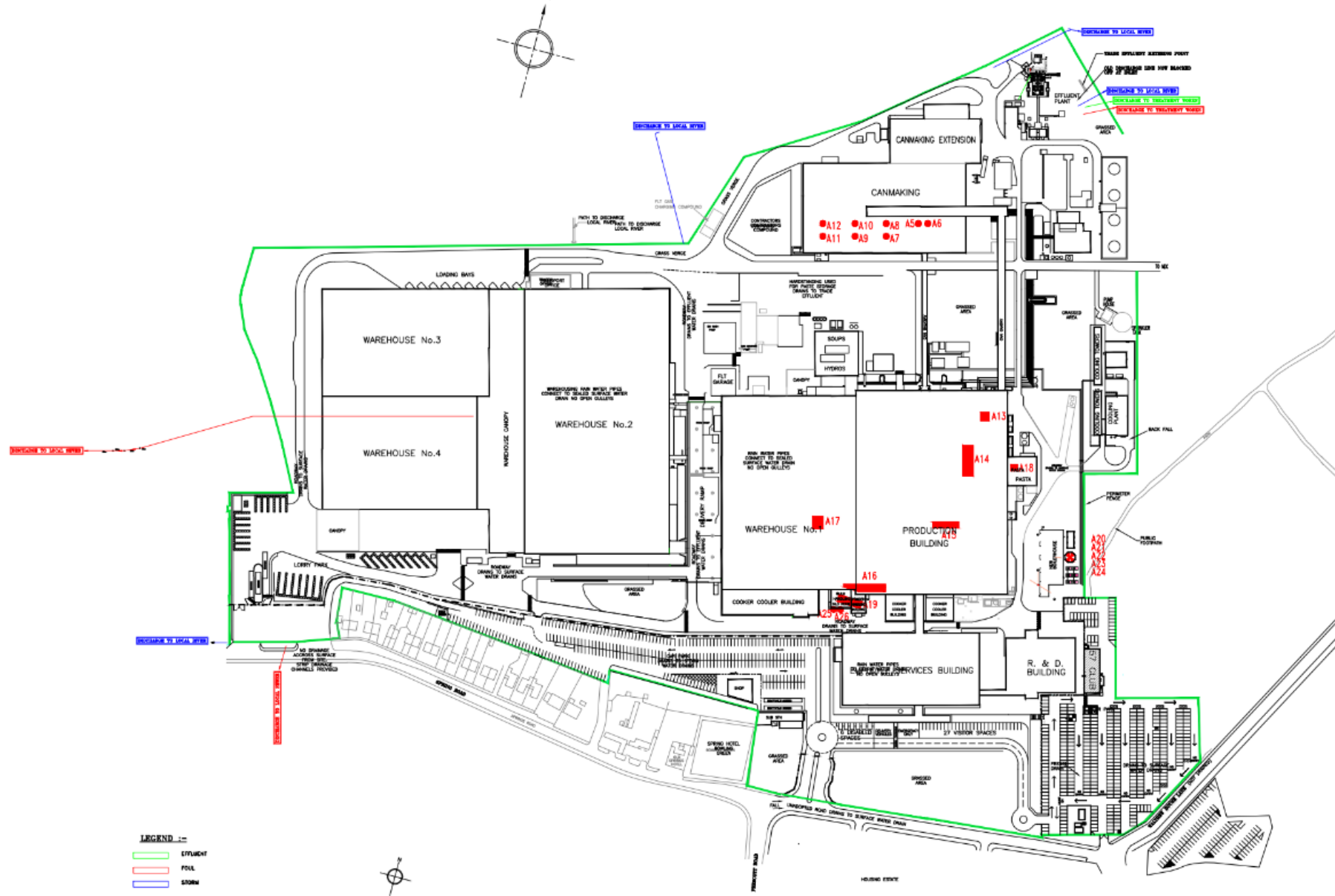
Where a minimum limit is set for any emission parameter, for example pH, reference to exceeding the limit shall mean that the parameter shall not be less than that limit.

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

- in relation to emissions from combustion processes, the concentration in dry air at a temperature of 273K, at a pressure of 101.3 kPa and with an oxygen content of 3% dry for liquid and gaseous fuels, 6% dry for solid fuels; and/or
- in relation to emissions from gas engines or gas turbines, the concentration in dry air at a temperature of 273K, at a pressure of 101.3 kPa and with an oxygen content of 15% dry for liquid and gaseous fuels ; and/or
- in relation to emissions from combustion processes comprising a gas turbine with a waste heat boiler, the concentration in dry air at a temperature of 273K, at a pressure of 101.3kPa and with an oxygen content of 15% dry, unless the waste heat boiler is operating alone, in which case, with an oxygen content of 3% 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



LEGEND – EMISSIONS TO AIR RELEASE POINTS

RELEASE POINTS

A1	BOILERS 1 AND 2 STACK DISCHARGE	} REDUNDANT	
A2	BOILERS 3 AND 4 STACK DISCHARGE		
A3	BOILER 5 STACK DISCHARGE		
A4	BOILER 6 STACK DISCHARGE		
A5	CANMAKING No 2 LINE LACQUER SPRAY LEV		
A6	CANMAKING No 2 LINE LACQUER DRYING OVEN LEV		
A7	CANMAKING No 4 LINE LACQUER SPRAY LEV		
A8	CANMAKING No 4 LINE LACQUER DRYING OVEN LEV		
A9	CANMAKING No 8 LINE LACQUER SPRAY LEV		
A10	CANMAKING No 8 LACQUER DRYING OVEN LEV		
A11	CANMAKING No 9 LINE LACQUER SPRAY LEV		
A12	CANMAKING No 9 LINE LACQUER DRYING OVEN LEV		
A13	2 OFF FILTER PROTECTED POWDER BLOWING DISCHARGE (ATMOSPHERIC)		
A13a	PUB 4 (PULSE BIN)		KSMFBPUB4
A13b	WARM MIX CENTRAL EXHAUST (DX25)		KSMFBDX25
A14	4 OFF FILTER PROTECTED POWDER BLOWING DISCHARGE (ATMOSPHERIC)		
A14a	BABYFOOD 1 RECEIVER HOPPER		KSMFBDX22
A14b	BABYFOOD 2 RECEIVER HOPPER		KSMFBDX23
A14c	NK3 (A) RECEIVER HOPPER		KSMFBDX26
A14d	NK3 (B) RECEIVER HOPPER		KSMFBDX27
A15	7 OFF FILTER PROTECTED POWDER BLOWING DISCHARGE (ATMOSPHERIC)		
A15a	BEANS RECEIVING HOPPER 42		KBMB4HO42
A15b	BEANS RECEIVING HOPPER 43		KBMB4HO43
A15c	BEANS RECEIVING HOPPER 44		KBMB4HO44
A15d	BEANS RECEIVING HOPPER 45		KBMB4HO45
A15e	PASTA RECEIVING HOPPER 1		
A15f	PASTA RECEIVING HOPPER 2		
A15g	PASTA RECEIVING HOPPER 3		
A16	7 OFF FILTER PROTECTED POWDER BLOWING DISCHARGE (ATMOSPHERIC)		
A16a	SACK SLITTER 1&2 (COMBINED DISCHARGE)		
A16b	BEAN CLASSIFIER DUST EXTRACTION 1		KBMB1DX01
A16c	BEAN CLASSIFIER DUST EXTRACTION 2		KBMB1DX02
A16d	BEAN CLASSIFIER DUST EXTRACTION 3		KBMR3DX12
A16e	BEAN A SIDE DUST EXTRACT (DE=BAGGING)		REDUNDANT
A16f	BEAN B SIDE DUST EXTRACT (DE=BAGGING)		
A16g	SACK SLITTER ROOM DUST EXTRACTION		
A17	4 OFF FILTER PROTECTED POWDER BLOWING DISCHARGE (ATMOSPHERIC)		
A17a	PULSE SORTING DUST EXTRACTION		KSMPSDX01

A17b	BI-VAC SYSTEM (PULSE WASTE)		NA
A18	4 OFF FILTER PROTECTED POWDER BLOWING DISCHARGE (INTERNAL)		
A19	22 OFF FILTER PROTECTED POWDER BLOWING DISCHARGE (INTERNAL)		
A19a	SOUPS BI-VAC SYSTEM		NA
A19b	SACK SLITTER 1 CLEANING TOWER		KSMPBDX01
A19c	SACK SLITTER 2 CLEANING TOWER		KSMPBDX03
A19d	BEANS SUGAR LE-COQ SIFTER FILTER	} REDUNDANT	KBMB4DF01
A19e	BEANS STARCH LE-COQ SIFTER FILTER		KBMB4DF02
A19f	WEIGHER (MIDDLE FLOOR DAY BIN)		KBMB4WE10
A20	CENTRE COMBINED STACK		
A21	BOILER 1 STACK		
A22	BOILER 2 STACK		
A23	BOILER 3 STACK		
A24	BOILER 4 STACK		
A25	1 OFF FILTERED + DUST DETECTION PROTECTED POWDER BLOWING DISCHARGE		
A26	1 OFF FILTERED + DUST DETECTION PROTECTED POWDER BLOWING DISCHARGE		

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