



**COMMONWEALTH OF PENNSYLVANIA
DEPARTMENT OF ENVIRONMENTAL PROTECTION
AIR QUALITY PROGRAM**

TITLE V/STATE OPERATING PERMIT

Issue Date: February 2, 2023

Effective Date: February 2, 2023

Expiration Date: February 2, 2028

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 operate the air emission source(s) more fully described in this permit. This Facility is subject to all terms and conditions specified in this permit. Nothing in this permit 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 permit condition is set forth in brackets. All terms and conditions in this permit are federally enforceable applicable requirements unless otherwise designated as "State-Only" or "non-applicable" requirements.

TITLE V Permit No: 39-00011

Federal Tax Id - Plant Code: 38-2943735-1

Owner Information

Name: HOLCIM (US) INC
Mailing Address: 5160 MAIN ST
WHITEHALL, PA 18052-1827

Plant Information

Plant: HOLCIM (US) INC/WHITEHALL PLT
Location: 39 Lehigh County 39925 Whitehall Township
SIC Code: 3241 Manufacturing - Cement, Hydraulic

Responsible Official

Name: LORRAINE FACCENDA
Title: PLANT MANAGER
Phone: (610) 261 - 3453 Email: lorraine.faccenda@lafargeholcim.com

Permit Contact Person

Name: ROBERT MCGEHEE
Title: DIRECTOR OF ENVIR & LAND
Phone: (518) 545 - 7556 Email: Robert.McGehee@holcim.com

[Signature] _____
MARK J. WEJKSZNER, NORTHEAST REGION AIR PROGRAM MANAGER



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

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**SECTION A. Site Inventory List**

Source ID	Source Name	Capacity/Throughput		Fuel/Material
035	EMERGENCY GENERATOR (85KW)	0.300	MMBTU/HR	
036	EMERGENCY GENERATOR (150 KW)	0.600	MMBTU/HR	
037	RANSOME GENERATOR (EAST)	17.100	MMBTU/HR	
		131.000	Gal/HR	#2 Oil
038	RANSOME GENERATOR (CENTER)	17.100	MMBTU/HR	
		131.000	Gal/HR	#2 Oil
039	RANSOME GENERATOR (WEST)	17.100	MMBTU/HR	
		131.000	Gal/HR	#2 Oil
101	K-2 KILN WITH PREHEATER/SNCR & DAA INJECTION SYSTEM	780.000	Gal/HR	#2 Oil
		70.000	Tons/HR	CLINKER
		10.000	Tons/HR	Bituminous
		3.000	Tons/HR	TDF
		4.000	Tons/HR	Coke
		3.300	Tons/HR	PDF
103	K-2 COOLER	70.000	Tons/HR	CLINKER
105	K-2 CLINKER TOWER	100.000	Tons/HR	CLINKER
106	BULK SILOS (B-5 D.C.)	200.000	Tons/HR	CEMENT
107	BULK SILO GROUP (B-9 D.C.)	200.000	Tons/HR	CEMENT
108	#1 RAW GRINDING MILL	110.000	Tons/HR	CEMENT ROCK
		93.300	Gal/HR	#2 Oil
109	H1/H2 HOMO SILO	220.000	Tons/HR	CEMENT ROCK
110	QUARRY IMPACTOR	750.000	Tons/HR	CEMENT ROCK
112	H3/H4 HOMO SILO	220.000	Tons/HR	CEMENT ROCK
113	K-2 DUST RETURN SYSTEM	180.000	Tons/HR	CEMENT DUST
114	K-3 KILN WITH PREHEATER/SNCR & DAA INJECTION SYSTEM	780.000	Gal/HR	#2 Oil
		50.000	Tons/HR	CLINKER
		5.000	Tons/HR	Bituminous
		2.000	Tons/HR	TDF
		2.500	Tons/HR	Coke
		3.300	Tons/HR	PDF
115	K-3 COOLER	50.000	Tons/HR	CLINKER
122	#2 FINISH MILL OSEPA	90.000	Tons/HR	CEMENT
123	CLINKER SILOS GROUP COLLECTOR	125.000	Tons/HR	CLINKER
124	K-3 CLINKER TOWER	60.000	Tons/HR	CLINKER
125	K-3 CLINKER TRANSFER TOWER			
127	#1 FINISH GRINDING MILL	70.000	Tons/HR	CEMENT
128	#2 FINISH GRINDING MILL	90.000	Tons/HR	CEMENT
129	#2 FINISH MILL AUXILLARIES	90.000	Tons/HR	CEMENT
132	PACKHOUSE 4 (EAST)	400.000	Tons/HR	CEMENT
133	B-13 & B-14 BULK SILOS	90.000	Tons/HR	CEMENT
135	H5/H6 HOMO SILO	220.000	Tons/HR	CEMENT ROCK

**SECTION A. Site Inventory List**

Source ID	Source Name	Capacity/Throughput	Fuel/Material
136	BULK SILOS LANE 1 REAR SPOUT	360.000 Tons/HR	CEMENT
137	FINISH MILL 1 AUXILIARIES	70.000 Tons/HR	CEMENT
138	#2 RAW GRINDING MILL	110.000 Tons/HR	CEMENT ROCK
		93.300 Gal/HR	#2 Oil
139	CLINKER STORAGE BUILDING	150.000 Tons/HR	CLINKER
140	BULK SILOS LANE 1 FRONT SPOUT	360.000 Tons/HR	CEMENT
141	BULK SILOS LANE 2 SPOUT	360.000 Tons/HR	CEMENT
143	COAL MILL 2	8.000 Tons/HR	COAL
144	COAL MILL 3	6.100 Tons/HR	COAL
145	PULVERIZED FUEL BIN	36.000 Tons/HR	PULVERIZED FUEL
146	K-2 FEED SYSTEM	140.000 Tons/HR	KILN FEED
148	#4 PACKHOUSE (WEST)	400.000 Tons/HR	CEMENT
149	#1 PACKHOUSE WEST	200.000 Tons/HR	CEMENT
150	#1 PACKHOUSE EAST	200.000 Tons/HR	CEMENT
151	CEMENT SILOS S10 - S23 GROUP	125.000 Tons/HR	CEMENT
152	NOS. 2 & 6 CLINKER SILOS LOADOUT SPOUTS		
153	BULK SILO B-11		
154	CEMENT/SLAG BLENDER		
155	PDF TRANSFER SYSTEM		
160	MISC FUGITIVE EMISSIONS		
162	1 FINISH MILL HES		
163	CLINKER RECLAIM BELT CONVEYOR SYSTEM		
164	PEBBLE LIME SILO		
165	RAW BELT 1		
170	STONE SILO 5 & 6 W/ BELT 9		
171	AMMONIA STORAGE TANK-12,000 GALLON CAPACITY		
172	HYDRATED LIME STORAGE SILO		
173	ARM FEEDING PROCESS		
C01	K-2 KILN BAGHOUSE		
C02	P-1 KILN BAGHOUSE		
C03	K-3 KILN BAGHOUSE		
C04	K-2 COOLER BAGHOUSE		
C06	K-3 COOLER BAGHOUSE		
C07	CLINKER TOWER COL		
C08	COAL MILL 2 BAGHOUSE		
C14	#2 FINISH MILL OSEPA BH		
C15	CLINKER SILOS DC		
C16	K-3 CLINKER TOWER BAGHOUSE		
C17	K-3 CLINKER TRANSFER TOWER BH		
C170	FABRIC COLLECTOR 5/6 SILO W/BIN VENT		

**SECTION A. Site Inventory List**

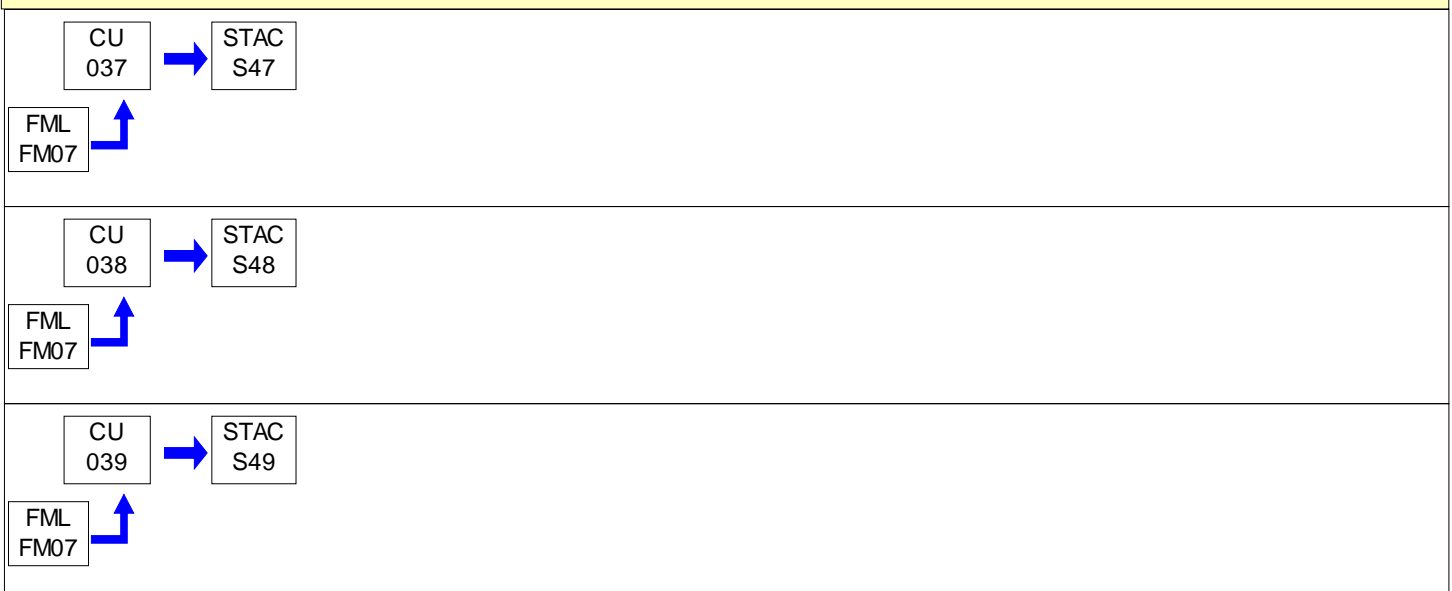
Source ID	Source Name	Capacity/Throughput	Fuel/Material
C172	LIME SILO BAGHOUSE		
C18	#1 FINISH GRINDING MILL B		
C19	#2 FINISH GRINDING MILL B		
C20	#2 FINISH MILL AUX BH		
C21	#1 RAW MILL BAGHOUSE		
C22	#2 RAW MILL BAGHOUSE		
C25	H5/H6 HOMO SILO BAGHOUSE		
C26	K-2 DUST RETURN BAGHOUSE		
C27	COAL MILL 3 BAGHOUSE		
C28	QUARRY IMPACTOR BAGHOUSE		
C29	#1 FIN.MILL AUX		
C30	#1 PACKHOUSE BAGHOUSE (EAST)		
C31	#1 PACKHOUSE BAGHOUSE		
C34	BULK SILO GROUP (B5 DC)		
C35	BULK SILO GROUP (B9 DC)		
C36	B-13 + B-14 SILO BAGHOUSE		
C39	PULV FUEL SILO 1 BAGHOUSE		
C40	#4 PACKHOUSE BAGHOUSE (WEST)		
C41	CLINKER HALL BAGHOUSE		
C43	BULK SILO LANE 1 FRONT SPOUT		
C44	BULK SILO LANE 1 REAR SPOUT		
C45	BULK SILO LANE 2 SPOUT		
C47	PACKHOUSE 4 BAGHOUSE (EAST)		
C48	#1 PACKHOUSE WEST COLLECTOR		
C50	CEMENT SILOS S10 - S23 GROUP COLLECTOR		
C51	#1 FINISH MILL HES BAGHOUSE		
C52	NOS. 2 & 6 CLINKER SILOS LOADOUT SPOUTS COLLECTOR		
C53	BULK SILO B-11 BAGHOUSE		
C55	PDF FEED BINS BAGHOUSE		
C61	CLINKER RECLAIM FABRIC COLLECTOR 1		
C62	CLINKER RECLAIM FABRIC COLLECTOR 2		
C63	CLINKER RECLAIM FABRIC COLLECTOR 3		
C64	CLINKER RECLAIM FABRIC COLLECTOR 4		
C65	CLINKER RECLAIM FABRIC COLLECTOR 5		
C66	CLINKER RECLAIM FABRIC COLLECTOR 6		
C67	CLINKER RECLAIM FABRIC COLLECTOR 7		
C68	CLINKER RECLAIM FABRIC COLLECTOR 8		
C69	CLINKER RECLAIM FABRIC COLLECTOR 9		
C70	PEBBLE LIME SILO FABRIC COLLECTOR		
C71	RAW BELT 1 FABRIC COLLECTOR		

**SECTION A. Site Inventory List**

Source ID	Source Name	Capacity/Throughput	Fuel/Material
C75	H1-H4 HOMO SILOS FABRIC COLLECTOR		
C76	K-2 FEED SYSTEM BAGHOUSE		
FM04	# 2 OIL		
FM05	SCRAP TIRE STORAGE		
FM06	BITUMINOUS COAL & COKE		
FM07	GENERATOR FUEL STORAGE (#2 OIL)		
FM08	#5 FUEL OIL		
FM09	SCRAP PLASTIC STORAGE		
FM10	NATURAL GAS MAIN		
S01	K-2 STACK		
S02	K-3 KILN STACK		
S04	K1/K2 CLK TOWER VENT		
S05	K2 COAL MILL VENT		
S06	K2 COOLER VENT		
S11	#2 FMOSEPA VENT		
S12	K3 COOLER VENT		
S13	K3 CLINKER TOWER VENT		
S14	K3 CLK TRNS VENT		
S15	#1 FINISH MILL VENT		
S16	#2 FINISH MILL VENT		
S17	#2 FINISH MILL AUX. VENT		
S170	FABRIC COLLECTOR STONE SILO 5/6 STACK		
S172	LIME SILO BAGHOUSE STACK		
S18	#1 RAW MILL VENT		
S19	#2 RAW MILL VENT		
S22	H5/H6 HOMO SILO VENT		
S23	K2 DUST RETURN SYS VENT		
S24	K3 COAL MILL VENT		
S25	IMPACTOR DC VENT		
S26	#1 FINISH MILL AUX VENT		
S28	#1 PH EAST DC VENT		
S31	B5 DUST COLLECTOR VENT		
S32	B9 DUST COLLECTOR VENT		
S33	B13/B14 DC VENT		
S36	PF BIN DC VENT		
S41	CLINKER STORAGE BLDG		
S42	BULK SILO LANE 1 FRONT		
S43	BULK SILO LANE 1 REAR		
S44	BULK SILO LANE 2 VENT		
S47	RANSOME GENERATOR EAST		

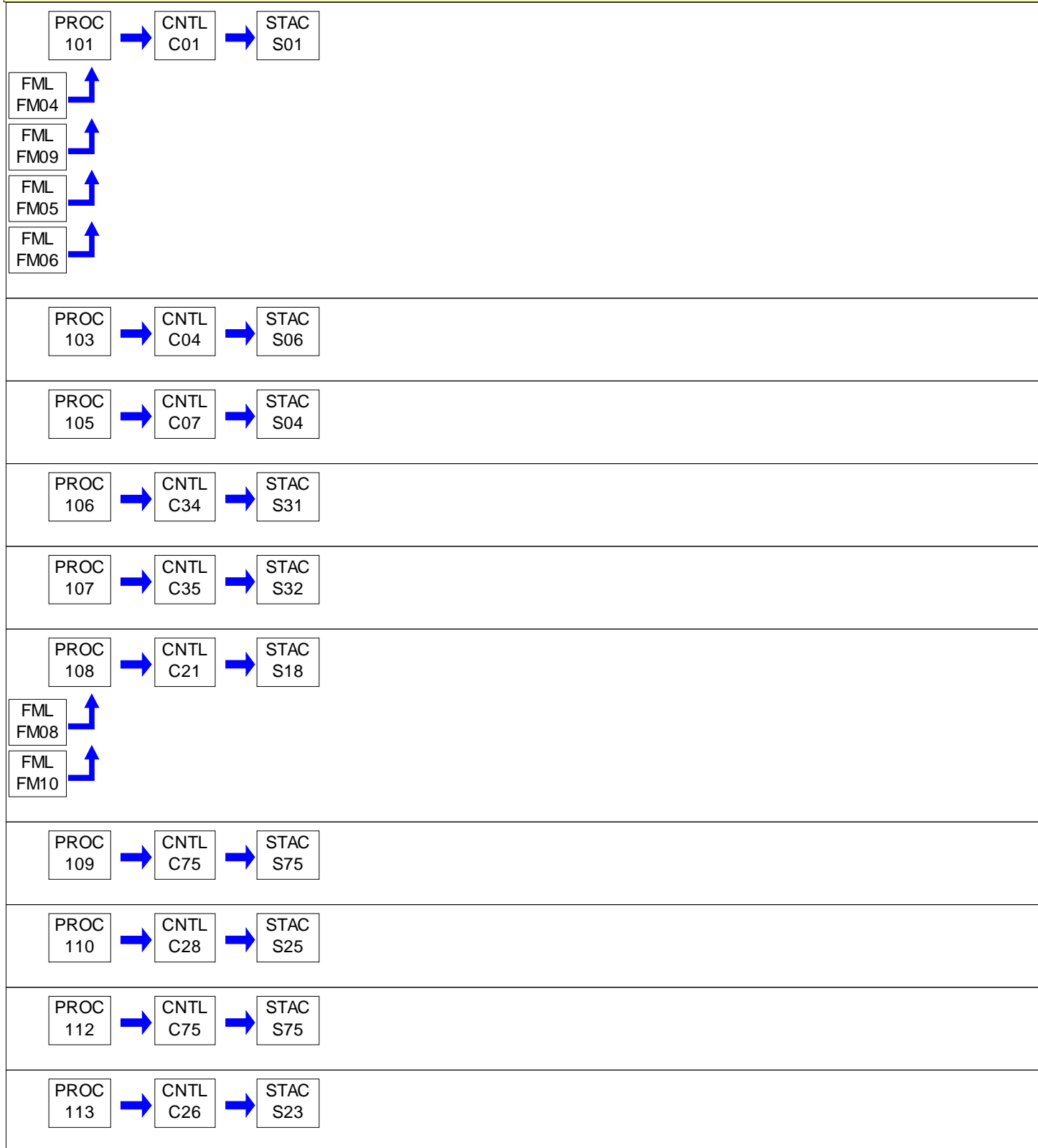
**SECTION A. Site Inventory List**

Source ID	Source Name	Capacity/Throughput	Fuel/Material
S48	RANSOME GENERATOR CENTER		
S49	RANSOME GENERATOR WEST		
S50	CLINKER SILO DC VENT		
S52	PACKHOUSE 4 STACK (EAST)		
S53	PACKHOUSE 1 STACK (WEST)		
S54	PACKHOUSE STACK 4 (WEST)		
S55	SILOS S10-S23		
S56	#1 FINISH MILL HES STACK		
S57	NOS. 2 & 6 LOADOUT SPOUTS COLLECTOR STACK		
S58	BULK SILO B-11 COLLECTOR VENT		
S60	PDF TRANSFER SYSTEM - STACK		
S61	CLINKER RECLAIM COLLECTOR 1 STACK		
S62	CLINKER RECLAIM COLLECTOR 2 STACK		
S63	CLINKER RECLAIM COLLECTOR 3 STACK		
S64	CLINKER RECLAIM COLLECTOR 4 STACK		
S65	CLINKER RECLAIM COLLECTOR 5 STACK		
S66	CLINKER RECLAIM COLLECTOR 6 STACK		
S67	CLINKER RECLAIM COLLECTOR 7 STACK		
S68	CLINKER RECLAIM COLLECTOR 8 STACK		
S69	CLINKER RECLAIM COLLECTOR 9 STACK		
S70	PEBBLE LIME SILO COLLECTOR STACK		
S71	RAW BELT 1 COLLECTOR STACK		
S75	H1-H4 HOMO SILOS COLLECTOR STACK		
S76	K-2 FEED SYSTEM BAGHOUSE STACK		
Z02	LAFARGE CORP/WHITEHALL PLT		

PERMIT MAPS

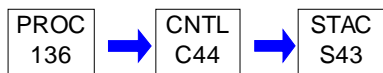
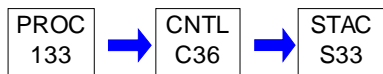
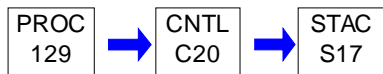
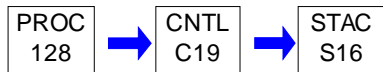
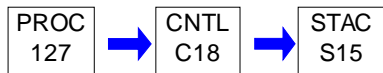
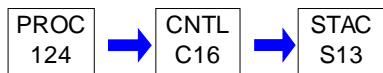
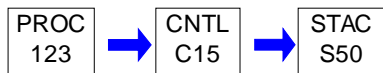
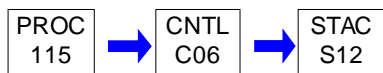
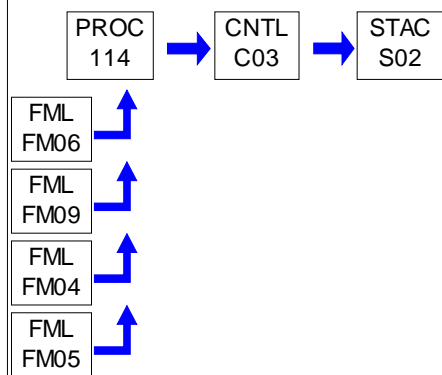


PERMIT MAPS





PERMIT MAPS



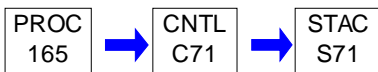
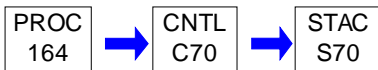
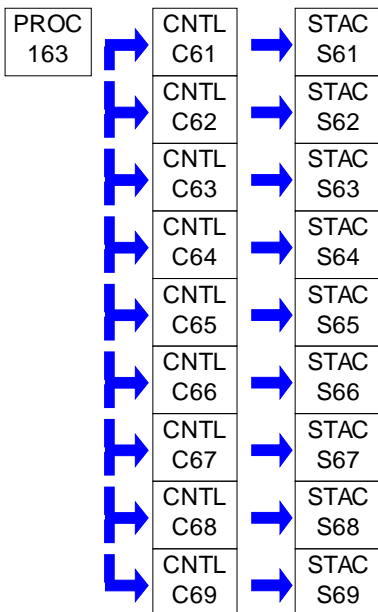
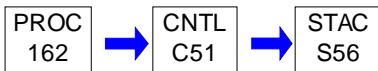
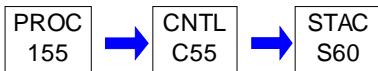
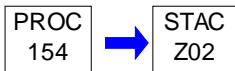
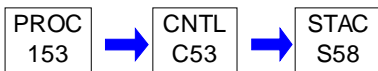


PERMIT MAPS





PERMIT MAPS



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

Words and terms that are not otherwise defined in this permit 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 § 121.7]**Prohibition of Air Pollution**

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

#003 [25 Pa. Code § 127.512(c)(4)]**Property Rights**

This permit does not convey property rights of any sort, or any exclusive privileges.

#004 [25 Pa. Code § 127.446(a) and (c)]**Permit Expiration**

This operating permit is issued for a fixed term of five (5) years and shall expire on the date specified on Page 1 of this permit. The terms and conditions of the expired permit shall automatically continue pending issuance of a new Title V permit, provided the permittee has submitted a timely and complete application and paid applicable fees required under 25 Pa. Code Chapter 127, Subchapter I and the Department is unable, through no fault of the permittee, to issue or deny a new permit before the expiration of the previous permit. An application is complete if it contains sufficient information to begin processing the application, has the applicable sections completed and has been signed by a responsible official.

#005 [25 Pa. Code §§ 127.412, 127.413, 127.414, 127.446(e), 127.503 & 127.704(b)]**Permit Renewal**

(a) An application for the renewal of the Title V permit shall be submitted to the Department at least six (6) months, and not more than 18 months, before the expiration date of this permit. The renewal application is timely if a complete application is submitted to the Department's Regional Air Manager within the timeframe specified in this permit condition.

(b) The application for permit renewal shall include the current permit number, the appropriate permit renewal fee, a description of any permit revisions and off-permit changes that occurred during the permit term, and any applicable requirements that were promulgated and not incorporated into the permit during the permit term. The fees shall be made payable to "The Commonwealth of Pennsylvania Clean Air Fund" and submitted with the fee form to the respective regional office.

(c) The renewal application shall also include submission of proof that the local municipality and county, in which the facility is located, have been notified in accordance with 25 Pa. Code § 127.413. The application for renewal of the Title V permit shall also include submission of compliance review forms which have been used by the permittee to update information submitted in accordance with either 25 Pa. Code § 127.412(b) or § 127.412(j).

(d) The permittee, upon becoming aware that any relevant facts were omitted or incorrect information was submitted in the permit application, shall promptly submit such supplementary facts or corrected information during the permit renewal process. The permittee shall also promptly provide additional information as necessary to address any requirements that become applicable to the source after the date a complete renewal application was submitted but prior to release of a draft permit.

#006 [25 Pa. Code §§ 127.450(a)(4) & 127.464(a)]**Transfer of Ownership or Operational Control**

(a) In accordance with 25 Pa. Code § 127.450(a)(4), a change in ownership or operational control of the source shall be treated as an administrative amendment if:

- (1) The Department determines that no other change in the permit is necessary;
- (2) A written agreement has been submitted to the Department identifying the specific date of the transfer of permit responsibility, coverage and liability between the current and the new permittee; and,
- (3) A compliance review form has been submitted to the Department and the permit transfer has been approved by

**SECTION B. General Title V Requirements**

the Department.

(b) In accordance with 25 Pa. Code § 127.464(a), this permit may not be transferred to another person except in cases of transfer-of-ownership which are documented and approved to the satisfaction of the Department.

#007 [25 Pa. Code § 127.513, 35 P.S. § 4008 and § 114 of the CAA]**Inspection and Entry**

(a) Upon presentation of credentials and other documents as may be required by law for inspection and entry purposes, the permittee shall allow the Department of Environmental Protection or authorized representatives of the Department to perform the following:

- (1) Enter at reasonable times upon the permittee's premises where a Title V source is located or emissions related activity is conducted, or where records are kept under the conditions of this permit;
- (2) Have access to and copy or remove, at reasonable times, records that are kept under the conditions of this permit;
- (3) Inspect at reasonable times, facilities, equipment including monitoring and air pollution control equipment, practices, or operations regulated or required under this permit;
- (4) Sample or monitor, at reasonable times, substances or parameters, for the purpose of assuring compliance with the permit or applicable requirements as authorized by the Clean Air Act, the Air Pollution Control Act, or the regulations promulgated under the Acts.

(b) 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.

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

#008 [25 Pa. Code §§ 127.25, 127.444, & 127.512(c)(1)]**Compliance Requirements**

(a) The permittee shall comply with the conditions of this permit. Noncompliance with this permit constitutes a violation of the Clean Air Act and the Air Pollution Control Act and is grounds for one (1) or more of the following:

- (1) Enforcement action
- (2) Permit termination, revocation and reissuance or modification
- (3) Denial of a permit renewal application

(b) A person may not cause or permit the operation of a source, which is subject to 25 Pa. Code Article III, unless the source(s) and air cleaning devices identified in the application for the plan approval and operating permit and the plan approval issued to the source are operated and maintained in accordance with specifications in the applications and the conditions in the plan approval and operating permit issued by the Department. A person may not cause or permit the operation of an air contamination source subject to 25 Pa. Code Chapter 127 in a manner inconsistent with good operating practices.

(c) For purposes of Sub-condition (b) of this permit condition, the specifications in applications for plan approvals and operating permits are the physical configurations and engineering design details which the Department determines are essential for the permittee's compliance with the applicable requirements in this Title V permit.

#009 [25 Pa. Code § 127.512(c)(2)]**Need to Halt or Reduce Activity Not a Defense**

It shall not be a defense for a permittee in an enforcement action that it would have been necessary to halt or reduce the permitted activity in order to maintain compliance with the conditions of this permit.

**SECTION B. General Title V Requirements****#010 [25 Pa. Code §§ 127.411(d) & 127.512(c)(5)]****Duty to Provide Information**

(a) The permittee shall furnish to the Department, within a reasonable time, information that the Department may request in writing to determine whether cause exists for modifying, revoking and reissuing, or terminating the permit, or to determine compliance with the permit.

(b) Upon request, the permittee shall also furnish to the Department copies of records that the permittee is required to keep by this permit, or for information claimed to be confidential, the permittee may furnish such records directly to the Administrator of EPA along with a claim of confidentiality.

#011 [25 Pa. Code §§ 127.463, 127.512(c)(3) & 127.542]**Reopening and Revising the Title V Permit for Cause**

(a) This Title V permit may be modified, revoked, reopened and reissued or terminated for cause. The filing of a request by the permittee for a permit modification, revocation and reissuance, or termination, or of a notification of planned changes or anticipated noncompliance does not stay a permit condition.

(b) This permit may be reopened, revised and reissued prior to expiration of the permit under one or more of the following circumstances:

(1) Additional applicable requirements under the Clean Air Act or the Air Pollution Control Act become applicable to a Title V facility with a remaining permit term of three (3) or more years prior to the expiration date of this permit. The Department will revise the permit as expeditiously as practicable but not later than 18 months after promulgation of the applicable standards or regulations. No such revision is required if the effective date of the requirement is later than the expiration date of this permit, unless the original permit or its terms and conditions has been extended.

(2) Additional requirements, including excess emissions requirements, become applicable to an affected source under the acid rain program. Upon approval by the Administrator of EPA, excess emissions offset plans for an affected source shall be incorporated into the permit.

(3) The Department or the EPA determines that this permit contains a material mistake or inaccurate statements were made in establishing the emissions standards or other terms or conditions of this permit.

(4) The Department or the Administrator of EPA determines that the permit must be revised or revoked to assure compliance with the applicable requirements.

(c) Proceedings to revise this permit shall follow the same procedures which apply to initial permit issuance and shall affect only those parts of this permit for which cause to revise exists. The revision shall be made as expeditiously as practicable.

(d) Regardless of whether a revision is made in accordance with (b)(1) above, the permittee shall meet the applicable standards or regulations promulgated under the Clean Air Act within the time frame required by standards or regulations.

#012 [25 Pa. Code § 127.543]**Reopening a Title V Permit for Cause by EPA**

As required by the Clean Air Act and regulations adopted thereunder, this permit may be modified, reopened and reissued, revoked or terminated for cause by EPA in accordance with procedures specified in 25 Pa. Code § 127.543.

#013 [25 Pa. Code § 127.522(a)]**Operating Permit Application Review by the EPA**

The applicant may be required by the Department to provide a copy of the permit application, including the compliance plan, directly to the Administrator of the EPA. Copies of title V permit applications to EPA, pursuant to 25 PA Code §127.522(a), shall be submitted, if required, to the following EPA e-mail box:

R3_Air_Apps_and_Notices@epa.gov

Please place the following in the subject line: TV [permit number], [Facility Name].

**SECTION B. General Title V Requirements****#014 [25 Pa. Code § 127.541]****Significant Operating Permit Modifications**

When permit modifications during the term of this permit do not qualify as minor permit modifications or administrative amendments, the permittee shall submit an application for significant Title V permit modifications in accordance with 25 Pa. Code § 127.541. Notifications to EPA, pursuant to 25 PA Code §127.522(a), if required, shall be submitted, to the following EPA e-mail box:

R3_Air_Apps_and_Notices@epa.gov

Please place the following in the subject line: TV [permit number], [Facility Name].

#015 [25 Pa. Code §§ 121.1 & 127.462]**Minor Operating Permit Modifications**

The permittee may make minor operating permit modifications (as defined in 25 Pa. Code §121.1), on an expedited basis, in accordance with 25 Pa. Code §127.462 (relating to minor operating permit modifications). Notifications to EPA, pursuant to 25 PA Code §127.462(c), if required, shall be submitted, to the following EPA e-mail box:

R3_Air_Apps_and_Notices@epa.gov

Please place the following in the subject line: TV [permit number], [Facility Name].

#016 [25 Pa. Code § 127.450]**Administrative Operating Permit Amendments**

(a) The permittee may request administrative operating permit amendments, as defined in 25 Pa. Code §127.450(a). Copies of request for administrative permit amendment to EPA, pursuant to 25 PA Code §127.450(c)(1), if required, shall be submitted to the following EPA e-mail box:

R3_Air_Apps_and_Notices@epa.gov

Please place the following in the subject line: TV [permit number], [Facility Name].

(b) Upon final action by the Department granting a request for an administrative operating permit amendment covered under §127.450(a)(5), the permit shield provisions in 25 Pa. Code § 127.516 (relating to permit shield) shall apply to administrative permit amendments incorporated in this Title V Permit in accordance with §127.450(c), unless precluded by the Clean Air Act or the regulations thereunder.

#017 [25 Pa. Code § 127.512(b)]**Severability Clause**

The provisions of this permit are severable, and if any provision of this permit is determined by the Environmental Hearing Board or a court of competent jurisdiction, or US EPA to be invalid or unenforceable, such a determination will not affect the remaining provisions of this permit.

#018 [25 Pa. Code §§ 127.704, 127.705 & 127.707]**Fee Payment**

(a) The permittee shall pay fees to the Department in accordance with the applicable fee schedules in 25 Pa. Code Chapter 127, Subchapter I (relating to plan approval and operating permit fees). The applicable fees shall be made payable to "The Commonwealth of Pennsylvania Clean Air Fund" with the permit number clearly indicated and submitted to the respective regional office.

(b) Emission Fees. The permittee shall, on or before September 1st of each year, pay applicable annual Title V emission fees for emissions occurring in the previous calendar year as specified in 25 Pa. Code § 127.705. The permittee is not required to pay an emission fee for emissions of more than 4,000 tons of each regulated pollutant emitted from the facility.

(c) As used in this permit condition, the term "regulated pollutant" is defined as a VOC, each pollutant regulated under Sections 111 and 112 of the Clean Air Act and each pollutant for which a National Ambient Air Quality Standard has been promulgated, except that carbon monoxide is excluded.

**SECTION B. General Title V Requirements**

(d) Late Payment. Late payment of emission fees will subject the permittee to the penalties prescribed in 25 Pa. Code § 127.707 and may result in the suspension or termination of the Title V permit. The permittee shall pay a penalty of fifty percent (50%) of the fee amount, plus interest on the fee amount computed in accordance with 26 U.S.C.A. § 6621(a)(2) from the date the emission fee should have been paid in accordance with the time frame specified in 25 Pa. Code § 127.705(c).

(e) The permittee shall pay an annual operating permit maintenance fee according to the following fee schedule established in 25 Pa. Code § 127.704(d) on or before December 31 of each year for the next calendar year.

(1) Eight thousand dollars (\$8,000) for calendar years 2021—2025.

(2) Ten thousand dollars (\$10,000) for calendar years 2026—2030.

(3) Twelve thousand five hundred dollars (\$12,500) for the calendar years beginning with 2031.

#019 [25 Pa. Code §§ 127.14(b) & 127.449]**Authorization for De Minimis Emission Increases**

(a) This permit authorizes de minimis emission increases from a new or existing source in accordance with 25 Pa. Code §§ 127.14 and 127.449 without the need for a plan approval or prior issuance of a permit modification. The permittee shall provide the Department with seven (7) days prior written notice before commencing any de minimis emissions increase that would result from either: (1) a physical change of minor significance under § 127.14(c)(1); or (2) the construction, installation, modification or reactivation of an air contamination source. The written notice shall:

(1) Identify and describe the pollutants that will be emitted as a result of the de minimis emissions increase.

(2) Provide emission rates expressed in tons per year and in terms necessary to establish compliance consistent with any applicable requirement.

The Department may disapprove or condition de minimis emission increases at any time.

(b) Except as provided below in (c) and (d) of this permit condition, the permittee is authorized during the term of this permit to make de minimis emission increases (expressed in tons per year) up to the following amounts without the need for a plan approval or prior issuance of a permit modification:

(1) Four tons of carbon monoxide from a single source during the term of the permit and 20 tons of carbon monoxide at the facility during the term of the permit.

(2) One ton of NO_x from a single source during the term of the permit and 5 tons of NO_x at the facility during the term of the permit.

(3) One and six-tenths tons of the oxides of sulfur from a single source during the term of the permit and 8.0 tons of oxides of sulfur at the facility during the term of the permit.

(4) Six-tenths of a ton of PM₁₀ from a single source during the term of the permit and 3.0 tons of PM₁₀ at the facility during the term of the permit. This shall include emissions of a pollutant regulated under Section 112 of the Clean Air Act unless precluded by the Clean Air Act or 25 Pa. Code Article III.

(5) One ton of VOCs from a single source during the term of the permit and 5.0 tons of VOCs at the facility during the term of the permit. This shall include emissions of a pollutant regulated under Section 112 of the Clean Air Act unless precluded by the Clean Air Act or 25 Pa. Code Article III.

(c) In accordance with § 127.14, the permittee may install the following minor sources without the need for a plan approval:

(1) Air conditioning or ventilation systems not designed to remove pollutants generated or released from other sources.

(2) Combustion units rated at 2,500,000 or less Btu per hour of heat input.

**SECTION B. General Title V Requirements**

(3) Combustion units with a rated capacity of less than 10,000,000 Btu per hour heat input fueled by natural gas supplied by a public utility, liquefied petroleum gas or by commercial fuel oils which are No. 2 or lighter, viscosity less than or equal to 5.82 c St, and which meet the sulfur content requirements of 25 Pa. Code § 123.22 (relating to combustion units). For purposes of this permit, commercial fuel oil shall be virgin oil which has no reprocessed, recycled or waste material added.

(4) Space heaters which heat by direct heat transfer.

(5) Laboratory equipment used exclusively for chemical or physical analysis.

(6) Other sources and classes of sources determined to be of minor significance by the Department.

(d) This permit does not authorize de minimis emission increases if the emissions increase would cause one or more of the following:

(1) Increase the emissions of a pollutant regulated under Section 112 of the Clean Air Act except as authorized in Subparagraphs (b)(4) and (5) of this permit condition.

(2) Subject the facility to the prevention of significant deterioration requirements in 25 Pa. Code Chapter 127, Subchapter D and/or the new source review requirements in Subchapter E.

(3) Violate any applicable requirement of the Air Pollution Control Act, the Clean Air Act, or the regulations promulgated under either of the acts.

(4) Changes which are modifications under any provision of Title I of the Clean Air Act and emission increases which would exceed the allowable emissions level (expressed as a rate of emissions or in terms of total emissions) under the Title V permit.

(e) Unless precluded by the Clean Air Act or the regulations thereunder, the permit shield described in 25 Pa. Code § 127.516 (relating to permit shield) shall extend to the changes made under 25 Pa. Code § 127.449 (relating to de minimis emission increases).

(f) Emissions authorized under this permit condition shall be included in the monitoring, recordkeeping and reporting requirements of this permit.

(g) Except for de minimis emission increases allowed under this permit, 25 Pa. Code § 127.449, or sources and physical changes meeting the requirements of 25 Pa. Code § 127.14, the permittee is prohibited from making physical changes or engaging in activities that are not specifically authorized under this permit without first applying for a plan approval. In accordance with § 127.14(b), a plan approval is not required for the construction, modification, reactivation, or installation of the sources creating the de minimis emissions increase.

(h) The permittee may not meet de minimis emission threshold levels by offsetting emission increases or decreases at the same source.

#020 [25 Pa. Code §§ 127.11a & 127.215]**Reactivation of Sources**

(a) The permittee may reactivate a source at the facility that has been out of operation or production for at least one year, but less than or equal to five (5) years, if the source is reactivated in accordance with the requirements of 25 Pa. Code §§ 127.11a and 127.215. The reactivated source will not be considered a new source.

(b) A source which has been out of operation or production for more than five (5) years but less than 10 years may be reactivated and will not be considered a new source if the permittee satisfies the conditions specified in 25 Pa. Code § 127.11a(b).

#021 [25 Pa. Code §§ 121.9 & 127.216]**Circumvention**

(a) The owner of this Title V facility, 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

**SECTION B. General Title V Requirements**

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 permit, 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.

#022 [25 Pa. Code §§ 127.402(d) & 127.513(1)]**Submissions**

(a) Reports, test data, monitoring data, notifications and requests for renewal of the permit shall be submitted to the:

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

(b) Any report or notification for the EPA Administrator or EPA Region III should be addressed to:

Enforcement & Compliance Assurance Division
Air, RCRA and Toxics Branch (3ED21)
Four Penn Center
1600 John F. Kennedy Boulevard
Philadelphia, PA 19103-2852

The Title V compliance certification shall be emailed to EPA at R3_APD_Permits@epa.gov.

(c) An application, form, report or compliance certification submitted pursuant to this permit condition shall contain certification by a responsible official as to truth, accuracy, and completeness as required under 25 Pa. Code § 127.402(d). Unless otherwise required by the Clean Air Act or regulations adopted thereunder, this certification and any other certification required pursuant to this permit shall state that, based on information and belief formed after reasonable inquiry, the statements and information in the document are true, accurate and complete.

#023 [25 Pa. Code §§ 127.441(c) & 127.463(e); Chapter 139; & 114(a)(3), 504(b) of the CAA]**Sampling, Testing and Monitoring Procedures**

(a) The permittee shall perform the emissions monitoring and analysis procedures or test methods for applicable requirements of this Title V permit. In addition to the sampling, testing and monitoring procedures specified in this permit, the Permittee shall comply with any additional applicable requirements promulgated under the Clean Air Act after permit issuance regardless of whether the permit is revised.

(b) The sampling, testing and monitoring required under the applicable requirements of this permit, shall be conducted in accordance with the requirements of 25 Pa. Code Chapter 139 unless alternative methodology is required by the Clean Air Act (including §§ 114(a)(3) and 504(b)) and regulations adopted thereunder.

#024 [25 Pa. Code §§ 127.511 & Chapter 135]**Recordkeeping Requirements**

(a) The permittee shall maintain and make available, upon request by the Department, records of required monitoring information that include the following:

- (1) The date, place (as defined in the permit) and time of sampling or measurements.
- (2) The dates the analyses were performed.
- (3) The company or entity that performed the analyses.
- (4) The analytical techniques or methods used.

**SECTION B. General Title V Requirements**

(5) The results of the analyses.

(6) The operating conditions as existing at the time of sampling or measurement.

(b) The permittee shall retain records of the required monitoring data and supporting information for at least five (5) years from the date of the monitoring sample, measurement, report or application. Supporting information includes the calibration data and maintenance records and original strip-chart recordings for continuous monitoring instrumentation, and copies of reports required by the permit.

(c) The permittee shall maintain and make available to the Department upon request, records including computerized records that may be necessary to comply with the reporting, recordkeeping and emission statement requirements in 25 Pa. Code Chapter 135 (relating to reporting of sources). In accordance with 25 Pa. Code Chapter 135, § 135.5, such records 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 information by indirect means.

#025 [25 Pa. Code §§ 127.411(d), 127.442, 127.463(e) & 127.511(c)]**Reporting Requirements**

(a) The permittee shall comply with the reporting requirements for the applicable requirements specified in this Title V permit. In addition to the reporting requirements specified herein, the permittee shall comply with any additional applicable reporting requirements promulgated under the Clean Air Act after permit issuance regardless of whether the permit is revised.

(b) Pursuant to 25 Pa. Code § 127.511(c), the permittee shall submit reports of required monitoring at least every six (6) months unless otherwise specified in this permit. Instances of deviations (as defined in 25 Pa. Code § 121.1) from permit requirements shall be clearly identified in the reports. The reporting of deviations shall include the probable cause of the deviations and corrective actions or preventative measures taken, except that sources with continuous emission monitoring systems shall report according to the protocol established and approved by the Department for the source. The required reports shall be certified by a responsible official.

(c) Every report submitted to the Department under this permit condition shall comply with the submission procedures specified in Section B, Condition #022(c) of this permit.

(d) Any records, reports or information obtained by the Department or referred to in a public hearing shall be made available to the public by the Department except for such records, reports or information for which the permittee has shown cause that the documents should be considered confidential and protected from disclosure to the public under Section 4013.2 of the Air Pollution Control Act and consistent with Sections 112(d) and 114(c) of the Clean Air Act and 25 Pa. Code § 127.411(d). The permittee may not request a claim of confidentiality for any emissions data generated for the Title V facility.

#026 [25 Pa. Code § 127.513]**Compliance Certification**

(a) One year after the date of issuance of the Title V permit, and each year thereafter, unless specified elsewhere in the permit, the permittee shall submit to the Department and EPA Region III a certificate of compliance with the terms and conditions in this permit, for the previous year, including the emission limitations, standards or work practices. This certification shall include:

- (1) The identification of each term or condition of the permit that is the basis of the certification.
- (2) The compliance status.
- (3) The methods used for determining the compliance status of the source, currently and over the reporting period.
- (4) Whether compliance was continuous or intermittent.

(b) The compliance certification shall be postmarked or hand-delivered no later than thirty days after each anniversary of the date of issuance of this Title V Operating Permit, or on the submittal date specified elsewhere in the permit, to the Department in accordance with the submission requirements specified in Section B, Condition #022 of this permit. The Title V compliance certification shall be emailed to EPA at R3_APD_Permits@epa.gov.

**SECTION B. General Title V Requirements****#027 [25 Pa. Code § 127.3]****Operational Flexibility**

The permittee is authorized to make changes within the Title V facility in accordance with the following provisions in 25 Pa. Code Chapter 127 which implement the operational flexibility requirements of Section 502(b)(10) of the Clean Air Act and Section 6.1(i) of the Air Pollution Control Act:

- (1) Section 127.14 (relating to exemptions)
- (2) Section 127.447 (relating to alternative operating scenarios)
- (3) Section 127.448 (relating to emissions trading at facilities with federally enforceable emissions caps)
- (4) Section 127.449 (relating to de minimis emission increases)
- (5) Section 127.450 (relating to administrative operating permit amendments)
- (6) Section 127.462 (relating to minor operating permit amendments)
- (7) Subchapter H (relating to general plan approvals and operating permits)

#028 [25 Pa. Code §§ 127.441(d), 127.512(i) and 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 Title V facility. The permittee shall submit the RMP to the federal Environmental Protection Agency according to the following schedule and requirements:

- (1) The permittee shall submit the first RMP to a central point specified by EPA no later than the latest of the following:
 - (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 EPA 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 permit 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.

(d) If the Title V facility is subject to 40 CFR Part 68, as part of the certification required under this permit, the permittee shall:

- (1) Submit a compliance schedule for satisfying the requirements of 40 CFR Part 68 by the date specified in 40 CFR § 68.10(a); or,
- (2) Certify that the Title V facility is in compliance with all requirements of 40 CFR Part 68 including the registration and submission of the RMP.

**SECTION B. General Title V Requirements**

(e) If the Title V facility is subject to 40 CFR Part 68, the permittee shall maintain records supporting the implementation of an accidental release program for five (5) years in accordance with 40 CFR § 68.200.

(f) When the Title V facility is subject to the accidental release program requirements of Section 112(r) of the Clean Air Act and 40 CFR Part 68, appropriate enforcement action will be taken by the Department if:

(1) The permittee fails to register and submit the RMP or a revised plan pursuant to 40 CFR Part 68.

(2) The permittee fails to submit a compliance schedule or include a statement in the compliance certification required under Section B, Condition #026 of this permit that the Title V facility is in compliance with the requirements of Section 112(r) of the Clean Air Act, 40 CFR Part 68, and 25 Pa. Code § 127.512(i).

#029 [25 Pa. Code § 127.512(e)]**Approved Economic Incentives and Emission Trading Programs**

No permit revision shall be required under approved economic incentives, marketable permits, emissions trading and other similar programs or processes for changes that are provided for in this Title V permit.

#030 [25 Pa. Code §§ 127.516, 127.450(d), 127.449(f) & 127.462(g)]**Permit Shield**

(a) The permittee's compliance with the conditions of this permit shall be deemed in compliance with applicable requirements (as defined in 25 Pa. Code § 121.1) as of the date of permit issuance if either of the following applies:

(1) The applicable requirements are included and are specifically identified in this permit.

(2) The Department specifically identifies in the permit other requirements that are not applicable to the permitted facility or source.

(b) Nothing in 25 Pa. Code § 127.516 or the Title V permit shall alter or affect the following:

(1) The provisions of Section 303 of the Clean Air Act, including the authority of the Administrator of the EPA provided thereunder.

(2) The liability of the permittee for a violation of an applicable requirement prior to the time of permit issuance.

(3) The applicable requirements of the acid rain program, consistent with Section 408(a) of the Clean Air Act.

(4) The ability of the EPA to obtain information from the permittee under Section 114 of the Clean Air Act.

(c) Unless precluded by the Clean Air Act or regulations thereunder, final action by the Department incorporating a significant permit modification in this Title V Permit shall be covered by the permit shield at the time that the permit containing the significant modification is issued.

#031 [25 Pa. Code §135.3]**Reporting**

(a) The permittee shall submit by March 1 of each year an annual emissions report for the preceding calendar year. The report shall include information for all active 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. All air emissions from the facility should be estimated and reported.

(b) A source owner or operator may request an extension of time from the Department for the filing of an annual emissions report, and the Department may grant the extension for reasonable cause.

#032 [25 Pa. Code §135.4]**Report Format**

Emissions reports shall contain sufficient information to enable the Department to complete its emission inventory. Emissions reports shall be made by the source owner or operator in a format specified by the Department.

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

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

- (1) Construction or demolition of buildings or structures.
- (2) Grading, paving and maintenance 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) Blasting in open pit mines. Emissions from drilling are not considered as emissions from blasting.
- (8) N/A.
- (9) Sources and classes of sources other than those identified in paragraphs (1)-(8), for which the operator has obtained a determination from the Department that fugitive emissions from the source, after appropriate control, meet the following requirements:
 - (i) the emissions are of minor significance with respect to causing air pollution; and
 - (ii) the emissions are not preventing or interfering with the attainment or maintenance of any ambient air quality standard.

002 [25 Pa. Code §123.2]**Fugitive particulate matter**

A person may not permit fugitive particulate matter to be emitted into the outdoor atmosphere from a source specified in SECTION C, Condition #001 if such emissions are visible at the point the emissions pass outside the person's property.

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

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.

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

(a) 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 unless noted differently under source level or group level conditions:

- (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.

005 [25 Pa. Code §123.42]**Exceptions**

(a) The limitations of 123.41 (relating to limitations) 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 123.1(a)(1) -- (9) (relating to prohibition of certain fugitive emissions).
- (4) When arising from the production of agricultural commodities in their unmanufactured state on the premises of the farm operation.

006 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

The operation of cement Kilns No. 2 and No. 3 shall never result in the emission of the following contaminants at rates exceeding the facility-wide intensity limits identified below:

1. NOX - 2.03 lb/ton of clinker 12 month rolling average.

**SECTION C. Site Level Requirements**

2. SO₂ - 2.59 lb/ton of clinker on a 12 month rolling average.

007 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1343]**Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****What standards apply to my kilns, clinker coolers, raw material dryers, and open clinker piles?**

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

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

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

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

II. TESTING REQUIREMENTS.**# 008 [25 Pa. Code §123.43]****Measuring techniques**

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

(1) A device approved by the Department and maintained to provide accurate opacity measurements.

(2) Observers, trained and qualified to measure plume opacity with the naked eye or with the aid of any devices approved by the Department.

III. MONITORING REQUIREMENTS.**# 009 [25 Pa. Code §127.511]****Monitoring and related recordkeeping and reporting requirements.**

To demonstrate compliance with the sulfur limitations in fuel oils, the permittee shall comply with the following requirements:

(a) The permittee shall perform an analysis of the fuel oils used on site on a monthly basis. A representative sample shall be obtained and tested. The fuel characteristics to be determined shall include, but not limited to the following:

(1) The heating value (BTU/Gal)

(2) The percent (%) sulfur content, by weight

(3) The percent (%) ash content, by weight

Testing shall be done in accordance with reference test method ASTM D-129-64 and 25 Pa. Code, Chapter 139.

(b) If the supplier of the fuel oil can provide annual certification of the values of the fuel characteristics mentioned in section (a), the permittee may substitute such certifications (signed by a responsible official) for the analysis of a representative

**SECTION C. Site Level Requirements**

sample.

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

If requested by the Department, the permittee shall perform stack tests, in accordance with the provisions of the most current publication of the DEP Source Testing Manual and Chapter 139 of the Rules and Regulations of the Department of Environmental Protection, within the time frame specified by the Department.

011 [25 Pa. Code §127.511]**Monitoring and related recordkeeping and reporting requirements.**

Visual emission checks of each emission point subject to an opacity limit (excluding sources handled by an opacity CEM) shall be conducted during periods of normal facility operation for a sufficient time interval to determine if the unit has visible emissions using 40 CFR 60 Appendix A, Method 22. If sources of visible emissions are identified during the survey, or at any other time, the permittee shall conduct a 40 CFR Appendix A, Method 9 evaluation within one hour. A Method 9 evaluation shall not be required if the visible emission condition is corrected in a timely manner and the units are operating at normal operating conditions.

A record of each visible emission check required above shall be maintained on site for a period of no less than five (5) years. Said record shall include, but not be limited to, the date, time, name of emission unit, the applicable visible emissions requirement, the results of the check, what action(s), if any, was/were taken, and the name of the observer.

The permittee shall monitor visible emissions from sources subject to an opacity limit (excluding sources covered by an Opacity CEM or fired by natural gas) in accordance with the following procedures, test methods and frequencies:

(a) EPA Method 22 shall be used to determine visible emissions. EPA Method 9 shall be used to determine opacity. Prior notification and a pre-test plan are not required to be submitted for each test or survey conducted.

(b) The permittee shall use the following monitoring schedule for conducting the visible emissions tests required by this condition (unless the source is subject to a limitation on opacity under § 63.1345, then you shall follow required opacity monitoring in accordance with the provisions of paragraphs (f)(1)(i) through (vii) of section § 63.1350.

(i) The initial monitoring frequency for performing visible tests is once per month.

(ii) If the tests conducted during six (6) consecutive months of operation show opacity within the applicable limits, the tests need only be done semi-annually.

(iii) If the tests conducted during the semi-annual test show opacity within the applicable limits, the tests need only be done once per year.

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

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

(d) If the observer is unable to conduct the tests due to unit downtime, visual interference caused by other visible emission sources (e.g. fugitive emissions during high wind conditions), or due to inclement weather conditions such as fog, heavy rain, or snow, the observer shall note such conditions on the data observation sheet and make at least three (3) periodic attempts to conduct the test throughout the day. The permittee shall attempt to make the observations daily until a valid observation period is completed.

012 [25 Pa. Code §127.511]**Monitoring and related recordkeeping and reporting requirements.**

The permittee shall record the pressure drop (for sources not handled by an opacity CEM) across the fabric collectors or other devices used to control the emissions of particulate matter at the facility. At a minimum these recordings shall be taken once per week, while the sources and collectors are in operation.

**SECTION C. Site Level Requirements****# 013 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1350]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Monitoring requirements.**

For sources subject to a limitation on opacity under § 63.1345, you must conduct required opacity monitoring in accordance with the provisions of paragraphs (f)(1)(i) through (vi) of this section and in accordance with your monitoring plan developed under § 63.1350(p).

IV. RECORDKEEPING REQUIREMENTS.**# 014 [25 Pa. Code §127.511]****Monitoring and related recordkeeping and reporting requirements.**

The facility shall record the results of the inspections required by SECTION C, Condition #012. The results of the inspection shall be recorded on a weekly basis, maintained in a logbook, and made available to the Department upon request.

015 [25 Pa. Code §127.511]**Monitoring and related recordkeeping and reporting requirements.**

- (a) The facility shall calculate the facility-wide 12 month rolling average NOX and SO2 emissions rates expressed as lb pollutant per ton of clinker produced, using the following procedure:
- (i) Sum the total pounds of NOX and SO2 emitted by Kiln Nos. 2 and 3 during the most recent complete month and the previous 11 months as measured in accordance with the continuous monitoring requirements of Source ID 101 and Source ID 114.
 - (ii) Sum the total tons of clinker produced by Kiln Nos. 2 and 3 during the most recent complete month and the previous 11 months.
 - (iii) Divide the total number of pounds of NOX and SO2 emitted by Kiln Nos. 2 and 3 during the 12 months by the total tons of clinker produced by kiln Nos. 2 and 3 during the same 12 months.
- (b) A new facility wide 12 month rolling average NOX and SO2 emission rate, expressed as lb pollutant per ton of clinker produced, shall be calculated for each new complete month.
- (c) In calculating each NOX and SO2 facility-wide 12 month rolling average emissions rate, the total pounds of NOX or SO2 emitted by Kiln Nos. 2 and 3 shall include all emissions of NOX and SO2 from kiln Nos. 2 and 3 including emissions during each startup, shutdown, or malfunction.

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

On a semi-annual basis, the permittee shall compile a report of all logged instances of exceedances of the visible emission limitations, (for sources not handled by the opacity CEM), that occurred during the previous six (6) months, to be submitted to the Department within thirty (30) days of the close of the six month period. If no exceedances were noted the report shall remain on site and made available to the Department upon request.

017 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

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

The permittee shall report malfunctions which occur at the Title V facility to the Department. As defined in 40 CFR Section 60.2 and incorporated by reference in 25 Pa. Code Chapter 122, a malfunction is any sudden, infrequent, and not reasonably preventable failure of air pollution control equipment, process equipment, or a process to operate in a normal or unusual manner. Failures that are caused in part by poor maintenance or careless operation are not malfunctions.

Malfunctions shall be reported as follows:

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

**SECTION C. Site Level Requirements**

of such malfunctions to the Department within three (3) days of the telephone report.

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

018 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.10]**Subpart A--General Provisions****Recordkeeping and reporting requirements.**

The owner or operator shall submit reports to the delegated State authority (which may be the same as the permitting authority) [See Section B, Condition #025]. The owner or operator shall send a copy of each report submitted to the State to the appropriate Regional Office of the EPA (to the attention of Director, Air, Radiation, and Toxics Division, EPA Region III, 1650 Arch Street, Philadelphia, PA 19103-2029). The regional office may waive this requirement for any reports at its discretion.

019 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.5]**Subpart A--General Provisions****Construction and reconstruction.**

[From 40 CFR 63.5]

No person may construct a new affected source or reconstruct an affected source subject to 40 CFR Part 63 Subpart LLL, or reconstruct a source such that the source becomes an affected source subject to the standard, without notifying the Administrator of the intended construction or reconstruction. The notification shall be submitted in accordance with the procedures in 40 CFR 63.9(b) and shall include all the information required for an application for approval of construction or reconstruction as specified in 40 CFR 63.5(d). For major sources, the application for approval of construction or reconstruction may be used to fulfill the notification requirements of this paragraph.

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

(a) 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 §127.512]**Operating permit terms and conditions.**

Whenever the sources are in operation, the control devices for these sources shall be in operation.

022 [25 Pa. Code §129.14]**Open burning operations**

(a) Air basins. No person may permit the open burning of material in an air basin.

(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 solely for recreational or ceremonial purposes.
- (6) A fire set solely for cooking food.

**SECTION C. Site Level Requirements**

(c) Clearing and grubbing wastes. The following is applicable to clearing and grubbing wastes:

(1) As used in this subsection the following terms shall have the following meanings:

Air curtain destructor -- A mechanical device which forcefully projects a curtain of air across a pit in which open burning is being conducted so that combustion efficiency is increased and smoke and other particulate matter are contained.

Clearing and grubbing wastes -- Trees, shrubs, and other native vegetation which are cleared from land during or prior to the process of construction. The term does not include demolition wastes and dirt laden roots.

(2) Subsection (a) notwithstanding, clearing and grubbing wastes may be burned in a basin subject to the following requirements:

(i) Air curtain destructors shall be used when burning clearing and grubbing wastes.

(ii) Each proposed use of air curtain destructors shall be reviewed and approved by the Department in writing with respect to equipment arrangement, design and existing environmental conditions prior to commencement of burning. Proposals approved under this subparagraph need not obtain plan approval or operating permits under Chapter 127 (relating to construction modification, reactivation and operation of sources).

(iii) Approval for use of an air curtain destructor at one site may be granted for a specified period not to exceed 3 months, but may be extended for additional limited periods upon further approval by the Department.

(iv) The Department reserves the right to rescind approval granted if a determination by the Department indicates that an air pollution problem exists.

(3) During an air pollution episode, open burning is limited by Chapter 137 (relating to air pollution episodes) and shall cease as specified in such chapter.

VII. ADDITIONAL REQUIREMENTS.**# 023 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The following condition is based on the Consent Decree (CD) between LaFarge (now Holcim) and US EPA:

Emission reductions resulting from compliance with the requirements of (see applicable conditions incorporating CD NO_x and SO₂ limits) shall not be considered as a creditable contemporaneous emission decrease for the purpose of obtaining a netting credit under the Clean Air Act's Non-attainment NSR and PSD programs.

These limitations do not apply to emission reductions achieved by the permittee that are surplus to those required under the requirements of (see applicable conditions incorporating CD NO_x and SO₂ limits) ("surplus emission reductions"). As referenced herein, surplus emission reductions are the reduction over and above those required under the requirements of (see applicable conditions incorporating CD NO_x and SO₂ limits) that result from the permittee's compliance with federally enforceable emissions limits that are more stringent than limits imposed under (see applicable conditions incorporating CD NO_x and SO₂ limits) or from the permittee's compliance with emissions limits otherwise required under applicable provisions of the Clean Air Act or with an applicable SIP that contains more stringent limits than those imposed under the requirements of this permit under (see applicable conditions incorporating CD NO_x and SO₂ limits).

024 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1351]**Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Compliance dates.**

[From 40 CFR 63.1351 - Compliance Dates]

This Condition only applies to sources regulated by 40 CFR Part 63, Subpart LLL, as indicated in Sections D or E of this permit.

(a) The compliance date for any affected existing source subject to any rule requirements that were in effect before December 20, 2006, is:

(1) June 14, 2002, for sources that commenced construction before or on March 24, 1998, or

(2) June 14, 1999 or startup for sources that commenced construction after March 24, 1998.

**SECTION C. Site Level Requirements**

(b) The compliance date for any affected existing source subject to any rule requirements that became effective on December 20, 2006, is:

- (1) December 21, 2009, for sources that commenced construction after December 2, 2005 and before or on December 20, 2006, or
- (2) Startup for sources that commenced construction after December 20, 2006.

(c) The compliance date for existing sources for all the requirements that became effective on February 12, 2013, except for the open clinker pile requirements will be September 9, 2015.

(d) The compliance date for new sources is February 12, 2013, or startup, whichever is later.

(e) The compliance date for existing sources with the requirements for open clinker storage piles in § 63.1343(c) is February 12, 2014.

025 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.4]

Subpart A--General Provisions

Prohibited activities and circumvention.

[From 40 CFR 63.4(b) and (c)]

(b) Circumvention. No owner or operator subject to the provisions of this part shall build, erect, install, or use any article, machine, equipment, or process to conceal an emission that would otherwise constitute noncompliance with a relevant standard. Such concealment includes, but is not limited to—

- (1) The use of diluents to achieve compliance with a relevant standard based on the concentration of a pollutant in the effluent discharged to the atmosphere;
- (2) The use of gaseous diluents to achieve compliance with a relevant standard for visible emissions; and

(c) Fragmentation. Fragmentation after November 15, 1990 which divides ownership of an operation, within the same facility among various owners where there is no real change in control, will not affect applicability. The owner and operator must not use fragmentation or phasing of reconstruction activities (i.e., intentionally dividing reconstruction into multiple parts for purposes of avoiding new source requirements) to avoid becoming subject to new source requirements.

026 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.6]

Subpart A--General Provisions

Compliance with standards and maintenance requirements.

[From 40 CFR 63.6(f)]

Compliance with nonopacity emission standards--

(1) Applicability. The nonopacity emission standards set forth in this part [40 CFR Part 63, Subparts A and LLL], shall apply at all times except during periods of startup, shutdown, and malfunction, and as otherwise specified in an applicable subpart.

(2) Methods for determining compliance. The Administrator will determine compliance with nonopacity emission standards in 40 CFR Part 63, Subparts A and LLL in accordance with the requirements found in 40 CFR 63.6(f)(2).

[From 40 CFR 63.6(h)]

Compliance with opacity and visible emission standards--

(1) Applicability. The opacity and visible emission standards set forth in this part shall apply at all times except during periods of startup, shutdown, and malfunction, and as otherwise specified in an applicable subpart.

(2) The Administrator will determine compliance with opacity and visible emission standards in this part in accordance with the requirements contained in 40 CFR 63.6(h)(2).

(3) [Reserved]

(4) Notification of opacity or visible emission observations. The owner or operator of an affected source shall notify the Administrator in writing of the anticipated date for conducting opacity or visible emission observations in accordance with 63.9(f), if such observations are required for the source by a relevant standard.

**SECTION C. Site Level Requirements**

(5) Conduct of opacity or visible emission observations. When a relevant standard under this part includes an opacity or visible emission standard, the owner or operator of an affected source shall comply with the requirements contained in 40 CFR 63.6(h)(5)(i)-(v).

(6) Availability of records. The owner or operator of an affected source shall make available, upon request by the Administrator, such records that the Administrator deems necessary to determine the conditions under which the visual observations were made and shall provide evidence indicating proof of current visible observer emission certification.

(7) Use of a continuous opacity monitoring system. The owner or operator of an affected source required to use a continuous opacity monitoring system (COMS) shall comply with the requirements contained in 40 CFR 63.6(h)(7)(i)-(v).

(8) Finding of compliance. The Administrator will make a finding concerning an affected source's compliance with an opacity or visible emission standard upon obtaining all the compliance information required by the relevant standard (including the written reports of the results of the performance tests required by 63.7, the results of Test Method 9 or another required opacity or visible emission test method, the observer certification required by paragraph (h)(6) of this section, and the continuous opacity monitoring system results, whichever is/are applicable) and any information available to the Administrator needed to determine whether proper operation and maintenance practices are being used.

027 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.6]**Subpart A--General Provisions****Compliance with standards and maintenance requirements.**

[From 40 CFR 63.6(e)]

Operation and maintenance requirements.

(1)(i) At all times, including periods of startup, shutdown, and malfunction, owners or operators shall operate and maintain any affected source, including associated air pollution control equipment, in a manner consistent with good air pollution control practices for minimizing emissions. During a period of startup, shutdown, or malfunction, this general duty to minimize emissions requires that the owner or operator reduce emissions from the affected source to the greatest extent which is consistent with safety and good air pollution control practices. The general duty to minimize emissions during a period of startup, shutdown, or malfunction does not require the owner or operator to achieve emission levels that would be required by the applicable standard at other times if this is not consistent with safety and good air pollution control practices, nor does it require the owner or operator to make any further efforts to reduce emissions if levels required by the applicable standard have been achieved. Determination of whether such operation and maintenance procedures are being used will be based on information available to the Administrator which may include, but is not limited to, monitoring results, review of operation and maintenance procedures (including the startup shutdown, and malfunction plan required in paragraph (e)(3) of this section), review of operation and maintenance records, and inspection of the source.

(ii) Malfunctions must be corrected as soon as practicable after their occurrence. To the extent that an unexpected event arises during a startup, shutdown, or malfunction, an owner or operator must comply by minimizing emissions during such a startup, shutdown, and malfunction event consistent with safety and good air pollution control practices.

(iii) Operation and maintenance requirements established pursuant to section 112 of the Act are enforceable independent of emissions limitations or other requirements in relevant standards.

VIII. COMPLIANCE CERTIFICATION.

No additional compliance certifications exist except as provided in other sections of this permit including Section B (relating to Title V General Requirements).

IX. COMPLIANCE SCHEDULE.

No compliance milestones exist.

***** Permit Shield In Effect *****

**SECTION D. Source Level Requirements**

Source ID: 035

Source Name: EMERGENCY GENERATOR (85KW)

Source Capacity/Throughput: 0.300 MMBTU/HR

I. RESTRICTIONS.**Emission Restriction(s).****# 001 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

This SOURCE has been determined by the Department to be of minor significance under 25 Pa. Code, Chapter 127, Section 127.14(a)(8). However, this determination does not exempt the sources from compliance with all applicable air quality regulations specified in 25 Pa. Code Chapters 121-143.

The permittee shall comply with all applicable requirements of 40 CFR 63 Subpart ZZZZ and the following restrictions apply to this Emergency Generator:

- (i) NO_x emissions shall be less than 100 lbs/hr, 1000 lbs/day, 2.75 tons per ozone season and 6.6 tons per year on a 12-month rolling basis from the Emergency Generator.
- (ii) The Emergency Generator is limited to 500 hours of operation based on a 12 month rolling sum.
- (iii) The permittee shall, at a minimum, record and maintain records showing the NO_x emission limit and hour restriction. In addition, records shall be maintained in accordance with 40 CFR 63 Subpart ZZZZ. These shall be made available to the department and maintained for a period of five (5) years.
- (iv) The Emergency Generators shall be equipped with a non-resettable meter for hours of operation prior to startup and the meter shall be operated at all times the source is in operation.
- (v) The permittee shall keep records of the number of hours that the source operates on a monthly basis to verify compliance with the operation hours restriction in any 12 consecutive month period.
- (vi) PM emissions shall not exceed 0.04 gr/dscf.

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

III. MONITORING REQUIREMENTS.

No additional monitoring requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

IV. RECORDKEEPING REQUIREMENTS.

No additional record keeping requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

VI. WORK PRACTICE REQUIREMENTS.**# 002 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The equipment must be installed, maintained, and operated in accordance with manufacturer specifications and good operating practices for the control of VOC emissions per 25 Pa Code 129.97(c)(8)

**SECTION D. Source Level Requirements****VII. ADDITIONAL REQUIREMENTS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 036

Source Name: EMERGENCY GENERATOR (150 KW)

Source Capacity/Throughput: 0.600 MMBTU/HR

I. RESTRICTIONS.**Emission Restriction(s).****# 001 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

This SOURCE has been determined by the Department to be of minor significance under 25 Pa. Code, Chapter 127, Section 127.14(a)(8). However, this determination does not exempt the sources from compliance with all applicable air quality regulations specified in 25 Pa. Code Chapters 121-143.

The permittee shall comply with all applicable requirements of 40 CFR 63 Subpart ZZZZ and the following restrictions apply to this Emergency Generator:

- (i) N/A.
- (ii) The Emergency Generator is limited to 500 hours of operation based on a 12 month rolling sum.
- (iii) The permittee shall, at a minimum, record and maintain records showing the NO_x emission limit and hour restriction. In addition, records shall be maintained in accordance with 40 CFR 63 Subpart ZZZZ. These shall be made available to the department and maintained for a period of five (5) years.
- (iv) The Emergency Generators shall be equipped with a non-resettable meter for hours of operation prior to startup and the meter shall be operated at all times the source is in operation.
- (v) The permittee shall keep records of the number of hours that the source operates on a monthly basis to verify compliance with the operation hours restriction in any 12 consecutive month period.
- (vi) PM emissions shall not exceed 0.04 gr/dscf.

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

III. MONITORING REQUIREMENTS.

No additional monitoring requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

IV. RECORDKEEPING REQUIREMENTS.

No additional record keeping requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

VI. WORK PRACTICE REQUIREMENTS.**# 002 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The equipment must be installed, maintained, and operated in accordance with manufacturer specifications and good operating practices for the control of VOC emissions per 25 Pa Code 129.97(c)(8)

**SECTION D. Source Level Requirements****VII. ADDITIONAL REQUIREMENTS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 037

Source Name: RANSOME GENERATOR (EAST)

Source Capacity/Throughput: 17.100 MMBTU/HR
131.000 Gal/HR #2 Oil

Conditions for this source occur in the following groups: 3

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

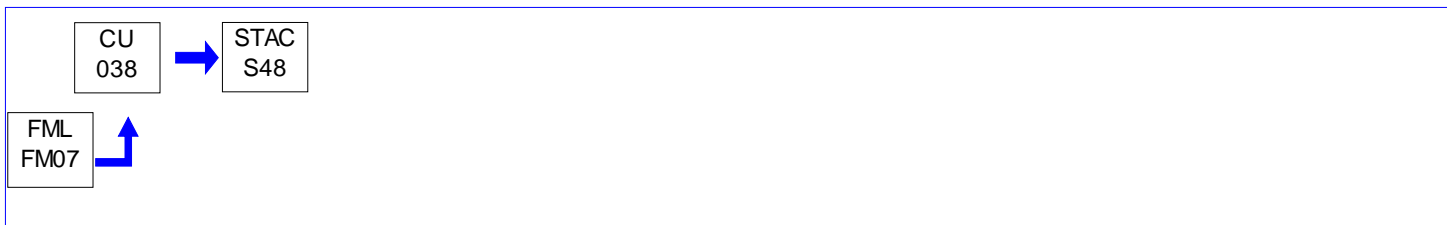
**SECTION D. Source Level Requirements**

Source ID: 038

Source Name: RANSOME GENERATOR (CENTER)

Source Capacity/Throughput: 17.100 MMBTU/HR
131.000 Gal/HR #2 Oil

Conditions for this source occur in the following groups: 3

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

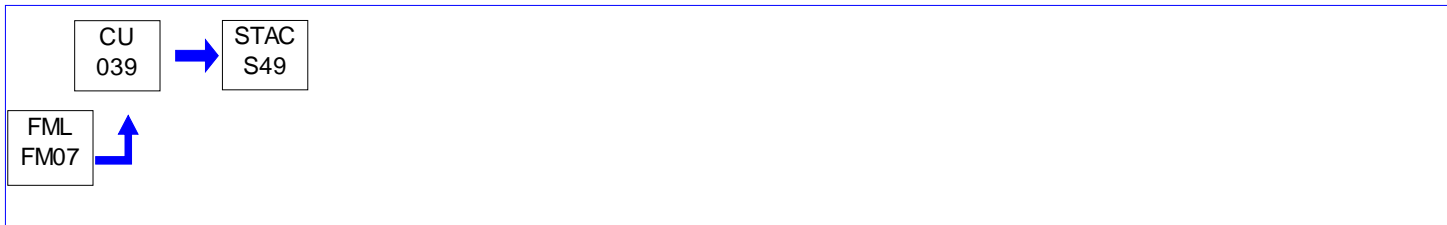
Source ID: 039

Source Name: RANSOME GENERATOR (WEST)

Source Capacity/Throughput: 17.100 MMBTU/HR

131.000 Gal/HR #2 Oil

Conditions for this source occur in the following groups: 3

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

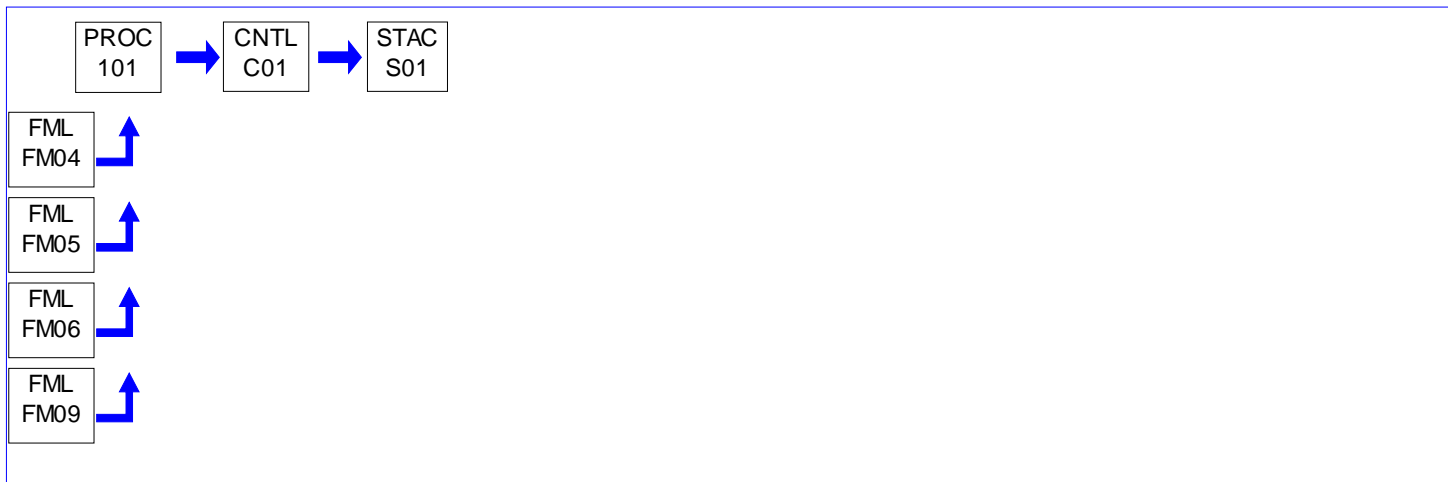
**SECTION D. Source Level Requirements**

Source ID: 101

Source Name: K-2 KILN WITH PREHEATER/SNCR & DAA INJECTION SYSTEM

Source Capacity/Throughput:	780.000 Gal/HR	#2 Oil
	70.000 Tons/HR	CLINKER
	10.000 Tons/HR	Bituminous
	3.000 Tons/HR	TDF
	4.000 Tons/HR	Coke
	3.300 Tons/HR	PDF

Conditions for this source occur in the following groups: 5

**I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The operation of cement Kiln No. 2, when fired by TDF and/or PDF, shall at no time result in the emission of the following contaminants at rates exceeding the limits identified in pounds per hour and verified by annual stack testing or quarterly CEM reporting.

Arsenic - 0.00151 lbs/hour
 Cadmium - 0.00525 lbs/hour
 Hexavalent Chromium - 0.00135 lbs/hour
 Lead - 0.07 lbs/hour
 Nickel - 0.0189 lbs/hour
 Zinc - 0.38689 lbs/hour
 Total VOCs - 5.4 lbs/hour
 SO₂ - 362.0 lbs/hour (3-hr block average)

NO_x emissions shall be limited to 2.36 lb/ton clinker produced on a 30-day rolling average per RACT II requirements in 25 Pa. Code 129.97(h)(3)

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

The operation of cement Kiln No.2, when not fired by TDF and/or PDF, shall never result in the emission of the following contaminants at rates exceeding the limits identified in pounds per hour:

297.7 pounds per hour of NO_x (30-day rolling average).

**SECTION D. Source Level Requirements****# 003 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The operation of cement Kiln No.2 shall never result in the emission of the following contaminants at rates exceeding the limits identified below:

SO₂- 4.06 lb/ton of clinker on 30-day rolling average

004 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

Pursuant to the Best Available Technology (BAT) provisions of 25 Pa. Code Section 127.12 (a) (5), the Owner or Operator shall limit the injection of 19.5% (w) aqueous ammonia (reagent) solution associated with the SNCR technology to the following:

- a. 120 gallons (454.2 liters) per hour on a 1-hour block basis (maximum).
- b. 496 tons of ammonia per year based on 12 month rolling sum.

005 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

The operation of cement Kiln No. 2 shall at no time result in the emission of the following contaminants at rates exceeding the limits identified in pounds per hour.

- a. Chlorine(Cl₂) - as determined in accordance with U.S. EPA Reference Method 26A (or an equivalent method approved by PADEP) shall not exceed 0.3 lb per hour. The permittee shall conduct at least one (1) compliance test on a yearly basis to measure chlorine emissions. Compliance with the chlorine emission limit shall be based on a five (5)-year arithmetic average of all valid chlorine emission test results.
- b. Hydrogen Cyanide (HCN)- as determined in accordance with U.S. EPA Conditional Test Method 33 (or an equivalent method approved by PADEP) shall not exceed 1.7 lb per hour. The permittee shall conduct at least one (1) compliance test on a yearly basis to measure cyanide emissions. Compliance with the cyanide emission limit shall be based on a five (5)-year arithmetic average of all valid cyanide emission test results.

Fuel Restriction(s).**# 006 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

1. The chlorine content of the PDF shall not exceed 1.6% by weight (as-fired).
2. The Btu content of the PDF shall be greater than 8,000 Btu per pound (as-fired).
3. The PDF shall consist of and be processed in accordance with DEP Bureau of Waste Management General Permit WMGR106.

Throughput Restriction(s).**# 007 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

- (a) The TDF feed rate to the kiln shall not exceed 3.0 tons per hour, measured every 15 minutes and average over an hour.
- (b) The PDF feed rate to the kiln shall not exceed 3.3 tons per hour, measured every 15 minutes and average over an hour.

II. TESTING REQUIREMENTS.**# 008 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

1. The permittee may be required to conduct source tests at any time or frequency as may be prescribed by the Department. At a minimum, source tests for arsenic, cadmium, hexavalent chromium, lead, nickel, zinc, total VOCs, CO, hydrogen

**SECTION D. Source Level Requirements**

cyanide (HCN), and chlorine (CL₂) emissions shall be conducted on a yearly basis.

2. For the stack tests specified above, the tests shall be conducted in accordance with 25 Pa. Code Chapter 139 as per the Department's source testing procedures described in the most recent Source Testing Manual of source testing procedures approved by the Department prior to testing. The stack test shall be performed while the aforementioned sources are operating at the maximum routine operating conditions or under such other conditions, within the capacity of the equipment, as may be requested by the Department.

3. At least sixty (60) calendar days prior to commencing an emission testing program required by this permit, a test protocol shall be submitted to the Department's Division of Source Testing and Monitoring and the Regional Office for review and approval. The test protocol shall meet all applicable requirements specified in the most current version of the Department's Source Testing Manual.

4. At least fifteen (15) calendar days prior to commencing an emission testing program required by this permit, written notification of the date and time of testing shall be provided to the Department's appropriate Regional Office. Written notification shall also be sent to the Department's Bureau of Air Quality, Division of Source Testing and Monitoring. The notification shall not be made without prior receipt of a protocol acceptance letter from the Department. The Department is under no obligation to accept the results of any testing performed without adequate advance written notice to the Department of such testing. In addition, the emissions testing shall not commence prior to receipt of a protocol acceptance letter from the Department.

5. Two (2) copies of a complete test report, including all operating conditions, shall be submitted to the Department no later than sixty (60) calendar days after completion of the on-site testing portion of an emission test program.

6. A complete test report shall include a summary of the emission results on the first page of the report indicating if each pollutant measured is within permitted limits and a statement of compliance or non-compliance with all applicable permit conditions. The summary results will include, at a minimum, the following information:

- a. A statement that the owner or operator has reviewed the report from the emissions testing body and agrees with the findings;
- b. Permit number(s) and condition(s) which are the basis for the evaluation;
- c. Summary of results with respect to each applicable permit condition; and
- d. Statement of compliance or non-compliance with each applicable permit condition.

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

Continuous monitoring requirements are as follows:

(1) The permittee shall operate and maintain the opacity continuous emission monitor, the sulfur oxide (SO₂) continuous emission monitor and the nitrogen oxides (NO_x) continuous emission monitor in conformance with 40 CFR Part 60, 25 PA Code Chapter 139 and the Department's most current Continuous Source Monitoring Manual (CEM Manual).

(2) Monitoring and recording of exhaust gas flow rate shall be conducted in accordance with the applicant's procedure approved by the Department.

(3) The continuous emission monitoring systems required must be operated and maintained in accordance with the quality assurance, recordkeeping and reporting requirements of 25 Pa. Code Chapter 139 of the CEM Manual.

010 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

The permittee shall install, operate and maintain a system to continuously monitor the injection rate of reagent solution associated with the SNCR technology in conjunction with Kiln No.2 clinker production. The output of the system shall be in terms of gallons per hour of reagent or equivalent units.

The permittee shall follow the protocol approved by the Department that includes the following:

**SECTION D. Source Level Requirements**

- a. A technical description of the monitoring system and the basis of its operation.
- b. Recommended maintenance practices and schedule.
- c. Recommended calibration techniques and schedule.
- d. Calculations to convert monitored liquid ammonia reagent usage to mass ammonia usage on a monthly and rolling 12-month basis.
- e. Recordkeeping report format.

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

1. The permittee shall adhere to the following sampling plan for PDF:

(a) A grab sample (as-fired) shall be obtained from the PDF feed hopper every shift for a total of 21 grab samples per 7-day period. The 21 samples shall be composited into one sample.

(b) The weekly composite sample (as-fired) shall be analyzed for the following: heat value (Btu/lb), chlorine content (% by weight), lead (ppm), manganese (ppm), nickel (ppm), silver (ppm), thallium (ppm), antimony (ppm), arsenic (ppm), copper (ppm), mercury (ppm), selenium (ppm), barium (ppm), beryllium (ppm), cadmium (ppm), chromium (ppm), cobalt (ppm) and zinc (ppm).

2. Prior to accepting plastics from industrial sources, the company shall submit the following information to the Department's Air Quality Program:

(a) A process description of the source(s) from which the industrial plastic is the result of and the name, address, responsible official and telephone number of the supplier.

(b) Each industrial plastic source shall be analyzed for the contaminants listed in this Condition 1(b).

IV. RECORDKEEPING REQUIREMENTS.**# 012 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

(a) The permittee shall record and maintain the following feed rates for cement Kiln No. 2:

- (1) Dry solids
- (2) Bituminous Coal
- (3) Coke
- (4) TDF
- (5) PDF

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

013 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

The permittee shall record the output of the reagent solution monitoring system and retain records to demonstrate on-going compliance with applicable reagent injection rate limits. The records shall be retained in a format that has been reviewed and approved by the Department.

014 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

a. The facility shall calculate kiln 30-day rolling average SO₂ emissions rates expressed as lb pollutant per ton of clinker produced, using the following procedure:

- i. Individually sum the total pounds of SO₂ emitted by kiln No. 2 during an operating day and the previous 29 operating days, as measured in accordance with monitoring condition above for CEMS.
- ii. Sum the total tons of clinker produced by kiln No. 2 during the same operating day and the previous 29 operating days.
- iii. Individually divide the total number of pounds of SO₂ emitted by kiln No. 2 during the 30-day period by the total tons of clinker produced by kiln No. 2 during the same 30 operating days.

b. A new 30-day rolling average SO₂ emission rate, expressed as lb pollutant per ton of clinker produced, for each new operating day.

c. In calculating each NO_x and SO₂ 30-day rolling average emission rate, the total pounds of NO_x or SO₂ emitted from Kiln No. 2 during the operating day or 30-day period shall include all emissions of NO_x and SO₂ from Kiln No. 2 that occur

**SECTION D. Source Level Requirements**

during the specified period, including emissions during each startup, shutdown, or malfunction.

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

1. The permittee shall keep adequate records to show compliance with the hydrogen cyanide (HCN), HCL, & chlorine (CL) emission limits based on a five (5)-year arithmetic average of all valid emission test results.
2. All records generated pursuant to this condition shall be kept for a minimum of five (5) years and shall be made available to the Department upon request.

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

- (a) The permittee shall maintain a file containing all records and other data that are required to be collected pursuant to the various provisions of this plan approval. The file shall include, but not be limited to: all air pollution control systems performance evaluations and records of calibration checks, adjustments and maintenance performed on all equipment which is subject to this plan approval. All measurements, records, and other data required to be maintained by the permittee shall be retained for at least five (5) years following the date on which such measurements, records or other data are recorded.

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VI. WORK PRACTICE REQUIREMENTS.**# 017 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The continuous emission monitoring systems required must be operated and maintained in accordance with the quality assurance, record keeping and reporting requirements of 25 PA Code Chapter 139 of the most current CEM Manual.

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

- a. The Company shall continuously operate the SNCR technology during all times of Kiln operation, except during periods of SNCR technology malfunction.
- b. The Company shall continuously operate the DAA technology during all times of kiln operation, except during periods of DAA technology malfunction.

019 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

1. Under no circumstances shall TDF and/or PDF be utilized during periods when the kiln is in other than a normal operating condition (i.e.start-up or malfunction).
2. The continuous emission monitoring systems required must be operated and maintained in accordance with the quality assurance, record keeping and reporting requirements of 25 PA Code Chapter 139 of the most current CEM Manual.
3. Within 30 days of each annual compliance test report, the permittee shall compare the five (5) year rolling average emission rates (lbs/hr) for HCl, HCN and chlorine with their respective limits listed in Condition #001 and #002 of Section D, Source Level Requirements for Source ID 101. The five (5) year rolling average emission rates (lbs/hr) for HCl, HCN and chlorine shall not exceed their respective limits listed in Condition #001 or #002 of Section D, Source Level Requirements for Source ID 101.

**SECTION D. Source Level Requirements****# 020 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The equipment must be installed, maintained, and operated in accordance with manufacturer specifications and good operating practices for the control of VOC emissions per 25 Pa Code 129.97(d).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 103

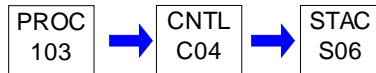
Source Name: K-2 COOLER

Source Capacity/Throughput:

70.000 Tons/HR

CLINKER

Conditions for this source occur in the following groups: 6

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

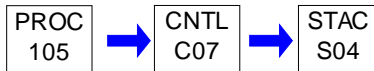
**SECTION D. Source Level Requirements**

Source ID: 105

Source Name: K-2 CLINKER TOWER

Source Capacity/Throughput: 100.000 Tons/HR CLINKER

Conditions for this source occur in the following groups: 2

**I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §123.13]****Processes**

The permittee may not permit the emission into the outdoor atmosphere of particulate matter from this source in a manner that the concentration of particulate matter in the effluent gas exceeds following:

Process Factor (F) for Clinker cooling - 50 (product)

(1) Formula

$$A = .76E^{(0.42)}$$

where:

A = Allowable emissions in pounds per hour.

E = Emission index = F x W pounds per hour.

F = Process factor in pounds per unit, and

W = Production or charging rate in units per hour.

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

The storage and handling of the material collected in the air cleaning devices associated with the source shall not at any time result in the emission of fugitive air contaminants in excess of the limitations specified in SECTION C, Condition #001.

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

The operation of the source shall not at any time result in the emission of fugitive air contaminants in excess of the limitations specified in SECTION C, Condition #001.

II. TESTING REQUIREMENTS.

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

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

No additional reporting requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VI. WORK PRACTICE REQUIREMENTS.

004 [25 Pa. Code §127.512]

Operating permit terms and conditions.

The company shall keep on hand a sufficient quantity of spare fabric collector bags for the fabric collectors associated with the source in order of be able to immediately replace any bags requiring replacement due to deterioration resulting from routine operation of the sources and fabric collectors.

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

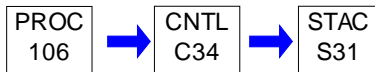
***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 106

Source Name: BULK SILOS (B-5 D.C.)

Source Capacity/Throughput: 200.000 Tons/HR CEMENT

Conditions for this source occur in the following groups: 2
9**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

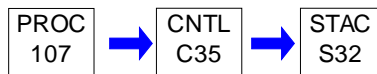
***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 107

Source Name: BULK SILO GROUP (B-9 D.C.)

Source Capacity/Throughput: 200.000 Tons/HR CEMENT

Conditions for this source occur in the following groups: 2
9**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

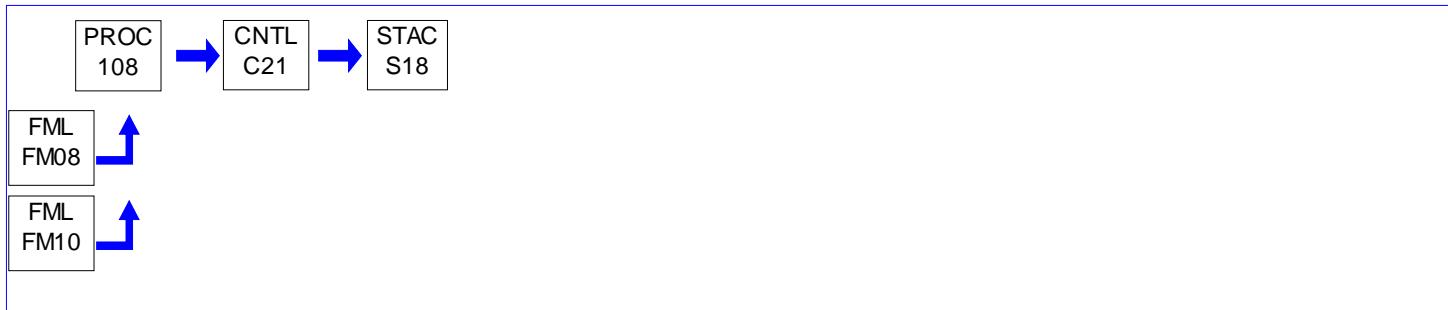
**SECTION D. Source Level Requirements**

Source ID: 108

Source Name: #1 RAW GRINDING MILL

Source Capacity/Throughput: 110.000 Tons/HR CEMENT ROCK
93.300 Gal/HR #2 Oil

Conditions for this source occur in the following groups: 11

**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 any process listed in section (b)(1) of this subpart, at any time, either in excess of the rate calculated by the formula in paragraph (2) or in such a manner that the concentration of particulate matter in the effluent gas exceeds 0.02 grains per dry standard cubic foot, whichever is greater.

002 [25 Pa. Code §123.21]**General**

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

003 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1343]**Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****What standards apply to my kilns, clinker coolers, raw material dryers, and open clinker piles?**

- (a) The emission limit for opacity for this source is 10%.
(b) Total hydrocarbon (THC) emissions limit for this source is 24 ppmvd.

II. TESTING REQUIREMENTS.

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

IV. RECORDKEEPING REQUIREMENTS.**# 004 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The permittee shall record the monthly fuel usage, for each fuel combusted, in the raw mill.

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

No additional reporting requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VI. WORK PRACTICE REQUIREMENTS.

005 [25 Pa. Code §127.512]

Operating permit terms and conditions.

The equipment must be installed, maintained, and operated in accordance with manufacturer specifications and good operating practices per 25 Pa Code 129.97(c)(3)

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

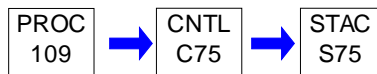
***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 109

Source Name: H1/H2 HOMO SILO

Source Capacity/Throughput: 220.000 Tons/HR CEMENT ROCK

Conditions for this source occur in the following groups: 2
9**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

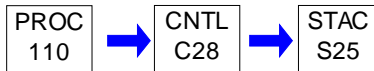
**SECTION D. Source Level Requirements**

Source ID: 110

Source Name: QUARRY IMPACTOR

Source Capacity/Throughput: 750.000 Tons/HR CEMENT ROCK

Conditions for this source occur in the following groups: 10

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

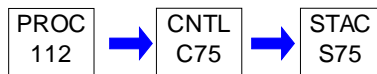
***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 112

Source Name: H3/H4 HOMO SILO

Source Capacity/Throughput: 220.000 Tons/HR CEMENT ROCK

Conditions for this source occur in the following groups: 2
9**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

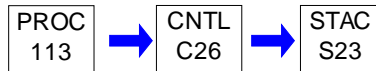
**SECTION D. Source Level Requirements**

Source ID: 113

Source Name: K-2 DUST RETURN SYSTEM

Source Capacity/Throughput: 180.000 Tons/HR CEMENT DUST

Conditions for this source occur in the following groups: 2

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

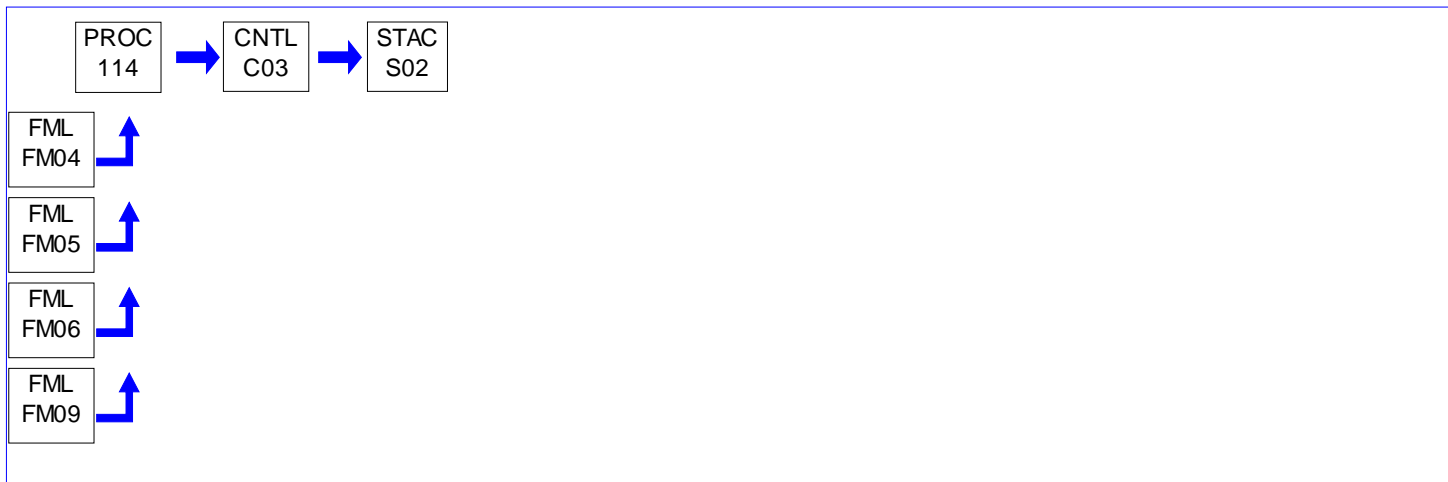
**SECTION D. Source Level Requirements**

Source ID: 114

Source Name: K-3 KILN WITH PREHEATER/SNCR & DAA INJECTION SYSTEM

Source Capacity/Throughput:	780.000 Gal/HR	#2 Oil
	50.000 Tons/HR	CLINKER
	5.000 Tons/HR	Bituminous
	2.000 Tons/HR	TDF
	2.500 Tons/HR	Coke
	3.300 Tons/HR	PDF

Conditions for this source occur in the following groups: 5

**I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The operation of cement Kiln No. 3, when fired by TDF and/or PDF, shall at no time result in the emission of the following contaminants at rates exceeding the limits identified in pounds per hour and verified by annual stack testing or quarterly CEM reporting:

Arsenic - 0.00098 lbs/hour
 Cadmium - 0.00131 lbs/hour
 Hexavalent Chromium - 0.00088 lbs/hour
 Lead - 0.043 lbs/hour
 Nickel - 0.01225 lbs/hour
 Zinc - 0.25076 lbs/hour
 Total VOCs - 5.7 lbs/hour
 SO₂ - 195.0 lbs/hour (3-hr block average)

NO_x emissions shall be limited to 2.36 lb/ton clinker produced on a 30-day rolling average per RACT II requirements in 25 Pa. Code 129.97(h)(3).

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

The operation of cement Kiln No. 3 shall at no time result in the emission of the following contaminants at rates exceeding the limits identified in pounds per hour:

a. Chlorine(Cl₂) - as determined in accordance with U.S. EPA Reference Method 26A (or an equivalent method approved by (PADEP) shall not exceed 0.3 lb per hour. The permittee shall conduct at least one (1) compliance test on a yearly basis to measure chlorine emissions. Compliance with the chlorine emission limit shall be based on a five (5) year arithmetic average of all valid chlorine emission test results.

**SECTION D. Source Level Requirements**

b. Hydrogen Cyanide (HCN)- as determined in accordance with U.S. EPA Conditional Test Method 33 (or an equivalent method approved by PADEP) shall not exceed 1.7 lb per hour. The permittee shall conduct at least one (1) compliance test on a yearly basis to measure cyanide emissions. Compliance with the cyanide emission limit shall be based on a five (5) year arithmetic average of all valid cyanide emission test results.

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

The operation of cement Kiln No. 3, when not fired by TDF and/or PDF, shall never result in the emission of the following contaminants at rates exceeding the limits identified in pounds per hour:

202.3 pounds per hour of NO_x (30-day rolling average)

004 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

The operation of cement Kiln No.3 shall never result in the emission of the following contaminants at rates exceeding the limits identified.

SO₂- 3.19 lb/ton of clinker on 30-day rolling average

Fuel Restriction(s).**# 005 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

1. The chlorine content of the PDF shall not exceed 1.6% by weight (as-fired).
2. The Btu content of the PDF shall be greater than 8,000 Btu per pound (as-fired).
3. The PDF shall consist of and be processed in accordance with DEP Bureau of Waste Management General Permit WMGR106.

Throughput Restriction(s).**# 006 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

- (a) The TDF feed rate to the kiln shall not exceed 2.0 tons per hour, based on an hourly average.
- (b) The PDF feed rate to the kiln shall not exceed 3.3 tons per hour, based on an hourly average.

Control Device Efficiency Restriction(s).**# 007 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

Pursuant to the Best Available Technology (BAT) provisions of 25 Pa. Code Section 127.12 (a) (5), the Owner or Operator shall limit the injection of 19.5% (w) aqueous ammonia (reagent) solution associated with the SNCR technology to the following:

- a. 120 gallons (454.2 liters) per hour on a 1-hour block basis (maximum).
- b. 216 tons of ammonia per year based on 12 month rolling sum.

II. TESTING REQUIREMENTS.**# 008 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

1. The permittee may be required to conduct source tests at any time or frequency as may be prescribed by the Department. At a minimum, source tests for arsenic, cadmium, hexavalent chromium, lead, nickel, zinc, total VOCs, CO, hydrogen cyanide (HCN), and chlorine (CL₂) emissions shall be conducted on a yearly basis.

**SECTION D. Source Level Requirements**

2. For the stack tests specified above, the tests shall be conducted in accordance with 25 Pa. Code Chapter 139 as per the Department's source testing procedures described in the most current Source Testing Manual of source testing procedures approved by the Department prior to testing. The stack test shall be performed while the aforementioned sources are operating at the maximum routine operating conditions or under such other conditions, within the capacity of the equipment, as may be requested by the Department.

3. At least sixty (60) calendar days prior to commencing an emission testing program required by this permit, a test protocol shall be submitted to the Department's Division of Source Testing and Monitoring and the Regional Office for review and approval. The test protocol shall meet all applicable requirements specified in the most current version of the Department's Source Testing Manual.

4. At least fifteen (15) calendar days prior to commencing an emission testing program required by this permit, written notification of the date and time of testing shall be provided to the Department's appropriate Regional Office. Written notification shall also be sent to the Department's Bureau of Air Quality, Division of Source Testing and Monitoring. The notification shall not be made without prior receipt of a protocol acceptance letter from the Department. The Department is under no obligation to accept the results of any testing performed without adequate advance written notice to the Department of such testing. In addition, the emissions testing shall not commence prior to receipt of a protocol acceptance letter from the Department.

5. Two (2) copies of a complete test report, including all operating conditions, shall be submitted to the Department no later than sixty (60) calendar days after completion of the on-site testing portion of an emission test program.

6. A complete test report shall include a summary of the emission results on the first page of the report indicating if each pollutant measured is within permitted limits and a statement of compliance or non-compliance with all applicable permit conditions. The summary results will include, at a minimum, the following information:

- a. A statement that the owner or operator has reviewed the report from the emissions testing body and agrees with the findings;
- b. Permit number(s) and condition(s) which are the basis for the evaluation;
- c. Summary of results with respect to each applicable permit condition; and
- d. Statement of compliance or non-compliance with each applicable permit condition.

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

Continuous monitoring requirements are as follows:

(1) The permittee shall operate and maintain the opacity continuous emission monitor, the sulfur oxide (SO₂) continuous emission monitor and the nitrogen oxides (NO_x) continuous emission monitor in conformance with 40 CFR Part 60, 25 PA Code Chapter 139 and the Department's most current Continuous Source Monitoring Manual (CEM Manual).

(2) Monitoring and recording of exhaust gas flow rate shall be conducted in accordance with the applicant's procedure approved by the Department.

(3) The continuous emission monitoring systems required in Condition (1) must be operated and maintained in accordance with the quality assurance, recordkeeping and reporting requirements of 25 Pa. Code Chapter 139 of the CEM Manual.

010 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

1. The permittee shall adhere to the following sampling plan for PDF:

(a) A grab sample (as-fired) shall be obtained from the PDF feed hopper every shift for a total of 21 grab samples per 7-day period. The 21 samples shall be composited into one sample.

(b) The weekly composite sample (as-fired) shall be analyzed for the following: heat value (Btu/lb), chlorine content (% by weight), lead (ppm), manganese (ppm), nickel (ppm), silver (ppm), thallium (ppm), antimony (ppm), arsenic (ppm), copper (ppm), mercury (ppm), selenium (ppm), barium (ppm), beryllium (ppm), cadmium (ppm), chromium (ppm), cobalt (ppm) and zinc (ppm).

**SECTION D. Source Level Requirements**

2. Prior to accepting plastics from industrial sources, the company shall submit the following information to the Department's Air Quality Program:

- (a) A process description of the source(s) from which the industrial plastic is the result of and the name, address, responsible official and telephone number of the supplier.
- (b) Each industrial plastic source shall be analyzed for the contaminants listed in this Condition 1(b).

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

The permittee shall install, operate and maintain a system to continuously monitor the injection rate of reagent solution associated with the SNCR technology in conjunction with Kiln No.3 clinker production. The output of the system shall be in terms of gallons per hour of reagent or equivalent units.

The permittee shall follow the protocol approved by the Department that includes the following:

- a. A technical description of the monitoring system and the basis of its operation.
- b. Recommended maintenance practices and schedule.
- c. Recommended calibration techniques and schedule.
- d. Proposed calculations to convert monitored liquid ammonia reagent usage to mass ammonia usage on a monthly and rolling 12- month basis.
- e. Proposed recordkeeping report format.

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

Continuous monitoring requirements are as follows:

- (1) The permittee shall operate and maintain the opacity continuous emission monitor, the sulfur oxide (SO₂) continuous emission monitor and the nitrogen oxides (NO_x) continuous emission monitor in conformance with 40 CFR Part 60, 25 PA Code Chapter 139 and the Department's most current Continuous Source Monitoring Manual (CEM Manual)
- (2) The permittee shall operate and maintain volumetric flow rate monitoring systems on Kiln No. 3 that conform to the requirements of 25 PA Code Chapter 139 and the current version of the PADEP Continuous Source Monitoring (CEM) Manual.

IV. RECORDKEEPING REQUIREMENTS.**# 013 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

- 1. The permittee shall keep adequate records to show compliance with the hydrogen cyanide (HCN), HCL, & chlorine (CL) emission limits based on a five (5) year arithmetic average of all valid emission test results.
- 2. All records generated pursuant to this condition shall be kept for a minimum of five (5) years and shall be made available to the Department upon request.

014 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

(a) The permittee shall maintain a file containing all records and other data that are required to be collected pursuant to the various provisions of this operating permit. The file shall include, but not be limited to: all air pollution control systems performance evaluations and records of calibration checks, adjustments and maintenance performed on all equipment which is subject to this operating permit. All measurements, records, and other data required to be maintained by the permittee shall be retained for at least five (5) years following the date on which such measurements, records or other data are recorded.

(b) The permittee shall record and maintain the following feed rates for cement Kiln No. 3:

- (1) Dry solids
- (2) Bituminous Coal
- (3) Coke
- (4) TDF

**SECTION D. Source Level Requirements**

(5) PDF

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

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

- a. The facility shall calculate kiln 30-day rolling average SO₂ emissions rates expressed as lb pollutant per ton of clinker produced, using the following procedure:
 - i. Individually sum the total pounds of SO₂ emitted by Kiln No. 3 during an operating day and the previous 29 operating days, as measured in accordance with previous monitoring requirement for CEMS.
 - ii. Sum the total tons of clinker produced by kiln No. 3 during the same operating day and the previous 29 operating days.
 - iii. Individually divide the total number of pounds of SO₂ emitted by kiln No. 3 during the 30-day period by the total tons of clinker produced by kiln No. 3 during the same 30 operating days.
- b. A new 30-day rolling average SO₂ emission rate, expressed as lb pollutant per ton of clinker produced, for each new operating day.
- c. In calculating each NO_x and SO₂ 30-day rolling average emission rate, the total pounds of SO₂ emitted by kiln No. 3 during the operating day or 30-day period shall include all emissions of NO_x and SO₂ from kiln No. 3 that occur during the specified period, including emissions during each startup, shutdown, or malfunction.

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

The permittee shall record the output of the reagent solution monitoring system and retain records to demonstrate on-going compliance with applicable reagent injection rate limits. The records shall be retained in a format that has been reviewed and approved by the Department.

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VI. WORK PRACTICE REQUIREMENTS.**# 017 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

1. Within 30 days of each annual compliance test report, the permittee shall compare the five (5) year rolling average emission rates (lbs/hr) for HCl, HCN and chlorine with their respective limits listed in Condition #001 and #002 of Section D, Source Level Requirements for Source ID 114. The five (5) year rolling average emission rates (lbs/hr) for HCl, HCN and chlorine shall not exceed their respective limits listed in Condition #001 or #002 for Source ID 114.
2. Under no circumstances shall TDF and /or PDF be utilized during periods when the kiln is in other than a normal operating condition (i.e. start-up or malfunction).
3. The continuous emission monitoring systems required must be operated and maintained in accordance with the quality assurance, record keeping and reporting requirements of 25 PA Code Chapter 139 of the most current CEM Manual.

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

- a. Upon installation of the SNCR technology, the Company shall continuously operate the SNCR technology during all times of Kiln operation, except during periods of SNCR technology malfunction.
- b. Upon installation of the DAA technology, the Company shall continuously operate the DAA technology during all times of kiln operation, except during periods of DAA technology malfunction.

**SECTION D. Source Level Requirements****# 019 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The equipment must be installed, maintained, and operated in accordance with manufacturer specifications and good operating practices for the control of VOC emissions per 25 Pa Code 129.97(d)

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 115

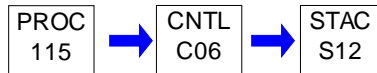
Source Name: K-3 COOLER

Source Capacity/Throughput:

50.000 Tons/HR

CLINKER

Conditions for this source occur in the following groups: 6

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VI. WORK PRACTICE REQUIREMENTS.**# 001 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The continuous emission monitoring system K3 clinker cooler as previously approved by the Department, must be operated and maintained in accordance with the quality assurance, recordkeeping and reporting requirements of Chapter 139 of the Pennsylvania Departments of Environmental Protections Rules and Regulations, and the Departments Latest Continuous Source Monitoring Manual. The required data reports and computer readable media formats as specified by the Department, within 30 days following the close of each calendar quarter.

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 122

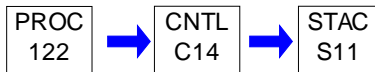
Source Name: #2 FINISH MILL OSEPA

Source Capacity/Throughput:

90.000 Tons/HR

CEMENT

Conditions for this source occur in the following groups: 7
8

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

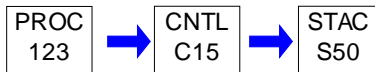
***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 123

Source Name: CLINKER SILOS GROUP COLLECTOR

Source Capacity/Throughput: 125.000 Tons/HR CLINKER

Conditions for this source occur in the following groups: 2
4**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 124

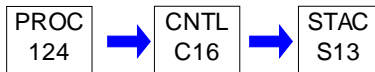
Source Name: K-3 CLINKER TOWER

Source Capacity/Throughput:

60.000 Tons/HR

CLINKER

Conditions for this source occur in the following groups: 1
2

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

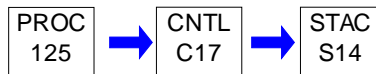
Source ID: 125

Source Name: K-3 CLINKER TRANSFER TOWER

Source Capacity/Throughput:

Conditions for this source occur in the following groups: 1

2

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 127

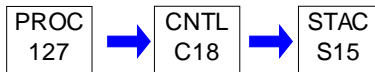
Source Name: #1 FINISH GRINDING MILL

Source Capacity/Throughput:

70.000 Tons/HR

CEMENT

Conditions for this source occur in the following groups: 7
8

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 128

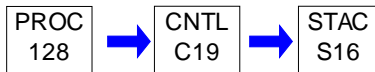
Source Name: #2 FINISH GRINDING MILL

Source Capacity/Throughput:

90.000 Tons/HR

CEMENT

Conditions for this source occur in the following groups: 7
8

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 129

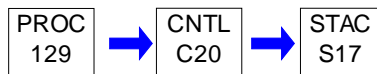
Source Name: #2 FINISH MILL AUXILLARIES

Source Capacity/Throughput:

90.000 Tons/HR

CEMENT

Conditions for this source occur in the following groups: 7
8

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

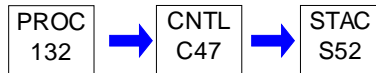
**SECTION D. Source Level Requirements**

Source ID: 132

Source Name: PACKHOUSE 4 (EAST)

Source Capacity/Throughput: 400.000 Tons/HR CEMENT

Conditions for this source occur in the following groups: 2

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 133

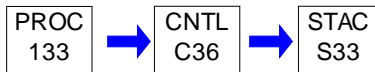
Source Name: B-13 & B-14 BULK SILOS

Source Capacity/Throughput:

90.000 Tons/HR

CEMENT

Conditions for this source occur in the following groups: 2
9

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VI. WORK PRACTICE REQUIREMENTS.

001 [25 Pa. Code §127.512]

Operating permit terms and conditions.

Only one (1) silo can be filled at a time.

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

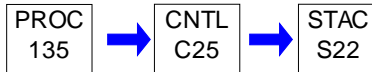
***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 135

Source Name: H5/H6 HOMO SILO

Source Capacity/Throughput: 220.000 Tons/HR CEMENT ROCK

Conditions for this source occur in the following groups: 2
9**I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §123.13]****Processes**

The permittee may not permit the emission into the outdoor atmosphere of particulate matter from this source in a manner that the concentration of particulate matter in the effluent gas exceeds the following:

- (1) 0.04 grains per dry standard cubic foot.

002 [40 CFR Part 60 Standards of Performance for New Stationary Sources §40 CFR 60.62]**Subpart F - Standards of Performance for Portland Cement Plants
Standard for particulate matter.**

No owner or operator subject to the provisions of this subpart shall cause to be discharged into the atmosphere from any affected facility other than the kiln and clinker cooler any gases which exhibit the following:

- (1) 10 percent opacity, or greater.

II. TESTING REQUIREMENTS.

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

VI. WORK PRACTICE REQUIREMENTS.**# 003 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The company shall keep on hand a sufficient quantity of spare fabric collector bags for the fabric collectors associated with the sources listed to be able to immediately replace any bags requiring replacement due to deterioration resulting from routine operation of the sources and fabric collectors.

**SECTION D. Source Level Requirements****VII. ADDITIONAL REQUIREMENTS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

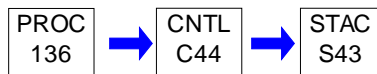
**SECTION D. Source Level Requirements**

Source ID: 136

Source Name: BULK SILOS LANE 1 REAR SPOUT

Source Capacity/Throughput: 360.000 Tons/HR CEMENT

Conditions for this source occur in the following groups: 2
4

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 137

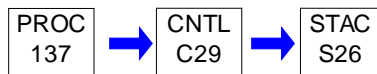
Source Name: FINISH MILL 1 AUXILLARIES

Source Capacity/Throughput:

70.000 Tons/HR

CEMENT

Conditions for this source occur in the following groups: 7
8

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

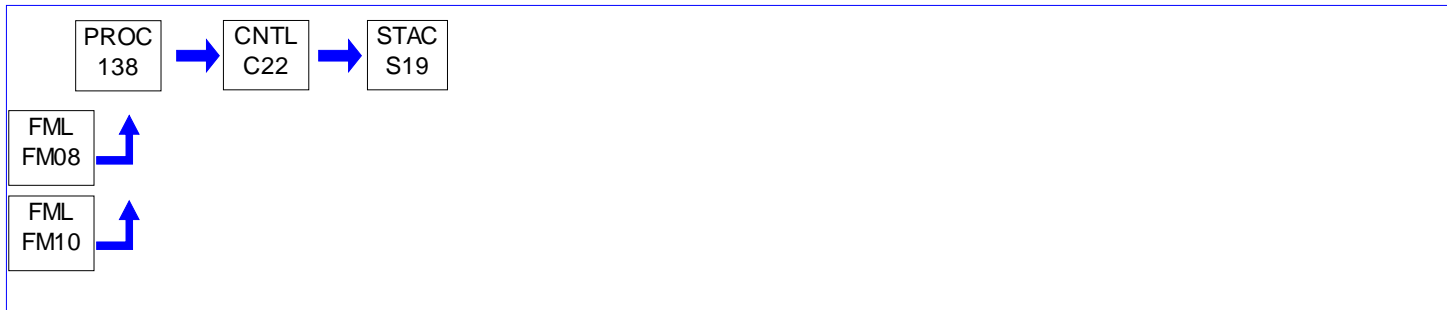
**SECTION D. Source Level Requirements**

Source ID: 138

Source Name: #2 RAW GRINDING MILL

Source Capacity/Throughput:	110.000 Tons/HR	CEMENT ROCK
	93.300 Gal/HR	#2 Oil

Conditions for this source occur in the following groups: 11

**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 any process listed in section (b)(1), at any time, either in excess of the rate calculated by the formula in paragraph (2) or in such a manner that the concentration of particulate matter in the effluent gas exceeds .02 grains per dry standard cubic foot, whichever is greater.

002 [25 Pa. Code §123.21]**General**

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

003 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1343]**Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****What standards apply to my kilns, clinker coolers, raw material dryers, and open clinker piles?**

1. The emission limit for opacity for this source is 10%.
2. Total hydrocarbon (THC) emissions limit for this source is 24 ppmvd.

II. TESTING REQUIREMENTS.**# 004 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1349]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Performance testing requirements.**

63.1349 Performance testing requirements.

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

**SECTION D. Source Level Requirements**

of installing a CEMS on the alkali bypass stack or coal mill stack, you may use the results of the initial and subsequent performance test to demonstrate compliance with the relevant emissions limit.

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

(b) (1) N/A.

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

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

(3) N/A.

(4) THC emissions test.

(i) If you are subject to limitations on THC emissions, you must operate a CEMS in accordance with the requirements in § 63.1350(i). For the purposes of conducting the accuracy and quality assurance evaluations for CEMS, the THC span value (as propane) is 50 to 60 ppmw and the reference method (RM) is Method 25A of appendix A to part 60 of this chapter.

(ii) Use the THC CEMS to conduct the initial compliance test for the first 30 kiln operating days of kiln operation after the compliance date of the rule. See § 63.1348(a).

(iii) If kiln gases are diverted through an alkali bypass or to a coal mill and exhausted through a separate stack, you must calculate a kiln-specific THC limit using Equation 9:

Where:

Cks = Kiln stack concentration (ppmvd).
 Qab = Alkali bypass flow rate (volume/hr).
 Cab = Alkali bypass concentration (ppmvd).
 Qcm = Coal mill flow rate (volume/hr).
 Ccm = Coal mill concentration (ppmvd).
 Qks = Kiln stack flow rate (volume/hr).

(iv) THC must be measured either upstream of the coal mill or the coal mill stack.

(v) Instead of conducting the performance test specified in paragraph (b)(4) of this section, you may conduct a performance test to determine emissions of total organic HAP by following the procedures in paragraph (b)(7) of this section.

(5) - (8) N/A.

[75 FR 55057, Sept. 9, 2010, as amended at 78 FR 10040, Feb. 12, 2013; 80 FR 44781, July 27, 2015; 80 FR 54729, Sept. 11, 2015; 81 FR 48359, July 25, 2016; 82 FR 28565, June 23, 2017; 82 FR 39673, Aug. 22, 2017; 83 FR 35132, July 25, 2018; 85 FR 63418, Oct. 7, 2020]

**SECTION D. Source Level Requirements****III. MONITORING REQUIREMENTS.****# 005 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1350]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Monitoring requirements.**

§ 63.1350 Monitoring requirements.

(a)

(1) Following the compliance date, the owner or operator must demonstrate compliance with this subpart on a continuous basis by meeting the requirements of this section.

(2) [Reserved]

(3) For each existing unit that is equipped with a CMS, maintain the average emissions or the operating parameter values within the operating parameter limits established through performance tests.

(4) Any instance where the owner or operator fails to comply with the continuous monitoring requirements of this section is a violation.

(b) - (e) N/A.

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

(1) (i) You must conduct a monthly 10-minute visible emissions test of each affected source in accordance with Method 22 of appendix A-7 to part 60 of this chapter. The performance test must be conducted while the affected source is in operation.

(ii) If no visible emissions are observed in six consecutive monthly tests for any affected source, the owner or operator may decrease the frequency of performance testing from monthly to semi-annually for that affected source. If visible emissions

are observed during any semi-annual test, you must resume performance testing of that affected source on a monthly basis and maintain that schedule until no visible emissions are observed in six consecutive monthly tests.

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

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

(2) (i) For a raw mill or finish mill, you must monitor opacity by conducting daily visible emissions observations of the mill sweep and air separator PM control devices (PMCD) of these affected sources in accordance with the procedures of Method 22 of appendix A-7 to part 60 of this chapter. The duration of the Method 22 performance test must be 6 minutes.

(ii) Within 24 hours of the end of the Method 22 performance test in which visible emissions were observed, the owner or operator must conduct a follow up Method 22 performance test of each stack from which visible emissions were observed during the previous Method 22 performance test.

(iii) If visible emissions are observed during the follow-up Method 22 performance test required by paragraph (f)(2)(ii) of this

section from any stack from which visible emissions were observed during the previous Method 22 performance test required by paragraph (f)(2)(i) of the section, you must then conduct an opacity test of each stack from which emissions were observed during the follow up Method 22 performance test in accordance with Method 9 of appendix A-4 to part 60 of this chapter. The duration of the Method 9 test must be 30 minutes.

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

(4) The requirements under paragraph (f)(2) of this section to conduct daily Method 22 testing do not apply to any specific raw mill or finish mill equipped with a COMS or BLDS.

(i) If the owner or operator chooses to install a COMS in lieu of conducting the daily visible emissions testing required under

**SECTION D. Source Level Requirements**

paragraph (f)(2) of this section, then the COMS must be installed at the outlet of the PM control device of the raw mill or finish mill and the COMS must be installed, maintained, calibrated, and operated as required by the general provisions in subpart A of this part and according to PS-1 of appendix B to part 60 of this chapter.

(ii) If you choose to install a BLDS in lieu of conducting the daily visible emissions testing required under paragraph (f)(2) of this section, the requirements in paragraphs (m)(1) through (m)(4), (m)(10) and (m)(11) of this section apply.

(g) - (h) N/A.

(i) THC Monitoring Requirements. If you are subject to an emissions limitation on THC emissions, you must comply with the monitoring requirements of paragraphs (i)(1) and (i)(2) and (m)(1) through (m)(4) of this section. You must also develop an emissions monitoring plan in accordance with paragraphs (p)(1) through (p)(4) of this section.

(1) You must install, operate, and maintain a THC continuous emission monitoring system in accordance with Performance

Specification 8 or Performance Specification 8A of appendix B to part 60 of this chapter and comply with all of the requirements for continuous monitoring systems found in the general provisions, subpart A of this part. The owner or operator must operate and maintain each CEMS according to the quality assurance requirements in Procedure 1 of appendix F in part 60 of this chapter. For THC continuous emission monitoring systems certified under Performance Specification 8A, conduct the relative accuracy test audits required under Procedure 1 in accordance with Performance Specification 8, Sections 8 and 11 using Method 25A in appendix A to 40 CFR part 60 as the reference method; the relative accuracy must meet the criteria of Performance Specification 8, Section 13.2.

(2) Performance tests on alkali bypass and coal mill stacks must be conducted using Method 25A in appendix A to 40 CFR part 60 and repeated every 30 months.

(j) - (p) N/A.

IV. RECORDKEEPING REQUIREMENTS.**# 006 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The permittee shall maintain a file containing all records and other data that are required to be collected pursuant to the various provisions of this operating permit. The file shall include, but not be limited to: all air pollution control systems performance evaluations and records of calibration checks, adjustments and maintenance performed on all equipment which is subject to this operating permit. All measurements, records, and other data required to be maintained by the permittee shall be retained for at least five (5) years following the date on which such measurements, records or other data are recorded.

007 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1353]**Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Notification requirements.**

[From 40 CFR 63.1353 - Notification Requirements]

The permittee shall comply with the applicable Notification requirements of 40 CFR 63.1353 as identified below:

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

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

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

**SECTION D. Source Level Requirements**

from the EPA. Permit applications shall be submitted by the same due dates as those specified for the initial notification.

(2) Notification of performance tests, as required by §§63.7 and 63.9(e).

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

(4) Notification, as required by §63.9(g), of the date that the continuous emission monitor performance evaluation required by §63.8(e) is scheduled to begin.

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

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

[64 FR 31925, June 14, 1999, as amended at 78 FR 10053, Feb. 12, 2013]

008 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1355]

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

Recordkeeping requirements.

The permittee shall comply with the applicable recordkeeping requirements of 40 CFR 63.1355 as identified below:

(a) The owner or operator shall maintain files of all information (including all reports and notifications) required by this section recorded in a form suitable and readily available for inspection and review as required by Section 63.10(b)(1). The files shall be retained for at least five (5) years following the date of each occurrence, measurement, maintenance, corrective action, report, or record. At a minimum, the most recent two (2) years of data shall be retained on site. The remaining three (3) years of data may be retained off site. The files may be maintained on microfilm, on a computer, on floppy disks, on magnetic tape, or on microfiche.

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

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

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

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

V. REPORTING REQUIREMENTS.

009 [25 Pa. Code §127.512]

Operating permit terms and conditions.

(a) The company, within one (1) hour of occurrence, shall notify the Department, at (610) 861-2070, of any malfunction, recordkeeping and reporting errors, or other possible non-compliance issues, which result in, or may possibly be resulting in, the emission of air contaminants in excess of the limitations specified in, or established pursuant to, any applicable rule or regulations contained in Article III of the Rules and Regulations of the Department of Environmental Protection. A written report shall be submitted to the Department within five working days following the incident describing the malfunction, recordkeeping and reporting error or other non-compliance issue and the corrective actions being taken. The Department may take enforcement action for any violations of the applicable standards.

(b) The source (s) are subject to Subpart F of the Standards of Performance for New Stationary Sources and to Subpart LLL of the National Emission Standards for Hazardous Air Pollutants for Source Categories. The source(s) shall comply with all applicable requirements of both Subparts. 40 CFR Sections 60.4 and 63.13 require submission of all requests, reports, applications, submittals and other communications to both EPA and the Department. The EPA copies shall be forwarded to:

Office of Air Enforcement and Compliance Assistance (3AP20)
United States Environmental Protection Agency
Region 3
1650 Arch Street
Philadelphia, PA 19103-2029

**SECTION D. Source Level Requirements****# 010 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1354]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Reporting requirements.**

§ 63.1354 Reporting requirements.

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

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

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

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

(3) As required by § 63.10(d)(4), the owner or operator of an affected source who is required to submit progress reports as a condition of receiving an extension of compliance under § 63.6(i) shall submit such reports by the dates specified in the written extension of compliance.

(4)-(5) [Reserved]

(6) As required by § 63.10(e)(2), the owner or operator shall submit a written report of the results of the performance evaluation for the continuous monitoring system required by § 63.8(e). The owner or operator shall submit the report simultaneously with the results of the performance test.

(7) As required by § 63.10(e)(2), the owner or operator of an affected source using a continuous opacity monitoring system to determine opacity compliance during any performance test required under § 63.7 and described in § 63.6(d)(6) shall report the results of the continuous opacity monitoring system performance evaluation conducted under § 63.8(e).

(8) As required by § 63.10(e)(3), the owner or operator of an affected source equipped with a continuous emission monitor shall submit an excess emissions and continuous monitoring system performance report for any event when the continuous monitoring system data indicate the source is not in compliance with the applicable emission limitation or operating parameter limit.

(9) The owner or operator shall submit a summary report semiannually within 60 days of the reporting period to the EPA via the Compliance and Emissions Data Reporting Interface (CEDRI). (CEDRI can be accessed through the EPA's Central Data Exchange (CDX) (<https://cdx.epa.gov>). You must use the appropriate electronic report in CEDRI for this subpart. Instead of using the electronic report in CEDRI for this subpart, you may submit an alternate electronic file consistent with the extensible markup language (XML) schema listed on the CEDRI website (<https://www.epa.gov/electronic-reporting-air-emissions/compliance-and-emissions-data-reporting-interface-cedri>), once the XML schema is available. If the reporting form specific to this subpart is not available in CEDRI at the time that the report is due, you must submit the report the Administrator at the appropriate address listed in § 63.13. You must begin submitting reports via CEDRI no later than 90 days after the form becomes available in CEDRI. The excess emissions and summary reports must be submitted no later than 60 days after the end of the reporting period, regardless of the method in which the reports are submitted. The report must contain the information specified in § 63.10(e)(3)(vi). In addition, the summary report shall include:

(i) All exceedances of maximum control device inlet gas temperature limits specified in § 63.1346(a) and (b);

(ii) Notification of any failure to calibrate thermocouples and other temperature sensors as required under § 63.1350(g)(1)(iii) of this subpart; and

(iii) Notification of any failure to maintain the activated carbon injection rate, and the activated carbon injection carrier gas flow rate or pressure drop, as applicable, as required under § 63.1346(c)(2).

(iv) Notification of failure to conduct any combustion system component inspections conducted within the reporting period as required under § 63.1347(a)(3).

(v) Any and all failures to comply with any provision of the operation and maintenance plan developed in accordance with § 63.1347(a).

(vi) For each PM CPMS, HCl, Hg, and THC CEMS, SO₂ CEMS, or Hg sorbent trap monitoring system, within 60 days after the reporting periods, you must report all of the calculated 30-operating day rolling average values derived from the CPMS, CEMS, CMS, or Hg sorbent trap monitoring systems.

(vii) In response to each violation of an emissions standard or established operating parameter limit, the date, duration



SECTION D. Source Level Requirements

and description of each violation and the specific actions taken for each violation including inspections, corrective actions and repeat performance tests and the results of those actions.

(10) If the total continuous monitoring system downtime for any CEM or any CMS for the reporting period is 10 percent or greater of the total operating time for the reporting period, the owner or operator shall submit an excess emissions and continuous monitoring system performance report along with the summary report.

(11)

(i) You must submit the information specified in paragraphs (b)(11)(i)(A) and (B) of this section no later than 60 days following the initial performance test. All reports must be signed by a responsible official.

(A) The initial performance test data as recorded under § 63.1349(a).

(B) The values for the site-specific operating limits or parameters established pursuant to § 63.1349(b)(1), (3), (6), (7), and (8), as applicable, and a description, including sample calculations, of how the operating parameters were established during the initial performance test.

(C) As of December 31, 2011, and within 60 days after the date of completing each performance evaluation or test, as defined in § 63.2, conducted to demonstrate compliance with any standard covered by this subpart, you must submit the relative accuracy test audit data and performance test data, except opacity data, to the EPA by successfully submitting the data electronically via CEDRI and by using the Electronic Reporting Tool (ERT) (see <https://www.epa.gov/electronic-reporting-air-emissions/electronic-reporting-tool-ert>). For any performance evaluations with no corresponding RATA pollutants listed on the ERT website, you must submit the results of the performance evaluation to the Administrator at the appropriate address listed in § 63.13.

(ii) For PM performance test reports used to set a PM CPMS operating limit, the electronic submission of the test report must also include the make and model of the PM CPMS instrument, serial number of the instrument, analytical principle of the instrument (e.g. beta attenuation), span of the instruments primary analytical range, milliamp value equivalent to the instrument zero output, technique by which this zero value was determined, and the average milliamp signals corresponding to each PM compliance test run.

(12) All reports required by this subpart not subject to the requirements in paragraphs (b)(9) introductory text and (b)(11)(i) of this section must be sent to the Administrator at the appropriate address listed in § 63.13. The Administrator or the delegated authority may request a report in any form suitable for the specific case (e.g., by commonly used electronic media such as Excel spreadsheet, on CD or hard copy). The Administrator retains the right to require submittal of reports subject to paragraphs (b)(9) introductory text and (b)(11)(i) of this section in paper format.

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

VI. WORK PRACTICE REQUIREMENTS.

No additional work practice requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

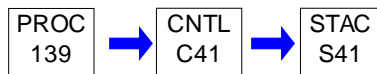
***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 139

Source Name: CLINKER STORAGE BUILDING

Source Capacity/Throughput: 150.000 Tons/HR CLINKER

Conditions for this source occur in the following groups: 8
9**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

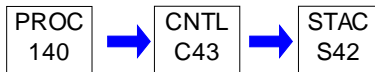
**SECTION D. Source Level Requirements**

Source ID: 140

Source Name: BULK SILOS LANE 1 FRONT SPOUT

Source Capacity/Throughput: 360.000 Tons/HR CEMENT

Conditions for this source occur in the following groups: 2
4

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

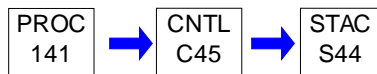
**SECTION D. Source Level Requirements**

Source ID: 141

Source Name: BULK SILOS LANE 2 SPOUT

Source Capacity/Throughput: 360.000 Tons/HR CEMENT

Conditions for this source occur in the following groups: 2
4

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 143

Source Name: COAL MILL 2

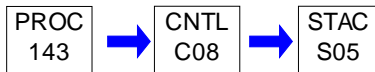
Source Capacity/Throughput:

8.000 Tons/HR

COAL

Conditions for this source occur in the following groups: 2

4

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 144

Source Name: COAL MILL 3

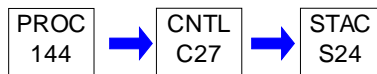
Source Capacity/Throughput:

6.100 Tons/HR

COAL

Conditions for this source occur in the following groups: 2

4

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 145

Source Name: PULVERIZED FUEL BIN

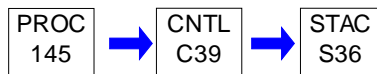
Source Capacity/Throughput:

36.000 Tons/HR

PULVERIZED FUEL

Conditions for this source occur in the following groups: 2

4

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

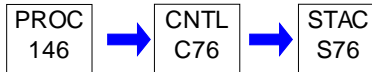
***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 146

Source Name: K-2 FEED SYSTEM

Source Capacity/Throughput: 140.000 Tons/HR KILN FEED

Conditions for this source occur in the following groups: 2
4**I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

1. Pursuant to the Best Available Technology provision of 25 PA Code, Chapter 127, the K-2 feed system baghouse is subject to the following emission limitations:

- a. PM₁₀ - 0.02 grains per dry standard cubic feet

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

1. The operation of all K-2 feed system equipment shall at all times be in compliance with 25 PA Code Section 123.1.

2. Fugitive emissions from the K-2 feed system operations shall be minimized by enclosing all conveyor belts totally on the top, bottom and sides as needed to contain the fugitive emissions in compliance with 25 PA Code 123.1

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

The storage and handling of the material collected in the air cleaning device(s) associated with the aforementioned source(s) shall not at any time result in the emission of fugitive air contaminants in excess of the limitations specified in Section 123.1 of chapter 123 of the Rules and Regulations of the Department of Environmental Protection.

II. TESTING REQUIREMENTS.

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

III. MONITORING REQUIREMENTS.**# 004 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

Mechanical gauges shall be installed and maintained to indicate, in inches of water column, the static pressure differential across the baghouse. The mechanical gauge shall be installed, calibrated, operated, and maintained according to the vendor's specifications.

IV. RECORDKEEPING REQUIREMENTS.**# 005 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The permittee shall record the pressure drop across the baghouse. At a minimum these recordings shall be taken once per week, while the sources and baghouse are in operation. The recordings shall be maintained in a logbook and made available to the Department upon request.

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

No additional reporting requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VI. WORK PRACTICE REQUIREMENTS.

006 [25 Pa. Code §127.512]

Operating permit terms and conditions.

1. The company shall keep on hand a sufficient quantity of spare baghouse bags/filters for the baghouse(s) associated with the aforementioned source(s) in order to be able to immediately replace any bags requiring replacement due to deterioration resulting from routine operation of the source(s) and baghouse(s).
2. The aforementioned source(s) may only be operated as long as the associated air pollution control devices are operated and maintained in accordance with manufacturers specifications and any conditions set forth in this operating permit.

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

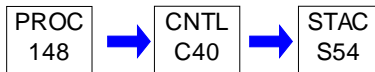
**SECTION D. Source Level Requirements**

Source ID: 148

Source Name: #4 PACKHOUSE (WEST)

Source Capacity/Throughput: 400.000 Tons/HR CEMENT

Conditions for this source occur in the following groups: 2
4

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

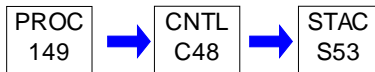
***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 149

Source Name: #1 PACKHOUSE WEST

Source Capacity/Throughput: 200.000 Tons/HR CEMENT

Conditions for this source occur in the following groups: 2
4**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

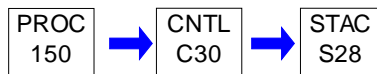
***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 150

Source Name: #1 PACKHOUSE EAST

Source Capacity/Throughput: 200.000 Tons/HR CEMENT

Conditions for this source occur in the following groups: 2
4**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

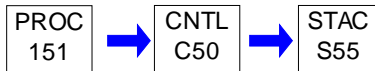
No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 151 Source Name: CEMENT SILOS S10 - S23 GROUP
 Source Capacity/Throughput: 125.000 Tons/HR CEMENT

Conditions for this source occur in the following groups: 2

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

001 [25 Pa. Code §123.13]

Processes

The permittee may not permit the emission into the outdoor atmosphere of particulate matter from this source in a manner that the concentration of particulate matter in the effluent gas exceeds the following:

- (1) 0.04 grains per dry standard cubic foot

002 [40 CFR Part 60 Standards of Performance for New Stationary Sources §40 CFR 60.62]

**Subpart F - Standards of Performance for Portland Cement Plants
Standard for particulate matter.**

No owner or operator subject to the provisions of this subpart shall cause to be discharged into the atmosphere from any affected facility other than the kiln and clinker cooler any gases which exhibit the following:

- (1) 10 percent opacity, or greater.

II. TESTING REQUIREMENTS.

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

VI. WORK PRACTICE REQUIREMENTS.

003 [25 Pa. Code §127.512]

Operating permit terms and conditions.

The company shall keep on hand a sufficient quantity of spare fabric collector bags for the fabric collector(s) associated with

**SECTION D. Source Level Requirements**

the sources listed to be able to immediately replace any bags requiring replacement due to deterioration resulting from routing operation of the sources and fabric collectors.

004 [25 Pa. Code §127.512]

Operating permit terms and conditions.

The fabric collectors must be equipped with a device for monitoring the pressure differential across the collectors.

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

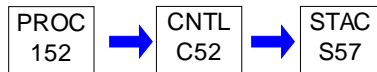
**SECTION D. Source Level Requirements**

Source ID: 152

Source Name: NOS. 2 & 6 CLINKER SILOS LOADOUT SPOUTS

Source Capacity/Throughput:

Conditions for this source occur in the following groups: 9

**I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

Both clinker loadout spouts shall not exceed a total annual operation of 2,880 hours per year (12 month rolling sum).

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

1. Both clinker loadout spouts shall not exceed a total production rate of 150,000 tons of clinker per year (12 month rolling sum).

2. Only one load out spout can be in operation at any given time.

II. TESTING REQUIREMENTS.

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

IV. RECORDKEEPING REQUIREMENTS.**# 003 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The company shall maintain records to show compliance with Conditions #001 and #002 above.

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

**SECTION D. Source Level Requirements****VII. ADDITIONAL REQUIREMENTS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

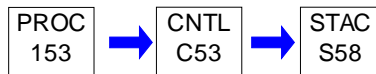
Source ID: 153

Source Name: BULK SILO B-11

Source Capacity/Throughput:

Conditions for this source occur in the following groups: 8

9

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

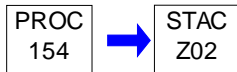
Source ID: 154

Source Name: CEMENT/SLAG BLENDER

Source Capacity/Throughput:

Conditions for this source occur in the following groups: 2

9

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

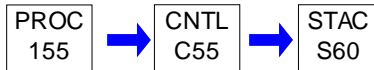
***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 155

Source Name: PDF TRANSFER SYSTEM

Source Capacity/Throughput:

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

001 [25 Pa. Code §127.512]

Operating permit terms and conditions.

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

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

III. MONITORING REQUIREMENTS.

002 [25 Pa. Code §127.512]

Operating permit terms and conditions.

The fabric collector must be equipped with a device for monitoring the pressure differential across the collector.

IV. RECORDKEEPING REQUIREMENTS.

No additional record keeping requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

VI. WORK PRACTICE REQUIREMENTS.

003 [25 Pa. Code §127.512]

Operating permit terms and conditions.

The company shall keep on hand a sufficient quantity of spare fabric collector bags for the fabric collector associated with the aforementioned source in order to be able to immediately replace any bags requiring replacement due to deterioration resulting from routine operation of the source and fabric collector.

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 160

Source Name: MISC FUGITIVE EMISSIONS

Source Capacity/Throughput:

I. RESTRICTIONS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

III. MONITORING REQUIREMENTS.

No additional monitoring requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

IV. RECORDKEEPING REQUIREMENTS.

No additional record keeping requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

VI. WORK PRACTICE REQUIREMENTS.

No additional work practice requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

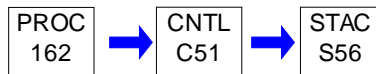
Source ID: 162

Source Name: 1 FINISH MILL HES

Source Capacity/Throughput:

Conditions for this source occur in the following groups: 8

9

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

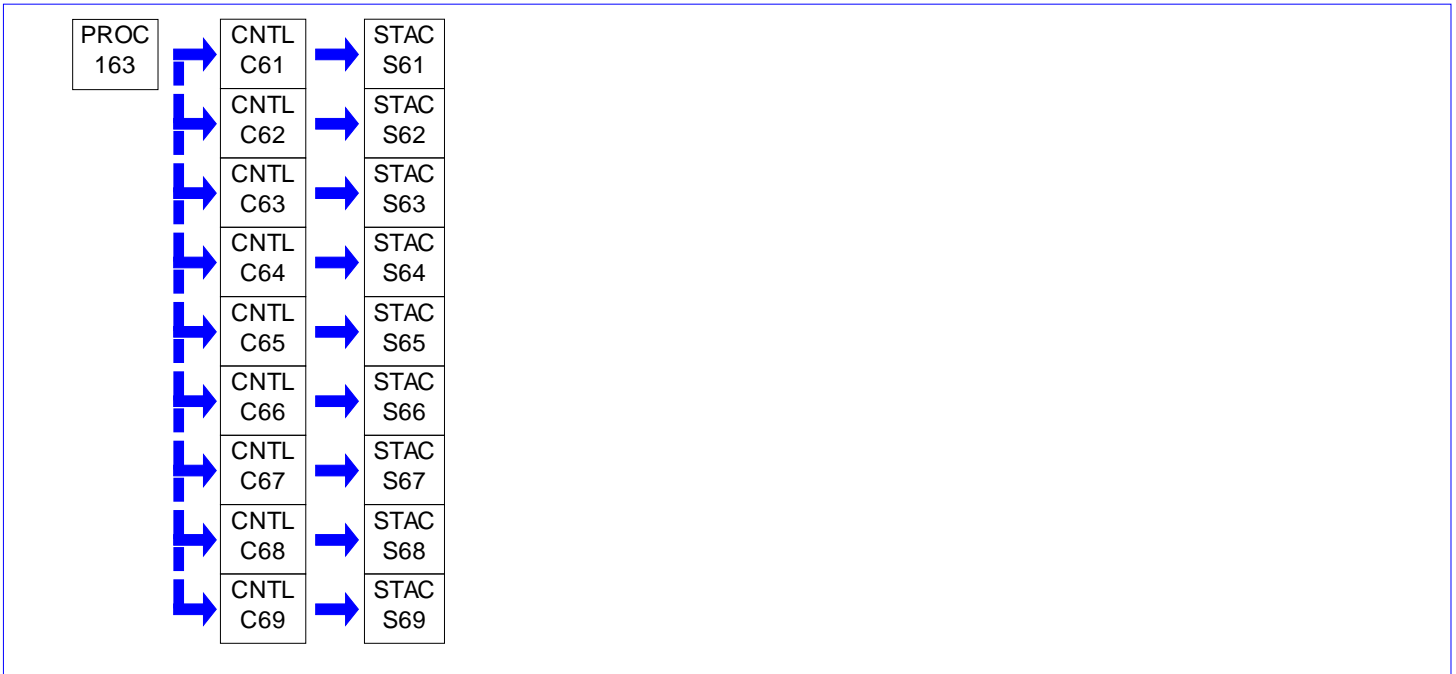
***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 163

Source Name: CLINKER RECLAIM BELT CONVEYOR SYSTEM

Source Capacity/Throughput:

Conditions for this source occur in the following groups: 2
9**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).



SECTION D. Source Level Requirements

VI. WORK PRACTICE REQUIREMENTS.

No additional work practice requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

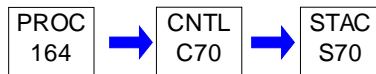
Source ID: 164

Source Name: PEBBLE LIME SILO

Source Capacity/Throughput:

Conditions for this source occur in the following groups: 2

9

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

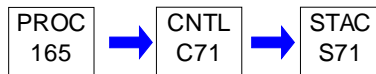
Source ID: 165

Source Name: RAW BELT 1

Source Capacity/Throughput:

Conditions for this source occur in the following groups: 10

2

**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

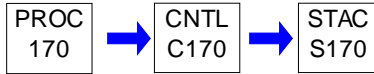
No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 170 Source Name: STONE SILO 5 & 6 W/ BELT 9

Source Capacity/Throughput:

Conditions for this source occur in the following groups: 2
9**I. RESTRICTIONS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

III. MONITORING REQUIREMENTS.**# 001 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The company shall monitor and record the pressure drop across dust collector no less than once per week. The logs of pressure drop readings shall be made available to the Department upon request.

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

The pressure drop across the collectors shall be within a range of 4" to 6" of water.

IV. RECORDKEEPING REQUIREMENTS.

No additional record keeping requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VI. WORK PRACTICE REQUIREMENTS.**# 003 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The permittee shall ensure that the control device is operated at all times when the silos and #9 belt are in operation. At no time shall the silos and #9 Belt be operated without the simultaneous operation of the fabric collector.

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 171

Source Name: AMMONIA STORAGE TANK-12,000 GALLON CAPACITY

Source Capacity/Throughput:

I. RESTRICTIONS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

III. MONITORING REQUIREMENTS.

No additional monitoring requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

IV. RECORDKEEPING REQUIREMENTS.

No additional record keeping requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

VI. WORK PRACTICE REQUIREMENTS.

No additional work practice requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 172

Source Name: HYDRATED LIME STORAGE SILO

Source Capacity/Throughput:

Conditions for this source occur in the following groups: 2

**I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

Pursuant to the Best Available Technology requirements of 25 Pa. Code Sections 127.1 and 127.12, the particulate matter emissions (PM/PM10/PM2.5) from the exhaust of Lime Storage Silo (Source ID 172) shall not exceed 0.02 grains/dscf.

II. TESTING REQUIREMENTS.

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

VI. WORK PRACTICE REQUIREMENTS.**# 002 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

1. The company shall keep on hand a sufficient quantity of spare filters for the bin vent associated with the aforementioned source in order to be able to immediately replace any filters requiring replacement due to deterioration resulting from routine operation of the source and bin vent.
2. The aforementioned source 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.
3. The company shall ensure that the capture system and control devices are operated at all times the processes are in operation.

**SECTION D. Source Level Requirements****VII. ADDITIONAL REQUIREMENTS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

**SECTION D. Source Level Requirements**

Source ID: 173

Source Name: ARM FEEDING PROCESS

Source Capacity/Throughput:

Conditions for this source occur in the following groups: 2

I. RESTRICTIONS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V 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 permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements) and/or Section E (Source Group Restrictions).

***** Permit Shield in Effect. *****

**SECTION E. Source Group Restrictions.**

Group Name: 1

Group Description: K3 Clinker Handling

Sources included in this group

ID	Name
124	K-3 CLINKER TOWER
125	K-3 CLINKER TRANSFER TOWER

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 any process listed in Group-1 in a manner that the concentration of particulate matter in the effluent gas exceeds the following:

(1) 0.04 grain per dry standard cubic foot, when the effluent gas volume is less than 150,000 dry standard cubic feet per minute.

002 [40 CFR Part 60 Standards of Performance for New Stationary Sources §40 CFR 60.62]**Subpart F - Standards of Performance for Portland Cement Plants
Standard for particulate matter.**

No owner or operator subject to the provisions of this subpart shall cause to be discharged into the atmosphere from any affected facility other than the kiln and clinker cooler any gases which exhibit the following:

(1) 10 percent opacity, or greater.

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

III. MONITORING REQUIREMENTS.

No additional monitoring requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

IV. RECORDKEEPING REQUIREMENTS.

No additional record keeping requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

VI. WORK PRACTICE REQUIREMENTS.**# 003 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The company shall keep on hand a sufficient quantity of spare fabric collector bags for the fabric collector(s) associated with the sources listed in GROUP - 1 to be able to immediately replace any bags requiring replacement due to deterioration resulting from routing operation of the sources and fabric collectors.

**SECTION E. Source Group Restrictions.****VII. ADDITIONAL REQUIREMENTS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

***** Permit Shield in Effect. *****

**SECTION E. Source Group Restrictions.**

Group Name: 10

Group Description: Quarry

Sources included in this group

ID	Name
110	QUARRY IMPACTOR
165	RAW BELT 1

I. RESTRICTIONS.**Emission Restriction(s).****# 001 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

Pursuant to the Best Available Technology (BAT) provisions of 25 PA Code Section 127.12 (a)(5), particulate emissions from the fabric collectors shall not exceed 0.015 grain/dscf.

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

III. MONITORING REQUIREMENTS.**# 002 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The fabric collectors must be equipped with a device for monitoring the pressure differential across the collectors.

IV. RECORDKEEPING REQUIREMENTS.**# 003 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The permittee shall record pressure differential readings from the collectors on a weekly basis and these records shall be kept for a five (5) year period and shall be made available to the Department upon request.

V. REPORTING REQUIREMENTS.**# 004 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

These sources are subject to Subpart LLL of the National Emission Standards for Hazardous Air Pollutants for Source Categories. The source(s) shall comply with all applicable requirements of the Subpart. 40 CFR Sections 63.13 require submission of all requests, reports, applications, submittals and other communications to both EPA and the Department. The EPA copies shall be forwarded to:

Office of Air Enforcement and Compliance Assistance (3AP20)
 United States Environmental Protection Agency
 Region 3
 1650 Arch Street
 Philadelphia, PA 19103-2029

VI. WORK PRACTICE REQUIREMENTS.**# 005 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The company shall keep on hand a sufficient quantity of spare fabric collector bags for the fabric collectors associated with the aforementioned sources in order to be able to immediately replace any bags requiring replacement due to deterioration resulting from routine operation of the sources and fabric collectors.

**SECTION E. Source Group Restrictions.****VII. ADDITIONAL REQUIREMENTS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

***** Permit Shield in Effect. *****

**SECTION E. Source Group Restrictions.**

Group Name: 11

Group Description: Raw Mills

Sources included in this group

ID	Name
108	#1 RAW GRINDING MILL
138	#2 RAW GRINDING MILL

I. RESTRICTIONS.**Emission Restriction(s).****# 001 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1343]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****What standards apply to my kilns, clinker coolers, raw material dryers, and open clinker piles?**

The Sources in this Group 11 are subject to the following THC and opacity limits of 40 CFR 63.1343.

1. The emission limit for opacity for this source is 10% during all operating modes.
2. Total hydrocarbon (THC) emissions limit for this source is 24 ppmvd at normal operating conditions.

II. TESTING REQUIREMENTS.**# 002 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1349]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Performance testing requirements.**

The Sources in this Group 11 are subject to the applicable requirements of:

- § 40 CFR 63.1349(a)
- § 40 CFR 63.1349(b)(2) [Opacity tests]
- § 40 CFR 63.1349(b)(4) [THC emissions test]

III. MONITORING REQUIREMENTS.**# 003 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1350]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Monitoring requirements.**

The Sources in this Group 11 are subject to the applicable requirements of:

- § 40 CFR 63.1350(a)
- § 40 CFR 63.1350(f) [Opacity monitoring requirements]
- § 40 CFR 63.1350(i) [THC Monitoring Requirements]

IV. RECORDKEEPING REQUIREMENTS.**# 004 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1355]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Recordkeeping requirements.**

The Sources in this Group 11 are subject to the applicable requirements of:

- § 40 CFR 63.1355

**SECTION E. Source Group Restrictions.****V. REPORTING REQUIREMENTS.**

No additional reporting requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

VI. WORK PRACTICE REQUIREMENTS.

No additional work practice requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

***** Permit Shield in Effect. *****

**SECTION E. Source Group Restrictions.**

Group Name: 2

Group Description: Other NESHAP Sources

Sources included in this group

ID	Name
105	K-2 CLINKER TOWER
106	BULK SILOS (B-5 D.C.)
107	BULK SILO GROUP (B-9 D.C.)
109	H1/H2 HOMO SILO
112	H3/H4 HOMO SILO
113	K-2 DUST RETURN SYSTEM
123	CLINKER SILOS GROUP COLLECTOR
124	K-3 CLINKER TOWER
125	K-3 CLINKER TRANSFER TOWER
132	PACKHOUSE 4 (EAST)
133	B-13 & B-14 BULK SILOS
135	H5/H6 HOMO SILO
136	BULK SILOS LANE 1 REAR SPOUT
140	BULK SILOS LANE 1 FRONT SPOUT
141	BULK SILOS LANE 2 SPOUT
143	COAL MILL 2
144	COAL MILL 3
145	PULVERIZED FUEL BIN
146	K-2 FEED SYSTEM
148	#4 PACKHOUSE (WEST)
149	#1 PACKHOUSE WEST
150	#1 PACKHOUSE EAST
151	CEMENT SILOS S10 - S23 GROUP
154	CEMENT/SLAG BLENDER
163	CLINKER RECLAIM BELT CONVEYOR SYSTEM
164	PEBBLE LIME SILO
165	RAW BELT 1
170	STONE SILO 5 & 6 W/ BELT 9
172	HYDRATED LIME STORAGE SILO
173	ARM FEEDING PROCESS

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

001 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1345]

Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry**Emissions limits for affected sources other than kilns; in-line kiln/raw mills; clinker coolers; new and reconstructed raw**

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

**SECTION E. Source Group Restrictions.****II. TESTING REQUIREMENTS.****# 002 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1349]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Performance testing requirements.**

63.1349 Performance testing requirements.

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

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

(b)

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

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

[75 FR 55057, Sept. 9, 2010, as amended at 78 FR 10040, Feb. 12, 2013; 80 FR 44781, July 27, 2015; 80 FR 54729, Sept. 11, 2015; 81 FR 48359, July 25, 2016; 82 FR 28565, June 23, 2017; 82 FR 39673, Aug. 22, 2017; 83 FR 35132, July 25, 2018; 85 FR 63418, Oct. 7, 2020]

III. MONITORING REQUIREMENTS.**# 003 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1350]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Monitoring requirements.**

§ 63.1350 Monitoring requirements.

(a)

(1) Following the compliance date, the owner or operator must demonstrate compliance with this subpart on a continuous basis by meeting the requirements of this section.

(2) [Reserved]

(3) For each existing unit that is equipped with a CMS, maintain the average emissions or the operating parameter values within the operating parameter limits established through performance tests.

(4) Any instance where the owner or operator fails to comply with the continuous monitoring requirements of this section is a violation.

**SECTION E. Source Group Restrictions.**

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

(1)

(i) You must conduct a monthly 10-minute visible emissions test of each affected source in accordance with Method 22 of appendix A-7 to part 60 of this chapter. The performance test must be conducted while the affected source is in operation.

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

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

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

(v) Any totally enclosed conveying system transfer point, regardless of the location of the transfer point is not required to conduct Method 22 visible emissions monitoring under this paragraph. The enclosures for these transfer points must be operated and maintained as total enclosures on a continuing basis in accordance with the facility operations and maintenance plan.

(vi) If any partially enclosed or unenclosed conveying system transfer point is located in a building, you must conduct a Method 22 performance test, of appendix A-7 to part 60 of this chapter, according to the requirements of paragraphs (f)(1)(i) through (iv) of this section for each such conveying system transfer point located within the building, or for the building itself according to paragraph (f)(1)(vii) of this section.

(vii) If visible emissions from a building are monitored, the requirements of paragraphs (f)(1)(i) through (f)(1)(iv) of this section apply to the monitoring of the building, and you must also test visible emissions from each side, roof, and vent of the building for at least 10 minutes.

(2)

(i) For a raw mill or finish mill, you must monitor opacity by conducting daily visible emissions observations of the mill sweep and air separator PM control devices (PMCD) of these affected sources in accordance with the procedures of Method 22 of appendix A-7 to part 60 of this chapter. The duration of the Method 22 performance test must be 6 minutes.

(ii) Within 24 hours of the end of the Method 22 performance test in which visible emissions were observed, the owner or operator must conduct a follow up Method 22 performance test of each stack from which visible emissions were observed during the previous Method 22 performance test.

(iii) If visible emissions are observed during the follow-up Method 22 performance test required by paragraph (f)(2)(ii) of this

section from any stack from which visible emissions were observed during the previous Method 22 performance test required by paragraph (f)(2)(i) of the section, you must then conduct an opacity test of each stack from which emissions were observed during the follow up Method 22 performance test in accordance with Method 9 of appendix A-4 to part 60 of this chapter. The duration of the Method 9 test must be 30 minutes.

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

(4) The requirements under paragraph (f)(2) of this section to conduct daily Method 22 testing do not apply to any specific raw mill or finish mill equipped with a COMS or BLDS.

(i) If the owner or operator chooses to install a COMS in lieu of conducting the daily visible emissions testing required under paragraph (f)(2) of this section, then the COMS must be installed at the outlet of the PM control device of the raw mill or finish mill and the COMS must be installed, maintained, calibrated, and operated as required by the general provisions in subpart A of this part and according to PS-1 of appendix B to part 60 of this chapter.

(ii) If you choose to install a BLDS in lieu of conducting the daily visible emissions testing required under paragraph (f)(2)

**SECTION E. Source Group Restrictions.**

of
this section, the requirements in paragraphs (m)(1) through (m)(4), (m)(10) and (m)(11) of this section apply.

[75 FR 55059, Sept. 9, 2010, as amended at 76 FR 2836, Jan. 18, 2011; 78 FR 10048, Feb. 12, 2013; 80 FR 44788, preview citation details, July 27, 2015; 80 FR 54729, Sept. 11, 2015; 81 FR 48361, July 25, 2016; 82 FR 28565, June 23, 2017; 82 FR 39673, Aug. 22, 2017; 83 FR 35133, July 25, 2018]

IV. RECORDKEEPING REQUIREMENTS.**# 004 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1355]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Recordkeeping requirements.**

[From 40 CFR 63.1355 - Recordkeeping Requirements]

The permittee shall comply with the applicable Recordkeeping requirements of 40 CFR 63.1355 as identified below:

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

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

- (1) All documentation supporting initial notifications and notifications of compliance status under §63.9;
- (2) All records of applicability determination, including supporting analyses; and
- (3) If the owner or operator has been granted a waiver under §63.8(f)(6), any information demonstrating whether a source is meeting the requirements for a waiver of recordkeeping or reporting requirements.

(c) - (h) NA.

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

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

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

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

- (1) Initial notifications as required by §63.9(b) through (d). For the purposes of this subpart, a Title V or 40 CFR part 70 permit application may be used in lieu of the initial notification required under §63.9(b), provided the same information is contained in the permit application as required by §63.9(b), and the State to which the permit application has been submitted has an approved operating permit program under part 70 of this chapter and has received delegation of authority from the EPA. Permit applications shall be submitted by the same due dates as those specified for the initial notification.
- (2) Notification of performance tests, as required by §§63.7 and 63.9(e).
- (3) Notification of opacity and visible emission observations required by §63.1349 in accordance with §§63.6(h)(5) and 63.9(f).
- (4) Notification, as required by §63.9(g), of the date that the continuous emission monitor performance evaluation required by §63.8(e) is scheduled to begin.

**SECTION E. Source Group Restrictions.**

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

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

[64 FR 31925, June 14, 1999, as amended at 78 FR 10053, Feb. 12, 2013]

006 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1354]

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

Reporting requirements.

§63.1354 Reporting requirements.

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

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

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

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

(3) As required by §63.10(d)(4), the owner or operator of an affected source who is required to submit progress reports as a condition of receiving an extension of compliance under §63.6(i) shall submit such reports by the dates specified in the written extension of compliance.

(4)-(5) [Reserved]

(6) As required by §63.10(e)(2), the owner or operator shall submit a written report of the results of the performance evaluation for the continuous monitoring system required by §63.8(e). The owner or operator shall submit the report simultaneously with the results of the performance test.

(7) As required by §63.10(e)(2), the owner or operator of an affected source using a continuous opacity monitoring system to determine opacity compliance during any performance test required under §63.7 and described in §63.6(d)(6) shall report the results of the continuous opacity monitoring system performance evaluation conducted under §63.8(e).

(8) As required by §63.10(e)(3), the owner or operator of an affected source equipped with a continuous emission monitor shall submit an excess emissions and continuous monitoring system performance report for any event when the continuous monitoring system data indicate the source is not in compliance with the applicable emission limitation or operating parameter limit.

(9) The owner or operator shall submit a summary report semiannually within 60 days of the reporting period to the EPA via the Compliance and Emissions Data Reporting Interface (CEDRI). (CEDRI can be accessed through the EPA's Central Data Exchange (CDX) (<https://cdx.epa.gov/>). You must use the appropriate electronic report in CEDRI for this subpart.

Instead of using the electronic report in CEDRI for this subpart, you may submit an alternate electronic file consistent with the extensible markup language (XML) schema listed on the CEDRI website (<https://www.epa.gov/electronic-reporting-air-emissions/compliance-and-emissions-data-reporting-interface-cedri>), once the XML schema is available. If the reporting form specific to this subpart is not available in CEDRI at the time that the report is due, you must submit the report the Administrator at the appropriate address listed in §63.13. You must begin submitting reports via CEDRI no later than 90 days after the form becomes available in CEDRI. The excess emissions and summary reports must be submitted no later than 60 days after the end of the reporting period, regardless of the method in which the reports are submitted. The report must contain the information specified in §63.10(e)(3)(vi). In addition, the summary report shall include:

(i) All exceedances of maximum control device inlet gas temperature limits specified in §63.1346(a) and (b);

(ii) Notification of any failure to calibrate thermocouples and other temperature sensors as required under §63.1350(g)(1)(iii) of this subpart; and

(iii) Notification of any failure to maintain the activated carbon injection rate, and the activated carbon injection carrier gas flow rate or pressure drop, as applicable, as required under §63.1346(c)(2).

(iv) Notification of failure to conduct any combustion system component inspections conducted within the reporting period as required under §63.1347(a)(3).

(v) Any and all failures to comply with any provision of the operation and maintenance plan developed in accordance with

**SECTION E. Source Group Restrictions.**

§63.1347(a).

(vi) For each PM CPMS, HCl, Hg, and THC CEMS, SO₂ CEMS, or Hg sorbent trap monitoring system, within 60 days after the reporting periods, you must report all of the calculated 30-operating day rolling average values derived from the CPMS, CEMS, CMS, or Hg sorbent trap monitoring systems.

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

(10) If the total continuous monitoring system downtime for any CEM or any CMS for the reporting period is 10 percent or greater of the total operating time for the reporting period, the owner or operator shall submit an excess emissions and continuous monitoring system performance report along with the summary report.

(11)(i) You must submit the information specified in paragraphs (b)(11)(i)(A) and (B) of this section no later than 60 days following the initial performance test. All reports must be signed by a responsible official.

(A) The initial performance test data as recorded under §63.1349(a).

(B) The values for the site-specific operating limits or parameters established pursuant to §63.1349(b)(1), (3), (6), (7), and (8), as applicable, and a description, including sample calculations, of how the operating parameters were established during the initial performance test.

(C) As of December 31, 2011, and within 60 days after the date of completing each performance evaluation or test, as defined in §63.2, conducted to demonstrate compliance with any standard covered by this subpart, you must submit the relative accuracy test audit data and performance test data, except opacity data, to the EPA by successfully submitting the data electronically via CEDRI and by using the Electronic Reporting Tool (ERT) (see <https://www.epa.gov/electronic-reporting-air-emissions/electronic-reporting-tool-ert>). For any performance evaluations with no corresponding RATA pollutants listed on the ERT website, you must submit the results of the performance evaluation to the Administrator at the appropriate address listed in §63.13.

(ii) For PM performance test reports used to set a PM CPMS operating limit, the electronic submission of the test report must also include the make and model of the PM CPMS instrument, serial number of the instrument, analytical principle of the instrument (e.g. beta attenuation), span of the instruments primary analytical range, milliamp value equivalent to the instrument zero output, technique by which this zero value was determined, and the average milliamp signals corresponding to each PM compliance test run.

(12) All reports required by this subpart not subject to the requirements in paragraphs (b)(9) introductory text and (b)(11)(i) of this section must be sent to the Administrator at the appropriate address listed in §63.13. The Administrator or the delegated authority may request a report in any form suitable for the specific case (e.g., by commonly used electronic media such as Excel spreadsheet, on CD or hard copy). The Administrator retains the right to require submittal of reports subject to paragraphs (b)(9) introductory text and (b)(11)(i) of this section in paper format.

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

[64 FR 31925, June 14, 1999, as amended at 75 FR 55063, Sept. 9, 2010; 78 FR 10053, Feb. 12, 2013; 80 FR 44790, July 27, 2015; 83 FR 35135, July 25, 2018]

VI. WORK PRACTICE REQUIREMENTS.

No additional work practice requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

**SECTION E. Source Group Restrictions.****VII. ADDITIONAL REQUIREMENTS.**

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

***** Permit Shield in Effect. *****

**SECTION E. Source Group Restrictions.**

Group Name: 3

Group Description: Ransome Diesel Generators

Sources included in this group

ID	Name
037	RANSOME GENERATOR (EAST)
038	RANSOME GENERATOR (CENTER)
039	RANSOME GENERATOR (WEST)

I. RESTRICTIONS.**Emission Restriction(s).****# 001 [25 Pa. Code §123.11]****Combustion units**

A person may not permit the emission into the outdoor atmosphere of particulate matter from a combustion unit in excess of 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.

002 [25 Pa. Code §123.21]**General**

The permittee may not permit the emission into the outdoor atmosphere of sulfur oxides from each source contained in GROUP - 3 in a manner that the concentration of the sulfur oxides, expressed as SO₂, in the effluent gas exceeds the following:

(1) 500 parts per million, by volume, dry basis.

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

III. MONITORING REQUIREMENTS.

No additional monitoring requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

IV. RECORDKEEPING REQUIREMENTS.**# 003 [25 Pa. Code §127.511]****Monitoring and related recordkeeping and reporting requirements.**

The permittee shall keep a record of fuel usage and operating hours for each generator contained in GROUP - 3. These records shall be maintained for at least 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 permit including Section B (Title V General Requirements).

VI. WORK PRACTICE REQUIREMENTS.**# 004 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

Each generator shall be set and maintained at 7.5 degrees retarded relative to standard timing.

005 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

Each generator contained in GROUP - 3 shall be maintained and operated in accordance with the manufacturers' specifications.

**SECTION E. Source Group Restrictions.****# 006 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The equipment must be installed, maintained, and operated in accordance with manufacturer specifications and good operating practices for the control of VOC and NOx emissions per 25 Pa Code 129.97(c)(1) and 129.97(c)(2)

VII. ADDITIONAL REQUIREMENTS.**# 007 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

These Sources in GROUP - 3 shall comply with all applicable requirements of 40 CFR 60 Subpart ZZZZ and each generator must operate less than 180 hours per year.

***** Permit Shield in Effect. *****

**SECTION E. Source Group Restrictions.**

Group Name: 4

Group Description: Cement Shipping and Fuel Processing

Sources included in this group

ID	Name
123	CLINKER SILOS GROUP COLLECTOR
136	BULK SILOS LANE 1 REAR SPOUT
140	BULK SILOS LANE 1 FRONT SPOUT
141	BULK SILOS LANE 2 SPOUT
143	COAL MILL 2
144	COAL MILL 3
145	PULVERIZED FUEL BIN
146	K-2 FEED SYSTEM
148	#4 PACKHOUSE (WEST)
149	#1 PACKHOUSE WEST
150	#1 PACKHOUSE EAST

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 any process listed in Group-4 in a manner that the concentration of particulate matter in the effluent gas exceeds the following:

(1) 0.04 grain per dry standard cubic foot, when the effluent gas volume is less than 150,000 dry standard cubic feet per minute.

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

III. MONITORING REQUIREMENTS.

002 [25 Pa. Code §127.512]

Operating permit terms and conditions.

The fabric collectors must be equipped with a device for monitoring the pressure differential across the collectors.

IV. RECORDKEEPING REQUIREMENTS.

003 [25 Pa. Code §127.512]

Operating permit terms and conditions.

The permittee shall record pressure differential readings from the collectors on a weekly basis and these records shall be kept for a five (5) year period and shall be made available to the Department upon request.

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

VI. WORK PRACTICE REQUIREMENTS.

004 [25 Pa. Code §127.512]

Operating permit terms and conditions.

The company shall keep on hand a sufficient quantity of spare fabric collector bags for the fabric collector(s) associated with

**SECTION E. Source Group Restrictions.**

the sources listed in Group-4 to be able to immediately replace any bags requiring replacement due to deterioration resulting from routing operation of the sources and fabric collectors.

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

***** Permit Shield in Effect. *****

**SECTION E. Source Group Restrictions.**

Group Name: 5

Group Description: Cement Kilns #2 and #3 With NSPS Standards

Sources included in this group

ID	Name
101	K-2 KILN WITH PREHEATER/SNCR & DAA INJECTION SYSTEM
114	K-3 KILN WITH PREHEATER/SNCR & DAA INJECTION SYSTEM

I. RESTRICTIONS.**Emission Restriction(s).****# 001 [40 CFR Part 60 Standards of Performance for New Stationary Sources §40 CFR 60.62]****Subpart F - Standards of Performance for Portland Cement Plants****Standard for particulate matter.**

(a) On and after the date on which the performance test required to be conducted by 60.8 is completed, no owner or operator subject to the provisions of this subpart shall cause to be discharged into the atmosphere from any kiln any gases which:

- (1) Contain particulate matter in excess of 0.15 kg per metric ton of feed (dry basis) to the kiln (0.30 lb per ton).
- (2) Exhibit greater than 20 percent opacity.

002 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1343]**Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****What standards apply to my kilns, clinker coolers, raw material dryers, and open clinker piles?**

§ 63.1343 What standards apply to my kilns, clinker coolers, raw material dryers, and open clinker storage piles?

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

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

(1) The emissions limits for these sources are shown in Table 1.

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

If your source is a (an): And the operating mode is: And if is located at a Your emissions limits are: And the units of the emissions limit are: The oxygen correction factor is:

1. Existing kiln: Normal operation: Major or area source:

PM: 0.07 lb/ton clinker (Method 5 or 51, 3 test runs)

D/F: 0.2 ng/dscm (TEQ) @7% O₂ (if average temperature at inlet to kiln fabric filter is 400F or less, this limit is 0.4 ng/dscm (TEQ))

Hg: 55 lb/MM tons clinker

THC: 24 ppmvd @ 7% O₂ (measured as propane) (Or alternative emission limit of 12 ppmvd @ 7% O₂ for organic HAP)

2. Existing kiln: Normal operation: Major source HCl: 3 ppmvd @ 7 %.

3. Existing kiln: Startup and shutdown: Major or area source: Work practices (63.1346(g)): N/A: N/A

**SECTION E. Source Group Restrictions.****# 003 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1346]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Operating limits for kilns.**

(a) The owner or operator of a kiln subject to a D/F emissions limitation under § 63.1343 must operate the kiln such that the temperature of the gas at the inlet to the kiln PM control device (PMCD) and alkali bypass PMCD, if applicable, does not exceed the applicable temperature limit specified in paragraph (b) of this section. The owner or operator of an in-line kiln/raw mill subject to a D/F emissions limitation under §63.1343 must operate the in-line kiln/raw mill, such that:

(1) When the raw mill of the in-line kiln/raw mill is operating, the applicable temperature limit for the main in-line kiln/raw mill exhaust, specified in paragraph (b) of this section and established during the performance test when the raw mill was operating, is not exceeded, except during periods of startup and shutdown when the temperature limit may be exceeded by no more than 10 percent.

(2) When the raw mill of the in-line kiln/raw mill is not operating, the applicable temperature limit for the main in-line kiln/raw mill exhaust, specified in paragraph (b) of this section and established during the performance test when the raw mill was not operating, is not exceeded, except during periods of startup/shutdown when the temperature limit may be exceeded by no more than 10 percent.

(3) If the in-line kiln/raw mill is equipped with an alkali bypass, the applicable temperature limit for the alkali bypass specified in paragraph (b) of this section and established during the performance test, with or without the raw mill operating, is not exceeded, except during periods of startup/shutdown when the temperature limit may be exceeded by no more than 10 percent.

(b) The temperature limit for affected sources meeting the limits of paragraph (a) of this section or paragraphs (a)(1) through (a)(3) of this section is determined in accordance with § 63.1349(b)(3)(iv).

(c) For an affected source subject to a D/F emissions limitation under § 63.1343 that employs sorbent injection as an emission control technique for D/F control, you must operate the sorbent injection system in accordance with paragraphs (c)(1) and (2) of this section.

(1) The rolling three-hour average activated sorbent injection rate must be equal to or greater than the sorbent injection rate determined in accordance with § 63.1349(b)(3)(vi).

(2) You must either:

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

(ii) Maintain the minimum activated carbon injection carrier gas pressure drop, as a rolling threehour average, based on the manufacturer's specifications. These specifications must be documented in the test plan developed in accordance with § 63.7(c).

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

(e) For an affected source subject to a D/F emissions limitation under § 63.1343 that employs carbon injection as an emission control technique you may substitute, at any time, a different brand or type of sorbent provided that the replacement has equivalent or improved properties compared to the sorbent specified in the site-specific performance test plan and used in the performance test. The owner or operator must maintain documentation that the substitute sorbent will provide the same or better level of control as the original sorbent.

(f) No kiln may use as a raw material or fuel any fly ash where the mercury content of the fly ash has been increased through the use of activated carbon, or any other sorbent, unless the facility can demonstrate that the use of that fly ash will not result in an increase in mercury emissions over baseline emissions (i.e., emissions not using the fly ash). The facility has the burden of proving there has been no emissions increase over baseline. Once the kiln is in compliance with a mercury emissions limit specified in § 63.1343, this paragraph no longer applies.

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(g) During periods of startup and shutdown you must meet the requirements listed in (g)(1) through (4) of this section.

(1) During startup you must use any one or combination of the following clean fuels: natural gas, synthetic natural gas, propane, distillate oil, synthesis gas (syngas), and ultra-low sulfur diesel (ULSD) until the kiln reaches a temperature of 1200 degrees Fahrenheit.

(2) Combustion of the primary kiln fuel may commence once the kiln temperature reaches 1200 degrees Fahrenheit.

(3) All dry sorbent and activated carbon systems that control hazardous air pollutants must be turned on and operating at the time the gas stream at the inlet to the baghouse or ESP reaches 300 degrees Fahrenheit (five minute average) during startup. Temperature of the gas stream is to be measured at the inlet of the baghouse or ESP every minute. Such injection systems can be turned off during shutdown. Particulate control and all remaining devices that control hazardous air pollutants should be operational during startup and shutdown.

(4) You must keep records as specified in § 63.1355 during periods of startup and shutdown.

[75 FR 55054, Sept. 9, 2010, as amended at 78 FR 10039, Feb. 12, 2013; 80 FR 44781, July 27, 2015]

II. TESTING REQUIREMENTS.**# 004 [40 CFR Part 60 Standards of Performance for New Stationary Sources §40 CFR 60.64]****Subpart F - Standards of Performance for Portland Cement Plants****Test methods and procedures.**

(a) In conducting the performance tests required in 60.8, the owner or operator shall use as reference methods and procedures the test methods in appendix A of this part or other methods and procedures as specified in this section, except as provided in 60.8(b).

(b) The owner or operator shall determine compliance with the particulate matter standard in 60.62 as follows:

(1) The emission rate (E) of particulate matter shall be computed for each run using the following equation:

$$E = (cs \text{ Qsd}) / (P \text{ K})$$

where:

E=emission rate of particulate matter, kg/metric ton (lb/ton) of kiln feed.

cs=concentration of particulate matter, g/dscm (g/dscf).

Qsd=volumetric flow rate of effluent gas, dscm/hr (dscf/hr).

P=total kiln feed (dry basis) rate, metric ton/hr (ton/hr).

K=conversion factor, 1000 g/kg (453.6 g/lb).

(2) Method 5 shall be used to determine the particulate matter concentration (cs) and the volumetric flow rate (Qsd) of the effluent gas.

The sampling time and sample volume for each run shall be at least 60 minutes and 0.85 dscm (30.0 dscf) for the kiln and at least 60 minutes and 1.15 dscm (40.6 dscf) for the clinker cooler.

(3) Suitable methods shall be used to determine the kiln feed rate (P), except fuels, for each run. Material balance over the production system shall be used to confirm the feed rate.

(4) Method 9 and the procedures in 60.11 shall be used to determine opacity.

005 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1349]**Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Performance testing requirements.**

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The Sources in this Group 05 are subject to the applicable requirements of § 63.1349 Performance Testing Requirements.

III. MONITORING REQUIREMENTS.**# 006 [40 CFR Part 60 Standards of Performance for New Stationary Sources §40 CFR 60.63]****Subpart F - Standards of Performance for Portland Cement Plants****Monitoring of operations.**

(a) The owner or operator of any portland cement plant subject to the provisions of this part shall record the daily production rates and kiln feed rates.

(b) Except as provided in paragraph (c) of this section, each owner or operator of a kiln or clinker cooler that is subject to the provisions of this subpart shall install, calibrate, maintain, and operate in accordance with 60.13 a continuous opacity monitoring system to measure the opacity of emissions discharged into the atmosphere from any kiln or clinker cooler. Except as provided in paragraph (c) of this section, a continuous opacity monitoring system shall be installed on each stack of any multiple stack device controlling emissions from any kiln or clinker cooler. If there is a separate bypass installed, each owner or operator of a kiln or clinker cooler shall also install, calibrate, maintain, and operate a continuous opacity monitoring system on each bypass stack in addition to the main control device stack. Each owner or operator of an affected kiln or clinker cooler for which the performance test required under 60.8 has been completed on or prior to December 14, 1988, shall install the continuous opacity monitoring system within 180 days after December 14, 1988.

(c) NA.

(d) For the purpose of reports under 60.65, periods of excess emissions that shall be reported are defined as all 6-minute periods during which the average opacity exceeds that allowed by 60.62(a)(2) or 60.62(b)(2).

(e) The provisions of paragraphs (a), (b), and (c) of this section apply to kilns and clinker coolers for which construction, modification, or reconstruction commenced after August 17, 1971.

007 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1350]**Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Monitoring requirements.**

The Sources in this Group 05 are subject to the applicable requirements of § 63.1350 Monitoring requirements.

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

[Additional authority for this permit condition is derived from 25 Pa. Code Sections 139.101(5) and 139.101(12), 139.103, 139.108 or 139.111]]

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

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

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

009 [40 CFR Part 60 Standards of Performance for New Stationary Sources §40 CFR 60.65]**Subpart F - Standards of Performance for Portland Cement Plants****Recordkeeping and reporting requirements.**

(a) Each owner or operator required to install a continuous opacity monitoring system under 60.63(b) shall submit reports

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of excess emissions as defined in 60.63(d). The content of these reports must comply with the requirements in 60.7(c). Notwithstanding the provisions of 60.7(c), such reports shall be submitted semiannually.

(b) Each owner or operator monitoring visible emissions under 60.63(c) shall submit semiannual reports of observed excess emissions as defined in 60.63(d).

(c) Each owner or operator of facilities subject to the provisions of 60.63(c) shall submit semiannual reports of the malfunction information required to be recorded by 60.7(b). These reports shall include the frequency, duration, and cause of any incident resulting in deenergization of any device controlling kiln emissions or in the venting of emissions directly to the atmosphere.

(d) The requirements of this section remain in force until and unless the Agency, in delegating enforcement authority to a State under section 111(c) of the Clean Air Act, 42 USC 7411, approves reporting requirements or an alternative means of compliance surveillance adopted by such States. In that event, affected sources within the State will be relieved of the obligation to comply with this section, provided that they comply with the requirements established by the State.

010 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1355]**Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Recordkeeping requirements.**

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

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

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

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

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

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

(d) [Reserved]

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

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

(g)

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

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

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

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

V. REPORTING REQUIREMENTS.**# 011 [25 Pa. Code §127.511]****Monitoring and related recordkeeping and reporting requirements.**

[Additional authority for this permit condition is derived from 25 Pa. Code Sections 139.101(1)(iv), 139.101(10) and 139.101(12), 139.103, 139.108 or 139.111]

(a) The permittee shall submit quarterly reports of continuous emission monitoring to the Department in accordance with the requirements established in 25 Pa. Code Chapter 139, Subchapter C (relating to requirements for source monitoring for stationary sources), (and) the "Record Keeping and Reporting" requirements as established in the Department's Continuous Source Monitoring Manual, Revision No. 8, 274-0300-001.

(b) The permittee shall report emissions for all periods of unit operation, including startup, shutdown and malfunction.

(c) Initial quarterly reports following system certification shall be submitted to the Department within 35 days following the date upon which the Department notifies the owner or operator, in writing, of the approval of the continuous source monitoring system for use in determining compliance with applicable emission standards.

(d) Subsequent quarterly reports shall be submitted to the Department within 30 days after the end of each calendar quarter.

(e) Failure to submit required reports of continuous emission monitoring within the time periods specified in this Condition, shall constitute violations of this Permit, unless approved in advance by the Department in writing.

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

012 [25 Pa. Code §145.143.]**Standard requirements.**

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

(b) The owner or operator shall determine allowable emissions by multiplying the tons of clinker produced by the Portland cement kiln for the period by 6 pounds per ton of clinker produced.

(c) The owner or operator shall install and operate a CEMS, and shall report CEMS emissions data, in accordance with the CEMS requirements of either Chapter 139 or 145 (relating to sampling and testing; and interstate pollution transport reduction) and calculate actual emissions using the CEMS data reported to the Department. Any data invalidated under Chapter 139 shall be substituted with data calculated using the potential emission rate for the unit or, if approved by the Department in writing, an alternative amount of emissions that is more representative of actual emissions that occurred during the period of invalid data.

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

(e) If the combined allowable emissions from Portland cement kilns at a facility from May 1 through September 30 exceed

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the combined actual emissions from Portland cement kilns subject to this section at the facility during the same period, the owner or operator may deduct the difference or any portion of the difference from the amount of actual emissions from Portland cement kilns at the owner or operator's other facilities located in this Commonwealth for that period.

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

- (1) The serial number of each NO_x allowance surrendered.
- (2) The calculations used to determine the quantity of NO_x allowances required to be surrendered.

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

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

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

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

013 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1354]**Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Reporting requirements.**

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

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

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

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

(3) As required by § 63.10(d)(4), the owner or operator of an affected source who is required to submit progress reports as a condition of receiving an extension of compliance under § 63.6(i) shall submit such reports by the dates specified in the written extension of compliance.

(4)-(5) [Reserved]

(6) As required by § 63.10(e)(2), the owner or operator shall submit a written report of the results of the performance evaluation for the continuous monitoring system required by § 63.8(e). The owner or operator shall submit the report simultaneously with the results of the performance test.

(7) As required by § 63.10(e)(2), the owner or operator of an affected source using a continuous opacity monitoring system to determine opacity compliance during any performance test required under § 63.7 and described in § 63.6(d)(6) shall report the results of the continuous opacity monitoring system performance evaluation conducted under § 63.8(e).

(8) As required by § 63.10(e)(3), the owner or operator of an affected source equipped with a continuous emission monitor shall submit an excess emissions and continuous monitoring system performance report for any event when the continuous monitoring system data indicate the source is not in compliance with the applicable emission limitation or operating parameter limit.

(9) The owner or operator shall submit a summary report semiannually within 60 days of the reporting period to the EPA via the Compliance and Emissions Data Reporting Interface (CEDRI). (CEDRI can be accessed through the EPA's Central Data Exchange (CDX) (<https://cdx.epa.gov/>). You must use the appropriate electronic report in CEDRI for this subpart. Instead of using the electronic report in CEDRI for this subpart, you may submit an alternate electronic file consistent with the extensible markup language (XML) schema listed on the CEDRI website (<https://www.epa.gov/electronic-reporting-air-emissions/compliance-and-emissions-data-reporting-interface-cedri>), once the XML schema is available. If the reporting

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form specific to this subpart is not available in CEDRI at the time that the report is due, you must submit the report the Administrator at the appropriate address listed in § 63.13. You must begin submitting reports via CEDRI no later than 90 days after the form becomes available in CEDRI. The excess emissions and summary reports must be submitted no later than 60 days after the end of the reporting period, regardless of the method in which the reports are submitted. The report must contain the information specified in § 63.10(e)(3)(vi). In addition, the summary report shall include:

- (i) All exceedances of maximum control device inlet gas temperature limits specified in § 63.1346(a) and (b);
- (ii) Notification of any failure to calibrate thermocouples and other temperature sensors as required under § 63.1350(g)(1)(iii) of this subpart; and
- (iii) Notification of any failure to maintain the activated carbon injection rate, and the activated carbon injection carrier gas flow rate or pressure drop, as applicable, as required under § 63.1346(c)(2).
- (iv) Notification of failure to conduct any combustion system component inspections conducted within the reporting period as required under § 63.1347(a)(3).
- (v) Any and all failures to comply with any provision of the operation and maintenance plan developed in accordance with § 63.1347(a).
- (vi) For each PM CPMS, HCl, Hg, and THC CEMS, SO₂ CEMS, or Hg sorbent trap monitoring system, within 60 days after the reporting periods, you must report all of the calculated 30-operating day rolling average values derived from the CPMS, CEMS, CMS, or Hg sorbent trap monitoring systems.
- (vii) In response to each violation of an emissions standard or established operating parameter limit, the date, duration and description of each violation and the specific actions taken for each violation including inspections, corrective actions and repeat performance tests and the results of those actions.

(10) If the total continuous monitoring system downtime for any CEM or any CMS for the reporting period is 10 percent or greater of the total operating time for the reporting period, the owner or operator shall submit an excess emissions and continuous monitoring system performance report along with the summary report.

(11)

(i) You must submit the information specified in paragraphs (b)(11)(i)(A) and (B) of this section no later than 60 days following the initial performance test. All reports must be signed by a responsible official.

(A) The initial performance test data as recorded under § 63.1349(a).

(B) The values for the site-specific operating limits or parameters established pursuant to § 63.1349(b)(1), (3), (6), (7), and (8), as applicable, and a description, including sample calculations, of how the operating parameters were established during the initial performance test.

(C) As of December 31, 2011, and within 60 days after the date of completing each performance evaluation or test, as defined in § 63.2, conducted to demonstrate compliance with any standard covered by this subpart, you must submit the relative accuracy test audit data and performance test data, except opacity data, to the EPA by successfully submitting the data electronically via CEDRI and by using the Electronic Reporting Tool (ERT) (see <https://www.epa.gov/electronic-reporting-air-emissions/electronic-reporting-tool-ert>). For any performance evaluations with no corresponding RATA pollutants listed on the ERT website, you must submit the results of the performance evaluation to the Administrator at the appropriate address listed in § 63.13.

(ii) For PM performance test reports used to set a PM CPMS operating limit, the electronic submission of the test report must also include the make and model of the PM CPMS instrument, serial number of the instrument, analytical principle of the instrument (e.g. beta attenuation), span of the instruments primary analytical range, milliamp value equivalent to the instrument zero output, technique by which this zero value was determined, and the average milliamp signals corresponding to each PM compliance test run.

(12) All reports required by this subpart not subject to the requirements in paragraphs (b)(9) introductory text and (b)(11)(i) of this section must be sent to the Administrator at the appropriate address listed in § 63.13. The Administrator or the delegated authority may request a report in any form suitable for the specific case (e.g., by commonly used electronic media such as Excel spreadsheet, on CD or hard copy). The Administrator retains the right to require submittal of reports subject to paragraphs (b)(9) introductory text and (b)(11)(i) of this section in paper format.

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

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[64 FR 31925, June 14, 1999, as amended at 75 FR 55063, Sept. 9, 2010; 78 FR 10053, Feb. 12, 2013; 80 FR 44790, July 27, 2015; 83 FR 35135, July 25, 2018]

VI. WORK PRACTICE REQUIREMENTS.**# 014 [25 Pa. Code §127.511]****Monitoring and related recordkeeping and reporting requirements.**

[Additional authority for this permit condition is derived from 25 Pa. Code Sections 139.101(1)(iv), 139.101(2), 139.101(3), 139.101(4), 139.101(6), 139.101(7), 139.101(8), 139.101(12), 139.101(14) and 139.101(15)]

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

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

(c) Data Availability Standards: Continuous emission monitoring shall meet the following minimum data availability requirements:

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

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

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

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

(3) Emission Standard(s) To Which Data Availability Standard applies:

(i) CO (ppmvd)

(ii) NO_x (ppmvd)

(iii) CO₂ (lbs per MW-hr gross)

(iv) Ammonia (ppmvd), if ammonia CEMS is installed

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

***** Permit Shield in Effect. *****

**SECTION E. Source Group Restrictions.**

Group Name: 6

Group Description: Clinker Cooler K2 and K3 with NESHAP Standards

Sources included in this group

ID	Name
103	K-2 COOLER
115	K-3 COOLER

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

001 [25 Pa. Code §127.512]

Operating permit terms and conditions.

The clinker coolers are subject to PC MACT emission limit of 0.07 lb/ton clinker per 63.1343(b)(1).

II. TESTING REQUIREMENTS.

002 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1349]

Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry**Performance testing requirements.**

The company shall comply with the PC MACT requirements applicable to these sources. The following regulations are applicable:

40 CFR 63.1349(a)

40 CFR 63.1349(b)(1) [PM Emissions Tests]

III. MONITORING REQUIREMENTS.

003 [25 Pa. Code §127.511]

Monitoring and related recordkeeping and reporting requirements.

Every two (2) years a system performance audit shall be conducted on the opacity monitors using the monitoring relative accuracy procedure specified in the Phase II Section of the Department's Continuous Source Monitoring Manual except that testing only need be conducted during three days.

004 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1350]

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

The company shall comply with the PC MACT requirements applicable to these sources. The following regulations are applicable:

40 CFR 63.1350(a)

40 CFR 63.1350(b)(1) [PM CPMS]

IV. RECORDKEEPING REQUIREMENTS.

005 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1355]

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

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

**SECTION E. Source Group Restrictions.**

data may be retained off site. The files may be maintained on microfilm, on a computer, on floppy disks, on magnetic tape, or on microfiche.

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

- (1) All documentation supporting initial notifications and notifications of compliance status under §63.9;
- (2) All records of applicability determination, including supporting analyses; and
- (3) If the owner or operator has been granted a waiver under §63.8(f)(6), any information demonstrating whether a source is meeting the requirements for a waiver of recordkeeping or reporting requirements.

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

(d) [Reserved]

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

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

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

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

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

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

V. REPORTING REQUIREMENTS.

006 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1353]

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

Notification requirements.

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

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

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

(2) Notification of performance tests, as required by §§63.7 and 63.9(e).

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

**SECTION E. Source Group Restrictions.**

63.9(f).

(4) Notification, as required by §63.9(g), of the date that the continuous emission monitor performance evaluation required by §63.8(e) is scheduled to begin.

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

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

[64 FR 31925, June 14, 1999, as amended at 78 FR 10053, Feb. 12, 2013]

007 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1354]**Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Reporting requirements.**

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

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

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

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

(3) As required by §63.10(d)(4), the owner or operator of an affected source who is required to submit progress reports as a condition of receiving an extension of compliance under §63.6(i) shall submit such reports by the dates specified in the written extension of compliance.

(4)-(5) [Reserved]

(6) As required by §63.10(e)(2), the owner or operator shall submit a written report of the results of the performance evaluation for the continuous monitoring system required by §63.8(e). The owner or operator shall submit the report simultaneously with the results of the performance test.

(7) As required by §63.10(e)(2), the owner or operator of an affected source using a continuous opacity monitoring system to determine opacity compliance during any performance test required under §63.7 and described in §63.6(d)(6) shall report the results of the continuous opacity monitoring system performance evaluation conducted under §63.8(e).

(8) As required by §63.10(e)(3), the owner or operator of an affected source equipped with a continuous emission monitor shall submit an excess emissions and continuous monitoring system performance report for any event when the continuous monitoring system data indicate the source is not in compliance with the applicable emission limitation or operating parameter limit.

(9) The owner or operator shall submit a summary report semiannually within 60 days of the reporting period to the EPA via the Compliance and Emissions Data Reporting Interface (CEDRI). (CEDRI can be accessed through the EPA's Central Data Exchange (CDX) (<https://cdx.epa.gov/>). You must use the appropriate electronic report in CEDRI for this subpart.

Instead of using the electronic report in CEDRI for this subpart, you may submit an alternate electronic file consistent with the extensible markup language (XML) schema listed on the CEDRI website (<https://www.epa.gov/electronic-reporting-air-emissions/compliance-and-emissions-data-reporting-interface-cedri>), once the XML schema is available. If the reporting form specific to this subpart is not available in CEDRI at the time that the report is due, you must submit the report the Administrator at the appropriate address listed in §63.13. You must begin submitting reports via CEDRI no later than 90 days after the form becomes available in CEDRI. The excess emissions and summary reports must be submitted no later than 60 days after the end of the reporting period, regardless of the method in which the reports are submitted. The report must contain the information specified in §63.10(e)(3)(vi). In addition, the summary report shall include:

(i) All exceedances of maximum control device inlet gas temperature limits specified in §63.1346(a) and (b);

(ii) Notification of any failure to calibrate thermocouples and other temperature sensors as required under §63.1350(g)(1)(iii) of this subpart; and

(iii) Notification of any failure to maintain the activated carbon injection rate, and the activated carbon injection carrier gas flow rate or pressure drop, as applicable, as required under §63.1346(c)(2).

(iv) Notification of failure to conduct any combustion system component inspections conducted within the reporting period

**SECTION E. Source Group Restrictions.**

as required under §63.1347(a)(3).

(v) Any and all failures to comply with any provision of the operation and maintenance plan developed in accordance with §63.1347(a).

(vi) For each PM CPMS, HCl, Hg, and THC CEMS, SO₂ CEMS, or Hg sorbent trap monitoring system, within 60 days after the reporting periods, you must report all of the calculated 30-operating day rolling average values derived from the CPMS, CEMS, CMS, or Hg sorbent trap monitoring systems.

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

(10) If the total continuous monitoring system downtime for any CEM or any CMS for the reporting period is 10 percent or greater of the total operating time for the reporting period, the owner or operator shall submit an excess emissions and continuous monitoring system performance report along with the summary report.

(11)(i) You must submit the information specified in paragraphs (b)(11)(i)(A) and (B) of this section no later than 60 days following the initial performance test. All reports must be signed by a responsible official.

(A) The initial performance test data as recorded under §63.1349(a).

(B) The values for the site-specific operating limits or parameters established pursuant to §63.1349(b)(1), (3), (6), (7), and (8), as applicable, and a description, including sample calculations, of how the operating parameters were established during the initial performance test.

(C) As of December 31, 2011, and within 60 days after the date of completing each performance evaluation or test, as defined in §63.2, conducted to demonstrate compliance with any standard covered by this subpart, you must submit the relative accuracy test audit data and performance test data, except opacity data, to the EPA by successfully submitting the data electronically via CEDRI and by using the Electronic Reporting Tool (ERT) (see <https://www.epa.gov/electronic-reporting-air-emissions/electronic-reporting-tool-ert>). For any performance evaluations with no corresponding RATA pollutants listed on the ERT website, you must submit the results of the performance evaluation to the Administrator at the appropriate address listed in §63.13.

(ii) For PM performance test reports used to set a PM CPMS operating limit, the electronic submission of the test report must also include the make and model of the PM CPMS instrument, serial number of the instrument, analytical principle of the instrument (e.g. beta attenuation), span of the instruments primary analytical range, milliamp value equivalent to the instrument zero output, technique by which this zero value was determined, and the average milliamp signals corresponding to each PM compliance test run.

(12) All reports required by this subpart not subject to the requirements in paragraphs (b)(9) introductory text and (b)(11)(i) of this section must be sent to the Administrator at the appropriate address listed in §63.13. The Administrator or the delegated authority may request a report in any form suitable for the specific case (e.g., by commonly used electronic media such as Excel spreadsheet, on CD or hard copy). The Administrator retains the right to require submittal of reports subject to paragraphs (b)(9) introductory text and (b)(11)(i) of this section in paper format.

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

[64 FR 31925, June 14, 1999, as amended at 75 FR 55063, Sept. 9, 2010; 78 FR 10053, Feb. 12, 2013; 80 FR 44790, July 27, 2015; 83 FR 35135, July 25, 2018]

VI. WORK PRACTICE REQUIREMENTS.

008 [25 Pa. Code §127.512]

Operating permit terms and conditions.

The company shall keep on hand a sufficient quantity of spare fabric collector bags for the fabric collector(s) associated with the sources contained in GROUP - 6 in order of be able to immediately replace any bags requiring replacement due to deterioration resulting from routine operation of the source(s) and fabric collector(s).

**SECTION E. Source Group Restrictions.****# 009 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The storage and handling of the material collected in the air cleaning devices associated with the sources contained in GROUP 6 shall not at any time result in the emission of fugitive air contaminants in excess of the limitations specified in SECTION C, Condition #002.

010 [25 Pa. Code §127.512]**Operating permit terms and conditions.**

The clinker coolers are subject to PC MACT and SU/SD work practices per 63.1343(b) and 63.1348(b)(9).

VII. ADDITIONAL REQUIREMENTS.**# 011 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1356]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Sources with multiple emission limits or monitoring requirements.**

[From 40 CFR 63.1356 - Exemption from New Source Performance Standards]

(a) Except as provided in Paragraphs (a)(1) and (a)(2) of this section, any affected source subject to the provisions of this subpart is exempted from any otherwise applicable New Source Performance Standard contained in 40 CFR Part 60, Subpart F.

(1) Not Applicable

(2) Not Applicable

***** Permit Shield in Effect. *****

**SECTION E. Source Group Restrictions.**

Group Name: 7

Group Description: Finish mills

Sources included in this group

ID	Name
122	#2 FINISH MILL OSEPA
127	#1 FINISH GRINDING MILL
128	#2 FINISH GRINDING MILL
129	#2 FINISH MILL AUXILLARIES
137	FINISH MILL 1 AUXILLARIES

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 any process listed in Group-7 in such a manner that the concentration of particulate matter in the effluent gas exceeds the following:

(1) .04 grain per dry standard cubic foot, when the effluent gas volume is less than 150,000 dry standard cubic feet per minute.

(ii) The rate determined by the formula:

$$A = 6000/E$$

where:

A = Allowable emissions in grains per dry standard cubic foot, and

E = Effluent gas volume in dry standard cubic feet per minute,

when E is equal to or greater than 150,000 but less than 300,000.

(iii) .02 grain per dry standard cubic foot, when the effluent gas volume is greater than 300,000 dry standard cubic feet per minute.

(2) Allowable emissions. Allowable emissions under this subsection are graphically indicated in Appendix C.

002 [40 CFR Part 60 Standards of Performance for New Stationary Sources §40 CFR 60.62]**Subpart F - Standards of Performance for Portland Cement Plants****Standard for particulate matter.**

For all sources in this group, no owner or operator subject to the provisions of this subpart shall cause to be discharged into the atmosphere from any affected facility other than the kiln and clinker cooler any gases which exhibit the following:

(1) 10 percent opacity, or greater.

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

III. MONITORING REQUIREMENTS.**# 003 [25 Pa. Code §127.511]****Monitoring and related recordkeeping and reporting requirements.**

The fabric collectors associated with each source contained in GROUP - 7 must be equipped with a device for monitoring the pressure differential across the collectors.

**SECTION E. Source Group Restrictions.****IV. RECORDKEEPING REQUIREMENTS.****# 004 [25 Pa. Code §127.511]****Monitoring and related recordkeeping and reporting requirements.**

The permittee shall record pressure differential readings from the collectors on a weekly basis and these records shall be kept for a five (5) year period and shall be made available to the Department upon request.

V. REPORTING REQUIREMENTS.

No additional reporting requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

VI. WORK PRACTICE REQUIREMENTS.**# 005 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The company shall keep on hand a sufficient quantity of spare fabric collector bags for the fabric collectors associated with the sources contained in GROUP - 7 in order to be able to immediately replace any bags requiring replacement due to deterioration resulting from routine operation of the sources and fabric collectors.

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

***** Permit Shield in Effect. *****

**SECTION E. Source Group Restrictions.**

Group Name: 8

Group Description: Raw and Finish Mill NESHAP Requirements

Sources included in this group

ID	Name
122	#2 FINISH MILL OSEPA
127	#1 FINISH GRINDING MILL
128	#2 FINISH GRINDING MILL
129	#2 FINISH MILL AUXILLARIES
137	FINISH MILL 1 AUXILLARIES
139	CLINKER STORAGE BUILDING
153	BULK SILO B-11
162	1 FINISH MILL HES

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

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

[78 FR 10039, Feb. 12, 2013]

II. TESTING REQUIREMENTS.**# 002 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1349]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Performance testing requirements.**

The company shall comply with the PC MACT requirements applicable to these sources. The following regulations are applicable:

40 CFR 63.1349(a)

40 CFR 63.1349(b)(2) [Opacity tests]

40 CFR 63.1349(b)(4) [THC emissions test]

III. MONITORING REQUIREMENTS.**# 003 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1350]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Monitoring requirements.**

The company shall comply with the PC MACT requirements applicable to these sources. The following regulations are applicable:

40 CFR 63.1350(a)

40 CFR 63.1350(f) [Opacity monitoring requirements]

40 CFR 63.1350(i) [THC Monitoring Requirements]

**SECTION E. Source Group Restrictions.****IV. RECORDKEEPING REQUIREMENTS.****# 004 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1355]****Subpart LLL -- National Emission Standards for Hazardous Air Pollutants From the Portland Cement Manufacturing Industry****Recordkeeping requirements.**

The company shall comply with the current and most updated PC MACT regulations for this Subpart.

§ 63.1355 Recordkeeping requirements.

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

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

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

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

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

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

(d) [Reserved]

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

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

(g)

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

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

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

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

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

**SECTION E. Source Group Restrictions.**

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

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

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

(2) Notification of performance tests, as required by §§63.7 and 63.9(e).

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

(4) Notification, as required by §63.9(g), of the date that the continuous emission monitor performance evaluation required by §63.8(e) is scheduled to begin.

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

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

[64 FR 31925, June 14, 1999, as amended at 78 FR 10053, Feb. 12, 2013]

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

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

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

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

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

(3) As required by §63.10(d)(4), the owner or operator of an affected source who is required to submit progress reports as a condition of receiving an extension of compliance under §63.6(i) shall submit such reports by the dates specified in the written extension of compliance.

(4)-(5) [Reserved]

(6) As required by §63.10(e)(2), the owner or operator shall submit a written report of the results of the performance evaluation for the continuous monitoring system required by §63.8(e). The owner or operator shall submit the report simultaneously with the results of the performance test.

(7) As required by §63.10(e)(2), the owner or operator of an affected source using a continuous opacity monitoring system to determine opacity compliance during any performance test required under §63.7 and described in §63.6(d)(6) shall report the results of the continuous opacity monitoring system performance evaluation conducted under §63.8(e).

(8) As required by §63.10(e)(3), the owner or operator of an affected source equipped with a continuous emission monitor shall submit an excess emissions and continuous monitoring system performance report for any event when the continuous monitoring system data indicate the source is not in compliance with the applicable emission limitation or operating parameter limit.

(9) The owner or operator shall submit a summary report semiannually within 60 days of the reporting period to the EPA via the Compliance and Emissions Data Reporting Interface (CEDRI). (CEDRI can be accessed through the EPA's Central Data Exchange (CDX) (<https://cdx.epa.gov/>). You must use the appropriate electronic report in CEDRI for this subpart.

**SECTION E. Source Group Restrictions.**

Instead of using the electronic report in CEDRI for this subpart, you may submit an alternate electronic file consistent with the extensible markup language (XML) schema listed on the CEDRI website (<https://www.epa.gov/electronic-reporting-air-emissions/compliance-and-emissions-data-reporting-interface-cedri>), once the XML schema is available. If the reporting form specific to this subpart is not available in CEDRI at the time that the report is due, you must submit the report to the Administrator at the appropriate address listed in §63.13. You must begin submitting reports via CEDRI no later than 90 days after the form becomes available in CEDRI. The excess emissions and summary reports must be submitted no later than 60 days after the end of the reporting period, regardless of the method in which the reports are submitted. The report must contain the information specified in §63.10(e)(3)(vi). In addition, the summary report shall include:

- (i) All exceedances of maximum control device inlet gas temperature limits specified in §63.1346(a) and (b);
- (ii) Notification of any failure to calibrate thermocouples and other temperature sensors as required under §63.1350(g)(1)(iii) of this subpart; and
- (iii) Notification of any failure to maintain the activated carbon injection rate, and the activated carbon injection carrier gas flow rate or pressure drop, as applicable, as required under §63.1346(c)(2).
- (iv) Notification of failure to conduct any combustion system component inspections conducted within the reporting period as required under §63.1347(a)(3).
- (v) Any and all failures to comply with any provision of the operation and maintenance plan developed in accordance with §63.1347(a).
- (vi) For each PM CPMS, HCl, Hg, and THC CEMS, SO₂ CEMS, or Hg sorbent trap monitoring system, within 60 days after the reporting periods, you must report all of the calculated 30-operating day rolling average values derived from the CPMS, CEMS, CMS, or Hg sorbent trap monitoring systems.
- (vii) In response to each violation of an emissions standard or established operating parameter limit, the date, duration and description of each violation and the specific actions taken for each violation including inspections, corrective actions and repeat performance tests and the results of those actions.

(10) If the total continuous monitoring system downtime for any CEM or any CMS for the reporting period is 10 percent or greater of the total operating time for the reporting period, the owner or operator shall submit an excess emissions and continuous monitoring system performance report along with the summary report.

(11)(i) You must submit the information specified in paragraphs (b)(11)(i)(A) and (B) of this section no later than 60 days following the initial performance test. All reports must be signed by a responsible official.

(A) The initial performance test data as recorded under §63.1349(a).

(B) The values for the site-specific operating limits or parameters established pursuant to §63.1349(b)(1), (3), (6), (7), and (8), as applicable, and a description, including sample calculations, of how the operating parameters were established during the initial performance test.

(C) As of December 31, 2011, and within 60 days after the date of completing each performance evaluation or test, as defined in §63.2, conducted to demonstrate compliance with any standard covered by this subpart, you must submit the relative accuracy test audit data and performance test data, except opacity data, to the EPA by successfully submitting the data electronically via CEDRI and by using the Electronic Reporting Tool (ERT) (see <https://www.epa.gov/electronic-reporting-air-emissions/electronic-reporting-tool-ert>). For any performance evaluations with no corresponding RATA pollutants listed on the ERT website, you must submit the results of the performance evaluation to the Administrator at the appropriate address listed in §63.13.

(ii) For PM performance test reports used to set a PM CPMS operating limit, the electronic submission of the test report must also include the make and model of the PM CPMS instrument, serial number of the instrument, analytical principle of the instrument (e.g. beta attenuation), span of the instruments primary analytical range, milliamp value equivalent to the instrument zero output, technique by which this zero value was determined, and the average milliamp signals corresponding to each PM compliance test run.

(12) All reports required by this subpart not subject to the requirements in paragraphs (b)(9) introductory text and (b)(11)(i) of this section must be sent to the Administrator at the appropriate address listed in §63.13. The Administrator or the delegated authority may request a report in any form suitable for the specific case (e.g., by commonly used electronic media such as Excel spreadsheet, on CD or hard copy). The Administrator retains the right to require submittal of reports subject to paragraphs (b)(9) introductory text and (b)(11)(i) of this section in paper format.

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

**SECTION E. Source Group Restrictions.**

operator during a malfunction of an affected source to minimize emissions in accordance with §63.1348(d), including actions taken to correct a malfunction.

[64 FR 31925, June 14, 1999, as amended at 75 FR 55063, Sept. 9, 2010; 78 FR 10053, Feb. 12, 2013; 80 FR 44790, July 27, 2015; 83 FR 35135, July 25, 2018]

VI. WORK PRACTICE REQUIREMENTS.

No additional work practice requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

***** Permit Shield in Effect. *****

**SECTION E. Source Group Restrictions.**

Group Name: 9

Group Description: Silos

Sources included in this group

ID	Name
106	BULK SILOS (B-5 D.C.)
107	BULK SILO GROUP (B-9 D.C.)
109	H1/H2 HOMO SILO
112	H3/H4 HOMO SILO
133	B-13 & B-14 BULK SILOS
135	H5/H6 HOMO SILO
139	CLINKER STORAGE BUILDING
152	NOS. 2 & 6 CLINKER SILOS LOADOUT SPOUTS
153	BULK SILO B-11
154	CEMENT/SLAG BLENDER
162	1 FINISH MILL HES
163	CLINKER RECLAIM BELT CONVEYOR SYSTEM
164	PEBBLE LIME SILO
170	STONE SILO 5 & 6 W/ BELT 9

I. RESTRICTIONS.**Emission Restriction(s).****# 001 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

Pursuant to the Best Available Technology (BAT) provisions of 25 PA Code Section 127.12 (a) (5), particulate emissions from the fabric collector for Source ID Nos. 106, 109, 112, 133, 163, and 164 shall not exceed 0.015 grain/dscf.

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

Pursuant to the Best Available Technology (BAT) provisions of 25 PA Code Section 127.12 (a) (5), particulate emissions from the fabric collectors associated with source ID's 107, 135, 139, 152, 153, 154, 162 and 170 shall not exceed 0.02 grain/dscf.

003 [40 CFR Part 60 Standards of Performance for New Stationary Sources §40 CFR 60.62]**Subpart F - Standards of Performance for Portland Cement Plants****Standard for particulate matter.**

Pursuant to the provisions of 40 CFR Section 60.62 (c), the visible air contaminants from the fabric collector(s) shall not be emitted in such a manner that the opacity of the emissions is equal to or greater than 10% at any time.

II. TESTING REQUIREMENTS.

No additional testing requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

III. MONITORING REQUIREMENTS.**# 004 [25 Pa. Code §127.511]****Monitoring and related recordkeeping and reporting requirements.**

The fabric collectors must be equipped with a device for monitoring the pressure differential across the collectors.

IV. RECORDKEEPING REQUIREMENTS.**# 005 [25 Pa. Code §127.511]****Monitoring and related recordkeeping and reporting requirements.**

The permittee shall record pressure differential readings from the collectors on a weekly basis and these records shall be

**SECTION E. Source Group Restrictions.**

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

V. REPORTING REQUIREMENTS.**# 006 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The sources are subject to Subpart F of the Standards of Performance for New Stationary Sources and to Subpart LLL of the National Emission Standards for Hazardous Air Pollutants for Source Categories. The sources shall comply with all applicable requirements of both Subparts. 40 CFR Sections 60.4 and 63.13 require submission of all requests, reports, applications, submittals and other communications to both EPA and the Department. The EPA copies shall be forwarded to:

Office of Air Enforcement and Compliance Assistance (3AP20)
United States Environmental Protection Agency
Region 3
1650 Arch Street
Philadelphia, PA 19103-2029

VI. WORK PRACTICE REQUIREMENTS.**# 007 [25 Pa. Code §127.512]****Operating permit terms and conditions.**

The company shall keep on hand a sufficient quantity of spare fabric collector bags for the fabric collectors associated with the aforementioned sources in order to be able to immediately replace any bags requiring replacement due to deterioration resulting from routine operation of the source(s) and fabric collectors.

VII. ADDITIONAL REQUIREMENTS.

No additional requirements exist except as provided in other sections of this permit including Section B (Title V General Requirements).

***** Permit Shield in Effect. *****

**SECTION F. Alternative Operation Requirements.**

No Alternative Operations exist for this Title V facility.

**SECTION G. Emission Restriction Summary.**

Source Id	Source Description	Emission Limit	Pollutant
037	RANSOME GENERATOR (EAST)	0.400 Lbs/MMBTU	TSP
038	RANSOME GENERATOR (CENTER)	0.400 Lbs/MMBTU	TSP
039	RANSOME GENERATOR (WEST)	0.400 Lbs/MMBTU	TSP
106	BULK SILOS (B-5 D.C.)	0.015 gr/DRY FT3	TSP
107	BULK SILO GROUP (B-9 D.C.)	0.015 gr/DRY FT3	TSP
109	H1/H2 HOMO SILO	0.015 gr/DRY FT3	TSP
112	H3/H4 HOMO SILO	0.015 gr/DRY FT3	TSP
133	B-13 & B-14 BULK SILOS	0.015 gr/DRY FT3	TSP
135	H5/H6 HOMO SILO	0.015 gr/DRY FT3	TSP
139	CLINKER STORAGE BUILDING	0.015 gr/DRY FT3	TSP
146	K-2 FEED SYSTEM	0.020 gr/DRY FT3	PM10

**SECTION G. Emission Restriction Summary.**

Source Id	Source Description	Emission Limit	Pollutant
152	NOS. 2 & 6 CLINKER SILOS LOADOUT SPOUTS	0.015 gr/DRY FT3	TSP
153	BULK SILO B-11	0.015 gr/DRY FT3	TSP
154	CEMENT/SLAG BLENDER	0.015 gr/DRY FT3	TSP
162	1 FINISH MILL HES	0.015 gr/DRY FT3	TSP
163	CLINKER RECLAIM BELT CONVEYOR SYSTEM	0.015 gr/DRY FT3	TSP
164	PEBBLE LIME SILO	0.015 gr/DRY FT3	TSP
170	STONE SILO 5 & 6 W/ BELT 9	0.015 gr/DRY FT3	TSP

Site Emission Restriction Summary

Emission Limit	Pollutant
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**SECTION H. Miscellaneous.**

(a) The Department received the operating permit application for this facility on 07/22/2021. The facility is required to pay an Annual Operating Permit Maintenance Fee in accordance with Pennsylvania Code, Title 25, Chapter 127, Section 127.704(d). The Annual Maintenance Fee is due on or before December 31 of each year for the next calendar year.

(b) This permit is a renewal of Operating Permit ADMINISTRATIVE AMENDMENT TV 39-00011 issued 10/21/2021.

(c) This is a Title V Operating Permit facility.

(d) The following is a list of sources that have been determined by the Department to be of minor significance under 25 Pa. Code, Chapter 127, Section 127.14(a)(8) and are not regulated in this TV Operating Permit. However, this determination does not exempt the sources from compliance with all applicable air quality regulations specified in 25 Pa. Code Chapters 121-143:

ALL RFD'S.

The following RFD's have been approved for this facility:

39-0624: Silo 5 & 6

39-0749: 9A dust collector

39-0640 approved 6/4/2009 use calcium waste in place of limestone

RFD approved 6/4/2009 adding blower on #5&6 bin vents

39-0660 approved 1/28/2010 conveyor system

RFD approved 1000 cfm dust collector

RFD approved 10/17/2008 lime addition to kiln 2

RFD approved 12/19/2008 add dust collectors at silos #5 & #6

RFD approved 1/13/2009 use cellular cement as an alternative raw material

39-0792 approved 12/23/2013 modify kiln feed pipe

39-0807 approved 6/9/2014 test burn plastic fuel

39-0806 approved 5/30/2014 test burn with egg shells

39-0813 approved 7/22/2014 request extension for trial burn of PDF

39-0814 approved 7/29/2014 sheave replacement on dust collector fan

39-0822 approved 12/9/2014 replace stack

39-0838 approved 7/2/2015 utilize damp lime and fines in ARM handling system

39-0846 approved 10/16/2015 approval of all lime-based materials in the ARM

39-0854 approved 2/1/2016 temporary engine

39-0750 approved 1/4/2013 two dust collectors

39-0755 approved 1/30/2013 new lime mud handling system

39-0787 approved 11/5/2013 new material handling system for their Medford material

39-0849 approved 11/25/2015 replace dust collector

39-0851 approved 12/21/2015 change of operation in pumping from raw mill to finish silo

39-0862 approved 8/23/2016 utilize purolite (PDF)

39-0880 approved 7/14/2017 trial burn of alternative fuel - Buffalo Fuels

RFD approved 2/9/2009 modify stage four feed pipe

39-0741 approved 9/14/2012 remove additional oil -contaminated soil

39-0834 approved 5/26/2015 temporary emergency generator

39-0839 approved 7/2/2015 trial burn of carpet backing calcium carbonate

39-0689 approved 12/6/2010 use a mobile screen temporarily

39-0690 approved 12/23/2010 replace burner nozzles on raw mills

RFD approved 9/12/2008 use #6 oil as Raw Mill Dryer fuel

39-0634 approved 4/13/2009 want to use foundry sand in mix

39-0749 approved 1/4/2013 two dust collectors

The following Plan Approvals were incorporated into the TV permit issued 01/30/2017:

39-309-055, 39-309-056, 39-309-057, 39-309-058, 39-309-060, 39-309-061, 39-309-062, 39-309-063, 39-309-064, 39-309-065, 39-309-066, 39-309-067, 39-309-068, 39-309-069, 39-309-071, 39-309-072, 39-309-075, 39-309-077, 39-309-078, 39-309-080, 39-309-074, 39-309-076, 39-309-081, 39-00011A, 39-00011B, 39-00011C, 39-00011D.

A PAL PERMIT #39-309-079 WAS ISSUED 11/01/2017.

**SECTION H. Miscellaneous.**

(1) The emission limitations listed in SECTION H of this permit are provided for informational purposes. The actual emission limits for each source are provided in SECTION D and E of this permit.

(2) The capacities listed in SECTION A and D of this permit are typical operational capacities and are included for informational purposes. The listed capacities are not to be construed as enforceable limits or maximum capacities. All enforceable limits which apply to any source included in this permit are included in the conditions of this permit.

(3) In accordance with 40 CFR 63.1351, the compliance date for an owner or operator (permittee) subject to the National Emissions Standards for Hazardous Air Pollutants from Portland Cement Manufacturing Industry, represented as Subparts A and LLL in this permit, is June 10, 2002. The compliance date for any new construction or reconstruction after March 24, 1998 is June 9, 1999 or immediately upon startup of operations, whichever is sooner.

(4) The definitions, units of measurements, and abbreviations described in 40 CFR 63.2, 63.3, and 63.1341 shall be used to interpret any applicable requirements from 40 CFR Part 63 that are included in this permit.

(5) The compliance date for the MACT standards, once effective, shall not change the current schedule being conducted in SECTION C, Site Level Condition #023.

(6) All references to coal tar are tire derived fuel (TDF).



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