Notice: Grant of Permit

This permit has been granted by the Scottish Environment Protection Agency (SEPA) in exercise of its powers under Regulation 13 of the Pollution Prevention and Control (Scotland) Regulations 2012.

Permit number:	PPC/A/1198070
Operator:	Graham's, The Family Dairy Ltd SC312966 Airthrey Kerse Dairy Henderson Street Bridge of Allan Stirlingshire FK9 4RW
Date of issue:	9 March 2022
Permitted activities:	The operation of an installation where the following activities are carried out: "treating and processing milk, the quantity of milk received being more than 200 tonnes per day and any directly associated activities, as further detailed in this permit.
Site location:	Airthrey Kerse Dairy Henderson Street Bridge of Allan Stirlingshire FK9 4RW
Conditions applicable to this permit:	The conditions contained in the schedules of this permit. Terms used in this permit are, unless otherwise specified, defined in the Interpretation of Terms schedule.

INTERPRETATION OF TERMS

For the purposes of this Permit, and unless the context requires otherwise, the following definitions shall apply:

"Authorised Person" means a person who is authorised in writing under Section 108 of the Environment Act 1995 to carry out duties on behalf of SEPA;

"Climate Change Agreement" has the same meaning as in Section 46 of the Finance Act 2000;

"Controlled Waters" has the same meaning as in Section 30 A of the Control of Pollution Act 1974 (as amended);

"Emission" has the same meaning as in the Regulations

"Engine" means gas engine.

"Gas engine" means an internal combustion engine which operates according to the Otto cycle and uses spark ignition to burn fuel;

"hazardous substance" means substances or mixtures as defined in Article 3 of Regulation (EC) No 1272/2008 of the European Parliament on classification, labelling and packaging of substances and mixtures;

"incident" means any of the following situations:

- Where an incident occurs which has caused or may have the potential to cause Pollution;
- Where any malfunction, breakdown or failure of plant or techniques is detected which has caused or may have the potential to cause pollution;
- Where any substance, vibration, heat or noise specified in any Condition of this Permit is detected in an Emission from a source not authorised by a Condition of this Permit and in a quantity which may cause Pollution;
- Where an Emission of any Pollutant not authorised to be released under any condition of this Permit is detected;
- Where an Emission of any substance, vibration, heat or noise is detected that has exceeded, or is likely to exceed, or has caused, or is likely to cause to be exceeded any limit on Emissions specified in a Condition of this Permit.

"Location Plan" means the plan attached as Appendix 2;

"medium combustion plant" means A combustion plant with a rated thermal input equal to or greater than 1 megawatt but less than 20 megawatts;

"nitrogen oxides y(NO_x)" means the sum of nitrogen oxide and nitrogen dioxide and the mass concentration or mass of NOx is expressed as the equivalent nitrogen dioxide concentration;

"natural gas" means naturally occurring methane with no more than 20% (by volume) of inerts and other constituents;

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

“the Permitted Activities” are defined in Schedule 1 of this Permit;

“the Permitted Installation” is defined in Schedule 1 of this Permit and includes references the parts of the Permitted Installation;

“Pollutant” and “Pollution” have the same meaning as in the Regulations;

“rated thermal input” means The rate at which fuel can be burned at the maximum continuous rating of the appliance multiplied by the net calorific value of the fuel and expressed as megawatts thermal;

“SEPA” means the Scottish Environment Protection Agency;

“start-up and shut-down" as defined in the Commission Implementing Decision (2012/249/EU), OJ L 334, 17.12.2000, p.17;

“the Site” is defined in Schedule 1 of this Permit and ‘on-site’ and ‘off-site’ shall be interpreted accordingly;

“the Site Boundary” means the boundary of the site as shown in green on the Site Plan;

“Site Plan” means the plan attached as Appendix 1;

“the Regulations” means The Pollution Prevention and Control (Scotland) Regulations 2000;

Any reference to a group of Conditions, numbered Condition, Schedule, Table, Appendix, Figure or Paragraph is a reference to a group of Conditions, numbered Condition, Schedule, Table, Appendix, Figure or Paragraph bearing that number in the Permit;

Except where specified otherwise in this permit:

- “day” means any period of 24 consecutive hours;
- “week” means a period of 7 consecutive days;
- “month” means a calendar month:
- “year” means any period of 12 consecutive months.

And any derived words (e.g. “monthly”, “quarterly”) shall be interpreted accordingly; and Except where specified otherwise in this Permit, any reference to an enactment or statutory instrument includes a reference to it as amended (whether before or after the date of this Permit) and to any other enactment, which may, after the date of this Permit, directly or indirectly replace it, with or without amendment.

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1. THE PERMITTED INSTALLATION

1.1. Description of the Permitted Installation

1.1.1. The permitted installation to which this Permit applies ("the Permitted Installation") is the stationary technical unit specified in paragraph 1.1.4 ("the stationary technical unit"), where the activities specified in paragraph 1.1.3 are carried out ("the Activities") together with the directly associated activities specified in paragraph 1.1.5 ("the Directly Associated Activities"). The site and location of the Permitted Installation is delineated in red on the Site Plan ("the Site").

1.1.1.1. The site of the permitted installation is delineated in green on the Site Plan in Appendix 1 ("the site boundary").

1.1.2. The location of the Site is as shown delineated in red on the Location Plan in Appendix 2 and Site Plan in Appendix 1.

1.1.3. The Activities carried out at the Stationary Technical Unit are the treating and processing of milk, the quantity of milk received being greater than 200 tonnes per day, being an activity described in Paragraph (e) of Part A of Section 6.8 of Schedule 1 of the Regulations.

1.1.4. The Stationary Technical Unit comprises the following units:

1.1.4.1. The Dairy, comprising of:

a) Raw milk reception cooling and storage with associated chiller units

b) 1 milk processing line comprising of:
- Balance tank which regulates the flow through the process;
- Separator which produces the skim by separating the milk from the cream and removing impurities;
- Standardisation unit which reintroduces the appropriate quantity of cream into the skim depending on the product being produced;
- Homogenisation unit which distributes the cream evenly throughout the milk
- Pasteurisation unit to destroy pathogens;
- Bactofugation unit which removes bacteria spores from the milk.

c) 1 Cream processing line comprising of:
- Balance tank
- Separator which produces the skim by separating the milk from the cream and removing impurities.
- Pasteurisation unit.
- Skimmed milk line.
- Cream line
- Butter line
- Two block butter machines
- One spreadable machine

d) Chiller units which cool the pasteurised milk and pasteurised cream.

1.1.5. The following Directly Associated Activities are carried out on the Site:

1.1.5.1. Packaging of finished milk on HDPE bottle filler units filling 1, 2, 4 and 6 pint bottles with skimmed semi-skimmed and standardised whole milk.
1.1.5.2. Packaging of finished cream
1.1.5.3. Packaging of butter on two Benhill 250g block butter machines
1.1.5.4. Packaging of spreadable on one spreadable machine (250g and 500g size tubs)
1.1.5.5. Chilled product storage
1.1.5.6. Automated Cleaning in Place (CIP) system utilising acid, caustic and disinfection agents
1.1.5.7. Waste storage
1.1.5.8. An effluent collection system comprising of drains, sumps, tanks and pipes.
1.1.5.9. Boiler plant serving the dairy comprising of 2 x container packaged Gas steam boilers with each boiler rated at 860KW and which fire only natural gas.

1.1.5.10. An effluent treatment plant comprising:
a) effluent collection comprising drains, sumps and pipes.
b) Dissolved air flotation (DAF) Unit fitted with flowmeter and automatic shutdown;
c) An automatic chemical dosing system fitted with safety controls;
d) Sludge collection and mixing tank;
e) Balance tanks with related transfer pumps;
f) 3 Interceptor Chambers;
g) Sump Chamber;
h) Discharge Chamber;

1.1.5.11. Road tankers and refrigerated trailer units while on site; and

1.1.5.12. Tanker washing facilities

1.1.6. For the purposes of this Permit the activities and Directly Associated Activities shall be known together as “the Permitted Activities”.

2. STANDARD CONDITIONS

2.1. Administration

2.1.1. The operator shall have an appropriate person (and deputy) as the primary point of contact with SEPA and shall notify SEPA in writing of the name of the appointed person (and deputy) within 4 weeks of the date of this permit.

2.1.2. In the event of a different person being appointed to act as primary point of contact (or deputy) the operator shall notify SEPA in writing of the name of the appointed person or deputy without delay.

2.1.3. A copy of this permit shall be kept at the Permitted Installation and shall be made readily accessible for examination by all staff.

2.1.4. Any systems or procedures used by the operator to demonstrate compliance with a Condition of this Permit shall be recorded.

2.2. Records

2.2.1. All records made in compliance with this Permit shall be kept in a systematic manner.

2.2.2. Unless otherwise specified in a condition of this Permit, every record made in compliance with a Condition of this Permit shall be preserved for a period of not less than five years from the date of it being made. Every such record shall be kept at the Permitted Installation for not less than one year from the date of it's being made and thereafter preserved at a location, previously notified to SEPA in writing, if that location is not at the Permitted Installation.

2.2.3. All records shall be legible, and any amendment made to any record made in compliance with a Condition of this Permit shall be made in such a way as to leave the original entry clear and legible. The reason for each amendment shall be explained in the said record.

2.2.4. Without prejudice to Condition 2.2.2, all operator's records relevant operation and maintenance of the Permitted Installation shall be kept at the Permitted Installation for not less than one year from the end of the period to which they apply.

2.3. Reporting

2.3.1. Where any condition of this Permit requires information to be reported, report shall be forwarded to SEPA at the email address registry@sepa.org.uk and cc'd to fasp@sepa.org.uk, or to the address specified in the explanatory notes attached to this Permit by the date(s) or within the period or at the frequency specified in Table 2.1 appended to this schedule and, where appropriate the first report shall be due on the date specified in that Table. All such reports shall include the Permit number and the name of the operator.

Table 2.1 – Reporting Requirements

Summary of information to be reported	Condition	Date within period/frequency to be reported	Date first report due
Notification of appropriate person	2.1.1	Within 4 weeks of permit issue	N/A
Notification of a change of appropriate person	2.1.2	Without delay	N/A
Incident investigation report	2.4.6	Within 14 days of the date of the incident unless otherwise agreed in writing with SEPA	N/A
Resource utilisation	2.5.1	At least once every 4 years	31 January 2023
Systematic installation review	2.7.5	At least once every 4 years	31 January 2023
Groundwater and soil monitoring requirements	2.7.8	Within one month of the analysis being completed	
Groundwater and soil monitoring plan and methodology for monitoring	2.7.10	At least 6 months in advance of the monitoring being carried out	
Notification of cessation of Permitted Activities	2.9.2	No later than 2 months prior to the proposed date of cessation or as agreed in writing with SEPA	N/A
Noise and vibration assessment	3.1.1	At least once every 4 years	31 January 2023
Sampling report of effluent emissions at sampling point S2	4.2.8	Quarterly, within two weeks of the end of the quarter: 1 January to 31 March, 1 April to 30 June, 1 July to 30 September, 1 October to 31 December.	30 June 2023
Sampling plan	4.2.9	Annually	31 March 2022
Annual review of bunding, sumps, pipelines and storage areas	4.6.2	Yearly	31 January 2023
Spillage Plan	4.7.2	At least once every 4 years	30 June 2023

2.3.2. Where the Permitted Installation has not operated for the duration of any reporting period specified in Table 2.1, the Operator shall provide written notification to SEPA. This shall confirm that no reports have been made in terms of Condition 2.3.1 because the Permitted Installation has not operated during said period. Notifications shall be submitted within one month of the end of the reporting period concerned.

2.3.3. All notifications required by any Condition of this Permit shall be made to SEPA in the manner specified in that Condition to the address specified in the explanatory notes.

2.4. Incidents

2.4.1. In the event of an Incident all necessary measures shall immediately be taken:

- to prevent, or where that is not practicable to reduce, emissions from the Permitted Installation;
- to limit the environmental consequences as a result of that Incident; and
- to prevent further possible Incidents.

2.4.2. Without prejudice to the requirements of condition 2.11.1, in the event of a breach of any condition of this Permit the Operator shall immediately take the measures necessary to ensure that compliance is restored in the shortest possible time.

2.4.3. Notwithstanding the requirements of Condition 2.11.1 and 2.11.2 where a breach of any condition of this Permit or an Incident poses an immediate danger to human health, or threatens to cause an immediate significant adverse effect on the environment, the Operator shall suspend operation of the Permitted Installation or relevant part thereof until such time as it can be operated in compliance with this Permit.

2.4.4. In the event of an Incident and/or a breach of any condition of this Permit, the Operator shall notify SEPA by telephone without delay to 0800 80 70 60. A notification that relates to an Incident shall include as far as practicable the information specified in condition 2.11.5.

2.4.5. The Operator shall confirm any Incident to SEPA in writing by the next working day after the Incident. This confirmation shall include:

- The time and duration of the Incident;
- The receiving environmental medium or media where there has been any emission as a result of the Incident;
- An estimate of the quantity and composition of any emission;
- The measures taken to prevent or minimise any emission or further emission;
- An assessment of the cause of the Incident;
- Proposals for remediation (where appropriate); and
- Proposals for preventing a repetition of the Incident.

2.4.6 Any incident notified to SEPA shall be investigated by the Operator, and a report of the investigation sent to SEPA. The report shall detail, as a minimum, the circumstances of the incident, an assessment of any harm to the environment and the steps taken by the Operator to bring the incident to an end. The report shall also set out proposals for remediation, where necessary, and for preventing a repetition of the incident.

2.4.7 Within 6 months of the date of the Permit the Operator shall prepare, implement, and maintain an “Incident Prevention and Mitigation Plan”.

2.4.8 Following an Incident and at least every 4 years the Operator shall review the “Incident Prevention and Mitigation Plan” required under condition 2.4.6. Each review of the plan shall be recorded and where the Operator makes any revisions to the plan these revisions shall be recorded.

2.5. Resource Utilisation

2.5.1. At least every four years, the Operator shall carry out a systematic assessment to determine:

2.5.1.1. how and where raw materials (including water and fuel) and energy are used within the Permitted Installation;

2.5.1.2. the quantities of raw materials (including water and fuel) and energy used within the Permitted Installation;

2.5.1.3. how and where material losses and wastes are generated within the Permitted Installation;

2.5.1.4. the quantities of material losses and wastes are generated within the Permitted Installation;

2.5.1.5. how and where raw materials (including water) and energy can be utilised more efficiently within the Permitted Installation to reduce resource use and minimise material losses and waste; and

2.5.1.6. which of the resource efficiency measures identified in 2.2.1.5 will be implemented at the Permitted Installation during the 4 year assessment cycle.

2.5.2. The assessment required by condition 2.5.1 shall be recorded using the SEPA "systematic assessment of resource use and efficiency template" (IED-T-04), or an equivalent format as agreed by SEPA, and reported to SEPA as specified in Table 2.1.

2.5.3. The Operator shall implement the resource efficiency measures identified in the systematic assessment within the timescales specified in the systematic assessment.

2.5.4. The information required in 2.5.1.2 and 2.5.1.4 shall be recorded annually.

2.5.5. For the purposes of condition 2.5.1 "raw materials", "energy" and "fuel" shall, as a minimum, include the materials listed in Table 2.2.

2.5.6. In the event that the Permitted Installation ceases to be covered by a climate change agreement, the Operator shall provide written notification to SEPA within one month of such cessation.

Table 2.2 - Resource Utilisation Data Recording

Raw Material, Energy or Fuel	**Unit of Measurement**
Raw Milk	m^3
Mains Water	m^3
Product Packaging (excluding labels and shrink wrap)	Tonnes
Phosphoric Acid, Nitric Acid, Sodium Hydroxide	m^3
Peroxyacetic Acid/ Acetic Acid/ Hydrogen Peroxide Mix	m^3
Other Cleaning Chemicals	m^3
Water Treatment Chemicals for use in the Effluent Treatment Plant	Litres

Activated Carbon Filters	Kg
Gas	m^3
Refrigerant Gas	Kg
Gas Oil	m^3 & KWh
Selective Catalytic Reduction Agent	m^3
Electricity	KWh

2.6. Waste Management

2.6.1. The operator shall maintain a record of the location, estimated quantities and types of all waste stored within the Permitted Installation. The said record shall be updated weekly.

2.7. Protection of Soil and Groundwater

2.7.1. There shall be no emission of any Pollutants to groundwater or soil from the Permitted Installation.

2.7.2. The operator shall maintain a record of any incident that has, or might have, impacted on the condition of any soil or groundwater including the soil or groundwater under the site, either as a result of that incident or as a result of an accumulation of incidents, together with a record of any further investigation or remediation work carried out.

2.7.3. Notwithstanding the requirements of Condition 2.2.2, the record required by Condition 2.7.2 shall be preserved until this Permit is surrendered.

2.7.4. The Operator shall maintain plans that identify the configuration and specification of all drains and sub-surface pipework and the position and purpose of all sub-surface sumps and storage vessels that are used or have been used within the Site from the date of this Permit until the Permit is surrendered.

2.7.5. The operator shall at least every 4 years carry out a systematic inspection and review of the condition of the internal floors, external yard surfaces, bunding, foul drainage systems and process drains, the purpose of which shall be to ensure compliance with condition 2.7.1. Each assessment shall be recorded and reported to SEPA.

2.7.6. The Operator shall at least once per year carry out a systematic assessment and inspection of internal floors, external yard surfaces and bunding in order to ensure compliance with Condition 2.7.1.

2.7.7. Any remedial action or upgrade identified by the systematic assessment and inspection required by Conditions 2.7.5 and 2.7.6 shall be completed within 3 months of completion of the survey or within such a timescale as is agreed in writing with SEPA.

2.7.8. The operator shall monitor the groundwater and soil at the site for the relevant hazardous substances specified in table 2.3 at the frequency specified in table 2.3, the purpose of which shall be to identify groundwater and soil contamination associated with the activities specified in Table 2.3 by those relevant hazardous substances. Each assessment shall be recorded and reported to SEPA.

2.7.9. The assessment required by condition 2.7.8 shall include interpretation of the results with reference to previous monitoring undertaken (including the site and where applicable baseline reports) and operations at the permitted installation and details of corrective actions that are required to protect groundwater and soil and remedy any contamination that has occurred a result of permitted activities.

2.7.10. The operator shall submit a detailed groundwater and soil monitoring plan, for the monitoring required by conditions 2.7.8 to SEPA at least six months in advance of carrying out the monitoring, which shall include the locations at which monitoring shall be carried out and the methodology which shall be used.

2.7.11. The operator shall carry out the monitoring required by condition 2.7.8 in accordance with the groundwater and soil monitoring plan required by condition 2.7.10.

2.7.12. The operator shall review the plan required by Condition 2.7.10 no later than 6 months after each monitoring event. The purpose of the review shall be to determine whether any changes to monitoring locations, frequency or parameters are required and where changes are proposed, submit a revised plan to SEPA.

2.7.13. Notwithstanding the requirements of Condition 2.2 all plans, monitoring and assessments reports undertaken in accordance with Conditions 2.7.5, 2.7.8, and 2,7.10 shall be preserved until the permit is surrendered.

2.7.14. The operator shall maintain the groundwater monitoring wells detailed in the plan required in Condition 2.7.10 in a condition fit for purpose, unless otherwise agreed in writing with SEPA. Where a well's function is compromised it shall be repaired or replaced to allow sample collection in accordance with Conditions 2.7.8.

Table 2.3 – Groundwater and Soil Monitoring Requirements

<table>
<tr><th rowspan="2">Relevant hazardous substance</th><th colspan="3">Location</th><th colspan="2">Frequency</th></tr>
<tr><th>Borehole</th><th>Easting</th><th>Northing</th><th>Groundwater</th><th>Soil</th></tr>
<tr><td>Diesel</td><td colspan="3" rowspan="2">To be agreed in writing with SEPA as per condition 2.7.8</td><td rowspan="2">5 Years</td><td rowspan="2">10 Years</td></tr>
<tr><td>Lubricating Oil</td></tr>
</table>

2.8. Start Up

2.8.1. By 30 June 2022 The Operator shall prepare and maintain a plan ("the Start Up Plan") setting out the necessary steps to be taken by the operator prior to start up of operations of the Permitted Installation to ensure that all appropriate preventative measures are taken against Pollution and that no significant pollution is caused.

2.8.2. At least every 4 years, the Operator shall review the Start Up Plan required under Condition 2.8.1. Each review of the said Start Up Plan shall be recorded and where the Operator makes any revisions to the said plan, said revisions shall be recorded.

2.9. Decommissioning

2.9.1. By 30 June 2022 The Operator shall prepare and maintain a plan ("the De-commissioning Plan") for the decommissioning of the Permitted Installation. The De-commissioning Plan shall set out the steps to be taken by the operator after final cessation of the Permitted Activities.

2.9.2. The Operator shall notify SEPA in writing of its intention to cease the Permitted Activities, or any part thereof, for any period exceeding 12 months, no later than 2 months prior to the proposed date of cessation.

2.9.3. The Operator shall implement the De-commissioning Plan on final cessation of the Activities or any part thereof.

2.9.4. The Operator shall review, record, and where necessary, update the De-commissioning Plan as follows:

2.9.4.1. At least every 4 years; and

2.9.4.2. Where the Operator plans to make substantial change in the extent or nature of the Permitted Installation.

2.10. Sampling and Monitoring Facilities

2.10.1. Sampling measurement and monitoring facilities at the Permitted Installation shall conform to the requirements of the relevant test methods specified in any condition of the Permit or as otherwise agreed in writing with SEPA.

2.10.2. Unrestricted access to all sampling points required by any Condition of this Permit shall be provided at all times.

2.11. Staffing and Management

2.11.1. All staff engaged in carrying on the Permitted Activities shall be provided with adequate professional and technical development training and written operating instructions to enable them to carry out their duties.

2.11.2. The operator shall ensure that all staff engaged in carrying on the Permitted Activities are fully conversant with those aspects of the Permit Conditions which are relevant to their duties.

2.11.3. The operator shall maintain a record of the skills and training requirements for each job and shall keep records of all relevant training.

2.11.4. The permitted Installation shall be managed and supervised by appropriately qualified persons to ensure that the conditions of the Permit are being complied with.

3. CONDITIONS APPLYING TO THE PERMITTED INSTALLATION AS A WHOLE

3.1. Noise and Vibration

3.1.1. At least every 4 years or in the event of a significant change to the Permitted Installation, the Operator shall carry out a systematic assessment of noise and vibration Emissions associated with the Permitted Installation, the purpose of which shall be to identify methods of reducing noise and vibration Emissions. Each assessment shall be recorded and reported to SEPA.

3.2. Odour Conditions

3.2.1. All Emissions to air from the Permitted Installation shall be free from offensive odour, as perceived by an Authorised Person, outside the Site Boundary.

4. CONDITIONS APPLYING TO THE TREATING AND PROCESSING OF MILK

4.1. Air Emissions Conditions

4.1.1. All emissions to air arising from the Permitted Installation, other than steam or water vapour, shall be colourless and free from persistent mist, fume and droplets.

4.1.2. The Emissions to air specified in Table 4.1, as annexed in Appendix 4, shall be permitted only from the Emission locations specified in that Table and shall not exceed the limits for the parameters specified in the said Table.

4.2. Water and Effluent Discharge Conditions

4.2.1. There shall be no discharge to the surface water drainage system from the Permitted Installation other than uncontaminated surface water.

4.2.2. There shall be no discharge to the surface water drainage system via the sampling point S2, as shown in Appendix 3 – Sampling Point Location, from the Permitted Installation other than uncontaminated surface water.

4.2.3. All effluent from the Permitted Installation other than uncontaminated surface water shall be discharged to the effluent treatment system described in condition 1.1.5.10.

4.2.4. All effluent from the Dairy side of the Permitted Installation other than uncontaminated surface water shall be discharged to the effluent treatment system as shown in Appendix 3 – Sampling Point Location.

4.2.5. The emissions to the effluent treatment plant and surface water specified in Table 4.2 in Appendix 4, shall be permitted only from the emission points specified in that Table to the destinations specified in that Table and only after having passed the sample points specified in that Table.

4.2.6. Subject to Condition 4.2.3 and 4.2.4, no emission specified in Table 4.2 shall exceed the limit, or be out with the range, as appropriate, for the parameters specified in said Table.

4.2.7. Measurement and/or sampling of the Emissions in Table 4.2 shall be carried out by the Operator at the sampling locations specified in that Table subject to the requirements for monitoring specified in Table 4.3 as annexed as Appendix 4.

4.2.8. The date, time and results of all samples and measurements carried out in compliance with Condition 4.2.7 shall be recorded by the operator and reported.

4.2.9. A sampling plan shall be agreed in writing with SEPA and shall include, but not limited to, the parameters specified in Table 4.2, as annexed in Appendix 4, and shall be maintained and reviewed annually. The reviewed sampling plan shall be submitted to SEPA by 30 November annually.

4.3. Operation of Process

4.3.1. No person shall be permitted to operate the process unless the operator has formally notified the person that he is so permitted.

4.3.2. All plant, instrumentation and buildings used in carrying out the permitted activities, shall be maintained in proper working condition and subject to an effective preventative maintenance schedule which shall include:

4.3.2.1. Checking of significant components for correct operation;

4.3.2.2. Survey of pipes, tanks, drums, pumps and valves for leaks;

4.3.2.3. Checking and cleaning of filters, tanks and sumps;

4.3.2.4. Calibration of measuring equipment; and

4.3.2.5. Removing of deposits in any air handling extraction systems.

4.3.3. Maintenance, whether under a scheme of planned maintenance or consequent to a breakdown, shall be organised in such a way that releases to air, sewers or land of potentially polluting substances are minimised.

4.3.4. All maintenance carried out shall be recorded in writing detailing the date, time, maintenance carried out, and the person carrying out the maintenance.

4.4. Permit Compliance Plan

4.4.1. The Operator shall prepare, record, and implement works operating procedures designed to meet the conditions of this Permit.

4.4.2. The procedures referred to in Condition 4.4.1 shall also include the methods to be used both before the process is operated, and also during the operation of the process for identifying and responding to any occurrence that may occur within the process which may require notification to SEPA under conditions 2.4.1 and 2.4.2, and for assessing the environmental impact of such an occurrence should one be identified.

4.4.3. The Operator shall review and where necessary define, prepare, record and implement all operating systems and procedures necessary for compliance with the conditions of this Permit, whenever there are any changes to the Permitted Activities or in any case at intervals of not more than two years or other period as agreed in writing with SEPA.

4.4.4. Where any system or procedure required by Condition 4.4.3 is not immediately available, the Operator shall prepare such a procedure or system, which shall be available for use by the Operator within 2 months of the date when such a need was identified.

4.4.5. The procedures and systems required by Condition 4.4.3 and Condition 4.4.4 shall include methods to be used in assessing any new process or process modification to be incorporated within the existing process in respect to its Emissions both under normal operating conditions and as a result of process upset.

4.5. Introduction of New Raw Materials

4.5.1. Prior to the introduction to the Permitted Installation of any new chemicals the operator shall carry out a review to ensure that the necessary systems are adopted to minimise the pollution potential from the material. The review must encompass the areas as a minimum.

4.5.1.1. Justification of the use of the substance as opposed to changes in process operation to obtain the same end result.

4.5.1.2. Obtain information from the manufacturer on the environmental impact of the substance including aquatic toxicity data and potential incompatibility with other substances.

4.5.1.3. Determine the environmental fate of the substance.

4.5.1.4. Determine the biodegradability of the substances.

4.5.1.5. Confirm that adequate training has been provided and procedures are in place to ensure proper usage, handling, and spill response.

4.5.2. The findings of any review required by Condition 4.5.1 shall be recorded in a register. This register shall also include either the date of a notification made to SEPA under Regulation 12 or the date an application made to SEPA under Regulation 13 in respect of its introduction, or a comment that such a notification or application was not considered necessary together with any correspondence received from SEPA in response.

4.6. Raw Material, Waste Handling and Storage

4.6.1. The materials described in Table 4.4 as annexed as Appendix 5 shall be stored on the Site only in the location, method and quantities specified in this table.

4.6.2. The Operator shall maintain an inventory recording the quantities and environmental characteristics of raw materials used and stored at the Permitted Installation.

4.6.3. By 31 December of each year the Operator shall undertake and record annual inspections of all bunds, sumps, pipelines and storage areas on the Permitted installation which shall include an assessment of their integrity and fitness for purpose. The inspections shall be in accordance with current European or British Standard Specifications.

4.6.4. A report on the conclusions from the inspections required by Condition 4.6.3 detailing any remedial actions required, a timetable for their completion, and record of the inspection shall be sent to SEPA within one month of the completion of the inspections.

4.6.5. The Operator shall, wherever practical, purchase raw materials and chemicals in returnable, re-usable containers and make arrangements, where possible, for the return of such containers without the requirement for washing out the residues.

4.7. Incident Prevention

4.7.1. The Operator shall ensure that all materials, products, by-products or wastes which may result in pollution if they enter soil, groundwater, controlled waters or an effluent collection system shall be stored in designated areas designed to prevent the release of any of those materials to soil, groundwater, controlled waters or effluent collection systems, in such a manner as to prevent any such release.

4.7.2. Notwithstanding the requirements of Condition 2.4.5, the Operator shall prepare, record and implement a spillage plan designed to prevent the release of any pollutants to surface water or Site drains from any spillage or leaks resulting from the Permitted Activities. As part of the said plan the Operator shall identify what, if any, spillage equipment is to be maintained on Site, the quantity of such equipment, and the strategic locations of any storage bins containing the said equipment.

4.7.3. The spillage plan required by Condition 4.7.2 shall be completed by 30 June 2022 and a copy of the plan reported to SEPA within one month of the completion of the plan.

4.7.4. Following an Incident and at least every 4 years the Operator shall review the "Spillage Plan" required under condition 4.7.2. Each review of the plan shall be recorded and where the Operator makes any revisions to the plan these revisions shall be recorded.

4.7.5. All chemicals shall be stored in appropriately signed and segregated areas and appropriately bunded as required, to minimise the risk of adverse reaction as follows:

4.7.5.1. Acids and alkalis shall be stored in different areas; and

4.7.5.2. Oxidising and reducing agents shall be stored in different areas.

4.8. Effluent Treatment plant

4.8.1. The effluent treatment plant shall be operated and maintained so as to minimise the emission of offensive odour.

4.8.2. Liquid effluent and sludge shall be transferred within pipe work designed, constructed and linked in a manner which prevents leakages.

4.8.3. All discharged sludge from the effluent treatment plant shall be stored in sealed, lidded or otherwise covered tanks or receptacles prior to removal off site.

4.9. Cooling Water Discharge

4.9.1. The discharge of cooling water from the permitted installation to the Forglen Burn is not permitted under the conditions of this permit.

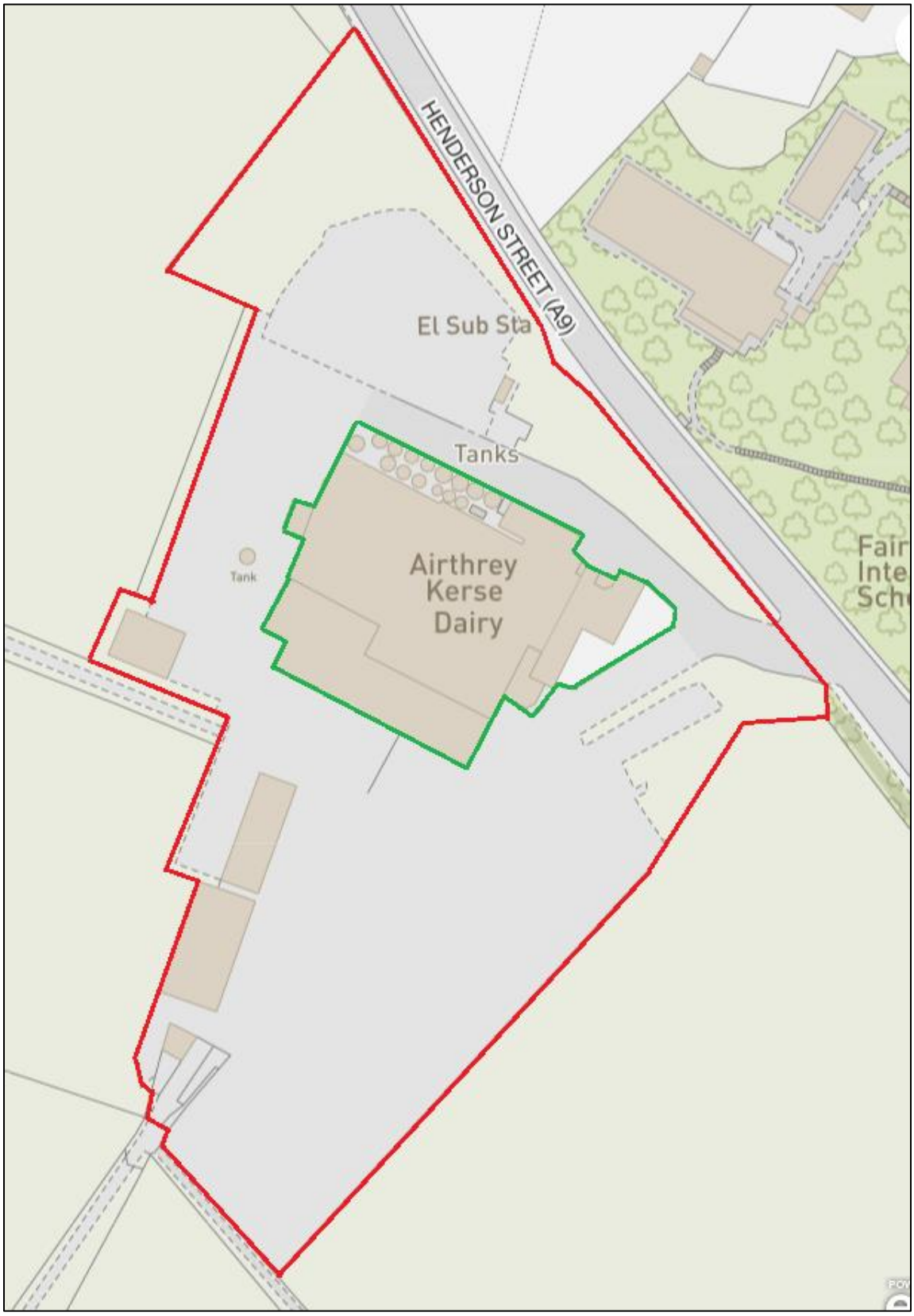
4.10. Refrigerant/Coolant Leakage Detection

4.10.1. The refrigerant/coolant leak detection monitoring system shall be provided.

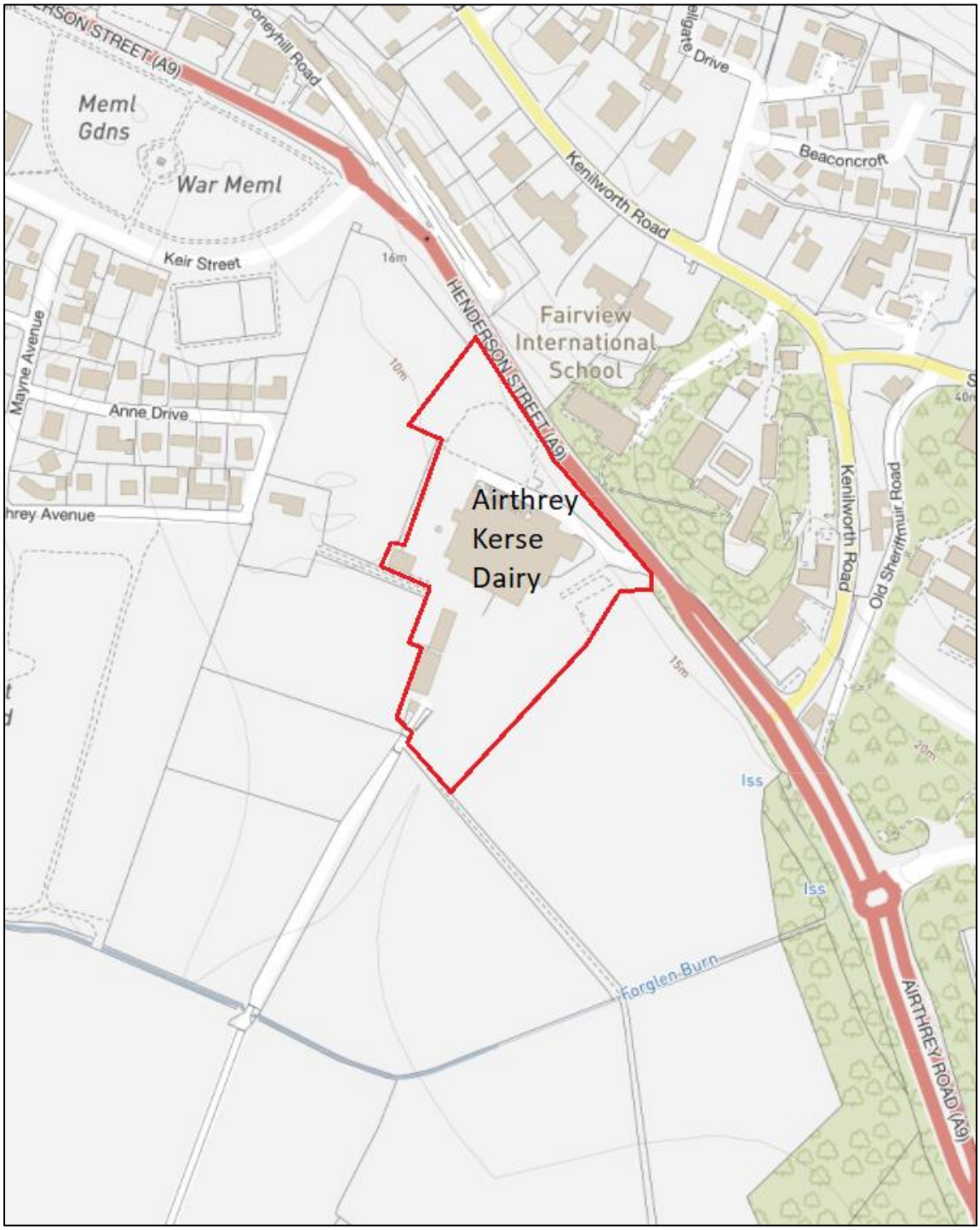
4.10.2. In the event of a leak being detected a signal shall activate warning audible and visual alarms and the refrigerant plant shall be automatically shut down.

4.10.3. Any leakage of refrigerant/coolant detected shall be recorded in accordance 2.4.1

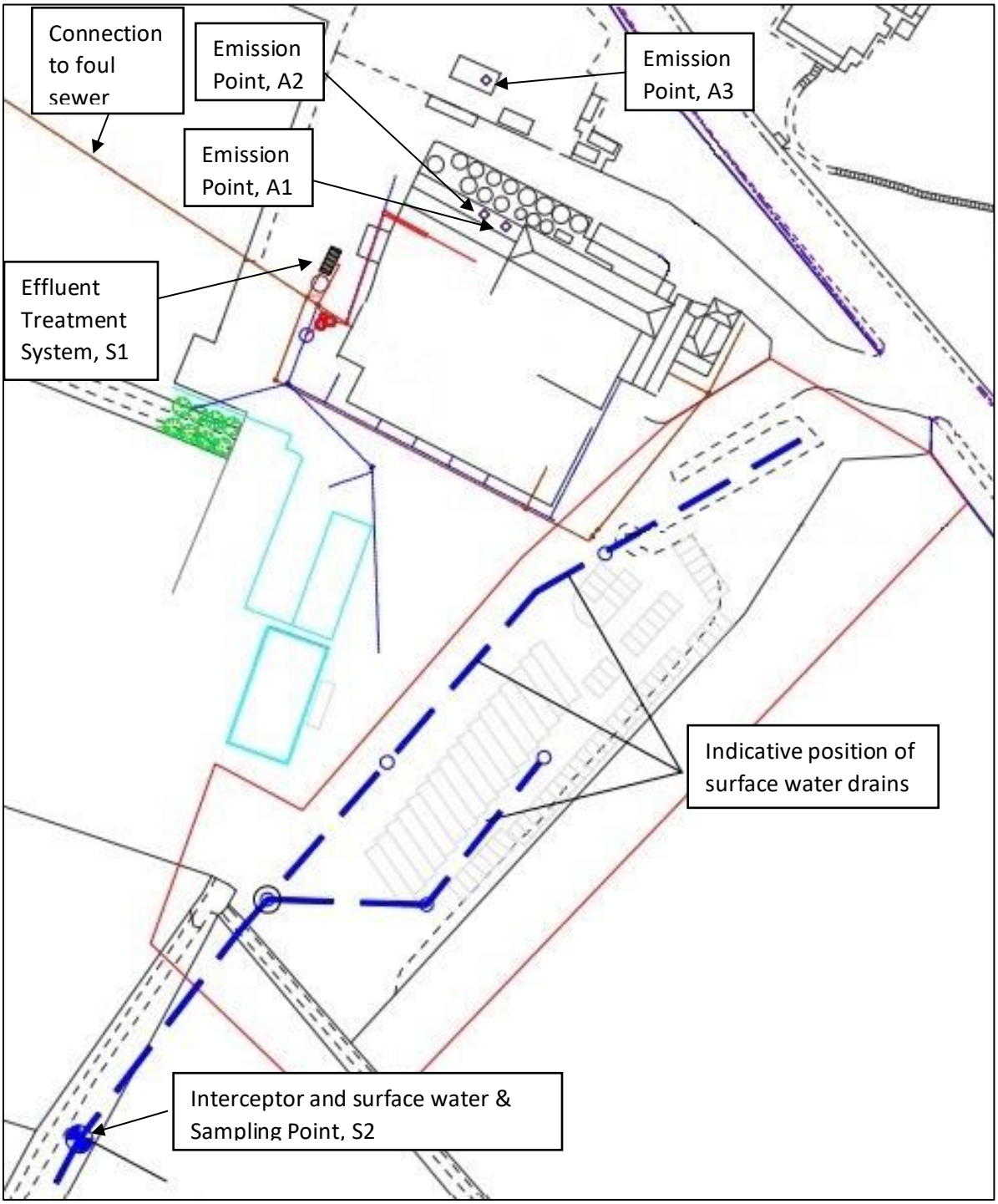
APPENDIX 1 – Site Plan



APPENDIX 2 – Location Plan



APPENDIX 3 – Sampling Point Locations



APPENDIX 4 – Emission Limit Value Tables As Specified In Schedule 4

Table 4.1 Emissions to Air ELVs

Source of Emission	Emission point number	A1	A2	A3
	Emission source	Boiler 1	Boiler 2	Emergency Generator
	Stack height (m) Flue diameter (m)	0.75 0.35	0.75 0.35	N/A 0.11
	Location on site plan	A1	A2	A3
	NGR	NS 80005 96899	NS 80000 96901	NS 80007 96929
Monitoring Details	Type of monitoring	SS	SS	SS
	Sampling Location	Stack	Stack	Stack
	Visible Smoke – Ringleman No. (as determined in accordance with BS2742:1969(as amended)) During Start up period At all other times	 Not to exceed shade 2. Not to exceed shade 1 for any period longer than 4 consecutive minutes or 24 minutes in aggregate in any 8 hour period.	 Not to exceed shade 2. Not to exceed shade 1 for any period longer than 4 consecutive minutes or 24 minutes in aggregate in any 8 hour period.	 Not to exceed shade 2. Not to exceed shade 1 for any period longer than 4 consecutive minutes or 24 minutes in aggregate in any 8 hour period.

Table 4.2 – Emissions to Effluent Collection System/Water ELVs

Location Point number(s) on discharge plan	**S1**	**S2**
Source of Emission	Effluent Collection System	Surface water collection and drainage system
Emission Location	Discharge to effluent treatment plant	Discharge to Forglen Burn at: NS 79830 96582
Sampling Location	Effluent sampling chamber located at treatment plant	Effluent sampling chamber located at: NS 79910 96694
BOD (mg/l)	No limit set	3
Suspended Solids (mg/l)	No limit set	25
pH	No limit set	6 - 9
COD (mg/l)	No limit set	No limit set
Total Phosphorus (mg/l)	No limit set	No limit set
Fe (mg/l)	No limit set	No limit set
Temperature (°C)	No limit set	No limit set
Maximum daily volume limit (m^3)	No limit set	No limit set
Flow rate (l/s)	No limit set	No limit set
Oil or grease (mg/l)	No limit set	No limit set

Table 4.3 – Emissions to Effluent Collection System/Water Monitoring Requirements

Parameter	Emission Point	Monitoring Frequency	Monitoring Device Type	Test Method
BOD (mg/l)	S2	Monthly	Instantaneous	Latest standard from Environment Agency M18 guidance Document (EA M18) or as otherwise agreed in writing with SEPA
Suspended Solids (mg/l)	S2	Monthly	Instantaneous	Latest standard from Environment Agency M18 guidance Document (EA M18) or as otherwise agreed in writing with SEPA
pH	S2	Monthly	Instantaneous	Latest standard from Environment Agency M18 guidance Document (EA M18) or as otherwise agreed in writing with SEPA
COD (mg/l)	S2	N/A	N/A	Latest standard from Environment Agency M18 guidance Document (EA M18) or as otherwise agreed in writing with SEPA
Total Phosphorus (mg/l)	S2	N/A	N/A	Latest standard from Environment Agency M18 guidance Document (EA M18) or as otherwise agreed in writing with SEPA
Fe (mg/l)	S2	N/A	N/A	Latest standard from Environment Agency M18 guidance Document (EA M18) or as otherwise agreed in writing with SEPA
Temperature (°C)	S2	N/A	N/A	Latest standard from Environment Agency M18 guidance Document (EA M18) or as otherwise agreed in writing with SEPA
Maximum daily volume limit (m^3)	S2	N/A	N/A	Latest standard from Environment Agency M18 guidance Document (EA M18) or as otherwise agreed in writing with SEPA
Flow rate (l/s)	S2	N/A	N/A	Latest standard from Environment Agency M18

				guidance Document (EA M18) or as otherwise agreed in writing with SEPA
Oil or grease (mg/l)	S2	N/A	N/A	Latest standard from Environment Agency M18 guidance Document (EA M18) or as otherwise agreed in writing with SEPA

APPENDIX 5 – Raw Material, Waste Handling and Storage

Description	Location of Storage	Method of Storage	On Site quantity	Storage conditions
***Refrigerants**	Various plant rooms	Sealed systems	234 Kg	Sealed system
Chemicals				
CIP Cleaning Chemicals	Various storage & intermediate storage locations around site	IBC's, 200 l drums, 20 l carboys	Cipton – 2 IBC's of 950L, Primesoft - 2 IBC's of 900L, Dilac Acid - 1 IBC of 900L, Divosan forte - 1 IBC of 1000kg, Glide (20L) – 15 drums, Hypofoam (20L) – 15 drums, Sureclean (200L) – 2 drums	Stored on bunded pallet or in bunded store
Sodium Hydroxide for effluent treatment plant	Inside storage unit	Bunded IBC	1000ltr	Bunded tank system
Sulphuric acid for effluent treatment plant	Inside storage unit	Bunded IBC	1000ltr	Bunded tank system
Effluent treatment chemicals	Effluent treatment plant	IBC's, 200 l drums, 20 l carboys	Alresolve – 2,000ltrs, Anfloc (25kg) - 1	Stored on bunded pallet or in bunded store
Water	Storage Tank	Storage Tank	42,000 ltr	Storage Tank
Milk				
Raw Milk	Raw Milk Silos	Silos/Containers		Silos/Containers
Cream	Raw Milk Silos	Silos/Containers		Silos/Containers
Pasteurised Milk	Finished Milk Silos	Silos/Containers		Silos/Containers
Fuel				
Diesel	Fuel island	Fuel island	10,000 ltr	Fuel island
Red diesel	Fuel island	Fuel island	3,000 ltr	Fuel island
Ad Blue	Fuel island	Fuel island	3,000 ltr	Fuel island
Gas Oil (for boiler)	Outside storage tank	Bunded tank		Bunded Tank
Waste				
Tipped milk and the butter machine washdowns	Dairy Waste Area	IBC's	Tipped Milk – 2-3 IBC's a week are generated and uplifted weekly Butter – 15-20 IBC's generated a month which are uplifted and taken	Outside

			to an AD plant.	
Cardboard bales	Dairy Waste Area	Baled on Pallet	3 bales generated a week – uplifted weekly	Outside on Pallet
Compacted milk bottles	Dairy Waste Area	Baled on Pallet	N/A	Outside on Pallet
Food waste	Dairy Waste Area	Food waste skip	1 skip	Food waste skip
Polythene bales	Dairy Waste Area	Baled on Pallet	7 bales generated a week – uplifted weekly	Outside on Pallet
Mixed waste recycling skips	Dairy Waste Area	Waste skip	1 skip	Waste skip
General waste skip	Dairy Waste Area	Waste skip	1 skip	Waste skip
Stainless steel skip	Dairy Waste Area	Waste skip	1 skip	Waste skip
Mild steel skip	Dairy Waste Area	Waste skip	1 skip	Waste skip
Wood skip	Dairy Waste Area	Waste skip	1 skip	Waste skip
Hazardous waste	Site Service Area	Various containers	N/A	Bunded container storage facilities
Waste oil	Site Service Area	Waste oil storage container	Container holds 300-400L and is emptied approximately 4 times a year	Self Bunded Oil Container

EXPLANATORY NOTES
(These Explanatory Notes do not form part of the Permit)

1. BAT

It should be noted that Regulation 22 of the Regulations specifies that it is a condition of a Permit that the operator must use the best available techniques (BAT) for preventing or, where that is not practicable, reducing emissions from the installation. This is referred to as the 'general' BAT condition.

This does not apply to the extent that any other condition of the permit, or a standard rule which has effect as a standard rules condition, has the same effect.

Examples of aspects of the operation that have not been regulated by specific Conditions are general maintenance requirements.

BAT is defined in Regulation 4 of the Regulations as follows:

"best available techniques" mean the most effective and advanced stage in the development of activities and their methods of operation which indicates the practical suitability of particular techniques for providing the basis for emission limit values and other permit conditions designed to prevent and, where that is not practicable, to reduce emissions and the impact on the environment as a whole

"available techniques" means those techniques which have been developed on a scale which allows implementation in the relevant industrial sector, under economically and technically viable Conditions, taking into consideration the cost and advantages, whether or not the techniques are used or produced inside the UK, as long as they are reasonably accessible to the operator.

"best" means in relation to techniques, the most effective in achieving a high general level of protection of the environment as a whole.

"techniques" includes both the technology used and the way in which an installation is designed, built, maintained, operated and decommissioned.

"BAT conclusions" means a document containing the parts of a BAT reference document laying down the conclusions on best available techniques, their description, information to assess their applicability, the emission levels associated with the best available techniques, associated monitoring, associated consumption levels and, where appropriate, relevant site remediation measures.

"emerging technique" means a novel technique for an industrial activity that, if commercially developed, could, when compared to existing best available techniques provide a higher level of protection of the environment, or at least the same level of protection of the environment and higher cost savings.

"emission levels associated with best available techniques" means the range of emission levels obtained under normal operating conditions using a best available technique, or combination of best available techniques, as described in BAT conclusions, expressed as an average over a given period of time, under specified reference conditions.

Schedule 3 of the Regulations specifies the matters to be taken into account in determining BAT.

In considering BAT, SEPA would expect the Operator to have regard to all relevant PPC sector or other technical guidance, including BAT Reference Documents and BAT Conclusions published by the European Commission and UK technical guidance published by the Environment Agency.

2. GENERAL STATUTORY REQUIREMENTS

The Permit does not detract from any other statutory requirements applicable to you in respect of the Permitted Installation, such as any need to obtain planning permission or building regulations approval or any responsibilities under legislation for health, safety and welfare in the workplace.

3. APPEALS

If you are aggrieved by any of the Conditions of the Permit, you should initially contact the local SEPA Office at the address or telephone number below. Further information on your right of appeal and the appeals procedure is contained Regulation 58 and Schedule 8 of the Regulations.

4. SUBSISTENCE CHARGES

An annual subsistence charge will be payable in respect of the Permit in terms of the Environmental Regulation (Scotland) Charging Scheme 2018, or any relevant charging scheme made under Section 41 of the Environment Act 1995, copies of which are available from SEPA.

5. ADDRESS AND TELEPHONE NUMBERS

The contact address and telephone number for all information to be reported in terms of the Permit, is as follows:

Scottish Environment Protection Agency

Angus Smith Building
6 Parklands Avenue
Eurocentral
Holytown
North Lanarkshire
ML1 4WQ

Tel: 01698 839000
Fax: 01698 738155

6. REVIEW OF CONDITIONS

The Conditions of the Permit will be periodically reviewed by SEPA.

7. PROPOSED CHANGE IN OPERATION OF INSTALLATION

It is a requirement of Regulation 45 of the Regulations that if you propose to make a change in the operation of the installation, you must notify SEPA at least 14 days before making the change. The requirement under Regulation 45 does not apply if

you have already made an application to SEPA for the variation of the Conditions of the Permit containing a description of the proposed change.

N.B. the requirements of Regulation 45 are in addition to any obligations you may have under the Permit itself to only operate the Permitted Installation in the manner set out in the Permit and to notify SEPA of proposed changes to the Permitted Installation.

Regulation 46 and Schedule 7 of the Regulations provide details on applications for variation of the Permit in respect of proposed changes and substantial changes in operation.

"Change in operation" and "substantial change in operation" are defined in Regulation 2 of the Regulations.

8. ENFORCEMENT & OFFENCES

If SEPA is of the opinion that you have contravened or are contravening or are likely to contravene a Condition of the Permit, or an Incident or accident significantly affecting the environment has occurred as a result of the operation of the Installation it may serve an Enforcement Notice. Further details on Enforcement Notices are provided in Regulation 55 of the Regulations.

If SEPA is of the opinion that the operation of an installation poses an immediate danger to human health, threatens to create an immediate significant adverse effect upon the environment or involves a risk of serious pollution it must, in certain circumstances, serve a Suspension Notice on you. Further details on Suspension Notices are provided in Regulation 56 of the Regulations.

It is an offence to operate an installation covered by the Regulations without a Permit or in breach of the Conditions of the Permit. It is an offence to fail to comply with the requirements of an Enforcement or Suspension Notice. It is an offence to intentionally make a false entry in any record required to be kept under a Condition of a Permit. Further details on offences and on penalties liable to be imposed upon conviction of an offence are provided in Regulation 67 of the Regulations.

Directors, managers and other individuals within a company may be held personally liable for offences under the Regulations.

All personnel who are responsible for fulfilling any Condition of the Permit should be made aware of these facts.

9. BREACH OF A PERMIT CONDITION

Regulation 52 of the Regulations specifies that the Operator of an Installation must immediately give notice to SEPA of any breach of a condition of the permit. It is an offence to fail, without reasonable excuse to comply with Regulation 52.

Any statement made by an operator to SEPA for the purposes of complying with regulation 52 may only be used in a prosecution for an offence where in giving evidence the operator makes a statement inconsistent with the initial notification.

All personnel who are responsible for fulfilling any Condition of the Permit should be made aware of these facts.

10. RECORDED SYSTEMS, PROCEDURES OR INFORMATION RECORDING/ RETURN REQUIREMENTS

Where a Condition requires any system, procedure or information record/return, the Operator may demonstrate compliance by making use of any relevant existing written system used for any other purpose and which meets the requirements of the relevant Condition.

11. SYSTEMATIC ASSESSMENT (AND REVIEW)

Where a Condition of the permit requires a "systematic assessment (and review)" the assessment should be undertaken in a methodical and arranged manner. If you require guidance on the scope or extent of any assessment (and review) required to be undertaken, you should contact your local SEPA office at the address or telephone number given above.

12. COMMERCIAL CONFIDENTIALITY

Regulation 64 of the Regulations requires that SEPA maintain a register ("a Public Register"), whilst Schedule 9 of the Regulations sets out what the Public Register shall contain. Regulation 66(2) provides you with an opportunity to apply for exclusion from the Public Register for certain confidential information. Where you are required to supply SEPA with information whether via a condition in this permit, or otherwise, and that information falls under Schedule 9, if you wish it to be excluded from the public register as confidential information, then such a submission must include an application made under Regulation 66(2).