



**COMMONWEALTH OF PENNSYLVANIA
DEPARTMENT OF ENVIRONMENTAL PROTECTION
AIR QUALITY PROGRAM**

STATE ONLY SYNTHETIC MINOR OPERATING PERMIT

Issue Date: August 17, 2023 Effective Date: October 16, 2023
Revision Date: October 16, 2023 Expiration Date: August 16, 2028
Revision Type: Modification

In accordance with the provisions of the Air Pollution Control Act, the Act of January 8, 1960, P.L. 2119, as amended, and 25 Pa. Code Chapter 127, the Owner, [and Operator if noted] (hereinafter referred to as permittee) identified below is authorized by the Department of Environmental Protection (Department) to operate the air emission source(s) more fully described in this permit. This Facility is subject to all terms and conditions specified in this permit. Nothing in this permit relieves the permittee from its obligations to comply with all applicable Federal, State and Local laws and regulations.

The regulatory or statutory authority for each permit condition is set forth in brackets. All terms and conditions in this permit are federally enforceable unless otherwise designated.

State Only Permit No: 23-00108

Synthetic Minor

Federal Tax Id - Plant Code: 26-0072915-1

Owner Information

Name: BARRY CALLEBAUT USA LLC
Mailing Address: 903 INDUSTRIAL HWY
EDDYSTONE, PA 19022-1531

Plant Information

Plant: BARRY CALLEBAUT USA LLC/EDDYSTONE
Location: 23 Delaware County 23821 Eddystone Borough
SIC Code: 2066 Manufacturing - Chocolate And Cocoa Products

Responsible Official

Name: GABRIEL AMORIM
Title: SITE MANAGER
Phone: (484) 490 - 2661 Email: gabriel_amorim@barry-callebaut.com

Permit Contact Person

Name: PHILIP SCARFO
Title: EHS MANAGER
Phone: (856) 676 - 1299 Email: philip_scarfo@barry-callebaut.com

[Signature] _____
JAMES D. REBARCHAK, SOUTHEAST REGION AIR PROGRAM MANAGER



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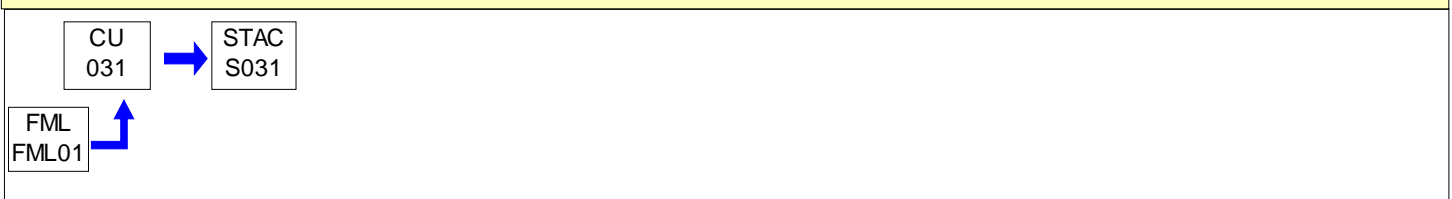
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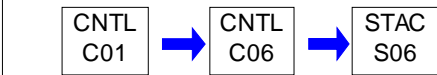
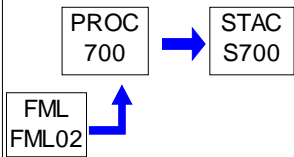
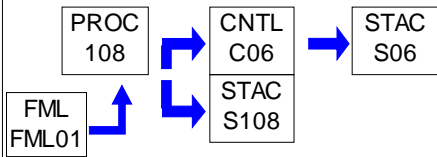
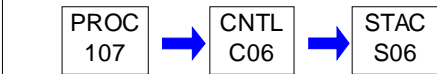
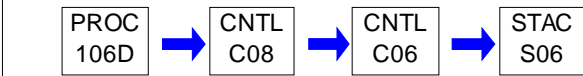
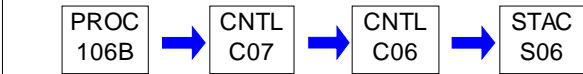
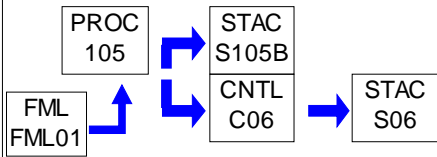
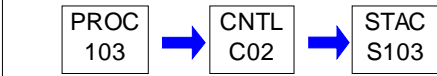
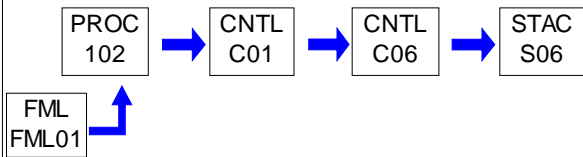
**SECTION A. Site Inventory List**

| Source ID | Source Name | Capacity/Throughput | Fuel/Material |
|-----------|--------------------------------------|---------------------|---------------------|
| 031 | BOILER (CBLE200-500) | 20.160 MMBTU/HR | |
| | | 19.570 MCF/HR | Natural Gas |
| 102 | PRE-ROASTING PROCESS | 4.290 MMBTU/HR | |
| | | 17,857.440 Lbs/HR | SHELLED COCOA BEANS |
| | | 4,290.000 CF/HR | Natural Gas |
| 103 | WINNOWER AIR CLASSIFICATION | 17,857.440 Lbs/HR | SHELLED COCOA BEANS |
| 104 | WINNOWER AIR CLASSIFICATION | 17,857.440 Lbs/HR | SHELLED COCOA BEANS |
| 105 | ROASTER #1 | 3.960 MMBTU/HR | |
| | | 5,511.560 Lbs/HR | COCOA BEAN NIBS |
| | | 3,960.000 CF/HR | Natural Gas |
| 106A | NIB GRINDING LINE #1 | 5,500.000 Lbs/HR | COCOA BEAN NIBS |
| 106B | NIB GRINDING LINE #2 | 5,500.000 Lbs/HR | COCOA BEANS NIB |
| 106D | NIB GRINDING LINE #3 | 6,614.000 Lbs/HR | COCOA BEAN NIBS |
| 107 | G.W. BARTH ALKALIZER | 5,511.560 Lbs/HR | COCOA BEAN NIBS |
| 108 | ROASTER #2 | 3.960 MMBTU/HR | |
| | | 9,479.880 Lbs/HR | COCOA BEAN NIBS |
| | | 3,882.000 CF/HR | Natural Gas |
| 700 | ONAN 250DFAC GENSET | 16.800 Gal/HR | Diesel Fuel |
| C01 | PRE-ROASTER CYCLONE | N/A | |
| C02 | ROTARY SCREEN CYCLONE | N/A | |
| C03 | WINNOWER AIR CLASSIFICATION CYCLONE | N/A | |
| C04 | NIB GRINDING #1 MIST ELIMINATOR | N/A | |
| C06 | ANGUIL REGENERATIVE THERMAL OXIDIZER | 5,882.000 CF/HR | Natural Gas |
| C07 | NIB GRINDING #2 MIST ELIMINATOR | N/A | |
| C08 | NIB GRINDING #3 MIST ELIMINATOR | N/A | |
| FML01 | NATURAL GAS | | |
| FML02 | DIESEL FUEL | | |
| S031 | BOILER (CBLE200-500) STACK | | |
| S06 | ANGUIL RTO STACK | | |
| S103 | ROTARY SCREEN STACK | | |
| S104 | WINNOWER AIR CLASSIFICATION STACK | | |
| S105B | ROASTER #1 (COMBUSTION) STACK | | |
| S108 | ROASTER #2 (COMBUSTION) STACK | | |
| S700 | ONAN 250DFAC GENSET STACK | | |

PERMIT MAPS

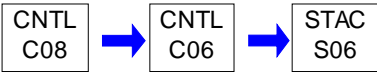
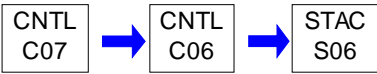
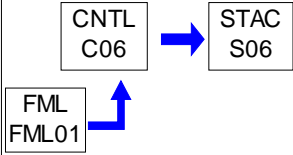
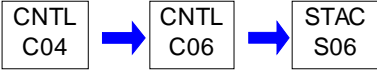
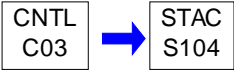


PERMIT MAPS





PERMIT MAPS



**SECTION B. General State Only Requirements****#001 [25 Pa. Code § 121.1]****Definitions.**

Words and terms that are not otherwise defined in this permit shall have the meanings set forth in Section 3 of the Air Pollution Control Act (35 P.S. § 4003) and in 25 Pa. Code § 121.1.

#002 [25 Pa. Code § 127.446]**Operating Permit Duration.**

- (a) This operating permit is issued for a fixed term of five (5) years and shall expire on the date specified on Page 1 of this permit.
- (b) The terms and conditions of the expired permit shall automatically continue pending issuance of a new operating permit, provided the permittee has submitted a timely and complete application and paid applicable fees required under 25 Pa. Code Chapter 127, Subchapter I and the Department is unable, through no fault of the permittee, to issue or deny a new permit before the expiration of the previous permit.

#003 [25 Pa. Code §§ 127.412, 127.413, 127.414, 127.446 & 127.703(b)]**Permit Renewal.**

- (a) The permittee shall submit a timely and complete application for renewal of the operating permit to the appropriate Regional Air Program Manager. The application for renewal of the operating permit shall be submitted at least six (6) months and not more than 18 months before the expiration date of this permit.
- (b) The application for permit renewal shall include the current permit number, a description of any permit revisions that occurred during the permit term, and any applicable requirements that were promulgated and not incorporated into the permit during the permit term. An application is complete if it contains sufficient information to begin processing the application, has the applicable sections completed and has been signed by a responsible official.
- (c) The permittee shall submit with the renewal application a fee for the processing of the application as specified in 25 Pa. Code § 127.703(b). The fees shall be made payable to "The Commonwealth of Pennsylvania Clean Air Fund" and submitted with the fee form to the respective regional office.
- (d) The renewal application shall also include submission of proof that the local municipality and county, in which the facility is located, have been notified in accordance with 25 Pa. Code § 127.413.
- (e) The application for renewal of the operating permit shall also include submission of supplemental compliance review forms in accordance with the requirements of 25 Pa. Code § 127.412(b) and § 127.412(j).
- (f) The permittee, upon becoming aware that any relevant facts were omitted or incorrect information was submitted in the permit application, shall promptly submit such supplementary facts or corrected information as necessary to address any requirements that become applicable to the source after the permittee submits a complete application, but prior to the date the Department takes action on the permit application.

#004 [25 Pa. Code § 127.703]**Operating Permit Fees under Subchapter I.**

- (a) The permittee shall pay the annual operating permit maintenance fee according to the following fee schedule in either paragraph (1) or (2) in accordance with 25 Pa. Code § 127.703(d) on or before December 31 of each year for the next calendar year.
- (1) For a synthetic minor facility, a fee equal to:
- (i) Four thousand dollars (\$4,000) for calendar years 2021—2025.
 - (ii) Five thousand dollars (\$5,000) for calendar years 2026—2030.
 - (iii) Six thousand three hundred dollars (\$6,300) for the calendar years beginning with 2031.

**SECTION B. General State Only Requirements**

(2) For a facility that is not a synthetic minor, a fee equal to:

- (i) Two thousand dollars (\$2,000) for calendar years 2021—2025.
- (ii) Two thousand five hundred dollars (\$2,500) for calendar years 2026—2030.
- (iii) Three thousand one hundred dollars (\$3,100) for the calendar years beginning with 2031.

(b) The applicable fees shall be made payable to "The Commonwealth of Pennsylvania Clean Air Fund" with the permit number clearly indicated and submitted to the respective regional office.

#005 [25 Pa. Code §§ 127.450 (a)(4) and 127.464]**Transfer of Operating Permits.**

(a) This operating permit may not be transferred to another person, except in cases of transfer-of-ownership that are documented and approved by the Department.

(b) In accordance with 25 Pa. Code § 127.450(a)(4), a change in ownership of the source shall be treated as an administrative amendment if the Department determines that no other change in the permit is required and a written agreement has been submitted to the Department identifying the specific date of the transfer of permit responsibility, coverage and liability between the current and the new permittee and a compliance review form has been submitted to, and the permit transfer has been approved by, the Department.

(c) This operating permit is valid only for those specific sources and the specific source locations described in this permit.

#006 [25 Pa. Code § 127.441 and 35 P.S. § 4008]**Inspection and Entry.**

(a) Upon presentation of credentials and other documents as may be required by law, the permittee shall allow the Department or authorized representatives of the Department to perform the following:

(1) Enter at reasonable times upon the permittee's premises where a source is located or emissions related activity is conducted, or where records are kept under the conditions of this permit;

(2) Have access to and copy, at reasonable times, any records that are kept under the conditions of this permit;

(3) Inspect at reasonable times, any facilities, equipment including monitoring and air pollution control equipment, practices, or operations regulated or required under this permit;

(4) Sample or monitor, at reasonable times, any substances or parameters, for the purpose of assuring compliance with the permit or applicable requirements as authorized by the Clean Air Act, the Air Pollution Control Act, or the regulations promulgated under the Acts.

(b) Pursuant to 35 P.S. § 4008, no person shall hinder, obstruct, prevent or interfere with the Department or its personnel in the performance of any duty authorized under the Air Pollution Control Act or regulations adopted thereunder including denying the Department access to a source at this facility. Refusal of entry or access may constitute grounds for permit revocation and assessment of criminal and/or civil penalties.

(c) Nothing in this permit condition shall limit the ability of the EPA to inspect or enter the premises of the permittee in accordance with Section 114 or other applicable provisions of the Clean Air Act.

#007 [25 Pa. Code §§ 127.441 & 127.444]**Compliance Requirements.**

(a) The permittee shall comply with the conditions of this operating permit. Noncompliance with this permit constitutes a violation of the Clean Air Act and the Air Pollution Control Act and is grounds for one or more of the following:

**SECTION B. General State Only Requirements**

- (1) Enforcement action
- (2) Permit termination, revocation and reissuance or modification
- (3) Denial of a permit renewal application

(b) A person may not cause or permit the operation of a source which is subject to 25 Pa. Code Article III unless the source(s) and air cleaning devices identified in the application for the plan approval and operating permit and the plan approval issued for the source is operated and maintained in accordance with specifications in the applications and the conditions in the plan approval and operating permit issued by the Department. A person may not cause or permit the operation of an air contamination source subject to 25 Pa. Code Chapter 127 in a manner inconsistent with good operating practices.

(c) For purposes of Sub-condition (b) of this permit condition, the specifications in applications for plan approvals and operating permits are the physical configurations and engineering design details which the Department determines are essential for the permittee's compliance with the applicable requirements in this State-Only permit. Nothing in this sub-condition shall be construed to create an independent affirmative duty upon the permittee to obtain a predetermination from the Department for physical configuration or engineering design detail changes made by the permittee.

#008 [25 Pa. Code § 127.441]**Need to Halt or Reduce Activity Not a Defense.**

It shall not be a defense for the permittee in an enforcement action that it was necessary to halt or reduce the permitted activity in order to maintain compliance with the conditions of this permit.

#009 [25 Pa. Code §§ 127.442(a) & 127.461]**Duty to Provide Information.**

(a) The permittee shall submit reports to the Department containing information the Department may prescribe relative to the operation and maintenance of each source at the facility.

(b) The permittee shall furnish to the Department, in writing, information that the Department may request to determine whether cause exists for modifying, revoking and reissuing, or terminating this permit, or to determine compliance with the permit. Upon request, the permittee shall also furnish to the Department copies of records that the permittee is required to maintain in accordance with this permit.

#010 [25 Pa. Code § 127.461]**Revising an Operating Permit for Cause.**

This operating permit may be terminated, modified, suspended or revoked and reissued if one or more of the following applies:

- (1) The permittee constructs or operates the source subject to the operating permit so that it is in violation of the Air Pollution Control Act, the Clean Air Act, the regulations thereunder, a plan approval, a permit or in a manner that causes air pollution.
- (2) The permittee fails to properly or adequately maintain or repair an air pollution control device or equipment attached to or otherwise made a part of the source.
- (3) The permittee has failed to submit a report required by the operating permit or an applicable regulation.
- (4) The EPA determines that the permit is not in compliance with the Clean Air Act or the regulations thereunder.

#011 [25 Pa. Code §§ 127.450, 127.462, 127.465 & 127.703]**Operating Permit Modifications**

(a) The permittee is authorized to make administrative amendments, minor operating permit modifications and significant operating permit modifications, under this permit, as outlined below:

**SECTION B. General State Only Requirements**

(b) Administrative Amendments. The permittee shall submit the application for administrative operating permit amendments (as defined in 25 Pa. Code § 127.450(a)), according to procedures specified in § 127.450 unless precluded by the Clean Air Act or its regulations.

(c) Minor Operating Permit Modifications. The permittee shall submit the application for minor operating permit modifications (as defined 25 Pa. Code § 121.1) in accordance with 25 Pa. Code § 127.462.

(d) Significant Operating Permit Modifications. The permittee shall submit the application for significant operating permit modifications in accordance with 25 Pa. Code § 127.465.

(e) The applicable fees shall be made payable to "The Commonwealth of Pennsylvania Clean Air Fund" with the permit number clearly indicated and submitted to the respective regional office.

#012 [25 Pa. Code § 127.441]**Severability Clause.**

The provisions of this permit are severable, and if any provision of this permit is determined by a court of competent jurisdiction to be invalid or unenforceable, such a determination will not affect the remaining provisions of this permit.

#013 [25 Pa. Code § 127.449]**De Minimis Emission Increases.**

(a) This permit authorizes de minimis emission increases in accordance with 25 Pa. Code § 127.449 so long as the permittee provides the Department with seven (7) days prior written notice before commencing any de minimis emissions increase. The written notice shall:

(1) Identify and describe the pollutants that will be emitted as a result of the de minimis emissions increase.

(2) Provide emission rates expressed in tons per year and in terms necessary to establish compliance consistent with any applicable requirement.

(b) The Department may disapprove or condition de minimis emission increases at any time.

(c) Except as provided below in (d), the permittee is authorized to make de minimis emission increases (expressed in tons per year) up to the following amounts without the need for a plan approval or prior issuance of a permit modification:

(1) Four tons of carbon monoxide from a single source during the term of the permit and 20 tons of carbon monoxide at the facility during the term of the permit.

(2) One ton of NO_x from a single source during the term of the permit and 5 tons of NO_x at the facility during the term of the permit.

(3) One and six-tenths tons of the oxides of sulfur from a single source during the term of the permit and 8.0 tons of oxides of sulfur at the facility during the term of the permit.

(4) Six-tenths of a ton of PM₁₀ from a single source during the term of the permit and 3.0 tons of PM₁₀ at the facility during the term of the permit. This shall include emissions of a pollutant regulated under Section 112 of the Clean Air Act unless precluded by the Clean Air Act, the regulations thereunder or 25 Pa. Code Article III.

(5) One ton of VOCs from a single source during the term of the permit and 5.0 tons of VOCs at the facility during the term of the permit. This shall include emissions of a pollutant regulated under Section 112 of the Clean Air Act unless precluded by the Clean Air Act, the regulations thereunder or 25 Pa. Code Article III.

(6) Other sources and classes of sources determined to be of minor significance by the Department.

(d) In accordance with § 127.14, the permittee is authorized to install the following minor sources without the need for a plan approval or permit modification:

**SECTION B. General State Only Requirements**

- (1) Air conditioning or ventilation systems not designed to remove pollutants generated or released from other sources.
 - (2) Combustion units rated at 2,500,000 or less Btu per hour of heat input.
 - (3) Combustion units with a rated capacity of less than 10,000,000 Btu per hour heat input fueled by natural gas supplied by a public utility or by commercial fuel oils which are No. 2 or lighter, viscosity less than or equal to 5.82 c St, and which meet the sulfur content requirements of 25 Pa. Code §123.22 (relating to combustion units). For purposes of this permit, commercial fuel oil shall be virgin oil which has no reprocessed, recycled or waste material added.
 - (4) Space heaters which heat by direct heat transfer.
 - (5) Laboratory equipment used exclusively for chemical or physical analysis.
 - (6) Other sources and classes of sources determined to be of minor significance by the Department.
- (e) This permit does not authorize de minimis emission increases if the emissions increase would cause one or more of the following:
- (1) Increase the emissions of a pollutant regulated under Section 112 of the Clean Air Act except as authorized in Subparagraphs (c)(4) and (5) of this permit condition.
 - (2) Subject the facility to the prevention of significant deterioration requirements in 25 Pa. Code Chapter 127, Subchapter D and/or the new source review requirements in Subchapter E.
 - (3) Violate any applicable requirement of this permit, the Air Pollution Control Act, the Clean Air Act, or the regulations promulgated under either of the acts.
- (f) Emissions authorized under this permit condition shall be included in the monitoring, recordkeeping and reporting requirements of this permit.
- (g) Except for de minimis emission increases, installation of minor sources made pursuant to this permit condition and Plan Approval Exemptions under 25 Pa. Code § 127.14 (relating to exemptions), the permittee is prohibited from making changes or engaging in activities that are not specifically authorized under this permit without first applying for a plan approval. In accordance with § 127.14(b), a plan approval is not required for the construction, modification, reactivation, or installation of the sources creating the de minimis emissions increase.
- (h) The permittee may not meet de minimis emission threshold levels by offsetting emission increases or decreases at the same source.

#014 [25 Pa. Code § 127.3]**Operational Flexibility.**

The permittee is authorized to make changes within the facility in accordance with the regulatory provisions outlined in 25 Pa. Code § 127.3 (relating to operational flexibility) to implement the operational flexibility requirements provisions authorized under Section 6.1(i) of the Air Pollution Control Act and the operational flexibility terms and conditions of this permit. The provisions in 25 Pa. Code Chapter 127 which implement the operational flexibility requirements include the following:

- (1) Section 127.14 (relating to exemptions)
- (2) Section 127.447 (relating to alternative operating scenarios)
- (3) Section 127.448 (relating to emissions trading at facilities with Federally enforceable emissions caps)
- (4) Section 127.449 (relating to de minimis emission increases)
- (5) Section 127.450 (relating to administrative operating permit amendments)

**SECTION B. General State Only Requirements**

(6) Section 127.462 (relating to minor operating permit modifications)

(7) Subchapter H (relating to general plan approvals and general operating permits)

#015 [25 Pa. Code § 127.11]**Reactivation**

(a) The permittee may not reactivate a source that has been out of operation or production for at least one year unless the reactivation is conducted in accordance with a plan approval granted by the Department or in accordance with reactivation and maintenance plans developed and approved by the Department in accordance with 25 Pa. Code § 127.11a(a).

(b) A source which has been out of operation or production for more than five (5) years but less than 10 years may be reactivated and will not be considered a new source if the permittee satisfies the conditions specified in 25 Pa. Code § 127.11a(b).

#016 [25 Pa. Code § 127.36]**Health Risk-based Emission Standards and Operating Practice Requirements.**

(a) When needed to protect public health, welfare and the environment from emissions of hazardous air pollutants from new and existing sources, the permittee shall comply with the health risk-based emission standards or operating practice requirements imposed by the Department, except as precluded by §§ 6.6(d)(2) and (3) of the Air Pollution Control Act [35 P.S. § 4006.6(d)(2) and (3)].

(b) A person challenging a performance or emission standard established by the Department has the burden to demonstrate that performance or emission standard does not meet the requirements of Section 112 of the Clean Air Act.

#017 [25 Pa. Code § 121.9]**Circumvention.**

No person may permit the use of a device, stack height which exceeds good engineering practice stack height, dispersion technique or other technique which, without resulting in reduction of the total amount of air contaminants emitted, conceals or dilutes an emission of air contaminants which would otherwise be in violation of 25 Pa. Code Article III, except that with prior approval of the Department, the device or technique may be used for control of malodors.

#018 [25 Pa. Code §§ 127.402(d) & 127.442]**Reporting Requirements.**

(a) The permittee shall comply with the applicable reporting requirements of the Clean Air Act, the regulations thereunder, the Air Pollution Control Act and 25 Pa. Code Article III including Chapters 127, 135 and 139.

(b) The permittee shall submit reports to the Department containing information the Department may prescribe relative to the operation and maintenance of any air contamination source.

(c) Reports, test data, monitoring data, notifications and requests for renewal of the permit shall be submitted to the:

Regional Air Program Manager
PA Department of Environmental Protection
(At the address given in the permit transmittal letter, or otherwise notified)

(d) Any records or information including applications, forms, or reports submitted pursuant to this permit condition shall contain a certification by a responsible official as to truth, accuracy and completeness. The certifications submitted under this permit shall require a responsible official of the facility to certify that based on information and belief formed after reasonable inquiry, the statements and information in the documents are true, accurate and complete.

(e) Any records, reports or information submitted to the Department shall be available to the public except for such

**SECTION B. General State Only Requirements**

records, reports or information which meet the confidentiality requirements of § 4013.2 of the Air Pollution Control Act and §§ 112(d) and 114(c) of the Clean Air Act. The permittee may not request a claim of confidentiality for any emissions data generated for the facility.

#019 [25 Pa. Code §§ 127.441(c) & 135.5]**Sampling, Testing and Monitoring Procedures.**

(a) The permittee shall comply with the monitoring, recordkeeping or reporting requirements of 25 Pa. Code Chapter 139 and the other applicable requirements of 25 Pa. Code Article III and additional requirements related to monitoring, reporting and recordkeeping required by the Clean Air Act and the regulations thereunder including the Compliance Assurance Monitoring requirements of 40 CFR Part 64, where applicable.

(b) Unless alternative methodology is required by the Clean Air Act and regulations adopted thereunder, sampling, testing and monitoring required by or used by the permittee to demonstrate compliance with any applicable regulation or permit condition shall be conducted in accordance with the requirements of 25 Pa. Code Chapter 139.

#020 [25 Pa. Code §§ 127.441(c) and 135.5]**Recordkeeping.**

(a) The permittee shall maintain and make available, upon request by the Department, the following records of monitored information:

- (1) The date, place (as defined in the permit) and time of sampling or measurements.
- (2) The dates the analyses were performed.
- (3) The company or entity that performed the analyses.
- (4) The analytical techniques or methods used.
- (5) The results of the analyses.
- (6) The operating conditions as existing at the time of sampling or measurement.

(b) The permittee shall retain records of any required monitoring data and supporting information for at least five (5) years from the date of the monitoring, sample, measurement, report or application. Supporting information includes the calibration data and maintenance records and original strip-chart recordings for continuous monitoring instrumentation, and copies of reports required by the permit.

(c) The permittee shall maintain and make available to the Department upon request, records including computerized records that may be necessary to comply with the reporting, recordkeeping and emission statement requirements in 25 Pa. Code Chapter 135 (relating to reporting of sources). In accordance with 25 Pa. Code Chapter 135, § 135.5, such records may include records of production, fuel usage, maintenance of production or pollution control equipment or other information determined by the Department to be necessary for identification and quantification of potential and actual air contaminant emissions.

#021 [25 Pa. Code § 127.441(a)]**Property Rights.**

This permit does not convey any property rights of any sort, or any exclusive privileges.

#022 [25 Pa. Code § 127.447]**Alternative Operating Scenarios.**

The permittee is authorized to make changes at the facility to implement alternative operating scenarios identified in this permit in accordance with 25 Pa. Code § 127.447.

**SECTION B. General State Only Requirements****#023 [25 Pa. Code §135.3]****Reporting**

(a) If the facility is a Synthetic Minor Facility, the permittee shall submit by March 1 of each year an annual emissions report for the preceding calendar year. The report shall include information for all active previously reported sources, new sources which were first operated during the preceding calendar year, and sources modified during the same period which were not previously reported. All air emissions from the facility should be estimated and reported.

(b) A source owner or operator of a Synthetic Minor Facility may request an extension of time from the Department for the filing of an annual emissions report, and the Department may grant the extension for reasonable cause.

#024 [25 Pa. Code §135.4]**Report Format**

If applicable, the emissions reports shall contain sufficient information to enable the Department to complete its emission inventory. Emissions reports shall be made by the source owner or operator in a format specified by the Department.

**SECTION C. Site Level Requirements****I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §121.7]****Prohibition of air pollution.**

No person may permit air pollution as that term is defined in the Air Pollution Control Act (35 P.S. Section 4003).

002 [25 Pa. Code §123.1]**Prohibition of certain fugitive emissions**

(a) No person may permit the emission into the outdoor atmosphere of a fugitive air contaminant from a source other than the following:

(1) Construction or demolition of buildings or structures.

(2) Grading, paving, and maintenance of roads and streets.

(3) Use of roads and streets. Emissions from material in or on trucks, railroad cars, and other vehicular equipment are not considered as emissions from use of roads and streets.

(4) Clearing of land.

(5) Stockpiling of materials.

(6) Open burning operations, as specified in 25 Pa. Code § 129.14.

(7) N/A

(8) N/A

(9) Sources and classes of sources, other than those identified in (1) - (8) of this condition, for which the operator has obtained a determination from the Department that fugitive emissions from the source, after appropriate controls, meet the following requirements:

(i) The emissions are of minor significance with respect to causing air pollution; and

(ii) The emissions are not preventing or interfering with the attainment or maintenance of any ambient air quality standard.

003 [25 Pa. Code §123.2]**Fugitive particulate matter**

A person may not permit fugitive particulate matter to be emitted into the outdoor atmosphere from a source specified in 25 Pa. Code § 123.1(a) (relating to prohibition of certain fugitive emissions) if such emissions are visible at the point the emissions pass outside the person's property.

004 [25 Pa. Code §123.31]**Limitations**

A person may not permit the emission into the outdoor atmosphere of any malodorous air contaminants from any source in such a manner that the malodors are detectable outside the property of the person on whose land the source is being operated.

005 [25 Pa. Code §123.42]**Exceptions**

The opacity limitations as per 25 Pa. Code § 123.41 shall not apply to a visible emission in any of the following instances:

(a) When the presence of uncombined water is the only reason for failure of the emission to meet the limitations.

(b) When the emission results from the operation of equipment used solely to train and test persons in observing the opacity of visible emissions.

(c) When the emission results from the sources specified in 25 Pa. Code § 123.1(a) (relating to prohibition of certain

**SECTION C. Site Level Requirements**

fugitive emissions).

006 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall not permit the emission into the outdoor atmosphere of visible air contaminants in such a manner that the opacity of the emission is either of the following:

- (a) Equal to or greater than 10% for a period or periods aggregating more than three minutes in any 1 hour.
- (b) Equal to or greater than 30% at any time.

[Compliance with this streamlined permit condition assures compliance with 25 Pa. Code § 123.41]

007 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall ensure that the total pollutant emissions from the facility shall not exceed the following limitations:

- (a) Nitrogen Oxides (NOx): 24.9 tons per year as a 12-month rolling sum.
- (b) Volatile Organic Compounds (VOC): 24.9 tons year as a 12-month rolling sum.
- (c) Particulate Matter <10 Microns (PM10): 100.0 tons per year as a 12-month rolling sum.
- (d) Particulate Matter <2.5 Microns (PM2.5): 100.0 tons per year as a 12-month rolling sum.

008 [25 Pa. Code §129.14]**Open burning operations**

No person may permit the open burning of material in the Southeast Air Basin, except when the open burning results from:

- (a) A fire set to prevent or abate a fire hazard, when approved by the Department and set by or under the supervision of a public officer.
- (b) Any fire set for the purpose of instructing personnel in fire fighting, when approved by the Department.
- (c) A fire set for the prevention and control of disease or pests, when approved by the Department.
- (d) A fire set in conjunction with the production of agricultural commodities in their unmanufactured state on the premises of the farm operation.
- (e) A fire set for the purpose of burning domestic refuse, when the fire is on the premises of a structure occupied solely as a dwelling by two families or less and when the refuse results from the normal occupancy of the structure.
- (f) A fire set solely for recreational or ceremonial purposes.
- (g) A fire set solely for cooking food.

II. TESTING REQUIREMENTS.**# 009 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a) If at any time the Department has cause to believe that air contaminant emissions from any source may be in excess of the limitations specified in this Permit, or established pursuant to, any applicable rule or regulation contained in 25 Pa. Code Article III, the permittee shall be required to conduct whatever tests are deemed necessary by the Department to determine the actual emission rate(s).

**SECTION C. Site Level Requirements**

(b) Such testing shall be conducted in accordance with the provisions of 25 Pa. Code Chapter 139, the most current version of the DEP Source Testing Manual, and the EPA Clean Air Act National Stack Testing Guidance, when applicable, and in accordance with any restrictions or limitations established by the Department at such time as it notifies the permittee that testing is required.

III. MONITORING REQUIREMENTS.**# 010 [25 Pa. Code §123.43]****Measuring techniques**

Visible emissions may be measured using either of the following:

- (a) A device approved by the Department and maintained to provide accurate opacity measurements; or
- (b) Observers trained and qualified to measure plume opacity with the naked eye or with the aid of any devices approved by the Department.

011 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall monitor the total NO_x, VOC, PM₁₀ and PM_{2.5} emissions from the facility on a monthly basis, and as a 12-month rolling sum.

012 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

- (a) The permittee shall monitor the facility, once per operating day, for the following:
 - (1) Odors which may be objectionable (as per 25 Pa. Code § 123.31).
 - (2) Visible emissions (as per 25 Pa. Code §§ 123.41 and 123.42).
 - (3) Fugitive particulate matter (as per 25 Pa. Code §§ 123.1 and 123.2).
- (b) Objectionable odors, fugitive particulate emissions, and visible emissions that are caused or may be caused by operations at the site shall:
 - (1) Be investigated.
 - (2) Be reported to the facility management, or individual(s) designated by the permittee.
 - (3) Have appropriate corrective action taken (for emissions that originate on-site).
 - (4) Be recorded in a permanent written log.
- (c) After six (6) months of daily monitoring, and upon the permittee's request, the Department will determine the feasibility of decreasing the monitoring frequency to weekly for the next six month period.
- (d) After six (6) months of weekly monitoring, and upon the permittee's request, the Department will determine the feasibility of decreasing the frequency of monitoring to monthly.
- (e) The Department reserves the right to change the above monitoring requirements at any time, based on but not limited to: the review of the compliance certification, complaints, monitoring results, and/or Department findings.

IV. RECORDKEEPING REQUIREMENTS.**# 013 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

- (a) The permittee shall calculate and maintain records of the pollutants emissions on a monthly basis and as a 12-month rolling sum, from each source at the facility, where the potential annual emissions of a pollutant is equal to or greater than 0.1 tons:
 - (1) Nitrogen Oxides (NO_x)
 - (2) Volatile Organic Compounds (VOCs)
 - (3) Total Particulate Matter (PM)
 - (4) Particulate Matter <10 Microns (PM₁₀)

**SECTION C. Site Level Requirements**

- (5) Particulate Matter <2.5 Microns (PM_{2.5})
- (6) Carbon Monoxide (CO)
- (7) Sulfur Oxides (SO_x)

(b) Recordkeeping of emissions shall be performed in such a way to show compliance to all emission restrictions contained herein this operating permit.

014 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall maintain a record of all monitoring of fugitive emissions, visible emissions and odors, including those that deviate from the conditions found in this permit. The record of deviations shall contain, at a minimum, the following items:

- (a) Date, time, and location of the incident(s).
- (b) The cause of the event.
- (c) The corrective action taken, if necessary, to abate the situation and prevent future occurrences.

015 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall maintain records of all the facility's increases of emissions from the following categories:

- (a) emissions increase of minor significance without notification to the Department.
- (b) de minimis increases with notification to the Department, via letter.
- (c) increases resulting from a Request for Determination (RFD) to the Department.
- (d) increases resulting from the issuance of a plan approval and subsequent operating permit.

V. REPORTING REQUIREMENTS.**# 016 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a) The permittee shall report malfunctions, emergencies or incidents of excess emissions to the Department at 484-250-5920. A malfunction is any sudden, infrequent, and not reasonably preventable failure of air pollution control equipment, process equipment, or a process to operate in a normal or usual manner. An emergency is any situation arising from sudden and reasonably unforeseeable events beyond the control of the owner or operator of a facility which requires immediate corrective action to restore normal operation and which causes the emission source to exceed emissions, due to unavoidable increases in emissions attributable to the situation. An emergency shall not include situations caused by improperly designed equipment, lack of preventive maintenance, careless or improper operation, or operator error.

(b) When the malfunction, emergency or incident of excess emissions poses an imminent danger to the public health, safety, welfare, or environment, it shall be reported to the Department and the County Emergency Management Agency by telephone within one (1) hour after the discovery of the malfunction, emergency or incident of excess emissions. The owner or operator shall submit a written or emailed report of instances of such malfunctions, emergencies or incidents of excess emissions to the Department within three (3) business days of the telephone report.

(c) The report shall describe the following:

- (1) Name, permit or authorization number, and location of the facility;
- (2) Nature and cause of the malfunction, emergency or incident;
- (3) Date and time when the malfunction, emergency or incident was first observed;
- (4) Expected duration of excess emissions;
- (5) Estimated rate of emissions; and
- (6) Corrective actions or preventative measures taken.

(d) Any malfunction, emergency or incident of excess emissions that is not subject to the notice requirements of paragraph (b) of this condition shall be reported to the Department by telephone within 24 hours (or by 4:00 PM of the next business day, whichever is later) of discovery and in writing or by e-mail within five (5) business days of discovery. The report shall contain the same information required by paragraph (c), and any permit specific malfunction reporting requirements.

**SECTION C. Site Level Requirements**

(e) During an emergency an owner or operator may continue to operate the source at their discretion provided they submit justification for continued operation of a source during the emergency and follow all the notification and reporting requirements in accordance with paragraphs (b)-(d), as applicable, including any permit specific malfunction reporting requirements.

(f) Reports regarding malfunctions, emergencies or incidents of excess emissions shall be submitted to the appropriate DEP Regional Office Air Program Manager.

(g) Any emissions resulted from malfunction or emergency are to be reported in the annual emissions inventory report, if the annual emissions inventory report is required by permit or authorization.

017 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

[Additional authority for this condition is also derived from 40 CFR Part 68.]

(a) If required by Section 112(r) of the Clean Air Act, the permittee shall develop and implement an accidental release program consistent with requirements of the Clean Air Act, 40 CFR Part 68 (relating to chemical accident prevention provisions) and the Federal Chemical Safety Information, Site Security and Fuels Regulatory Relief Act (P.L. 106-40).

(b) The permittee shall prepare and implement a Risk Management Plan (RMP) which meets the requirements of Section 112(r) of the Clean Air Act, 40 CFR Part 68 and the Federal Chemical Safety Information, Site Security and Fuels Regulatory Relief Act when a regulated substance listed in 40 CFR § 68.130 is present in a process in more than the threshold quantity at a facility. The permittee shall submit the RMP to the federal Environmental Protection Agency according to the following schedule and requirements:

(1) The permittee shall submit the first RMP to a central point specified by EPA no later than the latest of the following:

- (i) Three years after the date on which a regulated substance is first listed under 40 CFR § 68.130; or,
- (ii) The date on which a regulated substance is first present above a threshold quantity in a process.

(2) The permittee shall submit any additional relevant information requested by the Department or EPA concerning the RMP and shall make subsequent submissions of RMPs in accordance with 40 CFR § 68.190.

(3) The permittee shall certify that the RMP is accurate and complete in accordance with the requirements of 40 CFR Part 68, including a checklist addressing the required elements of a complete RMP.

(c) As used in this permit condition, the term "process" shall be as defined in 40 CFR § 68.3. The term "process" means any activity involving a regulated substance including any use, storage, manufacturing, handling, or on-site movement of such substances or any combination of these activities. For purposes of this definition, any group of vessels that are interconnected, or separate vessels that are located such that a regulated substance could be involved in a potential release, shall be considered a single process.

(d) If this facility is subject to 40 CFR Part 68, as part of the certification required under this permit, the permittee shall:

(1) Submit a compliance schedule for satisfying the requirements of 40 CFR Part 68 by the date specified in 40 CFR § 68.10(a); or,

(2) Certify that this facility is in compliance with all requirements of 40 CFR Part 68 including the registration and submission of the RMP.

(e) If this facility is subject to 40 CFR Part 68, the permittee shall maintain records supporting the implementation of an accidental release program for five (5) years in accordance with 40 CFR § 68.200.

(f) When this facility is subject to the accidental release program requirements of Section 112(r) of the Clean Air Act and 40 CFR Part 68, appropriate enforcement action will be taken by the Department if the permittee fails to submit a compliance schedule or fails to register and submit the RMP or a revised plan pursuant to 40 CFR Part 68.

**SECTION C. Site Level Requirements****VI. WORK PRACTICE REQUIREMENTS.****# 018 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall ensure that the source(s) and air pollution control device(s), listed in this permit, are operated and maintained in a manner consistent with good operating and maintenance practices, and in accordance with manufacturer's specifications.

019 [25 Pa. Code §123.1]**Prohibition of certain fugitive emissions**

A person responsible for any source specified in 25 Pa. Code § 123.1 shall take all reasonable actions to prevent particulate matter from becoming airborne. These actions shall include, but not be limited to, the following:

- (a) Use, where possible, of water or suitable chemicals, as approved by the Department, for control of dust in the demolition of buildings or structures, construction operations, the grading of roads, or the clearing of land.
- (b) Application of asphalt, water, or other suitable chemicals, as approved by the Department, on dirt roads, material stockpiles and other surfaces which may give rise to airborne dusts.
- (c) Paving and maintenance of roadways.
- (d) Prompt removal of earth or other material from paved streets onto which earth or other material has been transported by trucking or earth moving equipment, erosion by water, or by other means.

020 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall immediately, upon discovery, implement measures, which may include the application for the installation of an air cleaning device(s), if necessary, to reduce the air contaminant emissions to within applicable limitations, if at any time the operation of the source(s) identified in this permit, is causing the emission of air contaminants in excess of the limitations specified in, or established pursuant to, 25 Pa. Code Article III or any other applicable rule promulgated under the Clean Air Act.

021 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee may not modify any air contaminant system identified in this permit, prior to obtaining Department approval, except those modifications authorized by Condition #013(g), of Section B, of this permit.

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

VIII. COMPLIANCE CERTIFICATION.

No additional compliance certifications exist except as provided in other sections of this permit including Section B (relating to State Only General Requirements).

IX. COMPLIANCE SCHEDULE.

No compliance milestones exist.

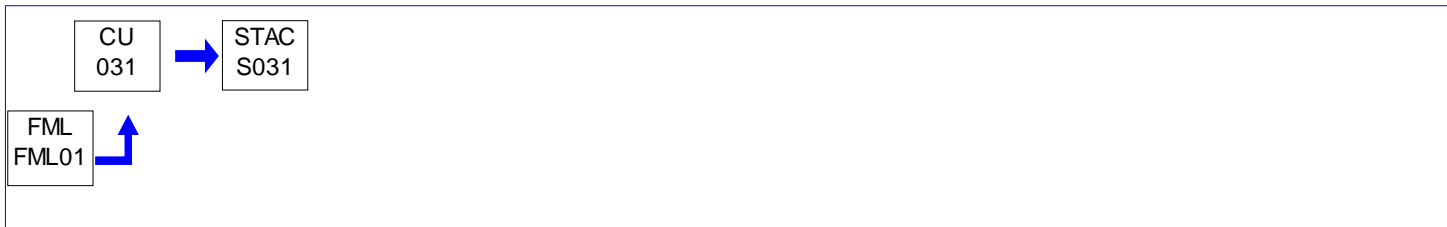
**SECTION D. Source Level Requirements**

Source ID: 031

Source Name: BOILER (CBLE200-500)

Source Capacity/Throughput: 20.160 MMBTU/HR

19.570 MCF/HR Natural Gas

**I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §123.11]****Combustion units**

A person may not permit the emission into the outdoor atmosphere of particulate matter from a combustion unit in excess of 0.4 pounds per million Btu of heat input, pursuant to 25 Pa. Code § 123.11(a)(1).

002 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall ensure that pollutant emissions from the Boiler (CBLE200-500) (Source ID: 031) shall not exceed the following:

- (a) 30 ppm_{dV} NO_x at 3% oxygen
- (b) 300 ppm_{dV} CO at 3% oxygen

Fuel Restriction(s).**# 003 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall only burn natural gas in the Boiler (CBLE200-500) (Source ID: 031).

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

III. MONITORING REQUIREMENTS.**# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall monitor the NO_x and VOC emissions from the Boiler (CBLE200-500) (Source ID: 031) on a monthly basis and as a 12-month rolling sum, when operating.

005 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall monitor the fuel usage from the Boiler (CBLE200-500) (Source ID: 031) on a monthly basis and as a 12-month rolling sum, when operating.

[Compliance with this condition assures compliance with 40 CFR § 60.48c(g).]

**SECTION D. Source Level Requirements****IV. RECORDKEEPING REQUIREMENTS.****# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall calculate and maintain records of the fuel usage from the Boiler (CBLE200-500) (Source ID: 031) on a monthly basis and as a 12-month rolling sum, when operating.

[Compliance with this condition assures compliance with 40 CFR § 60.48c(g).]

007 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall calculate and maintain records of the NO_x and VOC emissions from the Boiler (CBLE200-500) (Source ID: 031) on a monthly basis and as a 12-month rolling sum, when operating.

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

VI. WORK PRACTICE REQUIREMENTS.**# 008 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall ensure that the Boiler (CBLE200-500) (Source ID: 031) shall be:

- (a) Operated in such a manner as not to cause air pollution.
- (b) Operated and maintained in a manner consistent with good operating and maintenance practices.
- (c) Operated and maintained in accordance with the manufacturer's specifications.

009 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall ensure that the Boiler (CBLE200-500) (Source ID: 031) shall be equipped with a fuel gauge to continuously monitor the use of natural gas.

VII. ADDITIONAL REQUIREMENTS.**# 010 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall ensure that the Boiler (CBLE200-500) (Source ID: 031) shall be equipped with flue gas recirculation (FGR) and low-NO_x burner technology.

011 [40 CFR Part 60 Standards of Performance for New Stationary Sources §40 CFR 60.40c]**Subpart Dc - Standards of Performance for Small Industrial- Commercial-Institutional Steam Generating Units Applicability and delegation of authority.**

The Boiler (CBLE200-500) (Source ID: 031) is subject to the regulations of 40 CFR Part 60, Subpart Dc - Standards of Performance for Small Industrial-Commercial-Institutional steam generating Units - and must meet the reporting and recordkeeping requirements of 40 CFR § 60.48c.

012 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.11193]**SUBPART JJJJJJ - National Emission Standards for Hazardous Air Pollutants for Industrial, Commercial, and Institutional Boilers Area Sources****Am I subject to this subpart?**

(a) Pursuant to the definition under 40 CFR § 63.11195(e), the Boiler (CBLE200-500) (Source ID: 031) is categorized as a "gas-fired boiler" that is not subject to the requirements of Subpart JJJJJJ.

(b) Pursuant to the provisions under 40 CFR § 63.11237, a "gas-fired boiler" includes any boiler that burns gaseous fuels not combined with any solid fuels and burns liquid fuel only during periods of gas curtailment, gas supply interruption,

**SECTION D. Source Level Requirements**

startups, or for periodic testing, maintenance, or operator training on liquid fuel. Periodic testing, maintenance, or operator training on liquid fuel shall not exceed a combined total of 48 hours during any calendar year.

**SECTION D. Source Level Requirements**

Source ID: 102

Source Name: PRE-ROASTING PROCESS

Source Capacity/Throughput: 4.290 MMBTU/HR

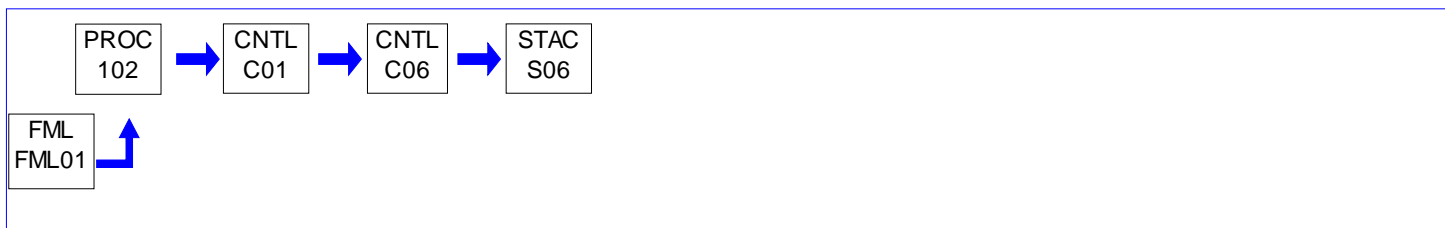
17,857.440 Lbs/HR

SHELLED COCOA BEANS

4,290.000 CF/HR

Natural Gas

Conditions for this source occur in the following groups: GRP 1

**I. RESTRICTIONS.****Throughput Restriction(s).****# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall ensure that the throughput of shelled cocoa beans through the Pre-Roasting Process (Source ID: 102) shall not exceed 64,152 metric tonnes per year as a 12-month rolling sum.

002 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall ensure that the total fuel use for Pre-Roaster (Source ID: 102) and the Roaster #1 (Source ID: 105) shall not exceed 64,059,000 cubic feet of natural gas per year, as a 12-month rolling sum.

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

III. MONITORING REQUIREMENTS.**# 003 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall ensure that the shelled cocoa beans shall be weighed prior to being processed in the Pre-Roasting Process (Source ID: 102).

IV. RECORDKEEPING REQUIREMENTS.**# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall record the throughput of shelled cocoa beans through the Pre-Roasting Process (Source ID: 102) in metric tonnes (MT) on a monthly basis and as a 12-month rolling sum.

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

VI. WORK PRACTICE REQUIREMENTS.**# 005 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall ensure that the Pre-Roasting Process (Source ID: 102) shall not be operated unless emissions from

**SECTION D. Source Level Requirements**

the source are being directed to the Pre-Roaster Cyclone (Source ID: C01) and the Anguil Regenerative Thermal Oxidizer (Source ID: C06) and both control devices are operating in accordance with the requirements of this operating permit.

006 [25 Pa. Code §127.441]

Operating permit terms and conditions.

The permittee shall ensure that the emissions from the Pre-Roasting Process (Source ID: 102) shall be controlled by the Pre-Roaster Cyclone (Source ID: C01) followed by the Anguil Regenerative Thermal Oxidizer (Source ID: C06).

VII. ADDITIONAL REQUIREMENTS.

007 [25 Pa. Code §127.441]

Operating permit terms and conditions.

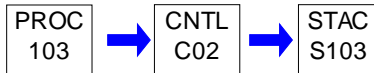
- (a) The Pre-Roaster drum is manufactured by GW Barth, A.G., Model No. IR-8000.
- (b) The Pre-Roaster burner is manufactured by Maxon, Model No. Infrawave 21X DG 300.

**SECTION D. Source Level Requirements**

Source ID: 103

Source Name: WINNOWING PROCESS - ROTARY SCREEN

Source Capacity/Throughput: 17,857.440 Lbs/HR SHELLED COCOA BEANS

**I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall ensure that the particulate matter (PM) emissions from the Wining Process - Rotary Screen (Source ID: 103) shall not exceed 0.02 grain per dry standard cubic feet.

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

III. MONITORING REQUIREMENTS.

No additional monitoring requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

IV. RECORDKEEPING REQUIREMENTS.

No additional record keeping requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

VI. WORK PRACTICE REQUIREMENTS.**# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall ensure that the Wining Process - Rotary Screen (Source ID: 103) shall not be operated unless emissions from the source are being directed to the Rotary Screen Cyclone (Source ID: C02) and the cyclone is operating in accordance with the requirements of this operating permit.

VII. ADDITIONAL REQUIREMENTS.**# 003 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The Wining Process - Rotary Screen (Source ID: 103) is manufactured by GW Barth, A.G., Model No. W8000.

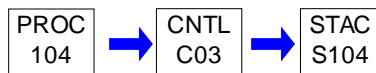
**SECTION D. Source Level Requirements**

Source ID: 104

Source Name: WINNOWER AIR CLASSIFICATION

Source Capacity/Throughput: 17,857.440 Lbs/HR

SHELLED COCOA BEANS

**I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall ensure that the particulate matter (PM) emissions from the Winnower Air Classification (Source ID: 104) shall not exceed 0.02 grain per dry standard cubic feet (gr/dscf).

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

III. MONITORING REQUIREMENTS.

No additional monitoring requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

IV. RECORDKEEPING REQUIREMENTS.

No additional record keeping requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

VI. WORK PRACTICE REQUIREMENTS.**# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall ensure that the Winnowing Air Classification (Source ID: 104) shall not be operated unless emissions from the source are being directed to the Winnower Air Classification Cyclone (Source ID: C03) and the cyclone is operating in accordance with the requirements of this operating permit.

VII. ADDITIONAL REQUIREMENTS.**# 003 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The Winnower Air Classification (Source ID: 104) is manufactured by GW Barth, A.G., Model No. W8000.

**SECTION D. Source Level Requirements**

Source ID: 105

Source Name: ROASTER #1

Source Capacity/Throughput: 3.960 MMBTU/HR

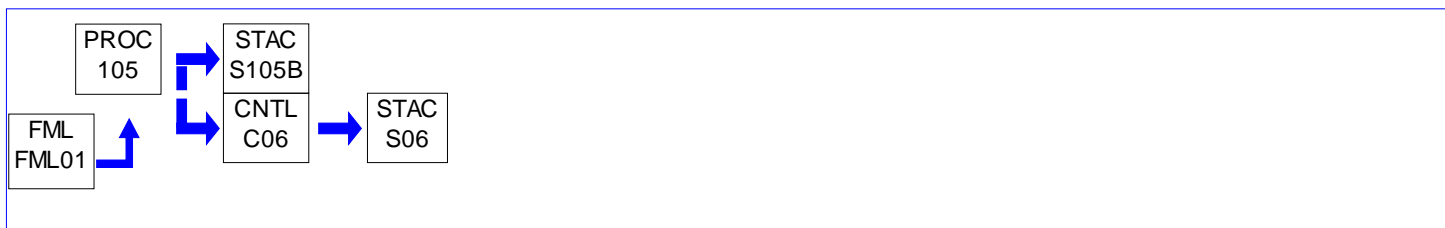
5,511.560 Lbs/HR

COCOA BEAN NIBS

3,960.000 CF/HR

Natural Gas

Conditions for this source occur in the following groups: GRP 1

**I. RESTRICTIONS.****Emission Restriction(s).**

001 [25 Pa. Code §127.441]

Operating permit terms and conditions.

The permittee shall ensure that the particulate matter (PM) emissions from the Roaster #1 (Source ID: 105) combustion stack shall not exceed 0.02 grain per dry standard cubic feet.

[Compliance with this more stringent condition also assures compliance with 25 Pa. Code § 123.13(c)(1)(i).]

Throughput Restriction(s).

002 [25 Pa. Code §127.441]

Operating permit terms and conditions.

(a) The permittee shall ensure that the throughput of cocoa bean nibs through Roaster #1 (Source ID: 105) shall not exceed 19,800 metric tonnes per year as 12-month rolling sum.

(b) The throughput shall be based on the weight of cocoa bean nibs prior to being alkalized and roasted.

003 [25 Pa. Code §127.441]

Operating permit terms and conditions.

The permittee shall ensure that the fuel use for Pre-Roaster and the Roaster #1 (Source ID: 105) shall not exceed 64,059,000 cubic feet of natural gas per year as a 12-month rolling sum.

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

III. MONITORING REQUIREMENTS.

004 [25 Pa. Code §127.441]

Operating permit terms and conditions.

(a) The permittee shall ensure that the throughput of cocoa bean nibs through Roaster #1 (Source ID: 105) shall be weighed prior to processing the cocoa bean nibs in Roaster #1 (Source ID: 105).

(b) If the cocoa bean nibs are processed in the G.W. Barth Alkalizer (Source ID: 107) prior to Roaster #1 (source ID: 105), then the permittee shall ensure that the cocoa bean nibs shall be weighed prior to being processed in the alkalizer.

**SECTION D. Source Level Requirements****# 005 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall ensure that the throughput of cocoa bean nibs through Roaster #1 (Source ID: 105) shall be weighed per batch and total each month prior to processing the cocoa bean nibs in the roaster.

IV. RECORDKEEPING REQUIREMENTS.**# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall record the throughput of cocoa bean nibs through Roaster #1 (Source ID: 105), in metric tonnes, on a monthly basis and as a 12-month rolling sum.

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

VI. WORK PRACTICE REQUIREMENTS.

No additional work practice requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.**# 007 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

- (a) The Roaster #1 with cooling drum is manufactured by GW Barth, A.G., Model No. Tornado 10500 RS.
- (b) The Roaster #1 burner is manufactured by Maxon, Model No. Ovenpak EB 5.

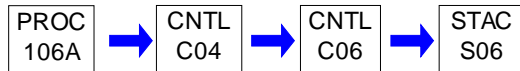
**SECTION D. Source Level Requirements**

Source ID: 106A

Source Name: NIB GRINDING LINE #1

Source Capacity/Throughput: 5,500.000 Lbs/HR COCOA BEAN NIBS

Conditions for this source occur in the following groups: GRP 2

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

III. MONITORING REQUIREMENTS.

No additional monitoring requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

IV. RECORDKEEPING REQUIREMENTS.

No additional record keeping requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

VI. WORK PRACTICE REQUIREMENTS.

No additional work practice requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.**# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a) The Nib Grinding Line #1 (Source ID: 106A) consists of the following: a primary grinder, an intermediate grinder, two (2) fine grinders, and various holding tanks.

(b) Each grinder in the nib grinding process is manufactured by Duyvis, Model No. Nibrotom 3000.

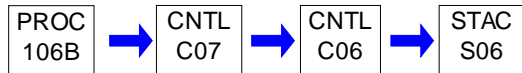
**SECTION D. Source Level Requirements**

Source ID: 106B

Source Name: NIB GRINDING LINE #2

Source Capacity/Throughput: 5,500.000 Lbs/HR COCOA BEANS NIB

Conditions for this source occur in the following groups: GRP 2

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

III. MONITORING REQUIREMENTS.

No additional monitoring requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

IV. RECORDKEEPING REQUIREMENTS.

No additional record keeping requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

VI. WORK PRACTICE REQUIREMENTS.

No additional work practice requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.**# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a) The Nib Grinding Line #2 (Source ID: 106B) consists of the following: a primary grinder, an intermediate grinder, two (2) fine grinders, and various holding tanks.

(b) Each grinder in the nib grinding process is manufactured by Duyvis, Model No. Nibrotom 3000.

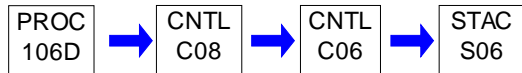
**SECTION D. Source Level Requirements**

Source ID: 106D

Source Name: NIB GRINDING LINE #3

Source Capacity/Throughput: 6,614.000 Lbs/HR COCOA BEAN NIBS

Conditions for this source occur in the following groups: GRP 2

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

III. MONITORING REQUIREMENTS.

No additional monitoring requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

IV. RECORDKEEPING REQUIREMENTS.

No additional record keeping requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

VI. WORK PRACTICE REQUIREMENTS.

No additional work practice requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

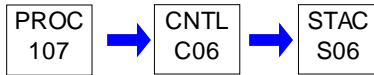
**SECTION D. Source Level Requirements**

Source ID: 107

Source Name: G.W. BARTH ALKALIZER

Source Capacity/Throughput: 5,511.560 Lbs/HR

COCOA BEAN NIBS

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

III. MONITORING REQUIREMENTS.**# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a) The permittee shall ensure that throughput of cocoa bean nibs shall be weighed prior to being processed in the Alkalizer (Source ID: 107).

(b) If a batch of cocoa bean nibs is not going to be processed in the Alkalizer (Source ID: 107), those batches shall be weighed before being processed in the Roasting Process.

IV. RECORDKEEPING REQUIREMENTS.**# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall record the throughput of cocoa bean nibs on a monthly basis and as a 12-month rolling sum.

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

VI. WORK PRACTICE REQUIREMENTS.**# 003 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a) The permittee shall ensure that all emissions from the Alkalizer (Source ID: 107) shall be exhausted to the Anguil Regenerative Thermal Oxidizer (Source ID: C06).

(b) The permittee shall ensure that the Alkalizer (Source ID: 107) shall not be operated unless the Anguil Regenerative Thermal Oxidizer (Source ID: C02) is operating properly and complying with all applicable requirements as described herein this operating permit.

VII. ADDITIONAL REQUIREMENTS.**# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall ensure that the Alkalizer (Source ID: 107) shall be the same as or equivalent to that manufactured by G.W. Barth, Model No. CNA 5500.

**SECTION D. Source Level Requirements**

Source ID: 108

Source Name: ROASTER #2

Source Capacity/Throughput: 3.960 MMBTU/HR

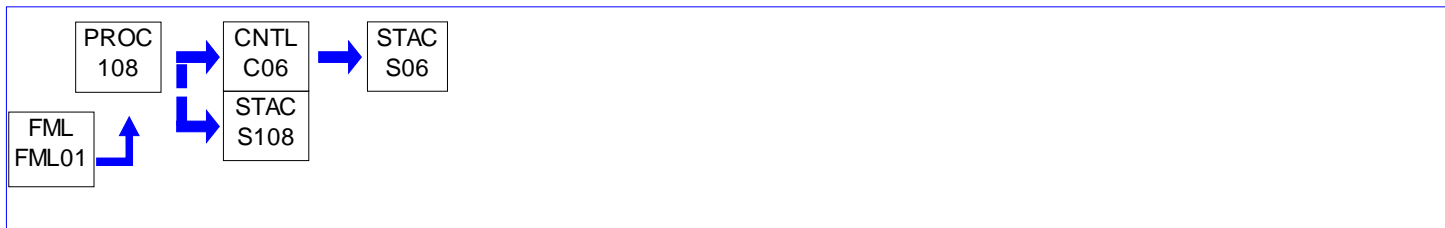
9,479.880 Lbs/HR

COCOA BEAN NIBS

3,882.000 CF/HR

Natural Gas

Conditions for this source occur in the following groups: GRP 1

**I. RESTRICTIONS.****Emission Restriction(s).**

001 [25 Pa. Code §127.441]

Operating permit terms and conditions.

The permittee shall ensure that the particulate matter (PM) emissions from the Roaster #2 (Source ID: 108) combustion stack shall not exceed 0.02 grain per dry standard cubic feet.

[Compliance with this more stringent condition also assures compliance with 25 Pa. Code § 123.13(c)(1)(i).]

Throughput Restriction(s).

002 [25 Pa. Code §127.441]

Operating permit terms and conditions.

The permittee shall ensure that the throughput of cocoa bean nibs through Roaster #2 (Source ID: 108) shall not exceed 34,056 metric tonnes per year as a 12-month rolling sum.

003 [25 Pa. Code §127.441]

Operating permit terms and conditions.

The permittee shall ensure that the fuel use the Roaster #2 (Source ID: 108) shall not exceed 30,748,000 cubic feet of natural gas per year as a 12-month rolling sum.

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

III. MONITORING REQUIREMENTS.

004 [25 Pa. Code §127.441]

Operating permit terms and conditions.

(a) The permittee shall ensure that the throughput of cocoa bean nibs through Roaster #2 (Source ID: 108) shall be weighed prior to processing the cocoa bean nibs in the roaster.

(b) The permittee shall ensure that the throughput of cocoa bean nibs through Roaster #2 (Source ID: 108) shall be monitored per batch and totaled each month.

**SECTION D. Source Level Requirements****IV. RECORDKEEPING REQUIREMENTS.****# 005 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall record the throughput of cocoa bean nibs through Roaster #2 (Source ID: 108), in metric tonnes, on a monthly basis and as a 12-month rolling sum.

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

VI. WORK PRACTICE REQUIREMENTS.**# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall ensure that the Roaster #2 (Source ID: 108) shall not be used to alkalize cocoa beans or implement flavor injection.

(a) The alkalization and flavor injection feed points to the roaster shall be closed with blind flanges. No connecting piping for the solution feeds shall be installed.

(b) The Roaster is permitted for steam injection.

007 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall ensure that the Roaster #2 (Source ID: 108) shall be equipped with a fuel gauge to determine fuel used exclusively by this source.

VII. ADDITIONAL REQUIREMENTS.**# 008 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a) The permittee shall ensure that the Roaster #2 (Source ID: 108) and its associated cooling drum shall be the same as or equivalent to that manufactured by GW Barth, A.G., Model No. Tornado 10500 RS.

(b) The permittee shall ensure that the roaster burner shall be the same as or equivalent to that manufactured by Maxon, Model No. Ovenpak EB 5.

**SECTION D. Source Level Requirements**

Source ID: 700

Source Name: ONAN 250DFAC GENSET

Source Capacity/Throughput:

16.800 Gal/HR

Diesel Fuel

**I. RESTRICTIONS.****Emission Restriction(s).**

001 [25 Pa. Code §123.13]

Processes

No person may permit the emission into the outdoor atmosphere of particulate matter from this source in excess of 0.04 gr/dscf, pursuant to 25 Pa. Code § 123.13(c)(1)(x).

002 [25 Pa. Code §123.21]

General

No person may permit the emission into the outdoor atmosphere of sulfur oxides from this source in a manner that the concentration of the sulfur oxides, expressed as SO₂, in the effluent gas exceeds 500 ppmvd.

003 [25 Pa. Code §127.441]

Operating permit terms and conditions.

The permittee shall ensure that the combined NO_x emissions from all exempt internal combustion engines at the site, regardless of size, shall not exceed 100 lbs/hr, 1000 lbs/day, 2.75 tons per ozone season and 6.6 tons per year on a 12-month rolling basis.

004 [40 CFR Part 60 Standards of Performance for New Stationary Sources §40 CFR 60.4205]

Subpart III - Standards of Performance for Stationary Compression Ignition Internal Combustion Engines**What emission standards must I meet for emergency engines if I am an owner or operator of a stationary CI internal co**

The permittee shall ensure that the Onan 250DFAC GenSet (Source ID: 700) shall not exceed the following emission rates:

- (a) Hydrocarbons (HC): 1.0 g/HP-hr
- (b) Nitrogen Oxides (NO_x): 6.9 g/HP-hr
- (c) Carbon Monoxide (CO): 8.5 g/HP-hr
- (d) Particulate Matter (PM): 0.40 g/HP-hr

Fuel Restriction(s).

005 [40 CFR Part 60 Standards of Performance for New Stationary Sources §40 CFR 60.4207]

Subpart III - Standards of Performance for Stationary Compression Ignition Internal Combustion Engines**What fuel requirements must I meet if I am an owner or operator of a stationary CI internal combustion engine subject t**

The permittee shall only use diesel fuel in this Onan 250DFAC GenSet (Source ID: 700) that meets the following parameters:

- (a) Sulfur content. 15 ppm maximum.
- (b) Cetane index or aromatic content, as follows:
 - (1) A minimum cetane index of 40; or
 - (2) A maximum aromatic content of 35 volume percent

**SECTION D. Source Level Requirements****II. TESTING REQUIREMENTS.****# 006 [40 CFR Part 60 Standards of Performance for New Stationary Sources §40 CFR 60.4211]****Subpart III - Standards of Performance for Stationary Compression Ignition Internal Combustion Engines****What are my compliance requirements if I am an owner or operator of a stationary CI internal combustion engine?**

The permittee shall demonstrate compliance with the emission limits applicable to this Onan 250DFAC Gen Set (Source ID: 700) in accordance with one of the following methods:

- (a) Keeping records of performance test results for each pollutant for a test conducted on a similar engine from the same manufacturer; the test must have been conducted using the same methods specified in 40 CFR Part 60, Subpart III.
- (b) Keeping records of engine manufacturer data indicating compliance with the standards.
- (c) Conducting an initial performance test to demonstrate compliance with the emission standards according to the requirements specified in 40 CFR § 60.4212, as applicable.

III. MONITORING REQUIREMENTS.**# 007 [40 CFR Part 60 Standards of Performance for New Stationary Sources §40 CFR 60.4209]****Subpart III - Standards of Performance for Stationary Compression Ignition Internal Combustion Engines****What are the monitoring requirements if I am an owner or operator of a stationary CI internal combustion engine?**

The permittee shall ensure that the Onan 250DFAC GenSet (Source ID: 700) shall be equipped with a non-resettable hour meter.

IV. RECORDKEEPING REQUIREMENTS.**# 008 [40 CFR Part 60 Standards of Performance for New Stationary Sources §40 CFR 60.4211]****Subpart III - Standards of Performance for Stationary Compression Ignition Internal Combustion Engines****What are my compliance requirements if I am an owner or operator of a stationary CI internal combustion engine?**

The permittee shall maintain on site at all times records which demonstrate compliance with the applicable emission limits associated with this source.

009 [40 CFR Part 60 Standards of Performance for New Stationary Sources §40 CFR 60.4214]**Subpart III - Standards of Performance for Stationary Compression Ignition Internal Combustion Engines****What are my notification, reporting, and recordkeeping requirements if I am an owner or operator of a stationary CI internal combustion engine?**

- (a) The permittee shall ensure that the hours of operation of the Onan 250DFAC GenSet (Source ID: 700) (Source ID: 700) shall be recorded each time it is operated, including the reason for operating, and specifying if it was for emergency service or non-emergency service.
- (b) The permittee shall ensure that the hours of operation shall be summarized on a monthly basis and as a 12-month rolling sum.

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

VI. WORK PRACTICE REQUIREMENTS.**# 010 [40 CFR Part 60 Standards of Performance for New Stationary Sources §40 CFR 60.4200]****Subpart III - Standards of Performance for Stationary Compression Ignition Internal Combustion Engines****Am I subject to this subpart?**

- (a) The permittee shall operate the emergency stationary R.I.C.E. according to the requirements in the most recent version of 40 C.F.R. Section 60.4211(f).
- (b) If the permittee does not operate the engine according to the requirements of 40 C.F.R. Section 60.4211(f), the engine

**SECTION D. Source Level Requirements**

will not be considered an emergency engine under 40 C.F.R. Part 60 Subpart IIII and must meet all requirements for non-emergency engines

011 [40 CFR Part 60 Standards of Performance for New Stationary Sources §40 CFR 60.4211]**Subpart IIII - Standards of Performance for Stationary Compression Ignition Internal Combustion Engines****What are my compliance requirements if I am an owner or operator of a stationary CI internal combustion engine?**

(a) The permittee shall operate and maintain the stationary CI internal combustion engine according to the manufacturer's emission-related written instructions.

(b) The permittee shall only be allowed to change those emission-related settings that are permitted by the manufacturer.

(c) If the permittee cannot operate and maintain this source according to the manufacturer's emission-related written instructions, or the permittee changes emission-related settings in a way that is not permitted by the manufacturer, the permittee shall demonstrate compliance as follows:

(1) The permittee shall keep a maintenance plan and records of conducted maintenance and must, to the extent practicable, maintain and operate the engine in a manner consistent with good air pollution control practice for minimizing emissions.

(2) The permittee must conduct an initial performance test to demonstrate compliance with the applicable emission standards within 1 year after the source is no longer installed, configured, operated, and maintained in accordance with the manufacturer's emission-related written instructions, or within 1 year after the permittee changes emission-related settings in a way that is not permitted by the manufacturer.

VII. ADDITIONAL REQUIREMENTS.**# 012 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The Onan 250DFAC GenSet (Source ID: 700) is an emergency generator rated at 250 kW (380 bhp) with a 6-cylinder, Cummins LTA10-G1 diesel engine.

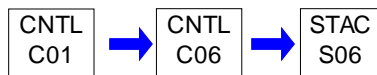
**SECTION D. Source Level Requirements**

Source ID: C01

Source Name: PRE-ROASTER CYCLONE

Source Capacity/Throughput:

N/A

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

III. MONITORING REQUIREMENTS.**# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall monitor the amperage of the fan motor associated with the Pre-Roaster Cyclone (Source ID: C01) on a daily basis.

002 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall monitor the following for the water filtration system associated with the Pre-Roaster Cyclone (Source ID: C01) on a weekly basis:

- (a) The amount of makeup water for the cyclone is added.
- (b) The number of rolls of filter paper for the trough/paper filter system is used.
- (c) The number of cartridges for the secondary water filtration system is used.

003 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall monitor the water flow rate to the Pre-Roaster Cyclone (Source ID: C01) on a daily basis.

IV. RECORDKEEPING REQUIREMENTS.**# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall record the water flow rate to the top of the Pre-Roaster Cyclone (Source ID: C01) on a daily basis.

005 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall record the amperage of the fan motor associated with the Pre-Roaster Cyclone (Source ID: C01) on a daily basis.

006 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall record the following for the water filtration system associated with the Pre-Roaster Cyclone (Source ID: C01) on a weekly basis:

- (a) The amount of makeup water for the cyclone is added.
- (b) The number of rolls of filter paper for the trough/paper filter system is used.
- (c) The number of cartridges for the secondary water filtration system is used.

**SECTION D. Source Level Requirements****V. REPORTING REQUIREMENTS.**

No additional reporting requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

VI. WORK PRACTICE REQUIREMENTS.

007 [25 Pa. Code §127.441]

Operating permit terms and conditions.

The permittee shall ensure that the Pre-Roaster Cyclone (Source ID: C01) shall be operating at all times when the Pre-Roasting Process is in operation.

008 [25 Pa. Code §127.441]

Operating permit terms and conditions.

The permittee shall ensure that the water flow rate to the top of the Pre-Roaster Cyclone (Source ID: C01) shall be maintained at around 14 gallons per minute but not less than 13 gallons per minute.

009 [25 Pa. Code §127.441]

Operating permit terms and conditions.

The permittee shall ensure that the exhaust fan amperage reading shall be maintained between 26.0 - 41.0 amps.

010 [25 Pa. Code §127.441]

Operating permit terms and conditions.

(a) The permittee shall ensure that the water filtration system shall have a functioning alarm system to indicate when cartridges need to be changed.

(b) The permittee shall ensure that the alarm system shall be operating whenever the Pre-Roasting Process (Source ID: 102) is operating.

011 [25 Pa. Code §127.441]

Operating permit terms and conditions.

(a) The permittee shall ensure that Pre-Roaster Cyclone (Source ID: C01) shall be equipped with a gauge to show the water flow to the top of the Pre-Roaster Cyclone.

(b) The permittee shall ensure that the make-up water source shall be equipped with a water gauge to track the amount of make-up water added.

012 [25 Pa. Code §127.441]

Operating permit terms and conditions.

The permittee shall ensure that the Pre-Roaster Cyclone (Source ID: C01) shall have ports upstream and downstream such that, if necessary, the pressure drop across the Pre-Roaster Cyclone can be determined.

013 [25 Pa. Code §127.441]

Operating permit terms and conditions.

The permittee shall take all reasonable steps to ensure that malodors do not result from the Pre-Roaster Cyclone (Source ID: C01) water filtration system, including the waste material resulting from the water filtration system.

014 [25 Pa. Code §127.441]

Operating permit terms and conditions.

The permittee shall take all reasonable steps to minimize fugitive VOC emissions from the Pre-Roaster Cyclone (Source ID: C01) water filtration system. This includes minimizing fugitive VOC emissions from the waste material generated by the water filtration system.

VII. ADDITIONAL REQUIREMENTS.

015 [25 Pa. Code §127.441]

Operating permit terms and conditions.

The Pre-Roaster Cyclone (Source ID: C01), designated Cyclone 304, is manufactured by MAC Equipment, Model No. HE43.

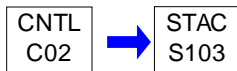
**SECTION D. Source Level Requirements**

Source ID: C02

Source Name: ROTARY SCREEN CYCLONE

Source Capacity/Throughput:

N/A

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

III. MONITORING REQUIREMENTS.**# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall monitor the amperage of the fan motor associated with the Rotary Screen Cyclone (Source ID: C02) on a daily basis.

IV. RECORDKEEPING REQUIREMENTS.**# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall record the amperage of the fan motor associated with the Rotary Screen Cyclone (Source ID: C02) on a daily basis.

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

VI. WORK PRACTICE REQUIREMENTS.**# 003 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall ensure that the Rotary Screen Cyclone (Source ID: C02) shall be operating at all times when the Winnower Process - Rotary Screen (Source ID: 103) is in operation.

004 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall ensure that the exhaust fan amperage reading shall be maintained between 30.0 - 45.0 amps.

005 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

(a) The permittee shall ensure that the Rotary Screen Cyclone (Source ID: C02) shall have ports upstream and downstream such that, if necessary, the pressure drop across the Rotary Screen Cyclone can be determined.

(b) The pressure drop across the Rotary Screen Cyclone (Source ID: C02) shall be monitored upon the request of the Department.

**SECTION D. Source Level Requirements****VII. ADDITIONAL REQUIREMENTS.****# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The Rotary Screen Cyclone (Source ID: C02), designated Cyclone 407, is manufactured by MAC Equipment, Model No. HE36.

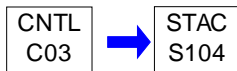
**SECTION D. Source Level Requirements**

Source ID: C03

Source Name: WINNOWER AIR CLASSIFICATION CYCLONE

Source Capacity/Throughput:

N/A

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

III. MONITORING REQUIREMENTS.**# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall monitor the amperage of the fan motor associated with the Winnower Air Classification Cyclone (Source ID: C03) on a daily basis.

IV. RECORDKEEPING REQUIREMENTS.**# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall record the amperage of the fan motor associated with the Winnower Air Classification Cyclone (Source ID: C03) on a daily basis.

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

VI. WORK PRACTICE REQUIREMENTS.**# 003 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall ensure that the Winnower Air Classification Cyclone (Source ID: C03) shall be operating at all times when the Winnower Air Classification (Source ID: 104) is in operation.

004 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall ensure that the exhaust fan amperage reading shall be maintained between 16.0 - 30.0 amps.

005 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

(a) The permittee shall ensure that the Winnower Air Classification Cyclone (Source ID: C03) shall have ports upstream and downstream such, that if necessary, the pressure drop across the Winnower Air Classification Cyclone can be determined.

(b) The pressure drop across the Winnower Air Classification Cyclone (Source ID: C03) shall be monitored upon the request of the Department.

**SECTION D. Source Level Requirements****VII. ADDITIONAL REQUIREMENTS.****# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The Winnower Air Classification Cyclone (Source ID: C03), designated Cyclone 408, is manufactured by MAC Equipment, Model No. HE33.

**SECTION D. Source Level Requirements**

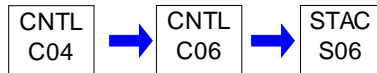
Source ID: C04

Source Name: NIB GRINDING #1 MIST ELIMINATOR

Source Capacity/Throughput:

N/A

Conditions for this source occur in the following groups: GRP 3

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

III. MONITORING REQUIREMENTS.

No additional monitoring requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

IV. RECORDKEEPING REQUIREMENTS.

No additional record keeping requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

VI. WORK PRACTICE REQUIREMENTS.**# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall ensure that the exhaust fan amperage readings from the Nib Grinding #1 Mist Eliminator (Source ID: C04) shall be maintained between 1.0 - 3.0 amps.

VII. ADDITIONAL REQUIREMENTS.**# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

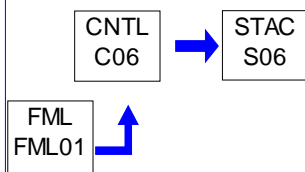
The Nib Grinding #1 Mist Eliminator (Source ID: C04) is manufactured by Munters, Model No. T-271.

**SECTION D. Source Level Requirements**

Source ID: C06

Source Name: ANGUIL REGENERATIVE THERMAL OXIDIZER

Source Capacity/Throughput: 5,882.000 CF/HR Natural Gas

**I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall ensure that emissions from the Anguil Regenerative Thermal Oxidizer (Source ID: C06) shall not exceed the following:

- (a) Nitrogen Oxides (NOx): 1.04 lbs/hr and 4.48 tons per year, as a 12-month rolling sum.
- (b) Volatile Organic Compounds (VOCs): 0.73 lb/hr and 3.14 tons per year, as 12-month rolling sum.

002 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall ensure that the particulate matter (PM) emissions from the Anguil Regenerative Thermal Oxidizer (Source ID: C06) shall not exceed 0.02 grains per dry standard cubic feet.

[Compliance with this more stringent condition also assures compliance with 25 Pa. Code § 123.13(c)(1)(i).]

Fuel Restriction(s).**# 003 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall ensure that the Anguil Regenerative Thermal Oxidizer (Source ID: C06) shall only burn natural gas for fuel.

Throughput Restriction(s).**# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall ensure that the Anguil Regenerative Thermal Oxidizer (Source ID: C06) shall not burn more than 51,530,000 cubic feet of natural gas per year, as a 12-month rolling sum.

Control Device Efficiency Restriction(s).**# 005 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall ensure that the Anguil Regenerative Thermal Oxidizer (Source ID: C06) shall reduce volatile organic compounds (VOCs) by 98 percent, or such that VOCs do not exceed 6 ppmv, as propane.

II. TESTING REQUIREMENTS.**# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

- (a) The permittee shall perform a stack test using the Department-approved procedures once every five (5) calendar years, where five calendar years is defined as beginning with the calendar year the latest stack test was performed and ending on

**SECTION D. Source Level Requirements**

December 31, five years later. Performance tests shall be conducted while the source is operating at maximum routine operating conditions or under such other conditions, within the capacity of the equipment, as may be requested by the Department. When testing of a source is required on a recurring basis, a single procedural protocol may be submitted for approval; thereafter, a letter referencing the previously approved procedural protocol is sufficient. However, if modifications are made to the process(es), if a different stack testing company is used, or if an applicable section of the stack testing manual has been revised since approval, a new protocol must be submitted for approval.

(b) At least ninety (90) days prior to the test, the permittee shall submit to the Department for approval the procedures for the test and a sketch with dimensions indicating the location of sampling ports and other data to ensure the collection of representative samples.

(c) The stack test shall, at a minimum, test for NO_x, VOCs, the VOC destruction efficiency and/or the VOC outlet concentration. Tests shall be conducted in accordance with the provisions of EPA Method(s) 7E and 25 or 25A or other Department approved methodology and 25 Pa. Code Chapter 139.

(d) During the aforementioned stack test, for each stack test run, the permittee shall take a pre-filter sample and a post-filter sample of water for testing the VOC content (using Method SW-846 8260D) in the water used in the Pre-Roaster Cyclone water filtration system. In addition, the permittee shall monitor and record the following parameters of the Pre-Roaster Cyclone water filtration system for each stack test run:

- (1) The filter paper discharge rate (inches/hour).
- (2) When filter cartridges are replaced.
- (3) The amount of make-up water added.
- (4) The water usage rate through the cyclone spray nozzles.

(e) At least thirty (30) days prior to the test, the Regional Air Quality Manager, shall be informed of the date and time of the test.

(f) Within sixty (60) days after the source test(s), two copies of the complete test report, including all operating conditions, shall be submitted to the Regional Air Quality Manager for approval.

(g) In the event that any of the above deadlines cannot be met, the permittee may request an extension for the due date(s) in writing and include a justification for the extension. The Department may grant an extension for a reasonable cause.

III. MONITORING REQUIREMENTS.

007 [25 Pa. Code §127.441]

Operating permit terms and conditions.

The permittee shall monitor the natural gas usage for the Anguil Regenerative Thermal Oxidizer (Source ID: C06) on a continuous basis.

008 [25 Pa. Code §127.441]

Operating permit terms and conditions.

The permittee shall monitor and calculate the NO_x and VOC emissions from the Anguil Regenerative Thermal Oxidizer (Source ID: C06) on a monthly basis and as a 12-month rolling sum.

IV. RECORDKEEPING REQUIREMENTS.

009 [25 Pa. Code §127.441]

Operating permit terms and conditions.

The permittee shall record the natural gas usage for the Anguil Regenerative Thermal Oxidizer (Source ID: C06) on a monthly basis and as a 12-month rolling sum.

010 [25 Pa. Code §127.441]

Operating permit terms and conditions.

The permittee shall record the combustion chamber temperature continuously using a method approved by DEP.

**SECTION D. Source Level Requirements****# 011 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

In the event there is a failure in the Anguil Regenerative Thermal Oxidizer (Source ID: C06) or any of the processes exhausting to the RTO, the permittee shall record the following:

- (a) Time of failure.
- (b) Time of repair.
- (c) Duration during which processes were still operating.
- (d) Uncontrolled emissions resulting from the RTO failure; emissions shall be reported using zero destruction efficiency.

012 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall maintain the necessary records shall to demonstrate compliance with the combustion tune-up requirements described herein this operating permit for the Anguil Regenerative Thermal Oxidizer (Source ID: C06), including, but not limited to dates and any corrective actions taken.

013 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall maintain records of the NO_x and VOC emissions from the Anguil Regenerative Thermal Oxidizer (Source ID: C06) on a monthly basis and as a 12-month rolling sum.

014 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall record any maintenance in a permanently bound logbook or other method approved by the Department. This log shall contain, at a minimum, the following information:

- (i) The date of the maintenance procedure.
- (ii) Type of maintenance performed.
- (iii) The name of the service company and technicians.

V. REPORTING REQUIREMENTS.**# 015 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

In the event there is a failure in the Anguil Regenerative Thermal Oxidizer (Source ID: C06) and there are processes exhausting to the RTO, the permittee shall report the following to the Department within two business days:

- (a) Time of failure.
- (b) Time of repair.
- (c) Duration during which processes were still operating.
- (d) Uncontrolled emissions resulting from the RTO failure; emissions shall be reported using zero destruction efficiency.

VI. WORK PRACTICE REQUIREMENTS.**# 016 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a) The Anguil Regenerative Thermal Oxidizer (Source ID: C06) shall control emissions from the Pre-Roasting Process, Roaster #1, the Roaster #1 cooling drum, the Alkalizer, Roaster #2, the Roaster #2 cooling drum, the Nib Grinding Line #1, the Nib Grinding Line #2 and the Nib Grinding Line #3.

**SECTION D. Source Level Requirements**

(b) The Anguil Regenerative Thermal Oxidizer (Source ID: C06) shall be operated with a minimum combustion temperature of 816°C (1500°F).

(c) The permittee shall ensure that the Anguil Regenerative Thermal Oxidizer (Source ID: C06) shall reach the minimum combustion temperature before the processes are exhausted to it. The RTO shall continue to operate until all processes exhausting to it have been completed and shut down.

017 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

(a) The permittee shall ensure that the Anguil Regenerative Thermal Oxidizer (Source ID: C06) shall be operated and maintained in a manner consistent with good operating and maintenance practices, and in accordance with the manufacturer's specifications.

(b) The permittee shall ensure that a tune-up shall be performed on the Anguil Regenerative Thermal Oxidizer (Source ID: C06) combustion system every 12 months to ensure that the burner is operating properly.

(c) The permittee shall calibrate and check the accuracy of monitoring equipment (i.e., thermocouple) of taking into account the manufacturer's specifications at approved time intervals.

(i) The thermocouple or other approved device shall be calibrated and checked for accuracy on an annual basis.

018 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

(a) The permittee shall ensure that the Anguil Regenerative Thermal Oxidizer (Source ID: C06) shall be equipped with a gauge to track natural gas fuel usage, separately from other natural gas combustion sources at the facility.

(b) The permittee shall ensure that the Anguil Regenerative Thermal Oxidizer (Source ID: C06) shall be equipped with a thermocouple to monitor the combustion chamber temperature on a continuous basis. The thermocouple shall be placed at the back of the combustion chamber, such that it reflects the combustion chamber temperature, while not being directly exposed to the burner flame.

(c) The permittee shall ensure that the Anguil Regenerative Thermal Oxidizer (Source ID: C06) is equipped with an audible alarm system that will engage when the RTO combustion chamber temperature drops below 1,500°F.

(b) The permittee shall ensure that the Anguil Regenerative Thermal Oxidizer (Source ID: C06) shall be equipped with a temperature recording device that continuously displays the temperature of the combustion chamber during operation.

019 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall ensure that, in the event the Anguil RTO (Source ID: C06) is not operating properly, the processing operation which vent to the RTO shall be shut down.

The processing operation consists of the Pre-Roaster (Source ID: 102), two (2) Roasters (Source ID(s): 105 and 108), Alkalizers (Source ID: 107) and three (3) Nib Grinders (Source ID(s): 106A, 106B and 106D).

VII. ADDITIONAL REQUIREMENTS.**# 020 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The Anguil Regenerative Thermal Oxidizer (Source ID: C06) is manufactured by Anguil Regenerative, Model No. RTO-250.

**SECTION D. Source Level Requirements**

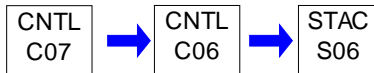
Source ID: C07

Source Name: NIB GRINDING #2 MIST ELIMINATOR

Source Capacity/Throughput:

N/A

Conditions for this source occur in the following groups: GRP 3

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

III. MONITORING REQUIREMENTS.

No additional monitoring requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

IV. RECORDKEEPING REQUIREMENTS.

No additional record keeping requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

VI. WORK PRACTICE REQUIREMENTS.**# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall ensure that the exhaust fan amperage readings from the Nib Grinding #2 Mist Eliminator (Source ID: C07) shall be maintained between 1.0 - 3.0 amps.

VII. ADDITIONAL REQUIREMENTS.**# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The Nib Grinding #2 Mist Eliminator (Source ID: C07) is manufactured by Munters, Model No. T-271.

**SECTION D. Source Level Requirements**

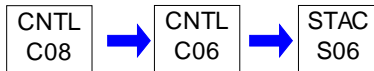
Source ID: C08

Source Name: NIB GRINDING #3 MIST ELIMINATOR

Source Capacity/Throughput:

N/A

Conditions for this source occur in the following groups: GRP 3

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

III. MONITORING REQUIREMENTS.

No additional monitoring requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

IV. RECORDKEEPING REQUIREMENTS.

No additional record keeping requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements) and/or Section E (Source Group Restrictions).

VI. WORK PRACTICE REQUIREMENTS.**# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a) The permittee shall ensure that the exhaust fan amperage readings from the Nib Grinding #3 Mist Eliminator (Source ID: C07) shall not exceed 2.8 amps.

(b) The permittee shall notify DEP if the fan amperage exceeds the range in paragraph (b).

VII. ADDITIONAL REQUIREMENTS.**# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The Nib Grinding #3 Mist Eliminator (Source ID: C08) is manufactured by Munters, Model No. T-271.

**SECTION E. Source Group Restrictions.**

Group Name: GRP 1

Group Description: Pre-Roasting Process and Roasters #1 and #2

Sources included in this group

| ID | Name |
|-----|----------------------|
| 102 | PRE-ROASTING PROCESS |
| 105 | ROASTER #1 |
| 108 | ROASTER #2 |

I. RESTRICTIONS.**Fuel Restriction(s).**

001 [25 Pa. Code §127.441]

Operating permit terms and conditions.

The permittee shall ensure that Source ID(s): 102, 105 and 108 shall only burn natural gas for fuel.

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

III. MONITORING REQUIREMENTS.

002 [25 Pa. Code §127.441]

Operating permit terms and conditions.

The permittee shall monitor the total, combined fuel usage for Source ID(s): 102, 105 and 108 on a monthly basis and as a 12-month rolling sum.

IV. RECORDKEEPING REQUIREMENTS.

003 [25 Pa. Code §127.441]

Operating permit terms and conditions.

The permittee shall record the total, combined fuel usage of natural gas for Source ID(s): 102, 105 and 108 on a monthly basis and as a 12-month rolling sum.

004 [25 Pa. Code §127.441]

Operating permit terms and conditions.

The permittee shall maintain records to demonstrate compliance with the combustion tune-up requirements described herein this operating permit for Source ID(s): 102, 105 and 108, including, but not limited to dates and any corrective actions taken.

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

VI. WORK PRACTICE REQUIREMENTS.

005 [25 Pa. Code §127.441]

Operating permit terms and conditions.

(a) The permittee shall ensure that all process emissions from Roaster #1 (Source ID: 105), its associated cooling drum cycle and Roaster #2 (Source ID: 108) shall be exhausted to the Anguil Regenerative Thermal Oxidizer (Source ID: C06) at all times when the roasters and the cooling drum are operating.

(b) The permittee shall ensure that neither Roaster #1 (Source ID: 105), its associated cooling drum, nor Roaster #2 (Source ID: 108), shall bypass the Anguil Regenerative Thermal Oxidizer (RTO) (Source ID: C06) unless one of the sources or the RTO malfunctions, causing risk of damage to equipment or harm to those present. Under such circumstances, Roaster #1 (Source ID: 105, its associated cooling drum and Roaster #2 (Source ID: 108) may complete the current batch of cocoa bean nibs if it is possible to do so. Roaster #1 (Source ID: 105), its associated cooling drum, or Roaster #2 (Source ID: 108), shall then be shut down until the source(s) and the control device are operating properly.

**SECTION E. Source Group Restrictions.****# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall ensure that a tune-up shall be performed on the combustion systems for Source ID(s): 102, 105 and 108 every 12 months to ensure that the burners are operating properly.

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

**SECTION E. Source Group Restrictions.**

Group Name: GRP 2

Group Description: Nib Grinding Lines #1, #2 and #3

Sources included in this group

| ID | Name |
|------|----------------------|
| 106A | NIB GRINDING LINE #1 |
| 106B | NIB GRINDING LINE #2 |
| 106D | NIB GRINDING LINE #3 |

I. RESTRICTIONS.

No additional requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

II. TESTING REQUIREMENTS.**# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a) The permittee shall perform an EPA Method 204 test to show that the rooms for the Nib Grinding Line #1 (Source ID: 106A), the Nib Grinding Line #2 (Source ID: 106B) and the Nib Grinding Line #3 (Source ID: 106D) meet the criteria for total enclosure as defined within Method 204.

(b) A Method 204 test shall be performed every 5 years unless the permittee can demonstrate that there are no fugitive VOC emissions resulting from the nib grinding operation based on previously approved testing of this source(s) and no modifications to the sources have occurred.

(c) All supporting documentation shall be submitted to the Department within 60 days after the Method 204 test has been performed.

III. MONITORING REQUIREMENTS.

No additional monitoring requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

IV. RECORDKEEPING REQUIREMENTS.

No additional record keeping requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

VI. WORK PRACTICE REQUIREMENTS.**# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a) The permittee shall ensure that the primary grinders associated with the Nib Grinding Line #1 (Source ID: 106A), the Nib Grinding Line #2 (Source ID: 106B) and the Nib Grinding Line #3 (Source ID: 106D) shall not be operated unless all emissions from the primary grinders are being directed to the Nib Grinding Line #1 Mist Eliminator (Source ID: C04), the Nib Grinding Line #2 Mist Eliminator (Source ID: C07) or to the Nib Grinding Line #3 Mist Eliminator (Source ID: C08) and then to the Anguil Regenerative Thermal Oxidizer (Source ID: C06).

(b) The permittee shall ensure that the Nib Grinding Line #1 Mist Eliminator (Source ID: C04), the Nib Grinding Line #2 Mist Eliminator (Source ID: C07), the Nib Grinding Line #3 Mist Eliminator (Source ID: C08) and the Anguil Regenerative Thermal Oxidizer (Source ID: C06) are operating in accordance with the requirements of this operating permit.

003 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall ensure that the intermediate grinders, the fine grinders, and the various holding tanks associated with the Nib Grinding Line #1 (Source ID: 106A), the Nib Grinding Line #2 (Source ID: 106B) and the Nib Grinding Line #3

**SECTION E. Source Group Restrictions.**

(Source ID: 108D) shall operate in a room meeting the criteria of a total enclosure, as defined by EPA's Reference Method 204.

(b) The permittee shall ensure that these sources shall not be operated unless all room air and process emissions are being directed to the Anguil Regenerative Thermal Oxidizer (Source ID: C06) and the Anguil Regenerative Thermal Oxidizer are operated in accordance with the requirements of this operating permit.

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

**SECTION E. Source Group Restrictions.**

Group Name: GRP 3

Group Description: Nib Grinding Mist Eliminators #1, #2 and #3

Sources included in this group

| ID | Name |
|-----|---------------------------------|
| C04 | NIB GRINDING #1 MIST ELIMINATOR |
| C07 | NIB GRINDING #2 MIST ELIMINATOR |
| C08 | NIB GRINDING #3 MIST ELIMINATOR |

I. RESTRICTIONS.

No additional requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

III. MONITORING REQUIREMENTS.**# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall monitor the amperage of the fan motors associated with the Nib Grinding Mist Eliminators (Source ID(s): C04, C07 and C08) on a daily basis.

IV. RECORDKEEPING REQUIREMENTS.**# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a) The permittee shall record the water flow rate(s) through the filter module(s) on a daily basis.

(b) The permittee shall record the amperage of the fan motors associated with the Nib Grinding Mist Eliminators (Source ID(s): C04, C07 and C08) on a daily basis.

(c) The permittee shall maintain a bi-weekly log of the following:

(1) The cleaning of the filter module(s), the condition of the filter module(s), and if either needs replacing.

(2) The cleaning of the water flow gauge(s) associated with these control devices (Source ID(s): C04, C07 and C08).

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).

VI. WORK PRACTICE REQUIREMENTS.**# 003 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a) The permittee shall ensure that the Nib Grinding Mist Eliminators (Source ID(s): C04, C07 and C08) shall be equipped with a gauge to show the water flow through the filter module(s).

(b) The permittee shall ensure that the water gauges associated with the Nib Grinding Mist Eliminators (Source ID(s): C04, C07 and C08) shall be cleaned on a bi-weekly basis, such that it can always be clearly read when the mist eliminator is being operated.

(c) The permittee shall ensure that the nib grinding mist eliminators filter modules shall be cleaned and inspected on a bi-weekly basis.

**SECTION E. Source Group Restrictions.****# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall ensure that the water flow rate associated with each Nib Grinding Mist Eliminator module shall be maintained at around 2.0 gallons per minute but not less than 1.5 gallons per minute.

005 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

(a) The permittee shall ensure that each of the Nib Grinding Mist Eliminators (Source ID(s): C04, C07 and C08) shall have ports upstream and downstream such that, if necessary, the pressure drop across the control devices can be determined across each control device module.

(b) The pressure drop across each of the Nib Grinding Mist Eliminators (Source ID(s): C04, C07 and C08) shall be monitored upon the request of the Department.

006 [25 Pa. Code §127.441]**Operating permit terms and conditions.**

The permittee shall ensure that the associated Nib Grinding Mist Eliminator (Source ID(s): C04, C07 and C08) shall be operated at all times when either of the Nib Grinding Lines (Source ID(s): 106A, 106B and 106D) are in operation.

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (State Only General Requirements).



SECTION F. Alternative Operation Requirements.

No Alternative Operations exist for this State Only facility.

**SECTION G. Emission Restriction Summary.**

| Source Id | Source Description | | |
|-----------------------|--------------------------------------|------------------------|------|
| 031 | BOILER (CBLE200-500) | | |
| Emission Limit | | Pollutant | |
| 300.000 | PPMV | 3% oxygen, dry basis | CO |
| 30.000 | PPMV | 3% oxygen, dry basis | NOX |
| 0.400 | Lbs/MMBTU | particulate matter | TSP |
| 103 | WINNOWING PROCESS - ROTARY SCREEN | | |
| Emission Limit | | Pollutant | |
| 0.020 | gr/DRY FT3 | particulate matter | TSP |
| 104 | WINNOWER AIR CLASSIFICATION | | |
| Emission Limit | | Pollutant | |
| 0.020 | gr/DRY FT3 | particulate matter | TSP |
| 105 | ROASTER #1 | | |
| Emission Limit | | Pollutant | |
| 0.020 | gr/DRY FT3 | Particulate Matter | TSP |
| 108 | ROASTER #2 | | |
| Emission Limit | | Pollutant | |
| 0.020 | gr/DRY FT3 | Particulate Matter | TSP |
| 700 | ONAN 250DFAC GENSET | | |
| Emission Limit | | Pollutant | |
| 8.500 | GRAMS/HP-Hr | | CO |
| 1.000 | GRAMS/HP-Hr | | NMHC |
| 2.750 | Tons/OZNESEAS | all IC engines on site | NOX |
| 6.600 | Tons/Yr | 12-month rolling sum | NOX |
| 6.900 | GRAMS/HP-Hr | | NOX |
| 100.000 | Lbs/Hr | all IC engines on site | NOX |
| 1,000.000 | Lbs/Day | al IC engines on site | NOX |
| 500.000 | PPMV | dry basis | SOX |
| 0.040 | gr/DRY FT3 | particulate matter | TSP |
| 0.400 | GRAMS/HP-Hr | particulate matter | TSP |
| C06 | ANGUIL REGENERATIVE THERMAL OXIDIZER | | |
| Emission Limit | | Pollutant | |
| 1.040 | Lbs/Hr | | NOX |
| 4.480 | Tons/Yr | 12-month rolling sum | NOX |
| 0.020 | gr/DRY FT3 | Particulate Matter | TSP |
| 0.730 | Lbs/Hr | | VOC |
| 3.140 | Tons/Yr | 12-month rolling sum | VOC |

**SECTION G. Emission Restriction Summary.****Site Emission Restriction Summary**

| Emission Limit | | Pollutant |
|-----------------|----------------------|-----------|
| 24.900 Tons/Yr | 12-month rolling sum | NOX |
| 24.900 Tons/Yr | 12-month rolling sum | VOC |
| 100.000 Tons/Yr | 12-month rolling sum | PM10 |
| 100.000 Tons/Yr | 12-month rolling sum | PM2.5 |

**SECTION H. Miscellaneous.**

(a) The following previously plan approvals, operating permits and Request For Determinations (RFD) serve as the basis for certain terms and conditions in this State Only Operating Permit No. 23-00108:

- (1) 23-302-143GP (One 20-16 MMBtu/hr Combustion Unit)
- (2) BAQ-GPA/GP1-23-015 (20.16 MMBtu/hr Combustion Unit)
- (3) Plan Approval No. 23-0108 (Construction of a cocoa processing facility)
- (4) Plan Approval No. 23-0108A (modification of a cocoa processing facility, installation of an alkalization process and a thermal oxidizer and to increase production from 40% to 100% capacity)
- (5) Plan Approval No. 23-0108B (modifies Plan Approval 23-0108A and for the installation of a RTO)
- (6) Plan Approval No. 23-0108C (change in short term and annual NOx emission limit for the RTO)
- (7) Plan Approval No. 23-0108D (Construction of G.W. Barth Alkalizer on Roaster #1, installation of Roaster #2, and installation of Nib Grinding Line #3)
- (8) Request For Determination (RFD) No. 9662 for the installation of the exempted Cake Alkalizer

(b) In accordance with 25 Pa. Code Section 123.1, whenever cocoa bean shells are loaded out from the Shell Silos into trucks, there shall be no fugitive emissions.

(c) Particulate Matter (PM) resulting from the Bean Receiving System shall be controlled by a dust collector and vented indoors, such that there shall be no outdoor emissions from this operation. The Bean Receiving System dust collector shall not be exhausted outdoors without prior approval from the Department.

(d) PM from the Bean Cleaning operation shall be directed to a cyclone and exhausted indoors only. The Bean Cleaning cyclone shall not be exhausted outdoors without prior approval from the Department.

(e) The following are insignificant sources (also referenced as trivial activities in "Air Quality Permit Exemptions," Document No. 275-2101-003, July 26, 2003) at the facility:

(1) Euroboiler: 793,000 BTU/hr; natural gas fired; per 40 CFR § 63.11195, this boiler is not subject to 40 CFR Part 63, Subpart JJJJJ.

(2) Cocoa Presses, Powder Lines, Cocoa Liquor and Cocoa Butter Melter Tanks (RFD No. 23-A01-926).

(3) Laboratory, for quality control testing of cocoa products (equipped with two (2) laboratory fume hoods, each rated for 1,000 acfm).

(4) Cake Alkalizer (exempted under RFD No. 9662).

(f) The State Only Operating Permit 23-00108 (APS ID: 921527, AUTH ID: 1148300) has been amended to incorporate the requirements of Plan Approval No. 23-0108D.

(g) The State Only Operating Permit 23-00108 (APS ID: 921527, AUTH ID: 1216042) has been renewed.

(h) The State Only Operating Permit 23-00108 (APS ID: 921527, AUTH ID: 1417716) has been renewed.

(i) The State Only Operating Permit 23-00108 (APS ID: 921527, AUTH ID: 1451098) has been modified for the installation of the Nib Grinding Line #3 (Source ID: 106D) and the Nib Grinding Line #3 Mist Eliminator (Source ID: C08) at the Eddystone facility.



***** End of Report *****
