

Variation reference number: 548/25

Schedule 2

Operator	Aalberts Surface Technologies Heat Ltd
Installation Address	Hortonwood 40 Telford Shropshire TF1 7EY
Permit Reference	166/230622
Grid Reference	SJ 68446 13806
Registered Office	Aalberts Surface Technologies Heat Ltd 629 Blackhorse Road Letchworth Garden City Hertfordshire SG6 1HD

Aalberts Surface Technologies Heat Ltd is hereby permitted by Telford & Wrekin Council to carry out the solvent emission activity of surface cleaning, as defined under Schedule 14 of The Environmental Permitting (England and Wales) Regulations 2016 ("The Regulations") and other activities as listed, which operate within the installation boundary marked in red on the attached plan in Appendix 1.

Signed:



Name: Clair Travis

Date: 14 July 2025

Environmental Health Officer

Authorised by the Borough of Telford and Wrekin to sign in that behalf

Status log	Relevant Dates
Date Permit First Issued	15/07/2006
Date of previous variations	10/03/2016
Name change from Hauck Heat Treatment Ltd, change of company address and new permit reference given	23/06/2022
Date of Latest Variation – change of permitted plant and equipment and updating conditions to last PG note 6/45(11)	14/07/2025

Introductory Note – This Introductory note does not form part of the permit.

Determination of application

Conditions have been inserted as representing the authority's judgement of what constitutes BAT, having regard to the statutory guidance PG 6/45 -surface cleaning, issued by the Secretary of State and to all site-specific considerations.

Description of the installation

This installation carries out the solvent emission activity of surface cleaning, with an annual solvent consumption greater than 1 tonne of designated hazard statement materials.

Surface cleaning falls within the scope of the Industrial Emissions Directive as an activity which is defined in Annex VII, Part 1. All Annex VII activities therefore fall within the scope of solvent emission activities defined under Schedule 14 of the Environmental Permitting (England and Wales) Regulations 2016.

The vapour degreasing unit has been manufactured by Hemo GMBH and is located on the shop floor with no extraction to atmosphere. The equipment is suitable for a load or basket with an internal working dimension of 1.7m diameter x 1.85m high with a maximum load of 5 tonnes. Typical efficiency of the degreaser is defined that 1.5 tonnes of components will be approximately degreased in 45 minutes.

The unit has a vacuum cylinder chamber system with an operating temperature of approximately 90°C. The unit is a closed loop system, which recirculates most of the solvent. Metal components are cleaned in the unit using Perchloroethylene. The system is designed to have virtually no emissions to air during start up, normal operation and shut down operations.

The machine recycles the contaminated solvent using a combination of condensers, separators and filters. The 'clean' solvent then returns to the solvent storage tanks within the unit. Waste material and spent solvent is captured within a waste container, via an enclosed transfer system. New solvent is added via an enclosed transfer system, when required.

The unit is seated within a bund suitable to capture solvent should a leak occur.

The unit is managed through the inbuilt computerised control system and is interlocked with certain operations within the unit such as loading door control, cleaning and discharging waste, raw material loading, filters and storage tanks. The interlocking system is connected to the alarm system. All alarms are recorded by the control system.

Raw and waste solvent is stored outside the factory in a designated area. The storage containers, known as 'safetainers' are self-bunded containers. These are owned and maintained by the supplier. They also supply the solvent and remove the waste solvent.

The installation layout is in Appendix 2.

The site does not have emissions to atmosphere and therefore the requirement to monitor emissions has been removed from the permit.

End of Introductory Note

Permit Conditions

General

1. An appropriate person (and deputy) shall be appointed as the primary point of contact with the regulator. The regulator shall be informed in writing of the appointed person (and deputy). In the event of a different person being appointed, the regulator shall be informed without delay.
2. A copy of this permit shall be kept at the installation. All relevant staff shall be made aware of its content and shall be told where it is kept.
3. If the operator proposes to make a change in the operation of the installation, they must, at least 14 days before making the change, notify the regulator on the appropriate form. The notification must contain a description of the proposed change in operation. A 'change in operation' means a change in the nature or functioning, or an extension, of the installation, which may have consequences for the environment.
4. All records required to demonstrate compliance with any conditions of this Permit shall be kept in an organised manner. The records shall be kept electronically or in paper form. Records:
 - a) Must be legible and any amendment entered into a record shall be made in such a way as to leave the original clear and legible.
 - b) Records shall be kept for a period of 3 years, unless otherwise stated.
 - c) Records shall be kept on-site for a minimum of 12 months. Records kept off-site, must be made available within 7 days of any request by the regulator.
5. All documentation required to be submitted to the regulator to demonstrate compliance with relevant conditions, shall be submitted in an electronic format. Submissions shall be sent to:
environmentalprotectionteam@telford.gov.uk

Permitted activity

6. The Operator is only permitted to operate an installation for the activities listed within Table 1 below.

Table 1		
Activities listed in Environmental Permitting (England and Wales) Regulations 2016	Description of the specified activity	Limits of specified activity
Schedule 14 – Surface cleaning as described in Annex VII, Part 1, item 11, using compounds specified in Article 59(5) of the Industrial Emissions Directive.	Using Perchloroethylene solvent to remove contamination from the surface of material/components.	The cleaning activity shall only be carried out within the Hemo GMBH Vapour degreasing unit.
Directly associated activities		
The storage and handling of raw materials and waste materials	Storage and handling of solvent materials in bunded storage containers. The transfer of materials to the degreasing unit	Receipt, handling and storage of all solvent liquid materials, including the transfer to/from the degreasing unit, the storage and transfer of solvent materials within the degreasing unit and the designated storage area outside the building.

Solvent consumption

7. The Operator shall submit to the Regulator no later than 1 February of each year, an inventory of solvent use within the installation for the previous year. The inventory shall record:
- The mass of solvent in the initial stock (I_s) at the start of the accounting period;
 - the mass of solvent in the purchased stock (P_s) during the accounting period;
 - the mass of solvent in the final stock (F_s) at the end of the accounting period.
 - The total solvent input (I_1) using the following equation; $I_1 = I_s + P_s - F_s$
 - The total solvent recovered for reuse off-site (O_8)
 - The solvent consumption (C) using the equation; $C = I_1 - O_8$

Operational controls

8. The degreasing unit shall be operated in accordance with the manufacturer's instructions.
9. Raw materials containing VOC shall be stored in sealed storage containers.
10. The transfer of materials containing VOCs shall be carried out by an enclosed transfer system.
11. Materials designated with hazard statement H351 (namely Perchloroethylene), shall, be controlled under contained conditions as far as technically and economically feasible to safeguard public health and the environment.
12. All appropriate precautions shall be taken to minimise emissions during start-up and shutdown.
13. The solvent bund beneath the degreasing unit shall be kept free of debris, including spillages/ leaks, which shall be removed without delay.
14. Manual surface cleaning with VOC materials shall not be allowed.
15. The unloading/loading equipment, which operators shall be trained to use, shall be used for all loads.
16. When charging the degreasing unit with VOC materials and when pumping out waste, totally contained emission free transfer systems shall be used.
17. An electronic recording system to monitor and record the consumption of organic solvent shall be utilised to minimise the amount of excess organic solvent / organic solvent cleaners used.
18. A high standard of housekeeping shall be maintained.
19. The plant and equipment shall be fitted with audible and visual alarms, situated appropriately to warn the operator of plant failure or malfunction.
20. The activation of alarms shall be automatically recorded.

Waste

21. All solvent contaminated waste shall only be stored in suitably sealed containers.
22. Prior to disposal, empty drums and containers contaminated with organic solvent shall be closed to minimise emissions from residues during storage prior to disposal and labelled, so that all personnel who handle them are aware of their contents and hazardous properties.

Emissions

- 23.** There shall be no emissions of odour beyond the site boundary as perceived by the Regulator.
- 24.** In the case of abnormal emissions, malfunction or breakdown leading to abnormal emissions, the operator shall:
- investigate and undertake remedial action immediately;
 - adjust the process or activity to minimise those emissions;
 - promptly record the events and actions taken.
 - Inform the regulator of the incident and the action taken.
- 25.** Where emissions have the potential to cause immediate danger to human health, or the potential to cause immediate significant adverse effect upon the environment, operations must be suspended and the regulator informed without delay with the following information:
- The toxicity of the substances being released,
 - the amount released,
 - wind direction and weather conditions,
 - the location of the installation and sensitive receptors.
- 26.** The Regulator shall be informed without delay, if:
- There is an emission that is likely to affect the local community or environment.
- 27.** The Operator shall maintain a written procedure for dealing with plant and equipment failure.

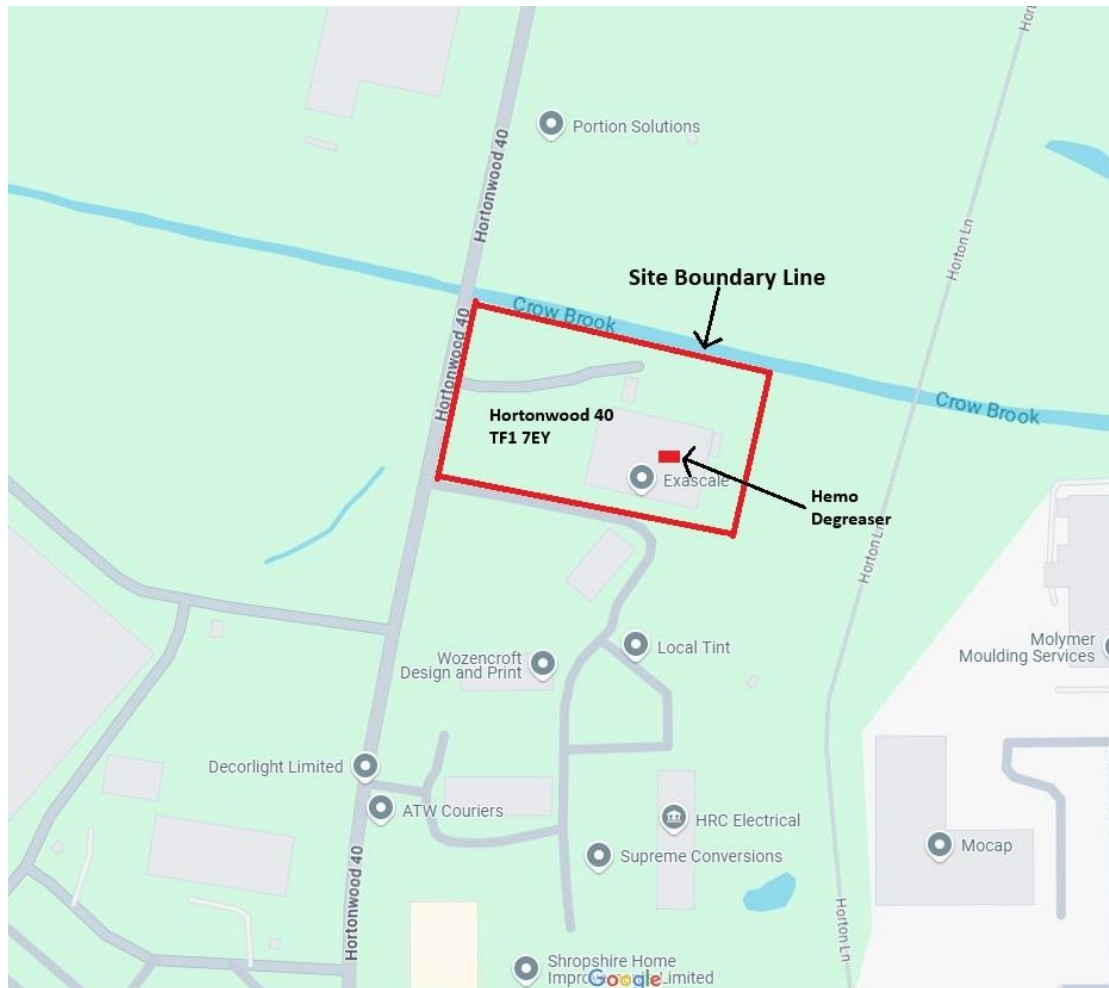
Training

- 28.** All staff whose functions could impact on emissions from the activity shall receive appropriate training on those functions. This shall include:
- awareness of their responsibilities under the permit;
 - The manufacturer's instructions on the operation of the degreasing unit, its controls and steps that are necessary to minimise emissions;
 - actions to take when there are abnormal conditions, or accidents or spillages that could, if not controlled, result in emissions;
 - Awareness of the responsibilities under the permit.
- 29.** The operator shall maintain a statement of training requirements for each post with the above-mentioned functions and keep a record of the training received by each person. These documents shall be made available to the regulator on request.

Maintenance

- 30.** The operator shall have available for inspection by the regulator:
- The manufacturer's instructions.
 - A written maintenance and servicing programme for the degreasing unit and its controls.
 - A record of the maintenance and servicing undertaken.

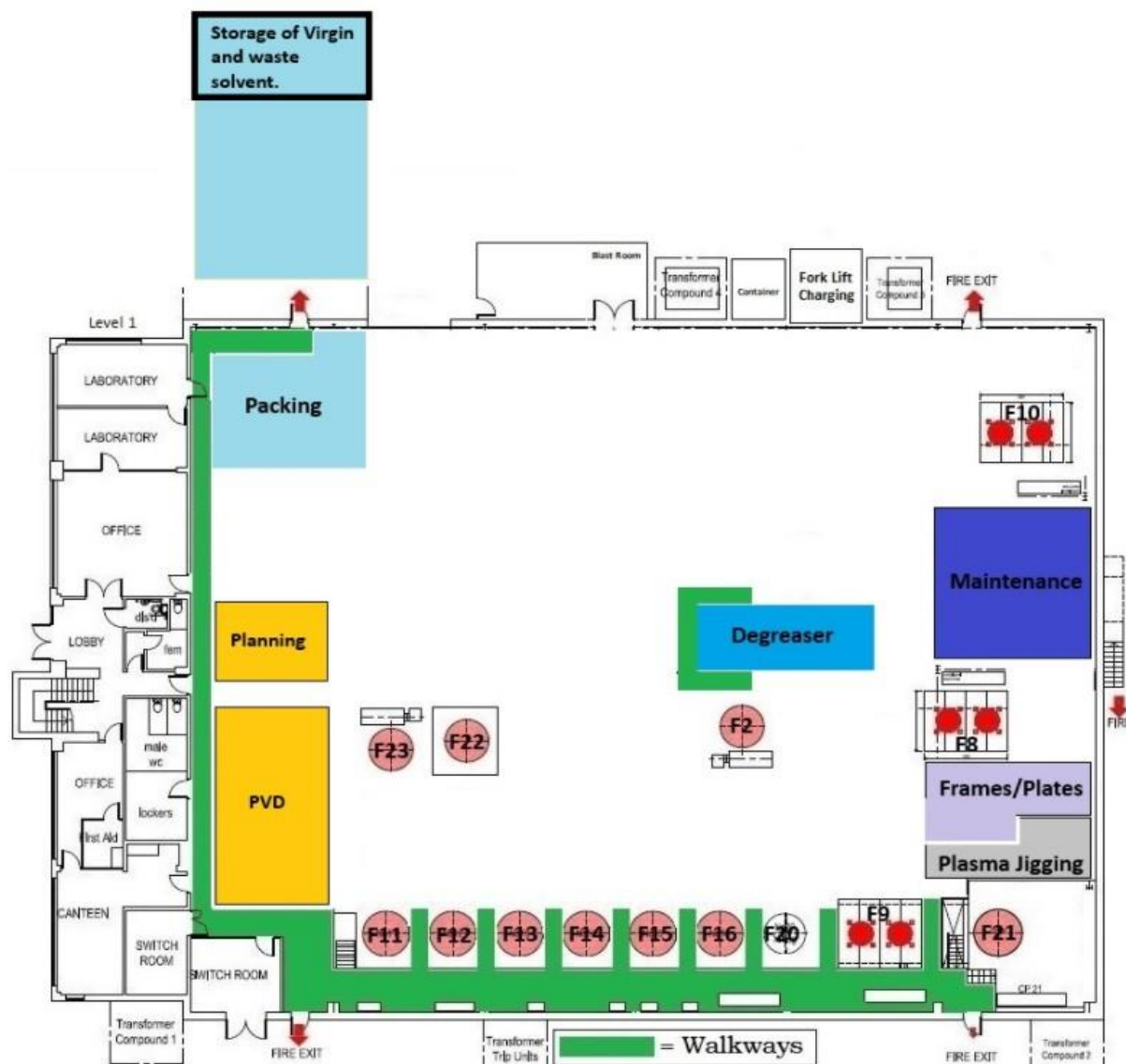
Appendix 1. Location of Installation Plan



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Appendix 2. – Site Layout



End of permit conditions

This section does not form part of the permit but contains guidance relevant to it.

I₁ Means the quantity of organic solvents or their quantity in mixtures purchased which are used as input into the process/activity (this is unlike the other solvent PG notes; the activity in this note includes organic solvents used in the cleaning of the products, but not those used for the cleaning of equipment).

O₈ Means organic solvents contained in mixtures recovered for reuse but not as input into the process/activity.

Appeal procedure

The operator can appeal against regulatory action by the regulator to the Secretary of State for Environment, Food & Rural Affairs. Appeals must be made in accordance with Regulation 31 and sent to the Secretary of State for Environment Food and Rural Affairs. The appeal for can be found at:

http://www.planning-inspectorate.gov.uk/pins/environment/environment/environmental_appeals/environmental_permitting_appeal_form.pdf

Guidance on the appeal procedure can be found at

http://www.planning-inspectorate.gov.uk/pins/environment/environment/environmental_appeals/environmental_permitting_guidance_notes.pdf

There are time limits for making an appeal as follows:

- a) in relation to an appeal against a revocation notice, before the notice takes effect;
- b) in relation to the withdrawal of a duly-made application under paragraph 4(2) of Schedule 5, not later than 15 working days from the date of the notice served under that paragraph;
- c) in relation to a variation notification, a suspension notice, an enforcement notice or a landfill closure notice, not later than 2 months from the date of the notification or notice;
- d) in any other case not later than 6 months from the date of the decision or deemed decision.

Please note:

An appeal will not suspend the effect of the conditions appealed against; the conditions must still be complied with.

In determining an appeal against one or more conditions, the Act allows the Secretary of State in addition to quash any of the other conditions not subject to the appeal and to direct the local authority either to vary any of these other conditions or to add new conditions.



Contact Numbers for the Regulator

The Regulator is the Public Protection Team of Telford & Wrekin Council. They can be contacted on 01925 381 818. You may also contact them by email at any time.

environmentalprotectionteam@telford.gov.uk

Correspondence Address

All correspondence to Telford & Wrekin Council relating to this information shall be addressed to: Public Protection, Telford and Wrekin Council, Darby House, Lawn Central, Telford, TF3 4JA.