

# Notice of variation and consolidation with introductory note

The Environmental Permitting (England & Wales) Regulations 2016

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Sofidel UK Limited  
Leicester Tissue Mill  
Waterside Road  
Hamilton Industrial Park  
Leicester  
LE5 1TZ

**Variation application number**

EPR/BJ6780IL/V007

**Permit number**

EPR/BJ6780IL

# Leicester Tissue Mill

## Permit number EPR/BJ6780IL

### 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. Only the variations specified in schedule 1 are subject to a right of appeal.

The permit has been reviewed against the requirements of the Medium Combustion Plant Directive (MCPD) for 2025 and relevant conditions and monitoring requirements have been added.

The installation includes two existing medium combustion plant that all run on natural gas. The two existing boilers are 9.5MWth each and a third (new) boiler is rated at 13.2MWth.

#### **About the site:**

The main purpose of the activity at the installation is producing toilet, facial and sanitary tissue / towel. The installation falls under the following IED Schedule 1 listed activity descriptions:

- **Section 6.1 Part A(1)(b)** - Producing, in industrial plant, paper and board where the plant has a production capacity of more than 20 tonnes per day - Manufacture of tissue towel and toilet tissue products from virgin pulp on two paper machines.
- **Section 5.4 Part A(1)(a)(ii)** - Disposal of non-hazardous waste with a capacity exceeding 50 tonnes per day involving physico-chemical treatment - Operation of DAF plant.

The installation is situated on the edge of an industrial estate in north east Leicester, with open fields on one side at national grid reference SK62610079. There is housing nearby and the Melton Brook runs along the western side of the site.

The tissue and towels are made from virgin pulp. This is done in two paper mills, which operate on a continuous basis and can produce up to 85,200 tonnes per annum (240 tonnes per day). PM2 has a larger capacity than PM1.

All raw materials are delivered by road. Pulp is stored either outside or inside and each paper mill has its own chemical store. The process uses large amounts of water, most of which is recycled. Process water is supplemented by potable town's water.

For each paper mill, the pulp is pulped in water to form a stock. The stock is then refined through mechanical refiners to develop fibre strength, combined with recovered pulp from other parts of the process, and is further diluted, cleaned and dosed with chemicals before being fed to the paper machine. Two layers of paper are formed at the machine from two separate stock feed tanks. Water is removed by gravity, then vacuum leaving a two ply paper sheet which is dried by a Yankee cylinder before being wound on to a reel. Wrapped reels are stored prior to conversion to products.

Water from the process is recycled where possible within the system. Some is directly re-used and some passes through a DAF clarifier. Flocculants are added to aid separation of the solids (fibres). The recovered solids are generally re-used in the process but are sometimes discharged to foul sewer. The installation does not have any further effluent treatment, the effluent is treated at the municipal sewage treatment works.

Drying of the paper is from direct contact with the hot surface of the Yankee cylinder (heated by steam from the boilers) and by direct heating of the paper on the cylinder with hot air from the hood heaters (burners). Each machine has its own hood heaters (2.6 MW thermal input on PM1 and 12.6 MW thermal input on PM2).

A natural gas boiler (13.2 MW thermal input) which is hydrogen ready (in the event that a hydrogen supply becomes available) provides steam supply for the manufacturing process, which releases from a 25m stack. Two back up boilers (each 9.5 MW thermal input and each producing 12 tonnes/hour steam) are capable of serving either paper mill. They are located together, and releases from both vent via a single 25m chimney. Regarding the hood burners, the spent hot air is exhausted out after heat recovery to conserve energy. The boilers and hood heaters operate with a non-interruptible gas supply.

There are several release points to air from the process areas which vent either just below the roof or from the roof. The general ventilation air from both paper machines goes through a mist eliminator with the releases from the wet end of the paper machines. Both paper machines have dust extraction systems installed. Releases to air include combustion products (sulphur dioxide (SO<sub>2</sub>), oxides of nitrogen (NO<sub>x</sub>), carbon monoxide (CO), particulates, paper dust and steam.

The schedules specify the changes made to the permit.

We consider that in reaching our decision to vary the permit we have taken into account all relevant considerations and legal requirements. We are satisfied that the permit will ensure that a high level of protection is provided for the environment and human health and that the activities will not give rise to any significant pollution of the environment or harm to human health.

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 BJ6780IL (EPR/BJ6780IL/A001)	20/02/01	Application for paper mill
Requests for further information	20/07/01 11/09/01	Response received
Permit determined BJ6780IL (EPR/BJ6780IL)	28/02/02	Permit issued
Variation application EPR/BJ6780IL/V002	30/04/07	Application received
Variation determined EPR/BJ6780IL/V002	13/06/07	Variation issued
Environment Agency Paper and Pulp Sector Review 2011 Variation ERP/BJ6780IL/V003 Additional information received	15/06/11	Including a change of Trading Name to Sofidel UK Limited
Environment Agency Paper and Pulp Sector Review 2011 Variation ERP/BJ6780IL/V003	12/09/11	Varied and consolidated permit issued in a modern format
EPR/BJ6780IL/V004 Response to Regulation 60 Notice dated 21/11/14	30/03/15	Technical standards detailed in response to the information notice Information to demonstrate that relevant BAT conclusions are met for the production of pulp, paper and board as detailed in document reference L284
Variation determined EPR/BJ6780IL/V004	22/08/16	Statutory review of permit - BAT Conclusions published 30 September 2014 Varied and consolidated permit issued

<b>Status log of the permit</b>		
<b>Description</b>	<b>Date</b>	<b>Comments</b>
Variation application EPR/BJ6780IL/V005	21/01/20	Duly made Replacement of PM1 dust extraction system Company registered address changed
Variation determined EPR/BJ6780IL/V005 (Billing ref: EPR/GP3001PM)	16/03/20	Variation issued
Variation application EPR/BJ6780IL/V006	31/08/23	Variation application for a new water mist removal system on PM2 and the installation of a new gas fired steam boiler (hydrogen ready).
Variation application duly made EPR/BJ6780IL/V006	09/04/24	Application duly made.
Variation application EPR/BJ6780IL/V006 additional information	22/05/24	Information to confirm ELV can be met for combustion of hydrogen in accordance with document 'Emission limit values for combustion of hydrogen. Guidance for emerging technology'.
Variation determined EPR/BJ6780IL/V006	12/07/24	Variation issued.
Application EPR/BJ6780IL/V007 (variation and consolidation)	Regulation 61 Notice response received 28/07/2024	Environment Agency initiated variation and consolidation following Medium Combustion Plant permit review.
Variation determined and consolidation issued EPR/BJ6780IL	18/12/24	Varied and consolidated permit issued.

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/BJ6780IL

### Issued to

**Sofidel UK Limited** (“the operator”)

whose registered office is

**Brunel Way  
Baglan Energy Park  
Briton Ferry  
Neath  
SA11 2FP**

company registration number **02245657**

to operate a regulated facility at

**Leicester Tissue Mill  
Waterside Road  
Hamilton Industrial Park  
Leicester  
LE5 1TZ**

to the extent set out in the schedules.

The notice shall take effect from 18/12/2024.

Name	Date
Beccy Brough	18/12/2024

Authorised on behalf of the Environment Agency

## Schedule 1

The following conditions were varied as a result of an Environment Agency initiated variation:

- Table S1.1, as referenced by conditions 2.1.1, 2.3.6 and 3.5.5, is amended to include details of MCP.
- Table S3.1, as referenced by conditions 3.1.1, 3.5.1 and 3.5.4, is amended to include Emission Limit Values and monitoring requirements in accordance with Annex II and Annex III of MCPD.
- Table S4.1, as referenced by condition 4.2.3, is amended to include an emission to air parameter.
- Table S4.3, as referenced by conditions 4.2.2 and 4.2.3, is amended to refer to the current emissions to air reporting form.
- Schedule 6, as referenced by condition 4.4.1, is amended to include additional interpretation.

The following conditions are added following an Environment Agency initiated variation:

- 2.3.6 For the following activities referenced in Schedule 1 Table S1.1 (AR3):
  - a) the operator must keep periods of start-up and shut down of the combustion plant as short as possible.
  - b) there shall be no persistent emission of 'dark smoke' as defined in section 3(1) of the Clean Air Act 1993.
- 3.5.5 For the following activities referenced in Schedule 1 Table S1.1 (AR3):
  - a) For existing MCP Monitoring measurements shall be carried out within four months of the issue date of this notice.
- 3.5.6 Monitoring of MCP shall not take place during periods of start-up or shut down.
- 4.1.3 The operator shall maintain a record of the type and quantity of fuel used and the total annual operating hours for each MCP.

## Schedule 2 – consolidated permit

Consolidated permit issued as a separate document.

# Permit

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

### Permit number

**EPR/BJ6780IL**

This is the consolidated permit referred to in the variation and consolidation notice for application EPR/BJ6780IL/V007 authorising,

**Sofidel UK Limited** (“the operator”),

whose registered office is

**Brunel Way  
Baglan Energy Park  
Briton Ferry  
Neath  
SA11 2FP**

company registration number **02245657**

to operate an installation at

**Leicester Tissue Mill  
Waterside Road  
Hamilton Industrial Park  
Leicester  
LE5 1TZ**

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

Name	Date
Beccy Brough	18/12/2024

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;
  - (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.

2.3.6 For the following activities referenced in Schedule 1 Table S1.1 (AR3):

- (a) the operator must keep periods of start-up and shut down of the combustion plant as short as possible.
- (b) there shall be no persistent emission of 'dark smoke' as defined in section 3(1) of the Clean Air Act 1993.

## **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.

### **3.2 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 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.

3.5.5 For the following activities referenced in Schedule 1 Table S1.1 (AR3):

- (a) For existing MCP Monitoring measurements shall be carried out within four months of the issue date of this notice.

3.5.6 Monitoring of MCP shall not take place during periods of start-up or shut down.

## 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.

4.1.3 The operator shall maintain a record of the type and quantity of fuel used and the total annual operating hours for each MCP.

### 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; and
- (b) the performance parameters set out in schedule 4 table S4.2 using the forms specified in table S4.3 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 S4.3 ; 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 (a)(i), or 4.3.1 (b)(i) where the information relates to the breach of a limit specified in the permit, 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 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.

4.3.4 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.

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

4.3.6 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 6.1 Part A(1)(b)	Producing, in industrial plant, paper and board where the plant has a production capacity of more than 20 tonnes per day.  Manufacture of tissue towel and toilet tissue products from virgin pulp on two paper machines.	From receipt and storage of pulp and other raw materials through specified activities (including stock preparation, approach flow system, paper machine, backwater system, hood heaters, drying and reeling operations), to storage and despatch of the tissue paper.
AR2	Section 5.4 Part A(1)(a)(ii)	Disposal of non-hazardous waste with a capacity exceeding 50 tonnes per day involving physico-chemical treatment.  Operation of Dissolved Air Flotation (DAF).	From receipt of mill effluent and boiler waters, associated sludge treatment to point of discharge to sewer.
<b>Directly Associated Activity</b>			
AR3	Steam supply from operation of a Schedule 25A Medium Combustion Plant	Operation of a natural gas (hydrogen ready) boiler (13.2MWth) which is a new MCP.  Operation of 2x natural gas boilers (9.5MWth each) both of which are existing MCP.	From receipt of natural gas to release of products of combustion to air.
AR4	Combustion	Burning gas in two direct fired hoods of 2.6MW and 12.6MW thermal input.	From combustion of fuel to release of exhaust gases to atmosphere.
AR5	Surface Water Drainage	Discharge of clean, uncontaminated site drainage.	From any point on site to entry to surface waters (Melton Brook).

<b>Table S1.2 Operating techniques</b>		
<b>Description</b>	<b>Parts</b>	<b>Date Received</b>
Application EPR/BJ6780IL/A001	The response to question 2.3 given in Annexe 2.3 of the application.	20/02/01
	Schedule 4 Notice Part 1 Response to questions 2.3 (a), (b) (c), (d), (e), (f), (g) and (h).	20/07/01
Response to Regulation 60 Notice dated 21/11/14	Technical standards detailed in response to BAT conclusions 1, 2, 5, 6, 7, 12, 17, 18, 47, 52 and 53 of the notice provided under Regulation 60 of Environmental Permitting Regulations.  Best available techniques as described in BAT conclusions under Directive 2010/75/EU of the European Parliament and of the Council on industrial emissions for production of pulp, paper and board.	30/03/15
Report for IC1 Sofidel UK EPR/BJ6780IL (updated)	All parts	Dated 20/01/20
Variation application EPR/BJ6780IL/V005	The response to 3a (Technical standards) in Part C3 of the application form.  Document 2, including maintenance schedule for fans.	21/01/20
Variation application EPR/BJ6780IL/V006	'Application Variation S4058-0320-0001JRS Supporting Information r1 V006 revised.pdf'. 'Application Variation BAT 17 Noise Additional Info.pdf'. 'Application Variation Updated emission points site plan 15012024'.	15/01/24

<b>Table S1.3 Improvement programme requirements</b>		
<b>Reference</b>	<b>Requirement</b>	<b>Date</b>
IC1	The Operator shall submit to the Environment Agency for approval, a report detailing the process monitoring required under Table S3.4 of this permit, for particulate emissions from non-combustion emission sources listed in table S3.1 of this permit. The submission shall make reference to techniques used to minimise and manage the release of particulate matter including; the source of particulate matter; available abatement/control measures; monitoring techniques/methods and inspection frequencies.	Complete
IC2	The operator shall submit for approval a site condition report (SCR) to meet the information requirements of Article 22(2) of the IED. The SCR shall include baseline conditions of soil and groundwater at the installation. This shall include the information necessary to determine the state of soil and groundwater contamination so as to make a quantified comparison with the state upon definitive cessation of activities provided for in Article 22(3) of the IED.	Complete



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

Table S2.1 Raw materials and fuels	
Raw materials and fuel description	Specification
-	-

## Schedule 3 – Emissions and monitoring

Table S3.1 Point source emissions to air – emission limits and monitoring requirements						
Emission point ref. & location Note 1	Source	Parameter	Limit (including unit)	Reference period	Monitoring frequency	Monitoring standard or method
A1	Boiler 1 and Boiler 2 (PM1 & PM2) operated on natural gas Note 2	Oxides of Nitrogen (NO and NO <sub>2</sub> expressed as NO <sub>2</sub> )	200 mg/m <sup>3</sup> Limit applies from 01/01/2025	Periodic	Every 3 years from date of acceptance of first monitoring measurements under condition 3.5.5	MCERTS BS EN 14792
		Carbon Monoxide (CO)	No limit set			MCERTS BS EN 15058
A4	Hood heater exhaust (PM1)	Oxides of Nitrogen (NO and NO <sub>2</sub> expressed as NO <sub>2</sub> )	No limit set	-	-	-
		Carbon Monoxide (CO)				
A9	Hood heater exhaust (PM2)	Oxides of Nitrogen (NO and NO <sub>2</sub> expressed as NO <sub>2</sub> )	No limit set	-	-	-
		Carbon Monoxide (CO)				
A10, A23	Pulper vents	-	-	-	-	-
A11, A22	Mist eliminator	-	-	-	-	-
A19	Dust extraction scrubber (PM2)	Particulates	No limit set	-	-	-
A12, A20	Vacuum pump Exhaust	-	-	-	-	-
A13, A15, A16, A21, A27	Emergency steam vents	-	-	-	-	-
A14	Vent from boiler room	-	-	-	-	-
A24, A25	Cooling towers	-	-	-	-	-
A26	Dust extraction scrubber (PM1)	Particulates	No limit set	-	-	-

Table S3.1 Point source emissions to air – emission limits and monitoring requirements						
Emission point ref. & location Note 1	Source	Parameter	Limit (including unit)	Reference period	Monitoring frequency	Monitoring standard or method
A28	Burner room vent	-	-	-	-	-
A29	Transformer room exhaust fan	-	-	-	-	-
A30	Workshop LEV exhaust fan	-	-	-	-	-
A31	Wet mist removal system (PM2)	-	No limit set	-	-	-
A32	Boiler 3 operated on natural gas Note 2	Oxides of Nitrogen (NO and NO <sub>2</sub> expressed as NO <sub>2</sub> )	100 mg/Nm <sup>3</sup>	In line with web guide: Monitoring stack emissions: low risk MCPs and specified generators Updated 4 June 2024.	Once within 4 months of the issue date of the permit or the date when the boiler is first put into operation, whichever is later, then every 3 years.	In line with web guide: Monitoring stack emissions: low risk MCPs and specified generators Updated 4 June 2024.
		Carbon Monoxide (CO)	No limit set			
	Boiler 3 operated on hydrogen Note 2	Oxides of Nitrogen (NO and NO <sub>2</sub> expressed as NO <sub>2</sub> )	137 mg/Nm <sup>3</sup>			
		Carbon Monoxide (CO)	No limit set			

**Note 1:** Emission points identified on site plan in Schedule 7 of this permit.

**Note 2:** Monitoring requirements are defined at a temperature of 273.15 K, a pressure of 101.3 kPa and after correction for the water vapour content of the waste gases at a standardised O<sub>2</sub> content of 6% for solid fuels, 15% for engines and gas turbines and 3% all other MCPs.

<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 On plan in Schedule 7 of this permit Surface water drainage system discharging into the Melton Brook	Uncontaminated surface water	No parameters set	No limit set	-	-	-

<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 <sup>Note 1</sup>	Site effluent treatment plant	Metals total and dissolved (Zn, Cu, Cd, Pb, Ni, Hg)	-	Spot sample	Twice per annum	BS EN ISO 15586 BS EN ISO 17294 BS EN ISO 17852 for Hg only
S1 <sup>Note 1</sup>	Site effluent treatment plant	Hazardous pollutants screen <sup>Note 2</sup>	-	Spot sample	Twice per annum	GCMS analysis at UKAS accredited laboratory

Note 1: Emission point on site plan in Schedule 7 of this permit, emission to Severn Trent Ltd sewer.

Note 2: Hazardous pollutants screen substances are: Chlorpyrifos, Cypermethrin, Endosulphan (A & B), 4- nonylphenols & Nonylphenol ethoxylates, PCP, TBT.

<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>
S1 <sup>Note 1</sup> on plan in Schedule 7 Emission to Severn Trent Ltd Sewer	Chemical oxygen demand (COD)	monthly	BS ISO 15705	Daily composite sample (flow proportional)
S1 <sup>Note 1</sup>	Total suspended solids (TSS)	monthly	BS EN 872	Daily composite sample (flow proportional)

Note 1: Emission point on site plan in Schedule 7 of this permit, emission to Severn Trent Ltd sewer.

## Schedule 4 – Reporting

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

<b>Table S4.1 Reporting of monitoring data</b>			
<b>Parameter</b>	<b>Emission or monitoring point/reference</b>	<b>Reporting period</b>	<b>Period begins</b>
Emissions to air (MCP) Parameters as required by condition 3.5.1	A1	Every 3 years from date of acceptance of first monitoring measurements under condition 3.5.5	1 January
Point source emissions to air Parameters as required by condition 3.5.1	A32	4 months from date of issue of permit and then every 3 years	1 January
Emissions to sewer Parameters as required by condition 3.5.1	S1	Every 6 months	1 January, 1 July

<b>Table S4.2 Performance parameters</b>			
<b>Parameter</b> <small>Note 1</small>	<b>Frequency of assessment</b>	<b>Units</b>	<b>Units</b>
Water inputs to the Mill <small>Note 1</small>	Annually	tonnes	m <sup>3</sup> /t
Water used in manufacturing <small>Note 1</small>	Annually	tonnes	m <sup>3</sup> /t
Other inputs of water/moisture <small>Note 1</small>	Annually	tonnes	m <sup>3</sup> /t
Water outputs <small>Note 1</small>	Annually	tonnes	m <sup>3</sup> /t
Waste/raw material inputs <small>Note 1</small>	Annually	tonnes	
Waste/raw material outputs <small>Note 1</small>	Annually	tonnes	
Net total annual production <small>Note 1</small>	Annually	tonnes	
Note 1: All to be monitored and reported in accordance with associated guidance note issued with variation EPR/BJ6780IL/V004.			

<b>Table S4.3 Reporting forms</b>		
<b>Media/parameter</b>	<b>Reporting format</b>	<b>Date of form</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
Sewer	Form sewer 1 or other form as agreed in writing by the Environment Agency	2016
Other performance indicators	Form performance 1 or other form as agreed in writing by the Environment Agency	2016

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

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

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

Name*	
Post	
Signature	
Date	

\* authorised to sign on behalf of the operator



## Schedule 6 - Interpretation

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

“ADt” means Air Dried Tonnes (of pulp) expressed as 90% dryness. ADt for paper should be reported at “normal” or average moisture content for the production over the course of any one year, noted but not corrected.

AOX is adsorbable organic halides measured according to the EN ISO:9562 standard method for waste waters.

“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.

“compliance date” means 01/01/2025 for existing MCPs with net rated thermal input of greater than 5MWth or 01/01/2030 for existing MCPs with a net rated thermal input of less than or equal to 5MWth.

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

“emissions to land” includes emissions to groundwater.

“EP Regulations” means The Environmental Permitting (England and Wales) Regulations SI 2010 No.675 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.

“existing medium combustion plant” means an MCP in operation before 20 December 2018.

“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

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

“medium combustion plant” or “MCP” means a combustion plant with a net rated thermal input equal to or greater than 1 MW but less than 50 MW.

“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, into the air from medium combustion plants, as read in accordance with Schedule 1A to the Environmental Permitting (England and Wales) Regulations 2016.

Metals monitoring as follows: Zn (Zinc), Cu (Copper), Cd (Cadmium), Pb (Lead), Ni (Nickel), Hg (Mercury).

Net production is as follows:

- (i) For paper mills: the unpacked, saleable production after the last slitter winder, i.e. before converting.
- (ii) For off-line coaters: production after coating.
- (iii) For tissue mills: saleable tonnes after the tissue machine before any rewinding processes and excluding any core.
- (iv) For market pulp mills: tonnage after packing (pulp at 90 % dryness, i.e. 'air dry' - AD).

(v) For integrated pulp mills: net pulp production refers to the tonnage after packing (pulp at 90 % dryness, i.e. AD) plus the pulp transferred to the paper mill (pulp calculated at 90 % dryness, i.e. air dry). For the net paper production of the integrated mill refer to (i)

“operating hours” means the time, expressed in hours, during which a combustion plant is operating and discharging emissions into the air, excluding start-up and shut-down periods.

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

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

Total nitrogen (Tot-N). Total nitrogen (Tot-N) given as N, The sum of organic nitrogen, free ammonia and ammonium (NH<sub>4</sub><sup>+</sup>-N), nitrites (NO<sub>2</sub><sup>-</sup>-N) and nitrates (NO<sub>3</sub><sup>-</sup>-N).

Total phosphorus (Tot-P). Total phosphorus (Tot-P) given as P, includes dissolved phosphorus plus any insoluble phosphorus carried over into the effluent in the form of precipitates or within microbes.

“Waste code” means the six digit code referable to a type of waste in accordance with the List of Wastes (England) Regulations 2005, or List of Wastes (Wales) Regulations 2005, as appropriate, and in relation to hazardous waste, includes the asterisk.

“Waste Framework Directive” or “WFD” means Waste Framework Directive 2008/98/EC of the European Parliament and of the Council on waste

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 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.

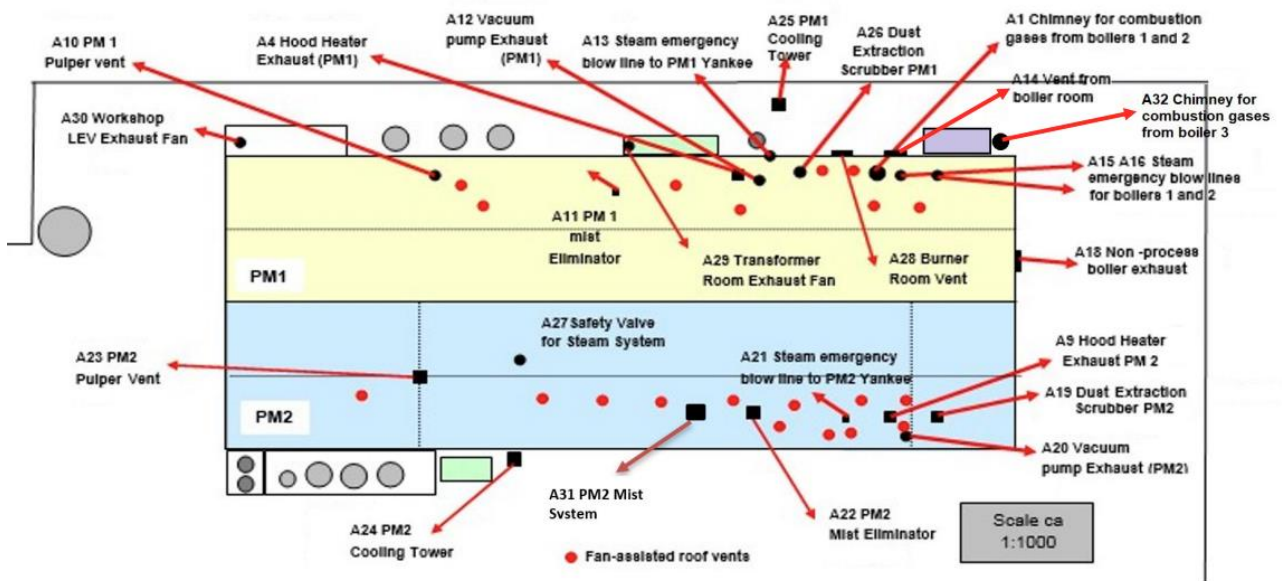
“year” means calendar year ending 31 December.

## Schedule 7 – Site plan



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# Emission points to air



END OF PERMIT