



COMMONWEALTH OF PENNSYLVANIA
DEPARTMENT OF ENVIRONMENTAL PROTECTION
AIR QUALITY PROGRAM

PLAN APPROVAL

Issue Date: January 23, 2026

Effective Date: January 23, 2026

Expiration Date: July 22, 2027

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 construct, install, modify or reactivate the air emission source(s) more fully described in the site inventory list. This Facility is subject to all terms and conditions specified in this plan approval. Nothing in this plan approval 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 plan approval condition is set forth in brackets. All terms and conditions in this permit are federally enforceable unless otherwise designated as "State-Only" requirements.

Plan Approval No. 48-00003K

Federal Tax Id - Plant Code: 20-2268581-1

Owner Information

Name: KEYSTONE CEMENT CO

Mailing Address: PO BOX A
BATH, PA 18014-0058

Plant Information

Plant: KEYSTONE PORTLAND CEMENT/EAST ALLEN

Location: 48 Northampton County 48915 East Allen Township

SIC Code: 3241 Manufacturing - Cement, Hydraulic

Responsible Official

Name: YONN H. BARRICK

Title: VP AND GENERAL MGR.

Phone: (717) 599 - 1719

Email: ybarrick@keystonecement.com

Plan Approval Contact Person

Name: CHRISTOPHER MADDEN

Title: ENV COMPLIANCE MGR

Phone: (839) 600 - 8172

Email: cmadden@keystonecement.com

[Signature] _____

MARK J. WEJKSZNER, NORTHEAST REGION AIR PROGRAM MANAGER



Plan Approval Description

This plan approval is for the installation of an additional baghouse for the dedicated particulate emissions control from the storage silos (C86). The clinker elevator, drag belt, and storage silos (Source ID 256) is currently controlled by one existing baghouse (C85). Installation of the additional baghouse is to provide additional particulate control and to reduce particulate loading on the existing baghouse and provide enhanced particulate control.



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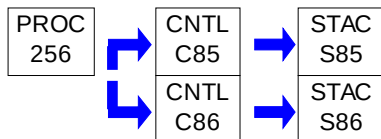
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**SECTION A. Plan Approval Inventory List**

Source ID	Source Name	Capacity/Throughput	Fuel/Material
256	CLINKER ELEVATOR, DRAG BELT, & SILO STORAGE		
C85	CLINKER ELEVATOR & DRAG BELT FABRIC COLLECTOR		
C86	STORAGE SILOS DUST COLLECTOR		
S85	CLINKER ELEVATOR AND DRAG BELT FABRIC FILTER STACK		
S86	STORAGE SILOS DUST COLLECTOR STACK		

PERMIT MAPS

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

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

#002 [25 Pa. Code § 127.12b (a) (b)]**Future Adoption of Requirements**

The issuance of this plan approval does not prevent the future adoption by the Department of any rules, regulations or standards, or the issuance of orders necessary to comply with the requirements of the Federal Clean Air Act or the Pennsylvania Air Pollution Control Act, or to achieve or maintain ambient air quality standards. The issuance of this plan approval shall not be construed to limit the Department's enforcement authority.

#003 [25 Pa. Code § 127.12b]**Plan Approval Temporary Operation**

This plan approval authorizes temporary operation of the source(s) covered by this plan approval provided the following conditions are met.

(a) When construction, installation, modification, or reactivation is being conducted, the permittee shall provide written notice to the Department of the completion of the activity approved by this plan approval and the permittee's intent to commence operation at least five (5) working days prior to the completion of said activity. The notice shall state when the activity will be completed and when the permittee expects to commence operation. When the activity involves multiple sources on different time schedules, notice is required for the commencement of operation of each source.

(b) Pursuant to 25 Pa. Code § 127.12b (d), temporary operation of the source(s) is authorized to facilitate the shakedown of sources and air cleaning devices, to permit operations pending the issuance of a permit under 25 Pa. Code Chapter 127, Subchapter F (relating to operating permits) or Subchapter G (relating to Title V operating permits) or to permit the evaluation of the air contaminant aspects of the source.

(c) This plan approval authorizes a temporary operation period not to exceed 180 days from the date of commencement of operation, provided the Department receives notice from the permittee pursuant to paragraph (a), above.

(d) The permittee may request an extension of the 180-day shakedown period if further evaluation of the air contamination aspects of the source(s) is necessary. The request for an extension shall be submitted, in writing, to the Department at least 30 days prior to the end of the initial 180-day shakedown period and shall provide a description of the compliance status of the source, a detailed schedule for establishing compliance, and the reasons compliance has not been established. This temporary operation period will be valid for a limited time and may be extended for additional limited periods, each not to exceed 180 days.

(e) The notice submitted by the permittee pursuant to subpart (a) above, prior to the expiration of the plan approval, shall modify the plan approval expiration date on Page 1 of this plan approval. The new plan approval expiration date shall be 180 days from the date of commencement of operation.

#004 [25 Pa. Code § 127.12(a) (10)]**Content of Applications**

The permittee shall maintain and operate the sources and associated air cleaning devices in accordance with good engineering practice as described in the plan approval application submitted to the Department.

#005 [25 Pa. Code §§ 127.12(c) and (d) & 35 P.S. § 4013.2]**Public Records and Confidential Information**

(a) The records, reports or information obtained by the Department or referred to at public hearings shall be available to the public, except as provided in paragraph (b) of this condition.

(b) Upon cause shown by the permittee that the records, reports or information, or a particular portion thereof, but not emission data, to which the Department has access under the act, if made public, would divulge production or sales figures or methods, processes or production unique to that person or would otherwise tend to affect adversely the

**SECTION B. General Plan Approval Requirements**

competitive position of that person by revealing trade secrets, including intellectual property rights, the Department will consider the record, report or information, or particular portion thereof confidential in the administration of the act. The Department will implement this section consistent with sections 112(d) and 114(c) of the Clean Air Act (42 U.S.C.A. § 7412(d) and 7414(c)). Nothing in this section prevents disclosure of the report, record or information to Federal, State or local representatives as necessary for purposes of administration of Federal, State or local air pollution control laws, or when relevant in a proceeding under the act.

#006 [25 Pa. Code § 127.12b]**Plan Approval Terms and Conditions**

[Additional authority for this condition is derived from 25 Pa. Code Section 127.13]

(a) This plan approval will be valid for a limited time, as specified by the expiration date contained on Page 1 of this plan approval. Except as provided in § § 127.11a and 127.215 (relating to reactivation of sources; and reactivation), at the end of the time, if the construction, modification, reactivation or installation has not been completed, a new plan approval application or an extension of the previous approval will be required.

(b) If construction has commenced, but cannot be completed before the expiration of this plan approval, an extension of the plan approval must be obtained to continue construction. To allow adequate time for departmental action, a request for the extension shall be postmarked at least thirty (30) days prior to the expiration date. The request for an extension shall include the following:

- (i) A justification for the extension,
- (ii) A schedule for the completion of the construction

If construction has not commenced before the expiration of this plan approval, then a new plan approval application must be submitted and approval obtained before construction can commence.

(c) If the construction, modification or installation is not commenced within 18 months of the issuance of this plan approval or if there is more than an 18-month lapse in construction, modification or installation, a new plan approval application that meets the requirements of 25 Pa. Code Chapter 127, Subchapter B (related to plan approval requirements), Subchapter D (related to prevention of significant deterioration of air quality), and Subchapter E (related to new source review) shall be submitted. The Department may extend the 18-month period upon a satisfactory showing that an extension is justified.

#007 [25 Pa. Code § 127.32]**Transfer of Plan Approvals**

(a) This plan approval may not be transferred from one person to another except when a change of ownership is demonstrated to the satisfaction of the Department and the Department approves the transfer of the plan approval in writing.

(b) Section 127.12a (relating to compliance review) applies to a request for transfer of a plan approval. A compliance review form shall accompany the request.

(c) This plan approval is valid only for the specific source and the specific location of the source as described in the application.

#008 [25 Pa. Code § 127.12(a)(4) & 35 P.S. § 4008 & § 114 of the CAA]**Inspection and Entry**

(a) 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.

(b) The permittee shall also allow the Department to have access at reasonable times to said sources and associated air cleaning devices with such measuring and recording equipment, including equipment recording visual observations, as the Department deems necessary and proper for performing its duties and for the effective enforcement of the Air Pollution Control Act and regulations adopted under the act.

**SECTION B. General Plan Approval Requirements**

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

#009 [25 Pa. Code 127.13a]**Plan Approval Changes for Cause**

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

- (a) The permittee constructs or operates the source subject to the plan approval in violation of the act, the Clean Air Act, the regulations promulgated under the act or the Clean Air Act, a plan approval or permit or in a manner that causes air pollution.
- (b) 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.
- (c) The permittee fails to submit a report required by this plan approval.
- (d) The Environmental Protection Agency determines that this plan approval is not in compliance with the Clean Air Act or the regulations thereunder.

#010 [25 Pa. Code §§ 121.9 & 127.216]**Circumvention**

- (a) The permittee, or any other person, may not circumvent the new source review requirements of 25 Pa. Code Chapter 127, Subchapter E by causing or allowing a pattern of ownership or development, including the phasing, staging, delaying or engaging in incremental construction, over a geographic area of a facility which, except for the pattern of ownership or development, would otherwise require a permit or submission of a plan approval application.
- (b) 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 this plan approval, the Air Pollution Control Act or the regulations promulgated thereunder, except that with prior approval of the Department, the device or technique may be used for control of malodors.

#011 [25 Pa. Code § 127.12c]**Submissions**

Reports, test data, monitoring data, notifications shall be submitted to the:

Regional Air Program Manager
PA Department of Environmental Protection
(At the address given on the plan approval transmittal letter or otherwise notified)

#012 [25 Pa. Code § 127.12(a)(9) & 40 CFR Part 68]**Risk Management**

- (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 listed threshold quantity at the facility. The permittee shall submit the RMP to the Environmental Protection Agency according to the following schedule and requirements:
 - (1) The permittee shall submit the first RMP to a central point specified by the Environmental Protection Agency no later than the latest of the following:

**SECTION B. General Plan Approval Requirements**

- (i) Three years after the date on which a regulated substance is first listed under § 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 the Environmental Protection Agency 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 plan approval 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.

#013 [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. §§ 4001-4015).

#014 [25 Pa. Code § 127.25]**Compliance Requirement**

A person may not cause or permit the operation of a source subject to § 127.11 (relating to plan approval requirements), unless the source and air cleaning devices identified in the application for the plan approval and the plan approval issued to the source, are operated and maintained in accordance with specifications in the application and conditions in the plan approval issued by the Department. A person may not cause or permit the operation of an air contamination source subject to this chapter in a manner inconsistent with good operating practices.

**SECTION C. Site Level Plan Approval Requirements****I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §123.1]****Prohibition of certain fugitive emissions**

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

- (1) Construction or demolition of buildings or structures.
- (2) Grading, paving and maintenance 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.
- (7) Blasting in open pit mines. Emissions from drilling are not considered as emissions from blasting.
- (8) Sources and classes of sources other than those identified in paragraphs (1)-(7), for which the operator has obtained a determination from the Department that fugitive emissions from the source, after appropriate control, 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.

002 [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 Site Level Condition #001 if such emissions are visible at the point the emissions pass outside the person's property.

003 [25 Pa. Code §123.31]**Limitations****Malodor Emissions**

- 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.

- At no time shall the utilization of waste fuels result in malodorous emission

004 [25 Pa. Code §123.41]**Limitations****Visible Emissions**

(a) A person may not permit the emission into the outdoor atmosphere of any visible air contaminants in such a manner that the opacity of the emission is either of the following:

- (1) Equal to or greater than 20% for a period or periods aggregating more than three minutes in any 1 hour.
- (2) Equal to or greater than 60% at any time.

(b) The limitations of this condition shall not apply to a visible emission in any of the following instances:

- (1) When the presence of uncombined water is the only reason for failure of the emission to meet limitation.
- (2) When the emission results from the operation of equipment used solely to train and test persons in observing the opacity of visible emissions.
- (3) When the emissions result from sources specified in Site Level Condition #001.

II. TESTING REQUIREMENTS.**# 005 [25 Pa. Code §123.43]****Measuring techniques**

(a) Visible Emissions may be measured using either of the following:

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

**SECTION C. Site Level Plan Approval Requirements**

the Department.

006 [25 Pa. Code §127.511]**Monitoring and related recordkeeping and reporting requirements.**

All sampling, testing and analysis performed in compliance with the requirements of any section of the permit shall be done in accordance with SECTION B - General Title V Requirement #023.

007 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

If at any time the Department has cause to believe that air contaminant emissions from the aforementioned sources may be in excess of the limitations specified in, or established pursuant to, any applicable rule or regulation contained in Article III of the Rules and Regulations of the Department of Environmental Protection, the company shall be required to conduct whatever tests are deemed necessary by the Department to determine the actual emission rate(s). Such testing shall be conducted in accordance with the provisions of Chapter 139 of the Rules and Regulations of the Department of Environmental Protection, where applicable, and in accordance with any restrictions or limitations established by the Department at such time as it notified the company testing is required.

III. MONITORING REQUIREMENTS.**# 008 [25 Pa. Code §127.511]****Monitoring and related recordkeeping and reporting requirements.**

The permittee shall record the pressure drop (for sources not handled by an opacity CEM or CPMS) across the fabric collectors or other devices used to control point source particulate matter emissions at the facility. At a minimum, these recordings shall be taken once per week, while the sources and collectors are in operation. If the observer is unable to record the pressure drop due to unit downtime, etc., the observer shall note such conditions on the data record sheet. The permittee shall attempt to record the pressure drop daily until a valid measurement is obtained.

009 [25 Pa. Code §127.511]**Monitoring and related recordkeeping and reporting requirements.****Visible Emissions**

(a) At least once per month, visual emission checks of each emission point subject to an opacity limit (excluding sources covered by an opacity CEM or CPMS) shall be conducted during periods of normal facility operation for a sufficient time interval to determine if the unit has visible emissions present. If sources of visible emissions are identified during the survey, or at any other time, the permittee shall conduct a 40 CFR §60 Appendix A, Method 9 evaluation within one (1) hour. A Method 9 evaluation shall not be required if the visible emission condition is corrected in a timely manner and the units are operating at normal operating conditions. For the purposes of this requirement, the duration of the Method 9 observations may be reduced from 3 hours (thirty 6-minute averages) to 1 hour (ten 6-minute averages) only if the following conditions apply:

- (1) There are no individual readings greater than 10% opacity; and
- (2) There are no more than 3 readings of 10% for the 1-hour period.

A record of each visible emission check required above shall be maintained in a form suitable and readily available for expeditious inspection and review. The files shall be retained for at least 5 years following the date of each occurrence, measurement, maintenance, corrective action, report, or record. At a minimum, the most recent 2 years of data shall be retained on site. The remaining 3 years of data may be retained off site. Such files may be maintained on electronic or other acceptable data storage media. Said record shall include, but not be limited to, the date, time, name of emission unit, the applicable visible emissions requirement, the results of the check, what action(s), if any, was/were taken and the name of the observer. In the event that visible emissions are observed and that Method 9 readings are required, prior notification and a pre-test plan are not required to be submitted for each set of observations conducted.

(b) The permittee shall use the following monitoring schedule for conducting the visible emissions observations required by this condition:

- (1) The monitoring frequency for determining the presence of visible emissions is once per month.
- (2) If the observations conducted during six (6) consecutive months of operation show no visible emissions, the observations need only be done semi-annually;

**SECTION C. Site Level Plan Approval Requirements**

(3) If an opacity exceedance occurs, the tests for the exceeding monitoring point will start over with monthly checks according to the monitoring frequency detailed above.

(c) All visible emissions observations shall be conducted during operating conditions that have the potential to create visible emissions.

(d) If the observer is unable to conduct the observations due to unit downtime, visual interference's caused by other visible emission sources (e.g. fugitive emissions during high wind conditions), due to weather conditions such as fog, heavy rain, snow, or due to other causes such as lack of daylight, etc., the observer shall note such conditions on the data observation sheet. The permittee shall attempt to make the observations daily until a valid observation period is completed.

(e) For units that operate intermittently or seasonally, the required observations shall be scheduled to occur on a monthly basis during the operating periods or operating season only.

(f) A record of each visible emission observation required above shall be maintained in a form suitable and readily available for expeditious inspection and review. Said record shall include, but not be limited to, the date, time, name of emission unit, the applicable visible emissions requirement, the results of the observation, what action(s), if any, was/were taken, and the name of the observer. The files shall be retained for at least 5 years following the date of each occurrence, measurement, maintenance, corrective action, report, or record. At a minimum, the most recent 2 years of data shall be retained on site. The remaining 3 years of data may be retained off site. Such files may be maintained on electronic or other acceptable data storage media.

(g) If a unit is subject to a opacity and monitoring requirement under 40 CFR Part 63, the facility shall demonstrate compliance using the monitoring standard specified in the applicable 40 CFR Part 63 requirement.

010 [25 Pa. Code §127.511]**Monitoring and related recordkeeping and reporting requirements.**

Each permitted fabric collector must be equipped with a device for monitoring the pressure differential.

011 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

(a) All fabric collectors must be equipped with a device for monitoring the pressure differential across the collectors.

(b) Whenever the sources are in operation, the control devices for these sources shall be in operation. On a weekly basis, the control devices for these sources shall be inspected. The inspection shall consist of a visible inspection to insure compliance with SECTION C - Condition #004.

(1) The range of the pressure differential will be the normal range based on operational history consistent with normal and proper operation of the baghouse.

(c) The company shall keep on hand a sufficient quantity of spare fabric collector bags for all control devices that may require immediate replacement due to deterioration resulting from routine operation of the sources and fabric collectors.

012 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

The company shall ensure that the control devices shall be equipped with the applicable monitoring equipment and that equipment shall be installed, calibrated, operated and maintained according to the good engineering/operating practices at all times the control device is in use.

IV. RECORDKEEPING REQUIREMENTS.**# 013 [25 Pa. Code §127.511]****Monitoring and related recordkeeping and reporting requirements.**

Visible Emissions

The permittee shall maintain records of all visible emission inspections and any exceedance of the visible emission limitations, (for sources not handled by an Opacity CEM or CPMS).

**SECTION C. Site Level Plan Approval Requirements****# 014 [25 Pa. Code §127.511]****Monitoring and related recordkeeping and reporting requirements.**

All records, reports and analytical results required by or generated to demonstrate compliance with the requirements of any section of this permit shall be maintained in accordance with SECTION B - General Title V Requirement #024, and shall be made available to the Department upon written or verbal request at a reasonable time.

015 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

The company shall maintain a file containing all records and other data that are required to be collected under the various provisions of the Title V Operating Permit. The file shall include, but not be limited to: all air pollution control systems performance evaluations and records of calibration checks, adjustments and maintenance performed on all equipment which is subject to this Title V Operating Permit. Measurements, records and other data required to be maintained by the company shall be retained for at least 2 years following the date on which the measurements, records or other data are recorded.

016 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

The permittee shall record the pressure drop across the fabric collectors. At a minimum, these recordings shall be taken once per week while the source and collectors are in operation. The recordings shall be maintained in a logbook and available to the Department upon request. The company may submit alternative methods and/or plans for approval to the Department for substitution of the requirement.

V. REPORTING REQUIREMENTS.**# 017 [25 Pa. Code §127.511]****Monitoring and related recordkeeping and reporting requirements.**

The Department shall be notified promptly of determining any failure to process equipment or the material being processed, failure of air pollution control equipment or a process operational error, which results in an increase in emissions above any allowable emission limits. In addition, the Department shall be notified in writing within five (5) days following the determination of such failure. The notification shall, at a minimum, include a statement identifying when the failure occurred, the duration of the excess emissions, and measures taken to correct the problem. The Department may take enforcement action for any violations of the applicable standards.

[Additional authority for this permit condition is derived from 25 Pa. Code Section 127.511(c).]

The permittee shall report malfunctions that result in excess emissions which occur at the Title V facility to the Department. As defined in 40 CFR Section 60.2 and incorporated by reference in 25 Pa. Code Chapter 122, 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. Failures that are caused in part by poor maintenance or careless operation are not malfunctions. Malfunctions shall be reported as follows:

(a) Malfunctions which occur at the Title V facility and which pose an imminent danger to public health, safety, welfare and the environment, shall be immediately reported to the Department by telephone. The telephone report of such malfunctions shall occur no later than two hours after the incident. The permittee shall submit a written report of instances of such malfunctions to the Department within three (3) days of the telephone report.

(b) Unless otherwise required by this permit, any other malfunction that is not subject to the reporting requirements of condition (a) above shall be reported to the Department, in writing, within five (5) days of discovery of the malfunction.

018 [25 Pa. Code §127.511]**Monitoring and related recordkeeping and reporting requirements.**

On a quarterly basis, the permittee shall compile a report of all logged instances of exceedences of the visible emission limitations (for sources not handled by a COMS or CPMS) that occurred during the previous three months, to be submitted to the Department within thirty (30) days of the close of the calendar quarter. If no exceedences were noted, the report shall be maintained and be made available to the Department upon request.

**SECTION C. Site Level Plan Approval Requirements****# 019 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

Any changes in the location of the aforementioned sources, or any changes in the process or control equipment that would qualify as a modification will require the submittal of an amended application for plan approval in accordance with the provisions of 25 Pa. Code Sections 127.11 and 127.12.

020 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

The permittee is subject to the applicable requirements of the National Emission Standards for Hazardous Air Pollutants (NESHAP) for Portland Cement Plants 40 CFR Part 63, Subpart LLL and shall comply with all applicable requirements of this Subpart as well as the applicable NESHAP Subpart A General Provisions.

40 CFR Section 63.13 requires submission of all requests, reports, applications, submittals and other communications to both EPA and the Department. The EPA copies shall be forwarded to:
Director, Air Protection Division, 1650 Arch Street, Philadelphia, PA 19103

021 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

Any notification as a result of any condition herein should be directed to:

Regional Air Quality Program Manager
Department of Environmental Protection
2 Public Square
Wilkes-Barre, PA 18701-1915

022 [25 Pa. Code §127.513]**Compliance certification.**

The reporting period for the certificate of compliance required by SECTION B - Condition #026, shall be for the previous calendar year, and it shall be submitted within 60 days after the specified period but no later than March 1st.

VI. WORK PRACTICE REQUIREMENTS.**# 023 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The aforementioned sources may only be operated as long as the associated air pollution control devices are operated and maintained in accordance with the specifications set forth in the respective plan approvals and the applications submitted for said plan approvals, operating permits (as approved by the Department) and in accordance with any conditions set forth.

024 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

The company shall maintain and operate the air pollution control equipment and air contamination sources in accordance with good engineering practice.

VII. ADDITIONAL REQUIREMENTS.**# 025 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The company shall not impose conditions upon or otherwise restrict the Department's access to the aforementioned sources and/or any associated air cleaning device and shall allow the Department to have access at any time to said sources and associated air cleaning devices with such measuring and recording equipment, including equipment recording visual observations, as the Department deems necessary and proper for performing its duties and for the effective enforcement of the Air Pollution Control Act.

026 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

The storage and handling of the material collected in the air cleaning devices associated with the sources at the facility shall not at any time result in the emission of fugitive air contaminants in excess of the limitations specified in 25 Pa. Code Section 123.1.

**SECTION C. Site Level Plan Approval Requirements****# 027 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The permittee shall comply with all additional site level conditions in accordance with the Title V Operating Permit.

VIII. COMPLIANCE CERTIFICATION.

No additional compliance certifications exist except as provided in other sections of this plan approval including Section B (relating to Plan Approval General Requirements).

IX. COMPLIANCE SCHEDULE.

No compliance milestones exist.

**SECTION D. Source Level Plan Approval Requirements**

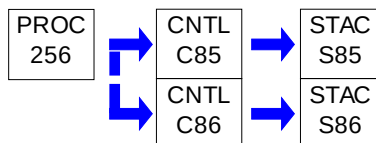
Source ID: 256

Source Name: CLINKER ELEVATOR, DRAG BELT, & SILO STORAGE

Source Capacity/Throughput:

Conditions for this source occur in the following groups: 29A

29D

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

001 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

Pursuant to the Best Available Technology (BAT) provision of 25 Pa. Code, Chapter 127.12(a)(5), fabric collector Control Device ID C86 is subject to the following air contaminant emission limits:

- i. The filterable particulate matter emissions in the exhaust of the dust collector (baghouse) shall not exceed 0.01 grains per dry standard cubic foot of effluent gas volume.

II. TESTING REQUIREMENTS.

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

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this plan approval including Section B (Plan Approval General Requirements) and/or Section E (Source Group Restrictions).

**SECTION E. Source Group Plan Approval Restrictions.**

Group Name: 29A

Group Description: Part 63 NESHAP LLL

Sources included in this group

ID	Name
256	CLINKER ELEVATOR, DRAG BELT, & SILO STORAGE

I. RESTRICTIONS.**Emission Restriction(s).****# 001 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1345]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Emissions limits for affected sources other than kilns; in-line kiln/raw mills; clinker coolers; new and reconstructed raw**

The owner or operator of each new or existing raw material, clinker, or finished product storage bin; conveying system transfer point; bagging system; bulk loading or unloading system; raw and finish mills; and each existing raw material dryer, at a facility which is a major source subject to the provisions of this subpart must not cause to be discharged any gases from these affected sources which exhibit opacity in excess of 10 percent.

[78 FR 10039, Feb. 12, 2013]

II. TESTING REQUIREMENTS.**# 002 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1348]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Compliance requirements.**

(a) Initial Performance Test Requirements. For an affected source subject to this subpart, you must demonstrate compliance with the emissions standards and operating limits by using the test methods and procedures in §§63.1349 and 63.7. Any cement kiln that has been subject to the requirements of subpart CCCC or subpart DDDD of 40 CFR Part 60, and is now electing to cease burning nonhazardous solid waste and become subject to this subpart, must meet all the initial compliance testing requirements each time it becomes subject to this subpart, even if it was previously subject to this subpart.

003 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1349]**Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Performance testing requirements.**

(a) You must document performance test results in complete test reports that contain the information required by paragraphs (a)(1) through (10) of this section, as well as all other relevant information. As described in §63.7(c)(2)(i), you must make available to the Administrator prior to testing, if requested, the site-specific test plan to be followed during performance testing. For purposes of determining exhaust gas flow rate to the atmosphere from an alkali bypass stack or a coal mill stack, you must either install, operate, calibrate and maintain an instrument for continuously measuring and recording the exhaust gas flow rate according to the requirements in paragraphs §63.1350(n)(1) through (10) of this subpart or use the maximum design exhaust gas flow rate. For purposes of determining the combined emissions from kilns equipped with an alkali bypass or that exhaust kiln gases to a coal mill that exhausts through a separate stack, instead of installing a CEMS on the alkali bypass stack or coal mill stack, you may use the results of the initial and subsequent performance test to demonstrate compliance with the relevant emissions limit.

- (1) A brief description of the process and the air pollution control system;
- (2) Sampling location description(s);
- (3) A description of sampling and analytical procedures and any modifications to standard procedures;
- (4) Test results;
- (5) Quality assurance procedures and results;
- (6) Records of operating conditions during the performance test, preparation of standards, and calibration procedures;
- (7) Raw data sheets for field sampling and field and laboratory analyses;
- (8) Documentation of calculations;
- (9) All data recorded and used to establish parameters for monitoring; and

**SECTION E. Source Group Plan Approval Restrictions.**

(10) Any other information required by the performance test method.

(b)(2) Opacity tests. If you are subject to limitations on opacity under this subpart, you must conduct opacity tests in accordance with Method 9 of appendix A-4 to part 60 of this chapter. The duration of the Method 9 performance test must be 3 hours (30 6-minute averages), except that the duration of the Method 9 performance test may be reduced to 1 hour if the conditions of paragraphs (b)(2)(i) and (ii) of this section apply. For batch processes that are not run for 3-hour periods or longer, compile observations totaling 3 hours when the unit is operating.

(i) There are no individual readings greater than 10 percent opacity;

(ii) There are no more than three readings of 10 percent for the first 1-hour period.

(e) Conditions of performance tests. Conduct performance tests under such conditions as the Administrator specifies to the owner or operator based on representative performance of the affected source for the period being tested. Upon request, you must make available to the Administrator such records as may be necessary to determine the conditions of performance tests.

III. MONITORING REQUIREMENTS.

No additional monitoring requirements exist except as provided in other sections of this plan approval including Section B (Plan Approval General Requirements).

IV. RECORDKEEPING REQUIREMENTS.

004 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1355]

Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry

Recordkeeping requirements.

(a) The owner or operator shall maintain files of all information (including all reports and notifications) required by this section recorded in a form suitable and readily available for inspection and review as required by §63.10(b)(1). The files shall be retained for at least five years following the date of each occurrence, measurement, maintenance, corrective action, report, or record. At a minimum, the most recent two years of data shall be retained on site. The remaining three years of data may be retained off site. The files may be maintained on microfilm, on a computer, on floppy disks, on magnetic tape, or on microfiche.

(b) The owner or operator shall maintain records for each affected source as required by §63.10(b)(2) and (b)(3) of this part; and

(1) All documentation supporting initial notifications and notifications of compliance status under §63.9;

(2) All records of applicability determination, including supporting analyses; and

(3) If the owner or operator has been granted a waiver under §63.8(f)(6), any information demonstrating whether a source is meeting the requirements for a waiver of recordkeeping or reporting requirements.

(c) In addition to the recordkeeping requirements in paragraph (b) of this section, the owner or operator of an affected source equipped with a continuous monitoring system shall maintain all records required by §63.10(c).

(g)

(1) You must keep records of the date, time and duration of each malfunction that causes an affected source to fail to meet an applicable standard; if there was also a monitoring malfunction, the date, time and duration of the monitoring malfunction; the record must list the affected source or equipment, an estimate of the volume of each regulated pollutant emitted over the standard for which the source failed to meet a standard, and a description of the method used to estimate the emissions.

(2) You must keep records of actions taken during periods of malfunction to minimize emissions in accordance with § 63.1348(d) including corrective actions to restore malfunctioning process and air pollution control and monitoring equipment to its normal or usual manner of operation.

(h) For each exceedance from an emissions standard or established operating parameter limit, you must keep records of the date, duration and description of each exceedance and the specific actions taken for each exceedance including inspections, corrective actions and repeat performance tests and the results of those actions.

**SECTION E. Source Group Plan Approval Restrictions.****V. REPORTING REQUIREMENTS.****# 005 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1353]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Notification requirements.**

(a) The notification provisions of 40 CFR part 63, subpart A that apply and those that do not apply to owners and operators of affected sources subject to this subpart are listed in Table 1 of this subpart. If any State requires a notice that contains all of the information required in a notification listed in this section, the owner or operator may send the Administrator a copy of the notice sent to the State to satisfy the requirements of this section for that notification.

(b) Each owner or operator subject to the requirements of this subpart shall comply with the notification requirements in §63.9 as follows:

(1) Initial notifications as required by §63.9(b) through (d). For the purposes of this subpart, a Title V or 40 CFR part 70 permit application may be used in lieu of the initial notification required under §63.9(b), provided the same information is contained in the permit application as required by §63.9(b), and the State to which the permit application has been submitted has an approved operating permit program under part 70 of this chapter and has received delegation of authority from the EPA. Permit applications shall be submitted by the same due dates as those specified for the initial notification.

(3) Notification of opacity and visible emission observations required by §63.1349 in accordance with §§63.6(h)(5) and 63.9(f).

(5) Notification of compliance status, as required by §63.9(h).

(6) Within 48 hours of an exceedance that triggers retesting to establish compliance and new operating limits, notify the appropriate permitting agency of the planned performance tests. The notification requirements of §§63.7(b) and 63.9(e) do not apply to retesting required for exceedances under this subpart.

006 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1354]**Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Reporting requirements.**

(a) The reporting provisions of subpart A of this part that apply and those that do not apply to owners or operators of affected sources subject to this subpart are listed in Table 1 of this subpart. If any State requires a report that contains all of the information required in a report listed in this section, the owner or operator may send the Administrator a copy of the report sent to the State to satisfy the requirements of this section for that report.

(b) The owner or operator of an affected source shall comply with the reporting requirements specified in §63.10 of the general provisions of this part 63, subpart A as follows:

(1) As required by §63.10(d)(2), the owner or operator shall report the results of performance tests as part of the notification of compliance status.

(2) As required by §63.10(d)(3), the owner or operator of an affected source shall report the opacity results from tests required by §63.1349.

(9) The owner or operator shall submit a summary report semiannually which contains the information specified in §63.10(e)(3)(vi). In addition, the summary report shall include:

(v) All failures to comply with any provision of the operation and maintenance plan developed in accordance with §63.1350(a).

(vii) In response to each violation of an emissions standard or established operating parameter limit, the date, duration and description of each violation and the specific actions taken for each violation including inspections, corrective actions and repeat performance tests and the results of those actions.

(c) Reporting a failure to meet a standard due to a malfunction. For each failure to meet a standard or emissions limit caused by a malfunction at an affected source, you must report the failure in the semi-annual compliance report required by §63.1354(b)(9). The report must contain the date, time and duration, and the cause of each event (including unknown cause, if applicable), and a sum of the number of events in the reporting period. The report must list for each event the affected source or equipment, an estimate of the volume of each regulated pollutant emitted over the emission limit for which the source failed to meet a standard, and a description of the method used to estimate the emissions. The report must also include a description of actions taken by an owner or operator during a malfunction of an affected source to minimize emissions in accordance with §63.1348(d), including actions taken to correct a malfunction.

**SECTION E. Source Group Plan Approval Restrictions.****VI. WORK PRACTICE REQUIREMENTS.****# 007 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1347]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Operation and maintenance plan requirements.**

(a) You must prepare, for each affected source subject to the provisions of this subpart, a written operations and maintenance plan. The plan must be submitted to the Administrator for review and approval as part of the application for a part 70 permit and must include the following information:

(1) Procedures for proper operation and maintenance of the affected source and air pollution control devices in order to meet the emissions limits and operating limits, including fugitive dust control measures for open clinker piles of §§ 63.1343, 63.1345, and 63.1346. Your operations and maintenance plan must address periods of startup and shutdown;

(2) Corrective actions to be taken when required by paragraph §63.1350(f)(3);

(3) n/a.

(b) Failure to comply with any provision of the operations and maintenance plan developed in accordance with this section is a violation of the standard.

[75 FR 55054, Sept. 9, 2010, as amended at 78 FR 10040, Feb. 12, 2013; 80 FR 44781, July 27, 2015]

VII. ADDITIONAL REQUIREMENTS.**# 008 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1340]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****What parts of my plant does this subpart cover?**

(a) The provisions of this subpart apply to each new and existing portland cement plant which is a major source or an area source as defined in §63.2.

(b) The affected sources subject to this subpart are:

(6) Each raw material, clinker, or finished product storage bin at any portland cement plant that is a major source;

(7) Each conveying system transfer point including those associated with coal preparation used to convey coal from the mill to the kiln at any portland cement plant that is a major source;

(d) If you are subject to any of the provisions of this subpart you are also subject to title V permitting requirements.

[75 FR 55051, Sept. 9, 2010, as amended at 78 FR 10036, Feb. 12, 2013]

**SECTION E. Source Group Plan Approval Restrictions.**

Group Name: 29D

Group Description: Part 63 NESHAP LLL

Sources included in this group

ID	Name
256	CLINKER ELEVATOR, DRAG BELT, & SILO STORAGE

I. RESTRICTIONS.**Emission Restriction(s).****# 001 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1345]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Emissions limits for affected sources other than kilns; in-line kiln/raw mills; clinker coolers; new and reconstructed raw**

The owner or operator of each new or existing raw material, clinker, or finished product storage bin; conveying system transfer point; bagging system; bulk loading or unloading system; raw and finish mills; and each existing raw material dryer, at a facility which is a major source subject to the provisions of this subpart must not cause to be discharged any gases from these affected sources which exhibit opacity in excess of 10 percent.

II. TESTING REQUIREMENTS.**# 002 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1348]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Compliance requirements.**

(a)(2) Opacity Compliance. If you are subject to the limitations on opacity under §63.1345, you must demonstrate compliance with the opacity emissions standards by using the performance test methods and procedures in §63.1349(b)(2). Use the maximum 6-minute average opacity exhibited during the performance test period to determine whether the affected source is in compliance with the standard.

(b)(3) Opacity Compliance. If you are subject to the limitations on opacity under §63.1345, you must demonstrate compliance using the monitoring methods and procedures in §63.1350(f) based on the maximum 6-minute average opacity exhibited during the performance test period. You must initiate corrective actions within one hour of detecting visible emissions above the applicable limit.

003 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1348]**Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Compliance requirements.**

(b)(2) Opacity tests. If you are subject to limitations on opacity under this subpart, you must conduct opacity tests in accordance with Method 9 of appendix A-4 to part 60 of this chapter. The duration of the Method 9 performance test must be 3 hours (30 6-minute averages), except that the duration of the Method 9 performance test may be reduced to 1 hour if the conditions of paragraphs (b)(2)(i) through (b)(2)(ii) of this section apply. For batch processes that are not run for 3-hour periods or longer, compile observations totaling 3 hours when the unit is operating.

(i) There are no individual readings greater than 10 percent opacity;

(ii) There are no more than three readings of 10 percent for the first 1-hour period.

III. MONITORING REQUIREMENTS.**# 004 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1350]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Monitoring requirements.**

(f) Opacity monitoring requirements. If you are subject to a limitation on opacity under §63.1345, you must conduct required opacity monitoring in accordance with the provisions of paragraphs (f)(1)(i) through (vii) of this section and in accordance with your monitoring plan developed under §63.1350(p). You must also develop an opacity monitoring plan in accordance with paragraphs (p)(1) through (4) and paragraph (o)(5), if applicable, of this section.

(1)(i) You must conduct a monthly 10-minute visible emissions test of each affected source in accordance with Method 22

**SECTION E. Source Group Plan Approval Restrictions.**

of appendix A-7 to part 60 of this chapter. The performance test must be conducted while the affected source is in operation.

(ii) If no visible emissions are observed in six consecutive monthly tests for any affected source, the owner or operator may decrease the frequency of performance testing from monthly to semi-annually for that affected source. If visible emissions are observed during any semi-annual test, you must resume performance testing of that affected source on a monthly basis and maintain that schedule until no visible emissions are observed in six consecutive monthly tests.

(iii) If no visible emissions are observed during the semi-annual test for any affected source, you may decrease the frequency of performance testing from semi-annually to annually for that affected source. If visible emissions are observed during any annual performance test, the owner or operator must resume performance testing of that affected source on a monthly basis and maintain that schedule until no visible emissions are observed in six consecutive monthly tests.

(iv) If visible emissions are observed during any Method 22 performance test, of appendix A-7 to part 60 of this chapter, you must conduct 30 minutes of opacity observations, recorded at 15-second intervals, in accordance with Method 9 of appendix A-4 to part 60 of this chapter. The Method 9 performance test, of appendix A-4 to part 60 of this chapter, must begin within 1 hour of any observation of visible emissions.

(3) If visible emissions are observed during any Method 22 visible emissions test conducted under paragraphs (f)(1) or (2) of this section, you must initiate, within one-hour, the corrective actions specified in your operation and maintenance plan as required in § 63.1347.

IV. RECORDKEEPING REQUIREMENTS.

No additional record keeping requirements exist except as provided in other sections of this plan approval including Section B (Plan Approval General Requirements).

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this plan approval including Section B (Plan Approval General Requirements).

VI. WORK PRACTICE REQUIREMENTS.

No additional work practice requirements exist except as provided in other sections of this plan approval including Section B (Plan Approval General Requirements).

VII. ADDITIONAL REQUIREMENTS.

005 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1340]

Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry

What parts of my plant does this subpart cover?

(a) The provisions of this subpart apply to each new and existing portland cement plant which is a major source or an area source as defined in §63.2.

(b) The affected sources subject to this subpart are:

(6) Each raw material, clinker, or finished product storage bin at any portland cement plant that is a major source;

(7) Each conveying system transfer point including those associated with coal preparation used to convey coal from the mill to the kiln at any portland cement plant that is a major source;

(d) If you are subject to any of the provisions of this subpart you are also subject to title V permitting requirements.

[75 FR 55051, Sept. 9, 2010, as amended at 78 FR 10036, Feb. 12, 2013]

**SECTION F. Alternative Operation Requirements.**

No Alternative Operations exist for this Plan Approval facility.

**SECTION G. Emission Restriction Summary.**

No emission restrictions listed in this section of the permit.



SECTION H. Miscellaneous.



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