



Non-technical Summary

Bradgate Bakery

FOR: SAMWORTH BROTHERS LTD

PROJECT NUMBER: ECCS 144 004

PREPARED BY: EC CONSULTANCY SERVICES LTD

Non-technical Summary

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1 NON-TECHNICAL SUMMARY

1.1 INTRODUCTION

This non-technical summary has been prepared in support of an application submitted to the Environment Agency (EA) for a variation to the existing installation permitted site (EPR/CP3430WV) located in Beaumont Keys, Leicester. The permit (commonly referred to as Bradgate Bakery) is operated by Samworth Brothers Ltd.

The site is a long-established Bakery business and employer in the local area which encompasses two facilities (Ashton Green & Madeline Road). The two facilities are collectively referred to as “Bradgate Bakery”. The site produces high quality ready to eat food products for major UK retailers. The processes carried out on site involve the production of sandwiches, wraps, pasta pots, and salads. Finished products are packed into skilnet sleeves, flow wrap, or plastic trays before being passed through to despatch. Product distribution is predominantly carried out by Samworth Brothers Supply Chain (SBSC), along with contract haulers to major supermarkets and convenience stores throughout the country. The Bakery employs approximately 1,600 people across the two sites and has been operational since 1993 (33 years ago). An Environmental Permit was originally applied for in 2015 (and subsequently granted in 2017) under one of the newly prescribed regulated activities within the Industrial Emissions Directive (IED).

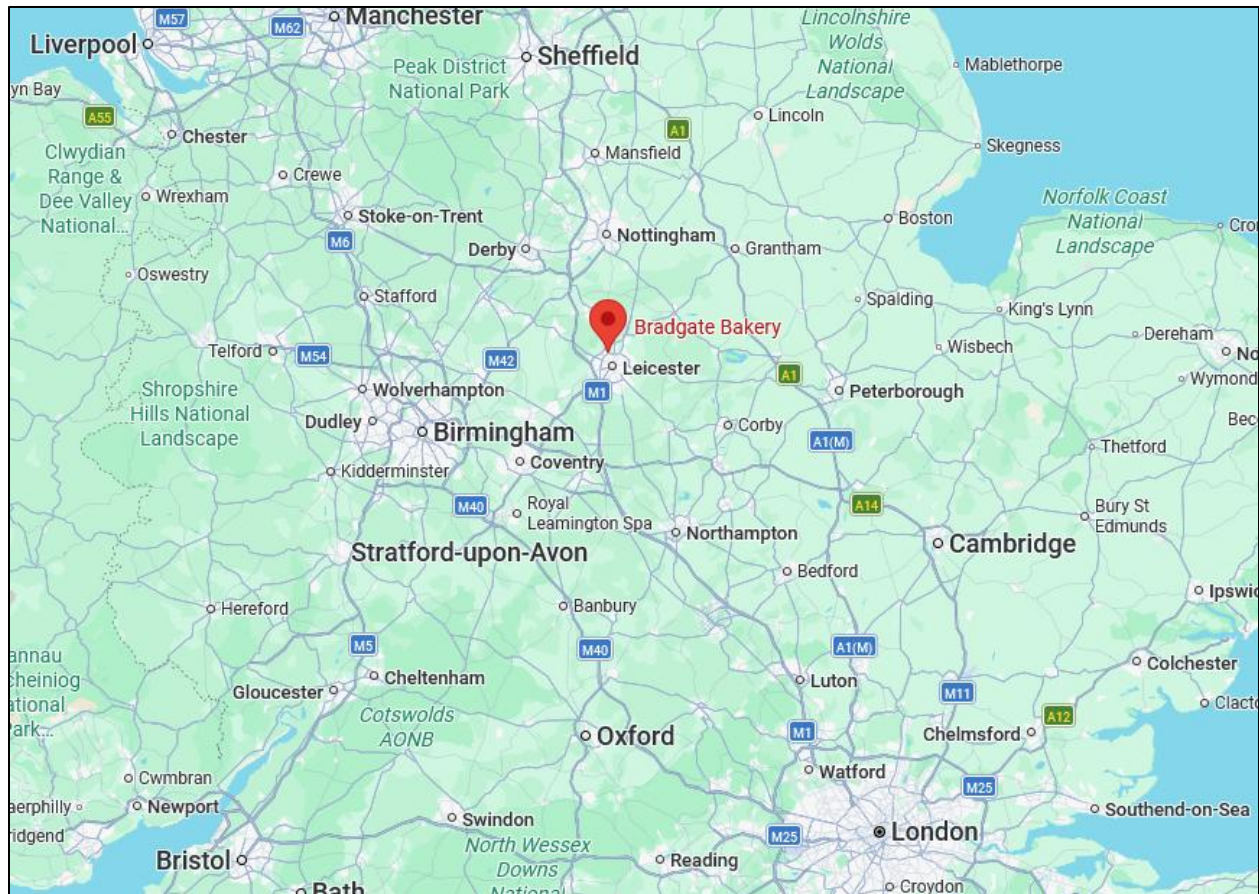
Samworth Brothers Ltd (Company No. 03116767) was incorporated on 20 October 1995. The company’s registered office address is: Chetwode House, 1 Samworth Way, Melton Mowbray, Leicestershire, LE13 1GA. The Company was originally founded in 1896 as a family business, with the Samworth group now employing over 9,500 people across the business Group.

1.2 SITE LOCATION AND ENVIRONMENTAL SETTING

The existing Bakery occupies some 6.2 acres of land and is located approximately 4 miles North-West of Leicester City Centre. The surrounding area consists of predominantly industrial units to the East and West, with small Greenfield areas to the South and North-West. The nearest residential areas are located to the North and South of the Bakery, beyond the Industrial Estate. To the West of the site is the ‘Walkers Charnwood Bakery’, which is another sister food manufacturing facility also owned and operated by Samworth Brothers Ltd. Access to the Industrial Estate is via the A563 (Kreffield Way) to the South, which links with the A46 which connects to Junction 21a of the M1 Motorway (approx. 5 miles to the South-West of the site). The nearest railway station is Leicester City Railway Station, located approximately 4.1 miles North-West of the site. The full site address is:

Bradgate Bakery
Madeline Road & Ashton Green
Beaumont Leys
Leicester
LE4 1WX

Figure 1.2.1 Site Location



Source: Google Maps © 2026

1.3 EXISTING PERMITTED ACTIVITIES

The site produces high quality ready to eat food products for major UK retailers. The processes carried out on site involve the production of sandwiches, wraps, pasta pots, and salads. Ingredients include bread, fresh produce, ready prepared cooked meats, dry pasta, rice, grains and ready to use sauces, all of which are from third party suppliers and delivered to site via third party road transport. Salad items are prepared in house by first entering through Intake, before passing through to the salad prep area, where produce is washed with chilled mains water and sliced/diced. Pasta is cooked and then transported to the quench and chill quench tanks before draining. Other ingredients will be de-boxed in Intake, transferred through sanitiser tunnel/de-bagged or removed from their cans prior to entering through to High Care. The individually prepared ingredients are then portioned into trays ready to be deposited mechanically or by hand on to the required product. Finished products are packed into skillet sleeves, flow wrap, or plastic trays before being passed through to despatch. Product distribution is predominantly carried out by Samworth Brothers Supply Chain (SBSC), along with contract haulers to major supermarkets and convenience stores throughout the country.

The primary Schedule 1 installation activity as currently listed in the permit as follows:

- **AR1 - Section 6.8 Part A(1)(d)(iii)(aa):** Treatment and processing, other than exclusively packaging, of animal and vegetable raw materials (other than milk only), both in combined and separate products, with a finished product production capacity in tonnes per day greater than 75 if A is equal to 10 or more. Where 'A' is the portion of animal material in percent of weight of the finished product production capacity. Production capacity is currently limited to 143 tonnes per day.
- **AR2 – Section 5.4 Part A1 (a) (ii):** Disposal of non-hazardous waste in a facility with a capacity exceeding 50 tonnes per day by Physico-chemical Treatment. prior to discharge to the foul to sewer.

The permit also has several Directly Associated Activities (DAAs):

- **AR3 – Steam supply** –Combustion plants:
 - 1 x 1 MWth natural gas fired boiler;
 - 6 x <1 MWth natural gas fired boilers;
 - 1 x < 1MWth natural gas steam generator;
 - 2 x <1 MWth natural gas fired ovens; and
 - 3 x < 1MWth natural gas fired tray wash burners.
- **AR4 – Raw material storage and handling** – Storage and handling of raw materials at the installation.
- **AR5 – Use of refrigerants** – Use of refrigerants in cooling, chilling and/or freezing systems at the installation.
- **AR6 – Storage and use of chemicals and oils** Storage and use of chemicals and oils at the installation.
- **AR7 – Waste storage and handling** Storage and handling of waste materials.
- **AR8 – Surface Water Drainage** collection of uncontaminated site surface waters.

1.4 CHANGES PROPOSED TO EXISTING PERMIT

The existing Installation Permit was varied in December 2024, and a Consolidated Permit issued following the completion of the Food and Drinks Sector Permit Review.

Since then, Samworth Brothers Ltd have secured a further investment for future development and expansion plans for their existing operations at the Bradgate Bakery site. The expansion project will include:

- the installation of multiple new production lines (up to 6 new lines) (which will result in an increase in overall daily throughput capacity at the site); and
- changes required to add an Effluent Treatment Plant (ETP) at the Ashton Green site. (It is worth noting that this new ETP will be located within the existing permitted site boundary and effluent will discharge via the existing consented discharge point to sewer from the site).

The above-mentioned changes to site operations will result in the following changes to the existing permitted activities:

- **Section 6.8 Part A(1)(d)(iii)(aa):** The new process lines will increase the overall throughput capacity at the site from the existing permitted daily production capacity of 143 tonnes per day to 250 tonnes per day; and
- **Section 5.4 Part A1 (a) (ii):** adding an additional listed activity to accommodate the new effluent treatment plant at the Ashton Green site.

The changes listed above will not result in any new point source emissions to air, groundwater, land, or sewer.

All changes proposed will take place within the existing permitted site boundary line.

1.5 PRE-APPLICATION CONSULTATION

The Operator applied for pre-application in June 2025. Site Specific advice was provided by Bethany Wignall via a series of email exchanges. A copy of the correspondence is provided within Appendix A to the main variation report (ECCS 144 004 R 002 A VR Final).

1.6 EXISTING ENVIRONMENTAL MANAGEMENT SYSTEM

The Environment Agency relies heavily upon the use of effective Environmental Management Systems (EMS) as a driver for environmental compliance and improvement.

The Bradgate Bakery Site currently implements their own comprehensive Environmental Management Systems (EMS) which is certified to ISO14001 standard. The existing EMS remains effective and will not require any significant changes as a result of this variation application with the exception of the inclusion of updated supplementary documentation as submitted within this application. The existing management teams, staffing levels and systems in place will remain fit for purpose. Further details of the existing EMS are provided within Variation Report (ECCS 144 004 R 002 A VR Final).

Samworth Brothers Ltd will remain responsible for making all investment decisions with regard permitted activities across both sites and will remain as the company responsible for overall compliance with any relevant permit conditions, power to employ and dismiss the key staff, and will ensure that emergency procedures are followed should a serious incidents occur across either of the two facilities.

1.7 ENVIRONMENTAL RISK ASSESSMENTS

An Environmental Risk Assessment has been completed as part of the preparatory work undertaken to support this permit variation application. The assessments undertaken have followed relevant guidance specified within the Environment Agency's Risk Assessment Guidance.

A number of assessments have been considered to determine the environmental risks posed by the new activity, and to identify whether the level of risk is considered acceptable. The risk assessment does not

assess existing activities that will remain unchanged, as these have already undergone assessment and are authorised under the existing permit.

The principal potential environmental impact from the proposed changes from the expansion operations across the site are potential noise impact from new plant and potential impact from loss of containment of effluent from the new ETP.

Detailed Noise Impact Assessment has been carried out to fully assess the potential for increased noise sources as a result of the changes across the site. The risk assessment concluded that the proposed changes to permitted activities will not result in an unacceptable impact on nearby sensitive receptors.

A CIRIA Risk Assessment has been carried out to establish the appropriate level of secondary containment required for all effluent and chemical storage tanks associated with the new effluent treatment process.

All other risk hazards identified have been considered and either assessed qualitatively or screened out as requiring no further detailed assessment.

The Operator already implements emergency procedures and protocols which are considered abnormal, or emergency situation associated with site operations. These procedures remain fit for purpose following implementation of the proposed expansion project.

The Operator has an existing Sewerage Discharge Consent from Severn Trent Water Ltd.

1.8 OPERATING TECHNIQUES, BAT ASSESSMENT AND MONITORING PLAN

Within the Variation Report (ECCS_144_004_R_002_A_VR_Final) full details are provided of the operating techniques that will be implemented across the site to minimise and control emissions from the proposed new activities and to demonstrate that the technology selection and control measures to be implemented follow Best Available Techniques (BAT).

Best Available Techniques (BAT) conclusions, under Directive 2010/75/EU of the European Parliament and of the Council, for the Food and Drinks Sector was published in 2019. Existing sites were required to demonstrate compliance (by 2023). All existing activities have already been considered against BAT as part of a separate study, prior to the compliance deadline of 2023. An updated BAT assessment has been submitted as part of this application for completeness.

1.9 SITE LAYOUT PLANS

A number of drawings have been submitted in support of this variation application. These drawings include the following:

- Existing Site Boundary Plan;
- Site Layout Plans;
- Revised Building Layout Plans;
- Emissions Plans;
- Drainage Plans;
- Process Flow Diagrams; and
- P&ID Drawings.

These drawings are contained within the Drawings Section of the submission.

