



COMMONWEALTH OF PENNSYLVANIA
DEPARTMENT OF ENVIRONMENTAL PROTECTION
AIR QUALITY PROGRAM

PLAN APPROVAL

Issue Date: June 8, 2026

Effective Date: June 8, 2026

Revision Date: June 8, 2026

Expiration Date: June 3, 2027

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. 48-00089F

Federal Tax Id - Plant Code: 22-3645461-1

Owner Information

Name: SPRAY TEK LLC

Mailing Address: 3010 AVENUE B
BETHLEHEM, PA 18017-2114

Plant Information

Plant: SPRAY TEK INC/BETHLEHEM

Location: 48 Northampton County 48001 Bethlehem City

SIC Code: 2087 Manufacturing - Flavoring Extracts And Syrups, Nec

Responsible Official

Name: ROB RUSCONI

Title: ENG PROJ MGR

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Email: rob.rusconi@spray-tek.net

Plan Approval Contact Person

Name: ROB RUSCONI

Title: ENG PROJ MGR

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[Signature] _____

MARK J. WEJKSZNER, NORTHEAST REGION AIR PROGRAM MANAGER



Plan Approval Description

This Plan Approval is for the addition of a roll filter (C113) , BLC Industries Inc Model AVR05V110 for PM capture and carbon adsorber (C112), APC Technologies Inc, Carbon Pure Activated Carbon System for odor control for current spray dryer lines No.6 and No. 13 (ID 101, 107). These will be added to the end of the exhaust before exiting to the atmosphere. Current control devices for the spray dryers will remain prior to the roll filter and carbon adsorber.



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

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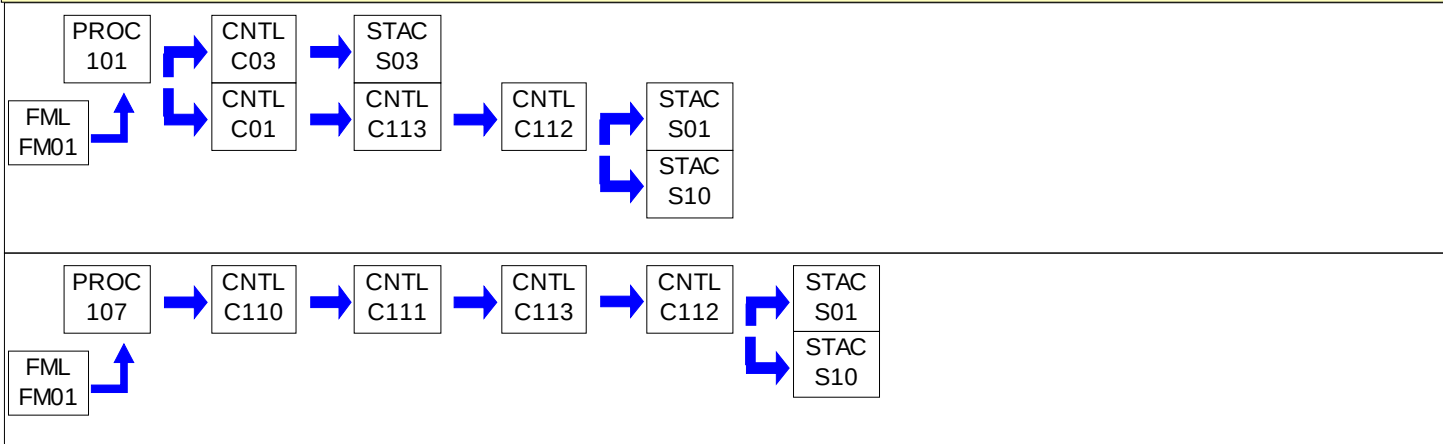
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**SECTION A. Plan Approval Inventory List**

Source ID	Source Name	Capacity/Throughput	Fuel/Material
101	SPRAY DRYER 6		
107	SPRAY DRYER 13	2.000 MMBTU/HR	
C01	SPRAY DRYER 6 SCRUBBER		
C03	SPRAY DRYER BAGHOUSE		
C110	CYCLONE - ID 107		
C111	SCRUBBER - ID 107		
C112	CARBON ADSORBER		
C113	ROLL FILTER		
FM01	NATURAL GAS		
S01	SCRUBBER 6 STACK		
S03	BAGHOUSE STACK		
S10	STACK - CARBON ADSORBER		

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.

001 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

A written list of the names of all odorous products shall be maintained. The list shall be updated on a weekly basis.

All odorous products must be processed through spray dryers 6 and/or 13 only with their associated carbon adsorber system.

If a product which was previously identified as having no odor proves to be odorous, it shall be added to the list of odorous products and run through lines 6 and/or 13 only in all future runs.

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.

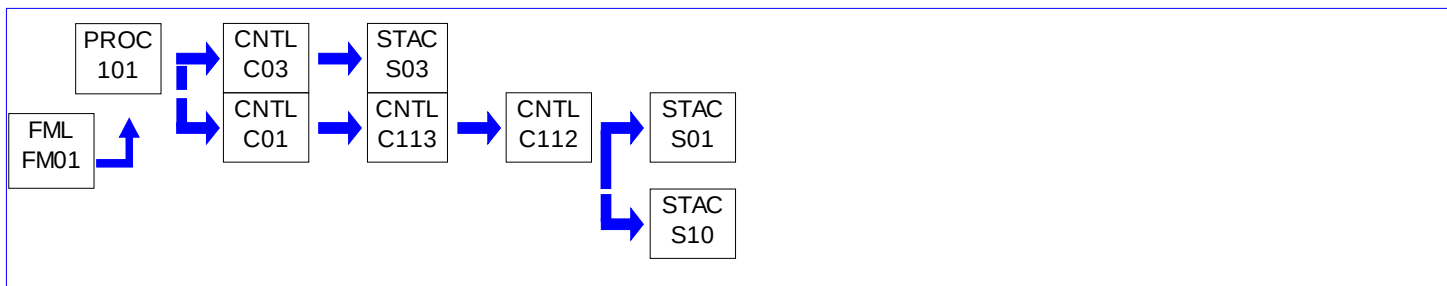
**SECTION D. Source Level Plan Approval Requirements**

Source ID: 101

Source Name: SPRAY DRYER 6

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.

001 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

Source ID 101 emissions are controlled by CD01 (Scrubber), CD03 (Baghouse) and C112 (Carbon adsorber).

No odor causing products shall be processed on Spray Dryer 6 (ID 101) without the Carbon adsorber operating (C112).

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

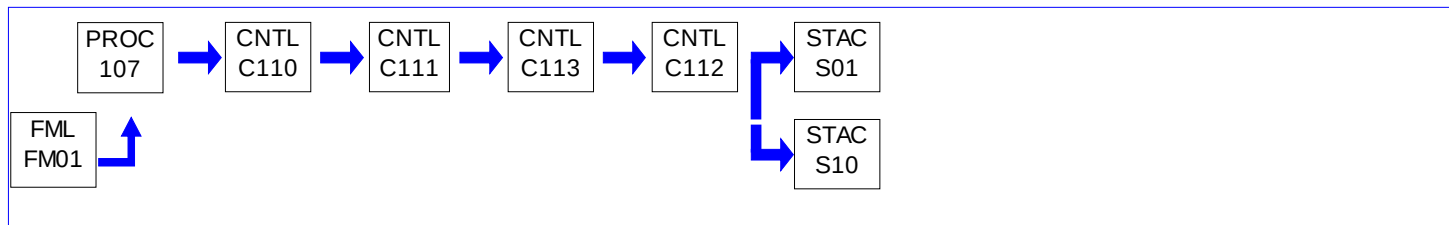
Source ID: 107

Source Name: SPRAY DRYER 13

Source Capacity/Throughput:

2.000 MMBTU/HR

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.

001 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

Any odor causing product must be run on Spray Dryer 13 (ID 107) while also running the carbon adsorber (C112).

Odor causing products shall include any products previously run on an uncontrolled line and caused detectable odors and any new products expected to create odors.

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

Group Name: GROUP 2

Group Description: Odor Controlled sources

Sources included in this group

ID	Name
101	SPRAY DRYER 6
107	SPRAY DRYER 13
C112	CARBON ADSORBER
C113	ROLL FILTER

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.**

Any odor causing product must be run on line 6 or line 13 (ID 101, 107) while also running the carbon adsorber (C112).

Odor causing products shall include any products previously run on an uncontrolled line and caused detectable odors and any new products expected to create odors.

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.**# 003 [25 Pa. Code §127.12b]****Plan approval terms and conditions.****FUGITIVE AND MALODOR EMISSIONS**

(a) The permittee shall conduct daily inspections of the facility perimeter, during daylight hours when the plant is in operation, to detect fugitive, and malodor emissions when either spray dryer(s) is operating and exhausting thru the carbon adsorber (C112) as follows:

(1) The presence of fugitive emissions at the facility, as stated in SECTION C - Condition #002 of SOOP 48-00089.

(2) The presence of malodor emissions beyond the boundaries of the facility, as stated in SECTION C - Condition #003 of SOOP 48-00089.

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

Each vessel will be equipped with appropriate sampling ports(inlet and outlet), pressure inlet flow gauges, and temperature indicators within each vessel.

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

The activated carbon beds shall be monitored (using an ionization detector) on a daily basis, on days product is running, at the inlet, between the first and second beds and after the second bed. If breakthrough of the first bed is detected, the first bed is removed, the second bed is shifted to the first position and the new bed is placed in the second position.

**SECTION E. Source Group Plan Approval Restrictions.****# 006 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

The carbon adsorber shall be equipped with instrumentation to measure the following:

- (1) Pressure drop across the adsorber
- (2) Incoming flow rate to the adsorber.

007 [25 Pa. Code §127.12b]**Plan approval terms and conditions.**

The roll filter shall be equipped with instrumentation to measure the following

- (1) Pressure drop across the filter

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

FUGITIVE, AND MALODOR EMISSIONS

(a) The permittee shall keep a logbook of fugitive, and malodor inspections performed. The logbook shall include the name of the company representative performing the inspection, the date and time of inspections, any instances of exceedances of visible emissions limitations, fugitive emissions limitations, and malodor emission limitations, and the name of the manager informed if a potential exceedance is observed. The permittee shall also record any and all corrective action(s) taken to abate each recorded deviation to prevent future occurrences.

(b) These records shall be kept for a five (5) year period and shall be made available to the Department upon request.

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

The company shall maintain records of the following:

- (a) Daily incoming flow rate to the carbon bed adsorber.
- (b) Daily pressure drop across the carbon bed adsorber.
- (c) Daily pressure drop across the roll filter.
- (d) Dates, times and readings for the PID VOC concentration weekly readings into and out of each adsorber chamber.
- (e) VOC emissions for the facility on a yearly (12-month rolling sum) basis.
- (f) Dates of maintenance performed on the carbon beds including dates when the carbon is replaced.
- (g) Dates of maintenance performed on the roll filter including dates when the roll media is replaced.
- (h) Date and time for each product processed through each line.
- (i) Safety data sheets for all products processed in each line.

These records shall be kept for five (5) years and shall be made available to the Department upon request.

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

A written list of the names of all odorous products shall be maintained. The list shall be updated on a weekly basis.

These records shall be kept for five (5) years and be made available to the Department upon request.

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

All sources and associated air cleaning devices shall be operated and maintained in accordance with manufacturer's specifications.

**SECTION E. Source Group Plan Approval Restrictions.****# 012 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

The source(s) shall not be operated without the carbon adsorber operating.

Spare carbon media shall be kept on site to change out media immediately when breakthrough is detected in the carbon media.

The product line must be shut down until the carbon media has been replaced when breakthrough is detected.

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

All odorous products must be processed through spray dryers 6 and/or 13 and the associated carbon adsorber system.

If a product which was previously identified as having no odor proves to be odorous, it shall be added to the list of odorous products and run through lines 6 and/or 13 in all future runs.

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

The roll filter (C113) shall automatically advance the media mechanically, based upon a timer or differential pressure setting of greater than 6 inches of water.

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 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 *****
