

Notice of variation and consolidation with introductory note

The Environmental Permitting (England & Wales) Regulations 2016

Advanced Proteins Unltd

Cheddleton Site
Bones Lane
Cheddleton
Staffordshire
ST13 7BT

Variation application number

EPR/HP3508BE/V002

Permit number

EPR/HP3508BE

Cheddleton Site

Permit number EPR/HP3508BE

Introductory note

This introductory note does not form a part of the notice

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

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

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

The Medium Combustion Plant (MCP) consists of 3 existing MCP: 1 x 15.96 MWth natural gas boiler, 1 x 13.44 MWth natural gas boiler and 1 x 11.118 MWth natural gas boiler which all have tallow as a backup fuel.

Monitoring and reporting requirements relating to chemical oxygen demand (COD) loss efficiency and additional Food Waste reporting requirements has also been added as part of this variation.

The main features of the permit are as follows:

The primary purpose of this installation is the operation of two rendering processes of category 1, 2 & 3 animal by-products (ABP) into tallow and processed animal protein or meat and bone meal (MBM). The tallow is used as a renewable fuel source both on site (in the thermal oxidisers) and for export off site. Also, the tallow is used in other industrial sectors such as the manufacture of soap and additives for engine oil. The process involves crushing the raw materials before processing in large cooking units. The product is then separated out into tallow and MBM. The installation can also process blood to manufacture blood meal.

The processing of the raw materials involves significant energy demand and is therefore supplied by three gas fired boilers (40.518 MWth in aggregate) raising steam for cooking. Also in operation are two regenerative thermal oxidisers (RTO) (41.6 MWth in aggregate) which are in place to both treat odour and to produce steam for the cooking processes. Both types of combustion plant run on natural gas, however, the option to burn tallow as a fuel is also permitted.

The plant also consists of 1 x 5 MWth natural gas fired spark ignition engine to generate 2 MW of electrical output and heat as combined heat and power (CHP). The CHP engine produces onsite electricity for use in the rendering of animal carcasses and animal waste processes. Electricity will not be exported to the local distribution network and will operate for approximately 95% of the year. As a new medium combustion plant, the CHP engine complies with the emission limit values outlined within the Medium Combustion Plant Directive.

Liquid process wastes from the activities at the installation and any contaminated surface water are treated in the onsite effluent treatment plant (ETP). The treatment capacity exceeds 50 tonnes per day and is therefore considered to be an installation activity in its own right. Treated process waters are discharged directly to the River Chumet under specified emission limit values, or to emission point W2.

The schedules specify the changes made to the permit.

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

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

Status log of the permit		
Description	Date	Comments
Application EPR/BK0086IY/A001	Duly made 31/05/2006	
Permit issued EPR/BK0086IY	03/10/2006	
Application EPR/BK0086IY/V002 (variation)	Duly made 27/03/2008	
Variation determined EPR/BK0086IY	25/07/2008	
Application EPR/BK0086IY/V003 (variation)	Duly made 15/12/2008	
Variation determined EPR/BK0086IY	15/01/2009	
Application EPR/BK0086IY/V004 (variation and consolidation)	Duly made 10/01/2011	
Variation determined EPR/BK0086IY	22/08/2011	
Agency variation determined EPR/BK0086IY	05/08/2013	
Application EPR/BK0086IY/V007 (variation and consolidation)	Duly made 16/05/2019	Application to operate a combined heat & power plant, remove installation activities and update the permit to modern conditions.
Variation determined EPR/BK0086IY	10/12/2019	Varied permit issued.
Application EA/EPR/HP3508BE/T001 (Full Transfer of permit)	Duly made 02/12/2019	Application to transfer the permit in full to Advanced Proteins Unltd
Transfer determined (Billing ref. HP3508BE)	17/02/2020	Transfer issued
Application EPR/HP3508BE/V002 (variation and consolidation)	Regulation 61 Notice response received 07/08/2024	Environment Agency initiated variation and consolidation following Medium Combustion Plant permit review.
Further information received	06/01/2025	Confirmation of MCP information
Further information received	21/03/2025	Confirmation of activities
Variation determined and consolidation issued EPR/HP3508BE	10/04/2025	Varied and consolidated permit issued

End of introductory note

Notice of variation and consolidation

The Environmental Permitting (England and Wales) Regulations 2016

The Environment Agency in exercise of its powers under regulation 20 of the Environmental Permitting (England and Wales) Regulations 2016 varies

Permit number

EPR/HP3508BE

Issued to

Advanced Proteins Unltd ("the operator")

whose registered office is

**Annesborough Industrial Estate,
Craigavon
Co. Armagh
BT67 9JD**

company registration number NI024133

to operate a regulated facility at

**Cheddleton Site
Bones Lane
Cheddleton
Staffordshire
ST13 7BT**

to the extent set out in the schedules.

The notice shall take effect from 10/04/2025

Name	Date
Kate Booth	10/04/2025

Authorised on behalf of the Environment Agency

Schedule 1

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

- Table S1.1, as referenced by conditions 2.1.1, 2.3.7, 3.1.4 and 3.5.5, is amended to add details of MCPs, including removing boiler 1 which is decommissioned, to correct activity references and to remove AR9 (this CHP is already included within AR3).
- Table S1.3, as referenced by condition 2.4.1 is amended to add IC17.
- Table S2.1, as referenced by condition 2.3.3, is amended to update the fuel description.
- Table S3.1, as referenced by conditions 3.1.1, 3.5.1 and 3.5.4, is amended to update monitoring requirements for boilers No.2 - No.4 and to remove Plant boiler No.1 (A3) as it is decommissioned.
- Table S4.1, as referenced by condition 4.2.3, is amended to add reporting requirements for MCPs.
- Table S4.3, as referenced by condition 4.2.2, has been updated and to include two new performance parameters; 'COD loss efficiency' and 'Food Waste'.
- Table S4.4, as referenced by conditions 4.2.2 and 4.2.3, has been updated to include an updated emissions to air reporting form a new reporting form titled 'Food Waste'.
- Schedule 6, as referenced by condition 4.4.1, has been updated to include additional interpretations related to MCP.

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

- Condition 2.3.7 has been added to include MCP operating techniques.
- Conditions 3.5.5 and 3.5.6 have been added to include MCP monitoring requirements.
- Condition 4.1.3 has been added to include MCP recording requirements.

Schedule 2 – consolidated permit

Consolidated permit issued as a separate document.

Permit

The Environmental Permitting (England and Wales) Regulations 2016

Permit number

EPR/HP3508BE

This is the consolidated permit referred to in the variation and consolidation notice for application
EPR/HP3508BE/V002 authorising,

Advanced Proteins Unltd ("the operator"),

whose registered office is

**Annesborough Industrial Estate,
Craigavon
Co. Armagh
BT67 9JD**

company registration number NI024133

to operate an installation at

**Cheddleton Site
Bones Lane
Cheddleton
Staffordshire
ST13 7BT**

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

Name	Date
Kate Booth	10/04/2025

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”).
- 2.1.2 Waste authorised by this permit shall be clearly distinguished from any other waste on the site.

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 Waste shall only be accepted if:
 - (a) it is of a type and quantity listed in schedule 2 table(s) S2.2, S2.3 and S2.4; and
 - (b) it conforms to the description in the documentation supplied by the producer and holder.
- 2.3.5 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.
- 2.3.6 The operator shall ensure that where waste produced by the activities is sent to a landfill site, it meets the waste acceptance criteria for that landfill.
- 2.3.7 For MCPs specified in Schedule 1 Table S1.1:
 - (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 and S3.2.
- 3.1.2 The limits given in schedule 3 shall not be exceeded.
- 3.1.3 Periodic monitoring shall be carried out at least once every 5 years for groundwater and 10 years for soil, unless such monitoring is based on a systematic appraisal of the risk of contamination.
- 3.1.4 For the following activities referenced in schedule 1, table S1.1 (5MWth CHP) the first monitoring measurements shall be carried out within four months of the issue date of the permit or the date when the MCP is first put into operation, whichever is later.

3.2 Emissions of substances not controlled by emission limits

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

3.3 Odour

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

- (b) implement the approved odour management plan, from the date of approval, unless otherwise agreed in writing by the Environment Agency.

3.4 Noise and vibration

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

3.5 Monitoring

- 3.5.1 The operator shall, unless otherwise agreed in writing by the Environment Agency, undertake the monitoring specified in the following tables in schedule 3 to this permit:
 - (a) point source emissions specified in table S3.1;
 - (b) surface water or groundwater specified in table S3.2.
- 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 and S3.2 unless otherwise agreed in writing by the Environment Agency.
- 3.5.5 For MCPs specified in Schedule 1 Table S1.1: For existing MCP Monitoring measurements shall be carried out within four months of the issue date of this notice.
- 3.5.6 Monitoring of MCP shall not take place during periods of start-up or shut down.

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.

- 4.2.5 Within 1 month of the end of each quarter, the operator shall submit to the Environment Agency using the form made available for the purpose, the information specified on the form relating to the site and the waste accepted and removed from it during the previous quarter, if during that quarter the total amount accepted exceeds 100 tonnes of non-hazardous waste or 10 tonnes of hazardous waste.

4.3 Notifications

4.3.1 In the event:

- (a) that the operation of the activities gives rise to an incident or accident which significantly affects or may significantly affect the environment, the operator must immediately—
 - (i) inform the Environment Agency,
 - (ii) take the measures necessary to limit the environmental consequences of such an incident or accident, and
 - (iii) take the measures necessary to prevent further possible incidents or accidents;
- (b) of a breach of any permit condition the operator must immediately—
 - (i) inform the Environment Agency, and
 - (ii) take the measures necessary to ensure that compliance is restored within the shortest possible time;
- (c) of a breach of permit condition which poses an immediate danger to human health or threatens to cause an immediate significant adverse effect on the environment, the operator must immediately suspend the operation of the activities or the relevant part of it until compliance with the permit conditions has been restored.

4.3.2 Any information provided under condition 4.3.1 (a)(i), or 4.3.1 (b)(i) where the information relates to the breach of a limit specified in the permit, shall be confirmed by sending the information listed in schedule 5 to this permit within the time period specified in that schedule.

4.3.3 Where the Environment Agency has requested in writing that it shall be notified when the operator is to undertake monitoring and/or spot sampling, the operator shall inform the Environment Agency when the relevant monitoring and/or spot sampling is to take place. The operator shall provide this information to the Environment Agency at least 14 days before the date the monitoring is to be undertaken.

4.3.4 The Environment Agency shall be notified within 14 days of the occurrence of the following matters, except where such disclosure is prohibited by Stock Exchange rules:

Where the operator is a registered company:

- (a) any change in the operator's trading name, registered name or registered office address; and
- (b) any steps taken with a view to the operator going into administration, entering into a company voluntary arrangement or being wound up.

Where the operator is a corporate body other than a registered company:

- (a) any change in the operator's name or address; and
- (b) any steps taken with a view to the dissolution of the operator.

In any other case:

- (a) the death of any of the named operators (where the operator consists of more than one named individual);
- (b) any change in the operator's name(s) or address(es); and
- (c) any steps taken with a view to the operator, or any one of them, going into bankruptcy, entering into a composition or arrangement with creditors, or, in the case of them being in a partnership, dissolving the partnership.

- 4.3.5 Where the operator proposes to make a change in the nature or functioning, or an extension of the activities, which may have consequences for the environment and the change is not otherwise the subject of an application for approval under the Regulations or this permit:
- (a) the Environment Agency shall be notified at least 14 days before making the change; and
 - (b) the notification shall contain a description of the proposed change in operation.
- 4.3.6 The Environment Agency shall be given at least 14 days notice before implementation of any part of the site closure plan.
- 4.3.7 Where the operator has entered into a climate change agreement with the Government, the Environment Agency shall be notified within one month of:
- (a) a decision by the Secretary of State not to re-certify the agreement;
 - (b) a decision by either the operator or the Secretary of State to terminate the agreement; and
 - (c) any subsequent decision by the Secretary of State to re-certify such an agreement.

4.4 Interpretation

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

Schedule 1 – Operations

Table S1.1 activities			
Activity reference	Activity listed in Schedule 1 of the EP Regulations	Description of specified activity and WFD Annex I and II operations	Limits of specified activity and waste types
AR1	S6.8 A(2)(a)	Disposing of or recycling animal carcasses or animal waste by rendering at plant or in a small waste incineration plant, where the plant or small waste incineration plant has a treatment capacity exceeding 10 tonnes per day of animal carcasses or animal waste or both in aggregate.	Crushing, heating and drying of imported feedstock to produce and separate substances suitable for incineration in the combustion facility, disposal off-site, or saleable products. Waste types and quantities are specified in Table S2.2 of this permit.
AR2	S6.8 A(1)(c)	Disposing of or recycling animal carcasses or animal waste, other than by rendering in a small waste incineration plant, at a plant with a treatment capacity exceeding 10 tonnes per day of animal carcasses or animal waste or both in aggregate.	The processing of raw blood from off-site slaughtering processes to produce blood meal. Waste types and quantities as specified in Table S2.3 of this permit.
AR3	S1.1 A(1)(a)	Burning any fuel in an appliance with a rated thermal input of 50 or more megawatts. Combustion of natural gas or tallow (liquid fuels other than gas oil) within three boilers which are existing MCP: 1 x 15.96 MWth (A4, boiler 2) 1 x 13.44 MWth (A5, boiler 3) 1 x 11.118MWth (A6, boiler 4) Total rated thermal input of existing MCP is 40.518 MWth. 1 x 5 MWth CHP engine (natural gas, A14) which is a new MCP. The total combined thermal input of all plant is 45.518 MWth.	From receipt of fuel to release of products of combustion to air. When tallow is used for Boilers 2 - 4 note 1 applies, when natural gas is used there is no restriction to operating hours. The CHP engine produces onsite electricity and steam for the rendering and processing of animal by-products.
AR4	S5.4 A(1)(a)(i)	Disposal of non-hazardous waste in a facility with a capacity of more than 50	Operation of an effluent treatment plant.

Table S1.1 activities			
Activity reference	Activity listed in Schedule 1 of the EP Regulations	Description of specified activity and WFD Annex I and II operations	Limits of specified activity and waste types
		tonnes per day by biological treatment.	
Directly Associated Activity			
AR5	Fuel, raw material and waste storage and handling	--	From receipt, or production of materials to use in on-site processes.
AR6	Odour abatement system	Operation of 2 thermal oxidisers each with a thermal input of 20.8 MWth (41.6 MWth in aggregate A1 & A2), operated using natural gas or tallow (liquid fuels other than gas oil).	Abatement of odour emissions to air from the rendering and blood plants. Comprises of biofilters, wet scrubbers and combustion in on site combustion plant and thermal oxidisers.
AR7	Processing, storage and handling of tallow	--	Tallow filtering and meat and bone meal milling, packing, storage and loading in dedicated facilities for on-site combustion or off-site use as a fuel by a third party or product distribution.
AR8	Spreading of ETP effluent within the installation boundary	--	Spreading of treated effluent to land as an alternative to discharge to the River Chumet.
AR9	Vehicle wash	--	On-site washing and cleaning of vehicles.
Note 1: Must not exceed 500 hours operation in a 12 month period as a rolling average over a 5 year period or operate for more than 750 hours in any single year.			

Table S1.2 Operating techniques		
Description	Parts	Date Received
Application EPR/BK0086IY/A001	Response to Section 2.1 to 2.11 in Appendix 10 of the application.	25/05/2006
Additional information	Additional information in relation to Sections 2.1 to 2.11 in Appendix 10 of the application and redefined installation boundary.	03/08/2006 – 15/08/2006
Variation application EPR/BK0086IY/V004	Response to Section 3 of Part B4 & C3 of the application including any related submitted reports.	10/01/2011
Additional information	Response to Schedule 5 Notice dated 06/06/2011. Operating techniques referred to within any Odour and Noise Management Plans (last reviewed September 2010).	24/06/2011
Variation application EPR/BK0086IY/V007	Supporting information containing operating techniques, <i>Environmental Permit Variation Technical Supporting Information Report. Final Report.</i> Reference 18415i1. Sections: Section 1.6 <i>Best Available Techniques.</i>	Duly made 16/05/2019

Table S1.2 Operating techniques		
Description	Parts	Date Received
	- Section 3.2 <i>Raw Materials</i>. - Section 3.3 <i>Waste Handling and Storage</i>. - Section 3.4 <i>Accidents and Consequences</i>. - Section 3.5 <i>Sound (Noise) Assessment</i>. - Section 4.1 <i>Point Source Emission to Air. Nitrogen Oxides (NO_x) Emissions Abatement</i>. - Section 5 <i>Emissions monitoring for CHP</i>	

Table S1.3 Improvement programme requirements		
Reference	Requirement	Date
IC10	The operator shall submit an emissions management plan to the Environment Agency. This shall include an updated emission release point diagram. On receipt of written agreement by the Environment Agency the operator shall maintain the emissions management plan within its own management system.	Complete
IC11	The operator shall submit a written proposal to the Environment Agency to carry out tests to determine the size distribution of the particulate matter in the exhaust gas emissions to air from emission point A1, identifying the fractions within the PM ₁₀ , PM _{2.5} and PM _{1.0} ranges. The proposal shall include a timetable for approval by the Environment Agency to carry out such tests and produce a report on the results. On receipt of written agreement by the Environment Agency to the proposal and the timetable, the operator shall carry out the tests and submit to the Environment Agency a report on the results.	Obsolete
IC12	Upon completion of commissioning of biobed E, the Operator shall undertake a survey to confirm that the fugitive escape from the odorous buildings served by all the air extraction systems is minimised. This shall include normal operating conditions where doors are opened. Proposals for improvements to minimise excessive releases shall be made. The survey shall be repeated on an annual basis as part of the odour management plan.	Complete
IC13	The operator shall undertake an olfactometry survey of all potentially odorous release points from the installation, both point source and fugitive. The survey shall include inlet and outlet exhausts on all the abatement units to establish their efficiencies. Proposals to maximise efficiencies of abatement shall be made where measurements show scope for improvement.	Complete
IC14	The olfactometry survey results shall be used in an air dispersion modelling exercise to predict the maximum ground level odour concentrations at the site boundary. For plant not yet commissioned the predicted worst case odour emissions shall be used in the modelling exercise. Proposals shall be made for further improvements to reduce odour if the survey indicates > 1.5 OU (1-hour average 98%ile) at the installation boundary.	Complete
IC15	The operator shall submit a written report to the Environment Agency on the commissioning of the biomass co-incinerator MBM plant. The report shall summarise the environmental performance of the plant as installed against the design parameters set out in the application. The report shall also include a review of the performance of the facility against the conditions of this permit and details of procedures developed during commissioning for achieving and demonstrating compliance with permit conditions.	Obsolete.

Table S1.3 Improvement programme requirements		
Reference	Requirement	Date
IC16	The operator shall review the pre-acceptance and acceptance procedures of any waste stream defined in Table S2.2 – S2.7. This review should also ensure that the Environment Agency is notified of any wastes received using a default '99' code. Upon completion of the review, the operator shall submit a written report summarising the improvements identified and a timetable for implementation. On receipt of written agreement by the Environment Agency the operator shall maintain the pre-acceptance and acceptance procedures as part of its own management system.	Complete.
IC17	The Operator shall submit a report on the opportunity to reduce Nox emissions to ensure continuing compliance with the Emission Limit Values (ELV) in this permit. Where emissions are currently above ELV, the operator shall undertake a review in accordance with the combustion plant original equipment manufacturer, qualified combustion engineer and/or burner manufacture. Where emissions are not currently exceeding but are close to the ELV the review can be carried out without external support. The review shall include, but not be limited to a review of air/fuel ratio, burner configurations and opportunities for burner upgrade, maintenance regimes, fuel quality, operating pattern.	Within 9 months from the date of this Notice

Schedule 2 – Waste types, raw materials and fuels

Table S2.1 Raw materials and fuels	
Raw materials and fuel description	Specification
Gas Oil or an equivalent substitute to be agreed in writing with the Environment Agency	Sulphur Content 0.1% w/w max
Natural and liquid petroleum gas fuel	--
Tallow fuel (meeting the Environment Agency 'End of Waste' test as described in the correspondence of the 22 December 2010 and 13 April 2011)	Less than 0.015% chlorine content
Animal by-products (as raw materials)	Those approved for processing at the installation under the Animal By-Products Regulations (as amended)

Table S2.2 Permitted waste types and quantities for the rendering plant	
Maximum quantity	No annual limit
Exclusions	Notwithstanding the specification of waste types below, wastes shall not be treated at the installation which has no approval under the Animal By-Products Regulations.
Waste code	Description
02	Wastes from agriculture, horticulture, aquaculture, forestry, hunting and fishing, food preparation and processing
02 01	wastes from agriculture, horticulture, aquaculture, forestry, hunting and fishing
02 01 02	animal-tissue waste
02 01 06	animal faeces, urine and manure (including spoiled straw), effluent, collected separately and treated off-site
02 01 99	wastes not otherwise specified
02 02	wastes from the preparation and processing of meat, fish and other foods of animal origin
02 02 01	sludges from washing and cleaning
02 02 02	animal-tissue waste
02 02 03	materials unsuitable for consumption or processing
02 02 04	sludges from on-site effluent treatment
02 02 99	wastes not otherwise specified
02 03	wastes from fruit, vegetables, cereals, edible oils, cocoa, coffee, tea and tobacco preparation and processing; conserve production; yeast and yeast extract production, molasses preparation and fermentation
02 03 04	materials unsuitable for consumption or processing
02 03 05	sludges from on-site effluent treatment
02 03 99	wastes not otherwise specified
02 05	wastes from the dairy products industry
02 05 01	materials unsuitable for consumption or processing
02 05 02	sludges from on-site effluent treatment
02 06	wastes from the baking and confectionery industry

Table S2.2 Permitted waste types and quantities for the rendering plant	
Maximum quantity	No annual limit
Exclusions	Notwithstanding the specification of waste types below, wastes shall not be treated at the installation which has no approval under the Animal By-Products Regulations.
Waste code	Description
02 06 01	materials unsuitable for consumption or processing
04	Wastes from the leather, fur and textile industries
04 01	wastes from the leather and fur industry
04 01 02	liming waste
04 01 09	wastes from dressing and finishing
07	Wastes from organic chemical processes
07 05	wastes from the MFSU of pharmaceuticals
07 05 99	wastes not otherwise specified
07 06	wastes from the MFSU of fats, grease, soaps, detergents, disinfectants and cosmetics
07 06 99	wastes not otherwise specified
19	Wastes from waste management facilities, off-site waste water treatment plants and the preparation of water intended for human consumption and water for industrial use
19 05	wastes from aerobic treatment of solid wastes
19 05 02	non-composted fraction of animal and vegetable waste
19 08	wastes from waste water treatment plants not otherwise specified
19 08 01	screenings
19 08 05	sludges from treatment of urban waste water
19 08 12	sludges from biological treatment of industrial waste water other than those mentioned in 19 08 11
19 08 14	sludges from other treatment of industrial waste water other than those mentioned in 19 08 13
20	Municipal wastes (household waste and similar commercial, industrial and institutional wastes) including separately collected fractions
20 01	separately collected fractions (except 15 01)
20 01 08	biodegradable kitchen and canteen waste
20 01 25	edible oil and fat
20 03	other municipal wastes
20 03 02	waste from markets

Table S2.3 Permitted waste types and quantities for the blood plant	
Maximum quantity	No annual limit
Exclusions	Notwithstanding the specification of waste types below, wastes shall not be treated at the installation which has no approval under the Animal By-Products Regulations.
Waste code	Description
02	Wastes from agriculture, horticulture, aquaculture, forestry, hunting and fishing, food preparation and processing
02 01	wastes from agriculture, horticulture, aquaculture, forestry, hunting and fishing
02 01 02	animal-tissue waste (blood only)

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 in the site emission point plan in application EPR/ BK0086IY/V007. Ref. 2005-1361-42 Rev C	Thermal oxidiser No.1	Particulate matter	150 mg/m ³ (liquid fuels)	Periodic over a minimum 4 hour period	Annual	BS EN 13284-1
			5 mg/m ³ (natural gas)			
		Oxides of Nitrogen (NO and NO ₂ expressed as NO ₂)	450 mg/m ³ (liquid fuel)	Periodic over a minimum 4 hour period	Annual	BS EN 14792
			140 mg/m ³ (natural gas)			
A2 in the site emission point plan in application EPR/ BK0086IY/V007. Ref. 2005-1361-42 Rev C	Thermal oxidiser No.2	Particulate matter	150 mg/m ³ (liquid fuels)	Periodic over a minimum 4 hour period	Annual	BS EN 13284-1
			5 mg/m ³ (natural gas)			
		Oxides of Nitrogen (NO and NO ₂ expressed as NO ₂)	450 mg/m ³ (liquid fuel)	Periodic over a minimum 4 hour period	Annual	BS EN 14792
			140 mg/m ³ (natural gas)			
A4 - A6 in the site emission point plan in application EPR/ BK0086IY/V007. Ref. 2005-1361-42 Rev C	Plant boiler No.2, Plant boiler No.3 and Plant boiler No.4 operated on Natural Gas Note 1	Oxides of Nitrogen (NO and NO ₂ expressed as NO ₂)	200 mg/m ³	Periodic	Every 3 years from date of acceptance of first monitoring measurements under condition 3.5.5	MCERTS BS EN 14792
		Carbon Monoxide	No limit set	Periodic		MCERTS BS EN 15058
	Plant boiler No.2, Plant boiler No.3 and Plant boiler No.4 operated on Liquid Fuels other than Gas Oil (Tallow) Note 1	Oxides of Nitrogen (NO and NO ₂ expressed as NO ₂)	No limit set	Periodic	After 1500 operating hours have elapsed and no less frequent than every 5 years from date of acceptance of first monitoring measurements under condition 3.5.5	MCERTS BS EN 14792
		Carbon Monoxide	No limit set	Periodic		MCERTS BS EN 15058
		Sulphur Dioxide	No limit set	Periodic		MCERTS BS EN 14791
		Dust	No limit set	Periodic		MCERTS

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
						BS EN 13284-1
A7 in the site emission point plan in application EPR/ BK0086IY/V007. Ref. 2005-1361-42 Rev C	Biofilter A	--	--	--	--	--
A8 in the site emission point plan in application EPR/ BK0086IY/V007. Ref. 2005-1361-42 Rev C	Biofilter B	--	--	--	--	--
A9 in the site emission point plan in application EPR/ BK0086IY/V007. Ref. 2005-1361-42 Rev C	Biofilter C	--	--	--	--	--
A10 in the site emission point plan in application EPR/ BK0086IY/V007. Ref. 2005-1361-42 Rev C	Biofilter D	--	--	--	--	--
A11 in the site emission point plan in application EPR/ BK0086IY/V007. Ref. 2005-1361-42 Rev C	Biofilter E	--	--	--	--	--
A12 in the site emission point plan in application EPR/ BK0086IY/V007. Ref. 2005-1361-42 Rev C	Biofilter F	--	--	--	--	--
A13 in the site emission point plan in application EPR/ BK0086IY/V007. Ref. 2005-1361-42 Rev C	Blood line odour scrubber	--	--	--	--	--
A14 in the site emission point	Combined heat and	Oxides of Nitrogen	95 mg/m ³	Periodic (average	Every 3 years	MCERTS

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
plan in application EPR/ BK0086IY/V007. Ref. 2005-1361-42 Rev C	power gas engine Note 1	(NO and NO ₂ expressed as NO ₂)		over one hour		BS EN 14792
		Carbon monoxide	No limit set	Periodic (average over one hour)	Every 3 years	MCERTS BS EN 15058
Note 1: Monitoring requirements are defined at a temperature of 273.15 K, a pressure of 101.3 kPa and after correction for the water vapour content of the waste gases at a standardised O ₂ content of 15% for engines.						

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 emission to River Chumet in the site emission point plan in application EPR/ BK0086IY/V007. Ref. 2005-1361-42 Rev C	Final treated effluent bulk storage tank from effluent treatment plant	Discharge volume	672 m ³ /day	Periodic Calendar day Dry weather conditions	Weekly average	As agreed in writing with the Environment Agency
		Ammonia	10 mg/l	Periodic	Daily	
		Total suspended solids	45 mg/l	Periodic over a minimum 3 hour period	Daily	
		Oil and grease	None visible	--	Daily	
		pH	5 – 9	Instantaneous	Continuous	
		Biochemical oxygen demand (BOD)	20 mg/l	Periodic	Weekly	
		Temperature	25°C	Periodic	Daily	
W2 emission to land in the site emission point plan in application EPR/ BK0086IY/V007. Ref. 2005-1361-42 Rev C	Final treated effluent bulk storage tank from effluent treatment plant	Temperature	35°C	Periodic	Daily	
		Ammonia	20 mg/l	Periodic	Daily	

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
Emissions to air Parameters as required by condition 3.5.1.	A1, A2, A14	Every 12 months (A1 & A2) Every 3 years (A14)	1 January
	A4, A5, A6 (Existing MCP) using natural gas	Every 3 years from date of acceptance of first monitoring measurements under condition 3.5.5	1 January
	A4, A5, A6 (Existing MCP) using tallow	After 1500 operating hours have elapsed and no less frequent than every 5 years from date of acceptance of first monitoring measurements under condition 3.5.5	1 January
Emissions to water Parameters as required by condition 3.5.1	W1, W2	Every 6 months	1 January, 1 July

Table S4.2: Annual production/treatment	
Parameter	Units
--	--

Table S4.3 Performance parameters		
Parameter	Frequency of assessment	Units
Water usage	Annually	tonnes
Energy usage	Annually	MWh
Total raw material used	Annually	tonnes
COD loss efficiency	Annually	COD te/te product
Food waste	Annually	Tonnes
*COD loss efficiency to be calculated on a weekly frequency, reported annually. Or equivalent calculation as agreed in writing by the Environment Agency.		

Table S4.4 Reporting forms		
Media/parameter	Reporting format	Date of form
Point source emissions to air	Emissions to Air Reporting Form, or other form as agreed in writing by the Environment Agency	Version 1, 08/03/2021
Water and Land	Form water 1 or other form as agreed in writing by the Environment Agency	10/12/19
Water usage	Form water usage 1 or other form as agreed in writing by the Environment Agency	10/12/19
Energy usage	Form energy 1 or other form as agreed in writing by the Environment Agency	10/12/19
Other performance indicators	Form performance 1 or other form as agreed in writing by the Environment Agency	10/12/19
Food Waste	Food waste Reporting Form, or other form as agreed in writing by the Environment Agency	Version 1 06/02/2023

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 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.

“background concentration” means such concentration of that substance as is present in:

- for emissions to surface water, the surface water quality up-gradient of the site; or
- for emissions to sewer, the surface water quality up-gradient of the sewage treatment works discharge.

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

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

“emissions to land” includes emissions to groundwater.

“EP Regulations” means The Environmental Permitting (England and Wales) Regulations SI 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 or background concentration limit.

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

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

“Industrial Emissions Directive” means DIRECTIVE 2010/75/EU OF THE EUROPEAN PARLIAMENT AND OF THE COUNCIL of 24 November 2010 on industrial emissions

“List of Wastes” means the list of wastes established by Commission Decision 2000/532/EC replacing Decision 94/3/EC establishing a list of wastes pursuant to Article 1(a) of Council Directive 75/442/EEC on waste and Council Decision 94/904/EC establishing a list of hazardous waste pursuant to Article 1(4) of Council Directive 91/689/EEC on hazardous waste, as amended from time to time.

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

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

“Medium Combustion Plant Directive” or “MCPD” means Directive 2015/2193/EU of the European Parliament and of the Council on the limitation of emissions of certain pollutants into the air from medium combustion plants, into the air from medium combustion plants, as read in accordance with Schedule 1A to the Environmental Permitting (England and Wales) Regulations 2016. “recovery” means any of the operations provided for in Annex II to Directive 2008/98/EC of the European Parliament and of the Council on waste.

“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.

“Waste code” means the six digit code referable to a type of waste in accordance with the List of Wastes and in relation to hazardous waste, includes the asterisk.

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

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

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

- in relation to emissions from combustion processes, the concentration in dry air at a temperature of 273K, at a pressure of 101.3 kPa and with an oxygen content of 3% dry for liquid and gaseous fuels 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 location plan

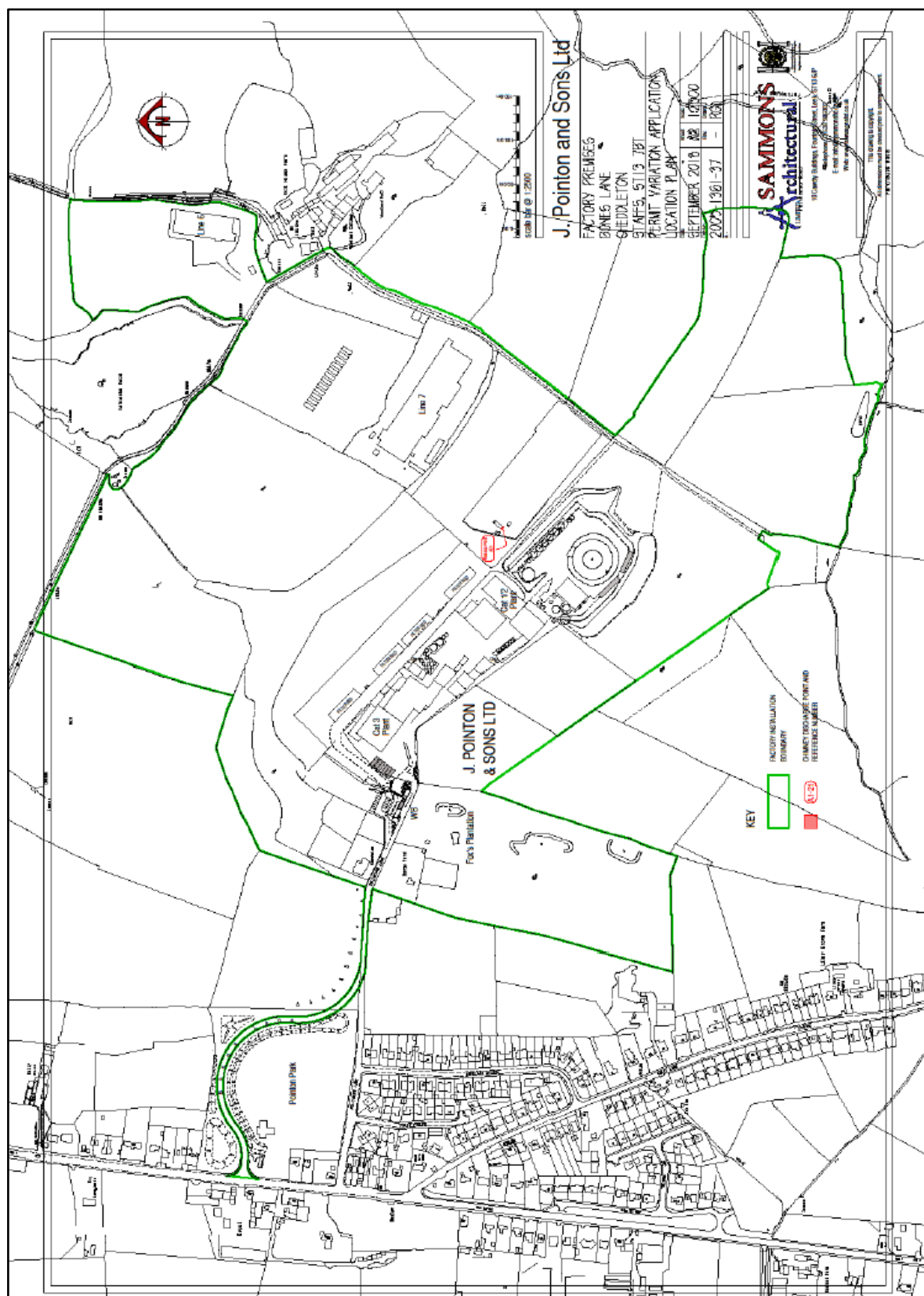


Table of Dimensions:

Dimension	Description
A1	Overall width of site
A2	Overall depth of site
A3	Overall length of site
A4	Overall width of site
A5	Overall depth of site
A6	Overall length of site
A7	Overall width of site
A8	Overall depth of site
A9	Overall length of site
A10	Overall width of site
A11	Overall depth of site
A12	Overall length of site
A13	Overall width of site
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A16	Overall width of site
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A95	Overall depth of site
A96	Overall length of site
A97	Overall width of site
A98	Overall depth of site
A99	Overall length of site
A100	Overall width of site

Permit number
EPR/HP3508BE