

DESIGN AND ACCESS/PLANNING STATEMENT

2327-VDG-ZZ-ZZ-RP-S-0100 RevP1

Lancashire Farm Dairies

138 Whitelees Road

Littleborough



CONTROL SHEET

Document Number		2327-VDG-ZZ-ZZ-RP-S-0100			
Document Title		Design and Access/Planning Statement			
Status	Revision	Date of Issue	Author	Checked	Reviewed
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Report Limitation

All comments and proposals contained in this report are based on information available to VDG during recent investigations.

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Table of Contents

1. THE SITE PROPOSALS.....	3
2. THE USE/WHY THE NEW SITE	3
3. THE NEED	4
4. LOCAL ECONOMY, JOBS CREATION AND SAFEGUARDING	6
5. SCALE AND APPEARANCE	6
6. ACCESS	7
7. OPERATIONAL REQUIREMENTS	7
8. BNG AND ECOLOGY	8
9. TREE.....	8
10. FLOOD RISK	8
11. SUMMARY.....	9

GLOSSORY

Term	Definition
VDG	Vision Design Group Civil and Structural Engineers

1. THE SITE PROPOSALS

The site is part of an existing industrial and manufacturing complex currently occupied by Lancashire Farm Dairies, previously known as the McCormicks site. The proposed development is located in the southwestern section of the Lancashire Farm Dairies facility, off Whitelees Road in Littleborough, entered around Ordnance Survey National Grid Reference 393357E, 416497N, with the postcode OL15 8BZ.

The proposed development includes the installation of four silo milk tanks, along with associated slab and foundation works, and a protective bund. This development is planned for the south east of the car park off Whitelees Road, adjacent to the existing concrete service yard.

Appendix 01 contains a location plan of Lancashire Farm Dairies. The entire Lancashire Farm site covers approximately 3.2 hectares. The area designated for the silo base is 182m², and the service yard extension will cover about 130m². The development involves converting a portion of the car park into the silo slab and foundation and extending the current service yard onto a grassed area. Due to the car park's slope from north to south, a small perimeter retaining wall will be needed for the service yard extension.

Development proposals are detailed in Appendix 02, while existing site photographs are provided in Appendix 03. The site is elevated above Stockton Street, the Aldi service yard, and the car park. To the south, the area is primarily industrial and commercial, while to the north, some residential terraces are partially screened by trees and landscaping.

Services information, provided by the client, includes selected statutory utility searches, as-built drawings, and below-ground utility scans, all found in Appendix 04. This information indicates that electric cables run along the service road through the centre of the service yard to Whitelees Road. Numerous services, including gas, electricity, and drainage sewers, are present at the Stockton Street entrance.

2. THE USE/WHY THE NEW SITE

The site is involved in the production of dairy products, with the finished goods stored and distributed from these Littleborough premises. Milk, one of the primary raw materials, is stored on-site in vertical silos. The transfer process involves connecting flexible hoses to fixed site pipework, allowing milk from tankers to be pumped into the silos. Four silos are necessary to enable the manufacturing output.

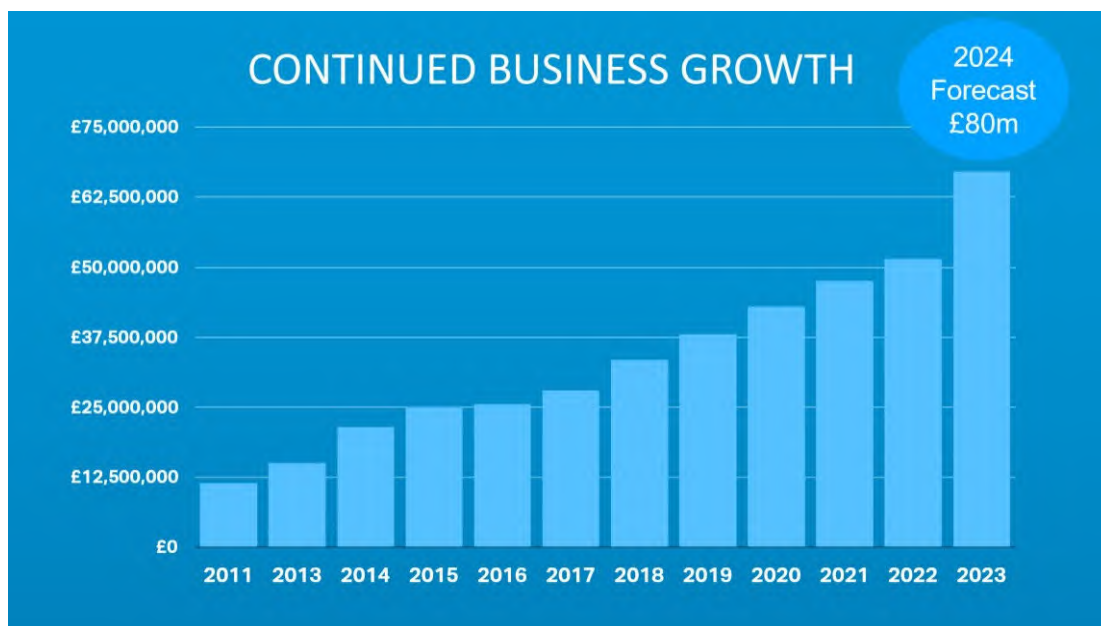
History of Lancashire Farm Dairies and purpose of new Site and why this is needed

Lancashire Farm Dairies began trading in 1984, initially wholesaling fresh produce alongside a range of set and stirred natural yogurts. By the mid-1990s, the company shifted its focus entirely to yogurt production, operating from a small facility in Rochdale. Over the next decade, the business grew steadily, building a strong customer network.

In 2010, the company was incorporated as Pakeeza Dairies Ltd after securing its first major supermarket listing with ASDA. Since then, it has expanded significantly and is now one of the UK's leading natural yogurt producers. Lancashire Farm Dairies supplies all major supermarkets, including ASDA, Tesco, Morrisons, Sainsbury's, Co-op, and Iceland, as well as discounters Aldi and Lidl. The company also serves wholesalers, food manufacturers, and food service businesses, including Associated British Foods and HelloFresh.

The Lancashire Farm brand has been part of the company's portfolio from the beginning. However, it was initially perceived as an ethnic brand, primarily sold in world food aisles, which limited its market reach. In recent years, the company has repositioned Lancashire Farm as a mainstream brand, appealing to a wider British demographic.

Today, Lancashire Farm Dairies is the third-largest producer of natural yogurt in the UK. Its products align with current health trends, offering low-sugar, low-fat, and natural options. The company has experienced rapid growth, with a forecasted revenue of £80 million for FY 2024, representing a 60% increase over the past three years.



3. THE NEED

The entire manufacturing plant depends on the milk supply from the silos and cannot operate without it. Ensuring this supply will help secure current jobs and potentially increase employment at the site, which is designated as employment land.

The various options available to the business are outlined below;

Option 1 – Do Nothing

This is not a viable option, as the entire business is at risk without a comprehensive solution covering the full dairy category. Without this project, the company would be excluded from key tenders, lose major customers, and ultimately jeopardize its future.

Option 2 – Outsource Yogurt Production

Outsourcing yogurt production is not a feasible solution. Partnering with an external processor would mean losing control over quality and operations, potentially resulting in a permanent loss of business—an unacceptable risk. Additionally, surplus yogurt production capacity in the UK is limited, leading to high transport costs and lost employment opportunities locally. Moreover, Lancashire Farm Dairies would be unable to source sufficient Free-Range Milk directly from farms, limiting its ability to support dairy farmers as intended.

Option 3 – Proceed with the Project

The preferred option is to acquire the site and establish a new yogurt and soft cheese manufacturing plant. This approach ensures continued business growth, enhances efficiency, and strengthens competitiveness. However, securing Business Rate Relief support is crucial to making this project financially viable.

Option 4 – Delay Until Full Capital is Available

Lancashire Farm Dairies is profitable and reinvesting in its business. However, the opportunity to acquire the identified site is available now. Since the site already has some necessary infrastructure in place, this would reduce setup costs and accelerate project timelines. If this opportunity is missed, the business may have to explore alternative strategic options, including a potential merger with a larger dairy company.

4. LOCAL ECONOMY, JOBS CREATION AND SAFEGUARDING

The following number of jobs will be safeguarded through the installation of the the silos at the plant.

Status	Full Time (min 30 hrs)	Part Time	Total P/T counted as 0.5
Directors / Partners	1	0	1
Managerial / Professional	24	0	24
Skilled	53	0	53
Semi-skilled	130	0	130
Unskilled	0	0	
Clerical	15	0	15
Total	223	0	223

The following number of jobs will be created through the installation of the silos at the plant:

Job Title	Number created?	Qualification/NVQ skills level	Basic Annual Salary £	When & how will they be recruited
Management	2	Level 6	60,000	01/09/24 – headhunted immediately
Skilled Operative	30	Level 4	35,000	Recruited locally – once commissioning is complete
Sales	2	Level 6	50,000	Recruited locally – headhunted immediately

IT	1	Level 5	£40,000	Recruited locally – once commissioning is complete
Warehouse	12	Level 3	30,000	Recruited locally – once commissioning is complete
Apprentice	3	Level 3	25,000	Recruited locally – once commissioning is complete

5. SCALE AND APPEARANCE

The proposed four aluminium-finished silos have a diameter of 4.4 meters and a height of 13.9 meters tall to the eaves of the tank excluding tank pipes and lid. To reduce the height of the silos these have been sunk into the ground. Detailed dimensions and tank specifications are provided in Appendix 05. The main building's ridge height is approximately 12 meters from the external ground level, while the service yard sits about 1.0 meters below the building's finished floor level. The service yard and car park are adjacent to Whitelees Road.

The silos will be positioned approximately 44 meters back from Whitelees Road and 64 meters from the nearest

residential houses. The view from Whitelees Road is screened by existing trees and a landscaped strip. The current 'skyline' visible from the car park and service road will continue to reflect the site's industrial character and the historical context of the Roch Valley, which contributed to Littleborough's development. The addition of the four new silos will blend seamlessly into this environment, having minimal, if any, impact on the overall setting.

A proposed landscaping scheme has been provided to help further screening By Trevor Bridge Associates Ltd.

Colour of tanks will match the green moorland metal cladding below:



BUNDING WALL

The concrete bunding wall is to be clad using a PVC metal cladding using the same colour as the silos.

6. ACCESS

The location of the new raw material silos has been carefully selected to optimise the plant's operations. Proper access and positioning are crucial for the loading and operational processes. HGV tankers can easily access the service yard, park, and efficiently offload milk. The slab bases for the silos are strategically positioned to avoid all major utilities, including electricity, gas, and drainage lines.

The silos are placed to ensure safe cleaning during maintenance and to facilitate the pipework that supplies the manufacturing plant. The entire site is constrained in terms of space, so the placement of the four silos must accommodate both transport and manufacturing needs while allowing for cleaning and factory supply operations. In line with the logistics team at Lancashire Farm Dairies, this location is ideal for ensuring the smooth operation of the facility.

The current access is from Stockton street and no change in deliveries, therefore operational and noise requirements remain as the current use so no further acoustic requirements should be required.

7. OPERATIONAL REQUIREMENTS

Hours of Operation

The facility operates **24/7** to ensure continuous production and supply.

Purpose and Function of the Storage Tanks

The storage tanks are a critical component of the manufacturing process, as production cannot proceed without them. These tanks serve as milk storage vessels, facilitating the transition from raw milk collection to paneer and yogurt production.

Milk Intake Process: Raw milk is delivered by farm collection tankers and offloaded into the storage tanks.

Operational Rotation: The tanks operate on a first-in, first-out (FIFO) system to maintain freshness and efficiency.

- One tank is designated for offloading incoming milk.

- A second tank is cleaned and prepared for refilling once the first tank reaches capacity.
- A third tank, which remains full, continuously supplies the processing plant for paneer and yogurt pasteurisation.

This sequence repeats throughout the production cycle, ensuring seamless operation.

Justification for Tank Size

The capacity of the storage tanks has been carefully determined based on:

- The operational capacity of processing and filling equipment.
- The need to meet customer demand efficiently.
- The ability to store 300,000 litres of raw milk per day, ensuring adequate storage for milk deliveries during non-operational hours.

Silo Usage and Delivery Schedule

- The silos are in constant use, operating per the facility's production requirements.
- Milk deliveries occur daily between 06:00 and 18:00, seven days a week.

Operational Noise Considerations

- Material Offloading & Silo Cleaning: Minimal noise is generated during these operations. The facility will implement Best Available Technology (BAT) to ensure low-noise mechanical equipment, such as pumps.
- Pump Operation Noise: Similar to offloading and cleaning, pump operation noise will be minimal due to the use of high-efficiency equipment.
- Pump System and Milk Distribution
- Milk is pumped from the silos into the factory using high-efficiency, variable-speed centrifugal pumps located at the silos.
- A valve distribution matrix and piping system ensure efficient milk transfer to designated processing equipment.

8. BNG AND ECOLOGY

The BNG and ecology report has been provided by Erap.

9. TREE

A Tree protection plan will have been provided to the existing trees on site.

All existing trees on the site will be fenced off in accordance with BS 5837:2012 "Trees in relation to construction - Recommendations". The fencing shall be retained during the period of construction and no work, excavation, tipping or stacking of materials shall take place within any such fence during the construction period."

10. FLOOD RISK

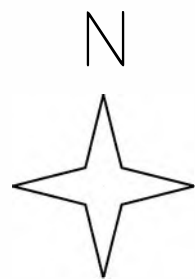
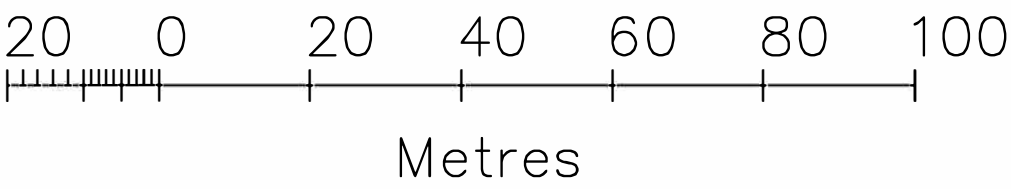
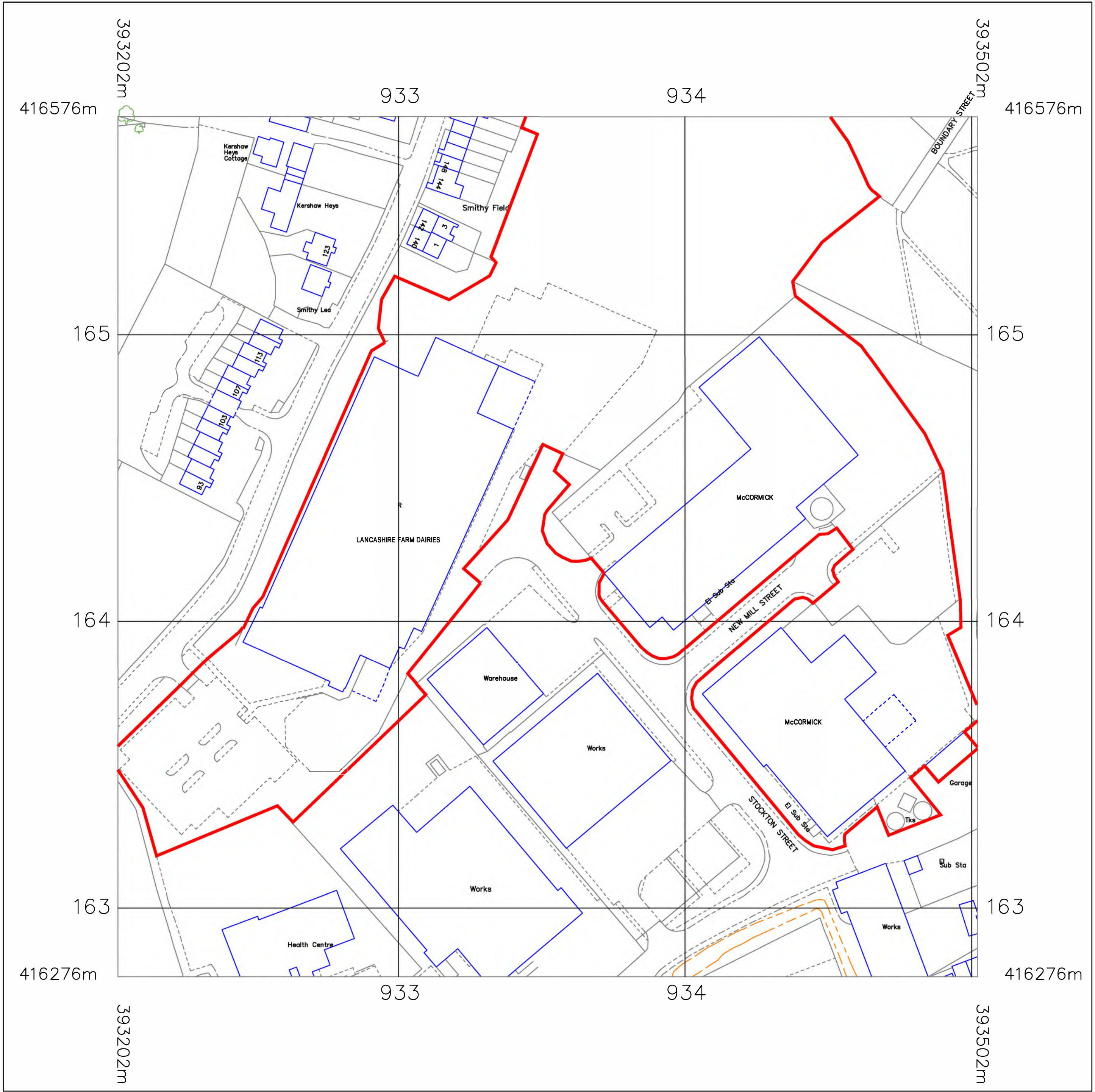
The site was subject to a flood risk assessment prepared by Black & Veatch, dated 2006 prior to further development and identified mitigation measures were put in place at that time. The proposal does not increase any existing floor area and the silo's are built on a small plinth, so the proposal does not create any inherent potential flood.

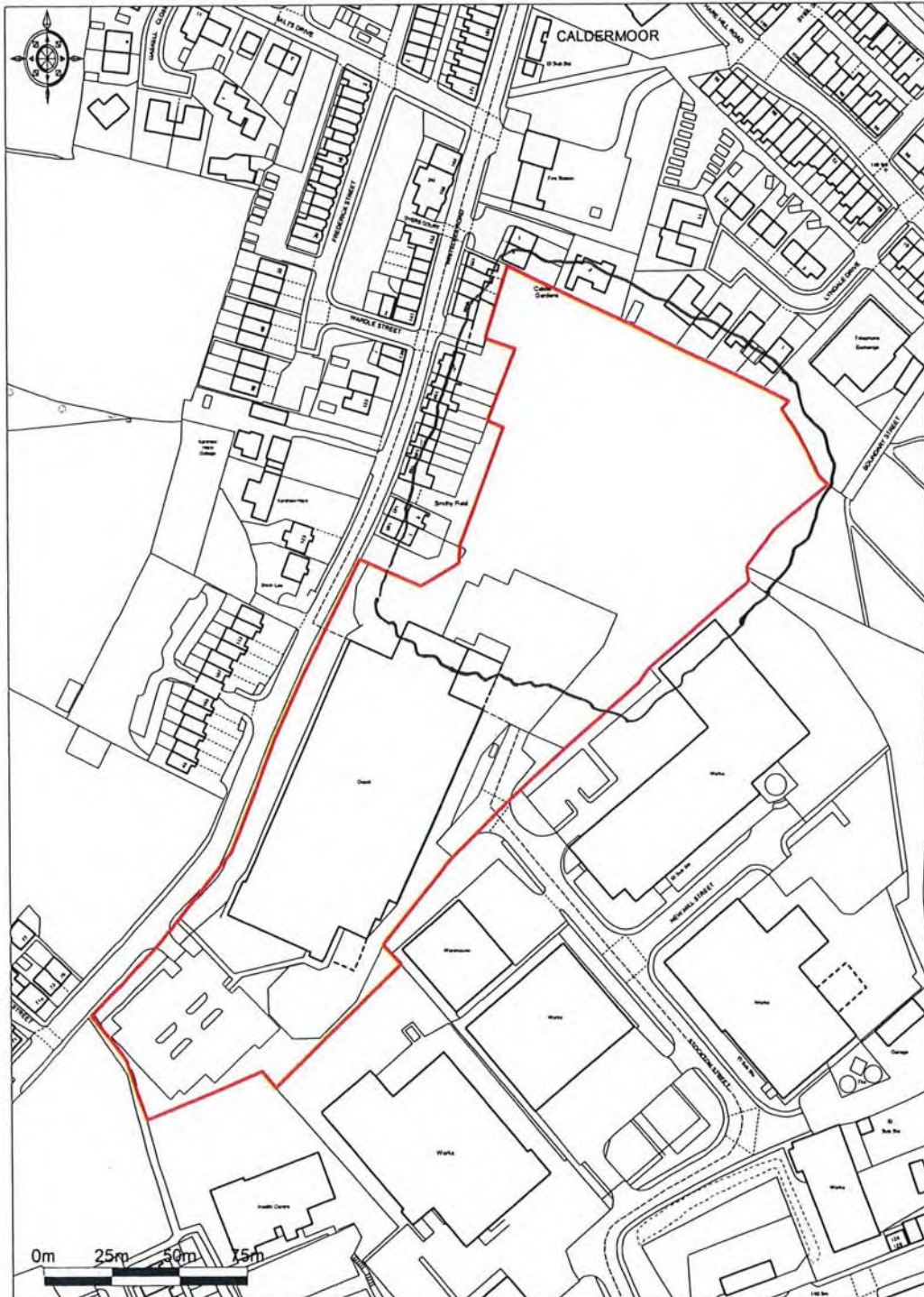
11. SUMMARY

Given that the visual impact is negligible, existing HGV access is adequate and the silos can only maintain employment on a site designated for such, the application should be supported positively and recommended for approval.

Appendix 01

Stanfords VectorMap





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Licence number 100020449. Plotted Scale - 1:2500

McCormick UK 138 Whitelees Rd Littleborough Lancs

Appendix 02

- General Notes**
1. Do not scale off these drawings. Work to stated dimensions only.
 2. All dimensions are in millimetres unless noted otherwise.
 3. These drawings should be read in conjunction with all other relevant drawings, specifications, schedules and other information including all other consultants drawings.
 4. The contractor is responsible for the temporary stability of all structures including the ground during the works and is to undertake the necessary temporary works designs as required.
 5. Setting out information to be co-ordinated by lead designer.

- KEY**
- NEW HERRACE FENCING
 - NEW TRIEF KERB
 - RED LINE BOUNDARY



EXISTING SITE PLAN
1 : 500



PROPOSED SITE PLAN
1 : 500

Rev	Description	Date
1	PLANNING ISSUE	25/02/25

CODE
I
SUITABILITY DESCRIPTION
PLANNING

STATUS
S2
PURPOSE OF ISSUE
PLANNING

PROJECT

SILO'S INSTALLATION

TITLE

EXISTING AND PROPOSED SITE
PLAN

CLIENT

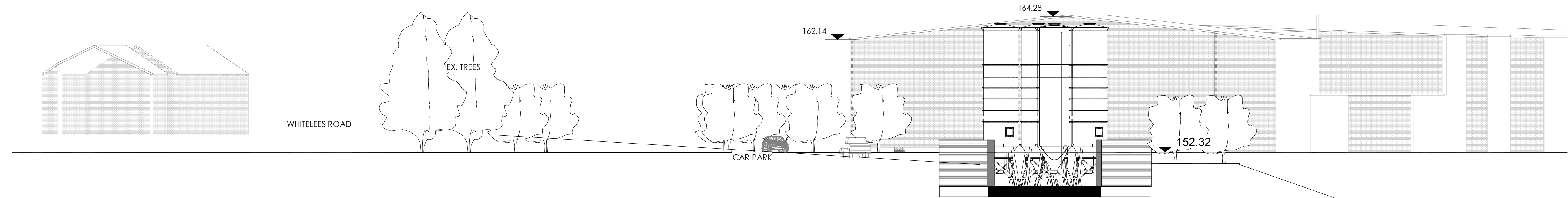
LANCASHIRE FARM DAIRIES

DRAWN BY
B.N
CHECKED BY
M.Walsh
DATE
19.08.24

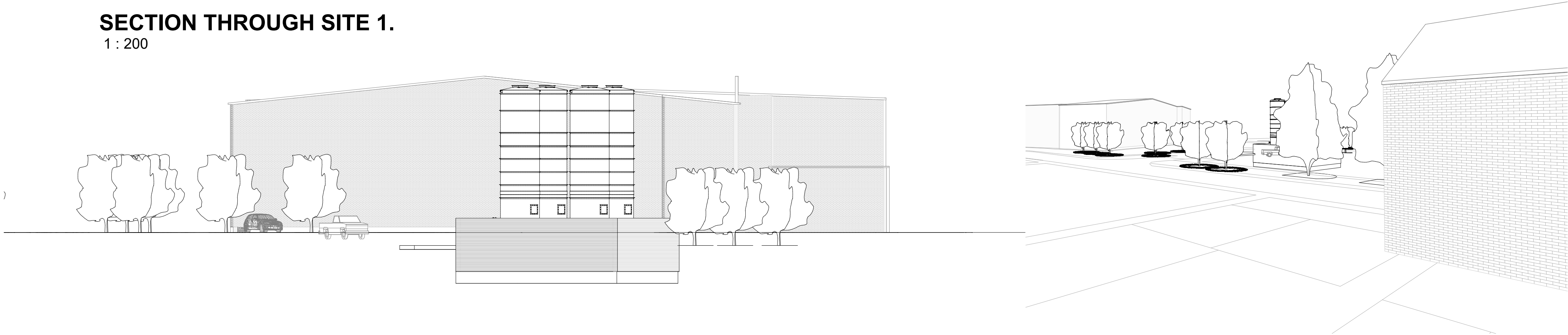
SCALE (@ A1)
1 : 500
PROJECT NUMBER
MCS2185

DRAWING NUMBER
VDG-2327-DWG-1000
REV
1

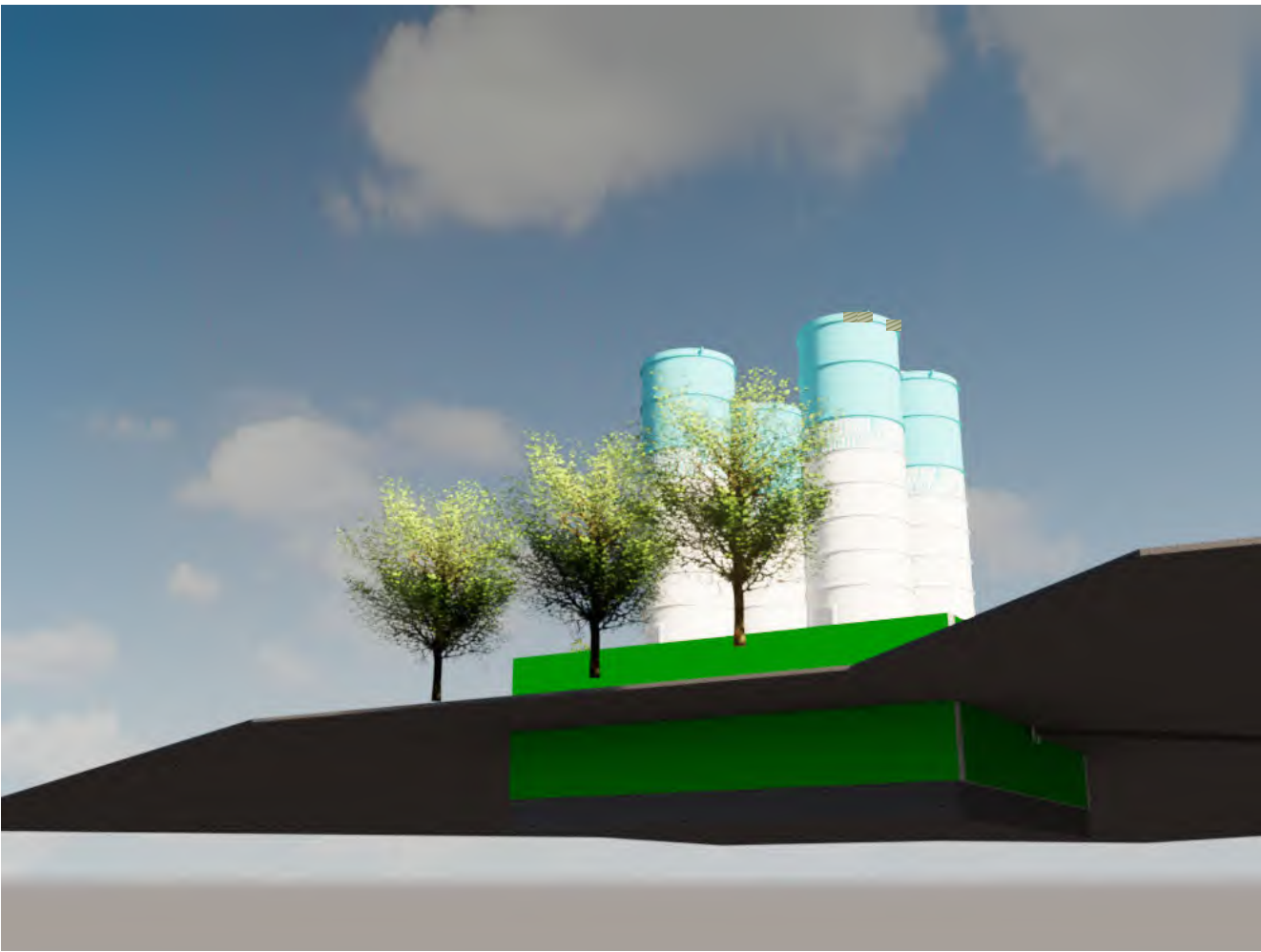
- General Notes**
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SECTION THROUGH SITE 1.
1 : 200



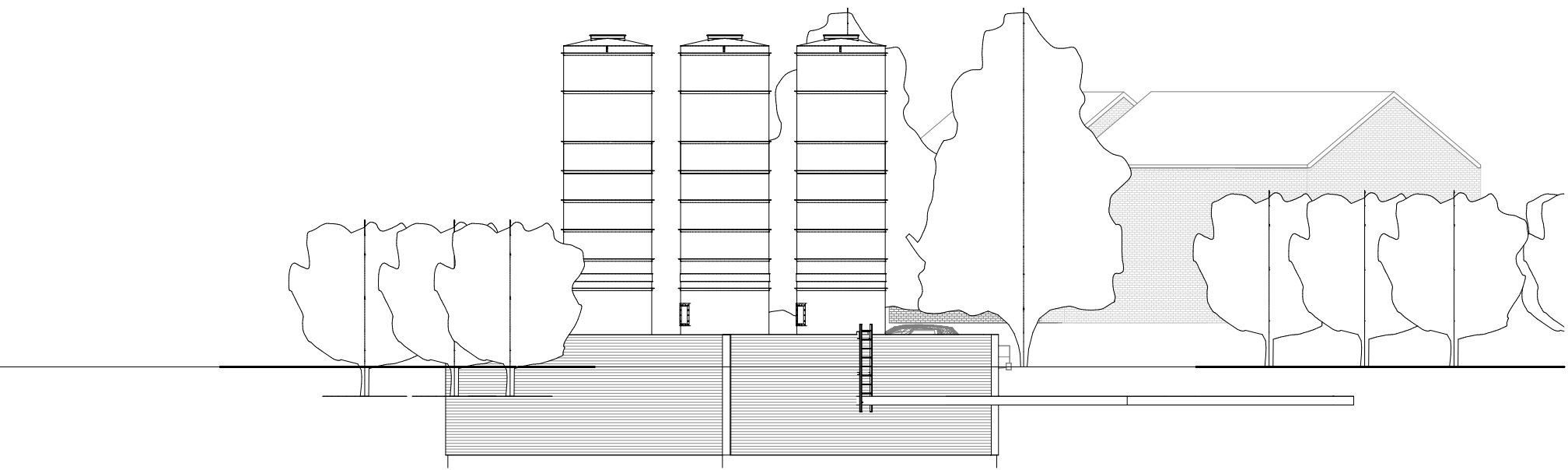
VIEW FROM RESIDENTIAL HOUSES



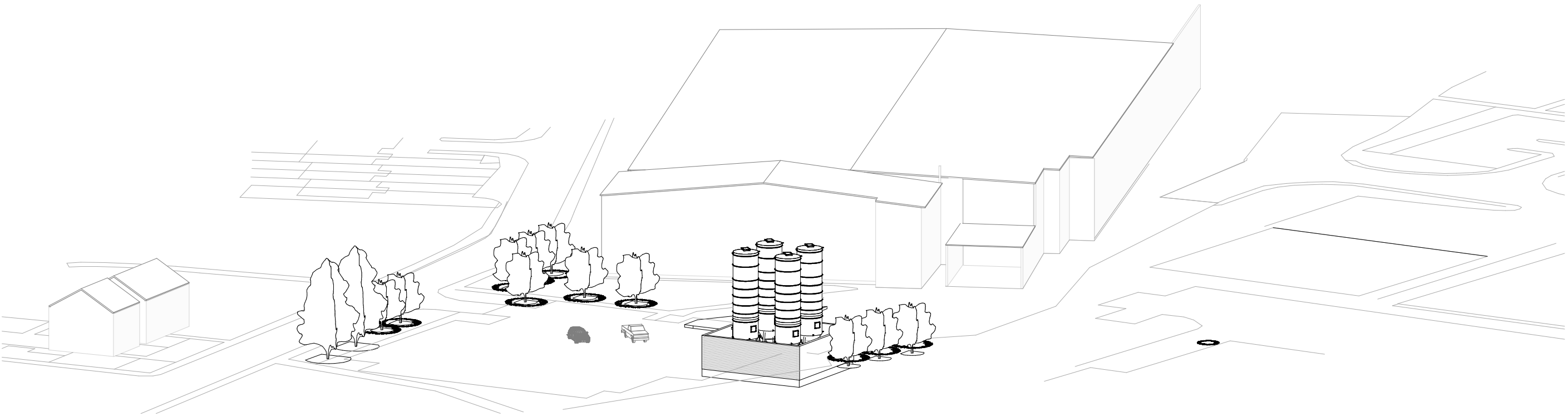
VIEW FROM LIDL BELOW



VIEW FROM RISIDENTIAL HOUSES



VIEW FROM BACK OF SILOS
1 : 200



3D OF SITE PROPOSALS

Rev	Description	Date
1	PLANNING ISSUE	25/02/25

CODE	SUITABILITY DESCRIPTION
I	PLANNING
STATUS	PURPOSE OF ISSUE
S2	PLANNING

PROJECT

SILO'S INSTALLATION

TITLE

SECTION, ELEVATIONS AND 3D
VIEWS

CLIENT

LANCASHIRE FARM DAIRIES

DRAWN BY
B.N

CHECKED BY
MW

DATE
19.08.24

SCALE (@ A1)

PROJECT NUMBER

1 : 200

MCS2185

DRAWING NUMBER

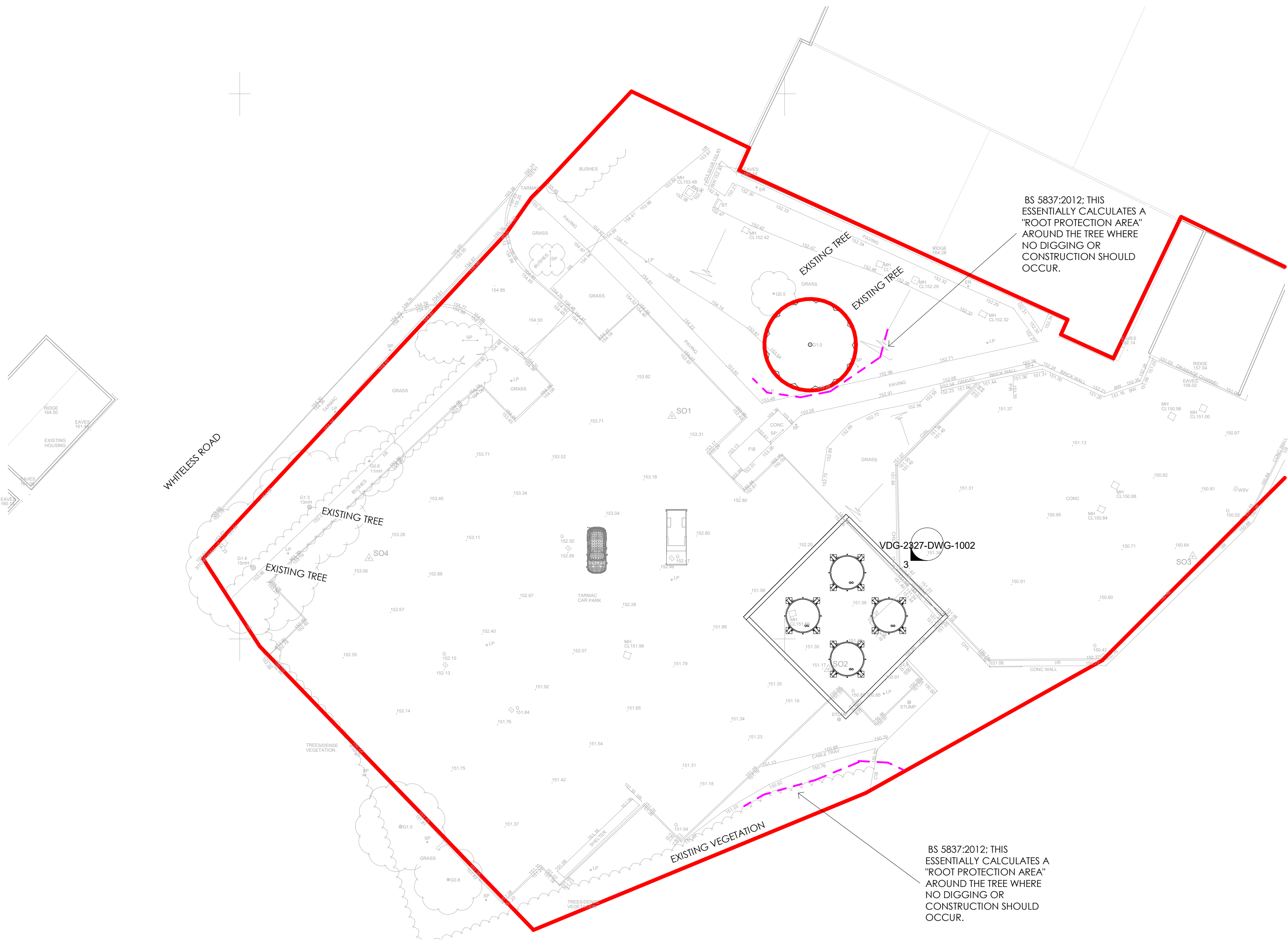
REV

VDG-2327-DWG-1001

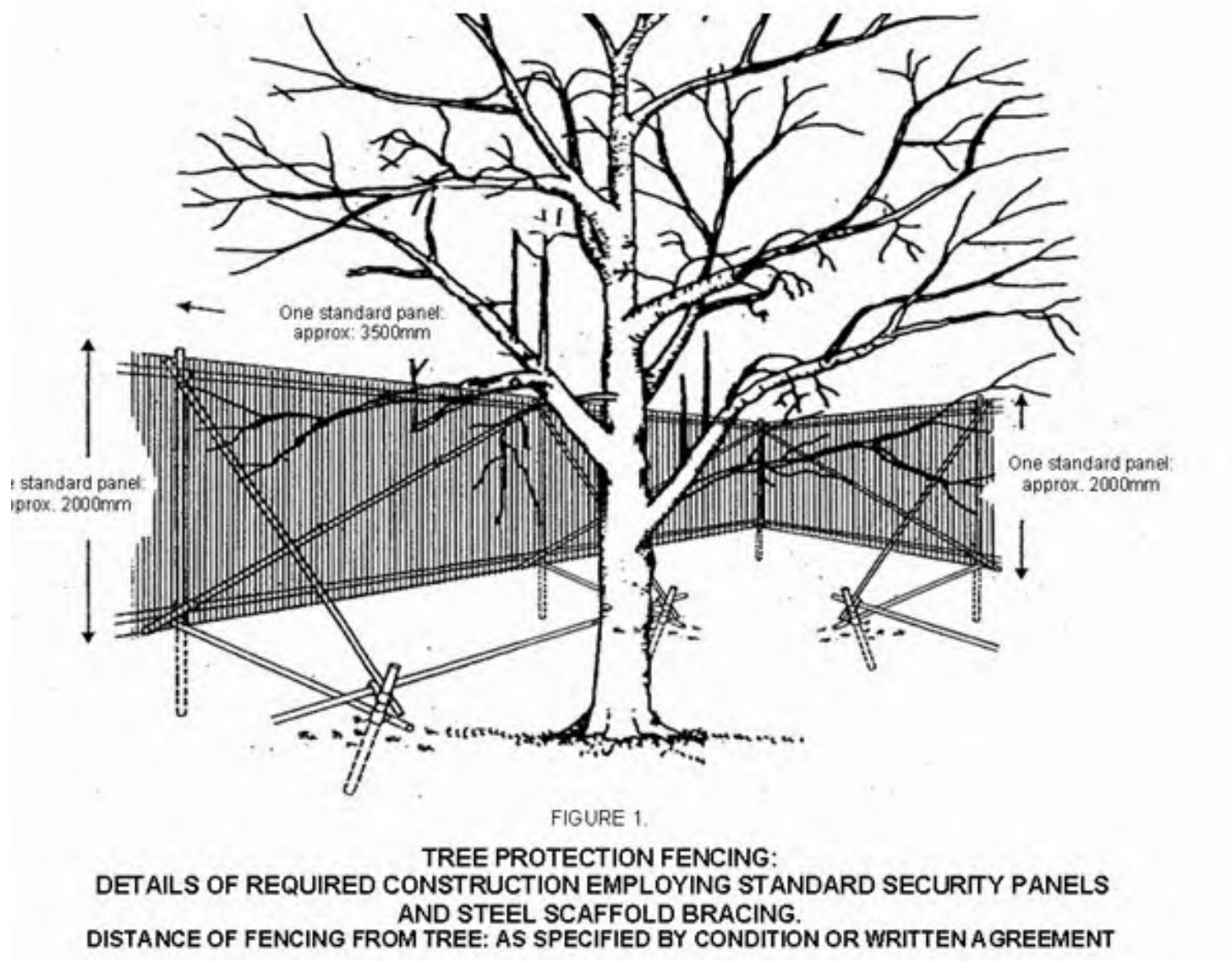
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DRAWN BY B.N	CHECKED BY M.W	DATE 19.08.24
SCALE (@ A1) As indicated	PROJECT NUMBER MCS2185	
DRAWING NUMBER		P
VDG-2327-DWG-1002		



Unless otherwise agreed construction of Tree Protection Fencing shall comprise weldmesh panels or close boarding supported on a framework of both vertical and horizontal steel scaffolding which is braced to resist impacts. A sample specification is given below (Default specification for protective barrier BS5837:2012).



Unless otherwise agreed in writing with the Local Planning Authority (LPA), the fencing shall be positioned at a distance from the trunk of at least:

- 12 times the diameter of the trunk measured at 1.5m for a single stemmed tree or
- 10 times the diameter of the tree measured immediately above the buttress flare for a multi-stemmed tree.

Notices should be fixed to the fencing displaying words such as 'Construction Exclusion Zone – Keep Out'.

All fencing shall be retained and maintained in good condition for the full duration of the construction period and considered sacrosanct unless otherwise agreed in writing with the LPA.

Within the fenced area, during the construction period:-

- No spoil, vehicles, fuel, materials, temporary buildings or ancillary equipment shall be stored.
- Existing ground levels shall not be raised or lowered.
- No services shall be laid without the written consent of the Local Planning Authority.
- Materials likely to be injurious to trees, such as the mixing of cement or the discharge of cement, oil, bitumen or other should not be permitted outside the fence where contaminated fluids could drain towards the tree.

Rev	Description	Date
1	PLANNING ISSUE	25/02/25

CODE	SUITABILITY DESCRIPTION
I	PLANNING
STATUS	PURPOSE OF ISSUE
S2	PLANNING

PROJECT

SILO'S INSTALLATION

TITLE

TREE PROTECTION FENCING

CLIENT

LANCASHIRE FARM DAIRIES

DRAWN BY
B.N

CHECKED BY
F.R

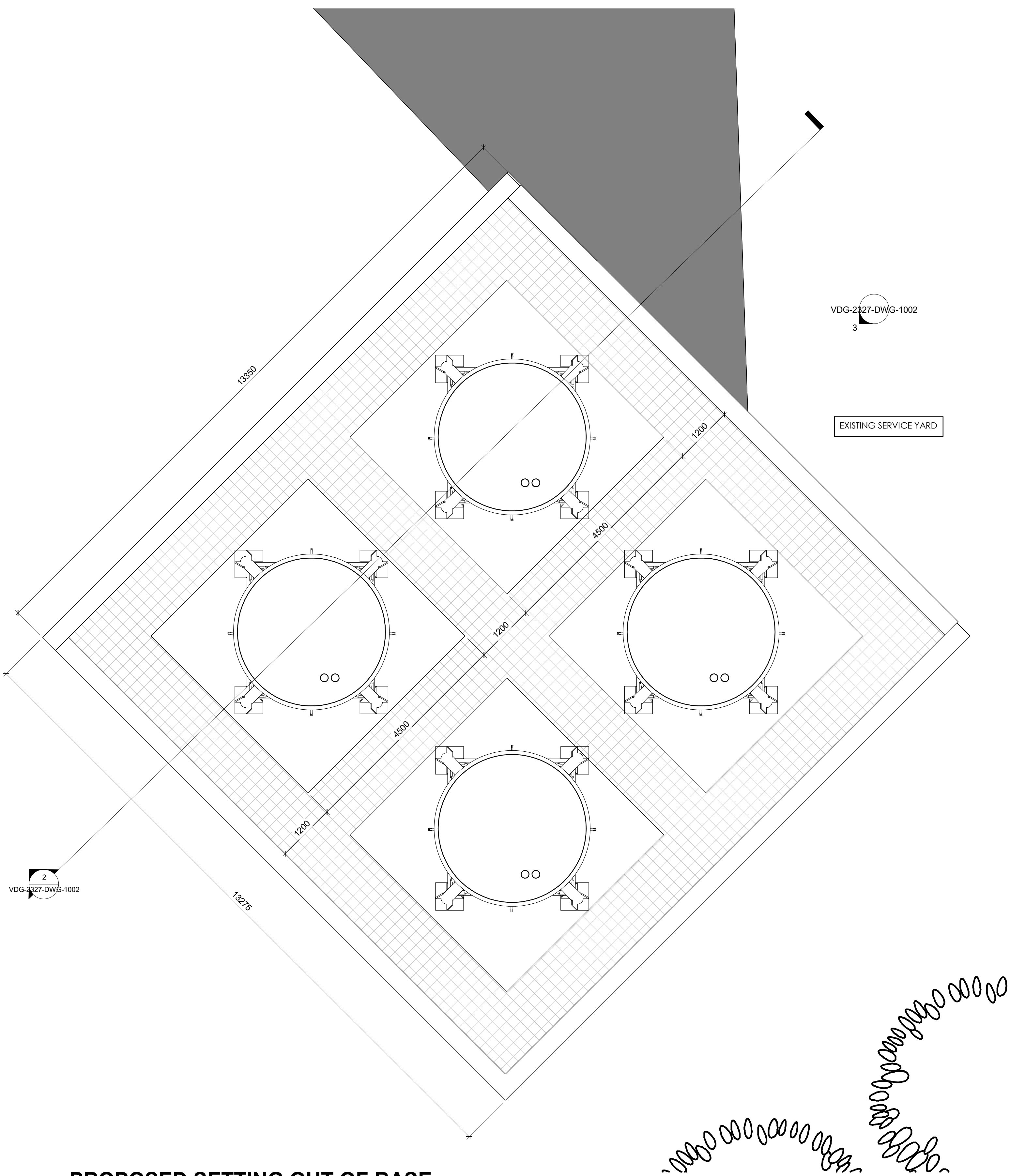
DATE
02/25/25

SCALE (@ A1)
1 : 250

PROJECT NUMBER
MCS2185

DRAWING NUMBER
VDG-2327-DWG-1003

REV
1



PROPOSED SETTING OUT OF BASE
1 : 50

Rev	Description	Date
1	PLANNING ISSUE	25/02/25

CODE	SUITABILITY DESCRIPTION
I	PLANNING
STATUS	PURPOSE OF ISSUE
S2	PLANNING

PROJECT

SILO'S INSTALLATION

TITLE

PROPOSED PLAN AREA OF SILO
BASE

CLIENT

LANCASHIRE FARM DAIRIES

DRAWN BY
B.N

CHECKED BY
F.R

DATE
02/25/25

SCALE (@ A1)
1 : 50

PROJECT NUMBER
MCS2185

DRAWING NUMBER	REV
VDG-2327-DWG-1004	1

Appendix 03



Grass area to extend to service yard



Carpark replaced with silos slab & foundations



Existing Car-Park



Site entrance to car-park



Entrance to office



Retained height from service yard to building level.



Footpath to front of building



Drop in elevation to Stockton Street



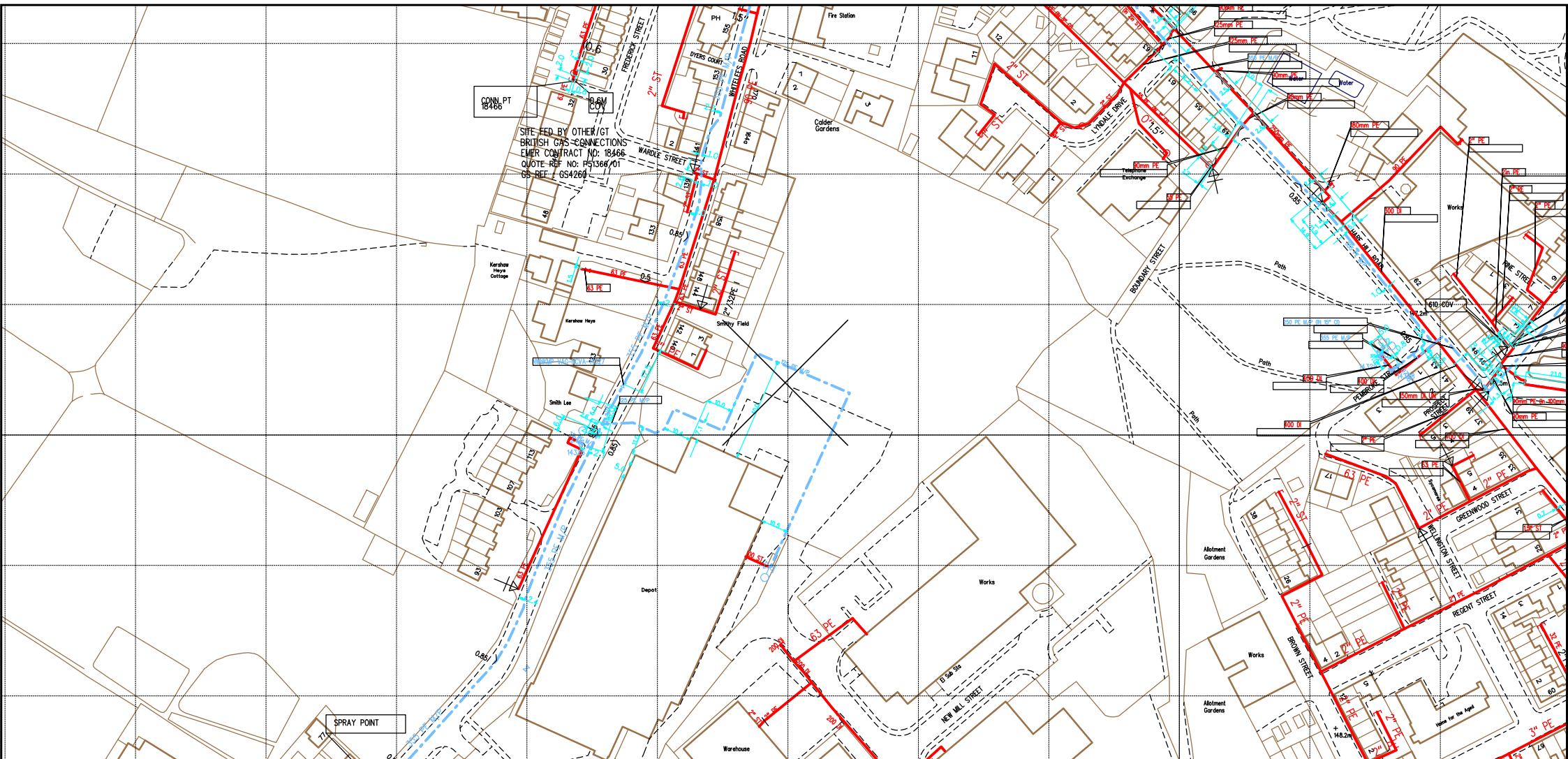
HGV loading bays



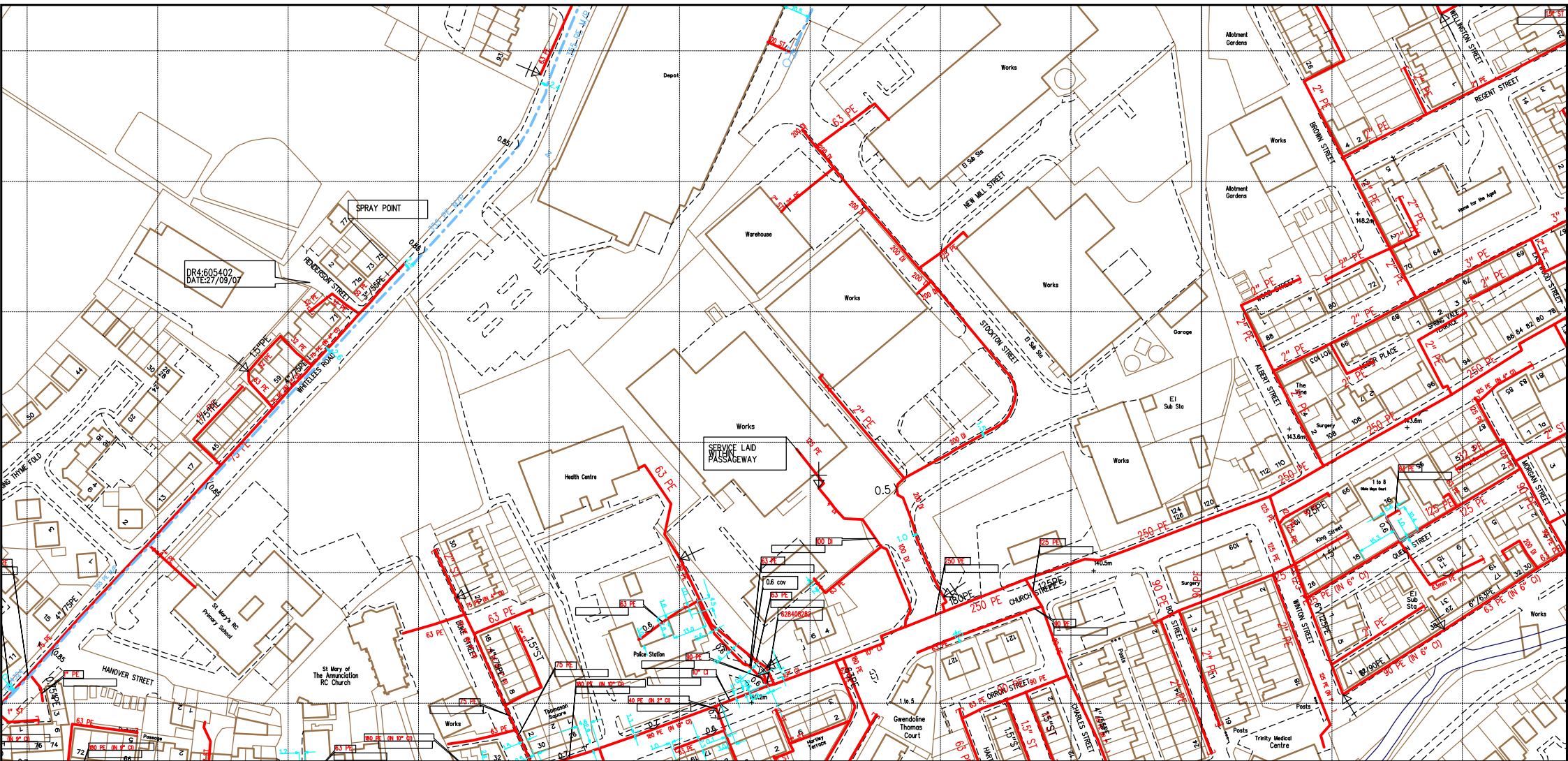
Roof to Lidl Building

Appendix 04

GAS



SCALE: Not to scale		LP MAINS MP MAINS IP MAINS LHP MAINS NHP MAINS	This plan shows those pipes owned by National Grid Gas plc in their role as a Licensed Gas Transporter (GT). Gas pipes owned by other GTs, or otherwise privately owned, may be present in this area. Information with regard to such pipes should be obtained from the relevant owners. The information shown on this plan is given without warranty, the accuracy thereof cannot be guaranteed. Service pipes, valves, syphons, stub connections, etc. are not shown but their presence should be anticipated. No liability of any kind whatsoever is accepted by National Grid Gas plc or their agents, servants or contractors for any error or omission. Safe digging practices, in accordance with HS(G)47, must be used to verify and establish the actual position of mains, pipes, services and other apparatus on site before any mechanical plant is used. It is your responsibility to ensure that this information is provided to all persons (either direct labour or contractors) working for you on or near gas apparatus. The information included on this plan should not be referred to beyond a period of 28 days from the date of issue. Further information on all DR4s can be determined by calling the DR4 hotline on 01455 892426 (9am-5pm) A DR4 is where a potential error has been identified within the asset record and a process is currently underway to investigate and resolve the error as appropriate.	MAPS Viewer Version 5.7.0.0	
USER ID: Cornerstone Projects				Local Machine This plan is reproduced from or based on the OS map by National Grid Gas plc, with the sanction of the controller of HM Stationery Office. Crown Copyright Reserved.	
DATE: 24/02/2017					
EXTRACT DATE: 06/12/2016					
MAP REF: SD9316					
CENTRE: 393349, 416520					
Some examples of Plant Items:			Valve Depth of Cover Syphon Diameter Change Material Change Out of Standard Service		



SCALE: Not to scale

USER ID: Cornerstone Projects

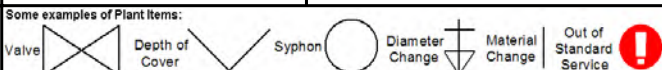
DATE: 24/02/2017

EXTRACT DATE: 06/12/2016

MAP REF: SD9316

CENTRE: 393340, 416323

LP MAINS
MP MAINS
IP MAINS
LHP MAINS
NHP MAINS



This plan shows those pipes owned by National Grid Gas plc in their role as a Licensed Gas Transporter (GT). Gas pipes owned by other GTs, or otherwise privately owned, may be present in this area. Information with regard to such pipes should be obtained from the relevant owners. The information shown on this plan is given without warranty, the accuracy thereof cannot be guaranteed. Service pipes, valves, syphons, stub connections, etc. are not shown but their presence should be anticipated. No liability of any kind whatsoever is accepted by National Grid Gas plc or their agents, servants or contractors for any error or omission. Safe digging practices, in accordance with HS(G)47, must be used to verify and establish the actual position of mains, pipes, services and other apparatus on site before any mechanical plant is used. It is your responsibility to ensure that this information is provided to all persons (either direct labour or contractors) working for you on or near gas apparatus. The information included on this plan should not be referred to beyond a period of 28 days from the date of issue. Further information on all DR4s can be determined by calling the DR4 hotline on 01455 892426 (9am-5pm) A DR4 is where a potential error has been identified within the asset record and a process is currently underway to investigate and resolve the error as appropriate.

MAPS Viewer Version 5.7.0.0

Local Machine

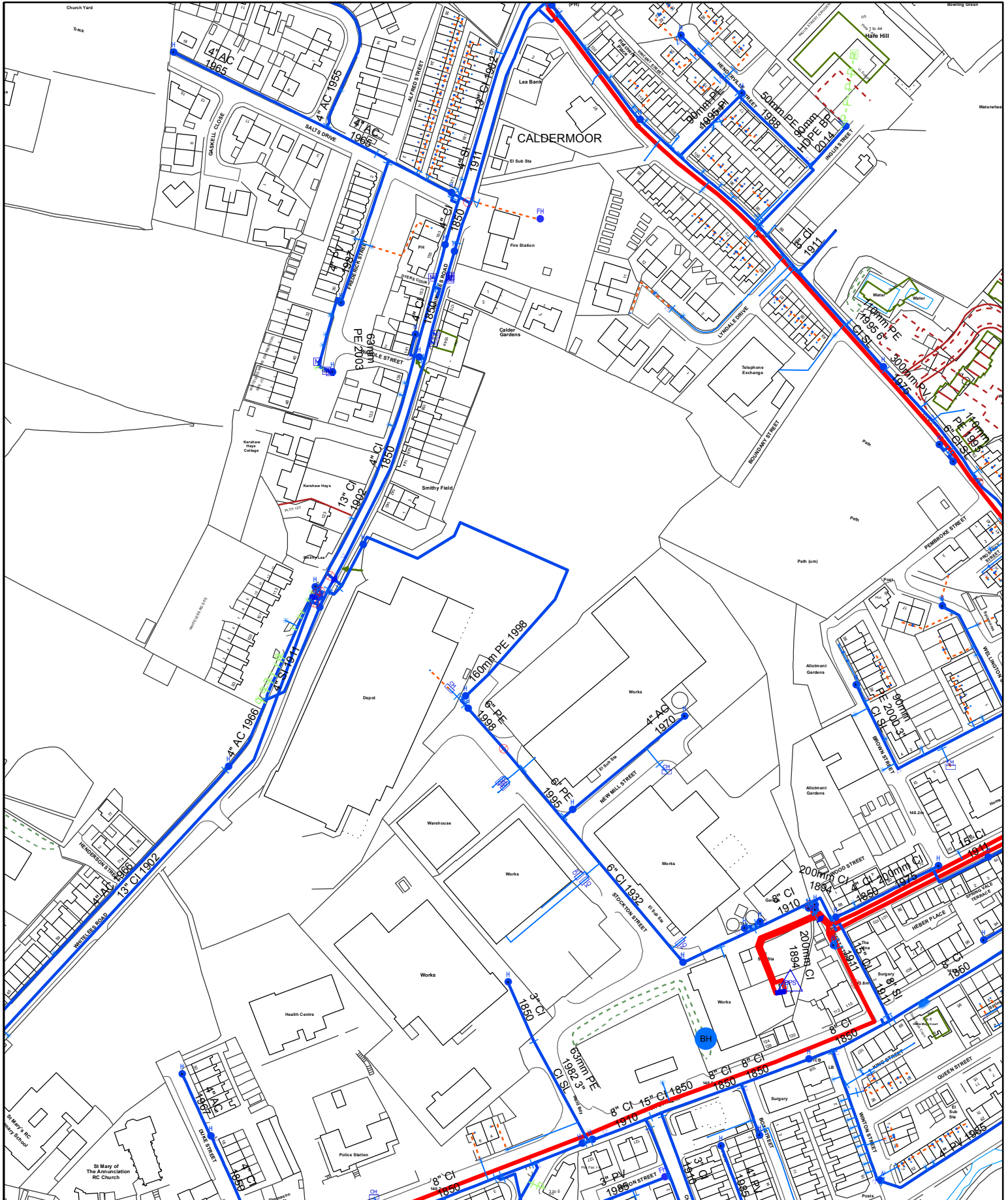
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Date: 27/02/2017

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Property Searches

Extract from Map Of Water Mains

X393362 Y416487

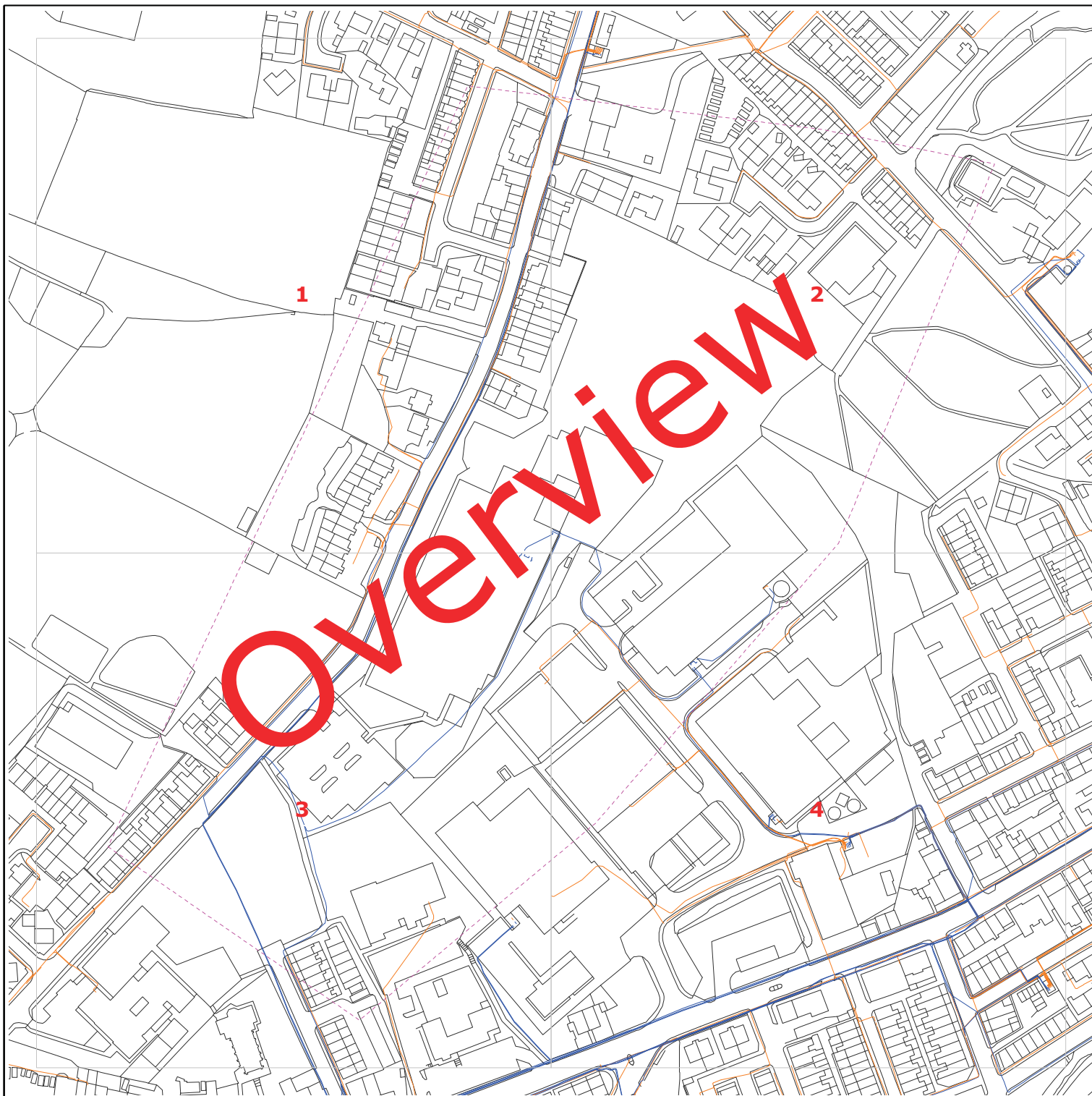


The position of this underground apparatus shown on this plan is approximate only and is given in accordance with the best information currently available. The actual positions may be different from those shown on the plan private service pipes may be shown by a broken blue line. United Utilities will not accept any liability for any damage caused by the actual positions being different from those shown

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ELECTRIC

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Company No. 5132353



Requested by: Duncan Phillips
 Company: Cornerstone Projects
 Date Requested: 24/02/2017
 Job Reference: 9956230
 Your Scheme/Reference: 6452

Operating Voltage	Colour Code	Line Colour
132kV	Black	
33kV	Green	
22kV-25kV	Yellow	
11kV	Red	
6kV-6.6kV	Blue	
1kV-6kV	Violet	
LV	Orange	
Unknown Voltage	Brown	



Dig Sites:

Area  Line 

Data Management
 Electricity North West
 Linley House
 Dickinson Street
 Manchester, M1 4LF
 Phone: 0800 195 4141
 Email: planrequest@enwl.co.uk

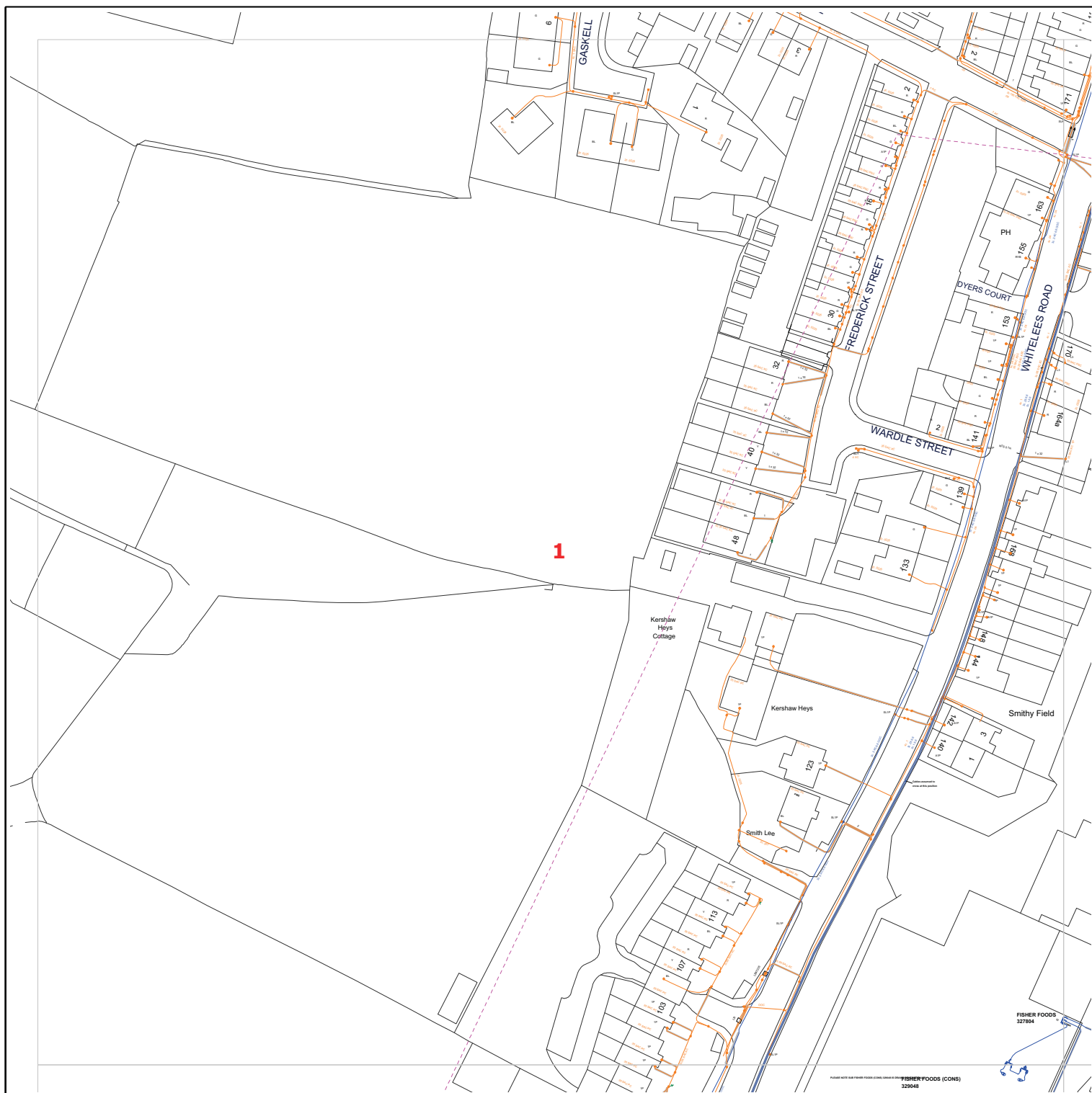
Scales on A4 paper:
 1:1250 Area dig site
 1:250 Line dig site

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Reference should be made to HSE Guidance, HS(G)47 "Avoiding Danger from Underground Services" and GS6 "Avoidance of Danger from Overhead Power Lines".

Electricity North West Limited 304 Bridgewater Place, Birchwood Park, Warrington WA3 6XG. Registered in England and Wales. Registered No 02366949



Requested by: Duncan Phillips
 Company: Cornerstone Projects
 Date Requested: 24/02/2017
 Job Reference: 9956230
 Your Scheme/Reference: 6452

Operating Voltage	Colour Code	Line Colour
132kV	Black	
33kV	Green	
22kV-25kV	Yellow	
11kV	Red	
6kV-6.6kV	Blue	
1kV-6kV	Violet	
LV	Orange	
Unknown Voltage	Brown	



Dig Sites:
 Area  Line 

Data Management
 Electricity North West
 Linley House
 Dickinson Street
 Manchester, M1 4LF
 Phone: 0800 195 4141
 Email: planrequest@enwl.co.uk

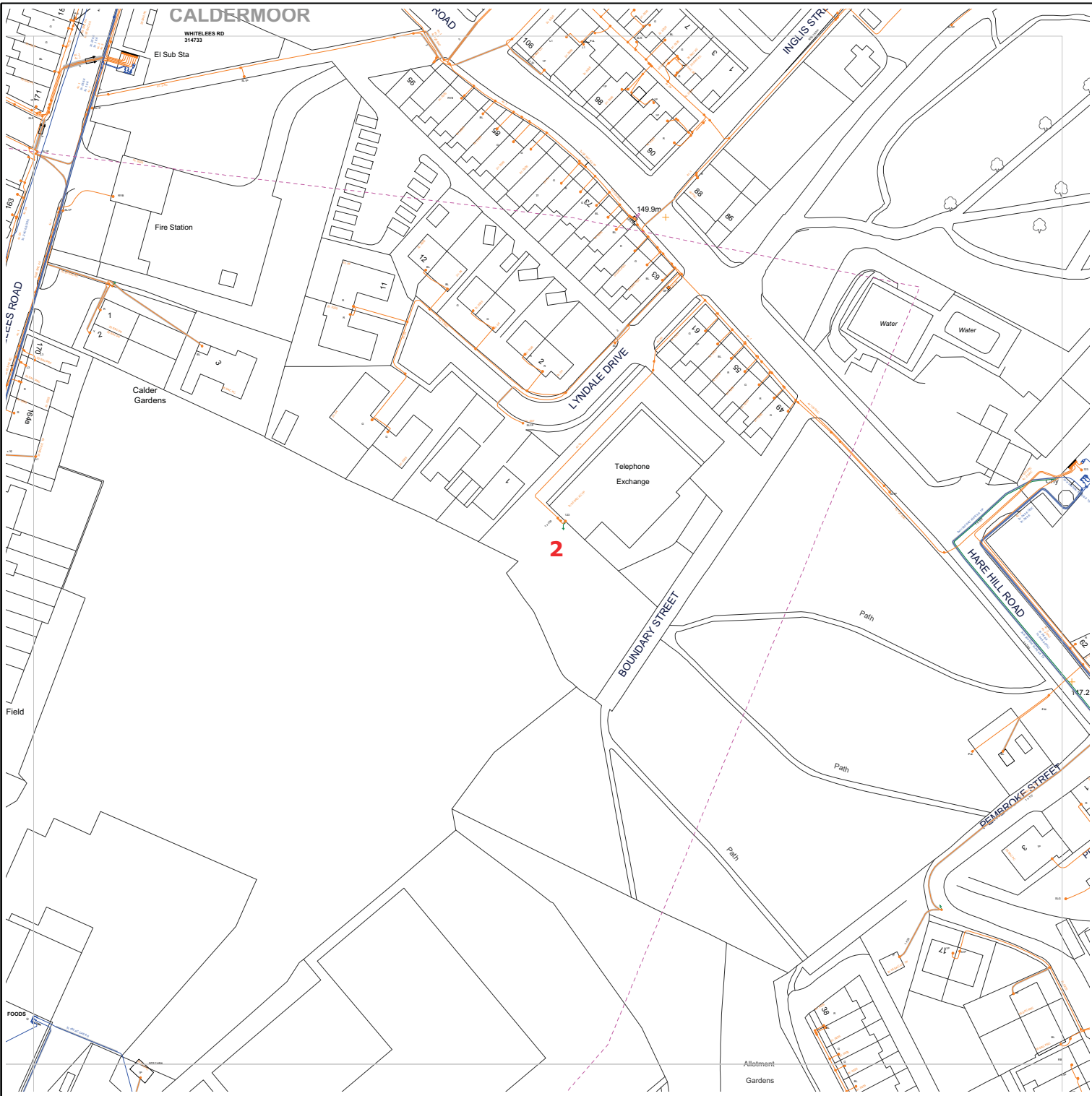
Scales on A4 paper:
 1:1250 Area dig site
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Dig Sites:

Area Line

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Dickinson Street
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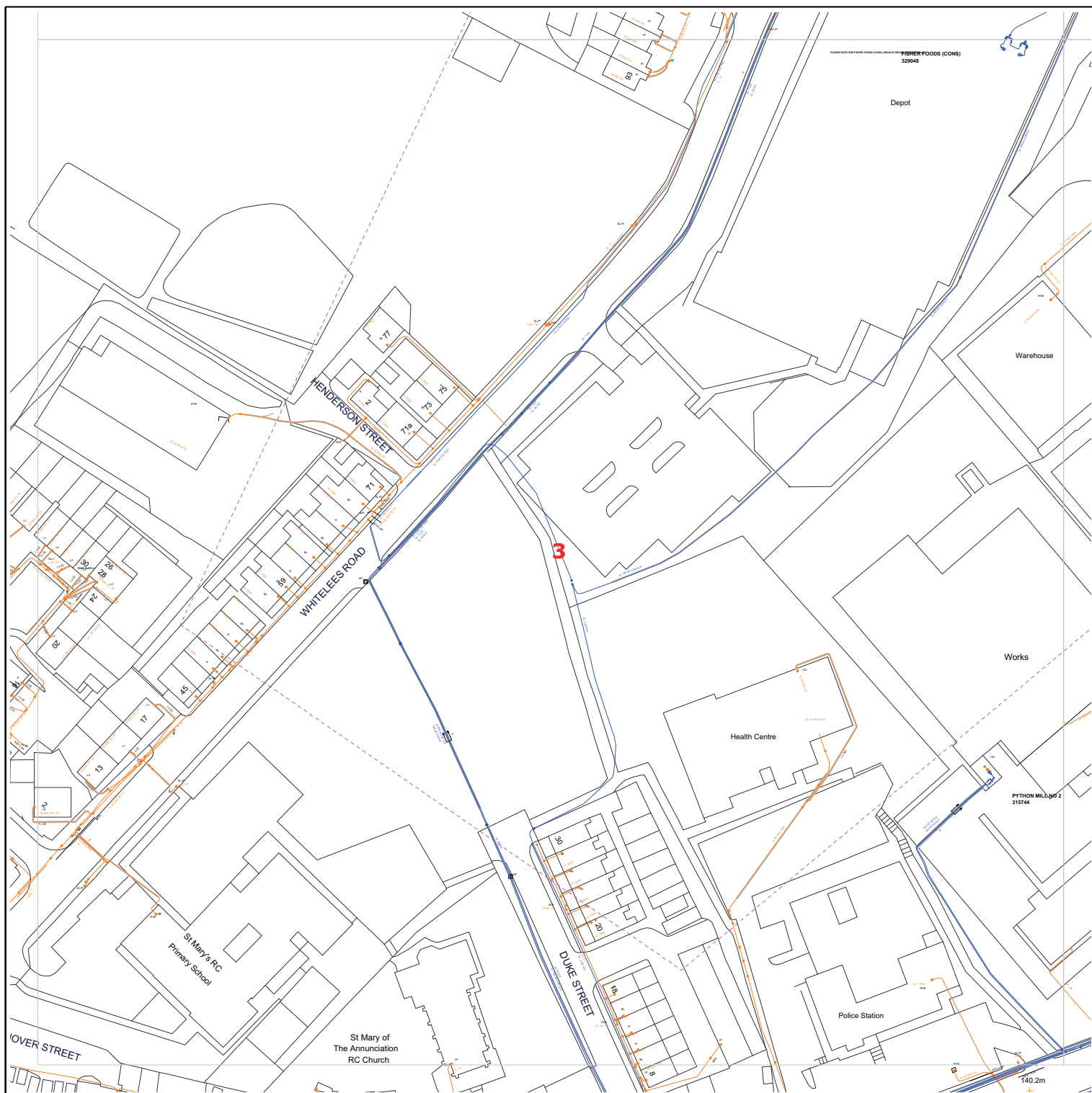
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Plans generated by DigSAFE Pro (tm) software provided by PelicanCorp



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electricity
 north west

Dig Sites:

Area Line

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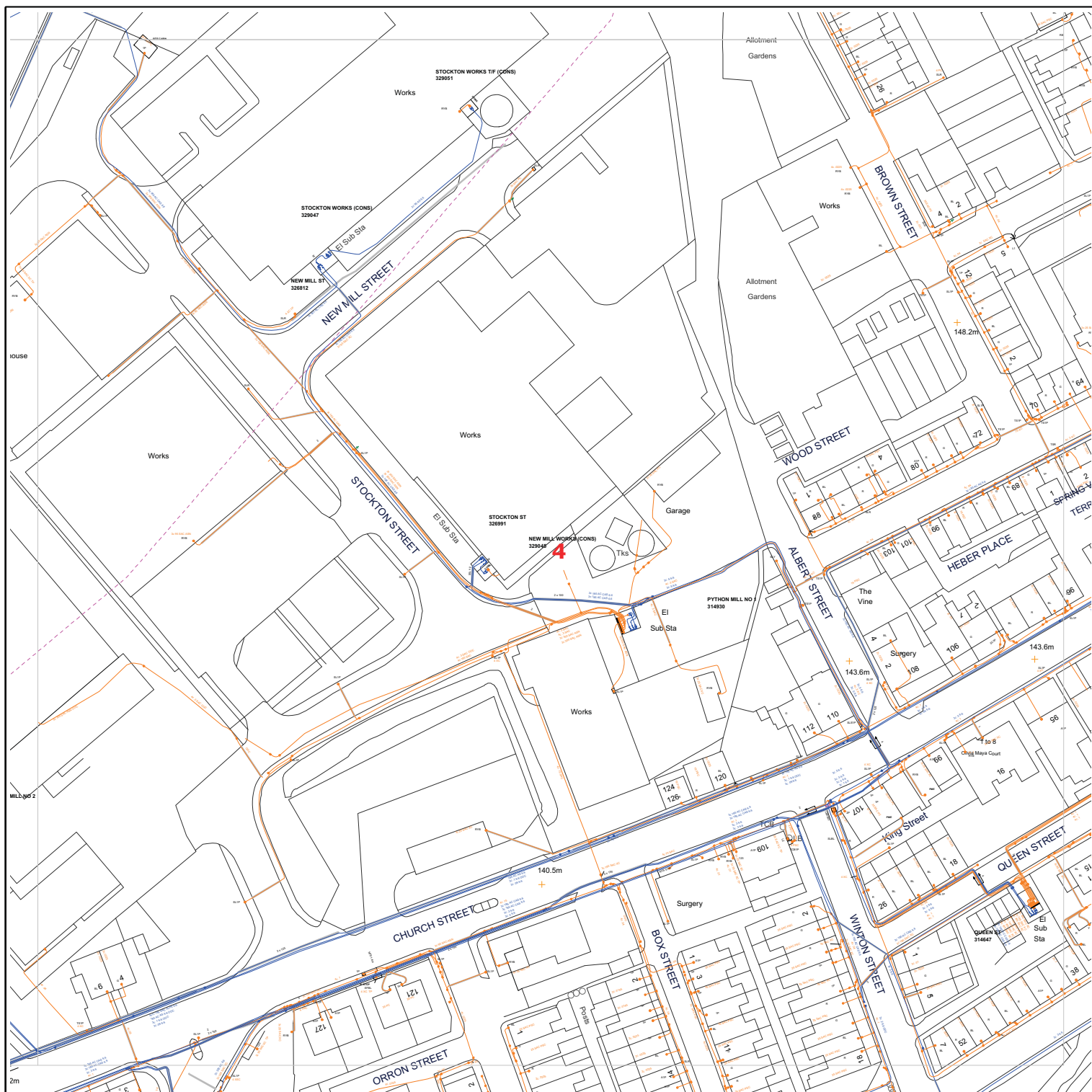
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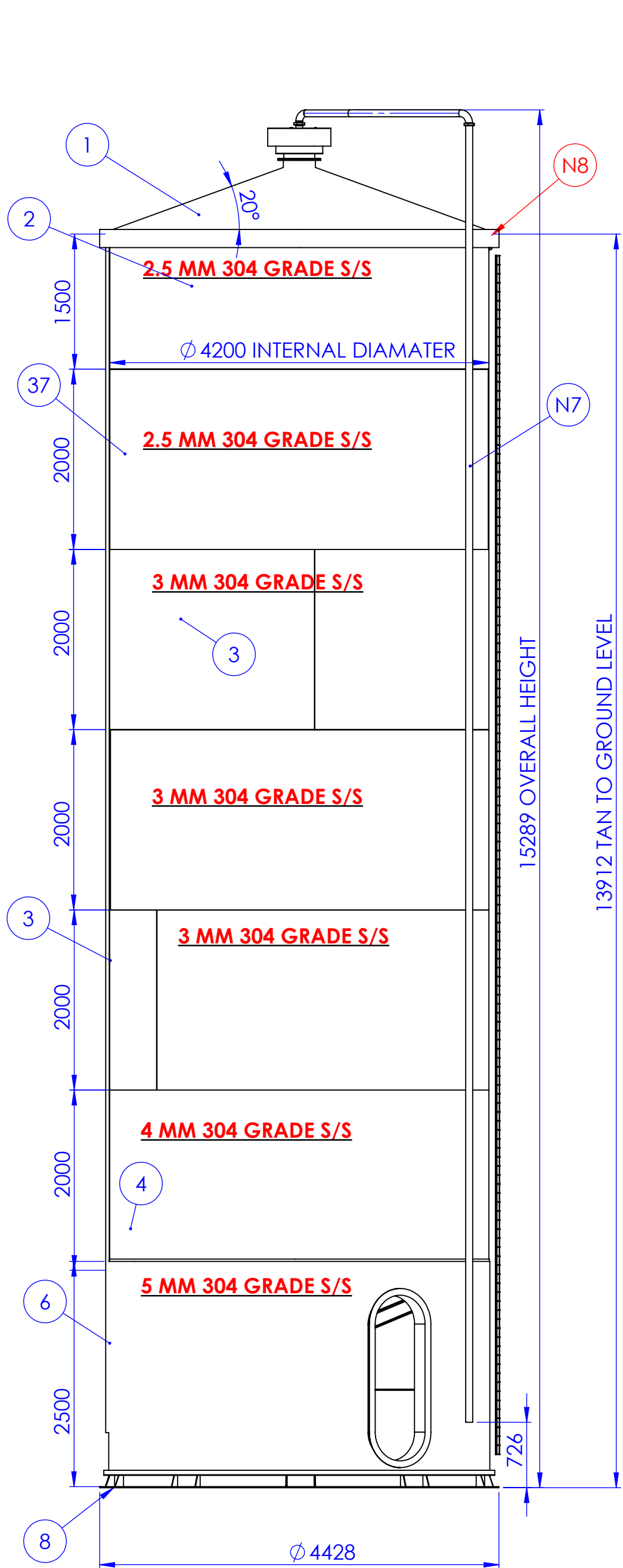
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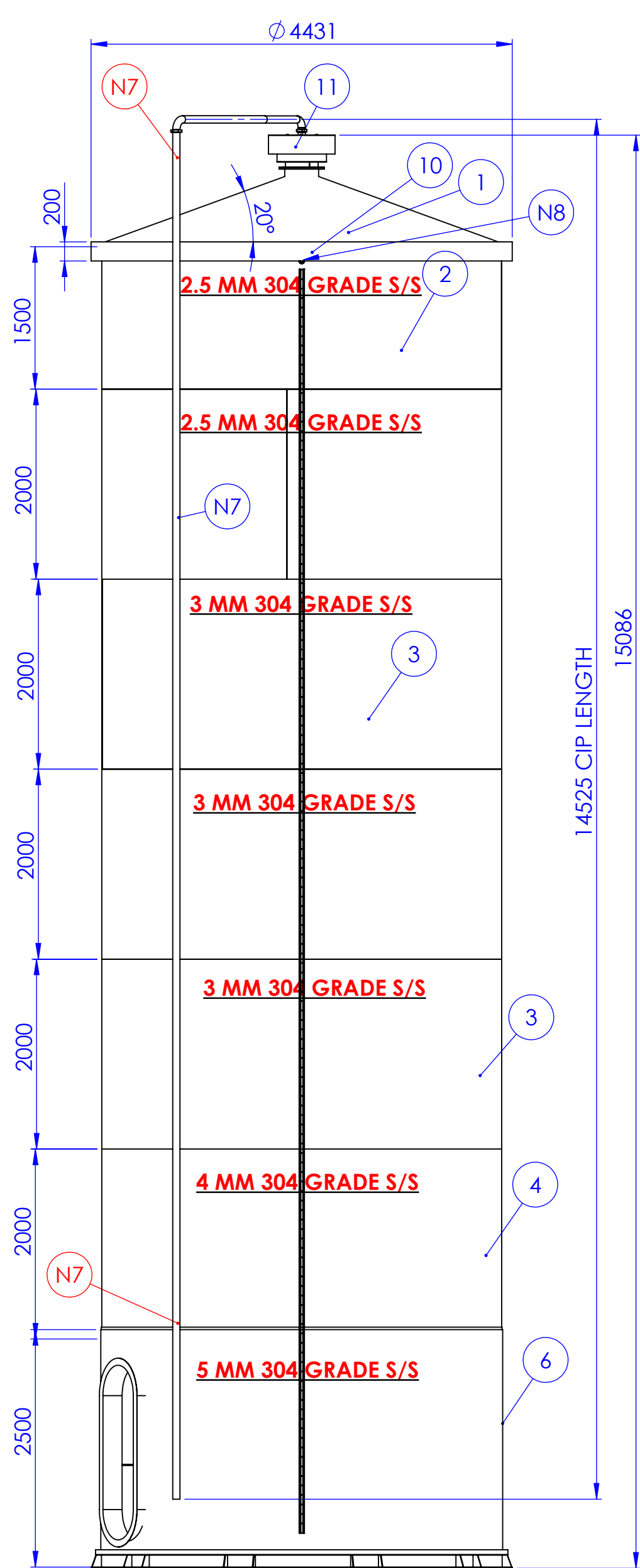
Scales on A4 paper:
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Appendix 05

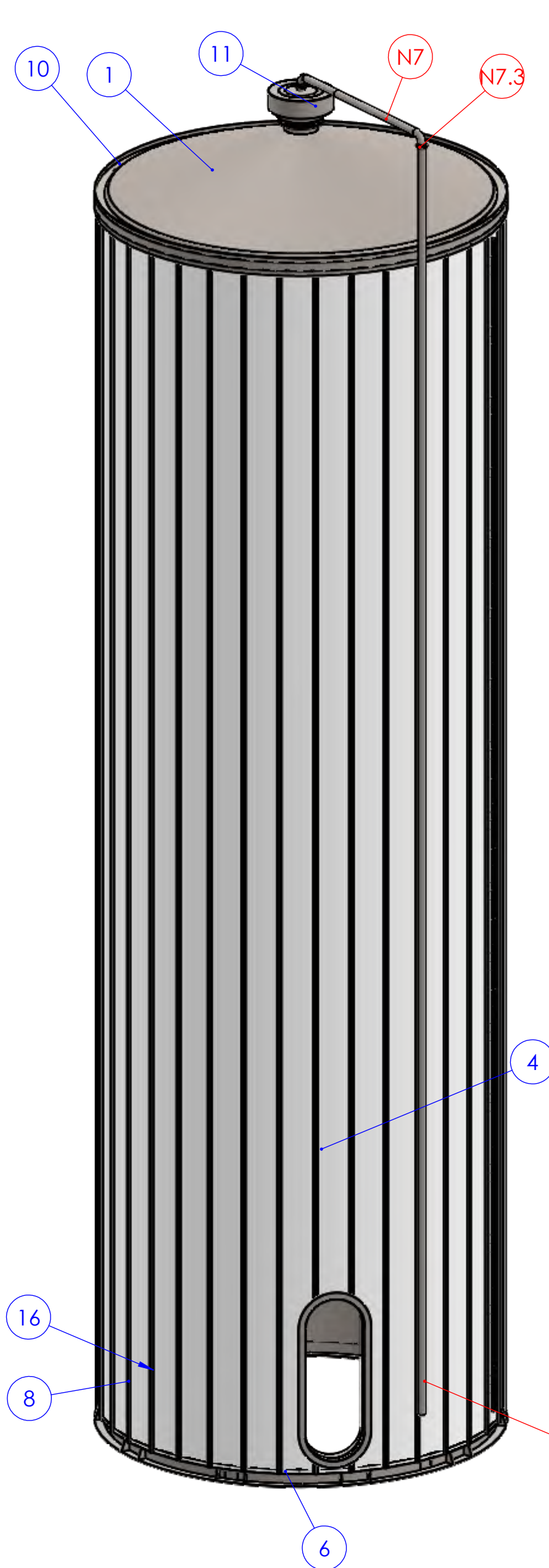
FRONT ELEVATION UNCLADDED



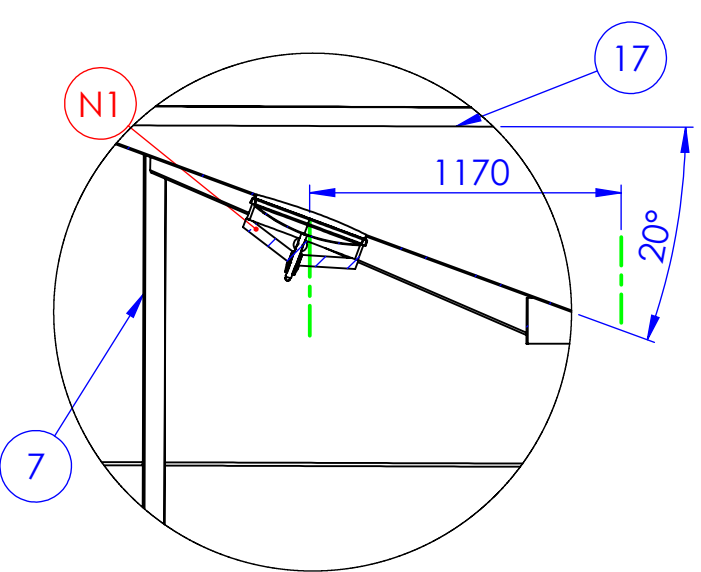
SIDE ELEVATION UNCLADDED



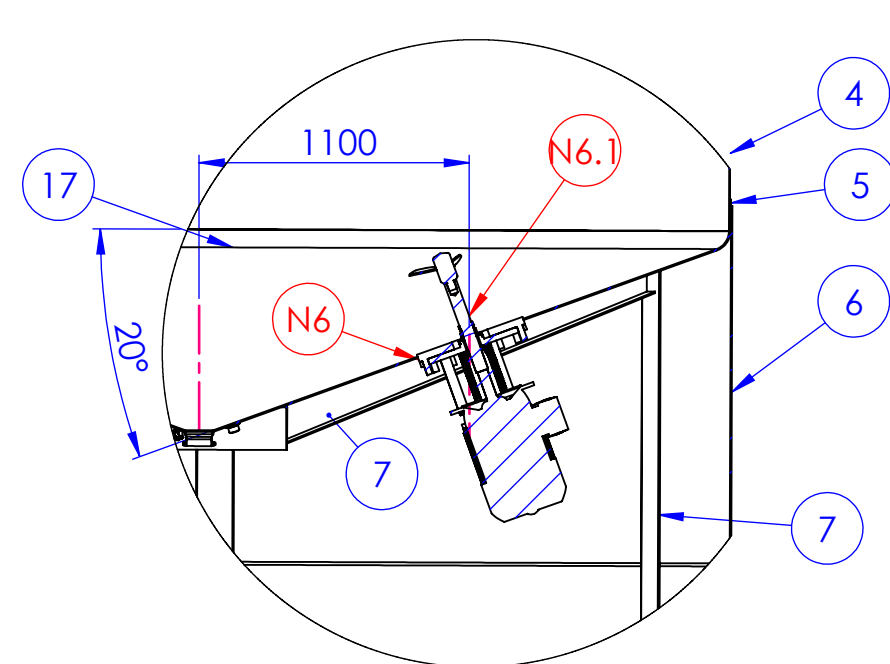
CLADDED VIEW ISOMETRIC



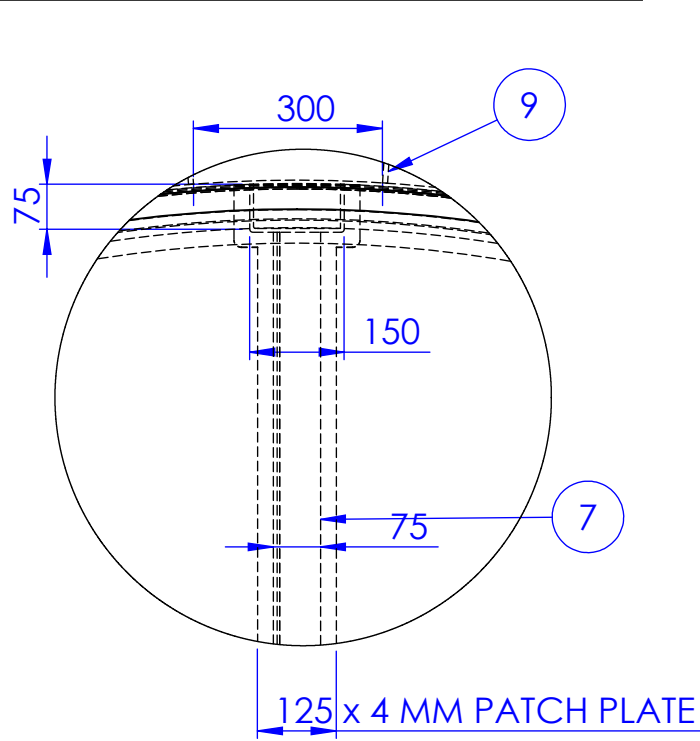
MANWAY SECTION VIEW



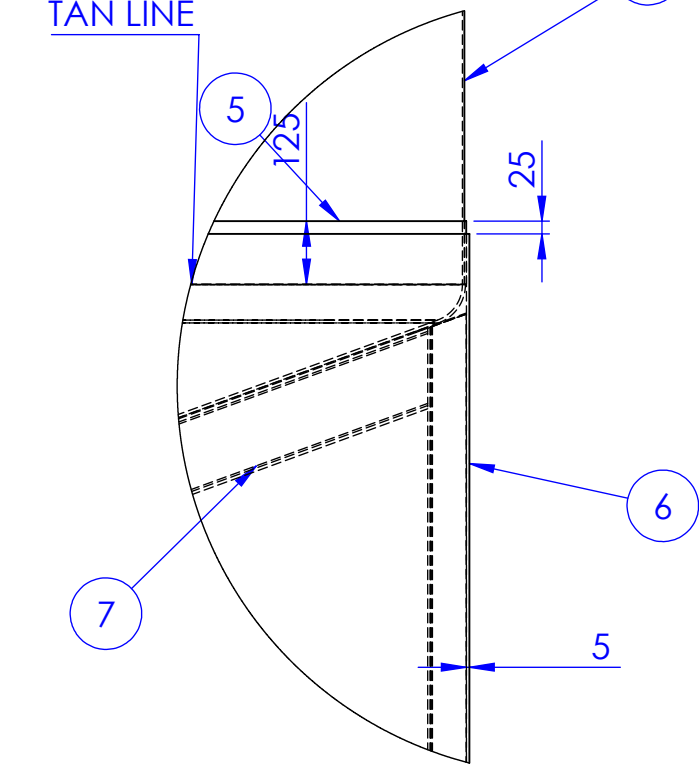
AGITATOR SECTION VIEW



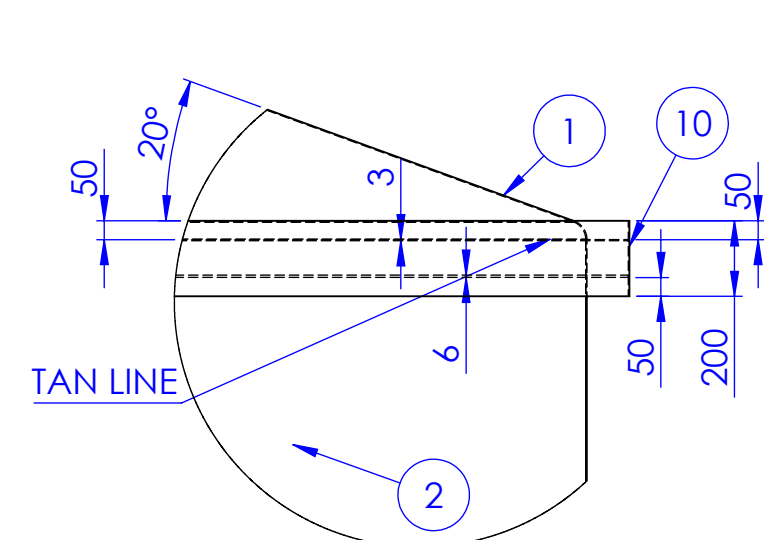
SUPPORT CHANNEL DETAIL



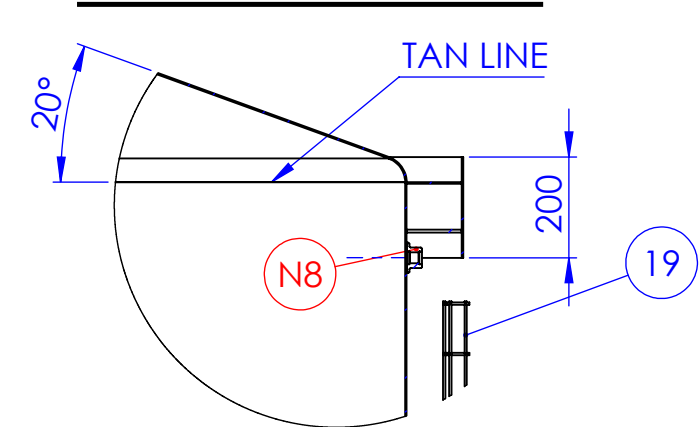
SKIRT ATTACHMENT DETAIL



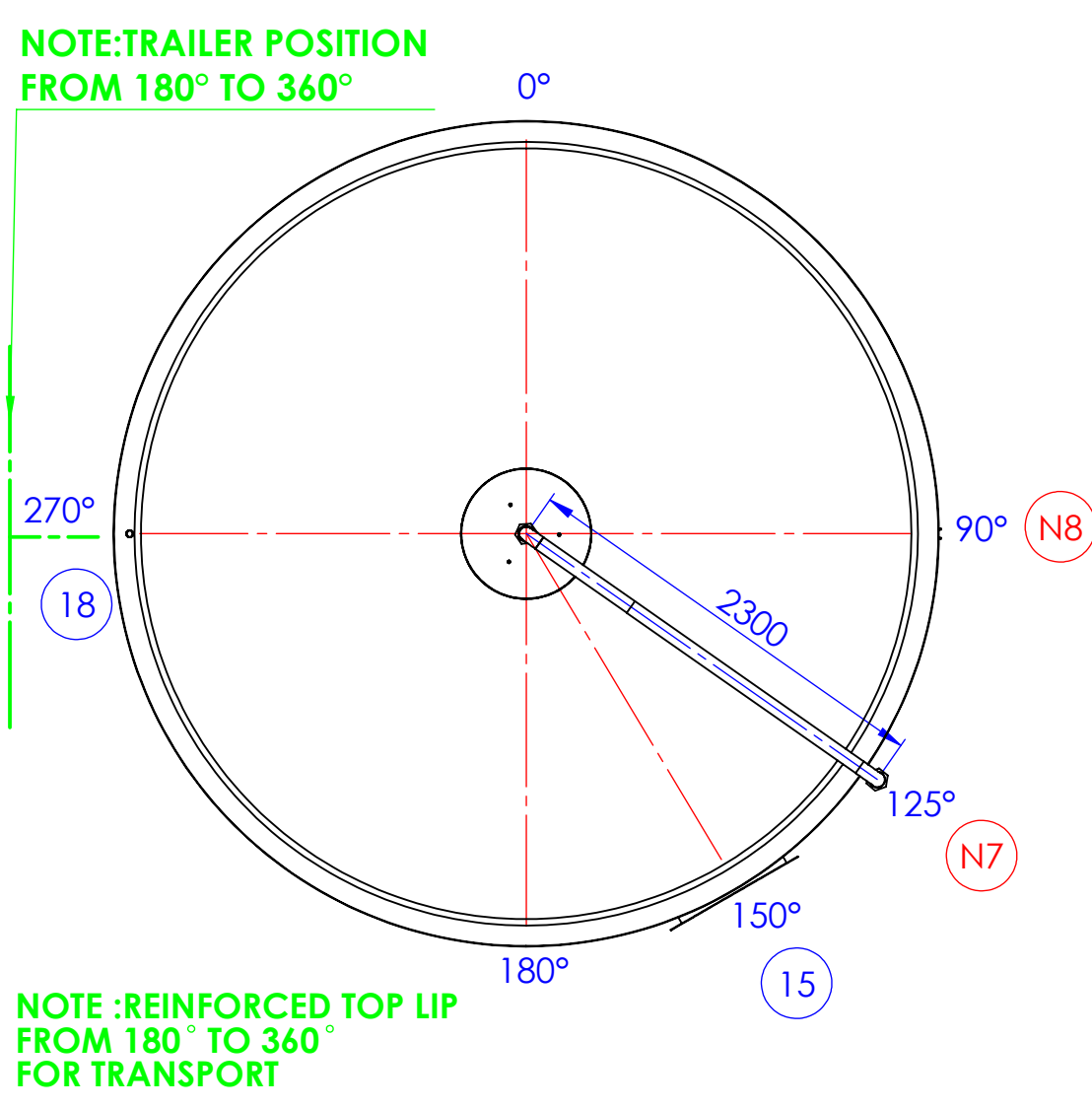
REINFORCED TOP LIP



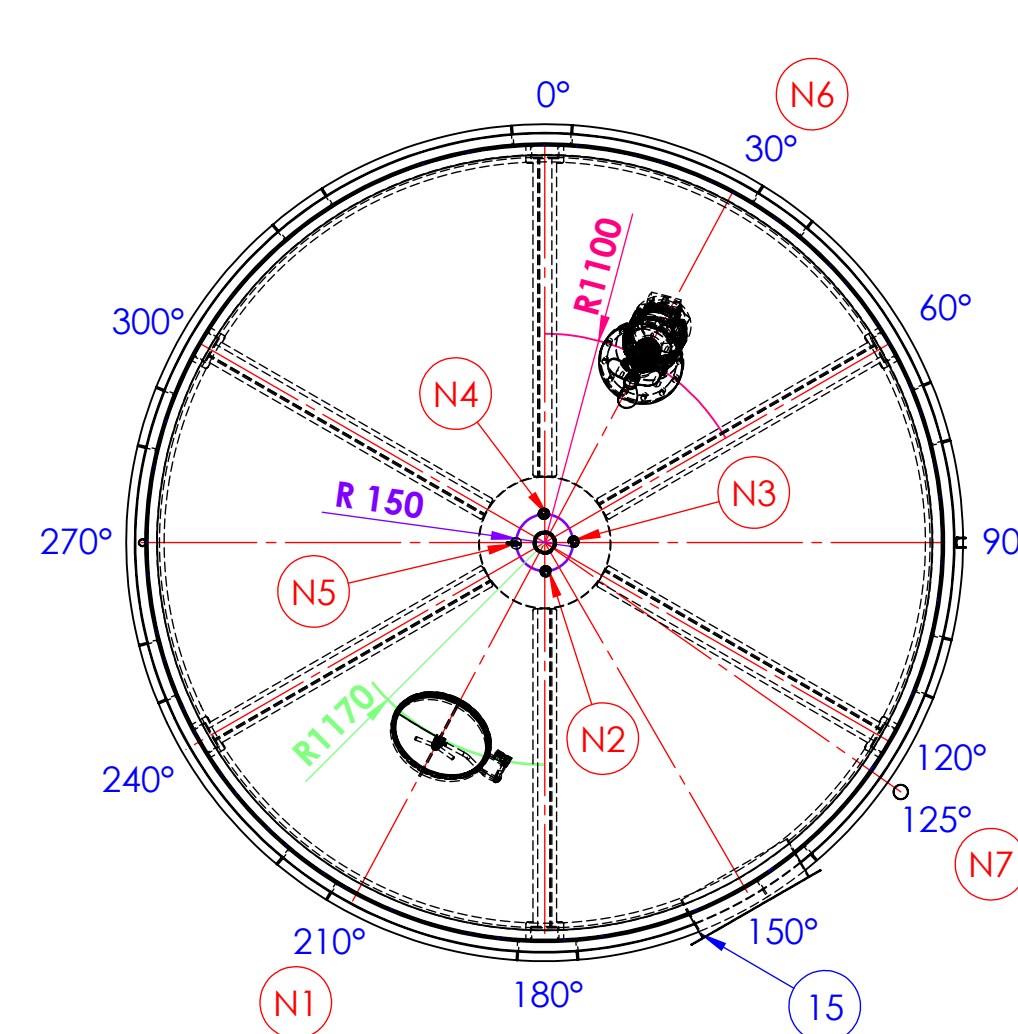
HIGH LEVEL PROBE



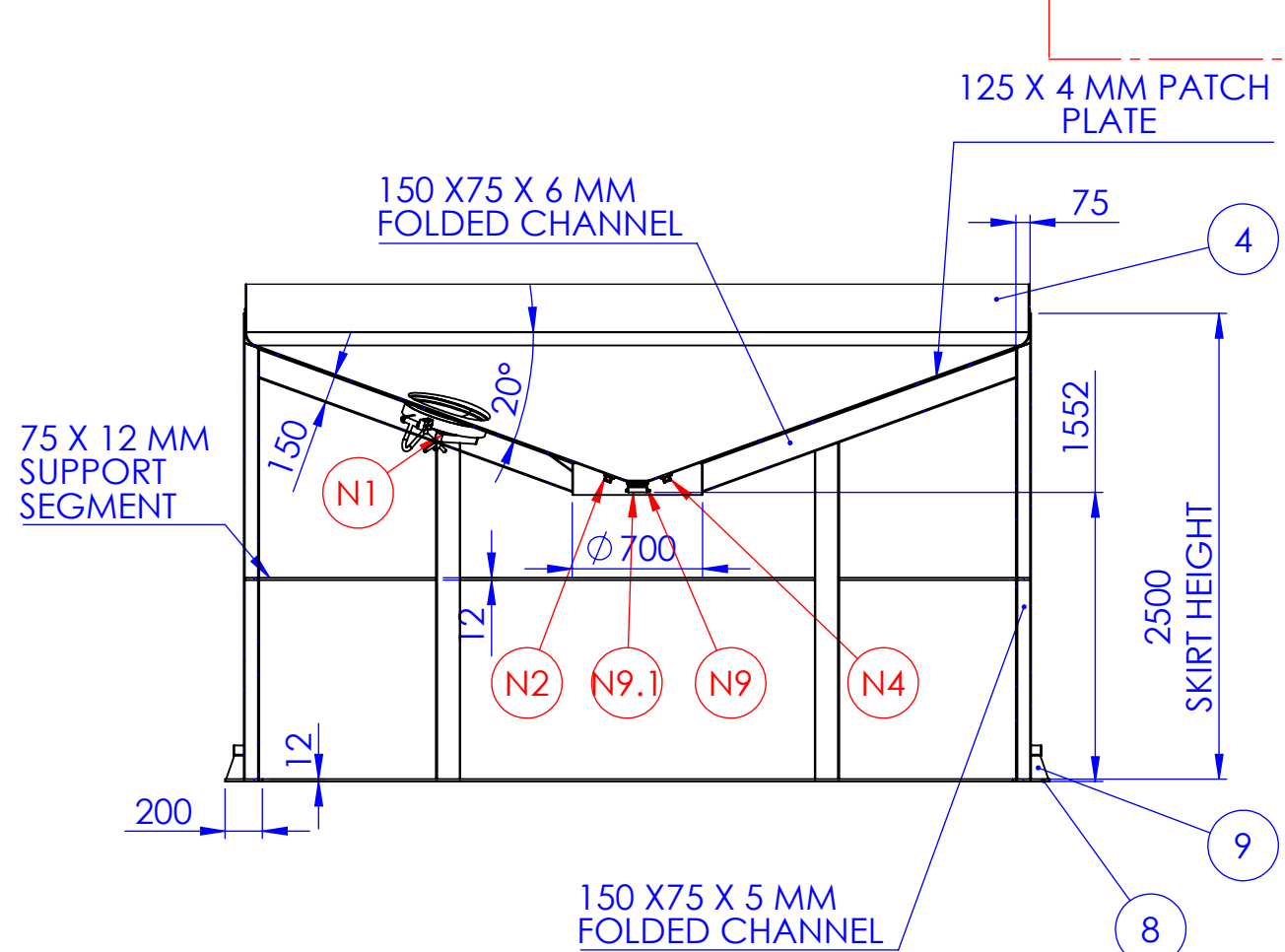
PLAN VIEW FROM ROOF LEVEL



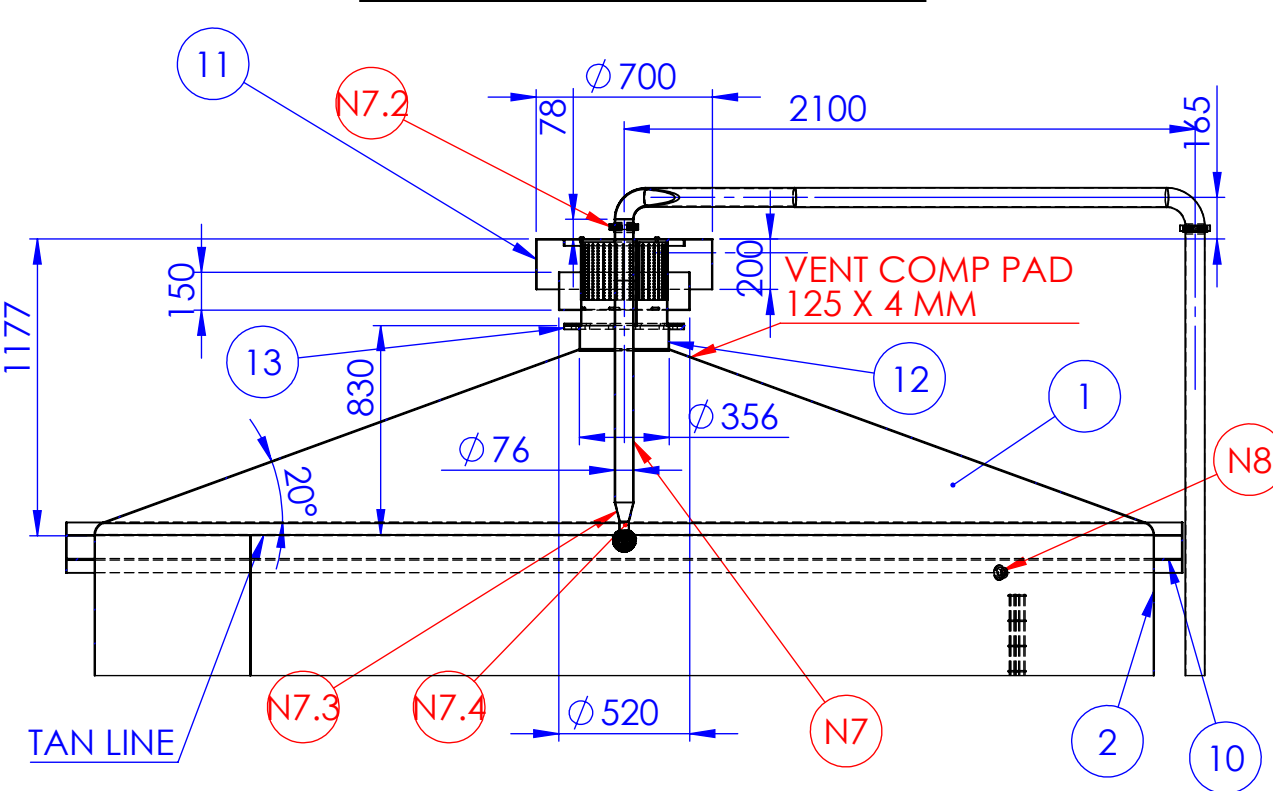
BASE PLAN VIEW FROM ROOF LEVEL



BASE SUPPORT SECTION VIEW



CIP AND VENT DETAILS



GENERAL SPECIFICATION

PROJECT NO :	12659-61	BWE NO :	12659-61
PURCHASE ORDER NUM :	SEP REF ASME 8 DIV 1 & EN 14015	DYE PENETRANT :	YES
DESIGN CODE :	SWE SS 001 /003&004	INSULATION :	50 MM ROCKWOOL
BWE WELD PROCEDURE :	YES	EXTERNAL PLATES AND PADS :	304L STAINLESS STEEL
RADIOGRAPHY :	NA	GASKET MATERIAL :	PTFE
PASSIVATION :	YES	WEIGHT FULL :	T.B.C
BWE SEAM WELD PROCEDURE :	BWE SS 005	BOTTOM JACKET AREA :	NA

DESIGN DATA / CAPACITY

	SHELL	JACKET	COIL
DESIGN PRESSURE BAR (G)	ATMOSPHERIC	NA	NOT REQUIRED
DESIGN TEMP *	AMBIENT	NA	N/A
OPERATING PRESSURE (BAR)	ATMOSPHERIC	NA	NOT REQUIRED
OPERATING TEMP	TO 95 DEG	NA	NOT REQUIRED
TEST MEDIUM	NOT REQUIRED	NA	NOT REQUIRED

PRESSURE EQUIPMENT DIRECTIVE 91/23/EC INFORMATION

CONTENTS :	RAW MILK	GROUP :	
PS XV :		CATEGORY NUM :	
CONFORMITY MODULE :		NOTIFIED BODY :	

SURFACE PREPARATION

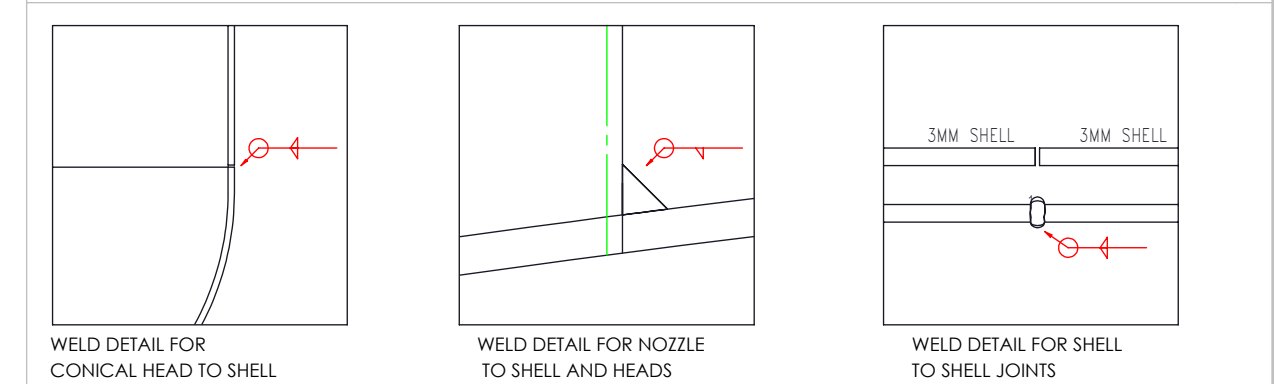
	SURFACE	SHELL WELDS	NOZZLE WELDS
INTERNAL :	2B COLD ROLLED	POLISHED 180 GRIT	POLISHED 180 GRIT
EXTERNAL UNEXPOSED :	2B COLD ROLLED	BUFFED / POLISHED	BUFFED / POLISHED
EXTERNAL EXPOSED :	CLADDING	POLISHED / BUFFED	BUFFED / POLISHED

BILL OF MATERIALS

ITEM NO.	PART	QTY.	DESCRIPTION	MATERIAL	FINISH
1	CONICAL HEAD 20°	1	CONICAL HEAD 304 GRADE 3 MM	304L STAINLESS STEEL	2B COLD ROLLED
2	SHELL SECTION 2.5 MM	2	STANDARD SECTION 304 GRADE	304L STAINLESS STEEL	2B COLD ROLLED
3	SHELL SECTION 3 mm	3	STANDARD SECTION 304 GRADE	304L STAINLESS STEEL	2B COLD ROLLED
4	STANDARD 4 mm SECTION	1	SECTION 304 GRADE 4 mm	304L STAINLESS STEEL	2B COLD ROLLED
5	SKIRT PATCH PLATE	1	125mm PATCH PLATE 4 mm	304L STAINLESS STEEL	2B COLD ROLLED
6	BOTTOM SKIRT	1	5 MM OUTER SUPPORT SKIRT	304L STAINLESS STEEL	2B COLD ROLLED
7	150 X 75 X 6mm FOLDED CHANNELS	1	6 mm LASER CUT CHANNELS C/W 4 mm COMP PAD	304L STAINLESS STEEL	2B COLD ROLLED
8	HOLDING-DOWN SEGMENT	1	12 MM LASER CUT SEGMENT	304L STAINLESS STEEL	HOT ROLLED
9	HOLDING-DOWN GUSSETS	10	LASER CUT GUSSETS 300 MM CENTRES 10 SETS	304L STAINLESS STEEL	HOT ROLLED
10	TOP LIP	1	3 MM TOP LIP C/W 6 MM REINFORCED TOP LIP FOR TRANSPORT	304L STAINLESS STEEL	2B COLD ROLLED
11	14 INCH VENT	1	BWE STANDARD VENT C/W CIP	316L STAINLESS STEEL	2B COLD ROLLED
12	VENT NECK	1	14 INCH SCH 10 VENT NECK	316L STAINLESS STEEL	180 GRIT
13	VENT FLANGE	1	15 MM FLANGE CONNECTION FOR VENT	304L STAINLESS STEEL	180 GRIT
14	VENT COMP PAD	1	4 MM VENT COMP PAD WITH 125 MM BAND	304L STAINLESS STEEL	2B COLD ROLLED
15	SKIRT ACCESS	1	6 MM ROLLED BAND C/W 3 MM FLASHING	304L STAINLESS STEEL	180 GRIT
16	CLADDING	1	R32 PROFILE PVC COATED CLADDING COLOUR T.B.C	PVC PROFILE CLADDING	
17	CONICAL BASE	1	CONICAL BASE 304 GRADE 6 MM	304L STAINLESS STEEL	2B COLD ROLLED
18	DRAIN	1	1.5 INCH DAIRY PIPED TO GROUND	304L STAINLESS STEEL	180 GRIT
19	CABLE TRAY	1	50 X 50 MM CABLE TRAY SERVING HGL LEVEL PROBE	304L STAINLESS STEEL	180 GRIT
20	CLADDING BASE	1	STAINLESS STEEL CLADDING BASE 3 MM	304L STAINLESS STEEL	2B COLD ROLLED
21	GUARD MASTER SWITCH	1	ALLEN BRADLEY GUARD MASTER 440C-B0426		

COMPONENT REFERENCE	PART	QTY.	PIPE SIZE	TYPE	DESCRIPTION	MATERIAL	FINISH
N1	SIDE ENTRY A16 MANWAY	1			SIDE ENTRY - LAVEGGI A16 MANWAY	316L STAINLESS STEEL	
N2	LOW LEVEL PROBE	1	NA		WELD IN SOCKET G1 INCH D-60 FDA EHEDG	316L STAINLESS STEEL	180 GRIT
N3	TEMP TRANSMITTER	1	N/A		WELD IN SOCKET G1 INCH D-60 FDA EHEDG	316L STAINLESS STEEL	180 GRIT
N4	PRESSURE TRANSMITTER	1	NA		WELD IN SOCKET E&H 50006262 DB5	316L STAINLESS STEEL	180 GRIT
N5	KEORIT SAMPLE VALVE	1	NA		HEAD AND BODY 440001	316L STAINLESS STEEL	180 GRIT
N6	AGITATOR FLANGE	1	NA		30 MM MACHINED FLANGE TO SUIT AGITATOR	304L STAINLESS STEEL	MACHINED
N6.1	STELZER AGITATOR	1	NA		SHU 6SL D2	304L STAINLESS STEEL	MACHINED
N7	CIP LINE	1	2"	DAIRY	3 INCH LINE C/W 90 DIA SPRAY BALL	316L STAINLESS STEEL	180 GRIT
N7.1	3" RJT UNION	1	3"	DAIRY	3" RJT UNION DAIRY	316L STAINLESS STEEL	NA
N7.2	3" RJT UNION	1	3"	DAIRY	3" RJT UNION DAIRY	316L STAINLESS STEEL	NA
N7.3	3" TO 1 1/2" REDUCER	1	NA	DAIRY	3" TO 1 1/2" CONCENTRIC REDUCER 316	316L STAINLESS STEEL	
N7.4	90 DIA 360 SPRAYBALL	1			90 DIAMETER, 360 DEGREE, 316 SPRAYBALL	316L STAINLESS STEEL	
N8	HIGH LEVEL PROBE	1	NA		WELD IN SOCKET G1 INCH D-60 FDA EHEDG	316L STAINLESS STEEL	180 GRIT
N9	BIO BORE SCH10 4" TO DAIRY 4"	1			BIO BORE SCH10 4" TO DAIRY 4"	316L STAINLESS STEEL	
N9.1	4" WELDING MALE	1	4"	DAIRY	4" WELDING MALE PART RJT 316	316L STAINLESS STEEL	

WELDING PROCEDURES



SEAM WELDING PROCEDURE NUMBER - BEL SS 001 (A)
DOUBLE OPERATOR DIG WELDING - BEL SS 003 (A)
MANUAL METAL ARC WELDING PROCEDURE NUMBER - BEL SS 002 (A)

1	DRAWING UPDATED TO 14 M STRAIGHT SECTION	AS	DS	03/12/2024
0	DRAWING ISSUED TO CUSTOMER / APPROVAL	AS	DS	14/10/24
ISSUE NO :	MODIFICATION	DRAWN	CHK'D	DATE

TITLE : 3 X 160,000 LTR RAW MILK SILOS
PROJECT NUMBER : 12659-61
CUSTOMER : LANCASHIRE FARM DAIRY
COMPLETION DATE : T.B.C

DRAWN : AS	SCALE : NTS		FOR REVIEW IN 6 WEEKS STEP 1 SINCE 15.08
CHECKED : DS	DATE : 14/10/24		
SHEET NO : 1	JOB NO : 12659-61		