Foyle - Gloucester

Environmental Permit Application

EPR Ref: UP3700PX/A001

Non-Technical Summary

Document Ref: Attachment B.2.4

Non-Technical Summary: Foyle - Gloucester

Type: Bespoke Environmental Permit Application

Pre-app Case Ref (EPR): UP3700PX/A001

Installation address: Forest Vale Industrial Estate, Forest Vale Rd, Cinderford GL14 2PH.

Operations: Slaughter of Cattle and Processing of Beef.

For the purposes of all application documents, the site will be referred to as "Foyle - Gloucester".

Foyle - Gloucester is a subsidiary of Foyle Food Group Ltd (PLC).

Company House Number: NI034218

Schedule 1 Activity:

Environmental Permitting (England and Wales) Regulations 2016,
Schedule 1: Activities, Installations and Mobile Plant,
Part 2: Activities,

Chapter 6: Other Activities

Section 6.8: The treatment of animal and vegetable matter and food industries,
Part A(1): (b): *Slaughtering animals at a plant with a carcass production capacity of more than 50 tonnes per day.*

Section 6.8: The treatment of animal and vegetable matter and food industries,
Part A(1): (d): *Treatment and processing, other than exclusively packaging, of the following raw materials, whether previously processed or unprocessed, intended for the production of food or feed (where the weight of the finished product excludes packaging)*

(i) *Only animal raw materials (other than milk only) with a finished production capacity greater than 75 tonnes per day.*

Chapter 5: Waste Management

Section 5.4: Disposal, recovery or a mix of disposal and recovery of non-hazardous waste,
Part A(1): (a): *Disposal of non-hazardous waste with a capacity exceeding 50 tonnes per day (or 100 tonnes per day if the only waste treatment activity is anaerobic digestion) involving one or more of the following activities, and excluding activities covered by Council Directive 91/271/EEC concerning urban waste-water treatment(a):*

(ii) *"physico-chemical treatment"*

Overview

Foyle Food Group operates a slaughtering facility on a 13,000 M^2 site located at Forest Vale Road, Forest Vale Industrial Estate, Cinderford, Gloucester, GL14 2PH, United Kingdom. Activities at the site include the slaughter of cattle and the dressing, chilling and quartering of beef carcasses, the cutting of beef and the harvesting of offal, cod fat and bones, the packing of beef, beef offal, cod fat and bones into vacuum pouches and lined cardboard boxes.

The east of the site is bounded by the B4227 main road. The south of the site is bounded by a car breakers yard, while the north is bounded by an industrial facility. The west boundary of the site is made up of a mixture of trees, hedgerows and the Cinderford Brook, beyond which is the Severn Trent municipal plant.

The Cinderford Brook watercourse also runs adjacent to the western boundary of the site. Regionally, the site is positioned in an industrial estate on the outskirts of the town of Cinderford which itself is located on the eastern fringe of the Forest of Dean in Gloucestershire. The Forest of Dean is characterised by more than 110 km^2 of mixed woodland.

The facility has a carcass production capacity of more than 50 tonnes per day, which equates to 300 head of cattle. The actual tonnage of finished product produced in 2018 was 20,712 tonnes.

The site at Gloucester was acquired from the family run business, Ensor's Ltd, at the end of 2013. Major investment (> £3 million) has allowed an upgrade of the complete premises to a high standard. The site has approval from many of the major retailers in UK and Europe, however retail packing from the site is limited to the packing of primal joints for a single retailer on a seasonal basis. The site exports to Europe, Africa, Asia, South America and North America.

The company's customer base is split between commercial and retail. The site produces primal cuts and trims which are dispatched to wholesalers. The site carries out all their own boning. Previously some meat was dispatched as quarters for boning at the sister site in Omagh Ireland.

The site employs approximately 230 staff and is approximately 13,000 M^2 in area, with a weekly slaughter in excess of 1500 cattle from which carcase beef is processed.

The plant operates production shifts on a five-day basis between 07:00-18:00, while cleaning occurs between 19.00 – 01:00. Week-end work may occur at peak production times and the engineering team provide 24/7 cover.

The sites effluent treatment plants discharge volume for 2018 was 21,318 M^3, which equates to an average discharge of 58 M^3 per day. The 2019 annualized discharge volume, based on the first 24-week of the year, was calculated to be 28,043 M^3, which equates to an average discharge of 77 M^3 per day.

The rate of treated effluent discharge is limit to 100 M^3 per day as per the site discharge licence.

All waste is segregated on site for removal to offsite waste facilities as appropriate.

1.0 Description of Process

The main stages of meat production and processing at the facility are discussed below. Further detail can be found in Attachment B.3.8 - Site Operations.

Lairage
Cattle scheduled for slaughter are delivered to the site by road. The animals are placed in livestock holding pens in the lairage area.

Slaughter Lines
Cattle are stunned / killed and hung by their back legs on an overhead rail system. The cattle then have the main arteries in their throats cut by trained slaughter operatives.

Blood from slaughtered animals is collected by means of a dedicated collection system. Blood is then transferred from the blood trough to the blood storage tank.

Head, Horn and Hoof Removal
Heads, horns and hooves are manually removed from cattle carcasses using hydraulically operated cropping shears and are sent to Specified Risk Material (SRM) skips for staining with blue dye.

Hide Removal
After bleeding, cattle have the mask and ears manually removed. After removal, the mask, which is classed as SRM, is stored in dedicated storage areas and stained with blue dye before disposal.

Trimming and Evisceration
Green offal (lungs, trachea) are collected and taken for further processing as at an off-site facilities. Gut (paunch) contents is also removed at this stage and stored for collection by a contractor for land-spreading.

The respiratory, pulmonary and digestive organs are then removed and sent for disposal or further processing as required. Red offal (heart, liver and kidneys) are removed and sent to the Red Offal processing area.

Red Offal Further Processing
Further to being initially chilled, red offal is trimmed, packed, labelled and weighed and sent to the chill for storage.

Carcass Quartering
The cattle carcasses are split along the spine using purpose designed electric saws. The spinal cord is then removed from the carcass using a vacuum suction system. Each side is cut, resulting in beef quarters.

Chilling
The beef quarters are placed in chilled storage prior to deboning.

De-boning
Beef quarters are de-boned, with bones directed to the designated bones trailer. The product would then be weighed and inspected, before being packaged and palletised.

Dispatch

An off-site contract cold storage facility is used, which is approved at group level, and BRC certified.

Cleaning

Procedures ensure that residual material is removed from floors, water is used efficiently and employees are trained.

2.0 Raw Materials

The primary raw material used at the site is cattle.

The majority of the cattle are sourced from the local area and from within the West Country counties. The site has weekly slaughter in excess of 1,500 cattle from which beef is processed.

3.0 Effluent Treatment Plant

Process effluent flows to the effluent plant where large solids are removed via an auger screen prior to transfer to a balance tank. Treatment chemicals (coagulant and flocculant) are added to the effluent water to pre-treat the water prior to processing through the DAF plant and discharge into the Severn Trent Water Ltd sewer at S-1 under discharge licence.

Sludge from the DAF is pumped to the Lairage Sump, which is emptied daily.

Non-Production related foul water (i.e. toilets) is directed to Severn Trent Sewer at S-2.

Detailed information on the site's effluent treatment plant and associated environmental aspects can be found in Attachment B.3.4 & B.3.5.

4.0 Emissions

The environmental emission sources and their supporting descriptive or assessment documents for the purposes of this application are as follows:

Air Emissions – The factory uses two CFB 4VT natural gas-powered boilers, located in the Maintenance Workshop to supply process steam to the whole factory. Boilers are maintained annually in order to ensure efficiency (see Attachment B.3.2).

Odour Controls – The Effluent Treatment Plant is operated by employees in receipt of regular periodic training with the knowledge to ensure odour emissions are mitigated. An Odour Impact Assessment Survey and Odour Management Plan have been developed and submitted as part of this application (see Attachment B.3.10.1 & B.3.10.2).

Noise – An Environmental Noise Assessment Survey was carried out in support of this application (see Attachment B.3.11). The facility was not audible at any of the closest noise sensitive locations. Noise levels within the vicinity of the facility are primarily dominated by road traffic and other non-site related sources.

Surface Water – This is collected via a network of surface water drains, which pass through an interceptor, before discharging to the Cinderford Brook via W-1. Roof water is collected in a Grey-Water Tank and used for the washing of Lorries. (see Attachment B.3.3).

Waste – All waste streams are segregated on site and transported offsite to licenced waste facilities as appropriate. No waste is sent to landfill (see Attachment B.3.14).

5.0 Complaints

The site has not received any complaints with regards to noise.

In the first half of 2019, the site has received two complaints with regards to odour.

The first complaint was received on 30th May at 17:30pm via telephone, from a local resident. A follow-up call was made to the complainant by the site's environmental offices and a complaint report form was completed.

The second complaint was received on 5th June at 15:25pm via e-mail, from a member of the local council. This e-mail was regarding odour complaints received by the council from the Foxes Bridge Road area the previous week.

The council are to follow up with the complainants for further details (times, dates and type of odour).

6.0 Non-Conformance

6.1 Final Effluent Discharge Non-Conformance

Extensive improvements and upgrades were carried out at the site's effluent treatment plant between Q3 2017 and Q1 2018.

Works on the plant commenced on 29th August 2017 in response to a final effluent discharge non-compliance notification by Severn Trent Water Ltd.

These works included the installation of a new covered Balance Tank, a new DAF Unit and all associated concrete and pipe works.

See Attachment B.3.4 - Emissions to Sewer for further detail.

6.2 Surfacewater Non-Conformance

On Thursday 17th January 2019, the site was informed by the Environment Agency of a potential surface water contamination issue at Cinderford Brook, in the vicinity of the sites surface water discharge point.

After an investigation, it was determined that a number of drains within the rear yard area, which were understood to be part of the process drainage network were actually being directed to the surface water drainage network.

For the list of mitigation measures, see Attachment B.3.3 - Emissions to Surface Water for further detail.

7.0 EA Guidance

The Foyle – Gloucester Ossett Bespoke Environmental Permit Application is based on the following Environment Agency guidance documents:

- Guidance notes on Part A – About You
- Guidance notes on Part B2 – General New Bespoke Permit
- Guidance notes on Part B3 – New Bespoke Installation Permit
- Guidance notes on Part F1 – Charges and Declarations
- Horizontal Guidance Note H1 Overview Document
  - H1 Annex A – Amenity & accident risk from installations and waste activities
  - H1 Annex D.2 – Discharges to surface waters
  - H1 Annex E - Surface Water Discharges (complex)
  - H1 Annex F – Air Emissions
  - H1 Annex G – Disposal or recovery of waste produced on site
  - H1 Annex H – Global warming potential
  - H1 Annex J – Groundwater
  - H1 Annex K – Cost benefit analysis
  - H1 Software Tool User Guide Version 2.74
- H2 IPPC Guidance Note Energy Efficiency
- H3 (Part 2) Noise Assessment and Control
- H4 Odour Management (2011)
- H5 Site Condition Report – Guidance Note
- H5 Site Condition Report – Word Template
- Guidance: Risk assessments for your environmental permit
- Guidance: Surface water pollution risk assessment for your environmental permit
- Guidance: Air emissions risk assessment for your environmental permit
- Guidance: Groundwater risk assessment for your environmental permit
- Guidance: Control and monitor emissions for your environmental permit
- TGN: How to Comply with your Environmental Permit (EPR1.00) Version 8 (2014)
- TGN: How to Comply with your Environmental Permit: The Food and Drink Sector (EPR 6.10)

Appendix A: Site Layout Plan