



Operator	Holcim UK Ltd
Installation Address	Holcim Telford – Building (Blocks) Products Halesfield 21 Halesfield Telford TF7 4NF
Permit Reference	2681/161222
Grid Reference	SJ712053
Registered Office	Holcim UK Ltd Bardon Hill Bardon Road Coalville Leicestershire LE67 1TL
Registered Number	00245717

Holcim UK Ltd (“The Operator”) is hereby permitted by Telford & Wrekin Council (“The Regulator”) to operate a small waste incineration plant (SWIP) as defined under Schedule 13 of The Environmental Permitting (England and Wales) Regulations 2016 (“The Regulations”). To the extent authorised by and subject to the conditions of this Permit and operate within the installation boundary outlined in red as detailed in Appendix 1 of this permit.

Signed:

Name: Clair Travis

Date: 12 August 2024

Environmental Health Officer

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

CONTENTS

Introductory note	1
Permit status log	5
Contact details	5
Legislation that has been applied in this permit	6
Process flow diagram and non- technical description	7
Permit Conditions	9
General requirements	9
Permitted activities	9
Permitted waste	10
Operating techniques	11
Delivery and reception of waste	11
Soil and groundwater	12
Heat recovery	12
Residues	12
Permissible period of abnormal operation	13
Breakdown	14
Management	14
Emissions and pollution	15
Monitoring of emissions	15
Compliance with emission limits	16
Monitoring records and reporting	17
Records	18
Incidents and accidents	19
Residence time	19
Reduced operations	19
 Schedule A – Emission limits	 20
Schedule B – Interpretations	23
Schedule C – stack location	27
Schedule D - Delivery and acceptance of waste	28
 Appendix 1. Location of Installation	 30
Appendix 2. Site map and drainage map	31
 Table 1 – Permitted activities	 10
Table 2 – Permitted non-hazardous waste types	10
Table 3 – Exhaust stack and parameters	15
Table 4 – Emission limits and monitoring requirements	20
Table 5 – Permissible periods of abnormal operation emission limits & monitoring	22
Table 6 – Equivalence factors for dibenzo-p-dioxins and dibenzofurans	22

Introductory Note

This Introductory provides relevant information related to this Permit

Decision to grant

The following permit is granted to Holcim UK Ltd as required under Regulation 13 of the environmental Permitting (England and Wales) Regulations 2016 ("the Regulations") to operate an installation to carry out the activity described in Schedule 13 of The Regulations, to the extent authorised by the Permit.

The permit is issued on the basis that the information provided by the applicant in support of the application for a permit was neither false nor misleading. Any change affecting the accuracy of such information shall be promptly notified, in writing, to Telford and Wrekin Council at the contact address.

Confidentiality

The permit requires the Operator to provide information to the Regulator. The Regulator will place the information onto the public register in accordance with the Regulations. If the Operator considers that any information provided is commercially confidential, they may apply to the Regulator to have such information withheld from the register as provided in the Regulations. To enable the Regulator to determine whether the information is commercially confidential, the Operator must clearly identify the information in question and must specify clear and precise reasons.

Inspections and risk rating

Under the Regulations, the Regulator is required to undertake appropriate periodic inspections of regulated facilities. Inspections will be undertaken in accordance with the LA-IPPC risk method risk assessment and following on from any complaints or applications.

Procedures and records shall be examined during inspections and will be referred to during the DEFRA annual risk rating of the permitted site. The site will be determined as either a LOW, MEDIUM or HIGH risk. This will determine the annual subsistence fee and the frequency of inspection.

Annual subsistence fee

An annual subsistence fee is payable to operate the permitted installation. An invoice will be issued annually. Failure to pay the subsistence fee may result in a late payment fee and/or revocation of the permit. You are reminded that the operation of an installation without a permit is an offence upon summary conviction to a fine and/or imprisonment.

Responsibility under other statutory requirements.

This permit is given in relation to the requirements of the Environmental Permitting (England and Wales) Regulations 2016 (as amended). It must not be taken to replace any responsibilities you may have under workplace health and safety

legislation. Neither does it detract from any statutory requirement such as the need to obtain Planning Permission and/or building Regulations approval.

For the prevention of accidents, the methods employed, and the equipment used to ensure the correct handling, storage and use of flammable materials needs to be determined by trained personnel in accordance with HSE guidance and the Dangerous Substances and Explosive Atmosphere Regulations (DSEAR).

Appeals

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 form 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 brought under Regulation 32(2)(b) and Schedule 6, in relation to the conditions of a permit 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 Regulations allows the Secretary of State in addition to quash any other conditions not subject to the appeal and direct the local authority either to vary any of these, or other conditions, or add new ones.

Review of Conditions

Under the Regulations the legislation requires permits to be 'reviewed' periodically but does not specify the frequency. It is considered that a frequency of once every eight years shall be adequate. Where significant pollution is encountered or where

there are changes to BAT, or where the operational safety of the activity requires other techniques to be used, an immediate review shall be undertaken.

Variation of the permit or part of the permit

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.

The operator may be liable to prosecution if they operate otherwise than in accordance with the conditions and plant described in this permit.

Transfer of the permit or part of the permit

Before the permit can be wholly or partially transferred to another person, an application to transfer the permit has to be made jointly by the existing and proposed operators. A transfer will be allowed unless the regulator considers the proposed operator will not be the person who will have control over the operation of the installation or will not comply with the conditions of the transferred permit.

Surrender of the permit or part of the permit

Where the operator intends to cease the operation of an installation (in whole or in part). For A2 permits, the Operator must apply for a surrender, using the appropriate form and in accordance with Regulation 25 and part 1 of Schedule 5 of the Regulations.

Offences

Offences under Regulation 38 of the Regulations are:

- (1) It is an offence for a person to—
 - (a) contravene regulation 12(1), or
 - (b) knowingly cause or knowingly permit the contravention of regulation 12(1)(a).
- (2) It is an offence for a person to fail to comply with or to contravene an environmental permit condition.
- (3) It is an offence for a person to fail to comply with the requirements of an enforcement notice or of a prohibition notice, suspension notice, landfill closure notice, mining waste facility closure notice, flood risk activity emergency works notice or flood risk activity remediation notice.
- (4) It is an offence for a person—
 - (a) to fail to comply with a notice under regulation 61(1) requiring the provision of information, without reasonable excuse;
 - (b) to make a statement which the person knows to be false or misleading in a material particular, or recklessly to make a statement which is false or misleading in a material particular, where the statement is made—
 - (i) in purported compliance with a requirement to provide information imposed by or under a provision of these Regulations,



- (ii) for the purpose of obtaining the grant of an environmental permit to any person, or the variation, transfer in whole or in part, or surrender in whole or in part of an environmental permit, or
 - (iii) for the purpose of obtaining, renewing or amending the registration of an exempt facility;
- (c) intentionally to make a false entry in a record required to be kept under an environmental permit condition;
- (d) with intent to deceive—
 - (i) to forge or use a document issued or authorised to be issued or required for any purpose under an environmental permit condition, or
 - (ii) to make or have in the person's possession a document so closely resembling such a document as to be likely to deceive.
- (5) It is an offence for an establishment or undertaking to—
 - (a) fail to comply with paragraph 17(3) or (4) of Schedule 2, or
 - (b) intentionally make a false entry in a record required to be kept under that paragraph.
- (6) If an offence committed by a person under this regulation is due to the act or default of some other person, that other person is also guilty of the offence and liable to be proceeded against and punished accordingly, whether or not proceedings for the offence are taken against the first mentioned person.

Penalties and enforcement undertakings

Penalties under Regulation 39 of the Regulations are:

- (1) Subject to paragraph (2), a person guilty of an offence under regulation 38(1), (2) or (3) is liable—
 - (a) on summary conviction to a fine or imprisonment for a term not exceeding 12 months, or to both;
 - (b) on conviction on indictment to a fine or imprisonment for a term not exceeding 5 years, or to both.
- (2) A person guilty of offence under regulation 38(1), (2) or (3) in respect of a flood risk activity is liable—
 - (a) on summary conviction to a fine or imprisonment for a term not exceeding 12 months, or to both
 - (b) on conviction on indictment to a fine or imprisonment for a term not exceeding 2 years, or both.
- (3) In relation to an offence committed before the commencement of section 154(1) of the Criminal Justice Act 2003(a), paragraphs (1)(a) and (2)(a) have effect as if for "12 months" there were substituted "6 months".
- (4) A person guilty of an offence under regulation 38(4) is liable—
 - (a) on summary conviction to a fine;
 - (b) on conviction on indictment to a fine or imprisonment for a term not exceeding 2 years, or to both.
- (5) An establishment or undertaking guilty of an offence under regulation 38(5) is liable on summary conviction to a fine not exceeding level 2 on the standard scale.
- (6) Schedule 26 (enforcement undertakings) has effect.

Permit status log

Detail	Dates
Date Permit First Issued	21 December 2021
Date of variations	16 December 2022
Change of ownership of the company. Now owned by Aggregate Industries Ltd. Transfer application completed and registered head office address updated. Still trading and operating under Besblock Ltd. No other permit changes made.	15 January 2024
Permit application for reduced operations and fees (Mothballing) accepted	1 July 2024
Permit variation to included conditions 69, 70 and 71, relating to the reduced operations.	7 August 2024
Permit transferred from Besblock Ltd to Holcim UK Ltd	27 August 2025

Reduced Operations

The permit has entered a period of reduced operations known as 'mothballing' after an application was received. The site has declared that the activity has ceased and is not expected to commence for at least a period of 12 months. Therefore, the application was accepted.

The permit has been updated to include a condition that stipulate the maximum time period allowed for mothballing. Conditions have been included to include the requirement to surrender the permit or it reverts to a full permit and fees after the period ends, or to provide evidence that the plant has been commissioned to the standards of the permit before recommencing operations.

Contact Details

The contact address, telephone number and email address for all correspondence in terms of the permit is as follows:

Public Protection
Telford and Wrekin Council
Addenbrooke House
Telford
TF3 4NT

Telephone: 01952 381818

Email: environmentalprotectionteam@telford.gov.uk

End of Introductory Note

Legislation that has been applied in this permit

The conditions within this permit have been made in accordance with Schedule 13 of The Environmental Protection (England and Wales) Regulations 2016 (as amended).

Telford and Wrekin Council has applied the following Articles listed with Schedule 13 from Directive 2010/75/EU the Industrial Emissions (The IED):

Small waste incineration Plant (SWIP) is described in the Regulations as; 'a waste incineration plant or waste co-incineration plant with a capacity less than or equal to 10 tonnes per day for hazardous waste, or 3 tonnes per hour for non-hazardous waste.'

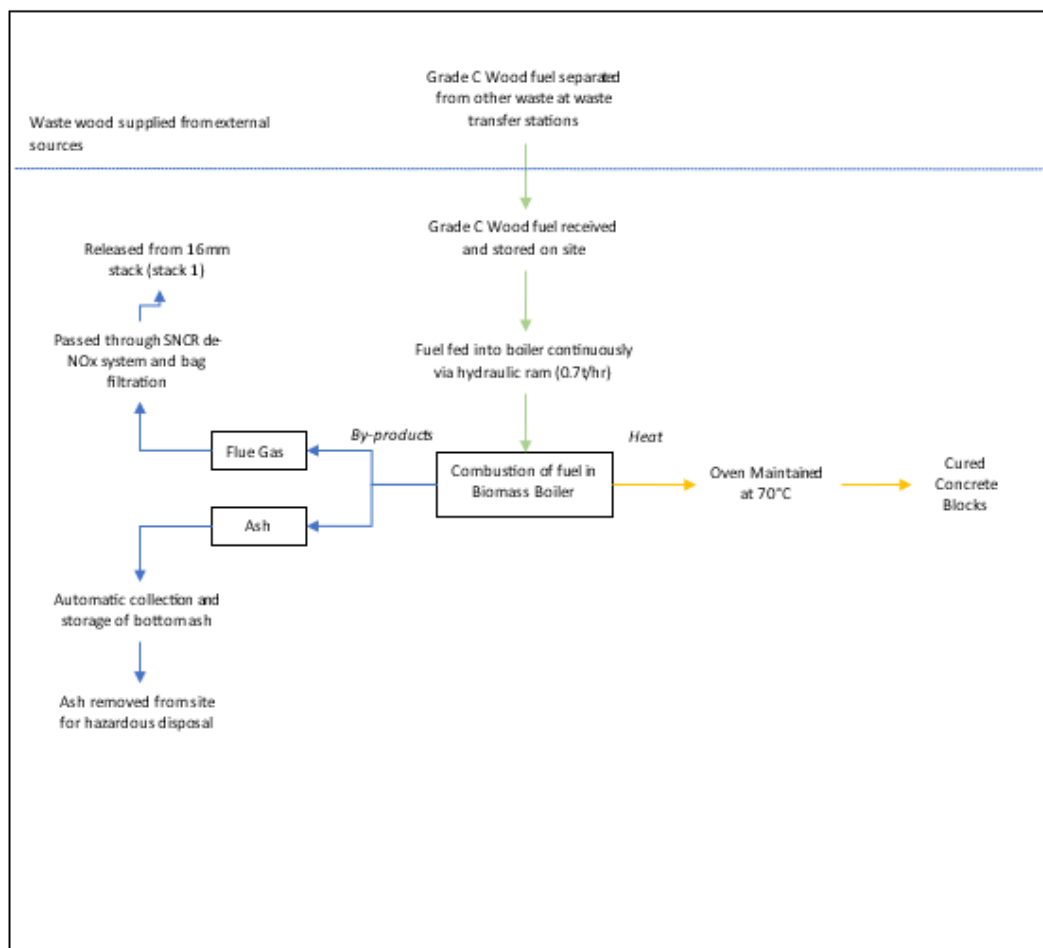
Article number applied	Article description
Article 7	Incidents and accidents
Article 8(2)	Non-compliance
Article 45(1), (2) and (4)	Inclusion of certain permit conditions
Article 46	Control of emissions
Article 47	Breakdown
Article 48 (1) to (4)	Monitoring of emissions
Article 49	Compliance with emission limit values
Article 50	Operating conditions
Article 52	Delivery and reception of waste
Article 53	residues

All other relevant legislation

Directive 2008/96/EC on Waste (Waste Framework Directive)

Commission Decision 2000/532/EC List of Wastes and Hazardous Wastes.

Process flow diagram and non- technical description



The plant operating at this site is for the purpose of the incineration of non-hazardous waste. The installation will then use the recovered heat for the oven used for concrete curing.

This site has been determined as an incineration plant. Although heat is recovered and used within the curing ovens, Guidance states that: 'Where waste and fuel are co-fired, if the purpose of the fuel is simply to raise the overall calorific value sufficiently to ensure the waste is efficiently destroyed, (because combustion would not otherwise be self-sustaining) then the primary purpose of the plant is waste disposal and the plant is an incinerator.'

The waste wood incineration plant will be housed in an existing building onsite and will be fed by a direct hydraulic infeed ram to allow constant feed. The site intends to store the fuel within the same building adjacent to the boiler to keep the wood dry.

The fuel is classed as Grade C waste wood. Grade C wood consists of non-hazardous waste wood sourced mainly from construction and demolition activities, recycling centres and civic amenity sites.

The by-products of the process are ash and flue gas. The boiler has an automatic de-ashing auger to remove bottom ash, which is then collected and removed from the site for hazardous disposal.

An abatement system is fitted to the boiler to limit the emissions in flue gases, this includes a SNCR de-NO_x system, Sodium Bicarbonate dosing, bag filtration to reduce particulate, NO_x and acid production. There will also be a continuous emissions monitoring system for the boiler.

The Reverse Osmosis unit will be used to purify the water in the biomass boiler plant by removing contaminants from the water before it enters the boiler. This is not part of the permitted activity but does form part of the plant.

Waste activities outside of the scope of the permit

If waste pre-treatment activities are operated independently of the incinerator with the outputs of that pre-treatment sent off-site for other treatments. This pre-treatment process will require a separate waste operation permit from the Environment Agency.

Permit Conditions

Unless otherwise stated, all conditions and schedules herein shall be complied with from the date of issue of this permit.

General Requirements

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 operation of the installation, he must, at least 14 days before making the change, notify the regulator in writing and on the appropriate application form from the regulator.
4. The Operator shall notify the Regulator in writing and within 14 days of their occurrence if they make:
 - a. Any change to the installation name, registered company name or company registered address.
 - b. A change to any particulars of the holding company (including details of any ultimate holding company where the Operator has become a subsidiary).

Permitted activities

5. The Operator is authorised to carry out the activities specified in Table 1. The activities shall only be carried out within the small waste incineration plant listed within Table 1 and shown on the plan in Appendix 2, and under the conditions of this Permit. Emissions from the activity shall not extend beyond the boundary of the site shown in red on the plan in Appendix 1.

Table 1 - Permitted activities			
Activity to which to EP Regulations apply	Make, Model and Serial number and type of SWIP and abatement system,	Description of specified activity	Limits of specified activity
Schedule 13 - Small Waste Incineration Plant (SWIP)	Binder Herz, Steam DK, 1650kW, waste wood incineration plant (boiler), with a direct hydraulic infeed ram. Variable heat load 1200kW to 1650kW.	The incineration of non-hazardous waste in a waste incineration plant with a capacity of less than 3 tonnes per hour.	From receipt of waste wood to the emission of exhaust gas and disposal of waste arising. Waste types and quantities as specified in Table 2 of this permit. Maximum of 175 tonnes at any one time and no more than 5903 tonnes per year. Maximum capacity of 860Kg/hour
	The abatement system: Selective non-catalytic reduction system, the MZA flue gas dust collector and bag filter, and the sodium bicarbonate injection system	Waste gases from the incinerator to pass through the abatement system before being expelled	The use of the auxiliary burner powered by natural gas to bring the incinerator to temperature of 850°C before charging waste wood, and/or to bring the incinerator to temperature of 850°C during abnormal operations. The handling, storage and removal of residues from the incineration of waste wood The exit of abated emissions through stack 1

Permitted waste

6. The Operator shall incinerate only those non-hazardous waste types listed in Table 2 and within the permitted annual usage.

Table 2 - Permitted non-hazardous waste types				
Waste code	Description	Waste type	Source	Permitted annual usage
17 02 01	Wood	Non-hazardous	grade C waste wood sourced from local waste processing companies	A total of up to 5903 tonnes per annum
19 12 07	Wood other than that mentioned in 19 12 06			



7. Waste wood shall only be accepted if:
 - a. It meets the requirements listed in Table 2 and
 - b. It conforms to the description in the documentation supplied by the producer or holder.
8. The Operator shall not incinerate any hazardous waste.
9. The maximum input of waste that may be incinerated in the small waste incineration plant is 5903 tonnes per annum, at a rate not exceeding 860Kg/hr tonnes per hour.

Operating techniques

10. Waste incineration plants shall be designed, equipped, built and operated in such a way that the gas resulting from the incineration of waste is raised in a controlled and homogeneous fashion and even under the most unfavourable conditions, to a temperature of at least 850 °C for at least two seconds.
11. Waste shall not be charged, or shall cease to be charged:
 - a. Until the combustion chamber is at 850°C,
 - b. The combustion chamber temperature monitor is below, or falls below, 850°C, or
 - c. any continuous emission limit value in Table 4 of schedule A is exceeded, other than under permissible periods of abnormal operation or
 - d. monitoring results required to demonstrate compliance with any continuous emission limit value in table 4 of Schedule A are unavailable other than during permissible periods of abnormal operation,
 - e. any continuous emission limit value for permissible periods of abnormal operation in table 5 of Schedule A is exceeded.
12. The auxiliary burner for the combustion chamber shall commence automatically at start-up or shut down or whenever the operating temperature falls below 850°C, as long as incomplete burned waste is within the combustion chamber.
13. The small waste incineration plant shall have an automatic system in place to prevent waste feed in the case of abnormal operation set out in condition 11.

Delivery and reception of waste

14. The operator must have procedures in place to ensure that only the permitted types of waste described in Table 2 are accepted.
15. Delivery of waste shall be carried out using covered transport directly into the storage building.

16. The delivery and reception of the permitted waste shall, subject to the conditions of this permit, be operated using the techniques and in the manner described in Schedule D.
17. Emissions from the delivery and reception of waste shall be free from odour and/or noise at levels likely to cause pollution outside the site boundary, as perceived by regulator.
18. The delivery and reception of waste shall not give rise to the presence of pests, odour or noise which are likely to cause pollution, hazard, or annoyance outside the boundary of the site.
19. No hazardous waste shall be accepted on site.

Soil and groundwater

20. The installation shall be operated in such a way as to prevent the unauthorised and accidental release of any polluting substances into soil, surface water and groundwater.
21. The storage of waste shall within a secure building on an impermeable surface, with appropriate secondary containment and a sealed drainage system.
22. All areas of the installation must have an impermeable surface.

Heat Recovery

23. The Operator shall ensure that any heat generated by the permitted incineration plant shall be utilised within the concrete curing oven.

Residues

24. The permitted installation shall be operated in such a way as to achieve a level of incineration such that the total organic carbon content of slag and bottom ashes is less than 3 %, or their loss on ignition is less than 5 % of the dry weight of the material. If necessary, waste pre-treatment techniques shall be used.
25. Bottom ash, fly ash and APC residues shall not be mixed and shall be disposed in accordance with their hazard risk rating by permitted waste management facilities.
26. Prior to determining the routes for the disposal or recycling of all residues, appropriate tests shall be carried out to establish the physical and chemical characteristics and the polluting potential of the residues. Those tests shall concern the total soluble fraction and heavy metals soluble fraction.



27. As a minimum, residues shall be sampled, tested and analysed in accordance with the Ash Sampling Protocol (TGN M4 or subsequent issues), and assessed against the criteria in Waste Classification (TGN WM3 or subsequent issues).
28. Residue samples shall be taken and tested and appropriate action taken:
- Within one month of the commencement of operations.
 - Whenever disposal or recovery routes change; or
 - When it is suspected that the nature or composition of the waste has changed such that the route currently selected may no longer be appropriate.

Permissible period of abnormal operation.

29. The operator shall record:
- The beginning and end of each permissible period of abnormal operation,
 - The reason for the permissible period abnormal operation,
 - The continual monitoring data of emissions released during the permissible period abnormal operation,
 - The action taken to restore the operations to normal operations.
30. During a permissible period of abnormal operation, The Operator shall restore normal operation of the failed equipment or replace the failed equipment as rapidly as possible.
31. Where, during permissible periods of abnormal operation any of the following situations arise, waste shall cease to be charged until normal operation can be restored:
- continuous measurement shows that an emission exceeds any emission limits in Table 5 of Schedule A, for a total of 4 hours uninterrupted duration;
 - there is a technically unavoidable stoppage, disturbance or failure of the abatement system or waste gas cleaning devices for a total of 4 hours uninterrupted duration;
 - the cumulative duration of "permissible periods of abnormal operation" over 1 calendar year has reached 60 hours;
 - Continuous emission monitors are unavailable.

Permissible periods of abnormal operation shall mean; any technically unavoidable stoppages, disturbances, or failures of the purification devices or the measurement devices, during which the emissions into the air and the discharges of wastewater may exceed the prescribed emission limit values.



- 32.** The Operator shall interpret the end of the permissible period of abnormal operation as the earliest of the following:
- when the failed equipment is repaired and brought back into normal operation;
 - when the operator initiates a shutdown of the combustion activity, as described in the application or as agreed in writing with the regulator.
 - when a period of four hours has elapsed from the start of the permissible period of abnormal operation;
 - When, in any calendar year, an aggregate of 60 hours has been reached for permissible periods of abnormal operation.

Breakdown

- 33.** In the case of a breakdown, the operator shall reduce or closedown operations as soon as practicable until normal operations can be restored.

Management

- 34.** The Operator shall manage and operate the activities authorised by this Permit:
- In accordance with a written environmental 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.
 - In accordance with written procedures to be held within the environmental management system. The procedures shall include:
 - Delivery and receipt of waste
 - Operating techniques
 - Incidents , accidents and breakdowns
 - Permissible period of abnormal operations.
 - Heat recovery
 - Residues
 - Maintenance
 - Emissions and pollution
 - Monitoring.
 - Reporting.
 - Training.
 - Odour/noise/ pest management.
 - Record keeping
 - Using competent persons that have been trained in the requirements of the approved competence scheme held within the environmental management system.

35. Records demonstrating compliance with Condition 34 shall be maintained and made available for inspection by the regulator.
36. The documentation described in Condition 34 and 35 shall be kept in a place that will allow convenient access to all relevant staff.

Emissions and Pollution

37. The emission limits given in tables 4 and 5 of schedule A shall not be exceeded.
38. Odour, noise, pests and emissions of substances not controlled by emission limits shall not cause nuisance and/or pollution.

Monitoring of emissions

39. All permitted emissions shall only exit through the exhaust stack detailed in Table 3.

Table 3 - Exhaust stack and parameters					
Stack number	Description	Release height	Stack diameter	Exit temperature	Efflux velocity
1	emission point serving the boiler and abatement system described in Table 1, at the location detailed in Schedule C	16m from ground level	550mm	160°C	7.6m/s

40. The location of all sampling points to be used for the monitoring of emissions, shall not be fitted without written agreement with the regulator prior to their installation.
41. The Operator shall, unless otherwise agreed in writing by the regulator, undertake the monitoring specified in table 4, and 5 of schedule A, using the methods stated in table 4 and 5.
42. For the determination of the total concentration of dioxins and furans, the mass concentrations of the dibenzo-p-dioxins and dibenzofurans specified in table 4 shall be multiplied by the toxic equivalence factors set out in table 6 before summing
43. 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.



44. Unless otherwise stated, any references in this permit to concentrations of substances in emissions into air means in relation to gases from incineration plants, the concentration in dry air at a temperature of 273K, at a pressure of 101.3 kPa and with an oxygen content of 11% vol.
45. Monitoring equipment, techniques, personnel and organisations employed for the emissions monitoring programme and the environmental or other monitoring specified in this permit, shall have either MCERTS certification or MCERTS accreditation (as appropriate) unless otherwise agreed in writing by the regulator.
46. Newly installed CEMs, or CEMs replacing existing CEMs, shall have MCERTS certification and shall be calibrated annually in accordance with Environment Agency TGN M20 (or subsequent documents).
47. Permanent means of access shall be provided to enable sampling/monitoring to be carried out in relation to the emission points on Stack 1.

Compliance with emission limits

48. In the case of continuous measurements, the half-hourly average values and the 10-minute average values shall be determined within the effective operating time, i.e. excluding the start-up and shut-down periods provided no waste is being incinerated.

The value of the 95% confidence interval shall then be subtracted from the measured value. The daily average values shall then be determined from those validated average values.

49. To obtain a valid daily average value no more than five half-hourly average values in any day shall be discarded due to maintenance of the continuous measurement system.
50. No more than ten daily average values per year shall be discarded due to maintenance of the continuous measurement system.
51. The values of the 95% confidence intervals of a single measured result at the daily emission limit value shall not exceed the following percentages:
- | | |
|-------------------------|-----|
| a. Carbon monoxide | 10% |
| b. Sulphur dioxide | 20% |
| c. Oxides of nitrogen | 20% |
| d. Particulate matter | 30% |
| e. Total organic carbon | 30% |
| f. Hydrogen chloride | 40% |
| g. Hydrogen fluoride | 40% |



- 52.** In the case of continuous measurements, the emission limit values referred to in table 4 (other than for carbon monoxide), shall be regarded as being complied with if:
- a. none of the daily average values exceeds any of the emission limit values; and
 - b. either, none of the half-hourly average values exceeds any of the emission limit values in the first column;
 - c. or, 97 % of the half-hourly average values over the year do not exceed any of the emission limit values in the second column.
 - d. Where it is not possible to establish a daily average, e.g. because of the intermittent operation of a batch incinerator plant. Then it is recommended that compliance shall be based on 97% compliance with the half-hourly emission limit values in the second column.
- 53.** In the case of continuous measurements of carbon monoxide, the emission limit values in table 4 shall be regarded as being complied with if:
- a. at least 97 % of the daily average values over the year do not exceed the emission limit value; and
 - b. either at least 95 % of all 10-minute average values taken in any 24-hour period (7 days for incinerators operating at 1,100 °C);
 - c. or all of the half-hourly average values taken in the same 24-hour period do not exceed the emission limit value
- 54.** In the case of periodic measurements, measured values shall not be adjusted to take account of the confidence intervals, but the uncertainty associated with the measurement shall be stated and if necessary, taken into account by the regulator when determining compliance with the emission limit values.

Monitoring records and reporting

- 55.** The Operator shall notify the regulator at least 7 days before any periodic monitoring exercise to determine compliance with emission limits within this permit. The Operator shall state the provisional time and date of monitoring, pollutants to be tested and the methods to be used.
- 56.** All monitoring results from any periodic monitoring exercise required by this permit shall be checked by the Operator and sent to the regulator within 8 weeks of the monitoring being undertaken.
- 57.** the operator must inform the regulator immediately in the event that continuous emissions monitoring demonstrates:



- a. Any daily average emission limit value for emissions to air is exceeded.
 - b. Any half-hour average emission limit value for emissions to air is exceeded for more than 4 hours uninterrupted or for more than 60 hours in total.
- 58.** The operator must inform the regulator immediately if the periodic emission monitoring demonstrates any emission limit value is exceeded.
- 59.** All monitoring results must be recorded, processed and presented in such a way as to enable the regulator to verify compliance with the operating conditions and emission limit values which are included in the permit.
- 60.** The operator shall report their emissions monitoring data to the regulator within one month at the end of each quarter. The operator must report all results.
- 61.** The operator shall report the number of cumulative hours, where the half hour ELVs were exceeded for the quarter and for the year to date.
- 62.** Where monitoring is not in accordance with the main procedural requirements of the relevant standard, deviations shall be reported as well as an estimation of the error involved.
- 63.** The Operator shall forward to the Regulator every 12 months, a report detailing the level of energy recovery from the installation.

Records

- 64.** All documentation required to be submitted to the regulator to demonstrate compliance with relevant conditions, shall be submitted in an electronic format and include the permit number and the Operator name. Submissions shall be sent to: environmentalprotectionteam@telford.gov.uk
- 65.** The operator shall keep and make available for inspection, written records of:
- a. All inspections both by external bodies and internal employees.
 - b. Maintenance including cleaning, maintenance undertaken by external contractors or internal personnel and breakdowns,
 - c. Operating procedures with subsequent training records.
 - d. Emission testing, continual emission monitoring, periodic and operator assessments as well as details of any testing platforms.
 - e. Records relevant to the acceptance and refusal of waste.
 - f. Records of permissible periods of operation, breakdown, incidents and accidents.
- 66.** All records must be kept for a minimum of 6 years.



Incidents and accidents

67. The Operator shall:

- a. In the event 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 regulator,
 - 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. in the event of a breach of any permit condition, The Operator must immediately:
 - i. Inform the regulator; and
 - ii. take the measures necessary to ensure that compliance is restored within the shortest possible time;
- c. in the event 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.

Residence time

- 68.** The Operator shall re-submit a Regulator approved calculation to demonstrate compliance with a 2 second residence time of the incineration plant, where the emission limits are exceeded.

Reduced operations

- 69.** The period of reduced operations (mothballing) started 1 July 2024 and shall end no later than 30 June 2027.
- 70.** The operator shall apply for a surrender of the permit at the end of the reduced operation period. If an application is not submitted, the permit, including fees, will revert to a full operational permit and full relevant fees.
- 71.** The operator cannot restart activities until they have submitted evidence demonstrating that all permit conditions can be complied with and provide any information required to show that they meet the requirements for best available techniques.



Schedule A – Emission limits

Table 4 - emission limits and monitoring requirements					
Emission point ref. & location	Parameter	Limit (including unit)	Reference period	Monitoring frequency	Monitoring standard or method
All emission limits apply to Stack 1, detailed in Schedule C	Particulate matter (PM)	30 mg/m ³	½-hr average	Continuous	BS EN 15267-1,2 & 3 and 14181
		10 mg/m ³	daily average		
	Total Organic Carbon (TOC)	20 mg/m ³	½-hr average	Continuous	BS EN 15267-1,2 & 3 and 14181
		10 mg/m ³	daily average		
	Hydrogen chloride (HCl)	60 mg/m ³	½-hr average	Continuous	BS EN 15267-1,2 & 3 and 14181
		10 mg/m ³	daily average		
	Carbon monoxide (CO)	100 mg/m ³	½-hr average	Continuous	BS EN 15267-1,2 & 3 and 14181
		50 mg/m ³	daily average		
	Sulphur dioxide (SO ₂)	200 mg/m ³	½-hr average	Continuous	BS EN 15267-1,2 & 3 and 14181
		50 mg/m ³	daily average		
	Oxides of nitrogen (NO and NO ₂ expressed as NO ₂)	400 mg/m ³	½-hr average	Continuous	BS EN 15267-1,2 & 3 and 14181
	Oxides of nitrogen (NO and NO ₂ expressed as NO ₂)	200 mg/m ³	daily average		
	Cadmium (Cd) & Thallium (Tl) and their compounds (total)	0.05 mg/m ³	Average over minimum 30 minute, maximum 8 hour period.	Quarterly in first year. Then Bi-annual	BS EN 14385 and EN 13211



Table 4 - emission limits and monitoring requirements

Emission point ref. & location	Parameter	Limit (including unit)	Reference period	Monitoring frequency	Monitoring standard or method
All emission limits apply to Stack 1, detailed in Schedule C	Hydrogen Fluoride (HF)	2mg/Nm ³	Average over three consecutive measurements of at least 30 minutes each	Quarterly in first year. Then Bi-annual	CEN TS 17340
	Mercury (Hg) and its compounds	0.05 mg/m ³	Average over minimum 30 minute, maximum 8 hour period	Quarterly in first year. Then Bi-annual	BS EN 14385 and EN 13211
	Antimony (Sb), Arsenic (As), Lead (Pb), Chromium (Cr), Cobalt (Co), Copper (Cu), Manganese (Mn), Nickel (Ni) Vanadium (V) and their compounds (expressed as a total)	0.5 mg/m ³	Average over minimum 30 minute, maximum 8 hour period	Quarterly in first year. Then Bi-annual	BS EN 14385 and EN 13211
	Dioxins / furans (I-TEQ)	0.1 ng/m ³	periodic over minimum 6 hours, maximum 8 hour period	Quarterly in first year. Then Bi-annual	BS EN 1948 Parts 1, 2 and 3

Table 5 - permissible periods of abnormal operation emission limits & monitoring					
Emission point ref. & location	Parameter	Emission Limit	Reference period	Monitoring frequency	Monitoring standard or method
Stack 1	Particulate matter (PM)	150 mg/m ³	½-hr average	Continuous measurement	BS EN 15267-3 during abatement plant failure
	Total Organic Carbon (TOC)	20 mg/m ³	½-hr average	Continuous measurement	BS EN 15267-3 during abatement plant failure
	Carbon monoxide (CO)	100 mg/m ³	½-hr average	Continuous measurement	BS EN 15267-3 during abatement plant failure

Table 6 - Equivalence factors for dibenzo-p-dioxins and dibenzofurans	
Dibenzo-p-dioxins and dibenzofurans	Toxic equivalence factor
2,3,7,8 — Tetrachlorodibenzodioxin (TCDD)	1
1,2,3,7,8 — Pentachlorodibenzodioxin (PeCDD)	0.5
1,2,3,4,7,8 — Hexachlorodibenzodioxin (HxCDD)	0.1
1,2,3,6,7,8 — Hexachlorodibenzodioxin (HxCDD)	0.1
1,2,3,7,8,9 — Hexachlorodibenzodioxin (HxCDD)	0.1
1,2,3,4,6,7,8 — Heptachlorodibenzodioxin (HpCDD)	0.01
Octachlorodibenzodioxin (OCDD)	0.001
2,3,7,8 — Tetrachlorodibenzofuran (TCDF)	0.1
2,3,4,7,8 — Pentachlorodibenzofuran (PeCDF)	0.5
1,2,3,7,8 — Pentachlorodibenzofuran (PeCDF)	0.05
1,2,3,4,7,8 — Hexachlorodibenzofuran (HxCDF)	0.1
1,2,3,6,7,8 — Hexachlorodibenzofuran (HxCDF)	0.1
1,2,3,7,8,9 — Hexachlorodibenzofuran (HxCDF)	0.1
2,3,4,6,7,8 — Hexachlorodibenzofuran (HxCDF)	0.1
1,2,3,4,6,7,8 — Heptachlorodibenzofuran (HpCDF)	0.01
1,2,3,4,7,8,9 — Heptachlorodibenzofuran (HpCDF)	0.01
Octachlorodibenzofuran (OCDF)	0.001

Schedule B – Interpretations

In this permit the meanings listed in schedule B shall be relevant to the compliance of the conditions of this permit.

Abnormal operation

means any technically unavoidable stoppages, disturbances, or failures of the abatement plant or the measurement devices, during which the concentrations in the discharges into air may exceed the normal emission limit values.

Accident

means an unintentional incident that may result in pollution.

APC residues

means air pollution control residues. These are materials left over after the removal of hazardous pollutants from the incineration process. APC residue is typically a mixture of ash, carbon and lime. It is a hazardous waste which must be disposed of at a hazardous waste landfill or undergoes further processing such as washing or stabilisation to send to a non-hazardous landfill.

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 Telford and Wrekin Council 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.

Bi-annual

Means twice per year means with at least five months between tests.

Bottom ash

Means ash removed by the de-ashing auger.

Calendar year

Means from 1 January to 31 December.

CEM

Means Continuous Emission Monitor

Competent Person

Means a person who has received the approved training in the operation of the small waste incineration plant and whose competence has been checked and reviewed. Details of the approved training procedures and competence assessment for each person are held within the environmental management system.

Daily average

Means for releases of substances to air means the average of valid half-hourly averages over the effective operating time within a 24 hour period

Dioxin and furans

Means polychlorinated dibenzo-p-dioxins and polychlorinated dibenzofurans.

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.

EP Regulations

Means The Environmental Permitting (England and Wales) Regulations 2016 (as amended) SI 2010 No.675 (including any subsequent EP regulations made under the Pollution Prevention and Control Act 1999). 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 or directly associated activities, either from the emission points specified in the tables of schedule A or from other localised or diffuse sources, which are not controlled by an emission limit.

First Year and Year

Shall mean the first 12 months from 23 May 2022 and then from 23 May to 22 May thereafter.

Grade C waste wood

Means non-hazardous waste wood sourced mainly from construction and demolition activities, recycling centres and civic amenity sites.

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.

Immediately

Means the same day or in the case of outside the working hours of Monday to Friday 8am to 4pm, before 10am the next working day.

Incineration line

Means all of the incineration equipment related to a common discharge to air location.

ISO

Means International Standards Organisation.

LOI

Means loss on ignition a technique used to determine the combustible material by heating the ash residue to a high temperature.

MCERTS

Means the Environment Agency's Monitoring Certification Scheme.

Next working day

Means before 12pm on the following day the incident occurred. If an incident occurs Saturday or Sunday, then notification must be before 12pm on the following Monday.

Permissible period of abnormal operation

Means the maximum permissible period of any technically unavoidable stoppages, disturbances, or failures of the purification devices or the measurement devices, during which the emissions into the air and the discharges of wastewater may exceed the prescribed emission limit values.

PCB

means Polychlorinated Biphenyl. Dioxin-like PCBs are the non-ortho and mono-ortho PCBs listed in the Box 2 below.

Quarterly

Means January to March; April to June; July to September and October to December.

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.

Residue

Means any liquid or solid waste which is generated by a small waste incineration plant or small waste co-incineration plant. This will include, incinerator bottom ash, boiler ash, APC residues and fly ash.

Shut down

Means any period where the plant is being returned to a non-operational state.

Start up

Means any period, where the plant has been non-operational, after igniting the auxiliary burner, until waste has been fed to the plant to initiate normal operational conditions.

The Operator

Means Holcim UK Limited.

The Regulator

Means Telford and Wrekin Council.

TOC

Means Total Organic Carbon. In respect of releases to air, this means the gaseous and vaporous organic substances, expressed as TOC. In respect of Bottom Ash, this means the total carbon content of all organic species present in the ash (excluding carbon in elemental form).

Hazardous waste

Means waste which displays one or more of the hazardous properties listed in Annex III of Directive 2008/98/EC;

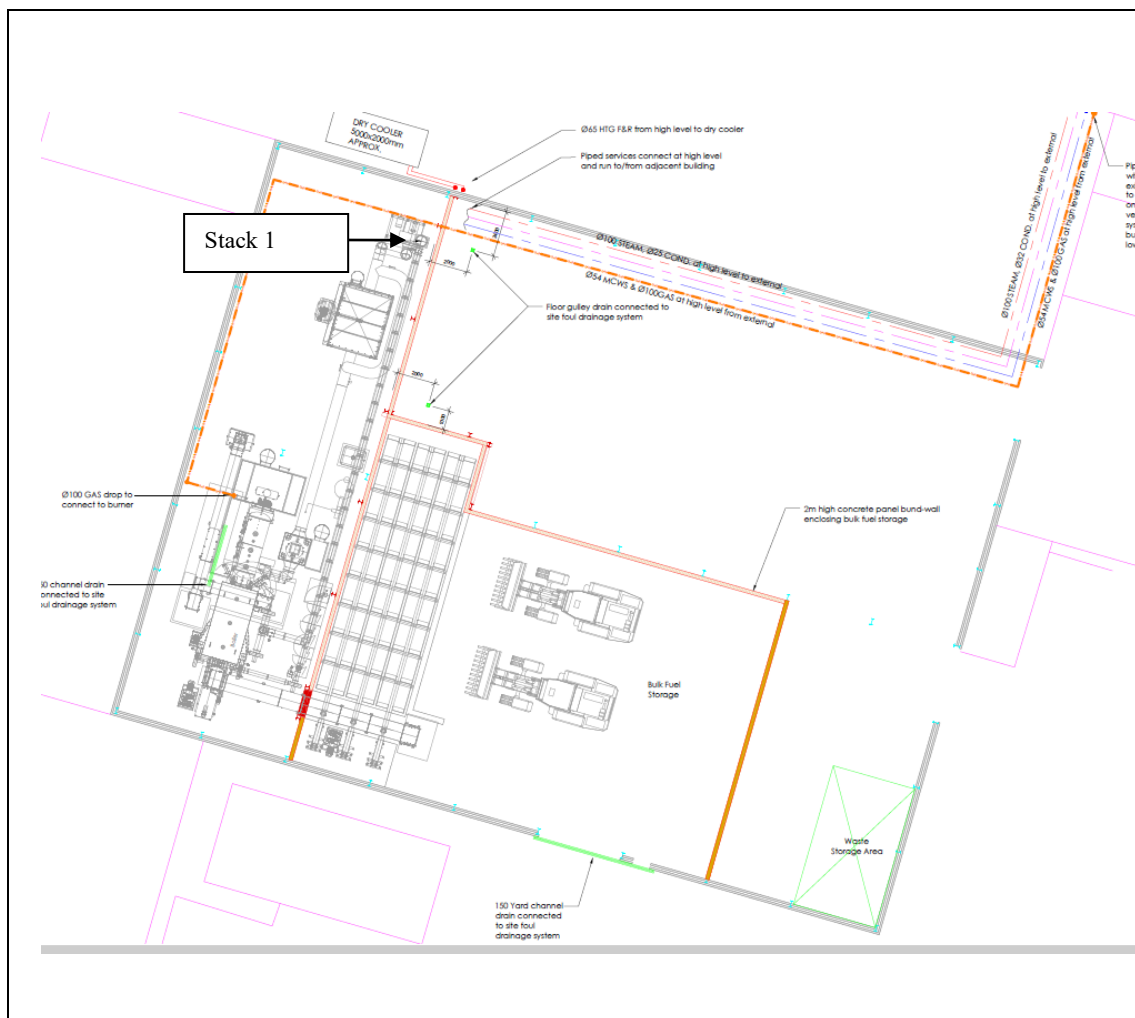
Waste code

Means the six digit code referable to a type of waste in accordance with Commission 'Decision 2000/532/EC List of Wastes and Hazardous Wastes' or 'Technical Guidance WM3 – Guidance on the classification and assessment of waste' as appropriate. 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

Schedule C – stack location



Schedule D - Delivery and acceptance of waste

In instances where the quantity of Grade C wood waste is not available from suppliers, then The Operator shall source Grade C waste wood from other suppliers or if necessary, use wood fuel of a higher grade.

Wood fuel pre-acceptance procedures

Waste wood fuels shall undergo pre-acceptance procedures prior to receipt onsite. The Operator will provide a written specification of the waste accepted.

Prior to the delivery of waste wood fuels, the supplier(s) shall confirm in writing, the following:

- a) The form and estimated mass of materials; and
- b) The form of the container transporting the materials.

Wood fuel acceptance

The Operator shall only accept non-hazardous waste wood, for use in the biomass boiler.

The Operator shall ensure that the site has qualified staff on site prior to the waste wood fuel being delivered.

The Operator shall ensure that the site has the capacity to accept and store incoming waste wood fuel.

Each load shall access the site via the site entrance. Documentation will be checked by an operative, to ensure that the waste wood fuel is compliant with the permitted waste types.

The site operator will then instruct the driver to proceed to the tipping area. A site operator will ensure that the carrier takes the delivery to the storage area where the waste wood will be tipped to avoid contamination with other materials onsite.

Records are kept on site of the materials received, including:

- a) Date and time of delivery;
- b) Type of material; and
- c) Mass of load.

Wood Fuel Inspection

Without compromising safety, each load deposited in the storage area shall be inspected by a trained member of staff. The visual inspection is to ensure that the load deposited contains:

- a) Only the waste wood for which the Operator is permitted to receive; and
- b) Does not contain material deemed unacceptable under the terms of the agreement between the Operator and the supplier and/or unsuitable for the materials use.

The Operator shall ensure that site conditions are such that allow a delivery of waste wood fuel to be safely and properly inspected on prior to receipt. This includes lighting if deliveries are accepted out of daylight hours.

Wood Fuel Rejection

Where the waste wood fuel delivered contravenes the conditions of this permit or site-specific criteria, the entire load shall be returned to the delivery vehicle and rejected and removed from site.

All rejected loads shall be recorded in the Site Diary.

Decontamination / On-Site Segregation

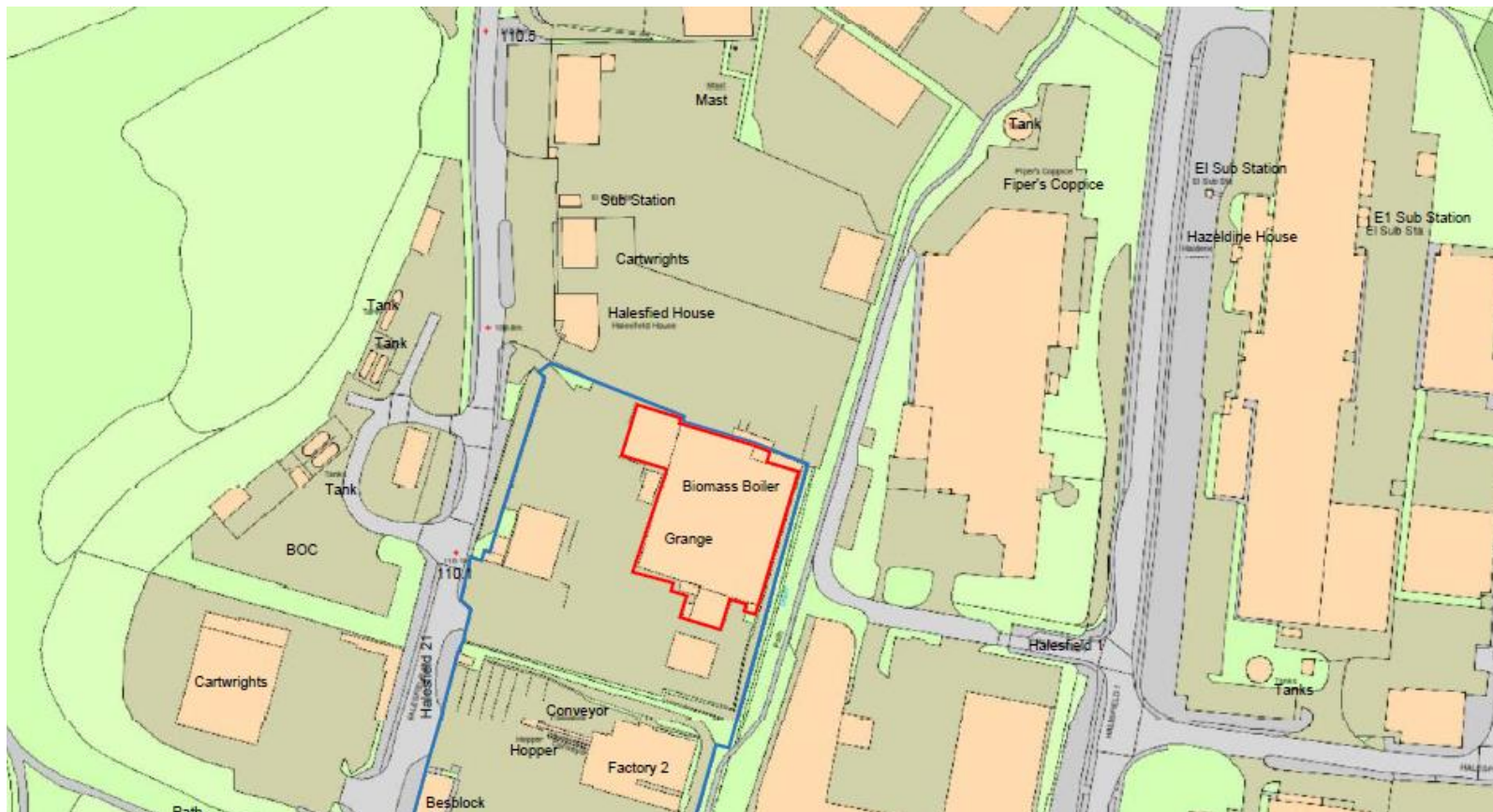
The storage area shall be swept clean prior to the movement of waste wood fuel into the storage area stockpiles. Waste wood fuel shall only be stored in the designated storage area that will remain free from any other materials used on site. Any small amounts of contamination found in the waste wood fuel shall be removed by hand prior to the waste wood being stored and used.

Traceability

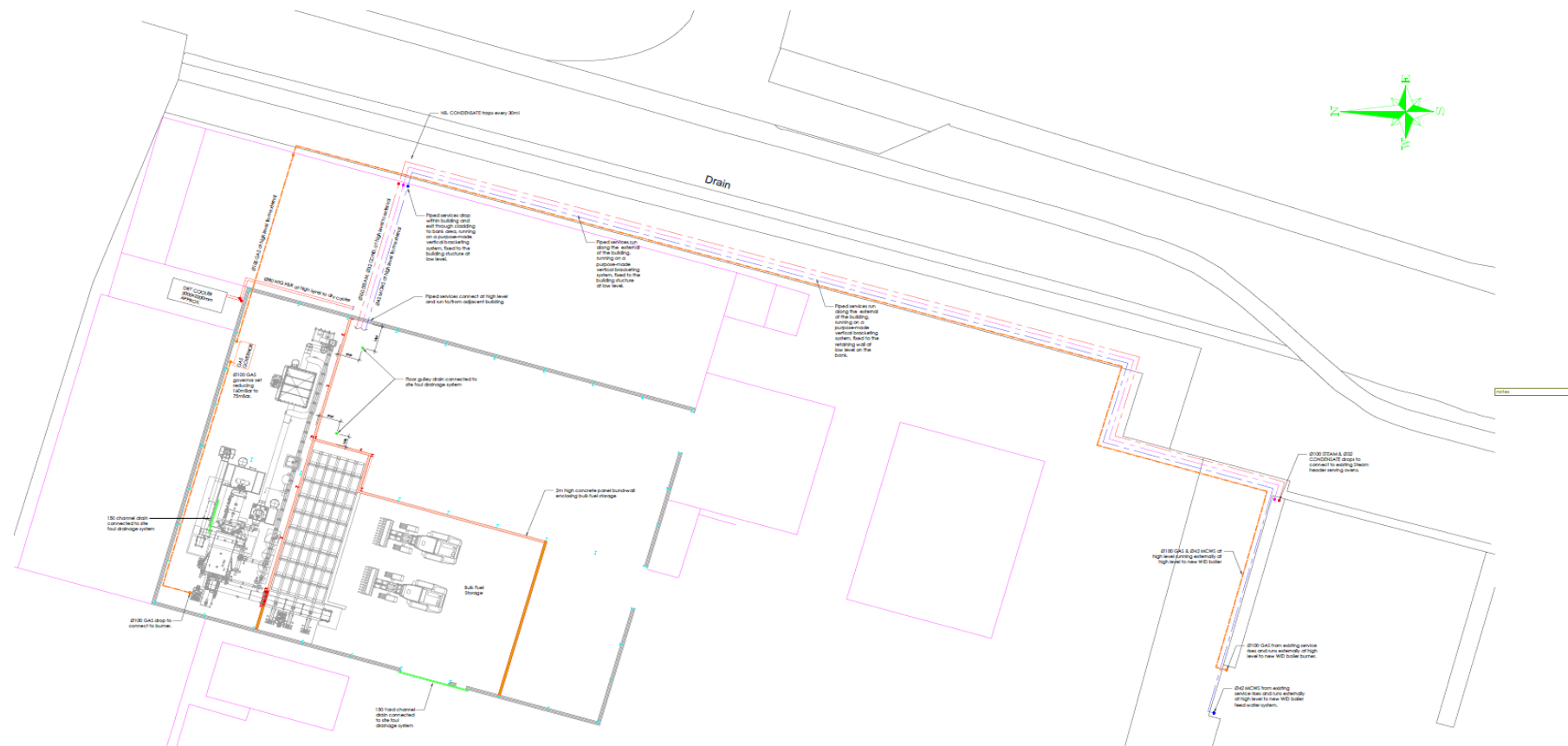
Records shall be maintained of all sources of waste wood fuel, along with the delivery dates and the volumes delivered. These records are retained in the site diary and contain records of any offsite measurements provided by the fuel supplier.



Appendix 1. Location of Installation



Appendix 2. site map and drainage map



End of Permit Conditions