



COMMONWEALTH OF PENNSYLVANIA
DEPARTMENT OF ENVIRONMENTAL PROTECTION
AIR QUALITY PROGRAM

PLAN APPROVAL

Issue Date: December 4, 2025 Effective Date: December 4, 2025
Revision Date: December 4, 2025 Expiration Date: November 29, 2026
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 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. 48-00005D

Federal Tax Id - Plant Code: 94-2626215-1

Owner Information

Name: HERCULES CEMENT CO LLC DBA BUZZI UNICEM USA
Mailing Address: 501 HERCULES DR
STOCKERTOWN, PA 18083-7009

Plant Information

Plant: HERCULES CEMENT CO LLC/STOCKERTOWN
Location: 48 Northampton County 48930 Stockertown Borough
SIC Code: 3241 Manufacturing - Cement, Hydraulic

Responsible Official

Name: RADOSLAV SLAVOV
Title: PLANT MANAGER
Phone: (610) 746 - 6220 Email: radoslav.slavov@buzziunicemusa.com

Plan Approval Contact Person

Name: JEREMY R MILLER
Title: ENVIRONMENTAL ENGINEER
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[Signature] _____
MARK J. WEJKSZNER, NORTHEAST REGION AIR PROGRAM MANAGER



Plan Approval Description

This Plan Approval is to permit the usage of alternative fuels (TDF, switchgrass, Green Fuel) currently permitted to be fired in Cement Kiln No. 3 preheater (ID 122) to also be allowed to be used as fuel in the Kiln No. 3 main burner (ID122) which will replace a portion of the coal and pet coke fired in the kiln system to reduce the usage of fossil fuels.

Emissions from the kiln are controlled by the existing controls: selective noncatalytic reduction (SNCR) (ID C72), drylime injection system (ID C75), and baghouse (ID C59). There will be no increase in emissions from Kiln 3 as a result of this project. The only physical change to the kiln will be an additional fuel insert line for alternative fuel feed at the Kiln 3 main burner.



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Note: These same sub-sections are repeated for each source!

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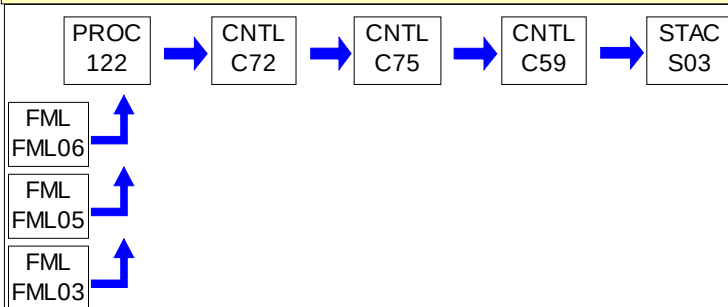
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**SECTION A. Plan Approval Inventory List**

Source ID	Source Name	Capacity/Throughput	Fuel/Material
122	NO. 3 PREHEATER PRECALCINER & CEMENT KILN SYSTEM	15.000 Tons/HR 15.000 Tons/HR 15.000 Tons/HR	TDF SWITCHGRASS GREEN FUEL
C59	MAIN BAGHOUSE		
C72	NO. 3 KILN SNCR		
C75	CALCIUM HYDROXIDE CONTROL FOR SO ₂ & HCL		
FML03	TIRE-DERIVED FUEL		
FML05	SWITCHGRASS		
FML06	GREEN FUEL		
S03	MAIN KILN SYSTEMS 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.

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

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).

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.

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.

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

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.

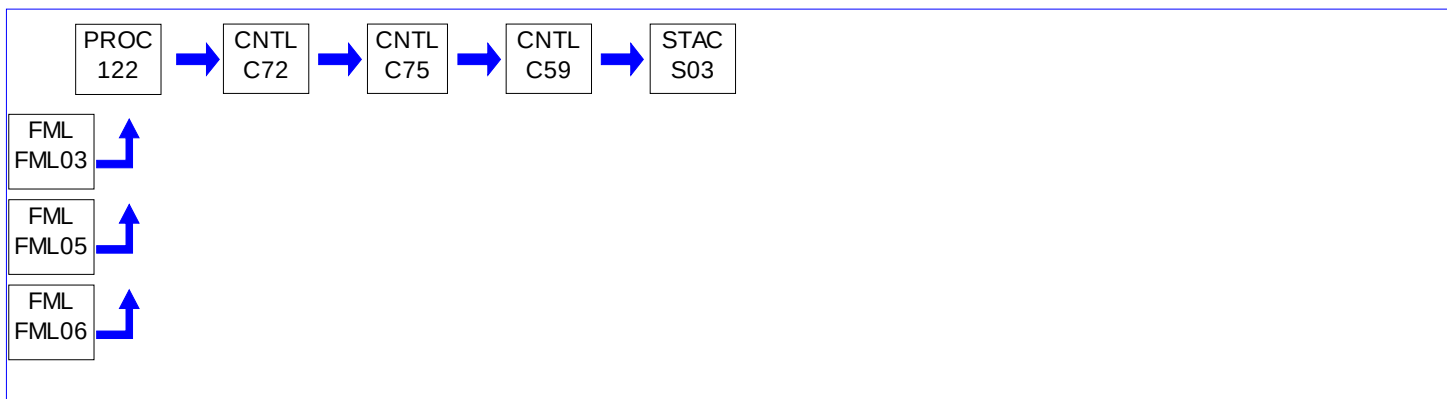
**SECTION D. Source Level Plan Approval Requirements**

Source ID: 122

Source Name: NO. 3 PREHEATER PRECALCINER & CEMENT KILN SYSTEM

Source Capacity/Throughput:	15.000 Tons/HR	TDF
	15.000 Tons/HR	SWITCHGRASS
	15.000 Tons/HR	GREEN FUEL

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

**I. RESTRICTIONS.**

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).

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: GROUP 3

Group Description: NO. 1 and NO. 3 CEMENT KILNS

Sources included in this group

ID	Name
122	NO. 3 PREHEATER PRECALCINER & CEMENT KILN SYSTEM

I. RESTRICTIONS.**Emission Restriction(s).****# 001 [25 Pa. Code §123.21]****General**

No person may permit the emission into the outdoor atmosphere of sulfur oxides from a source in a manner that the concentration of the sulfur oxides, expressed as SO₂, in the effluent gas exceeds 500 parts per million, by volume, dry basis.

002 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

(a) The following allowable emission limits are established for the operation of the No. 3 preheater and cement kiln and No. 1 cement kiln, in the NORMAL MODE (roller mill on):

- (1) Particulate matter emissions shall not exceed 39.33 lbs/hour.
- (2) Sulfur oxide emissions shall not exceed 500 ppm (1-hour block average), on a dry basis.
- (3) Nitrogen oxide emissions shall not exceed 492.0 lbs/hour (30-day rolling average).
- (4) Visible air contaminants shall not be emitted in such a manner that the opacity of the emissions is equal to or greater than 20% for a period or periods aggregating more than 3 minutes in any hour; or equal to or greater than 60% at any time.

003 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

(a) The following allowable emission limits are established for the operation of the No. 3 preheater cement kiln, including the No. 1 preheater cement kiln, in the BYPASS MODE (roller mill off):

- (1) Particulate matter emissions shall not exceed 28.0 lbs/hour.
- (2) Sulfur oxide emissions shall not exceed 500 ppm (1-hour block average), on a dry basis.
- (3) Nitrogen oxide emissions shall not exceed 492.0 lbs/hour (30-day rolling average).
- (4) Visible air contaminants shall not be emitted in such a manner that the opacity of the emissions is equal to or greater than 20% for a period or periods aggregating more than 3 minutes in any hour; or equal to or greater than 60% at any time.

004 [25 Pa. Code §145.143.]**Standard requirements.**

(a) By October 31, 2005, and each year thereafter, the owner or operator of a Portland cement kiln shall calculate the difference between the actual emissions from the unit during the period from May 1 through September 30 and the allowable emissions for that period.

(b) The owner or operator of a Portland cement kiln may not operate a Portland cement kiln in a manner that results in NO_x emissions in excess of its allowable emissions, except as otherwise specified in this section.

(1) N/A

(2) Beginning May 1 through September 30, 2011, and each year thereafter, the owner or operator of a Portland cement kiln shall determine allowable emissions of NO_x by multiplying the tons of clinker produced by the Portland cement kiln for the period by:

- (i) 3.88 pounds of NO_x per ton of clinker produced for long wet-process cement kilns.
- (ii) 3.44 pounds of NO_x per ton of clinker produced for long dry-process cement kilns.
- (iii) 2.36 pounds of NO_x per ton of clinker produced for:

- (A) Preheater cement kilns.
- (B) Precalciner cement kilns.

(c) The owner or operator shall install and operate a CEMS, and shall report CEMS emissions data, in accordance with the CEMS requirements of either Chapter 139 or 145 (relating to sampling and testing; and interstate pollution transport

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

reduction) and calculate actual emissions using the CEMS data reported to the Department. Any data invalidated under Chapter 139 shall be substituted with data calculated using the potential emission rate for the unit or, if approved by the Department in writing, an alternative amount of emissions that is more representative of actual emissions that occurred during the period of invalid data.

(d) The owner or operator of a Portland cement kiln subject to this section shall surrender to the Department one CAIR NO_x allowance and one CAIR NO_x ozone season allowance, as defined in 40 CFR 96.102 and 96.302 (relating to definitions), for each ton of NO_x by which the combined actual emissions exceed the allowable emissions of the Portland cement kilns subject to this section at a facility from May 1 through September 30. The surrendered allowances shall be of current year vintage. For the purposes of determining the amount of allowances to surrender, any remaining fraction of a ton equal to or greater than 0.50 ton is deemed to equal 1 ton and any fraction of a ton less than 0.50 ton is deemed to equal zero tons.

(e) If the combined allowable emissions from Portland cement kilns at a facility from May 1 through September 30 exceed the combined actual emissions from Portland cement kilns subject to this section at the facility during the same period, the owner or operator may deduct the difference or any portion of the difference from the amount of actual emissions from Portland cement kilns at the owner or operator's other facilities located in this Commonwealth for that period.

(f) By November 1, 2005, and each year thereafter, an owner or operator subject to this subchapter shall surrender the required NO_x allowances to the Department's designated NO_x allowance tracking system account, as defined in § 121.1 (relating to definitions), and shall provide in writing to the Department, the following:

(1) The serial number of each NO_x allowance surrendered.

(2) The calculations used to determine the quantity of NO_x allowances required to be surrendered.

(g) If an owner or operator fails to comply with subsection (f), the owner or operator shall by December 31 surrender three NO_x allowances of the current or later year vintage for each NO_x allowance that was required to be surrendered by November 1.

(h) The surrender of NO_x allowances under subsection (g) does not affect the liability of the owner or operator of the Portland cement kiln for any fine, penalty or assessment, or an obligation to comply with any other remedy for the same violation, under the CAA or the act.

(1) For purposes of determining the number of days of violation, if a facility has excess emissions for the period May 1 through September 30, each day in that period (153 days) constitutes a day in violation unless the owner or operator of the Portland cement kiln demonstrates that a lesser number of days should be considered.

(2) Each ton of excess emissions is a separate violation.

005 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1343]**Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****What standards apply to my kilns, clinker coolers, raw material dryers, and open clinker piles?**

(a) General.:The provisions in this section apply to each kiln and any alkali bypass associated with that kiln, clinker cooler, raw material dryer, and open clinker storage pile. All D/F, HCl, and total hydrocarbon (THC) emissions limit are on a dry basis. The D/F, HCl, and THC limits for kilns are corrected to 7 percent oxygen. All THC emissions limits are measured as propane. Standards for mercury and THC are based on a rolling 30-day average. If using a CEMS to determine compliance with the HCl standard, this standard is based on a rolling 30-day average. You must ensure appropriate corrections for moisture are made when measuring flow rates used to calculate mercury emissions. The 30-day period means all operating hours within 30 consecutive kiln operating days excluding periods of startup and shutdown. All emissions limits for kilns, clinker coolers, and raw material dryers currently in effect that are superseded by the limits below continue to apply until the compliance date of the limits below, or until the source certifies compliance with the limits below, whichever is earlier.

(b) Kilns, clinker coolers, raw material dryers, raw mills, and finish mills.

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

The emission limits for these sources are shown in table 1 below.

Table 1—Emissions Limits for Kilns, Clinker Coolers, Raw Material Dryers, Raw and Finish Mills

(1) If your source is a (an): Existing Kiln, And the operating mode is: Normal Operation, And if is located at a: Major Source,

Your emissions limits are:	The oxygen correction factor is:
PM[1] 0.07, lb/ton clinker	N/A
D/F[2] 0.2, ng/dscm	7%
Mercury 55, lb/MM tons clinker	N/A
THC[3][4] 24, lb/MM ppmvd	7%

2. If your source is An existing kiln, And the operating mode is: Normal operation, And if is located at a major source

Your emissions limits are:	The oxygen correction factor is:
HCl—3 ppmvd	7%

3. If your source is a (an): Existing Kiln, And the operating mode is: Startup and shutdown, And if is located at a: Major Source,

Your emission limits are:

Work practices (63.1346(g)), NA. NA.

[1] The initial and subsequent PM performance tests are performed using Method 5 or 5I and consist of three test runs.

[2] If the average temperature at the inlet to the first PM control device (fabric filter or electrostatic precipitator) during the D/F performance test is 400 °F or less this limit is changed to 0.40 ng/dscm (TEQ).

[3] Measured as propane.

[4] Any source subject to the 24 ppmvd THC limit may elect to meet an alternative limit of 12 ppmvd for total organic HAP.

(2) N/A

(c) Open clinker storage pile. The owner or operator of an open clinker storage pile must prepare, and operate in accordance with, the fugitive dust emissions control measures, described in their operation and maintenance plan (see §63.1347 of this subpart), that is appropriate for the site conditions as specified in paragraphs (c)(1) through (3) of this section. The operation and maintenance plan must also describe the measures that will be used to minimize fugitive dust emissions from piles of clinker, such as accidental spillage, that are not part of open clinker storage piles.

(1) The operation and maintenance plan must identify and describe the location of each current or future open clinker storage pile and the fugitive dust emissions control measures the owner or operator will use to minimize fugitive dust emissions from each open clinker storage pile.

(2) For open clinker storage piles, the operations and maintenance plan must specify that one or more of the following control measures will be used to minimize to the greatest extent practicable fugitive dust from open clinker storage piles: Locating the source inside a partial enclosure, installing and operating a water spray or fogging system, applying appropriate chemical dust suppression agents, use of a wind barrier, compaction, use of tarpaulin or other equally effective cover or use of a vegetative cover. You must select, for inclusion in the operations and maintenance plan, the fugitive dust control measure or measures listed in this paragraph that are most appropriate for site conditions. The plan must also explain how the measure or measures selected are applicable and appropriate for site conditions. In addition, the plan must be revised as needed to reflect any changing conditions at the source.

(3) Temporary piles of clinker that result from accidental spillage or clinker storage cleaning operations must be cleaned up within 3 days.

Fuel Restriction(s).

006 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

Alternative fuel (TDF/ Switchgrass/Green Fuel) shall not be used during start up of Kiln No. 3 (ID 122).

**SECTION E. Source Group Plan Approval Restrictions.****Throughput Restriction(s).****# 007 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

The fuel feed rate limits for the following fuels may not be exceeded.

- A) TDF(FML03) 15 Tons/hour
- B) Switchgrass(FML05) 15 Tons/hour
- C) Green Fuel(FML06) 15 Tons/hrs

008 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

Total annual clinker production is limited to a rate of 1,076,750 tons per year.

II. TESTING REQUIREMENTS.**# 009 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

- (1) The permittee may be required to conduct source tests at any time or frequency as may be prescribed by the Department.
- (2) For the stack tests specified above, the tests shall be conducted in accordance with 25 Pa. Code Chapter 139 as per the Department's source testing procedures described in the latest Source Testing Manual of source testing procedures approved by the Department prior to testing.
- (3) At least sixty (60) days prior to the test, test procedures and sketches with dimensions indicating the location of sampling ports and other data to ensure the collection of representative samples shall be submitted to the Department for approval.
- (4) At least two (2) weeks prior to the tests, the Department shall be informed of the date and time of the tests.
- (5) Within sixty (60) days for all pollutants identified in Condition (1), two (2) copies of the complete test report, including all operating conditions, shall be submitted to the Department for approval.

010 [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.**

The permittee shall comply with the applicable requirements of 40 CFR 63.1349 - See SECTION C - SITE LEVEL REQUIREMENTS

III. MONITORING REQUIREMENTS.**# 011 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

Quality Assurance Requirements:

Continuous Emission Monitoring Systems (CEMS) and components must be operated and maintained in accordance with the requirements established in 25 Pa. Code Chapter 139, Subchapter C (relating to requirements for source monitoring for stationary sources) and the "Quality Assurance" requirements in the Department's Continuous Source Monitoring Manual, Revision No. 8, 274-0300-001.

Compliance with any subsequently issued revision to the Continuous Source Monitoring Manual will constitute compliance with this permit condition.

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

Continuous Emission Monitoring Requirements:

The following continuous emission monitoring systems (CEMS) must be installed, approved by the Department, operated, and maintained for both kilns in accordance with the requirements of 25 Pa. Code Chapter 139, Subchapter C (relating to requirements for source monitoring for stationary sources), and the "Submittal and Approval", "Record Keeping and Reporting", and "Quality Assurance" requirements of Revision No. 8 of the Department's Continuous Source Monitoring Manual, 274-0300-001.

- (1) CEMS for sulfur oxides, nitrogen oxides, carbon dioxide, oxygen, stack flow, and opacity.

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

- (a) Source Combination to be Monitored: Cement Kilns No.1 and No.3.
(b) Parameter to be Reported: SO₂, NO₂, Opacity.
(c) Units of Measurement to be Reported: lbs/hr., ppm, %.
(d) Moisture Basis of Measurement to be Reported: NA
(e) Correction basis of Measurements to be Reported: None
(f) Data Substitution Required: No
(g) Emission Standards: Emission Restrictions listed in Condon #002 with Averaging Period Description, Emission Standard Value.
Compliance with any subsequently issued revisions to the Continuous Source Monitoring Manual will constitute compliance with the regulations.

013 [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.**

The permittee shall comply with the applicable monitoring requirements of 40 CFR 63.1350 - See SECTION C - SITE LEVEL REQUIREMENTS.

014 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1357]**Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Temporary, conditioned exemption from particulate matter and opacity standards.**

- (a) Subject to the limitations of paragraphs (b) through (f) of this section, an owner or operator conducting PM CEMS correlation tests (that is, correlation with manual stack methods) is exempt from:
- (1) Any particulate matter and opacity standards of part 60 or part 63 of this chapter that are applicable to cement kilns and in-line kiln/raw mills.
 - (2) Any permit or other emissions or operating parameter or other limitation on workplace practices that are applicable to cement kilns and in-line kiln raw mills to ensure compliance with any particulate matter and opacity standards of this part or part 60 of this chapter.
- (b) The owner or operator must develop a PM CEMS correlation test plan. The plan must be submitted to the Administrator for approval at least 90 days before the correlation test is scheduled to be conducted. The plan must include:
- (1) The number of test conditions and the number of runs for each test condition;
 - (2) The target particulate matter emission level for each test condition;
 - (3) How the operation of the affected source will be modified to attain the desired particulate matter emission rate; and
 - (4) The anticipated normal particulate matter emission level.
- (c) The Administrator will review and approve or disapprove the correlation test plan in accordance with §63.7(c)(3)(i) and (iii). If the Administrator fails to approve or disapprove the correlation test plan within the time period specified in §63.7(c)(3)(iii), the plan shall be considered approved, unless the Administrator has requested additional information.
- (d) The stack sampling team must be on-site and prepared to perform correlation testing no later than 24 hours after operations are modified to attain the desired particulate matter emissions concentrations, unless the correlation test plan documents that a longer period is appropriate.
- (e) The PM and opacity standards and associated operating limits and conditions will not be waived for more than 96 hours, in the aggregate, for the purposes of conducting tests to correlate PM CEMS with manual method test results, including all runs and conditions, except as described in this paragraph. Where additional time is required to correlate a PM CEMS device, a source may petition the Administrator for an extension of the 96-hour aggregate waiver of compliance with the PM and opacity standards. An extension of the 96-hour aggregate waiver is renewable at the discretion of the Administrator.
- (f) The owner or operator must return the affected source to operating conditions indicative of compliance with the applicable particulate matter and opacity standards as soon as possible after correlation testing is completed.

[64 FR 31925, June 14, 1999, as amended at 67 FR 16622, Apr. 5, 2002, eff. July 5, 2002]

**SECTION E. Source Group Plan Approval Restrictions.****IV. RECORDKEEPING REQUIREMENTS.****# 015 [25 Pa. Code §127.511]****Monitoring and related recordkeeping and reporting requirements.**

(a) The company shall maintain records in accordance with the record keeping requirements of 25 Pa. Code Chapter 129.95 as follows:

(1) The permittee shall maintain a file containing all records and other data that required to be collected pursuant to the various provisions of this Title V Permit. This 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 Permit. All measurements, records, and other data required to be maintained by the permittee shall be retained for at least two (2) years following the date on which such measurements, records or other data are recorded.

(2) All CEM reports shall be submitted to the Department within thirty-(30) days after each quarter but no later than the time frame established in the Department's latest Continuous Source Monitoring Manual. The Department reserves the right to require the report submissions in floppy disks with a format acceptable to the Department.

016 [25 Pa. Code §127.511]**Monitoring and related recordkeeping and reporting requirements.**

Compliance with this streamlined permit condition assures compliance with 40 CFR Part 63, Subpart LLL 63.1355. Recordkeeping Requirements:

Additional authority for this permit condition is derived from 40 CFR Part 63, Subpart LLL 63.1355 and 25 Pa. Code Sections 139.101(1)(iv), 139.101(10) and 139.101(12) and 139.103.

The permittee shall comply with the recordkeeping requirements established in 25 Pa. Code Chapter 139, Subchapter C in 25 Pa. Code Chapter 139, Subchapter C (relating to requirements for source monitoring for stationary sources), (and) the "Record Keeping and Reporting" requirements as established in the Department's Continuous Source Monitoring Manual, Revision No. 8, 274-0300-001 and the recordkeeping requirements established in 40 CFR Part 63, Subpart LLL 63.1355. Records shall be retained for at least five (5) years and shall be made available to the Department upon request.

Compliance with any subsequently issued revision to the Continuous Source Monitoring Manual will constitute compliance with this permit condition.

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

(a) The permittee shall record and maintain the following feed rates for each preheater and cement kiln:

(1) ANTHRACITE COAL AND CULM

(2) Tire-Derived Fuel

(3) #2 Oil

(4) Switchgrass

(5) Green Fuel - Non-hazardous secondary materials that are not solid wastes when used as fuels in combustion units as determined by EPA regulations at 40 CFR §241.3.

(6) Bituminous Coal

(7) Coke

This information shall be submitted to the Bethlehem District Office by March 1 of the following year.

018 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

The company shall record process raw material used, fuel used, clinker produced and operating hours to show compliance with the Emission Limits established in this SECTION E - GROUP 03 and Condition #7.

The actual records shall be kept on site and made available to the Department upon request. A summary of these records shall be compiled and submitted in the AIMS report by March 1 of the following year.

019 [25 Pa. Code §145.146.]**Recordkeeping.**

(a) The owner or operator of a Portland cement kiln shall maintain an operating log for each Portland cement kiln. The operating log must include the following on a monthly basis:

(1) The total hours of operation.

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(2) The type and quantity of fuel used.

(3) The quantity of clinker produced.

(b) The records maintained by the owner or operator of a Portland cement kiln must include the following:

(1) Source tests and operating parameters established during the initial source test and subsequent testing.

(2) The date, time and duration of any start-up, shutdown or malfunction of a Portland cement kiln or emissions monitoring system.

(3) The date and type of maintenance, repairs or replacements performed on the kilns, control devices and emission monitoring systems.

(c) The owner or operator of a Portland cement kiln shall maintain the records required under this section onsite for 5 years. The records shall be made available to the Department upon request.

Authority

The provisions of this § 145.146 issued under section 5(a)(1) of the Air Pollution Control Act (35 P. S. § 4005(a)(1)).

Source

The provisions of this § 145.146 adopted June 18, 2010, effective June 19, 2010, 40 Pa.B. 3346.

020 [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 Section 63.10(b)(1). The files shall be retained for at least five (5) years following the date of each occurrence, measurement, maintenance, corrective action, report, or record. At a minimum, the most recent two (2) years of data shall be retained on site. The remaining three (3) 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 Section 63.10(b)(2) and (b)(3) of this part; and

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

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

(3) If the owner or operator has been granted a waiver under Section 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 Section 63.10(c).

(d) [Reserved]

(e) You must keep records of the daily clinker production rates according to the clinker production monitoring requirements in §63.1350(d).

(f) You must keep records of the date, time and duration of each startup or shutdown period for any affected source that is subject to a standard during startup or shutdown that differs from the standard applicable at other times, and the quantity of feed and fuel used during the startup or shutdown period.

(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

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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.

[64 FR 31925, June 14, 1999, as amended at 71 FR 76552, Dec. 20, 2006; 75 FR 55064, Sept. 9, 2010; 78 FR 10053, Feb. 12, 2013; 80 FR 44791, July 27, 2015; 81 FR 48362, July 25, 2016; 83 FR 35135, July 25, 2018]

V. REPORTING REQUIREMENTS.**# 021 [25 Pa. Code §127.511]****Monitoring and related recordkeeping and reporting requirements.**

Compliance with this streamlined permit condition assures compliance with 40 CFR Part 63, Subpart LLL 63.1355. Recordkeeping Requirements:

Additional authority for this permit condition is derived from 40 CFR Part 63, Subpart LLL 63.1355 and 25 Pa. Code Sections 139.101(1)(iv), 139.101(10) and 139.101(12) and 139.103.

The permittee shall comply with the recordkeeping requirements established in 25 Pa. Code Chapter 139, Subchapter C in 25 Pa. Code Chapter 139, Subchapter C (relating to requirements for source monitoring for stationary sources), (and) the "Record Keeping and Reporting" requirements as established in the Department's Continuous Source Monitoring Manual, Revision No. 8, 274-0300-001 and the recordkeeping requirements established in 40 CFR Part 63, Subpart LLL 63.1355.

Records shall be retained for at least five (5) years and shall be made available to the Department upon request.

Compliance with any subsequently issued revision to the Continuous Source Monitoring Manual will constitute compliance with this permit condition.

022 [25 Pa. Code §127.511]**Monitoring and related recordkeeping and reporting requirements.**

(a) The company, within one (1) hour of occurrence, shall notify the Department, at (610) 861-2070, of any malfunction, recordkeeping and reporting errors, or other possible non-compliance issues, which result in, or may possibly be resulting

in, the emission of air contaminants in excess of the limitations specified in, or established pursuant to, any applicable rule or regulations contained in Article III of the Rules and Regulations of the Department of Environmental Protection.

(b) A written report shall be submitted to the Department within five (5) working days following the incident describing the malfunction, recordkeeping and reporting error or other non-compliance issue and the corrective actions being taken. The Department may take enforcement action for any violations of the applicable standards.

023 [25 Pa. Code §145.145.]**Compliance demonstration and reporting requirements.**

(a) By October 31, 2011, and each year thereafter, the owner or operator of a Portland cement kiln subject to § 145.143(b)(2) (relating to standard requirements) shall submit a written report to the Department, in a format approved by the Department, which includes the following:

(1) The difference between the actual NO_x emissions from the kiln during the interval from May 1 through September 30 and the allowable emissions for that period.

(2) The calculations used to determine the difference in emissions, including the CEMS data and clinker production data used to show compliance with the allowable emission limits in § 145.143(b)(2). The clinker production data must consist of the quantity of clinker, in tons, produced per day for each kiln.

(b) The owner or operator of a Portland cement kiln shall demonstrate compliance with the standard requirements in § 145.143(b)(2) on one of the following:

- (1) A kiln-by-kiln basis.
- (2) A facility-wide basis.
- (3) A system-wide basis.

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

The provisions of this § 145.145 issued under section 5(a)(1) of the Air Pollution Control Act (35 P. S. § 4005(a)(1)).

Source

The provisions of this § 145.145 adopted June 18, 2010, effective June 19, 2010, 40 Pa.B. 3346.

VI. WORK PRACTICE REQUIREMENTS.**# 024 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

Alternative fuel shall be handled to prevent fugitive emissions. Alternative Fuels (Switchgrass and Green Fuel) shall be stored in an enclosed storage building and be pneumatically conveyed to the kiln in an enclosed conveying system.

025 [25 Pa. Code §127.511]**Monitoring and related recordkeeping and reporting requirements.**

(a) Continuous emission monitoring shall meet the following minimum data availability requirements:

(1) In accordance with 25 Pa. Code Section 139.101(12), required monitoring shall, at a minimum, meet one of the following data availability requirements unless otherwise stipulated in this permit, a plan approval, Title 25 or an order issued under Section 4 of the Air Pollution Control Act:

(i) In each calendar month, at least 90% of the time periods for which [an emission standard or an operational parameter] applies, shall be valid as set forth in the Quality Assurance section of Revision No. 8 of the Department's Continuous Source Monitoring Manual, 274-0300-001.

or,

(ii) In each calendar quarter, at least 95% of the hours shall be valid as set forth in the Quality Assurance section of Revision No. 8 of the Department's Continuous Source Monitoring Manual, 274-0300-001.

Compliance with any subsequently issued revisions to the Continuous Source Monitoring Manual will constitute compliance with the regulations.

(2) As required under 25 Pa. Code Section 139.103(2) opacity monitoring systems shall meet at least one of the following data availability requirements, unless otherwise stipulated in this permit, a plan approval, Title 25 or an order issued under Section 4 of the Air Pollution Control Act:

(i) At least 90% of the hours in each calendar month shall be valid hours as set forth in the Quality Assurance section of Revision No. 8 of the Department's Continuous Source Monitoring Manual, 274-0300-001.

or,

(ii) At least 95% of the hours in each calendar quarter shall be valid hours as set forth in the Quality Assurance section of Revision No. 8 of the Department's Continuous Source Monitoring Manual, 274-0300-001.

Compliance with any subsequently issued revisions to the Continuous Source Monitoring Manual will constitute compliance with the regulations.

VII. ADDITIONAL REQUIREMENTS.**# 026 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1344]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Affirmative defense for exceedance of emission limit during malfunction.**

(a) The owner or operator of a kiln subject to a D/F emission limitation under Section 63.1343 must operate the kiln such that the temperature of the gas at the inlet to the kiln particulate matter control device (PMCD) and alkali bypass PMCD, if applicable, does not exceed the applicable temperature limit specified in Paragraph (b) of this section.

(b) The temperature limit for affected sources meeting the limits of Paragraph (a) of this section or Paragraphs (a)(1) through (a)(3) of this section is determined in accordance with Section 63.1349(b)(3)(iv)[SEE SECTION C].

(c) The owner or operator of an affected source subject to a D/F emission limitation under Section 63.1343 that employs carbon injection as an emission control technique must operate the carbon injection system in accordance with Paragraphs (c)(1) and (c)(2) of this section.

(1) The three-hour rolling average activated carbon injection rate shall be equal to or greater than the activated carbon injection rate determined in accordance with Section 63.1349(b)(3)(vi)[SEE SECTION C].

(2) The owner or operator shall either:

(i) Maintain the minimum activated carbon injection carrier gas flow rate, as a three-hour rolling average, based on the manufacturer's specifications. These specifications must be documented in the test plan developed in accordance with Section 63.7(c), or

(ii) Maintain the minimum activated carbon injection carrier gas pressure drop, as a three-hour rolling average, based on the manufacturer's specifications. These specifications must be documented in the test plan developed in accordance with

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Section 63.7(c).

(d) Except as provided in Paragraph (e) of this section, the owner or operator of an affected source subject to a D/F emission limitation under Section 63.1343 that employs carbon injection as an emission control technique must specify and use the brand and type of activated carbon used during the performance test until a subsequent performance test is conducted, unless the site-specific performance test plan contains documentation of key parameters that affect adsorption and the owner or operator establishes limits based on those parameters, and the limits on these parameters are maintained.

(e) The owner or operator of an affected source subject to a D/F emission limitation under Section 63.1343 that employs carbon injection as an emission control technique may substitute, at any time, a different brand or type of activated carbon provided that the replacement has equivalent or improved properties compared to the activated carbon specified in the sitespecific

performance test plan and used in the performance test. The owner or operator must maintain documentation that the substitute activated carbon will provide the same or better level of control as the original activated carbon.

**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 *****
