



Region 6 - Enforcement & Compliance Assurance Division
INSPECTION REPORT

Inspection Date(s):	09/24-26/2024 with this portion of the inspection occurring on 09/25/2024	
Media Program:	Water	
Regulatory Program(s)	NPDES Industrial	
Company Name:	W.H.B. Cattle, LP	
Facility Name:	Braum's Dairy	
Facility Physical Location:	491 County Street 2880 (35.32113, -97.86462)	
(city, state, zip code)	Tuttle, OK 73089	
Mailing address:	P.O. Box 725	
(city, state, zip code)	Tuttle, OK 73089	
County/Parish:	Grady	
Facility Phone Number		
Facility Contact:	Brian Warren	Operations Manager
	brian.warren@braums.com	
FRS Number:	110000709993	
Identification/Permit Number:	OKG010029	
Media Identifier Number:		
NAICS:	311520/311812	
SIC:	2024/2051/2052	
Personnel participating in inspection:		
Brian Warren	Braum's	Operations Manager
Drew Braum, Jr.	Braum's	Owner/Family
Jay Lowe	Braum's	Project Manager
Dakota Turpin	ODAFF	Inspector
Ada Pfeiffer	ODAFF	Inspector Supervisor
Juan Ibarra	EPA	Inspector
Lucas Bomar	EPA	Inspector
Carl Wills	EPA	Inspector
EPA Lead Inspector		11/22/2024
Signature/Date	Carl Wills	Date
Supervisor		
Signature/Date	Anthony Loston	Date

Section I – INTRODUCTION**PURPOSE OF THE INSPECTION**

EPA Region 6 inspectors Juan Ibarra, Lucas Bomar and Carl Wills arrived at Braum's Dairy at 0945 on 09/24/2024, for an announced 3-day inspection. Juan called Mr. Brian Warren (Braum's Dairy Operations Manager) the day prior to the inspection to ensure that he would be present during the inspection. We were accompanied by the Oklahoma Department of Agriculture, Food, and Forestry (ODAFF) inspector supervisors Keith Smith and Ada Pfeiffer, and inspector Dakota Turpin. We met with Brian Warren at the Opening Conference. Juan and I presented our credentials to Mr. Warren and informed him that this was an EPA inspection to evaluate the facility's compliance with their CAFO License (No. 1396-000) and the Concentrated Animal Feeding Operations (CAFO) requirements as found in the Clean Water Act (CWA) and the Oklahoma CAFO Act. We also informed him that we would also be assessing the food processing plant's wastewater management systems on 09/25/2024. The scope of the inspection was a full compliance evaluation and included an evaluation of the facility's compliance with their nutrient management plan (NMP).

On the second day of the inspection, I lead the inspection of the bakery and dairy food processing plant wastewater systems, which all the State (except for Keith Smith) and EPA inspection staff attended. The facility has three individuals with current Water Operator Licenses for the State of Oklahoma (see appendix 4).

Biosecurity protocols were reviewed with the ODAFF State Veterinarian (Dr. Alicia Gorczyca-Southerland) prior to the inspection and were strictly followed. These procedures included spraying the wheels of the GSA vehicle with Virkon S and Synergy disinfectant upon arrival at the dairy on each day of the inspection, along with the wheels of the trailer and Kawasaki four wheeled vehicle, which was used to help navigate the site. We wore disposable overboots on all three days of the inspection, clean clothes, and left the GSA vehicle at the office parking lot during the day while the inspection was being conducted.

FACILITY DESCRIPTION**License and General Operation:**

The annual ODAFF CAFO License (No. 1396-000) was reissued to Braum's Dairy on 5/15/2024 and it expires on 6/30/2025. The dairy is permitted for a maximum of 13,000 milking cows, but currently has about 10,684 milking cows that are milked twice per day, 903 dry cows and 306 heifers. Most on-site heifers and dry cows are kept on about 3,000 acres of pasture, away from the production area while 6-month-old heifers are sent out-of-state to Kansas. Young calves are

kept in calf hutches on-property. To minimize the impact that calf hutches could create, the calves are moved one single location space to the northeast or one single space to the southwest. When the calves are removed (after approximately 80 days, once they are weaned) and the calf hutch is moved, the pen area is raked-out of solids and rototilled. Then the new baby calves are placed on the new ground.

The Ice Cream Plant was constructed on the Braum's property in Tuttle, OK and started operations in 1987. In 2008, Braum's moved their bakery from Oklahoma City to the Tuttle property and started operations. The bakery is located adjacent to the milk plant (see Appendix 3). The industrial wastewater generated from cleaning and washing of the bakery and creamery equipment is piped to their CAFO lagoon and later land applied.

Dairy Lagoon Wastewater Commingling:

Braum's uses the dairy lagoon for two different operational purposes. The single lagoon receives both dairy production wastewater from the CAFO operation, and industrial process wastewater from the bakery and dairy food processing plant that is co-located with the dairy. The average amount of industrial process wastewater going to the CAFO lagoon from June 1, 2024, through September 25, 2024, (a period of almost four months) was 11.4% (see Appendix 2). This percentage of commingled wastewater flow is approximately the same as the month of April 2024 which was 11.77% (see the July 9-10, 2024, EPA inspection report). EPA and ODAFF are currently discussing the joint use of the lagoon and issues related to permitting and operation of the industrial wastewater systems.

The volume of water being used for cleaning in the bakery plant (which is primarily a dry process) is approximately 5%, while the balance of 95% is from the dairy food processing plant.

Section II – OBSERVATIONS**Dairy Lagoon Wastewater Commingling with the Food Production Industrial Wastewater:**

The single CAFO lagoon receives both dairy production and industrial process wastewater from both the bakery and dairy food processing plants (see Appendix 2), which are co-located with the dairy. The average amount of industrial process wastewater going to the CAFO lagoon from June 1, 2024, through September 25, 2024, (a period of almost four months) was 11.4%. Food grade cleaning products in 55-gallon plastic drums were either stored on top of spill containment pallets or within curbed areas with drains, prior to use. EPA and ODAFF are currently discussing the joint use of the lagoon and issues related to permitting and operation of the industrial wastewater systems.

From 6/1/2024, through 9/25/2024, for the 107 days of recorded discharge, the total CAFO WW flow to the lagoon was 234,974,410 gallons. The average daily CAFO WW discharge over this period was 2,196,022.5 gpd. During this same period, the Industrial Food Processing plant wastewater contribution totaled 30,262,586 gallons, or about 282,827.9 gpd.

Section III – AREAS OF CONCERN

- 1) The single lagoon receives commingled dairy production wastewater from the CAFO operation, and industrial process wastewater from the bakery and dairy processing plant that is co-located with the dairy. Per the ODAFF CAFO Act Section 20:50 Wastewater Retention Structures Part (D) "All substances entering the retention structures shall be composed entirely of wastewaters from the proper operation and maintenance of an animal feeding operation and the runoff from the animal feeding operation area. The disposal of any materials, other than substances associated with proper operation and maintenance of the facility into the containment structures, including but not limited to human waste, is prohibited."

Closing Conference:

EPA Region 6 and ODAFF inspectors (listed above in Purpose of the Inspection) conducted a closing conference at Braum's Dairy at 1313 on 09/26/2024, with Mr. Drew Braum, Jr/Owner, Mr. Jay Lowe/Braum's Project Manager and Mr. Brian Warren. During the closing conference, EPA and ODAFF reviewed the above listed Areas of Concern.

Section IV – FOLLOW UP

This follow-up inspection allowed for an evaluation of the processes occurring within the Bakery and Ice Cream Plants.

- 1) The Agency will be working with ODAFF and possibly ODEQ to determine next steps regarding the wastestream from the food processing plant.
- 2) Additionally, we will be looking at the volumes of wastewater to determine if the lagoon has capacity for this combined wastestream, which assumes that the facility will be allowed to continue the practice of comingling these wastestream.

Section V – LIST OF APPENDICES

Appendix 1 – Photolog: 7 photos taken on September 25, 2024

Appendix 2 – Table with Wastewater Transfer Events (06/01/2024 thru 09/25/2024, 5-pages)

Appendix 3 – Aerial Photograph Showing the Bakery and Dairy Food Plants

Appendix 4 – Water Operator Licenses

Appendix 1

Photograph Log



UNITED STATES ENVIRONMENTAL PROTECTION AGENCY

Photograph Log

Photo No. 1

Location: Braum's Dairy		
City: Tuttle	County: Grady	State: Oklahoma



Photo File Name: IMG_5261.JPG

Date of Photo: 09/25/2024

Time of Photo: 1221

GPS Lat/Long: 35.334367, -97.863013

Photographer: Carl Wills

Description: This is the lift station for all water leaving the bakery and ice cream plants. This lift station transfers the water to another lift station approximately 900-feet to the west. View is to the northwest.



UNITED STATES ENVIRONMENTAL PROTECTION AGENCY

Photograph Log

Photo No. 2

Location: Braum's Dairy		
City: Tuttle	County: Grady	State: Oklahoma



Photo File Name: IMG_5262.JPG

Date of Photo: 09/25/2024

Time of Photo: 1235

GPS Lat/Long: 35.334678, -97.866015

Photographer: Carl Wills

Description: A grab sample was collected from the inflow pipe to evaluate the pH of the water from the two plants. The pH value determined from the colorimetric strip indicated a value of 6. View is to the southwest.



Photograph Log

Photo No. 3

Location: Braum's Dairy		
City: Tuttle	County: Grady	State: Oklahoma



Photo File Name: IMG_5263.JPG

Date of Photo: 09/25/2024

Time of Photo: 1236

GPS Lat/Long: 35.334645, -97.865995

Photographer: Carl Wills

Description: Large trough approximately 900-feet west from first lift station. This trough has two pumps at the west end to pump the water to three screens and then flows via gravity into the lagoon. Mounted above the pumps is a camera, which allows all with access to view the water level in the trough if the high-level alarm is tripped. Additionally, to the right (north) of the trough is a concrete emergency containment area with stem walls on three sides to contain any overflow. View is to the west-northwest.



UNITED STATES ENVIRONMENTAL PROTECTION AGENCY

Photograph Log

Photo No. 4

Location: Braum's Dairy		
City: Tuttle	County: Grady	State: Oklahoma



Photo File Name: IMG_5264.JPG

Date of Photo: 09/25/2024

Time of Photo: 1251

GPS Lat/Long: 35.353912, -97.873753

Photographer: Carl Wills

Description: Three screens are used to remove any solids prior to flowing into the lagoon. Only one screen is used at a time. View is to the west-northwest.



UNITED STATES ENVIRONMENTAL PROTECTION AGENCY

Photograph Log

Photo No. 5

Location: Braum's Dairy		
City: Tuttle	County: Grady	State: Oklahoma



Photo File Name: IMG_5265.JPG

Date of Photo: 09/25/2024

Time of Photo: 1252

GPS Lat/Long: 35.353939, -97.873868

Photographer: Carl Wills

Description: Pictured is the inflow from the plants and the dairy along with the northern levee of the lagoon. The inflow comes in via the concrete channel on the right. The view is to the northwest.



UNITED STATES ENVIRONMENTAL PROTECTION AGENCY

Photograph Log

Photo No. 6

Location: Braum's Dairy		
City: Tuttle	County: Grady	State: Oklahoma



Photo File Name: IMG_5266.JPG

Date of Photo: 09/25/2024

Time of Photo: 1252

GPS Lat/Long: 35.353939, -97.873868

Photographer: Carl Wills

Description: Pictured is the southern levee of the lagoon showing adequate freeboard. The view is to the southwest.



UNITED STATES ENVIRONMENTAL PROTECTION AGENCY

Photograph Log

Photo No. 7

Location: Braum's Dairy		
City: Tuttle	County: Grady	State: Oklahoma



Photo File Name: IMG_5268.JPG

Date of Photo: 09/25/2024

Time of Photo: 1254

GPS Lat/Long: 35.354003, -97.873822

Photographer: Carl Wills

Description: Pictured is the flowmeter located prior to the diverter for the three screens see Photograph 4. The view is to the south.

Appendix 2

Wastewater Transfer Events



Waste Water Transfer Events

Data from 06/01/2024 00:00:00 to 09/25/2024 00:00:00

Event Date	FT10000 Farm Discharge	FT10005 Mfg Discharge	Lagoon Total
6/1/2024 11:59:44 PM	2,012,794	214,680	2,232,474
6/2/2024 11:59:44 PM	2,103,361	325,603	2,428,964
6/3/2024 11:59:44 PM	2,206,044	496,184	2,702,228
6/4/2024 11:59:44 PM	2,174,631	449,590	2,624,221
6/5/2024 11:59:44 PM	1,922,274	306,716	2,228,990
6/6/2024 11:59:44 PM	2,004,289	365,911	2,370,200
6/7/2024 11:59:44 PM	1,286,510	319,956	1,606,466
6/8/2024 11:59:44 PM	2,028,414	209,079	2,237,493
6/9/2024 11:59:44 PM	1,962,758	221,070	2,183,828
6/10/2024 11:59:44 PM	1,911,160	259,988	2,171,148
6/11/2024 11:59:44 PM	1,918,466	248,504	2,166,970
6/12/2024 11:59:44 PM	1,916,471	282,035	2,198,506
6/13/2024 11:59:44 PM	1,962,218	295,078	2,257,296
6/14/2024 11:59:44 PM	2,044,980	202,423	2,247,403
6/15/2024 11:59:44 PM	2,199,616	196,841	2,396,457
6/16/2024 11:59:44 PM	2,169,234	273,557	2,442,791
6/17/2024 11:59:44 PM	2,107,818	319,796	2,427,614
6/18/2024 11:59:44 PM	2,023,431	320,796	2,344,227
6/19/2024 11:59:44 PM	2,186,727	320,261	2,506,988
6/20/2024 11:59:44 PM	2,143,548	261,077	2,404,625
6/21/2024 11:59:44 PM	2,223,642	290,510	2,514,152
6/22/2024 11:59:44 PM	2,278,229	212,625	2,490,854
6/24/2024 12:00:08 AM	2,299,488	252,227	2,551,714
6/25/2024 12:00:06 AM	2,264,386	253,188	2,517,575
6/26/2024 12:00:09 AM	2,237,858	248,020	2,485,878



Waste Water Transfer Events

Data from 06/01/2024 00:00:00 to 09/25/2024 00:00:00

6/27/2024 12:00:07 AM	2,247,614	267,160	2,514,774
6/28/2024 12:00:11 AM	2,251,782	316,680	2,568,462
6/29/2024 12:00:09 AM	2,314,002	299,729	2,613,730
6/30/2024 12:00:11 AM	2,551,898	188,013	2,739,912
7/1/2024 12:00:13 AM	2,563,787	230,025	2,793,812
7/2/2024 12:00:15 AM	2,487,355	315,942	2,803,298
7/3/2024 12:00:16 AM	2,368,705	308,284	2,676,988
7/4/2024 12:00:14 AM	2,332,779	258,014	2,590,793
7/5/2024 12:00:17 AM	2,152,709	291,721	2,444,430
7/7/2024 12:00:14 AM	2,495,466	401,982	2,897,448
7/8/2024 12:00:19 AM	2,445,075	527,439	2,972,514
7/9/2024 12:00:18 AM	2,150,707	276,012	2,426,720
7/10/2024 12:00:17 AM	2,112,666	245,686	2,358,352
7/11/2024 12:00:20 AM	2,137,466	286,914	2,424,380
7/12/2024 12:00:18 AM	2,104,603	285,436	2,390,039
7/13/2024 12:00:20 AM	2,181,318	303,823	2,485,140
7/14/2024 12:00:20 AM	2,149,968	230,438	2,380,407
7/15/2024 12:00:22 AM	2,196,902	200,885	2,397,788
7/16/2024 12:00:27 AM	2,163,829	290,411	2,454,240
7/17/2024 12:00:22 AM	2,203,012	274,654	2,477,666
7/18/2024 12:00:23 AM	2,131,982	261,673	2,393,654
7/19/2024 12:00:28 AM	2,021,630	251,063	2,272,693
7/20/2024 12:00:27 AM	2,070,695	296,991	2,367,686
7/21/2024 12:00:25 AM	2,194,572	286,452	2,481,024
7/22/2024 12:00:25 AM	2,147,009	219,428	2,366,438
7/23/2024 12:00:29 AM	1,985,656	219,009	2,204,664



Waste Water Transfer Events

Data from 06/01/2024 00:00:00 to 09/25/2024 00:00:00

7/24/2024 12:00:29 AM	2,097,884	239,768	2,337,653
7/25/2024 12:00:29 AM	2,072,632	343,880	2,416,513
7/26/2024 12:00:29 AM	2,117,671	283,876	2,401,547
7/27/2024 12:00:30 AM	2,096,660	263,616	2,360,276
7/28/2024 12:00:30 AM	2,200,554	225,962	2,426,516
7/29/2024 12:00:31 AM	2,149,496	199,892	2,349,389
7/30/2024 12:00:30 AM	2,194,978	254,245	2,449,222
7/31/2024 12:00:36 AM	2,187,796	340,489	2,528,285
8/1/2024 12:00:35 AM	2,187,627	353,120	2,540,747
8/2/2024 12:00:38 AM	2,114,104	333,472	2,447,576
8/3/2024 12:00:36 AM	2,229,242	329,752	2,558,994
8/4/2024 12:00:40 AM	2,416,449	187,223	2,603,672
8/5/2024 12:00:39 AM	2,287,499	214,360	2,501,860
8/6/2024 12:00:37 AM	2,307,148	283,002	2,590,151
8/7/2024 12:00:40 AM	2,426,242	307,120	2,733,362
8/8/2024 12:00:40 AM	2,422,212	286,741	2,708,953
8/9/2024 12:00:38 AM	2,444,554	340,024	2,784,578
8/10/2024 12:00:40 AM	2,129,231	262,090	2,391,321
8/11/2024 12:00:39 AM	2,128,355	215,218	2,343,573
8/12/2024 12:00:37 AM	2,407,858	602,316	3,010,174
8/13/2024 12:00:38 AM	2,297,200	324,736	2,621,935
8/14/2024 12:00:39 AM	2,229,288	295,386	2,524,675
8/15/2024 12:00:41 AM	1,759,011	258,381	2,017,392
8/16/2024 12:00:43 AM	788,482	417,380	1,205,862
8/17/2024 12:00:41 AM	1,302,785	272,636	1,575,421
8/18/2024 12:00:44 AM	2,313,092	238,610	2,551,702



Waste Water Transfer Events

Data from 06/01/2024 00:00:00 to 09/25/2024 00:00:00

8/27/2024 2:25:09 PM	2,540,600	193,971	2,734,571
8/28/2024 12:00:49 AM	2,517,782	189,655	2,707,437
8/29/2024 12:00:50 AM	2,563,573	295,716	2,859,289
8/30/2024 12:00:50 AM	2,610,707	291,165	2,901,872
8/31/2024 12:00:55 AM	2,585,020	275,747	2,860,766
9/1/2024 12:00:51 AM	2,599,263	226,468	2,825,730
9/2/2024 12:00:52 AM	2,607,264	214,143	2,821,407
9/3/2024 12:00:57 AM	2,518,416	249,332	2,767,749
9/4/2024 12:00:57 AM	2,497,748	289,186	2,786,934
9/5/2024 12:00:57 AM	2,538,902	253,286	2,792,188
9/6/2024 12:00:57 AM	2,346,551	313,337	2,659,888
9/7/2024 12:00:58 AM	2,389,486	241,221	2,630,707
9/8/2024 12:00:58 AM	2,302,226	262,688	2,564,914
9/9/2024 12:00:58 AM	2,271,056	208,156	2,479,212
9/10/2024 12:01:03 AM	2,273,530	267,838	2,541,367
9/11/2024 12:01:03 AM	2,246,253	388,652	2,634,905
9/12/2024 12:01:03 AM	2,334,422	267,477	2,601,899
9/13/2024 12:01:03 AM	2,384,264	301,325	2,685,589
9/14/2024 12:01:03 AM	2,336,228	290,231	2,626,459
9/15/2024 12:01:03 AM	1,329,408	198,359	1,527,768
9/16/2024 12:01:03 AM	1,317,923	221,308	1,539,231
9/17/2024 12:01:03 AM	2,299,586	280,179	2,579,765
9/18/2024 12:01:07 AM	2,430,403	347,435	2,777,838
9/19/2024 12:01:09 AM	2,334,488	256,784	2,591,272
9/20/2024 12:01:06 AM	2,620,951	221,475	2,842,426
9/21/2024 12:01:09 AM	2,665,948	255,947	2,921,895

**Waste Water Transfer Events**

Data from 06/01/2024 00:00:00 to 09/25/2024 00:00:00

9/22/2024 12:01:07 AM	2,607,965	229,082	2,837,048
9/23/2024 12:01:09 AM	2,446,929	452,797	2,899,726
9/24/2024 12:01:12 AM	1,326,584	318,164	1,644,748
9/25/2024 12:01:10 AM	2,066,350	308,588	2,374,938
Report Total	234,974,410	30,262,586	265,237,001

Appendix 3
Aerial Photograph
Bakery and Dairy Food Plants



Appendix 4

Water Operator Licenses

