



COMMONWEALTH OF PENNSYLVANIA
DEPARTMENT OF ENVIRONMENTAL PROTECTION
AIR QUALITY PROGRAM

PLAN APPROVAL

Issue Date: November 21, 2025

Effective Date: November 21, 2025

Expiration Date: May 21, 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. 48-00125A

Federal Tax Id - Plant Code: 51-0274193-1

Owner Information

Name: KERRY INC.

Mailing Address: 5000 TOWNSHIP LINE RD
BETHLEHEM, PA 18017-9420

Plant Information

Plant: KERRY INC/BETHLEHEM FACILITY

Location: 48 Northampton County

48001 Bethlehem City

SIC Code: 2095 Manufacturing - Roasted Coffee

Responsible Official

Name: ENRIQUE MEDINA

Title: PLANT MANAGER

Phone: (484) 935 - 3880

Email: enrique.medinameraz@kerry.com

Plan Approval Contact Person

Name: ENRIQUE MEDINA

Title: PLANT MANAGER

Phone: (484) 935 - 3880

Email: enrique.medinameraz@kerry.com

[Signature] _____

MARK J. WEJKSZNER, NORTHEAST REGION AIR PROGRAM MANAGER



Plan Approval Description

This plan approval is for the installation of two (2) coffee roasting lines, each including a roaster, roaster cyclone, and catalytic oxidizer. There will also be a cooling process which includes two (2) cooling cyclones, grinding operations which is controlled by a dust collector, and liquid blending operations which is controlled by a dust collector. The catalytic oxidizers are used to control emissions from the roasting process and the cooling cyclones and dust collectors are used to control PM emissions from their respective processes. This facility is located in Bethlehem City, Northampton County.



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

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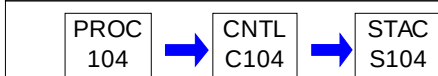
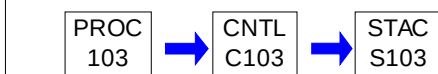
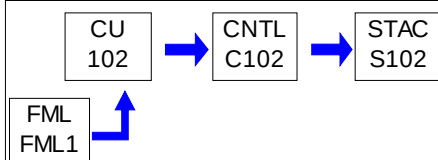
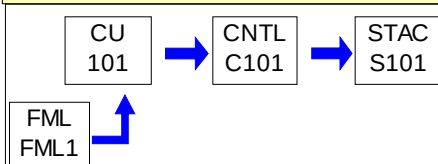
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**SECTION A. Plan Approval Inventory List**

Source ID	Source Name	Capacity/Throughput	Fuel/Material
101	DIEDRICH ROASTER - BURNER #1 DR-280 (PRO-001)		
102	DIEDRICH ROASTER - BURNER #2 DR-280 (PRO-002)		
103	COOLING BIN/DESTONER #1 (PRO-003)		
104	COOLING BIN/DESTONER #2 (PRO-004)		
105	ROASTED AIR CYCLONE #1 - DR-280 RA CYCLONE (ECU-001)		
106	ROASTED AIR CYCLONE #2 - DR-280 RA CYCLONE (ECU-002)		
107	GRINDERS (PRO-005 AND PRO-006)		
108	SPRAY DRIED COFFEE INDUCTION (PRO-007)		
C101	CATALYTIC OXIDIZER #1 - CR30/40V 122-2000MC-NB (ECU-003)		
C102	CATALYTIC OXIDIZER #2 - CR30/40V 122-2000MC-NB (ECU-004)		
C103	COOLING AIR CYCLONE #1 - DR-280 CB CYCLONE (ECU-005)		
C104	COOLING AIR CYCLONE #2 - DR-280 CB CYCLONE (ECU-006)		
C107	GRINDING ROOM BAGHOUSE (ECU-007)		
C108	LIQUID BLENDING ROOM BAGHOUSE (ECU-009)		
FML1	NATURAL GAS FUEL		
S101	STACK - CATALYTIC OXIDIZER #1		
S102	STACK - CATALYTIC OXIDIZER #2		
S103	STACK - COOLING AIR CYCLONE #1		
S104	STACK - COOLING AIR CYCLONE #2		
S107	STACK - GRINDING ROOM BAGHOUSE		
S108	STACK - LIQUID BLENDING ROOM BAGHOUSE		

PERMIT MAPS

**PERMIT MAPS**

PROC
105 → CNTL
C101 → STAC
S101

PROC
106 → CNTL
C102 → STAC
S102

PROC
107 → CNTL
C107 → STAC
S107

PROC
108 → CNTL
C108 → STAC
S108

**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 §121.7]****Prohibition of air pollution.**

No person may permit air pollution as that term is defined in the act.

002 [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 of roads and streets.

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

(4) Clearing of land.

(5) Stockpiling of materials.

(6) Open burning operations.

(7) Sources and classes of sources other than those identified in paragraphs (1)-(6), 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.

003 [25 Pa. Code §123.11]**Combustion units**

(a) A person may not permit the emission into the outdoor atmosphere of particulate matter from a combustion unit in excess of the following:

(1) The rate of 0.4 pound per million Btu of heat input, when the heat input to the combustion unit in millions of Btus per hour is greater than 2.5 but less than 50.

(2) The rate determined by the following formula:

$$A = 3.6E^{(-0.56)}$$

where

A = Allowable emissions in pounds per million BTUs of heat input,

and

E = Heat input to the combustion unit in millions of BTUs per hour,

when E is equal to or greater than 50 but less than 600.

(3) The rate of 0.1 pounds per million Btu of heat input when the heat input to the combustion unit in millions of Btus per hour is equal to or greater than 600.

(b) Allowable emissions under subsection (a) are graphically indicated in Appendix A.

**SECTION C. Site Level Plan Approval Requirements****# 004 [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 Condition #001 (relating to prohibition of certain fugitive emissions) if such emissions are visible at the point the emissions pass outside the person's property.

005 [25 Pa. Code §123.31]**Limitations**

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

006 [25 Pa. Code §123.41]**Limitations**

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

- (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.

007 [25 Pa. Code §123.42]**Exceptions**

The limitations of Site Condition #006 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 the limitations.
- (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 emission results from sources specified in Site Condition #001 (relating to prohibition of certain fugitive emissions).

II. TESTING REQUIREMENTS.**# 008 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

If requested by the Department, the company shall perform stack tests in accordance with the provisions of Chapter 139 of the Rules and Regulations of the Department, within a time specified by the Department.

009 [25 Pa. Code §127.12b]**Plan approval terms and conditions.**

a) The permittee shall email all source test submissions (protocols, reports, supplemental information, etc.) to both the AQ Program Manager for the Northeast Regional Office and the PSIMS Administrator in Central Office (email addresses are provided below). Any questions or concerns about source testing submissions can be sent to RA-EPstacktesting@pa.gov and the PSIMS Administrator will address them.

Northeast Region
RA-EPNEstacktesting@pa.gov

Central Office
RA-EPstacktesting@pa.gov

(b) The following pertinent information shall be listed on the title page.

(1) Test Date(s)

- (i) For protocols, provide the proposed date on which testing will commence or "TBD"
- (ii) For reports, provide the first and last day of testing

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

- (2) Primary Facility Identification Number (PF ID 885916): For test programs that were conducted under a multi-site protocol, also include the PF ID under which the protocol was stored in PSIMS, as indicated in the protocol response letter.
- (3) Source ID(s) for the applicable source(s) and air pollution control device(s): The term Source ID is used in the permit but "Other Id" is used in DEP electronic systems. They are the same number and must also be listed for control equipment.
- (4) Testing Requirements (all that apply):
- (i) Plan approval number(s)
- (c) If confidential information must be submitted, submit both a public copy, which has been redacted, and a confidential copy. The cover page of each submittal should state whether it is a "Public Copy" or "Confidential Copy" and each page of the latter must be marked "CONFIDENTIAL".

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

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 any devices approved by the Department.

011 [25 Pa. Code §127.12b]**Plan approval terms and conditions.**

The permittee shall conduct a facility-wide inspection for the presence of any visible stack emissions, fugitive emissions, and any potentially objectionable odors at the property line at a minimum of once a week, during daylight hours, and while the sources are operating. If visible stack emissions, fugitive emissions, and/or potentially objectionable odors are apparent, the permittee shall take corrective action. Records of each inspection shall be maintained in a log and at the minimum include the date, time, name and title of the observer, along with any corrective action taken as a result.

012 [25 Pa. Code §127.12b]**Plan approval terms and conditions.**

- (a) A visual inspection of the facility shall be performed on a weekly basis to determine if fugitive or visible emissions are detectable at the facility.
- (b) Visible emissions may be measured according to the methods specified in Section C, or alternatively, plant personnel who observe any visible emissions will report the incident of the visible emission to the Department within four hours of each incident and make arrangements for a certified observer to verify the opacity of the visible emissions.

IV. RECORDKEEPING REQUIREMENTS.**# 013 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

All logs and required records shall be maintained on site for a minimum of five years and shall be made available to the Department upon request.

014 [25 Pa. Code §127.12b]**Plan approval terms and conditions.**

- (a) The permittee shall keep records of the supporting calculations on a monthly basis for VOC, NO_x, and PM emissions from all sources at the facility.
- (b) These records shall be retained for a minimum of five (5) years and shall be made available to the Department upon request.

015 [25 Pa. Code §127.12b]**Plan approval terms and conditions.**

The permittee shall maintain a record of the results of the facilities visible and fugitive emissions inspections. At a

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minimum, the permittee shall record the date, time, results of the inspection, and individual conducting the inspection.

016 [25 Pa. Code §135.5]**Recordkeeping**

Source owners or operators shall maintain and make available upon request by the Department records including computerized records that may be necessary to comply with 135.21 (relating to reporting; and emission statements). These may include records of production, fuel usage, maintenance of production or pollution control equipment or other information determined by the Department to be necessary for identification and quantification of potential and actual air contaminant emissions. If direct recordkeeping is not possible or practical, sufficient records shall be kept to provide the needed informed by indirect means.

V. REPORTING REQUIREMENTS.**# 017 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

The permittee shall maintain all equipment in accordance with manufacturers specifications and maintain records of any maintenance performed.

018 [25 Pa. Code §127.12b]**Plan approval terms and conditions.**

The permittee shall maintain all equipment in accordance to manufacturing specifications and perform annual tune-ups as specified by the manufacturers.

019 [25 Pa. Code §127.12b]**Plan approval terms and conditions.**

Malfunction reporting shall be conducted as follows:

(a) For purpose of this condition a malfunction is defined as any sudden, infrequent, and not reasonably preventable failure of air pollution control equipment or source to operate in a normal or usual manner that may result in an increase in the emission of air contaminants. Examples of malfunctions may include, but are not limited to: large dust plumes, heavy smoke, a spill or release that results in a malodor that is detectable outside the property of the person on whose land the source is being operated.

(b) When the malfunction poses an imminent and substantial danger to the public health and safety or the environment, the notification shall be submitted to the Department no later than one hour after the incident commences.

(c) All other malfunctions that must be reported under subsection (a) shall be reported to the Department no later than the next business day.

(d) The report shall describe the:

- (1) Name and location of the facility;
- (2) Nature and cause of the malfunction or breakdown;
- (3) Time when the malfunction or breakdown was first observed;
- (4) Expected duration of excess emissions; and
- (5) Estimated rate of emissions.

(e) Malfunctions shall be reported to the Department at the following address:

PADEP
Air Quality Program
2 Public Square
Wilkes Barre, PA 18701
570-826-2511

(f) The owner or operator shall notify the Department immediately upon completion when corrective measures have been

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

accomplished.

(g) Subsequent to the malfunction, the owner/operator shall submit a full written report to the Department including the items identified in (d) and corrective measures taken on the malfunction within 15 days, if requested.

VI. WORK PRACTICE REQUIREMENTS.**# 020 [25 Pa. Code §123.1]****Prohibition of certain fugitive emissions**

The permittee shall take all reasonable actions to prevent particulate matter from becoming airborne. These actions shall include, but not be limited to, the following:

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

021 [25 Pa. Code §129.14]**Open burning operations**

a) No person may permit the open burning of material in an area outside of air basins in a manner that:

- (1) The emissions are visible, at any time, at the point such emissions pass outside the property of the person on whose land the open burning is being conducted.
- (2) Malodorous air contaminants from the open burning are detectable outside the property of the person on whose land the open burning is being conducted.
- (3) The emissions interfere with the reasonable enjoyment of life or property.
- (4) The emissions cause damage to vegetation or property.
- (5) The emissions are or may be deleterious to human or animal health.

(b) Exceptions: The requirements of subsections (a) do not apply where the open burning operations result from:

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



SECTION C. Site Level Plan Approval Requirements

VII. ADDITIONAL REQUIREMENTS.

022 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

The company shall not impose conditions upon or otherwise restrict the Department's access to the aforementioned source(s) and/or any associated air cleaning device(s) and shall allow the Department to have access at any time to said source(s) and associated air cleaning device(s) 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.

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.

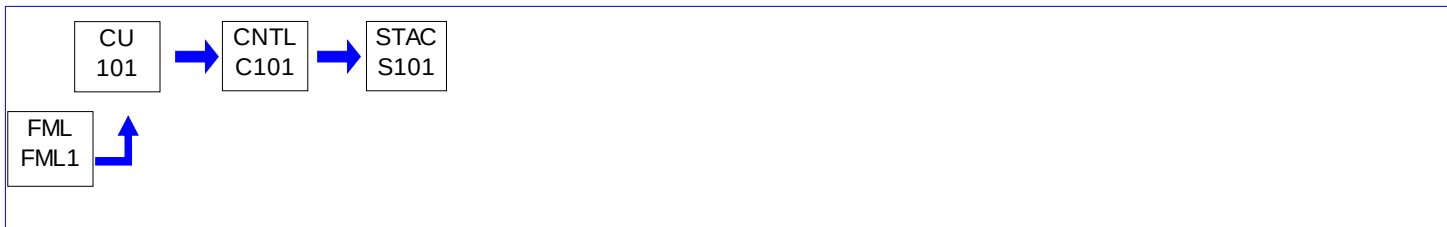
**SECTION D. Source Level Plan Approval Requirements**

Source ID: 101

Source Name: DIEDRICH ROASTER - BURNER #1 DR-280 (PRO-001)

Source Capacity/Throughput:

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 D. Source Level Plan Approval Requirements**

Source ID: 102

Source Name: DIEDRICH ROASTER - BURNER #2 DR-280 (PRO-002)

Source Capacity/Throughput:

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).

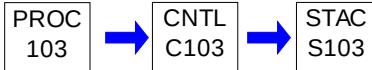
**SECTION D. Source Level Plan Approval Requirements**

Source ID: 103

Source Name: COOLING BIN/DESTONER #1 (PRO-003)

Source Capacity/Throughput:

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

**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).

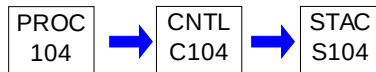
**SECTION D. Source Level Plan Approval Requirements**

Source ID: 104

Source Name: COOLING BIN/DESTONER #2 (PRO-004)

Source Capacity/Throughput:

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

**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).

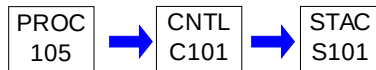
**SECTION D. Source Level Plan Approval Requirements**

Source ID: 105

Source Name: ROASTED AIR CYCLONE #1 - DR-280 RA CYCLONE (ECU-001)

Source Capacity/Throughput:

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).

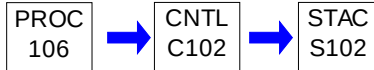
**SECTION D. Source Level Plan Approval Requirements**

Source ID: 106

Source Name: ROASTED AIR CYCLONE #2 - DR-280 RA CYCLONE (ECU-002)

Source Capacity/Throughput:

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).

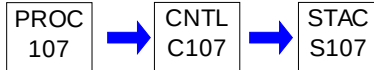
**SECTION D. Source Level Plan Approval Requirements**

Source ID: 107

Source Name: GRINDERS (PRO-005 AND PRO-006)

Source Capacity/Throughput:

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

**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).

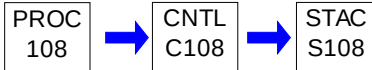
**SECTION D. Source Level Plan Approval Requirements**

Source ID: 108

Source Name: SPRAY DRIED COFFEE INDUCTION (PRO-007)

Source Capacity/Throughput:

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

**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 1

Group Description: Baghouses

Sources included in this group

ID	Name
107	GRINDERS (PRO-005 AND PRO-006)
108	SPRAY DRIED COFFEE INDUCTION (PRO-007)
C107	GRINDING ROOM BAGHOUSE (ECU-007)
C108	LIQUID BLENDING ROOM BAGHOUSE (ECU-009)

I. RESTRICTIONS.**Emission Restriction(s).****# 001 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

Pursuant to the Best Available Technology (BAT) provisions of 25 Pa. Code Section 127.12 (a)(5), particulate emissions from the baghouses shall not exceed 0.02 grain/dscf.

II. TESTING REQUIREMENTS.**# 002 [25 Pa. Code §127.12b]****Plan approval 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 that testing is required.

III. MONITORING REQUIREMENTS.**# 003 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

The baghouses must each be equipped with a device for monitoring the pressure differential across the collector (baghouse).

004 [25 Pa. Code §127.12b]**Plan approval terms and conditions.**

The company shall ensure that the control devices shall be equipped with the applicable monitoring equipment and the monitoring equipment shall be installed, calibrated, operated, and maintained according to the vendor's specifications at all times the control device is in use

IV. RECORDKEEPING REQUIREMENTS.**# 005 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

At least once weekly, the company shall record the pressure differential of each baghouse in operation. These records shall be maintained for a period of five (5) years and be made available to the Department upon request.

V. REPORTING REQUIREMENTS.**# 006 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

(a) The company, within one (1) hour of discovery, 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 issues and the corrective actions being taken. The Department may take enforcement action for any violations of the applicable standards.

**SECTION E. Source Group Plan Approval Restrictions.****VI. WORK PRACTICE REQUIREMENTS.****# 007 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

(a) The pressure differential across the baghouse shall be monitored and recorded on a weekly basis while the sources are operating. The permittee shall retain these records for a minimum of five (5) years and shall be made available to the Department upon request.

(b) Dust collected in the baghouse filters shall be discharged into closed containers only.

(c) The permittee shall keep on hand a sufficient quantity of spare baghouse bags/filters for the baghouse associated with this source in order to be able to immediately replace any bags/filters requiring replacement due to deterioration resulting from routine operation of the source and baghouse.

(d) The permittee shall maintain and operate the air pollution control equipment and sources in accordance with the manufacturers recommendation and with good engineering practice.

008 [25 Pa. Code §127.12b]**Plan approval terms and conditions.**

1. The aforementioned source(s) may only be operated as long as the associated air pollution control device(s) are operated and maintained in accordance with any conditions set forth herein.

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

009 [25 Pa. Code §127.12b]**Plan approval terms and conditions.**

1. All gauges employed by the permittee to monitor the required control device operating parameters shall have a scale such that the expected normal reading shall be no less than twenty percent (20%) of full scale and be accurate within plus or minus two percent (+/- 2%) of full scale reading.

2. All gauges employed for monitoring shall be calibrated at a frequency in accordance with the manufacturer's specifications, or at least annually, whichever is more frequent.

VII. ADDITIONAL REQUIREMENTS.

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

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

Group Name: GROUP 2

Group Description: Cooling Process

Sources included in this group

ID	Name
103	COOLING BIN/DESTONER #1 (PRO-003)
104	COOLING BIN/DESTONER #2 (PRO-004)
C103	COOLING AIR CYCLONE #1 - DR-280 CB CYCLONE (ECU-005)
C104	COOLING AIR CYCLONE #2 - DR-280 CB CYCLONE (ECU-006)

I. RESTRICTIONS.**Emission Restriction(s).****# 001 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

Pursuant to the Best Available Technology (BAT) provisions of 25 Pa. Code Section 127.12 (a)(5), particulate emissions from the cyclones shall not exceed 0.02 grain/dscf.

II. TESTING REQUIREMENTS.**# 002 [25 Pa. Code §127.12b]****Plan approval 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 that testing is required.

III. MONITORING REQUIREMENTS.**# 003 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

The company shall ensure that the control devices shall be equipped with the applicable monitoring equipment and the monitoring equipment shall be installed, calibrated, operated, and maintained according to the vendor's specifications at all times the control device is in use.

004 [25 Pa. Code §127.12b]**Plan approval terms and conditions.**

Visible emissions monitoring shall be conducted for each cooling cyclone on a weekly basis, as stated in Site Level Requirement #011.

IV. RECORDKEEPING REQUIREMENTS.**# 005 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

At least once weekly, the company shall record the results of the visible emissions inspection for the cooling cyclones. These records shall be maintained for a period of five (5) years and be made available to the Department upon request.

V. REPORTING REQUIREMENTS.**# 006 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

(a) The company, within one (1) hour of discovery, 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 issues and the corrective actions being taken. The

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

Department may take enforcement action for any violations of the applicable standards.

VI. WORK PRACTICE REQUIREMENTS.**# 007 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

(a) Dust collected in the cyclone shall be discharged into closed containers only.

(b) The permittee shall maintain and operate the air pollution control equipment and sources in accordance with the manufacturers recommendations and with good engineering practices.

008 [25 Pa. Code §127.12b]**Plan approval terms and conditions.**

1. The aforementioned source(s) may only be operated as long as the associated air pollution control device(s) are operated and maintained in accordance with any conditions set forth herein.

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

009 [25 Pa. Code §127.12b]**Plan approval terms and conditions.**

1. All gauges employed by the permittee to monitor the required control device operating parameters shall have a scale such that the expected normal reading shall be no less than twenty percent (20%) of full scale and be accurate within plus or minus two percent (+/- 2%) of full scale reading.

2. All gauges employed for monitoring shall be calibrated at a frequency in accordance with the manufacturer's specifications, or at least annually, whichever is more frequent.

VII. ADDITIONAL REQUIREMENTS.

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

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

Group Name: GROUP 3

Group Description: Roasting Process

Sources included in this group

ID	Name
101	DIEDRICH ROASTER - BURNER #1 DR-280 (PRO-001)
102	DIEDRICH ROASTER - BURNER #2 DR-280 (PRO-002)
105	ROASTED AIR CYCLONE #1 - DR-280 RA CYCLONE (ECU-001)
106	ROASTED AIR CYCLONE #2 - DR-280 RA CYCLONE (ECU-002)
C101	CATALYTIC OXIDIZER #1 - CR30/40V 122-2000MC-NB (ECU-003)
C102	CATALYTIC OXIDIZER #2 - CR30/40V 122-2000MC-NB (ECU-004)

I. RESTRICTIONS.**Emission Restriction(s).****# 001 [25 Pa. Code §123.31]****Limitations**

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

002 [25 Pa. Code §127.12b]**Plan approval terms and conditions.**

Pursuant to the Best Available Technology provision of 25 PA Code, Chapter 127, the catalytic oxidizer shall meet the following limitations:

a. Destruction Efficiency - 98% destruction efficiency for the VOCs (Volatile Organic Compounds) emissions in the control device.

003 [25 Pa. Code §127.12b]**Plan approval terms and conditions.**

The company shall ensure that the capture system and control devices are operated at all times of production and during non production times except shutdown for routine maintenance, checkups and repairs.

II. TESTING REQUIREMENTS.**# 004 [25 Pa. Code §127.12b]****Plan approval 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 that testing is required.

III. MONITORING REQUIREMENTS.**# 005 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

Temperature sensing and recording devices shall be installed to show that the temperature rise across the catalyst bed is as stated on the Plan Approval application.

006 [25 Pa. Code §127.12b]**Plan approval terms and conditions.**

The company shall ensure that the control devices shall be equipped with the applicable monitoring equipment and the monitoring equipment shall be installed, calibrated, operated, and maintained according to the vendor's specifications at all times the control device is in use.

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

Visible emissions monitoring shall be conducted for each catalytic oxidizer on a weekly basis, as stated in Site Level Requirement #011.

IV. RECORDKEEPING REQUIREMENTS.**# 008 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

The permittee shall maintain the following comprehensive and accurate records:

- (a) Amount of fuel used by roasters on a 12-month rolling sum basis.
- (b) Hours of operation of the coffee roasting lines on a 12-month rolling sum basis.
- (c) Results of facility-wide inspections including the date, time, name, and title of the observer, along with any corrective action taken as a result.
- (d) Copies of the manufacturer's recommended maintenance schedule for each air source and air cleaning device.
- (e) All maintenance performed on each source and air cleaning device.

009 [25 Pa. Code §127.12b]**Plan approval terms and conditions.**

At least once weekly, the company shall record the results of the visible emissions inspection for the catalytic oxidizers. These records shall be maintained for a period of five (5) years and be made available to the Department upon request.

V. REPORTING REQUIREMENTS.**# 010 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

(a) The company, within one (1) hour of discovery, 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 issues and the corrective actions being taken. The Department may take enforcement action for any violations of the applicable standards.

VI. WORK PRACTICE REQUIREMENTS.**# 011 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

1. The aforementioned source(s) 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 approval(s), and the application(s) submitted for said plan approval(s) (as approved by the Department), and in accordance with any conditions set forth herein.
2. The company shall maintain and operates the air pollution control equipment and sources in accordance with the manufacturers recommendation and with good engineering practices.

012 [25 Pa. Code §127.12b]**Plan approval terms and conditions.**

1. All gauges employed by the permittee to monitor the required control device operating parameters shall have a scale such that the expected normal reading shall be no less than twenty percent (20%) of full scale and be accurate within plus or minus two percent (+/- 2%) of full scale reading.
2. All gauges employed for monitoring shall be calibrated at a frequency in accordance with the manufacturer's specifications, or at least annually, whichever is more frequent.

013 [25 Pa. Code §127.12b]**Plan approval terms and conditions.**

Except for the first year, the owner or operator shall conduct a dryer burner tuning procedure in accordance with the

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

manufacturer's specifications to minimize NO_x and CO emissions each year thereafter. Conducting a burner tuning procedure in accordance with the manufacturer's specifications will be adequate. The owner or operator shall comply with the following requirements:

- i. The air-to-fuel ratio controls shall be inspected and adjusted to ensure proper operation in accordance with the manufacturer's specifications.
- ii. Monitoring records stating the following information shall be kept on site for a minimum of five years and shall be made available to the Department upon request.
 - 1.) The date of the tuning procedure;
 - 2.) The name of the servicing company and technician;
 - 3.) The production rate (tons/hr) or load before and after tuning;
 - 4.) The CO and NO_x concentrations (ppmvd) before and after tuning; and
 - 5.) The percent O₂ before and after tuning.

VII. ADDITIONAL REQUIREMENTS.**# 014 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

The company shall not impose conditions upon or otherwise restrict the Department's access to the aforementioned source(s) and/or any associated air cleaning device(s) and shall allow the Department to have access at any time to said source(s) and associated air cleaning device(s) 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.

**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 *****
