



# Notice of variation and consolidation with introductory note

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

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Cargill PLC  
Brocklebank Oilseed Processing Plant  
Regent Road  
Bootle  
Merseyside  
L20 8DF

### **Variation application number**

EPR/BN4142IY/V007

### **Permit number**

EPR/BN4142IY

# Brocklebank Oilseed Processing Plant

## Permit number EPR/BN4142IY

### Introductory note

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

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

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

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

We have implemented the requirements of the Medium Combustion Plant directive.

The schedules specify the changes made to the permit.

The main features of the permit are as follows.

The Cargill PLC site Brocklebank Oilseed Processing Plant Dock operates an oilseed processing installation at their Bootle site on Regent Road, Liverpool (National Grid Reference SJ3344794403). The site is located on Brocklebank Docks, on the eastern bank of the River Mersey. Residential housing is located approximately 200m to the east. The installation produces annually approximately 280,000 tonnes of crude vegetable oil and 568,000 tonnes per annum of edible vegetable oil from rapeseed, as well as 904,000 tonnes of meal for animal feed.

Process activities include screening, cleaning, conditioning (heating the seeds to control the moisture content) and flaking of seeds (cooking and expelling of flakes to mechanically obtain a proportion of the oil available). The remaining material is termed oilseed cake and is sent to the extractor where it is washed with a solvent (hexane) which removes the remaining accessible oil. The oil can be either exported to clients or refined on site prior to export. The dried and graded meal is stored in flat store in a warehouse before being sent to customers for animal feed. The raw materials arrive mainly by road and the final product leave the site by road via tankers or sea.

The following activities are directly associated with the production process: material handling and storage (intake of crude vegetable oil, intake and storage of rapeseed, transfer of material to preparation plant, seed and meal storage silos, storage warehouse, crude oil tank farm, edible oil tank farm, loading of product for transport to customers by road or by sea): waste handling and storage: skim pit (removal of hexane from process waste) and an engineering workshop and boiler plant (workshop, storage, electrical substation)

The installation uses physical and chemical treatment processes through the use of primary screening, chemical dosing, flocculation and coagulation, DAF, and settlement prior to treat effluent arising from the preparation plant, crude oil tank farm, intermediate tank farm, refinery buildings, roads to the east and west of the refinery building, edible oil tank farm and recovered/condensed vapours from the VSC exhaust gas prior to discharge to the foul sewer, under discharge consent from United Utilities. Emission point S2, leading to the same sewer, discharges trade effluent consisting of wastewater from the solvent extraction plant, including wash-water, final vent, and dryer/cooler scrubber effluent together with surface water runoff via interceptor. Water discharge of process effluent to Brocklebank Dock via emission point W1 is permitted only in abnormal atmospheric conditions such as total power failure at the site or storm conditions.

Air emissions are released into the atmosphere via air emission point A1 and A2 associated with seeds preparation, A3 servicing the solvent room, A5 and A6 associated with drying and cooling processes. All these

emission points are abated via scrubber or cyclone or both techniques simultaneously. Emission points A1, A2 and A5 are abated by both cyclone and scrubber, with emission point A3 abated by scrubber only. There is a single MCP on site in the form of a Boiler of 2.3 MWth capacity that is natural gas fired. Flue gases from the combustion process are released in the atmosphere via emission point A7.

The operator is a participant in the Climate Change Levy Agreement with the Food and Drink Federation. The site uses an EMS that is not accredited at ISO 14001 standard.

There are three Ramsar sites, two SACs, four SPAs within 10km. There is also one SSSI within 2km of the installation.

The status log of a permit sets out the permitting history, including any changes to the permit reference number.

<b>Status log of the permit</b>		
<b>Description</b>	<b>Date</b>	<b>Comments</b>
Application received EPR/BN4142IY	22/03/2005	Application received for oil production
Request for further information (dated 29/07/2005)	04/08/2005	--
Request to extend determination (dated 24/10/2005)	31/10/2005	Request accepted
Effluent improvement action plan	26/10/2005	--
Permit determined	07/12/2005	--
Variation application KP3231GK (EPR/BN4142IY/V002)	12/03/2009	--
Variation application KP3231GK	Withdrawn 16/11/2009	Application withdrawn as operator changed proposals.
Variation application EPR/BN4142IY/V003	Duly made 10/10/2011	Application to vary permit conditions to reflect operational changes, (replacement and re-positioning of the preparation vapour scrubber and replacement of the existing rotary seed conditioner with a vertical seed conditioner).
Variation EPR/BN4142IY/V003 determined	22/11/2011	Varied permit issued
Agency variation determined EPR/BN4142IY/V004	06/01/2014	Agency variation to implement the changes introduced by IED.
Notified of change of company registered address	01/02/2016	Company registered address changed from Knowle Hill Park, Fairmile Lane, Cobham, Surrey, KT11 2PD to Velocity V1, Brooklands Drive, Weybridge, Surrey, KT13 0SL
Variation issued EPR/BN4142IY	04/02/2016	Varied permit issued to Cargill PLC
Application EPR/BN4142IY/V006 (variation and consolidation)	Duly made 19/12/2018	Application to vary and update the permit to modern conditions. (Remove the existing Dryer/Cooler vent and replace it with a new scrubber/stack).
Variation determined EPR/BN4142IY	05/06/2019	Varied permit issued.
Application EPR/BN4142IY/V007 (variation and consolidation)	Regulation 61 Notice response received 21/10/2022	Environment Agency initiated variation and consolidation following the Food, Drink & Milk Industries sector permit review.

<b>Status log of the permit</b>		
<b>Description</b>	<b>Date</b>	<b>Comments</b>
Request for further information (dated 26/05/2023)	30/06/2023	EMS, wastewater monitoring, energy efficiency techniques, wastewater minimisation techniques, chemicals used minimisation techniques, buffer capacity, ETP stages, noise minimisation techniques, auxiliary vacuum usage, EPL for energy and wastewater, hexane loss, capacity, MCPs, cooling towers, containment, non-technical description of activity.
Additional information (dated 04/07/2023)	07/07/2023	Clarification regarding MCPs: only one MCP, Boiler D4, is present on the site.
Variation determined and consolidation issued EPR/BN4142IY	19/08/2024	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/BN4142IY

#### Issued to

**Cargill PLC** (“the operator”)

whose registered office is

**Velocity V1**

**Brooklands Drive**

**Weybridge**

**Surrey**

**KT13 0SL**

company registration number 01387437

to operate a regulated facility at

**Brocklebank Oilseed Processing Plant**

**Regent Road**

**Bootle**

**Merseyside**

**L20 8DF**

to the extent set out in the schedules.

The notice shall take effect from 19/08/2024.

Name	Date
Sandra Cavill	19/08/2024

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/BN4142IY**

This is the consolidated permit referred to in the variation and consolidation notice for application EPR/BN4142IY/V007 authorising,

**Cargill PLC** (“the operator”),

whose registered office is

**Velocity V1**

**Brooklands Drive**

**Weybridge**

**Surrey**

**KT13 0SL**

company registration number 01387437

to operate an installation at

**Brocklebank Oilseed Processing Plant**

**Regent Road**

**Bootle**

**Merseyside**

**L20 8DF**

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

<b>Name</b>	<b>Date</b>
<b>Sandra Cavill</b>	<b>19/08/2024</b>

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 - MCP) the first monitoring measurements shall be carried out within four months from the time of permit issue.

### **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 emission from point A2 shall not exceed 10,625 OU<sub>E</sub>/m<sup>3</sup> odour units.

### **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; 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 S3.1, 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.
- 4.2.5 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.

## 4.4 Interpretation

- 4.4.1 In this permit the expressions listed in schedule 6 shall have the meaning given in that schedule.
- 4.4.2 In this permit references to reports and notifications mean written reports and notifications, except where reference is made to notification being made "immediately", in which case it may be provided by telephone.

## Schedule 1 – Operations

<b>Table S1.1 activities</b>			
<b>Activity reference</b>	<b>Activity listed in Schedule 1 of the EP Regulations</b>	<b>Description of specified activity</b>	<b>Limits of specified activity</b>
AR1	Section 6.8 Part A1 (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 exceeding 300 tonnes per day (average value on a quarterly basis)	From receipt of raw materials delivered to the site, handling including seed preparation (screening, cleaning and conditioning), flaking, cooking, expelling, solvent extraction, hexane removal/recovery, condensing (hexane vapours), scrubber plant, filtration and degumming, oil refining, soapstock, and washwater treatment, bleaching deodorising, condensing (fatty acids) and hydrogenation.  •Daily production capacity is limited to 2,000 tonnes.
AR2	Section 5.4 Part A1 (a) (ii)	Physico-chemical Treatment of non-hazardous waste waters by dissolved air flotation.	From generation of waste water from the preparation plant, the crude oil tank farm, the intermediate tank farm, refinery buildings, roads to the east and west of the refinery building and edible oil tank farm to treatment including primary screening, chemical dosing, flocculation and coagulation, DAF, and settlement prior to discharged via interceptor to United Utilities sewer.
<b>Directly Associated Activity</b>			
AR3	Steam supply	Medium Combustion plants: Boiler: 2.3 MWth Natural gas fired	From receipt of fuel to release of products of combustion to air.
AR4	Raw material storage and handling	Storage and handling of raw materials at the installation	From receipt of raw materials including rape seed and crude vegetable oils by wagon or ship, storage of rapeseed in storage warehouse or silos, transfer of seed to preparation plant, storage of crude oil and edible oils in tank farms, transfer of materials within process, to dispatch of final product by loading of product for transport to customers by road or by sea.
AR5	Storage and use of chemicals and oils	Storage and use of chemicals and oils at the installation.	From receipt of chemicals and oils to disposal of wastes arising.

<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>
AR6	Waste storage and handling	Storage and handling of waste materials	From generation of waste to storage pending removal for disposal or recovery.
AR7	Skim pit	Skim pit	Removal of hexane from process effluent
AR8	Engineering workshops	Engineering workshops	Workshops, storage, electrical substation.
AR9	Process cooling waters	Operation of four cooling towers	From operation of cooling towers, including chemical dosing.
AR10	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>
Application	The response to questions 2.1 and 2.2 given in pages 13 to 42 of the application.	22/03/2005
Request for Information	All parts	04/08/2005
Effluent improvement action plan	All parts	26/10/2005
Variation application EPR/BN4142IY/V003	Response to 'Section 3 - Operating techniques' of the Part C3 application form, (Form EPC3).	10/10/2011
Variation EPR/BN4142IY	Application supporting documentation: <ul style="list-style-type: none"> <li>Appendix A: Cargill Final Report</li> <li>Appendix D: DC Changes Impacts Assessment</li> </ul>	19/12/2018
Request for further information	Email detailing 'Bleaching use'	11/03/2019
Regulation 61 (1) Notice – Responses to questions dated 09/06/2022	All parts	Received 21/10/2022
Request for further information dated 26/05/2023	EMS, wastewater monitoring, energy efficiency techniques, wastewater minimisation techniques, chemicals used minimisation techniques, buffer capacity, ETP stages, noise minimisation techniques, auxiliary vacuum usage, EPL for energy and wastewater, hexane loss, capacity, MCPs, cooling towers, containment, non-technical description of activity.	30/03/2023
Additional information (dated 04/07/2023)	Clarification regarding MCPs – only one MCP, Boiler D4 of 2.3 MWth capacity is present on the site.	07/07/2023

<b>Table S1.3 Improvement programme requirements</b>		
<b>Reference</b>	<b>Requirement</b>	<b>Date</b>
IC10	<p>The operator shall submit, for approval by the Environment Agency, a report demonstrating 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. The report shall include, but not be limited to, the following:</p> <ul style="list-style-type: none"> <li>• Methodology applied for achieving BAT</li> <li>• Demonstrating that BAT has been achieved.</li> </ul> <p>The report shall address the BAT Conclusions for Food, Drink and Milk Industries with respect to BATc 1, 5 and 6.</p> <p>Refer to BAT Conclusions for a full description of the BAT requirement.</p>	19/11/2024 or other date agreed in writing with the Environment Agency
IC11	<p>The Operator shall submit an updated Solvent Management Plan (SMP) to the Environment Agency for technical assessment and approval, demonstrating compliance against BAT 32 for the FDM industries. Further guidance on SMPs can be found on our website Solvent Management Plans: environmental permits - GOV.UK (<a href="http://www.gov.uk">www.gov.uk</a>)</p> <p>The updated plan must include the following elements:</p> <ul style="list-style-type: none"> <li>• a protocol containing actions and timelines;</li> <li>• a protocol for conducting solvent emissions monitoring;</li> <li>• a protocol for response to identified solvent loss events, e.g. fugitive emissions;</li> <li>• a protocol to reduce solvent mass-balance uncertainties;</li> <li>• a solvent reduction programme designed to identify the source(s), to measure/estimate solvent loss, to characterise the contributions of the sources and to implement prevention and/or reduction measures.</li> </ul> <p>The solvent management plan should be reviewed at least annually to ensure continued compliance against BAT 32 as described above.</p>	19/08/2025 or other date agreed in writing with the Environment Agency
IC12	<p>The operator shall confirm in writing to the Environment Agency that they have achieved the specific Environmental Performance Levels (EPLs) for specific energy consumption, where compliance with the EPL was not demonstrated at the time of R61 submission. Where an operator cannot achieve the EPL, they should provide a justification and derive a site-specific benchmark.</p> <p>Refer to BAT Conclusions for a full description of the requirements.</p>	19/11/2024 or other date agreed in writing with the Environment Agency
IC13	<p>The operator shall submit, for approval by the Environment Agency an annual monitoring procedure two weeks before the monitoring program is due to start. The information shall contain, but not limited to the following aspects:</p> <ul style="list-style-type: none"> <li>• Complete list of current emission points</li> <li>• Chosen emission points for the 2-day campaign monitoring program</li> <li>• Monitoring methodology or standard used, reflective of BATc 5 requirements</li> </ul>	19/08/2025 or other date as agreed in writing with the Environment Agency.
IC14	<p>The operator shall submit a written report to the Environment Agency for approval to review the substances with the potential of causing</p>	19/08/2025 or other date as agreed in writing with the Environment Agency.



<b>Table S1.3 Improvement programme requirements</b>		
<b>Reference</b>	<b>Requirement</b>	<b>Date</b>
	<p>odour emissions and associated abatement techniques current efficiencies.</p> <p>The report shall include but not limited to the following aspects:</p> <p>The report shall include but not limited to the following aspects:</p> <ul style="list-style-type: none"> <li>• Full investigation and characterisation of the inlet and outlet gas streams for site abatement systems.</li> <li>• Abatement emissions monitoring results including odour concentrations (OUe/m3), and GCMS monitoring.</li> <li>• Details of site-specific “action levels”.</li> <li>• Proposed ELVs (including the odour limit as set out in table S3.1)</li> <li>• Impact assessment and modelling for the proposed ELVs</li> <li>• Recommendations for improvement including the replacement or upgrading of the abatement plant where appropriate.</li> </ul> <p>The report should also list all relevant contingency mitigation actions to minimise the risk of elevated odour pollution from the installation in abnormal operating periods e.g. plant breakdown and detail the actions to restore systems to normal operating conditions for effective odour control.</p> <p>The monitoring program shall be reviewed on an annual basis and the results communicated to the Environment Agency.</p>	
IC15	<p>The Operator shall submit a written report to the Environment Agency of monitoring carried out to determine the size distribution of particulate matter in the exhaust gas emissions to air from emission point [A1, A2 and A5], identifying the fractions within the PM<sub>10</sub> and PM<sub>2.5</sub> ranges. The monitoring shall be carried out under representative operating conditions and shall be in accordance with EN ISO 23210 unless otherwise agreed with the Environment Agency.</p>	19/08/2025 or other date agreed in writing with the Environment Agency
IC16	<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>	19/08/2025 or other date agreed in writing with the Environment Agency

## Schedule 2 – Waste types, raw materials and fuels

Table S2.1 Raw materials and fuels	
Raw materials and fuel description	Specification
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## Schedule 3 – Emissions and monitoring

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]	Seed preparation vent via scrubber	Particulate matter	10 mg/m <sup>3</sup>	Hourly	Annually	BS EN 13284-1
A2 [Point A2 on site plan in Schedule 7]	Seed preparation building via scrubber	Particulate matter	10 mg/m <sup>3</sup>	Average over sampling period	Annually	BS EN 13284-1
		Odour [Note 1]	10,625 OUE /m <sup>3</sup> (spot sample)	Hourly average	Annually	BS EN 13725
A3 [Point A3 on site plan in Schedule 7]	Solvent building roof	Hexane	2 kg/hour	Hourly average	Annually	BS CEN/TS 13649 or as agreed in writing by the Environment Agency
		TVOC	No limit set	Average over sampling period	Annually	EN 12619
A5 [Point A5 on site plan in Schedule 7]	Dryer/cooler vent via cyclone separator and scrubber	Particulate matter	20 mg/m <sup>3</sup>	Average over sampling period	Annually	BS EN 13284-1
		Odour	No limit set	--	--	--
A7 [Point A7 on site plan in schedule 7]	Boiler D4 2.3 MWth Natural gas	Oxides of Nitrogen (NO and NO <sub>2</sub> expressed as NO <sub>2</sub> )	100 mg/m <sup>3</sup>	Periodic	Every three years	BS EN 14792
		Carbon monoxide	No limit set	Periodic	Every three years	MCERTS BS EN15058
Installation	Installation overall	Hexane losses	0.7 kg/tonne input of rapeseed processed	Average over sampling period	Annually	As specified by Solvent Management Plan [Note 2]
<p>Note 1: Subject to completion of improvement condition IC14, revised and/or additional parameters and ELVs will be considered for emission point A2.</p> <p>Note 2: Subject to completion of improvement condition IC12 and written agreement of the Environment Agency.</p>						

<b>Table S3.2 Point Source emissions to water (other than sewer) and land – emission limits and monitoring requirements</b>						
<b>Emission point ref. &amp; location</b>	<b>Source</b>	<b>Parameter</b>	<b>Limit (incl. unit)</b>	<b>Reference Period</b>	<b>Monitoring frequency</b>	<b>Monitoring standard or method</b>
W1 (Point 66 on drawing number CCAP 5004, submitted with original permit application dated 22/03/05) emissions to Brocklebank Dock, a tributary of the Tidal River Mersey	Process water, Site Drainage and Fire Water [NOTE 1]	Total suspended solids (TSS)	No limit set	--	--	--
<p>Note 1: A discharge shall only take place from W1 in the event of:</p> <ul style="list-style-type: none"> <li>• Total site power failure</li> <li>• An emergency requiring use of the fire water system</li> <li>• Extreme storm conditions such that the flow arriving in the pumping pit at NGR SJ335950 is in excess of 2.88 Ml/day.</li> </ul>						

<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>Source</b>	<b>Parameter</b>	<b>Limit (incl. Unit)</b>	<b>Reference period</b>	<b>Monitoring frequency</b>	<b>Monitoring standard or method</b>
S1 (Point 64 on CCAP Section 13.1) Emissions to Regent Road-United Utilities	Effluent from the preparation plant, the crude oil tank farm, the intermediate tank farm, refinery buildings, roads to the east and west of the refinery building, edible oil tank farm and recovered/ condensed vapours from the VSC exhaust gas treatment via the Effluent Treatment Plant	No parameter set	No limit set	--	--	--
S2 (Point 64 on CCAP Section 13.1) Emissions to Regent Road - United Utilities	Wastewater from the solvent extraction plant, including washwater, Final Vent and Dryer Cooler scrubber effluent, via a skim pit and '15' oil/water interceptor. Surface water drainage is also directed to sewer via this '15' interceptor.	No parameter set	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>
A3 on site plan in schedule 7	Hydrogen sulphide	Annually	As agreed in writing with the Environment Agency	Solvent loss per tonne crushed

## Schedule 4 – Reporting

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

Parameter	Emission or monitoring point/reference	Reporting period	Period begins
Point source emissions to air Parameters as required by condition 3.5.1	Drier: A5	Every 12 months	1 January
	Handling: A1 and A2		
	Odour: A2		
	Hexane A3		
	MCP plant: Boiler – A7	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

Parameter	Units
Crude oil	tonnes
Edible vegetable oil	tonnes
Animal feed	tonnes
Input of rape seed	Tonnes

Parameter	Frequency of assessment	Units
Water usage	Annually	m <sup>3</sup> /t of finished product
Energy usage	Annually	MWh
Waste disposal and recovery	Annually	t/t of finished product
COD loss efficiency	Annually*	COD te/te product
Food waste	Annually	Tonnes
Hexane usage	Annually	kg/t input of seed

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

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

## Schedule 5 – Notification

These pages outline the information that the operator must provide.

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

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

### Part A

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

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

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



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

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

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

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

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

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

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

Name*	
Post	
Signature	
Date	

\* authorised to sign on behalf of the operator

## Schedule 6 – Interpretation

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

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

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

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

“emissions to land” includes emissions to groundwater.

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

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

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

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

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

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

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

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

“Pests” means Birds, Vermin and Insects.

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

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

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



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