Permit with introductory note

The Environmental Permitting (England & Wales) Regulations 2016

McCormick (UK) Limited

McCormick Peterborough
Unit 5 Forli Strada
Alwalton Hill
Peterborough
PE7 3HH

Permit number

EPR/DP3720LF

McCormick Peterborough
Permit number EPR/DP3720LF

Introductory note

This introductory note does not form a part of the permit

The main features of the permit are as follows.

The installation manufactures hot and cold filled sauces, ketchups and condiments including ambient and chilled products for use by major food processes and retailers. Various packaging mediums are used including plastic, pots and thermoformed plastic cartons. Finished goods are transported from site and distributed by a third-party logistics company. The site is operational 24 hours a day, 7 days a week, 363 days a year and has the capacity to run a maximum of 12 kitchens, which is split between 9 non-emulsified kitchens (vegetable raw materials only) and 3 emulsified kitchens (animal and vegetable raw materials). The overall production capacity is 632 tonnes per day.

The activities are permitted under:

- Section 6.8A(1) (d) (ii) Treatment and processing, other than exclusively packaging, of the following raw materials, whether previously processed or unprocessed, intended for the production of food or feed (where the weight of the finished product excludes packaging) only vegetable raw materials with a finished product production capacity greater than 300 tonnes per day.
- Section 6.8 Part A(1)(d)(iii)(aa) Treatment and processing, other than exclusively packaging, of the following raw materials, whether previously processed or unprocessed, intended for the production of food or feed from animal and vegetable raw materials (other than milk only), both in combined and separate products, with a finished product production capacity in tonnes per day greater than 75 tonnes per day.
- 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.

The installation is located on the southern end of an industrial area with agricultural land to the south, in Peterborough with National Grid Reference TL 15420 93582.

The nearest sensitive human receptors are residential: Tollgate Farm which is roughly 590m southwest from the edge of the installation boundary and Kite Way which is roughly 580m east from the edge of the installation boundary, which has Windsor Crescent and Oliver Road further east as well as further residential receptors beyond. There are also residential human receptors to the west at Haddon Road and the north at Brudenell, Wingfield and beyond.

The site is roughly 281 metres west from Orton Pit SAC/SSSI and roughly 6.2km southwest from Nene Washes SAC/SPA/ Ramsar. There is a local wildlife site Chamber's Dole & Two Pond Coppice Woodland roughly 152m south of the site.

Site processes:

The production at the site is split between two main sauce mixing processes; emulsified and non-emulsified products. These are served by a common goods inwards area from which the raw materials are transferred to their relevant storage units.

Wet and dry ingredients are prepared separately before being mixed, filtered and either emulsified or pasteurised - depending on the product. The mixed product is sent to a holding tank prior to packing where it is filled into pots. The sauce packets are also manufactured on site and formed via film heating and cavity cooling.

Raw Materials Intake and Storage - Raw materials are delivered via bulk tanker, in drums, IBC’s, sacks, bags and smaller containers and are transferred to their applicable ambient, chilled or frozen storage units

for ingredients, the site also has a specific packaging storage unit. These are all temperature controlled depending on the function of the area. Entry of personnel and delivery of materials is strictly controlled.

There are a number of bulk storage units on site. All bulk tanks are within an enclosed tank farm that is part of the main factory unit, the indoor setting provides containment measures for all tanks in this area. Receipt of all materials is controlled, and spill kits are stored at point of receipt. The tanks contain process hot water, acetic acid, spirit vinegar, lactic acid, rapeseed oil, isosweet (a glucose/ fructose blend), red wine vinegar, glucose and caustak 25. Within the enclosed space are two separate internal bunds ensuring complete separation between acidic and alkali based materials. Stainless steel bulk tanks storing sugar and starch (powders) are stored externally. Adequate tertiary containment in the area surrounding the tanks provides appropriate containment measures in the unlikely event of a loss of containment.

Chemicals are stored externally on the southside of the Site boundary; they are in roofed containers and on bunded platforms providing secondary containment. The chemicals are held in tanks or within IBC's and are all delivered in IBC's.

Raw Materials Preparation (wet and dry) - Raw materials are removed from their packaging and weighed as per the product specification into Euro bins, buckets, bins or powder hoppers and held until mixing. The buckets are segregated and marked up for traceability and allergen purposes. Any packaging is removed from the area for segregation, baling and disposal via a third-party licensed waste disposal contractor.

Product Mixing emulsified - For products that require emulsifying, the wet and dry ingredients are first mixed separately. Dry ingredients are mixed, cooked, cooled and filtered before being transferred to a gum or vegetable phase holding tank. Wet ingredients are mixed in an aqueous preparation tank and filtered. Once both the wet and dry ingredients are filtered, the products are transferred to an emulsion tank to be homogenized, at this stage water and bulk liquid ingredients are added, as required as part of the recipe, and metered directly from the site's towns water supply or bulk tank farm. Once the emulsion process is complete, the product is transferred to a main holding tank and transferred to the packing line.

Product Mixing non-emulsified - Ingredients for non-emulsified products are transferred from their holding tanks to a mixing tank. Once mixed, the product is filtered and passed through pasteurisation holding tubes. The product is then transferred into a cooked buffer storage tank before being passed through cooking holding tubes and transferred to a holding tank for packaging.
Product Mixing – Waste Generated & CIP - Across both the emulsified and non-emulsified product lines tanks are cleaned via CIP cycles between a recipe change. Waste out can be generated at each stage of the process. Where there is any waste generated, it is removed from the area, segregated appropriately and removed from site via a licensed third-party waste disposal contractor. The site also crushes stainless steel drums prior to being collected by a certified waste carrier. The drums that are delivered to site contain tomato paste, a common ingredient for the product lines used.

Packing, palletisation & dispatch - The site manufactures the packaging for their products from base films. The film is heated before being passed through pot forming with cavity coding machinery. The pots, bottles or cartridges used to package the product are then air rinsed before being filled with the product. UV light is applied to the filled pot before the top film is applied and sealed. Individual pots are then punched before being x-rayed and packed into casing, labelled and placed on pallets for dispatch to customer.

Process Heat – Process heat is supplied by two natural gas-powered boilers which class as new Medium Combustion Plant (MCP): 2 x 4.2MWth natural gas fired Cochran boilers (A1 & A2).

The site also has a new MCP formed by 2 x 0.61MWth natural gas Fulton steam boilers (A6 & A7 form an MCP as shared stack).

The site also has the following plant which are not MCP:

- 2 x 0.12MWth natural gas Lochinvar boilers with shared flue (A3)
- 2 x 0.61MWth natural gas Fulton steam boilers (A4, A5)
- 2 x 0.388MWth natural gas water heaters (domestic use only, therefore not listed in table S1.1 or table S3.1)

Process Cooling - The process chillers consist of two ammonia plants both with a secondary glycol loop. They are used on Site to facilitate the cooling of ingredients and products that require refrigeration. 300kg of ammonia is utilised over five systems with a further 100kg stored. The Site the plants are maintained by the sites retained facilities external contractor. There are also a number of comfort cooling units that service office spaces, as with the process chillers, upkeep and maintenance of these units is completed by the retained facilities external contractor. McCormick is aware of the phase out of F-gas use; systems are under maintenance contracts and only compliant gases are used where top-up is required and for system replacement.

Effluent Plant Operation - The site has an effluent treatment plant which processes all wastewater from production before it is discharged to Flag Fen Wastewater Treatment Works. This consists of drum screening, pH balancing, chemical dosing, flocculation, coagulation, final treatment via DAF (dissolved air flotation) plant then via correction tank. The DAF and all process chemicals are contained within the building, and the balance tanks and waste storage is contained in a bunded enclosure outside of the main building. The system has an inbuilt 12-hour headroom capacity to allow for emergency circumstances such as management of catastrophic spills. The plant has been installed in line with BAT requirements including primary, secondary, and tertiary containment design in line with CIRIA C736, high level indicators, together with procedures including delivery, PPM, and regular visual inspection.

The site has an Environment Management System which the operator confirmed will incorporate all the requirements of BAT and that they have read the guidance and their management system will meet our requirements.

The site has odour abatement as detailed in their Odour Management Plan consisting of:

- An activated carbon filter on the sludge tank and the balance tanks.
- A Forbes Bulk Tank Vent Scrubber is linked to the acetic acid and lactic acid bulk tanks, located at S3, this absorbs odour arising from these materials and emits uncontaminated air from emission point A8.

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

Status log of the permit		
Description	**Date**	**Comments**
Application EPR/DP3720LF/A001	Duly made 16/12/2024	Application for bespoke installation permit for hot and cold filled sauces, ketchups and condiment making facility.
Additional information received	28/05/2025	Updated forms B2 and B6 received and confirmation of use of water heaters and what phase of building work the application is based on. Further detail provided in relation to odour abatement
Additional information received	04/07/2025	Confirmation of site emission points, updated site plan provided, confirmation of use of boilers and water heaters as well as capacities. Confirmation in relation to BAT 5 that the site does not dry dairy products. Confirmation MCP permit EPR/WE2681AB/V002 will be surrendered, as MCP is being incorporated into this permit.
Additional information received	18/07/2025 & 25/07/2025	Operator confirmation of kitchen line usage undertaken at site 18/07/2025 and our confirmation 25/07/2025 what scheduled activities these classify as.
Additional information received	31/07/2025	Updated Air Quality Assessment and surface water risk assessment.

Status log of the permit		
Description	**Date**	**Comments**
Additional information received	27/08/2025	Updated odour management plan in response to section 3B, Table 4 – General Requirements, Part B3 of the application form. Updated BAT document. Updated main application document- updated in relation to containment.
Additional payment received	09/09/2025	Further payment to capture all activities
Additional information received	10/10/2025	Updated OMP, updated BAT, updated site plan, raw data that informed their average effluent flow rate provided.
Additional information received	03/02/2026	Updated site plan provided, confirmation regarding drum crushing, emission points and site process steps undertaken.
Permit determined EPR/DP3720LF	04/02/2026	Permit issued to McCormick (UK) Limited.

End of introductory note

Permit

The Environmental Permitting (England and Wales) Regulations 2016

Permit number

EPR/DP3720LF

The Environment Agency hereby authorises, under regulation 13 of the Environmental Permitting (England and Wales) Regulations 2016

McCormick (UK) Limited ("the operator"),

whose registered office is

Exchange Tower
19 Canning Street
Edinburgh
Scotland
EH3 8EH

company registration number SC015262

to operate an installation at

McCormick Peterborough
Unit 5 Forli Strada
Alwalton Hill
Peterborough
PE7 3HH

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

Name	Date
Beccy Brough	**04/02/2026**

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 For the following activities referenced in schedule 1, table S1.1 (AR4):

(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.

3.4 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, 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 (AR4) the first monitoring measurements shall be carried out within four months of the issue date of the permit or of the date when the MCP is first put into operation, whichever is later.

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

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.

4.1.3 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;

(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 the operator shall notify the Environment Agency, as soon as is practicable, in writing of any change of MCP at the specified location.

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 6.8A(1)(d)(ii)	Treatment and processing, other than exclusively packaging, of the following raw materials, whether previously processed or unprocessed, intended for the production of food or feed (where the weight of the finished product excludes packaging) only vegetable raw materials with a finished product production capacity greater than 300 tonnes per day.	From receipt of raw materials through to dispatch of hot and cold filled sauces, ketchups and condiments. Production capacity is limited to 382 tonnes per day.
AR2	Section 6.8 Part A(1)(d)(iii)(aa)	3 kitchen lines of: 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 from animal and vegetable raw materials (other than milk only), both in combined and separate products, with a finished product production capacity in tonnes per day greater than 75 tonnes per day.	From receipt of raw materials through to dispatch of hot and cold filled sauces, ketchups and condiments. Production capacity is limited to 250 tonnes per day.
AR3	Section 5.4 Part A(1)(a)(ii)	Disposal of non-hazardous waste in a facility with a capacity exceeding 50 tonnes per day by physico-chemical treatment.	From generation of wastewater, to treatment and discharge to foul sewer. Effluent treatment including: drum screening, pH balancing, chemical dosing, flocculation, coagulation, and final treatment via DAF (dissolved air flotation) plant then via correction tank.
Directly Associated Activity			
AR4	Steam supply	New MCP: 2 x 4.2MWth natural gas fired Cochran boilers (A1 & A2) 2 x 0.61MWth natural gas Fulton boilers (A6 & A7	From receipt of fuel to release of products of combustion to air. No limit to operating hours.

Table S1.1 activities			
Activity reference	**Activity listed in Schedule 1 of the EP Regulations**	**Description of specified activity**	**Limits of specified activity**
		form an MCP as shared stack) Non MCP: 2 x 0.12MWth natural gas Lochinvar boilers with shared flue (A3) 2 x 0.61MWth natural gas Fulton boilers (A4, A5)	
AR5	Raw material storage and handling	Storage and handling of raw materials at the installation	From receipt of raw materials to dispatch of final product.
AR6	Use of refrigerants	Use of refrigerants in cooling, chilling and/or freezing systems at the installation.	From receipt of raw materials to dispatch of final product.
AR7	Storage and use of chemicals and oils	Storage and use of chemicals and oils at the installation.	From receipt of chemicals and oils to disposal of wastes arising.
AR8	Waste storage and handling	Storage and handling of waste materials	From generation of waste to storage pending removal for disposal or recovery. This includes crushing stainless steel drums (that contained ingredients used on site) prior to being collected by a certified waste carrier.
AR9	Process cooling waters	Operation of two cooling towers (ammonia plant)	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.

Table S1.2 Operating techniques		
Description	**Parts**	**Date Received**
Application	Main application document provided in response to section 3a – technical standards, Part B3 of the application form. Technical standards in relation to 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 the food, drink and milk industries BAT Conclusions Numbers: 1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12,13, 14, 15.	Duly Made 16/12/2024
Response to RFI	Updated form B2 and B6. Further detail provided in relation to odour abatement.	28/05/2025

Table S1.2 Operating techniques		
Description	**Parts**	**Date Received**
Response to RFI	Confirmation of site emission points, updated site plan provided, confirmation of use of boilers and water heaters as well as capacities. Confirmation in relation to BAT 5 that the site does not dry dairy products.	04/07/2025
Response to RFI	Operator confirmation of kitchen line usage undertaken at site 18/07/2025 and our confirmation 25/07/2025 what scheduled activities these classify as.	18/07/2025 & 25/07/2025
Response to RFI	Updated Air Quality Assessment and surface water risk assessment.	31/07/2025
Response to RFI	Updated odour management plan in response to section 3B, Table 4 – General Requirements, Part B3 of the application form. Updated BAT document. Updated main application document- updated in relation to containment.	27/08/2025
Response to RFI	Updated odour management plan approved, BAT 2 simplified process	10/10/2025
Operator response	Updated site plan provided, confirmation regarding drum crushing, emission points and site process steps undertaken.	03/02/2026

Table S1.3 Improvement programme requirements		
Reference	**Requirement**	**Date**
IC1	The operator shall submit a written plan to the Environment Agency for assessment and written approval. The plan/report must contain: • Details of how the surface water drainage infrastructure will be amended to ensure there is a means of shutting off the surface water outfall at the southern boundary which leads to the engineered flood retention pond. The operator must implement any proposals identified within the plan in accordance with the Environment Agency's written approval and within the approved timescales.	Within 3 months of permit issue.
IC2	The operator shall submit a written report to the Environment Agency for technical assessment and written approval. The report must contain: • Assessment of alternative cleaning products to hazardous substances used on site (including quantities used) and assessment of operational techniques. The operator shall implement the proposals in the report in line with the timescales as agreed in writing with the Environment Agency.	Within 6 months from permit issue.

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 (4.2MWth Cochran boiler) A2 (4.2MWth Cochran boiler) [Point A1 and A2 on site plan in Schedule 7]	2 x 4.2MWth natural gas fired boilers which are new MCP	Oxides of Nitrogen (NO and NO_2 expressed as NO_2)	100 mg/m^3	Periodic	Every three years	MCERTS BS EN14792
		Carbon monoxide	No Limit	Periodic	Every three years	MCERTS BS EN15058
A3 (2 x 0.12MWth Lochinvar boilers with shared flue)	2 x 0.12MWth natural gas fired boilers	No parameters set	No limit set	-	-	-
A4 (0.61MWth (Fulton boiler) A5 (0.61MWth Fulton boiler)	2 x 0.61MWth natural gas fired boilers	No parameters set	No limit set	-	-	-
A6 & A7 (2 x 0.61MWth Fulton boilers with shared flue)	2 x 0.61MWth natural gas fired boilers which form a new MCP	Oxides of Nitrogen (NO and NO_2 expressed as NO_2)	100 mg/m^3	Periodic	Every three years	MCERTS BS EN14792
		Carbon monoxide	No Limit	Periodic	Every three years	MCERTS BS EN15058
A8	Lactic and acetic Scrubber	No parameter set	No limit set	--	--	--
A9 - A18	Steam Release Valves	No parameter set	No limit set	--	--	--
A19	Compressors Exhaust Vent	No parameter set	No limit set	--	--	--
A20 – A36	HVAC mains & DC office vents	No parameter set	No limit set	--	--	--
A37- A44	HVAC factory vents	No parameter set	No limit set	--	--	--
A45 - A47	Compressors Exhaust Vent	No parameter set	No limit set	--	--	--

Table S3.2 Point Source emissions to water (other than sewer) and land – emission limits and monitoring requirements						
Emission point ref. & location	**Source**	**Parameter**	**Limit (incl. unit)**	**Reference Period**	**Monitoring frequency**	**Monitoring standard or method**
W1 [Point W1 on site plan in schedule 7] emission to surface water attenuation pond	Uncontaminated Surface water via interceptor	No parameters 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 [S1 on site plan in schedule 7] emission to Flag Fen Wastewater Treatment Works	Treated process effluent from onsite effluent treatment plant	No parameters set	No limit set	--	--	--

Schedule 4 – Reporting

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

Table S4.1 Reporting of monitoring data			
Parameter	**Emission or monitoring point/reference**	**Reporting period**	**Period begins**
Point source emissions to air Parameters as required by condition 3.5.1	A1, A2, A6 & A7 (New MCP)	First monitoring undertaken in accordance with Condition 3.5.5 to be reported within 3 months, and then every 3 years thereafter.	From first monitoring requirements in accordance with Condition 3.5.5

Table S4.2: Annual production/treatment	
Parameter	**Units**
Total product produced	tonnes
Effluent treated	m^3

Table S4.3 Performance parameters		
Parameter	**Frequency of assessment**	**Units**
Water usage	Annually	m^3
Energy usage	Annually	MWh
Waste – recovery/disposal routes	Annually	tonnes
Food waste	Annually	tonnes
Other performance parameters	Annually	tonnes per production unit

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

Schedule 5 – Notification

These pages outline the information that the operator must provide.

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

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

Part A

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

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

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

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

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

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

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

Part B – to be submitted as soon as practicable

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

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

Name*	
Post	
Signature	
Date	

* authorised to sign on behalf of the operator

Schedule 6 – Interpretation

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

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

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

“disposal” means any of the operations provided for in Annex I to the Waste Framework Directive.

“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.

“existing MCP” means an MCP first put into operation before 20/12/2018.

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

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

“Hazardous waste” has the meaning given in the Hazardous Waste (England and Wales) Regulations 2005.

“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.

“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.

“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.

“new MCP” means an MCP first put into operation on or after 20/12/2018.

“Pests” means Birds, Vermin and Insects.

“recovery” means any of the operations provided for in Annex II to the Waste Framework Directive.

“Waste Framework Directive” or “WFD” means Waste Framework Directive 2008/98/EC of the European Parliament and of the Council on waste, as read in accordance with Schedule 1A to the Environmental Permitting (England and Wales) Regulations 2016.

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

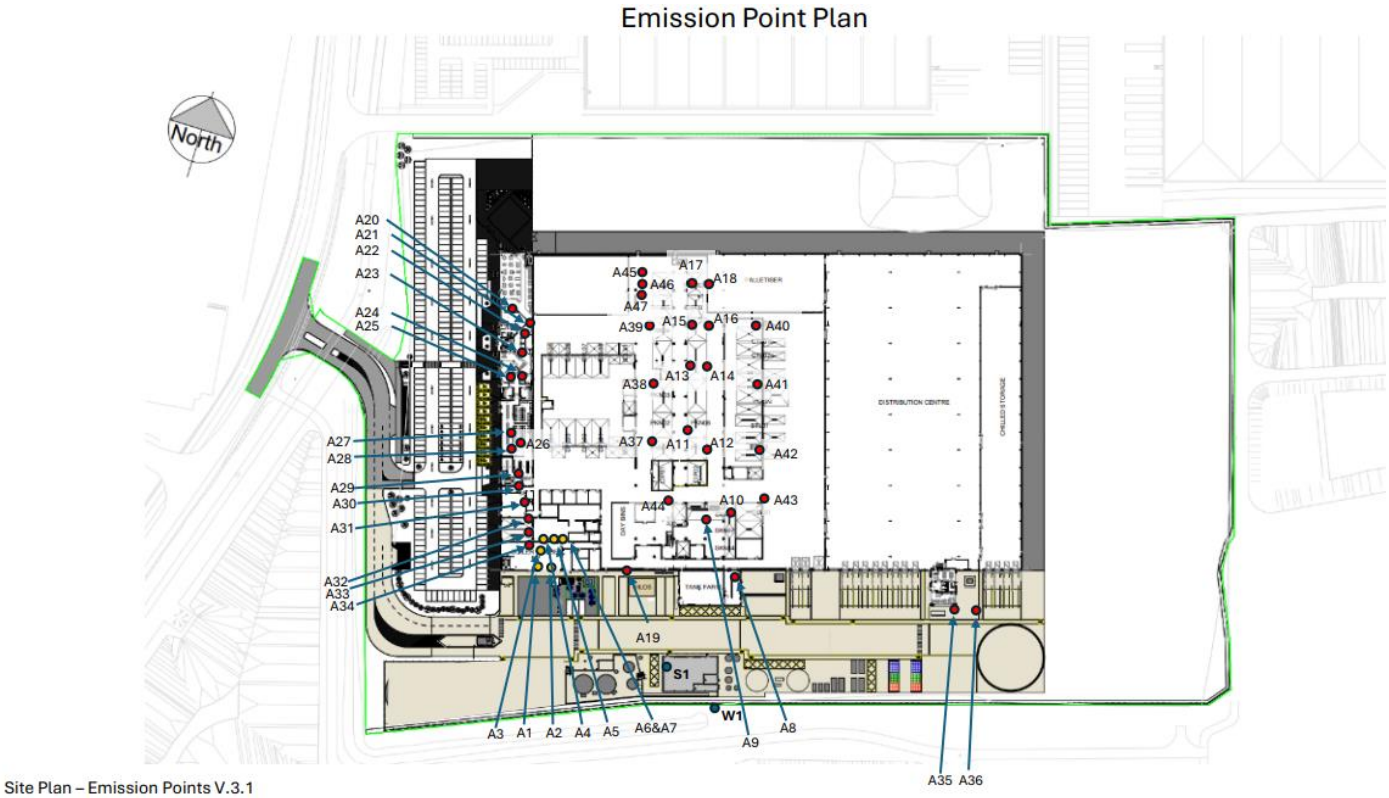
Unless otherwise stated, any references in this permit to concentrations of substances in emissions into air means:

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

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

“year” means calendar year ending 31 December.

Schedule 7 – Site plan



Site Plan – Emission Points V.3.1

END OF PERMIT

Emissions to Air Reporting Form

Permit number: EPR/DP3720LF **Operator:** McCormick (UK) LIMITED

Facility name: McCormick Peterborough **Emissions to Air Reporting Form: version 1, 08/03/2021**

Reporting of emissions to air for the period from *[DD/MM/YY]* to *[DD/MM/YY]*

Emission point	Substance / parameter	Emission Limit Value	Reference period	Test method [1]	Result [2]	Sample dates and times [3]	Uncertainty [4]
[e.g. A1]	*[e.g. Oxides of nitrogen (NO and NO_2 expressed as NO_2)]*	*[e.g. 200 mg/m^3]*	*[e.g. daily average]*	*[e.g. BS EN 14181]*	*[State result]*	*[State relevant dates and time periods]*	*[State uncertainty if not 95% confidence interval]*

Signed: *[Name]* **Date:** *[DD/MM/YY]*

(Authorised to sign as representative of the operator)

Guidance for use: Use this form to report your monitoring results.
Example text is shown in bracketed grey italics. Replace the example text by entering your own site specific information. Complete columns 1 to 5 using the information from schedule 3 of your permit. Complete columns 6 to 8 with your monitoring data. Add additional rows as necessary.

[1] Where an internationally recognised standard test method is used, give the reference number. Where another method that has been formally agreed with the Environment Agency, give the appropriate identifier. In other cases state the principal technique, for example gas chromatography.
[2] Give the result as the maximum value (or the minimum value in the case of a limit that is expressed as a minimum) obtained during the reporting period, expressed in the same terms as the emission limit value. Where the emission limit value is expressed as a range, give the result as the 'minimum to maximum' of the measured values.
[3] For non-continuous measurements give the date and time of the sample that produced the result. For continuous measurements give the percentage of the process operating time covered by the result.
[4] Complete if the uncertainty associated with the result is not a 95% confidence interval. Leave blank for 95% confidence intervals.

Food Waste Reporting Form

Permit number: **EPR/DP3720LF** **Operator:** McCormick (UK) LIMITED

Facility name: **McCormick Peterborough** **Food Waste Reporting Form: version 1, 06/02/2023**

Reporting of food waste for the period from *[DD/MM/YY]* to *[DD/MM/YY]*

Overall food waste (tonnes)	
Food waste as % of product	
Food waste disposal routes	*As specified below*

Source	**Tonnage**
Redistribution for human consumption	
Animal feed	
Bio-based materials/biochemical processing (e.g. feedstock for other industrial products)	
Anaerobic digestion/codigestion	
Composting/aerobic processes	
Incineration/controlled combustion	
Land application	

Landfill	
Sewer/wastewater treatment *(e.g. as COD)*	
Other (Please specify)	

Signed: **[Name]** **Date:** **[DD/MM/YY]**

(Authorised to sign as representative of the operator)

Guidance for use: Use this form to report your food waste metrics.

Example text is shown in bracketed grey italics. Replace the example text by entering your own site specific information.

Rationale: Avoidance of food waste is a key issue for the sector, both nationally and globally, and is subject to a United Nations Sustainable Development Goal: SDG 12.3: “By 2030, halve per capita global food waste at the retail and consumer levels and reduce food losses along production and supply chains, including post-harvest losses”.

This complements Defra’s Food and drink waste hierarchy: deal with surplus and waste - GOV.UK (www.gov.uk) and WRAP’s Target Measure Act Initiative.

Reporting of food waste should be to a set methodology such as the global Food Loss and Waste Accounting and Reporting Standard (FLW standard).

Water Usage Reporting Form

Permit number: EPR/DP3720LF

Operator: McCormick (UK) LIMITED

Facility name: McCormick Peterborough

Water Usage Reporting Form: version 1, 08/03/2021

Reporting of water usage for the year *[YYYY]*

Water source	Water usage (m^3)	Specific water usage (m^3/unit) [2]
Mains water	*[insert annual usage in m^3 where mains water is used]*	*[insert annual usage in m^3/unit where mains water is used]*
Site borehole	*[insert annual usage in m^3 where water is used from a site borehole]*	*[insert annual usage in m^3/unit where water is used from a site borehole]*
River abstraction	*[insert annual usage in m^3 where abstracted river water is used]*	*[insert annual usage in m^3/unit where abstracted river water is used]*
Other – *[specify other water source where applicablel. Add extra rows where needed]*	*[insert annual usage in m^3 where applicable]*	*[insert annual usage in m^3/unit where applicable]*
Total water usage	*[insert total annual water usage in m^3]*	*[insert total annual water usage in m^3/unit]*

Operator's comments

Signed: *[Name]* **Date:** *[DD/MM/YY]*

(Authorised to sign as representative of the operator)

Guidance for use: Use this form to report your annual water usage.
Example text is shown in bracketed grey italics. Replace the example text by entering your own site specific information. Add additional rows as necessary.

Energy Usage Reporting Form

Permit number: EPR/DP3720LF

Operator: McCormick (UK) LIMITED

Facility name: McCormick Peterborough

Energy Usage Reporting Form: version 1, 08/03/2021

Reporting of energy usage for the year *[YYYY]*

Energy source	Energy consumption / production (MWh)	Specific energy consumption (MWh/unit) [2]
Electricity imported as delivered - source [specify source, e.g. supplied from the national grid]	*[insert annual consumption in MWh where electricity is imported]*	*[insert annual consumption in MWh/unit where electricity is imported]*
Electricity imported as primary energy 1 – conversion factor of [specify conversion factor used to convert electricity delivered to primary energy]	*[insert annual consumption in MWh where electricity is imported]*	*[insert annual consumption in MWh/unit where electricity is imported]*
Natural gas	*[insert annual consumption in MWh where natural gas is used]*	*[insert annual consumption in MWh/unit where natural gas is used]*
Gas oil – conversion factor of [specify conversion factor used to convert tonnes to MWh]	*[insert annual consumption in MWh where gas oil is used]*	*[insert annual consumption in MWh/unit where gas oil is used]*
Imported heat	*[insert annual consumption in MWh where heat is imported]*	*[insert annual consumption in MWh/unit where heat is imported]*
Other – *[specify other energy source and conversion factors where applicable, e.g. renewable fuel. Add extra rows where needed]*	*[insert annual consumption in MWh where applicable]*	*[insert annual consumption in MWh/unit where applicable]*
Electricity exported	*[insert annual production in MWh where electricity is exported]*	Not applicable
Heat exported	*[insert annual production in MWh where heat is exported]*	Not applicable

Operator's comments

Signed: *[Name]* **Date:** *[DD/MM/YY]*

(Authorised to sign as representative of the operator)

Guidance for use: Use this form to report your annual energy usage.
Example text is shown in bracketed grey italics. Replace the example text by entering your own site specific information. Add additional rows as necessary.

[1] Multiply delivered electricity by 2.4 to convert to primary energy where the electricity is supplied from the national grid. If the electricity is supplied from another source, specify the conversion factor used. Add additional rows as needed if electricity is imported from multiple sources.
[2] Divide energy consumption by an appropriate unit of raw material processed or product output.

Other Performance Parameters Reporting Form

Permit number: EPR/DP3720LF **Operator:** McCormick (UK) LIMITED

Facility name: McCormick Peterborough **Other Performance Parameters Reporting Form: version 1, 08/03/2021**

Reporting of other performance parameters for the period from *[DD/MM/YY]* to *[DD/MM/YY]*

Parameter	Units
[e.g. Total raw material usage]	*[e.g. tonnes per production unit]*
Total product produced	tonnes
Effluent treated	m^3
COD efficiency	COD te/te product
Waste sent for recovery (specify route)	tonnes
Waste sent for recycling (specify route)	tonnes
Total product waste sent for disposal (specify route)	tonnes

Operator's comments

Signed: *[Name]* **Date:** *[DD/MM/YY]*

(Authorised to sign as representative of the operator)

Guidance for use: Use this form to report the performance parameters (other than water and energy) required by your permit.
Example text is shown in bracketed grey italics. Replace the example text by entering your own site specific information. The parameters to report and units to be used can be found in the 'Performance parameters' and 'Annual production/treatment' tables in schedule 4 of your permit. Add additional rows as necessary.