



COMMONWEALTH OF PENNSYLVANIA
DEPARTMENT OF ENVIRONMENTAL PROTECTION
AIR QUALITY PROGRAM

PLAN APPROVAL

Issue Date: October 31, 2025 Effective Date: September 20, 2026
Revision Date: September 15, 2026 Expiration Date: March 20, 2027
Revision Type: Extension

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. 15-0142A

Federal Tax Id - Plant Code: 38-4099125-1

Owner Information

Name: LAVAZZA NORTH AMERICA INC
Mailing Address: 1301 WILSON DR
WEST CHESTER, PA 19380-5954

Plant Information

Plant: LAVAZZA NORTH AMER/EAST GOSHEN TWP
Location: 15 Chester County 15919 East Goshen Township
SIC Code: 2095 Manufacturing - Roasted Coffee

Responsible Official

Name: DAVE AUGUSTIN
Title: MANUFACTURING DIRECTOR
Phone: (484) 574 - 1571 Email: David.augustin@lavazza.com

Plan Approval Contact Person

Name: RICHARD CLEMEN
Title: SR ENV AND SUSTAIN LEAD
Phone: (610) 442 - 0398 Email: Richard.Clemen@lavazza.com

[Signature] _____
JILLIAN A. GALLAGHER, SOUTHEAST REGION AIR PROGRAM MANAGER



Plan Approval Description

This plan approval will authorize the installation of coffee roasting process equipment consisting of a coffee roaster, coffee roaster cooler, afterburner/catalytic oxidizer and two cyclones.



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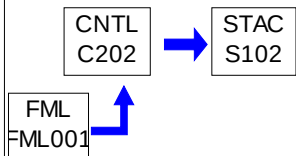
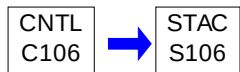
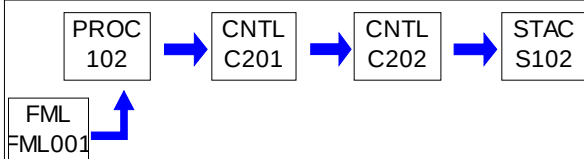
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**SECTION A. Plan Approval Inventory List**

Source ID	Source Name	Capacity/Throughput	Fuel/Material
101	COFFEE ROASTER	7.000 MMBTU/HR	
102	COFFEE ROASTER-2		
106	COFFEE ROASTER COOLER-2		
C106	COFFEE ROASTER COOLER CYCLONE-2	N/A	
C201	CHAFF COLLECTION ROASTING CYCLONE	N/A	
C202	AFTERBURNER/CATALYTIC OXIDIZER-2	N/A	
FML001	NATURAL GAS		
S102	AFTERBURNER/CAT OX STACK		
S106	COFFEE ROASTER COOLER CYCLONE-2 STACK		

PERMIT MAPS

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

**SECTION B. General Plan Approval Requirements**

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

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

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

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

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

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

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

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

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

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

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

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

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

(a) Pursuant to 35 P.S. § 4008, no person shall hinder, obstruct, prevent or interfere with the Department or its personnel in the performance of any duty authorized under the Air Pollution Control Act.

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

**SECTION B. General Plan Approval Requirements**

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

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

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

(a) The permittee constructs or operates the source subject to the plan approval in violation of the act, the Clean Air Act, the regulations promulgated under the act or the Clean Air Act, a plan approval or permit or in a manner that causes air pollution.

(b) The permittee fails to properly or adequately maintain or repair an air pollution control device or equipment attached to or otherwise made a part of the source.

(c) The permittee fails to submit a report required by this plan approval.

(d) The Environmental Protection Agency determines that this plan approval is not in compliance with the Clean Air Act or the regulations thereunder.

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

(a) The permittee, or any other person, may not circumvent the new source review requirements of 25 Pa. Code Chapter 127, Subchapter E by causing or allowing a pattern of ownership or development, including the phasing, staging, delaying or engaging in incremental construction, over a geographic area of a facility which, except for the pattern of ownership or development, would otherwise require a permit or submission of a plan approval application.

(b) No person may permit the use of a device, stack height which exceeds good engineering practice stack height, dispersion technique or other technique which, without resulting in reduction of the total amount of air contaminants emitted, conceals or dilutes an emission of air contaminants which would otherwise be in violation of this plan approval, the Air Pollution Control Act or the regulations promulgated thereunder, except that with prior approval of the Department, the device or technique may be used for control of malodors.

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

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

Regional Air Program Manager

PA Department of Environmental Protection

(At the address given on the plan approval transmittal letter or otherwise notified)

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

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

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

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

**SECTION B. General Plan Approval Requirements**

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

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

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

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

#013 [25 Pa. Code § 121.7]**Prohibition of Air Pollution**

No person may permit air pollution as that term is defined in the Air Pollution Control Act (35 P.S. §§ 4001-4015).

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

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



SECTION C. Site Level Plan Approval Requirements

I. RESTRICTIONS.

Emission Restriction(s).

001 [25 Pa. Code §123.42]

Exceptions

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

- (a) When the presence of uncombined water is the only reason for failure of the emission to meet the limitations.
- (b) When the emission results from the operation of equipment used solely to train and test persons in observing the opacity of visible emissions.
- (c) When the emission results from the sources specified in 25 Pa. Code § 123.1(a) (relating to prohibition of certain fugitive emissions).

II. TESTING REQUIREMENTS.

002 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

- (a) If at any time DEP has cause to believe that air contaminant emissions from any source may be in excess of the limitations specified in this Plan Approval, or established pursuant to, any applicable rule or regulation contained in 25 Pa. Code Article III, the permittee shall be required to conduct whatever tests are deemed necessary by DEP to determine the actual emission rate(s).
- (b) Such testing shall be conducted in accordance with the provisions of 25 Pa. Code Chapter 139, the most current version of the DEP Source Testing Manual, and the EPA Clean Air Act National Stack Testing Guidance, when applicable, and in accordance with any restrictions or limitations established by DEP at such time as it notifies the permittee that testing is required.

III. MONITORING REQUIREMENTS.

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

IV. RECORDKEEPING REQUIREMENTS.

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

V. REPORTING REQUIREMENTS.

003 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

- (a) The permittee shall report malfunctions, emergencies or incidents of excess emissions to DEP's 24-hour Emergency Hotline at 800.541.2050. A malfunction is any sudden, infrequent, and not reasonably preventable failure of air pollution control equipment, process equipment, or a process to operate in a normal or usual manner. An emergency is any situation arising from sudden and reasonably unforeseeable events beyond the control of the owner or operator of a facility which requires immediate corrective action to restore normal operation and which causes the emission source to exceed emissions, due to unavoidable increases in emissions attributable to the situation. An emergency shall not include situations caused by improperly designed equipment, lack of preventive maintenance, careless or improper operation, or operator error.
- (b) When the malfunction, emergency or incident of excess emissions poses an imminent danger to the public health, safety, welfare, or environment, it shall be reported to DEP and the County Emergency Management Agency by telephone within one (1) hour after the discovery of the malfunction, emergency or incident of excess emissions. The owner or operator shall submit a written or emailed report of instances of such malfunctions, emergencies or incidents of excess emissions to DEP within three (3) business days of the telephone report.
- (c) The report shall describe the following:

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

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

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

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

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

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

004 [25 Pa. Code §135.3]**Reporting**

If the permittee has been previously advised by DEP to submit a source report, the permittee shall submit by March 1, of each year, a source report for the preceding calendar year. The report shall include information from all previously reported sources, new sources which were first operated during the preceding calendar year, and sources modified during the same period which were not previously reported, including those sources listed in the Miscellaneous Section of this permit.

The permittee may request an extension of time from DEP for the filing of a source report, and DEP may grant the extension for reasonable cause.

VI. WORK PRACTICE REQUIREMENTS.**# 005 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

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

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

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

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

The permittee shall comply with all of the existing requirements of its current State Only Operating Permit, No. 15-00142, unless specifically revised in this plan approval. The provisions in this plan approval shall be construed to supersede any contrary provisions in any previous operating permit.



SECTION C. Site Level Plan Approval 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: COFFEE ROASTER

Source Capacity/Throughput:

7.000 MMBTU/HR

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

001 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

The permittee shall limit the throughput of the coffee roasters (Source ID 101 and 102) to 19,272 tons of green coffee beans per 12-month rolling sum basis.

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.

002 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

he permittee shall record the throughput, in tons, of green coffee beans processed through the coffee roasters (Source ID 101 and 102), on a monthly and 12-month rolling basis.

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.

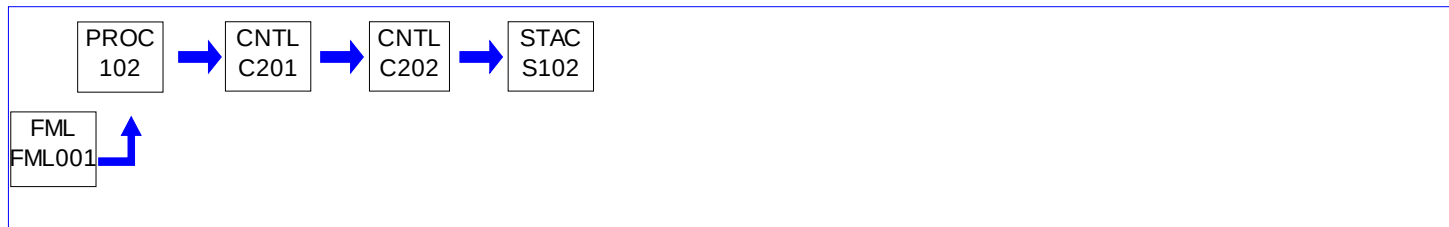
No additional requirements exist except as provided in other sections of this plan approval including Section B (Plan Approval General Requirements).

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

Source ID: 102

Source Name: COFFEE ROASTER-2

Source Capacity/Throughput:

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

001 [25 Pa. Code §123.13]

Processes

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

Throughput Restriction(s).

002 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

The permittee shall limit the throughput of the coffee roasters (Source ID 101 and 102) to 19,272 tons of green coffee beans per 12-month rolling sum basis.

II. TESTING REQUIREMENTS.

003 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

(a) The permittee shall perform a stack test using the DEP-approved procedures, to show compliance with the emission limits set for the source. The Source testing shall be performed within 180 days after startup of the source(s) and control device(s). Source testing shall be performed for the following pollutants: carbon monoxide (CO), particulate matter (PM) (filterable and condensable) and volatile organic compounds. Performance tests shall be conducted while the source is operating at maximum routine operating conditions or under such other conditions, within the capacity of the equipment, as may be requested by DEP.

(b) The stack test shall, at a minimum, test for the

CO - Method 10

filterable PM - Method 5/201

condensable PM - Method 202

Total Hydrocarbon, as a surrogate, for VOC - Method 25A

Tests shall be conducted in accordance with the provisions of the EPA Methods or other DEP approved methodology and 25 Pa. Code Chapter 139. Tests shall also be conducted in accordance with the provisions of the current version of the DEP Source Testing Manual and the EPA Clean Air Act National Stack Testing Guidance.

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

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

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

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

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

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

The permittee shall monitor the following:

- (a) fuel usage by the coffee roaster on a monthly basis
- (b) VOC, PM, CO, NO_x, and SO₂ emissions on a monthly and on a 12-month rolling basis, for the coffee roaster. Emissions shall be calculated using emissions factors approved by DEP.

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

The permittee shall record the throughput, in tons, of green coffee beans processed through the coffee roasters (Source ID 101 and 102), on a monthly and 12-month rolling basis.

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

The permittee shall keep records of the following:

- (a) emissions factors and data used in the emissions calculations.
- (b) fuel usage by the coffee roaster on a monthly basis
- (c) hours of operation of each source on a monthly basis.
- (d) VOC, PM, CO, NO_x, and SO₂ emissions on a monthly and on a 12-month rolling basis. Emissions shall be calculated using emissions factors approved by DEP.
- (e) maintenance performed including, but not limited to:
 - (i) monthly maintenance activities.
 - (ii) weekly thermal cleaning activity
 - (iii) semiannual dry ice blasting

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

The permittee shall perform:

- (a) monthly maintenance activities
- (b) weekly thermal cleaning of the roaster
- (c) dry ice blasting of the roaster on a semiannual basis

VII. ADDITIONAL REQUIREMENTS.

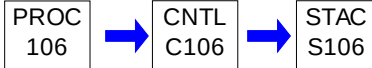
No additional requirements exist except as provided in other sections of this plan approval including Section B (Plan Approval General Requirements).

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

Source ID: 106

Source Name: COFFEE ROASTER COOLER-2

Source Capacity/Throughput:

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

001 [25 Pa. Code §123.13]

Processes

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

II. TESTING REQUIREMENTS.

002 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

(a) The permittee shall perform a stack test using the DEP-approved procedures, to show compliance with the emission limits set for the source. The Source testing shall be performed within 180 days after startup of the source(s) and control device(s). Source testing shall be performed for the following pollutants: particulate matter (PM) (filterable and condensable) and volatile organic compounds. Performance tests shall be conducted while the source is operating at maximum routine operating conditions or under such other conditions, within the capacity of the equipment, as may be requested by DEP.

(b) The stack test shall, at a minimum, test for the

filterable PM - Method 5/201

condensable PM - Method 202

Total Hydrocarbon, as a surrogate, for VOC - Method 25A

Tests shall be conducted in accordance with the provisions of the EPA Methods or other DEP approved methodology and 25 Pa. Code Chapter 139. Tests shall also be conducted in accordance with the provisions of the current version of the DEP Source Testing Manual and the EPA Clean Air Act National Stack Testing Guidance.

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

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

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

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

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).

**SECTION D. Source Level Plan Approval Requirements****IV. RECORDKEEPING REQUIREMENTS.****# 003 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

The permittee shall keep records of the following:

- (a) roasted coffee throughput, in tons, on a monthly and 12-month rolling basis
- (b) hours of operation on a monthly basis
- (c) maintenance performed on the equipment

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).

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

Source ID: C106

Source Name: COFFEE ROASTER COOLER CYCLONE-2

Source Capacity/Throughput:

N/A

CNTL C106	→	STAC S106
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I. RESTRICTIONS.**Emission Restriction(s).**

001 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

The pressure drop range across the cyclone shall be maintained between 1.96 and 4.01 in. of water column.

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.

002 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

The permittee shall monitor the pressure drop across the Roaster Cooler Cyclone at least once daily when in operation.

IV. RECORDKEEPING REQUIREMENTS.

003 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

The permittee shall record the pressure drop across the Roaster Cooler Cyclone at least once daily when in operation.

004 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

The permittee shall keep records of the following:

- (a) the pressure drop across the Coffee Roaster Cooler Cyclone at least once daily when in operation
- (b) hours of operation on a monthly basis
- (c) maintenance performed on the control device

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.

005 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

- (a) The permittee shall operate and maintain the sources and associated control devices according to the manufacturer's specifications and good air pollution control practices.
- (b) The permittee shall operate each control device at all times that the source is operating.



SECTION D. Source Level Plan Approval 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).

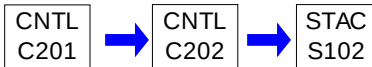
**SECTION D. Source Level Plan Approval Requirements**

Source ID: C201

Source Name: CHAFF COLLECTION ROASTING CYCLONE

Source Capacity/Throughput:

N/A

**I. RESTRICTIONS.****Operation Hours Restriction(s).**

001 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

The pressure drop range across the cyclone shall be maintained between 4.42 and 9.03 in. of water column.

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.

002 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

The permittee shall continuously measure the pressure drop across the Chaff Collection Roasting Cyclone when the coffee roaster is in operation.

IV. RECORDKEEPING REQUIREMENTS.

003 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

The permittee shall keep records of the following:

- (a) pressure drop across the Chaff Collection Roasting Cyclone Roaster Cyclone at least once daily when in operation.
- (b) hours of operation on a monthly basis.
- (c) maintenance performed on the control device.

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.

004 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

- (a) The permittee shall operate and maintain the sources and associated control devices according to the manufacturer's specifications and good air pollution control practices.
- (b) The permittee shall operate the control device at all times that the source is operating.
- (c) The permittee shall perform weekly thermal cleaning of the cyclone.



SECTION D. Source Level Plan Approval 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).

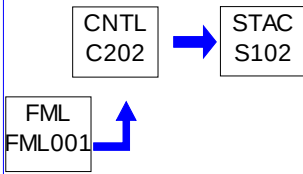
**SECTION D. Source Level Plan Approval Requirements**

Source ID: C202

Source Name: AFTERBURNER/CATALYTIC OXIDIZER-2

Source Capacity/Throughput:

N/A

**I. RESTRICTIONS.****Control Device Efficiency Restriction(s).**

001 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

The pressure drop across the afterburner/catalytic oxidizer shall be maintained between 0.8 and 1.2 in. of water column.

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.

002 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

The permittee shall:

- (a) continuously measure the pressure drop across the afterburner/catalytic oxidizer
- (b) continuously measure the inlet and outlet temperatures of the afterburner/catalytic oxidizer
- (c) fuel usage by the afterburner/catalytic oxidizer on a monthly basis
- (d) hours of operation on a monthly basis
- (e) maintenance performed on each source and control device

IV. RECORDKEEPING REQUIREMENTS.

003 [25 Pa. Code §127.12b]

Plan approval terms and conditions.

The permittee shall keep records of the following:

- (a) pressure drop across the afterburner/catalytic oxidizer bed continuously and record the pressure drop a minimum of once a day that the coffee roaster is operating.
- (b) inlet and outlet temperatures of the afterburner/catalytic oxidizer continuously. The permittee shall record the maximum temperature differential (including inlet and outlet temperatures) during a batch cycle a minimum of once a day that the coffee roaster is operating.
- (c) fuel usage by the catalytic oxidizer on a monthly basis
- (d) hours of operation on a monthly basis
- (e) maintenance performed

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

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

VI. WORK PRACTICE REQUIREMENTS.**# 004 [25 Pa. Code §127.12b]****Plan approval terms and conditions.**

- (a) The permittee shall operate and maintain the control device according to the manufacturer's specifications and good air pollution control practices.
- (b) The permittee shall operate the control device at all times that the source is operating.
- (c) The permittee shall perform monthly maintenance on the catalyst.
- (d) The permittee shall inspect and clean the catalyst on a semiannual basis.
- (e) The permittee shall perform monthly testing and maintenance on catalyst bed pressure monitoring device.

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

- (a) Exhaust gases entering the afterburner/catalytic oxidizer shall be a minimum temperature of 626 F (330 C), prior to operation of the coffee roaster. The permittee shall subsequently operate the afterburner/catalytic oxidizer at a minimum sustainable temperature of 626 F (330 C) for the exhaust gases entering the catalytic oxidizer during the roasting of green coffee beans.
- (b) The operating temperature of the exhaust gases exiting the afterburner/catalytic oxidizer shall be in the range of 662 F (350 C) to 842 F (450 C) during the roasting of green coffee beans.

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.

**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 *****
