



Notice of variation and consolidation with introductory note

The Environmental Permitting (England & Wales) Regulations 2016

Danish Crown UK Limited

Danish Crown Bugle
Ebenezer
Bugle
St Austell
PL26 8RR

Variation application number

EPR/DP3631RA/V003

Permit number

EPR/DP3631RA

Danish Crown Bugle

Permit number EPR/DP3631RA

Introductory note

This introductory note does not form a part of the notice

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

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

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

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

The schedules specify the changes made to the permit.

The main features of the permit are as follows.

The Danish Crown Bugle installation is located to the Northeast of the village of Bugle in central Cornwall and covered approximately 1.5 hectares. The site is accessed from St. Austell Street and located on National grid reference SX 03560 60170. The surrounding area mostly consists of rural farmland however, there are sensitive residential receptors to the North within 100m of the installation.

The Environmental Permit is for the following scheduled activity:

6.8 A(1) (d) (i) - Treatment and processing, other than exclusively packaging, of the following raw materials, whether previously processed or unprocessed, intended for the production of food or feed (where the weight of the finished product excludes packaging) only animal raw materials (other than milk only) with a finished product production capacity greater than 75 tonnes per day.

There is also an additional scheduled activity:

5.4 A(1) (a) (ii) - disposal of non-hazardous waste in a facility with a capacity exceeding 50 tonnes per day by physico-chemical treatment.

The installation has a maximum theoretical production capacity to produce 264 tonnes of finished product per day.

The installation produces a range of cooked, cured and smoked meat (primarily pork) and poultry products. Pork primals received on-site are first de-boned and de-fatted prior to either curing or cooking. Curing involves injection of meat with brine solution and emulsion materials, together with massage with paddles under vacuum. Cooking is carried out in steam ovens; cooked product is chilled. Smoking is carried out in friction wheel smoke houses fitted with catalytic converters to treat emissions. Waste streams include waste packaging; waste meat; bad fat; and effluent sludge. Process effluent together with site drainage from sensitive areas (trolley wash bay, compactor, animal byproducts storage trailer) are treated in the on-site effluent treatment plant. All other surface drainage discharges into a reed bed for treatment at the south end of the site, and thence discharges via an adjustable weir into an unnamed stream.

The main releases to air are the combustion gases from the on-site combustion plants and three smoke chambers. The installation utilises one 1.2 MWth gas oil (diesel) fired boiler. This boiler is used to produce steam and heat for direct process use. There is also a 0.5 MWth water boiler on-site.

There are four designated statutory sites within 10km of the installation which consist of Breney Common and Goss & Tregoss Moors (Special Area of Conservation (SAC)), St Austell Clay Pits (SAC), River Camel (SAC), and Falmouth Bay to St Austell Bay (Special Protection Area (SPA)). There is one statutory Site of Special Scientific Interest (SSSI) site within 2km of the installation which is the Mid Cornwall Moors. There are several non-statutory sites within 2km of the installation consisting of 6 wildlife sites.

The site has an internal Environmental Management System (EMS) which is audited through a scheduled internal audit process which takes place continuously.

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

Status log of the permit		
Description	Date	Comments
Application received EPR/TP3937PS/A001	Received 08/10/2004	Application received for the production of meat products, primarily pork.
Response to request for information	Sent 18/03/2005	Response received 03/04/2005.
Request to transfer application to a new Operator EPR/ZP3831SY	Received 28/06/2005	Application TP3937PS withdrawn.
Permit determined	05/10/2005	Permit EPR/ZP3831SY/A001 issued.
Agency variation determined EPR/ZP3831SY/V002	05/03/2014	Agency variation to implement the changes introduced by IED
Application EPR/DP3631RA/T001 (full transfer of permit EPR/ZP3831SY)	Duly made 03/03/2016	Application to transfer the permit in full to Danish Crown UK Limited.
Transfer determined EPR/DP3631RA	31/03/2016	Full transfer or permit complete.
Application EPR/DP3631RA/V003 (variation and consolidation)	Regulation 61 Notice response received 01/12/2022	Environment Agency initiated variation and consolidation following the Food, Drink & Milk Industries sector permit review.
Response to request for information dated 07/06/2024	Received 28/06/2024	Information requested in relation to Reg.61 response tool concerning BATc 1, 2, 3, 5, 6, 7, 11, 15, 29, medium combustion plant, climate change adaption, containment, site plan, and site name.
Response to request for information dated 16/07/2024	Received 18/07/2024	Information requested in relation to Reg.61 response tool concerning BATc 7.
Variation determined and consolidation issued EPR/DP3631RA	27/08/2024	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/DP3631RA

Issued to

Danish Crown UK Limited (“the Operator”)

whose registered office is

**57 Stanley Road
Whitefield
Manchester
M45 8GZ**

company registration number 02021233

to operate a regulated facility at

**Danish Crown Bugle
Ebenezer
Bugle
St Austell
PL26 8RR**

to the extent set out in the schedules.

The notice shall take effect from 27/08/2024.

Name	Date
Sandra Cavill	27/08/2024

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/DP3631RA

This is the consolidated permit referred to in the variation and consolidation notice for application EPR/DP3631RA/V003 authorising,

Danish Crown UK Limited (“the Operator”),

whose registered office is

**57 Stanley Road
Whitefield
Manchester
M45 8GZ**

company registration number 02021233

to operate an installation at

**Danish Crown Bugle
Ebenezer
Bugle
St Austell
PL26 8RR**

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

Name	Date
Sandra Cavill	27/08/2024

Authorised on behalf of the Environment Agency

Conditions

1 Management

1.1 General management

1.1.1 The Operator shall manage and operate the activities:

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

1.1.2 Records demonstrating compliance with condition 1.1.1 shall be maintained.

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

1.2 Energy efficiency

1.2.1 The Operator shall:

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

1.3 Efficient use of raw materials

1.3.1 The Operator shall:

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

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

1.4.1 The Operator shall take appropriate measures to ensure that:

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

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

2 Operations

2.1 Permitted activities

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

2.2 The site

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

2.3 Operating techniques

2.3.1 The activities shall, subject to the conditions of this permit, be operated using the techniques and in the manner described in the documentation specified in schedule 1, table S1.2, unless otherwise agreed in writing by the Environment Agency.

2.3.2 If notified by the Environment Agency that the activities are giving rise to pollution, the Operator shall submit to the Environment Agency for approval within the period specified, a revision of any plan or other documentation (“plan”) specified in schedule 1, table S1.2 or otherwise required under this permit which identifies and minimises the risks of pollution relevant to that plan, and shall implement the approved revised plan in place of the original from the date of approval, unless otherwise agreed in writing by the Environment Agency.

2.3.3 Any raw materials or fuels listed in schedule 2 table S2.1 shall conform to the specifications set out in that table.

2.3.4 The Operator shall ensure that where waste produced by the activities is sent to a relevant waste operation, that operation is provided with the following information, prior to the receipt of the waste:

- (a) the nature of the process producing the waste;
- (b) the composition of the waste;
- (c) the handling requirements of the waste;
- (d) the hazardous property associated with the waste, if applicable; and
- (e) the waste code of the waste.

2.4 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 (boiler plant) the first monitoring measurements shall be carried out within four months of 01/01/2030 or of the date when the MCP is first put into operation, whichever is later.

3.2 Emissions of substances not controlled by emission limits

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

3.3 Odour

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

3.4 Noise and vibration

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

3.5 Monitoring

- 3.5.1 The Operator shall, unless otherwise agreed in writing by the Environment Agency, undertake the monitoring specified in the following tables in schedule 3 to this permit:
- (a) point source emissions specified in tables S3.1, S3.2 and S3.3.
- 3.5.2 The Operator shall maintain records of all monitoring required by this permit including records of the taking and analysis of samples, instrument measurements (periodic and continual), calibrations, examinations, tests and surveys and any assessment or evaluation made on the basis of such data.
- 3.5.3 Monitoring equipment, techniques, personnel and organisations employed for the emissions monitoring programme and the environmental or other monitoring specified in condition 3.5.1 shall have either MCERTS certification or MCERTS accreditation (as appropriate), where available, unless otherwise agreed in writing by the Environment Agency.
- 3.5.4 Permanent means of access shall be provided to enable sampling/monitoring to be carried out in relation to the emission points specified in schedule 3 tables S3.1, S3.2, and S3.3 unless otherwise agreed in writing by the Environment Agency.

3.6 Pests

- 3.6.1 The activities shall not give rise to the presence of pests which are likely to cause pollution, hazard or annoyance outside the boundary of the site. The Operator shall not be taken to have breached this condition if appropriate measures, including, but not limited to, those specified in any approved pests management plan, have been taken to prevent or where that is not practicable, to minimise the presence of pests on the site.
- 3.6.2 The Operator shall:
- (a) if notified by the Environment Agency, submit to the Environment Agency for approval within the period specified, a pests management plan which identifies and minimises risks of pollution from pests;
- (b) implement the pests management plan, from the date of approval, unless otherwise agreed in writing by the Environment Agency.

4 Information

4.1 Records

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

4.2 Reporting

- 4.2.1 The Operator shall send all reports and notifications required by the permit to the Environment Agency using the contact details supplied in writing by the Environment Agency.
- 4.2.2 A report or reports on the performance of the activities over the previous year shall be submitted to the Environment Agency by 31 January (or other date agreed in writing by the Environment Agency) each year. The report(s) shall include as a minimum:
- (a) a review of the results of the monitoring and assessment carried out in accordance with the permit including an interpretive review of that data;
 - (b) the annual production/treatment data set out in schedule 4 table S4.2; and
 - (c) the performance parameters set out in schedule 4 table S4.3 using the forms specified in table S4.4 of that schedule.
- 4.2.3 Within 28 days of the end of the reporting period the Operator shall, unless otherwise agreed in writing by the Environment Agency, submit reports of the monitoring and assessment carried out in accordance with the conditions of this permit, as follows:
- (a) in respect of the parameters and emission points specified in schedule 4 table S4.1;
 - (b) for the reporting periods specified in schedule 4 table S4.1 and using the forms specified in schedule 4 table S4.4; and
 - (c) giving the information from such results and assessments as may be required by the forms specified in those tables.
- 4.2.4 The Operator shall, unless notice under this condition has been served within the preceding four years, submit to the Environment Agency, within six months of receipt of a written notice, a report assessing whether there are other appropriate measures that could be taken to prevent, or where that is not practicable, to minimise pollution.

4.3 Notifications

- 4.3.1 In the event:
- (a) that the operation of the activities gives rise to an incident or accident which significantly affects or may significantly affect the environment, the Operator must immediately—
 - (i) inform the Environment Agency,
 - (ii) take the measures necessary to limit the environmental consequences of such an incident or accident, and
 - (iii) take the measures necessary to prevent further possible incidents or accidents;
 - (b) of a breach of any permit condition the Operator must immediately—
 - (i) inform the Environment Agency, and
 - (ii) take the measures necessary to ensure that compliance is restored within the shortest possible time;
 - (c) of a breach of permit condition which poses an immediate danger to human health or threatens to cause an immediate significant adverse effect on the environment, the Operator must immediately suspend the operation of the activities or the relevant part of it until compliance with the permit conditions has been restored.
- 4.3.2 Any information provided under condition 4.3.1 shall be confirmed by sending the information listed in schedule 5 to this permit within the time period specified in that schedule.
- 4.3.3 Where the Environment Agency has requested in writing that it shall be notified when the Operator is to undertake monitoring and/or spot sampling, the Operator shall inform the Environment Agency when the

relevant monitoring and/or spot sampling is to take place. The Operator shall provide this information to the Environment Agency at least 14 days before the date the monitoring is to be 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

Table S1.1 activities			
Activity reference	Activity listed in Schedule 1 of the EP Regulations	Description of specified activity	Limits of specified activity
AR1	Section 6.8 Part A1 (d) (i)	Treatment and processing, other than exclusively packaging, of the following raw materials, whether previously processed or unprocessed, intended for the production of food or feed (where the weight of the finished product excludes packaging) only animal raw materials (other than milk only) with a finished product production capacity greater than 75 tonnes per day.	From receipt of raw materials such as pork primals, chicken and turkey to production of finished product including storage and dispatch of pork-based products off-site. Production capacity is limited to 264 tonnes per day.
AR2	Section 5.4 Part A1 (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 wastewater to discharge to sewer.
Directly Associated Activity			
AR3	Steam supply and heat generation	Medium Combustion plant: One 1.2 MWth diesel-fired boiler (A7), and one 0.5 MWth liquefied petroleum gas fired boiler (A2).	From receipt of diesel to release of combustion to air to production of steam and associated wastes removed from site.
AR4	Operation of ovens	One oil fired roaster (A5).	From receipt of fuel to release of products of combustion to air.
AR5	Operation of meat smoker chambers	Three meat smokers (A1, A4, and A6).	From receipt of fuel to release of products of combustion to air.
AR6	Raw material storage and handling	Storage and handling of raw materials at the installation.	From receipt of raw materials to dispatch of final product.
AR7	Use of refrigerants	Use of refrigerants in cooling, chilling and/or freezing systems at the installation.	From receipt of primals to dispatch of final product.
AR8	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.
AR9	Waste storage and handling	Storage and handling of waste materials.	From generation of waste to storage pending removal for disposal or recovery.

Table S1.1 activities			
Activity reference	Activity listed in Schedule 1 of the EP Regulations	Description of specified activity	Limits of specified activity
AR10	Surface water drainage	Collection of uncontaminated site surface waters.	Handling and storage of site drainage until discharge to the site surface water system.

Table S1.2 Operating techniques		
Description	Parts	Date Received
Regulation 61 (1) Notice – Responses to questions dated 01/08/2022	All parts	Received 01/12/2022
Regulation 61(1) Notice – request for further information dated 07/06/2024	Information requested in relation to Reg.61 response tool concerning BATc 1, 2, 3, 5, 6, 7, 11, 15, 29, medium combustion plant, climate change adaption, containment, site plan, and site name.	Received 28/06/2024
Regulation 61(1) Notice – request for further information dated 16/07/2024	Information requested in relation to Reg.61 response tool concerning BATc 7.	Received 18/07/2024

Table S1.3 Improvement programme requirements		
Reference	Requirement	Date
IC9	<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"> • Methodology applied for achieving BAT • Demonstrating that BAT has been achieved. <p>The report shall address the BAT Conclusions for Food, Drink and Milk Industries with respect to BATc 1, 2, 5 and 6. Refer to BAT Conclusions for a full description of the BAT requirement.</p>	3 months from date of issue or as agreed in writing by the Environment Agency 27/11/2024
IC10	<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 produce a plan for the onsite refrigerant system(s) at the installation. The plan is to be assessed by the Environment Agency and shall be incorporated within the existing environmental management system.</p> <p>The plan should include, but not be limited to, the following:</p> <ul style="list-style-type: none"> • Where practicable, retro filling systems containing high GWP refrigerants e.g. R-404A with lower GWP alternatives as soon as possible. 	3 months from date of issue or as agreed in writing by the Environment Agency 27/11/2024

Table S1.3 Improvement programme requirements		
Reference	Requirement	Date
	<ul style="list-style-type: none"> An action log with timescales, for replacement of end-of-life equipment using refrigerants with the lowest practicable GWP. 	
IC11	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.	12 months from date of issue or as agreed in writing by the Environment Agency 27/08/2025
IC12	The Operator shall produce a monitoring plan detailing how the management of relevant hazardous substances which did not screen out as low risk, based on the RHS baseline assessment, will be maintained and monitored to mitigate the risks of pollution. The plan shall be submitted for approval. The plan shall be implemented in accordance with the Environment Agency's written approval, including timescales to undertake any infrastructure improvements.	12 months from date of issue or as agreed in writing by the Environment Agency 27/08/2025

Schedule 2 – Waste types, raw materials and fuels

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

Schedule 3 – Emissions and monitoring

Table S3.1 Point source emissions to air – emission limits and monitoring requirements						
Emission point ref. & location	Source	Parameter	Limit (including unit)	Reference period	Monitoring frequency	Monitoring standard or method
A1 [Point A1 on site plan in Schedule 7]	Smoke chamber	Total Volatile Organic Compounds (TVOC)	50mg/m ³ [Note 1]	Average	Annually	BS EN12619
		Oxides of Nitrogen (NO and NO ₂ expressed as NO _x) [Note 2]	No limit set	Periodic	Annually	BS EN14792
		Carbon monoxide [Note 2]	No limit set	Periodic	Annually	BS EN15058
A2 [Point A2 on site plan in Schedule 7]	Water boiler 1 x 0.5 MWth liquefied petroleum gas fired boiler	No parameters set	No limit set	--	--	--
A4 [Point A4 on site plan in Schedule 7]	Smoke chamber	Total Volatile Organic Compounds (TVOC)	50mg/m ³ [Note 1]	Average	Annually	BS EN12619
		Oxides of Nitrogen (NO and NO ₂ expressed as NO _x) [Note 2]	No limit set	Periodic	Annually	BS EN14792
		Carbon monoxide [Note 2]	No limit set	Periodic	Annually	BS EN15058
A5 [Point A5 on site plan in Schedule 7]	Oil fired roaster	No parameters set	No limit set	--	--	--
A6 [Point A6 on site plan in Schedule 7]	Smoke chamber	Total Volatile Organic Compounds (TVOC)	50mg/m ³ [Note 1]	Average	Annually	BS EN12619
		Oxides of Nitrogen (NO and NO ₂ expressed as NO _x) [Note 2]	No limit set	Periodic	Annually	BS EN14792
		Carbon monoxide [Note 2]	No limit set	Periodic	Annually	BS EN15058

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
A7 [Point A on site plan in Schedule 7] [Note 3]	Boiler Plant 1 x 1.2 MWth Gas oil (diesel fired boiler) [Note 4]	Oxides of Nitrogen (NO and NO ₂ expressed as NO _x)	200 mg/m ³	Periodic	Every three years	BS EN14792
		Carbon monoxide	No Limit set	Periodic	Every three years	MCERTS BS EN15058

Note 1: The BAT-AEL does not apply when the TVOC emission load is below 500g/h.

Note 2: The monitoring only applies when a thermal oxidiser is used.

Note 3: The emission monitoring/limits requirements apply from 1 January 2030, unless otherwise advised by the Environment Agency and if the boiler is replaced.

Note 4: "Gas oil" includes diesel and is defined in Article 3(19) of the MCPD.

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

Emission point ref. & location	Source	Parameter	Limit (incl. unit)	Reference Period	Monitoring frequency	Monitoring standard or method
W1 [Point W1 on site plan in schedule 7] emission to unnamed stream via a reed bed.	Uncontaminated surface runoff	No parameter set	No limit set	--	--	--

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

Emission point ref. & location	Source	Parameter	Limit (incl. Unit)	Reference period	Monitoring frequency	Monitoring standard or method
S1 [Point S1 on site plan in schedule 7] emission to South West Water foul sewer.	Treated process effluent from onsite effluent treatment plant	No parameters Set	No limit set	--	--	--

Schedule 4 – Reporting

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

Parameter	Emission or monitoring point/reference	Reporting period	Period begins
Point source emissions to air	A1, A4, A6	Every 12 months	1 January
Parameters as required by condition 3.5.1	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
Total product produced.	tonnes

Parameter	Frequency of assessment	Units
Water usage	Annually	m ³
Energy usage	Annually	MWh
Waste	Annually	tonnes
COD loss efficiency	Annually*	COD te/te product
Refrigerant Consumption	Annually	kg
Food waste	Annually	Tonnes

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

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

Schedule 5 – Notification

These pages outline the information that the Operator must provide.

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

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

Part A

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

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

(b) Notification requirements for the breach of a limit	
To be notified within 24 hours of detection unless otherwise specified below	
Emission point reference/ source	
Parameter(s)	
Limit	
Measured value and uncertainty	
Date and time of monitoring	
Measures taken, or intended to be taken, to stop the emission	

Time periods for notification following detection of a breach of a limit	
Parameter	Notification period

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

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

Part B – to be submitted as soon as practicable

Any more accurate information on the matters for notification under Part A.	
Measures taken, or intended to be taken, to prevent a recurrence of the incident	
Measures taken, or intended to be taken, to rectify, limit or prevent any pollution of the environment which has been or may be caused by the emission	
The dates of any unauthorised emissions from the facility in the preceding 24 months.	

OFFICIAL

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:

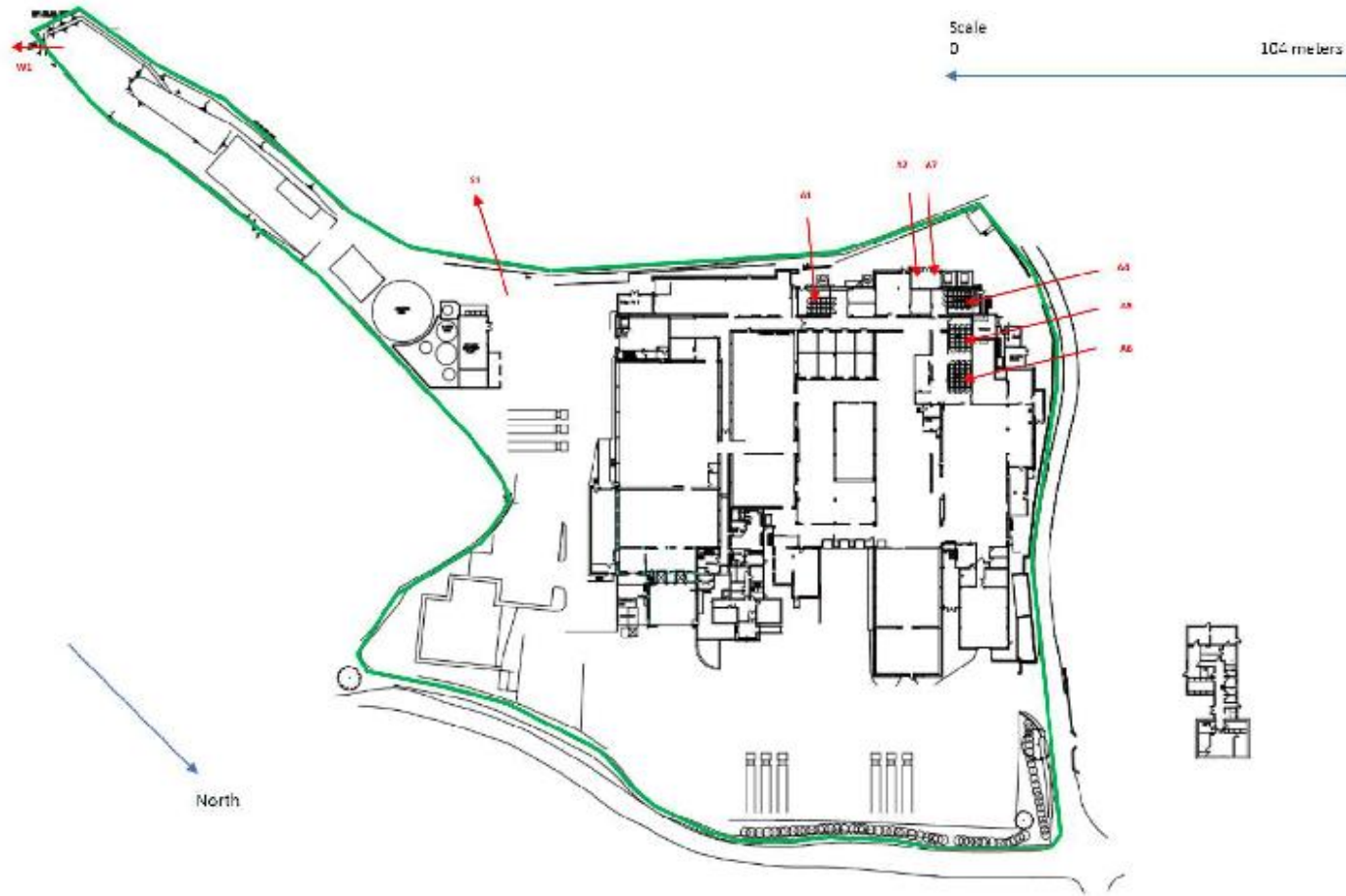
- in relation to emissions from combustion processes, the concentration in dry air at a temperature of 273K, at a pressure of 101.3 kPa and with an oxygen content of 3% dry for liquid and gaseous fuels, 6% dry for solid fuels; and/or
- in relation to emissions from gas engines or gas turbines, the concentration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

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

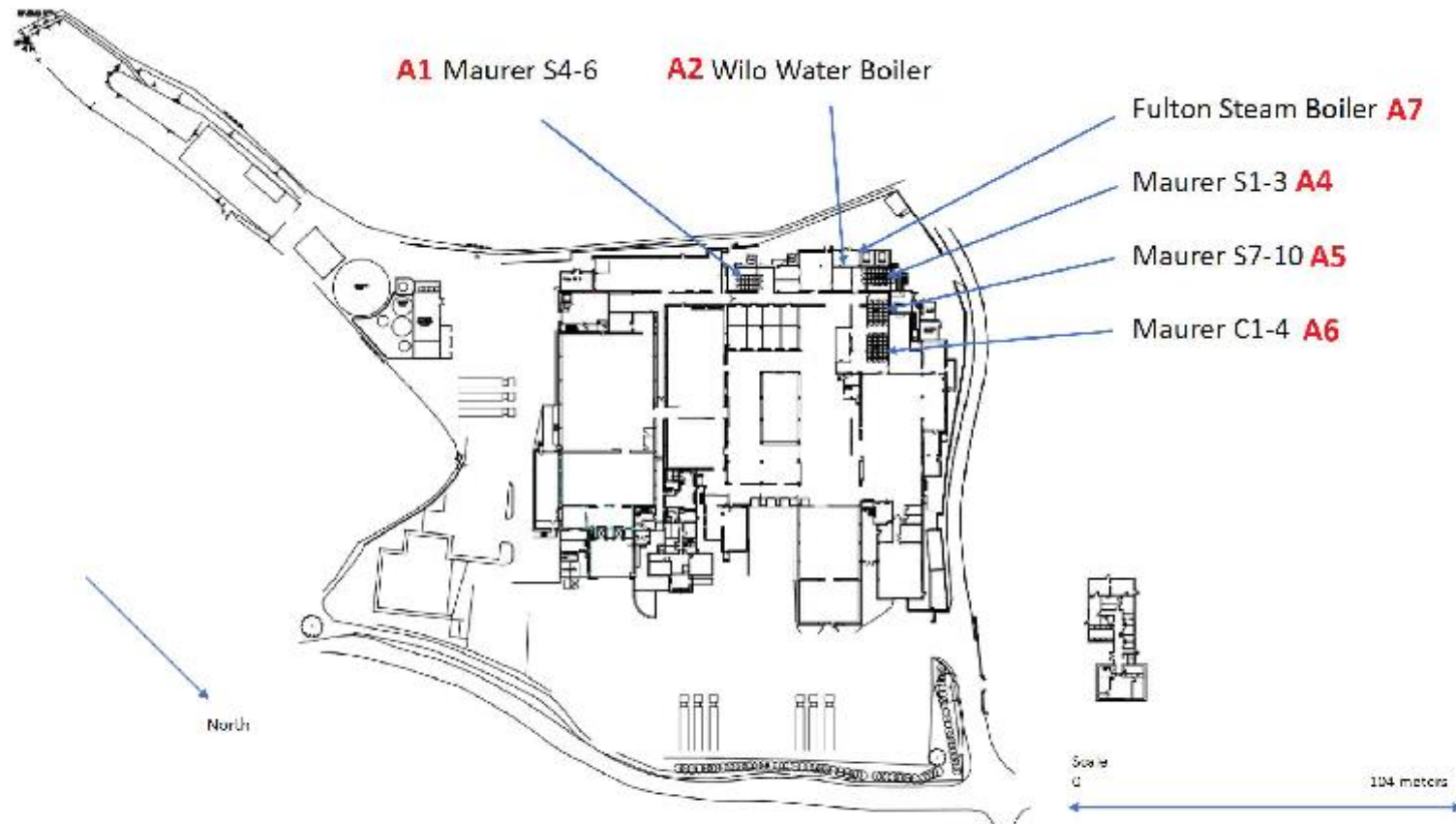
“year” means calendar year ending 31 December.

Schedule 7 – Site plan

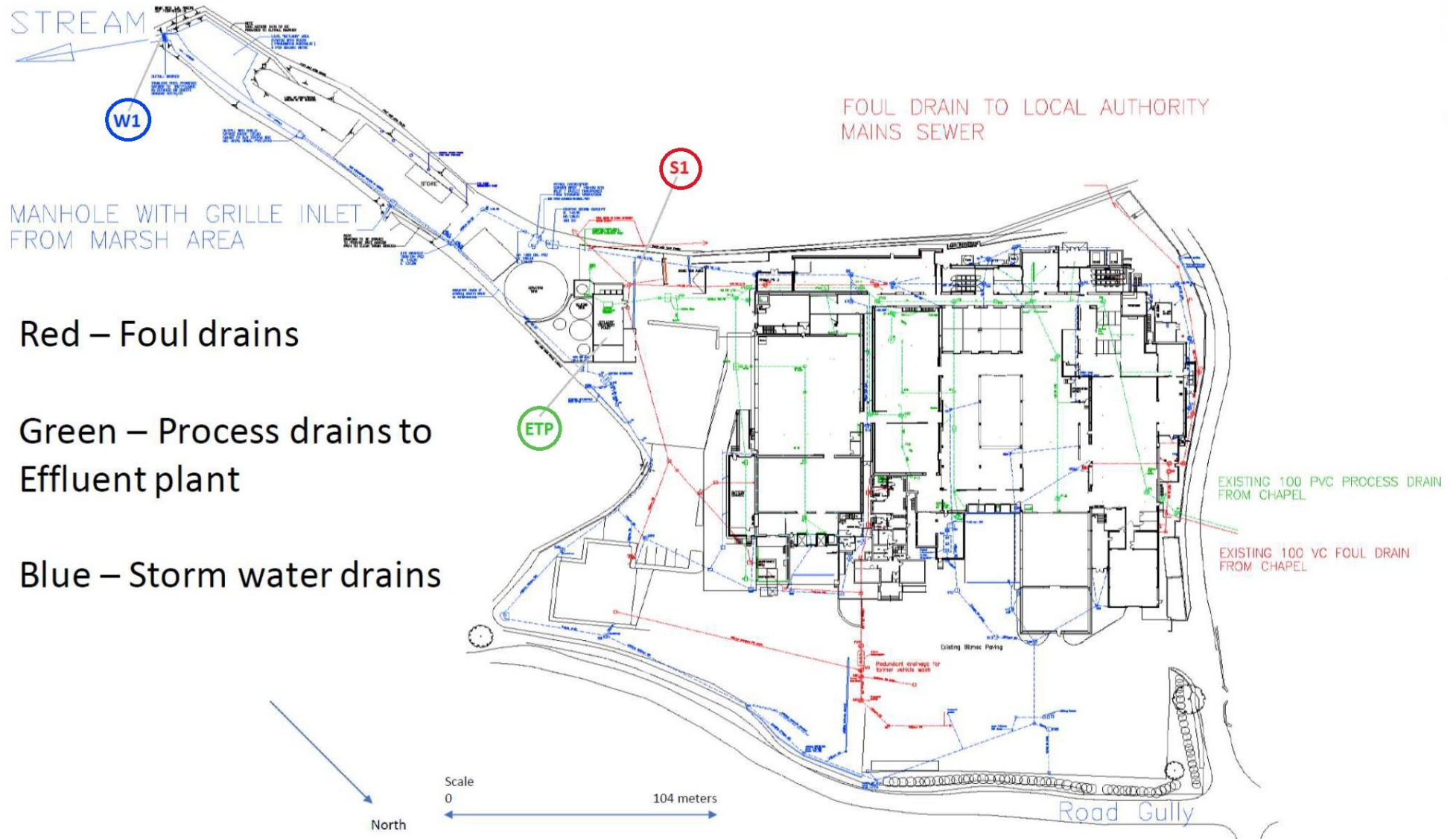
i) Site plan with emission points:



ii) Site plan showing emission source points to air:



iii) Site plan showing surface run off and sewer emission points with effluent flow:



Red – Foul drains

Green – Process drains to Effluent plant

Blue – Storm water drains

END OF PERMIT