



COMMONWEALTH OF PENNSYLVANIA  
DEPARTMENT OF ENVIRONMENTAL PROTECTION  
AIR QUALITY PROGRAM

**TITLE V/STATE OPERATING PERMIT**

Issue Date: March 11, 2024

Effective Date: March 11, 2024

Expiration Date: March 10, 2029

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: 46-00198**

Federal Tax Id - Plant Code: 36-0815905-1

**Owner Information**

Name: BLOMMER CHOCOLATE CO  
Mailing Address: 1101 BLOMMER DR  
EAST GREENVILLE, PA 18041-2140

**Plant Information**

Plant: BLOMMER CHOCOLATE CO/E GREENVILLE PLT  
Location: 46 Montgomery County 46954 Upper Hanover Township  
SIC Code: 2066 Manufacturing - Chocolate And Cocoa Products

**Responsible Official**

Name: MARK SLUSSER  
Title: OPS MANAGER  
Phone: (215) 679 - 4472 Email: mslusser@blommer.com

**Permit Contact Person**

Name: AARON PRIZER  
Title: EHS MGR  
Phone: (267) 612 - 4483 Email: aprizer@blommer.com

[Signature] \_\_\_\_\_  
JAMES D. REBARCHAK, SOUTHEAST REGION AIR PROGRAM MANAGER



## SECTION A. Table of Contents

### Section A. Facility/Source Identification

Table of Contents  
Site Inventory List

### Section B. General Title V Requirements

- #001 Definitions
- #002 Prohibition of Air Pollution
- #003 Property Rights
- #004 Permit Expiration
- #005 Permit Renewal
- #006 Transfer of Ownership or Operational Control
- #007 Inspection and Entry
- #008 Compliance Requirements
- #009 Need to Halt or Reduce Activity Not a Defense
- #010 Duty to Provide Information
- #011 Reopening and Revising the Title V Permit for Cause
- #012 Reopening a Title V Permit for Cause by EPA
- #013 Operating Permit Application Review by the EPA
- #014 Significant Operating Permit Modifications
- #015 Minor Operating Permit Modifications
- #016 Administrative Operating Permit Amendments
- #017 Severability Clause
- #018 Fee Payment
- #019 Authorization for De Minimis Emission Increases
- #020 Reactivation of Sources
- #021 Circumvention
- #022 Submissions
- #023 Sampling, Testing and Monitoring Procedures
- #024 Recordkeeping Requirements
- #025 Reporting Requirements
- #026 Compliance Certification
- #027 Operational Flexibility
- #028 Risk Management
- #029 Approved Economic Incentives and Emission Trading Programs
- #030 Permit Shield
- #031 Reporting
- #032 Report Format

### Section C. Site Level Title V Requirements

- C-I: Restrictions
- C-II: Testing Requirements
- C-III: Monitoring Requirements
- C-IV: Recordkeeping Requirements
- C-V: Reporting Requirements
- C-VI: Work Practice Standards
- C-VII: Additional Requirements
- C-VIII: Compliance Certification
- C-IX: Compliance Schedule

### Section D. Source Level Title V Requirements

- D-I: Restrictions
- D-II: Testing Requirements
- D-III: Monitoring Requirements
- D-IV: Recordkeeping Requirements
- D-V: Reporting Requirements



## SECTION A. Table of Contents

D-VI: Work Practice Standards  
D-VII: Additional Requirements

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

### Section E. Source Group Restrictions

E-I: Restrictions  
E-II: Testing Requirements  
E-III: Monitoring Requirements  
E-IV: Recordkeeping Requirements  
E-V: Reporting Requirements  
E-VI: Work Practice Standards  
E-VII: Additional Requirements

### Section F. Alternative Operating Scenario(s)

F-I: Restrictions  
F-II: Testing Requirements  
F-III: Monitoring Requirements  
F-IV: Recordkeeping Requirements  
F-V: Reporting Requirements  
F-VI: Work Practice Standards  
F-VII: Additional Requirements

### Section G. Emission Restriction Summary

### Section H. Miscellaneous

**SECTION A. Site Inventory List**

Source ID	Source Name	Capacity/Throughput		Fuel/Material
033	HURST BOILER NO. 1	12.550	MMBTU/HR	
		11,952.000	CF/HR	Natural Gas
034	HURST BOILER NO. 2	12.550	MMBTU/HR	
		11,952.000	CF/HR	Natural Gas
105	LINE 2 ROASTER	N/A		COCOA BEAN NIBS
106	LINE 2 ROASTER BURNER	3.180	MMBTU/HR	
		N/A		COCOA BEAN NIBS
		3,029.000	CF/HR	Natural Gas
107	LINE 2 COOLER	N/A		COCOA BEAN NIBS
108	LINE 2 GRINDER	N/A		COCOA BEAN NIBS
109	LINE 1 ROASTER	4.000	MMBTU/HR	
		3,810.000	CF/HR	Natural Gas
		N/A		COCOA BEANS
110A	LINE 1 FEED HOPPER	N/A		COCOA BEANS
110B	LINE 1 RETENTION CHAMBER	N/A		COCOA BEANS
111	PARTS WASHER	N/A		SOLVENT
113 A	BEAN CLEANING - UPGRADE A	N/A		COCOA BEANS
117A	LINE 2/3 WINNOWER	N/A		COCOA BEANS
118A	LINE 3 GRINDER	N/A		COCOA BEAN NIBS
119	MILL COLLECTOR 1	N/A		COCOA POWDER
120	MILL COLLECTOR 2	N/A		COCOA POWDER
121	MILL COLLECTOR 3	N/A		COCOA POWDER
122	RED CAKE QUAD BIN 1-4	N/A		KIBBLED COCOA
124A	ALKALIZATION PROCESSES	N/A		KIBBLED COCOA
125	LINE 3 ROASTER	5.000	MMBTU/HR	
		N/A		COCOA BEAN NIBS
		4,762.000	CF/HR	Natural Gas
126	LOW FAT SHELL BIN	N/A		COCOA BEAN SHELLS
127	HIGH FAT SHELL BIN	N/A		COCOA BEAN SHELLS
128	SUGAR SILOS (2 TOTAL)	N/A		SUGAR
129	BEAN UNLOADING 1	N/A		COCOA BEANS
130	BEAN UNLOADING 2	N/A		COCOA BEANS
131A	LINE 2/3 MICRONIZER & BUCKET ELEVATOR	2.440	MMBTU/HR	
		N/A		COCOA BEANS
		2,324.000	MMCF/HR	Natural Gas
132A	LINE 1 GRINDER	N/A		COCOA BEAN NIBS
135	LINE 1 WINNOWER	N/A		COCOA BEANS
142	LINE 2 ALKALIZATION MIXER	N/A		COCOA BEAN NIBS
143	LINE 4 MICRONIZER	4.300	MMBTU/HR	
		N/A		COCOA BEAN NIBS
		4,095.000	CF/HR	Natural Gas

**SECTION A. Site Inventory List**

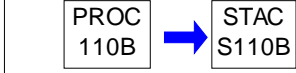
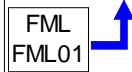
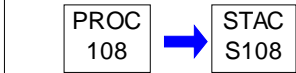
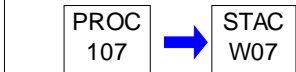
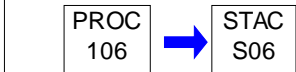
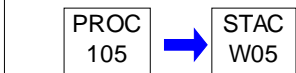
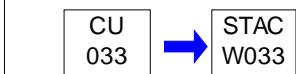
Source ID	Source Name	Capacity/Throughput	Fuel/Material
144	LINE 4 WINNOWER	N/A	COCOA BEANS
145	LINE 4 ROASTER	N/A	COCOA BEAN NIBS
146	LINE 4 ROASTER BURNER	3.970 MMBTU/HR	
		N/A	COCOA BEAN NIBS
		3,781.000 CF/HR	Natural Gas
147	LINE 4 COOLER	N/A	COCOA BEAN NIBS
148	LINE 4 GRINDING	N/A	COCOA BEAN NIBS
150	LINE 2/3 ASPIRATION BOX	N/A	COCOA BEANS
151	LINE 4 ASPIRATION BOX	N/A	COCOA BEANS
152	LINE 2 COLLECTOR	2.000 Lbs/HR	COCOA BEANS
153	LINE 4 COLLECTOR	N/A	COCOA BEANS
154	LINE 4 MATERIAL HANDLING SOURCES	N/A	COCOA BEAN NIBS
155	LINE 1 ASPIRATION CHANNEL	N/A	COCOA BEANS
700	EMERGENCY GENERATOR	5.700 Gal/HR	Diesel Fuel
C001	REGENERATIVE THERMAL OXIDIZER	N/A	Natural Gas
C113	BEAN CLEANING BAGHOUSE 1		
C113-2	BEAN CLEANING BAGHOUSE 2		
C117A	LINE 2/3 WINNOWER BAGHOUSE		
C118	DIFFUSION FILTER SYSTEM		
C119	MILL 1 BAGHOUSE		
C120	MILL 2 BAGHOUSE		
C121	MILL 3 BAGHOUSE		
C122	RED CAKE QUAD BINS 1 - 4 BAGHOUSES (4 TOTAL)		
C126A	LOW FAT SHELL BIN VENT BAG FILTER 1		
C126B	LOW FAT SHELL BIN VENT BAG FILTER 2		
C126C	LOW FAT SHELL BIN VENT BAG FILTER 3		
C127	HIGH FAT SHELL BIN BAGHOUSE		
C128	SUGAR SILO BAG FILTERS (2 TOTAL)		
C129	BEAN UNLOADING AREA 1 BAGHOUSE		
C130	BEAN UNLOADING AREA 2 BAGHOUSE		
C135	LINE 1 WINNOWER BAGHOUSE		
C137A	LINE 2/3 MICRONIZER & BUCKET ELEVATOR BAGHOUSE		
C144A	LINE 4 ASPIRATION BOX AND WINNOWER BAGHOUSE		
C150	LINE 2/3 ASPIRATION BOX BAGHOUSE		
C154	LINE 4 MATERIAL HANDLING DUST COLLECTOR		
C155	LINE 1 ASPIRATION CHANNEL DUST COLLECTOR		
SCR02	ALKALIZATION PROCESSES CONDENSER		
FML01	NATURAL GAS PIPE LINE		
FML03	DIESEL FUEL (EMERGENCY GENERATOR)		
917815	LINE 4 ROASTER BURNER STACK		

**SECTION A. Site Inventory List**

Source ID	Source Name	Capacity/Throughput	Fuel/Material
S001	RTO STACK		
S034	HURST BOILER NO. 2 STACK		
S06	LINE 2 ROASTER BURNER EXHAUST R12		
S09A	LINE 1 ROASTER EXHAUST R2		
S09B	LINE 1 ROASTER EXHAUST R3		
S108	LINE 2 GRINDER STACK		
S110A	LINE 1 FEED HOPPER EXHAUST R1		
S110B	LINE 1 RETENTION CHAMBER STACK		
S113	BEAN CLEANING EXHAUST BC1		
S113-2	BEAN CLEANING EXHAUST BC2		
S117	LINE 2/3 WINNOWER EXHAUST R17		
S118A	LINE 3 GRINDING EXHAUST AA11		
S119	MILL 1 EXHAUST A5		
S120	MILL 2 EXHAUST A4		
S121	MILL 3 EXHAUST A3		
S122	RED CAKE QUAD BINS 1 - 4 EXHAUST A6 - A9		
S125	LINE 3 ROASTER EXHAUST AA27		
S126A	LINE 1 WINNOWER BAGHOUSE EXHAUST R8		
S126B	LOW FAT SHELL BIN EXHAUST 2 BV1		
S126C	LOW FAT SHELL BIN EXHAUST 3 BV2		
S126D	LOW FAT SHELL BIN EXHAUST 4 BV3		
S127	HIGH FAT SHELL BIN STACK		
S128	SUGAR SILO BIN VENT EXHAUST		
S129	BEAN UNLOADING 1 EXHAUST		
S130	BEAN UNLOADING 2 EXHAUST		
S131	LINE 2/3 MICRONIZER EXHAUST R16		
S132	LINE 1 GRINDING EXHAUST		
S137	LINE 2/3 MICRONIZER & BUCKET ELEV STACK		
S142	LINE 2 ALKALIZATION MIXER STACK		
S143	LINE 4 MICRONIZER STACK		
S144A	LINE 4 ASPIRATION BOX AND WINNOWER BAGHOUSE STACK		
S147	LINE 4 COOLER STACK		
S150	LINE 2/3 ASPIRATION BOX BAGHOUSE STACK		
S152	LINE 2 COLLECTOR STACK		
S153	LINE 4 COLLECTOR STACK		
S154	LINE 4 MATERIAL HANDLING DUST COLLECTOR STACK		
S155	LINE 1 ASPIRATION CHANNEL DUST COLLECTOR STACK		
S700	EMERGENCY GENERATOR STACK		
SCR2	ALKALIZATION PROCESSES CONDENSER STACK		

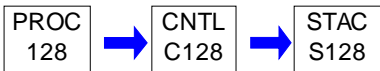
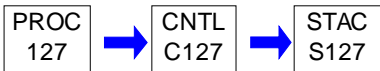
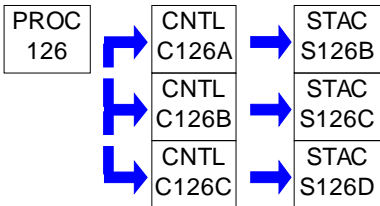
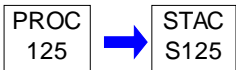
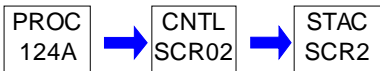
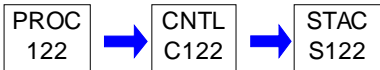
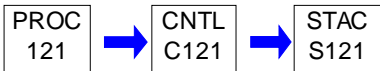
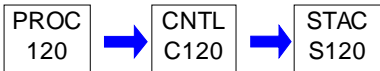
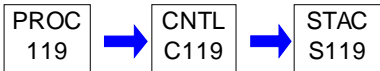
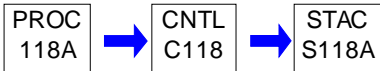
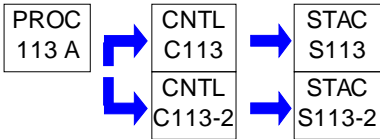
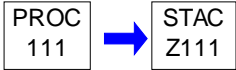
**SECTION A. Site Inventory List**

Source ID	Source Name	Capacity/Throughput	Fuel/Material
W033	HURST BOILER STACK		
W05	LINE 2 TORNADO ROASTER EXHAUST R10		
W07	LINE 2 COOLER EXHAUST R15		
Z111	PARTS WASHER FUGITIVES		

**PERMIT MAPS**



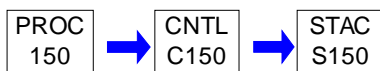
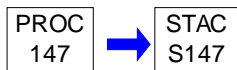
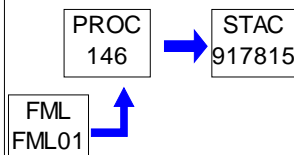
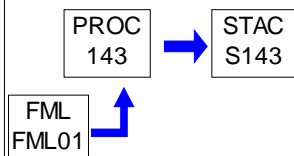
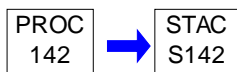
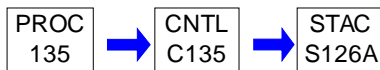
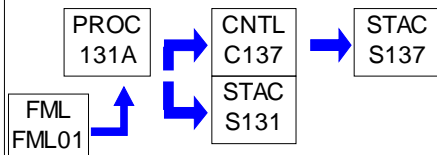
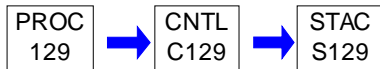
PERMIT MAPS





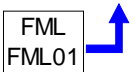
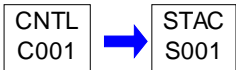
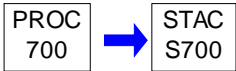
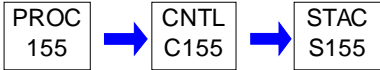
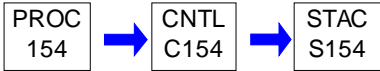
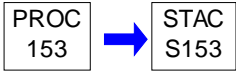
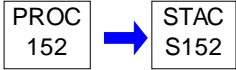
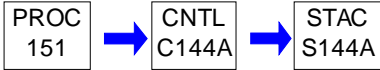


## PERMIT MAPS





## 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<sub>x</sub> from a single source during the term of the permit and 5 tons of NO<sub>x</sub> 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 PM<sub>10</sub> from a single source during the term of the permit and 3.0 tons of PM<sub>10</sub> 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, as specified in 25 Pa. Code § 129.14.
- (7) N/A
- (8) N/A
- (9) Sources and classes of sources other than those identified in (1)-(8) of this condition, for which the permittee 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 25 Pa. Code § 123.1(a) (relating to prohibition of certain fugitive emissions) 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 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:

- (a) Equal to or greater than 20% for a period or periods aggregating more than three minutes in any 1 hour; or
- (b) Equal to or greater than 60% at any time.

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

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

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

**# 006 [25 Pa. Code §129.14]****Open burning operations**

No person may permit the open burning of material in the Southeast Air Basin except where the open burning operations result from:

- (a) 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.

**SECTION C. Site Level Requirements**

- (b) Any fire set for the purpose of instructing personnel in fire fighting, when approved by the Department.
- (c) A fire set for the prevention and control of disease or pests, when approved by the Department.
- (d) A fire set in conjunction with the production of agricultural commodities in their unmanufactured state on the premises of the farm operation.
- (e) A fire set for the purpose of burning domestic refuse, when the fire is on the premises of a structure occupied solely as a dwelling by two families or less and when the refuse results from the normal occupancy of the structure.
- (f) A fire set solely for recreational or ceremonial purposes.
- (g) A fire set solely for cooking food.

**II. TESTING REQUIREMENTS.****# 007 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

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

**# 008 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The Department reserves the right to require exhaust stack testing of any source(s) as necessary to verify emissions for purposes including determining the correct emission fee, whether a malfunction has occurred or determining compliance with any applicable regulation.

**III. MONITORING REQUIREMENTS.****# 009 [25 Pa. Code §123.43]****Measuring techniques**

Visible emissions may be measured using either of the following:

- (a) A device approved by the Department and maintained to provide accurate opacity measurements; or
- (b) Observers trained and qualified to measure plume opacity with the naked eye or with the aid of any devices approved by the Department.

**# 010 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

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

- (a) The permittee shall monitor the facility, once per operating day, for the following:
  - (1) Odors which may be objectionable (as per 25 Pa. Code § 123.31).
  - (2) Visible Emissions (as per 25 Pa. Code §§ 123.41 and 123.42).
  - (3) Fugitive Particulate Matter (as per 25 Pa. Code §§ 123.1 and 123.2).
- (b) Objectionable odors, fugitive particulate emissions, and visible emissions that are caused or may be caused by operations at the site shall:
  - (1) Be investigated;
  - (2) Be reported to the facility management, or individual(s) designated by the permittee;

**SECTION C. Site Level Requirements**

- (3) Have appropriate corrective action taken (for emissions that originate on-site); and
- (4) Be recorded in a permanent written log.

(c) After six (6) months of daily monitoring, and upon the permittee's request, the Department will determine the feasibility of decreasing the monitoring frequency to weekly.

(d) After six (6) months of weekly monitoring, and upon the permittee's request, the Department will determine the feasibility of decreasing the monitoring frequency to monthly.

(e) The Department reserves the right to change the above monitoring requirements at any time, based on but not limited to: the review of the compliance certification, complaints, monitoring results, and/or Department findings.

Please note: Source ID 113A, Bean Cleaning – Upgrade A, is excluded from monitoring frequency reduction options [items (c) and (d), above].

**IV. RECORDKEEPING REQUIREMENTS.****# 011 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall maintain records of all the facility's increases of emissions from the following categories:

- (a) emissions increase of minor significance without notification to the Department.
- (b) de minimis increases with notification to the Department, via letter.
- (c) increases resulting from a Request for Determination (RFD) to the Department.
- (d) increases resulting from the issuance of a plan approval and subsequent operating permit.

**# 012 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall maintain a record of all monitoring of fugitive emissions, visible emissions and odors, including those that deviate from the terms and conditions of this permit. The report of deviations shall contain, at a minimum, the following items:

- (a) Date, time, and location of the incident(s).
- (b) The cause of the incident.
- (c) Any corrective action or preventative action taken.

**V. REPORTING REQUIREMENTS.****# 013 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

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

The permittee shall submit the following:

- (a) An annual certificate of compliance, due by April 1st of each year, for the period covering January 1 through December 31 of the previous year. This certificate of compliance shall document compliance with all permit terms and conditions set forth in this Title V permit as required under condition #26 of section B of this permit. The annual certificate of compliance shall be submitted to DEP electronically, and to EPA Region III in electronic form at the following email address: R3\_APD\_Permits@epa.gov. The subject line shall read: "TVOP No. 46-00198, Facility Name: BLOMMER CHOCOLATE CO/E GREENVILLE PLANT."
- (b) A semi-annual deviation report to DEP, due by October 1 of each year, for the period covering January 1 through June 30 of the same year. Note: The annual certification of compliance fulfills the obligation for the second deviation reporting period (July 1 through December 31 of the previous year).

**SECTION C. Site Level Requirements****# 014 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

- (a) The permittee shall report malfunctions, emergencies or incidents of excess emissions to the Department at 484-250-5920. A malfunction is any sudden, infrequent, and not reasonably preventable failure of air pollution control equipment, process equipment, or a process to operate in a normal or usual manner. An emergency is any situation arising from sudden and reasonably unforeseeable events beyond the control of the owner or operator of a facility which requires immediate corrective action to restore normal operation and which causes the emission source to exceed emissions, due to unavoidable increases in emissions attributable to the situation. An emergency shall not include situations caused by improperly designed equipment, lack of preventive maintenance, careless or improper operation, or operator error.
- (b) When the malfunction, emergency or incident of excess emissions poses an imminent danger to the public health, safety, welfare, or environment, it shall be reported to the Department and the County Emergency Management Agency by telephone within one (1) hour after the discovery of the malfunction, emergency or incident of excess emissions. The owner or operator shall submit a written or emailed report of instances of such malfunctions, emergencies or incidents of excess emissions to the Department within three (3) business days of the telephone report.
- (c) The report shall describe the following:
- (1) Name, permit or authorization number, and location of the facility;
  - (2) Nature and cause of the malfunction, emergency or incident;
  - (3) Date and time when the malfunction, emergency or incident was first observed;
  - (4) Expected duration of excess emissions;
  - (5) Estimated rate of emissions; and
  - (6) Corrective actions or preventative measures taken.
- (d) Any malfunction, emergency or incident of excess emissions that is not subject to the notice requirements of paragraph (b) of this condition shall be reported to the Department by telephone within 24 hours (or by 4:00 PM of the next business day, whichever is later) of discovery and in writing or by e-mail within five (5) business days of discovery. The report shall contain the same information required by paragraph (c), and any permit specific malfunction reporting requirements.
- (e) During an emergency an owner or operator may continue to operate the source at their discretion provided they submit justification for continued operation of a source during the emergency and follow all the notification and reporting requirements in accordance with paragraphs (b)-(d), as applicable, including any permit specific malfunction reporting requirements.
- (f) Reports regarding malfunctions, emergencies or incidents of excess emissions shall be submitted to the appropriate DEP Regional Office Air Program Manager.
- (g) Any emissions resulted from malfunction or emergency are to be reported in the annual emissions inventory report, if the annual emissions inventory report is required by permit or authorization.

**# 015 [25 Pa. Code §135.21]****Emission statements**

The permittee shall submit, by March 1 of each year, an annual emission statement for the preceding calendar year. Additionally, a description of the method used to calculate the emissions shall be included. The statement shall contain a certification by a company official or plant manager that the information contained in the statement is true and accurate.

**VI. WORK PRACTICE REQUIREMENTS.****# 016 [25 Pa. Code §123.1]****Prohibition of certain fugitive emissions**

A person responsible for any source specified 25 Pa. Code § 123.1 shall take all reasonable actions to prevent particulate matter from becoming airborne. These actions shall include, but not be limited to, the following

- (a) Use, where possible, of water or suitable chemicals, for control of dust in the demolition of buildings or structures,



**SECTION C. Site Level Requirements**

construction operations, the grading of roads, or the clearing of land.

(b) Application of asphalt, water, or other suitable chemicals, on dirt roads, material stockpiles and other surfaces which may give rise to airborne dusts.

(c) Paving and maintenance of roadways.

(d) 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 by other means.

**# 017 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code Sections 129.97 and 129.112.]

(a) The permittee shall install, maintain and operate each source and control device in accordance with the manufacturer's specifications and with good operating practices.

(b) The permittee shall maintain and operate all monitoring, sampling, and testing equipment according to manufacturer's specifications.

**# 018 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

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

**# 019 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall comply with the requirements of 40 CFR 82, Subpart F when servicing, maintaining, repairing, and disposing of equipment utilizing or containing Class I or Class II refrigerants.

**# 020 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code § 127.512.]

The permittee may not modify any air contaminant system identified in this permit prior to obtaining Department approval except those modifications authorized by Condition #019(g) of Section B of this permit.

**VII. ADDITIONAL REQUIREMENTS.**

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

**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: 033

Source Name: HURST BOILER NO. 1

Source Capacity/Throughput: 12.550 MMBTU/HR

11,952.000 CF/HR

Natural Gas

Conditions for this source occur in the following groups: RACT II &amp; III B

**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 0.4 pounds per million Btu of heat input, pursuant to 25 Pa. Code § 123.11(a)(1).

**# 002 [25 Pa. Code §123.22]****Combustion units**

No person may permit the emission into the outdoor atmosphere of sulfur oxides, expressed as SO<sub>2</sub>, from any combustion unit, in the Southeast Air Basin, in excess of 1.2 pounds per million Btu of heat input, pursuant to 25 Pa. Code § 123.22(e)(1).

**# 003 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a). The permittee shall limit the emissions of nitrogen oxides (NO<sub>x</sub>) from this source to or below 30 ppm<sub>dv</sub> at 3 percent oxygen.

(b). The permittee shall limit the emissions of carbon monoxide (CO) from this source to at or below 300 ppm<sub>dv</sub> at 3 percent oxygen.

[Compliance with the above permitted condition has been determined by the Department to meet the requirements for Best Available Technology (BAT) for small boilers.]

**Fuel Restriction(s).****# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The owner or operator shall use only natural gas as fuel for this source.

**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.****# 005 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall monitor the following for this source when this source is in operation:

**SECTION D. Source Level Requirements**

- (a). The type of fuel that is consumed by the source on at least a daily basis.
- (b). The amount of fuel that is consumed by the source on at least a quarterly basis as per the letter from the U.S. EPA dated January 6, 2006.
- (c). The hours of operation on at least a monthly basis.

**IV. RECORDKEEPING REQUIREMENTS.****# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

- (a). The permittee shall keep records of the following for this source when this source is in operation:
  - (1). The type of fuel that is consumed by the source on at least a daily basis.
  - (2). The amount of fuel that is consumed by the source on at least a quarterly basis as per the letter from the U.S. EPA dated January 6, 2006.
  - (3). The hours of operation on at least a monthly basis.
- (b). The owner or operator shall calculate and record the amount of particulate matter, sulfur dioxide, nitrogen oxides, carbon monoxide, and volatile organic compound emissions from this source on a monthly basis.
- (c). The owner or operator shall calculate and record the total amount of fuel used, the total hours of operation, and the total amount of each pollutant emitted from this source on a 12-month rolling sum basis.

[Compliance with this condition assures compliance with 40 CFR Part 60 Subpart Dc.]

**# 007 [40 CFR Part 60 Standards of Performance for New Stationary Sources §40 CFR 60.48c]****Subpart Dc - Standards of Performance for Small Industrial- Commercial-Institutional Steam Generating Units Reporting and recordkeeping requirements.**

For this source, the permittee shall

- (a). submit notification for construction or reconstruction and actual startup, as provided by §60.7 of this part and specified in 40 CFR §60.48c(a);
- (b). keep records of fuel certification and fuel consumption; and
- (c). submit fuel certified statement (reports).

The reporting period for the reports required under this subpart is each six-month period. All reports shall be submitted to the Administrator and shall be postmarked by the 30th day following the end of the reporting period.

**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.****# 008 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall install and maintain the necessary meter(s) to determine and to record the amount of fuel used.

**VII. ADDITIONAL REQUIREMENTS.****# 009 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

This source is a natural gas-fired Hurst boiler, Model No. S5-300-200-G, installed in 2005.



**SECTION D. Source Level Requirements**

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

**SECTION D. Source Level Requirements**

Source ID: 034

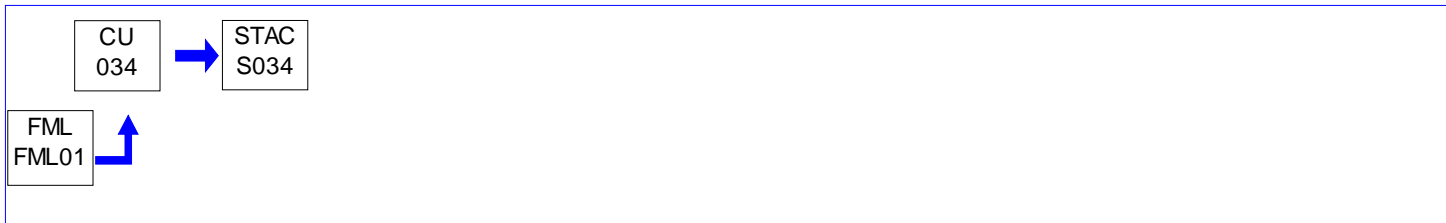
Source Name: HURST BOILER NO. 2

Source Capacity/Throughput: 12.550 MMBTU/HR

11,952.000 CF/HR

Natural Gas

Conditions for this source occur in the following groups: RACT II &amp; III B

**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 0.4 pounds per million Btu of heat input, pursuant to 25 Pa. Code § 123.11(a)(1).

**# 002 [25 Pa. Code §123.22]****Combustion units**

No person may permit the emission into the outdoor atmosphere of sulfur oxides, expressed as SO<sub>2</sub>, from any combustion unit, in the Southeast Air Basin, in excess of 1.2 pounds per million Btu of heat input, pursuant to 25 Pa. Code § 123.22(e)(1).

**# 003 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a). The permittee shall limit the emissions of nitrogen oxides (NO<sub>x</sub>) from this source to or below 30 ppm<sub>dv</sub> at 3 percent oxygen.

(b). The permittee shall limit the emissions of carbon monoxide (CO) from this source to at or below 300 ppm<sub>dv</sub> at 3 percent oxygen.

[Compliance with the above permitted condition has been determined by the Department to meet the requirements for Best Available Technology (BAT) for small boilers.]

**Fuel Restriction(s).****# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The owner or operator shall use only natural gas as the fuel for this source.

**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.****# 005 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall monitor the following for this source when this source is in operation:

**SECTION D. Source Level Requirements**

- (a). The type of fuel that is consumed by the source on at least a daily basis.
- (b). The amount of fuel that is consumed by the source on at least a quarterly basis as per the letter from the U.S. EPA dated January 6, 2006.
- (c). The hours of operation on at least a monthly basis.

**IV. RECORDKEEPING REQUIREMENTS.****# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

- (a). The permittee shall keep records of the following for this source when this source is in operation:
  - (1). The type of fuel that is consumed by the source on at least a daily basis.
  - (2). The amount of fuel that is consumed by the source on at least a quarterly basis as per the letter from the U.S. EPA dated January 6, 2006. The permittee shall keep the U.S. EPA letter on file to demonstrate that the quarterly recordkeeping maintains compliance for this boiler.
  - (3). The hours of operation on at least a monthly basis.
- (b). The owner or operator shall calculate and record the amount of particulate matter, sulfur dioxide, nitrogen oxides, carbon monoxide, and volatile organic compound emissions from this source on a monthly basis.
- (c). The owner or operator shall calculate and record the total amount of fuel used, the total hours of operation, and the total amount of each pollutant emitted from this source on a 12-month rolling sum basis.

[Compliance with this condition assures compliance with 40 CFR Part 60 Subpart Dc.]

**# 007 [40 CFR Part 60 Standards of Performance for New Stationary Sources §40 CFR 60.48c]****Subpart Dc - Standards of Performance for Small Industrial- Commercial-Institutional Steam Generating Units Reporting and recordkeeping requirements.**

For this source, the permittee shall

- (a). submit notification for construction or reconstruction and actual startup, as provided by §60.7 of this part and specified in 40 CFR §60.48c(a);
- (b). keep records of fuel certification and fuel consumption; and
- (c). submit fuel certified statement (reports).

The reporting period for the reports required under this subpart is each six-month period. All reports shall be submitted to the Administrator and shall be postmarked by the 30th day following the end of the reporting period.

**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.****# 008 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall install and maintain the necessary meter(s) to determine and to record the amount of fuel used.

**VII. ADDITIONAL REQUIREMENTS.****# 009 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

This source is a natural gas-fired Hurst boiler, Model No. S5-300-200-G, installed in 2007.



**SECTION D. Source Level Requirements**

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

**SECTION D. Source Level Requirements**

Source ID: 105

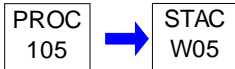
Source Name: LINE 2 ROASTER

Source Capacity/Throughput:

N/A

COCOA BEAN NIBS

Conditions for this source occur in the following groups: RACT II &amp; III A

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

No person may permit the emission into the outdoor atmosphere of particulate matter from this source at any time, in excess of 0.04 grains per dry standard cubic foot, pursuant to 25 Pa. Code Section 123.13(c)(1)(i).

**# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.99(c) and 129.114(c).]

The owner or operator shall limit the emissions of VOC from this source to less than 10.41 tons per year on a 12-month rolling sum 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) and/or Section E (Source Group Restrictions).

**III. MONITORING REQUIREMENTS.****# 003 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall monitor the amount of cocoa nibs processed through the Line 2 Roaster on a monthly basis.

**IV. RECORDKEEPING REQUIREMENTS.****# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§129.100(d) and 129.115(f).]

(a). The permittee shall keep records of the amount of cocoa nibs processed through the Line 2 Roaster on a monthly basis, and the permittee shall calculate and record the amount of volatile organic compounds (VOC) emitted from the Line 2 Roaster on a monthly basis.

(b). The permittee shall calculate and record the total amount of VOCs emitted from the Line 2 Roaster on a 12-month rolling sum basis.

**# 005 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.100(i) and 129.115(k).]



**SECTION D. Source Level Requirements**

The permittee shall keep records of the data collected for this source on file for a period of five (5) years, and these files 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) 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: 106

Source Name: LINE 2 ROASTER BURNER

Source Capacity/Throughput: 3.180 MMBTU/HR

N/A

COCOA BEAN NIBS

3,029.000 CF/HR

Natural Gas

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

No person may permit the emission into the outdoor atmosphere of particulate matter from this source at any time, in excess of 0.04 grains per dry standard cubic foot, pursuant to 25 Pa. Code Section 123.13(c)(1)(i).

**# 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 SO<sub>2</sub>, in the effluent gas exceeds 500 parts per million, by volume, dry basis, pursuant to 25 Pa. Code Section 123.21(b).

**# 003 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The owner or operator shall limit the emissions of VOC from this source to less than 0.09 tons per year for any consecutive 12-month rolling sum period.

**Fuel Restriction(s).****# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The owner or operator shall use only natural gas as the fuel for this source.

**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.****# 005 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall monitor the following on a monthly basis:

- The type of fuel used.
- The amount of fuel used.
- The hours of operation.

**SECTION D. Source Level Requirements****IV. RECORDKEEPING REQUIREMENTS.****# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a). The permittee shall keep records of the following on a monthly basis:

- (1). The type of fuel used.
- (2). The amount of fuel used.
- (3). The hours of operation.

(b). The owner or operator shall calculate and record the amount of particulate matter, sulfur dioxide, nitrogen oxides, carbon monoxide, and volatile organic compound emissions from this source on a monthly basis.

(c). The owner or operator shall calculate and record the total amount of fuel used, the total hours of operation, and the total amount of each pollutant emitted from this source on a 12-month rolling sum basis.

**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: 107

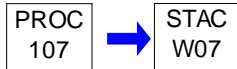
Source Name: LINE 2 COOLER

Source Capacity/Throughput:

N/A

COCOA BEAN NIBS

Conditions for this source occur in the following groups: RACT II &amp; III B

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

# 001 [25 Pa. Code §123.13]

**Processes**

No person may permit the emission into the outdoor atmosphere of particulate matter from this source at any time, in excess of 0.04 grains per dry standard cubic foot, pursuant to 25 Pa. Code Section 123.13(c)(1)(i).

# 002 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The owner or operator shall limit the emissions of VOC from this source to less than 1.91 tons per year on a 12-month rolling sum 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) and/or Section E (Source Group Restrictions).

**III. MONITORING REQUIREMENTS.**

# 003 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The permittee shall monitor the amount of cocoa nibs processed through the Line 2 Cooler on a monthly basis.

**IV. RECORDKEEPING REQUIREMENTS.**

# 004 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

(a). The permittee shall keep records of the amount of cocoa nibs processed through the Line 2 Cooler on a monthly basis, and the permittee shall calculate and record the amount of volatile organic compounds (VOC) emitted from the Line 2 Cooler on a monthly basis.

(b). The permittee shall calculate and record the total amount of VOCs emitted from the Line 2 Cooler on a 12-month rolling basis.

**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: 108

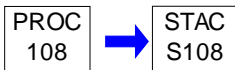
Source Name: LINE 2 GRINDER

Source Capacity/Throughput:

N/A

COCOA BEAN NIBS

Conditions for this source occur in the following groups: GRINDERS  
 RACT II & III A

**I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.99(c) and 129.114(c).]

The owner or operator shall limit the combined emissions of VOC from the Line 2 Grinder to less than 4.68 tons per year on a 12-month rolling sum 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) and/or Section E (Source Group Restrictions).

**III. MONITORING REQUIREMENTS.****# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall monitor the amount of nibs processed through Line 2 Grinder on a monthly basis.

**IV. RECORDKEEPING REQUIREMENTS.****# 003 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.100(d) and 129.115(f).]

(a). The permittee shall keep records of the amount of nibs processed through the Line 2 Grinder on a monthly basis, and the permittee shall calculate and record the amount of volatile organic compounds (VOC) emitted from Line 2 Grinder.

(b). The permittee shall calculate the total amount of VOCs emitted from Line 2 Grinder on a 12-month rolling sum basis.

**# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.100(i) and 129.115(k).]

The permittee shall keep records of the data collected for this source on file for a period of five (5) years, and these files shall be 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.

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: 109

Source Name: LINE 1 ROASTER

Source Capacity/Throughput: 4.000 MMBTU/HR

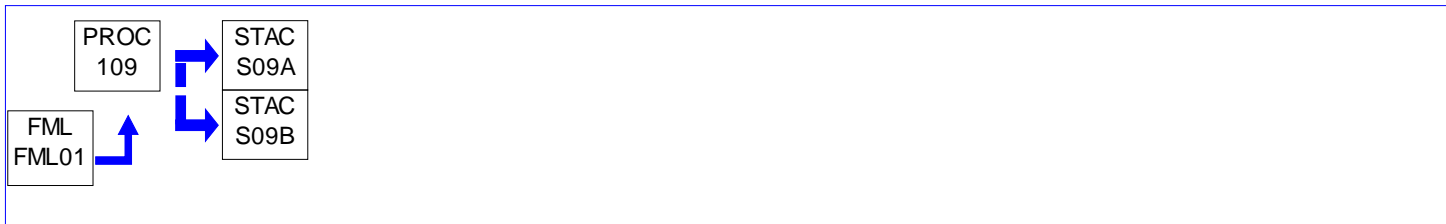
3,810.000 CF/HR

Natural Gas

N/A

COCOA BEANS

Conditions for this source occur in the following groups: RACT II & III A  
ROASTERS

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

# 001 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The owner or operator shall use only natural gas as the fuel for this source.

**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.**

# 002 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The permittee shall monitor the amount of cocoa beans processed through the Line 1 Roaster on a monthly basis.

**IV. RECORDKEEPING REQUIREMENTS.**

# 003 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.100(d) and 129.115(f).]

(1) The permittee shall keep records of the amount of cocoa beans processed through the Line 1 Roaster on a monthly basis, and the permittee shall calculate and record the amount of volatile organic compounds (VOC) emitted on a monthly basis.

(2) The permittee shall calculate and record the total amount of VOCs emitted from the Line 1 Roaster on a 12-month rolling sum basis.

# 004 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.100(i) and 129.115(k).]

The permittee shall keep records of the data collected for this source on file for a period of five (5) years, and these files shall be 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.

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: 110A

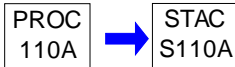
Source Name: LINE 1 FEED HOPPER

Source Capacity/Throughput:

N/A

COCOA BEANS

Conditions for this source occur in the following groups: RACT II &amp; III B

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

# 001 [25 Pa. Code §123.13]

**Processes**

No person may permit the emission into the outdoor atmosphere of particulate matter from this source at any time, in excess of 0.04 grains per dry standard cubic foot, pursuant to 25 Pa. Code Section 123.13(c)(1)(i).

**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.**

# 002 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The permittee shall monitor the amount of cocoa beans processed through the Line 1 Feed Hopper and the Line 1 Retention Chamber on a monthly basis.

**IV. RECORDKEEPING REQUIREMENTS.**

# 003 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

(a). The permittee shall keep records of the amount of cocoa beans processed through the Line 1 Feed Hopper and the Line 1 Retention Chamber on a monthly basis, and the permittee shall calculate and record the amount of volatile organic compounds emitted from the Line 1 Feed Hopper and the Line 1 Retention Chamber on a monthly basis.

(b). The permittee shall calculate and record the total amount of VOCs emitted from the Line 1 Feed Hopper and the Line 1 Retention Chamber on a 12-month rolling sum basis.

**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: 110B

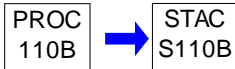
Source Name: LINE 1 RETENTION CHAMBER

Source Capacity/Throughput:

N/A

COCOA BEANS

Conditions for this source occur in the following groups: RACT II &amp; III B

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

# 001 [25 Pa. Code §123.13]

**Processes**

No person may permit the emission into the outdoor atmosphere of particulate matter from this source at any time, in excess of 0.04 grains per dry standard cubic foot, pursuant to 25 Pa. Code Section 123.13(c)(1)(i).

**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.**

# 002 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The permittee shall monitor the amount of cocoa beans processed through the Line 1 Feed Hopper and Line 1 Retention Chamber on a monthly basis.

**IV. RECORDKEEPING REQUIREMENTS.**

# 003 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

(a). The permittee shall keep records of the amount of cocoa beans processed through the Line 1 Feed Hopper and Line 1 Retention Chamber on a monthly basis, and the permittee shall calculate and record the amount of volatile organic compounds emitted from the Line 1 Feed Hopper and Line 1 Retention Chamber on a monthly basis.

(b). The permittee shall calculate and record the total amount of VOCs emitted from the Line 1 Feed Hopper and Line 1 Retention Chamber on a 12-month rolling sum basis.

**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**

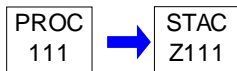
Source ID: 111

Source Name: PARTS WASHER

Source Capacity/Throughput:

N/A

SOLVENT

**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.****# 001 [25 Pa. Code §129.63]****Degreasing operations**

(a). A person who sells or offers for sale any solvent containing VOCs for use in a cold cleaning machine shall provide, to the purchaser, the following written information:

- (1). The name and address of the solvent supplier.
- (2). The type of solvent including the product or vendor identification number.
- (3). The vapor pressure of the solvent measured in mm Hg at 20 degrees C (68 degrees F).

(b). The permittee shall maintain for at least two (2) years and shall provide to the Department, on request, the information specified in paragraph (a) above. An invoice, bill of sale, certificate that corresponds to the number of sales, Safety Data Sheet (SDS), or other appropriate documentation acceptable to the Department may be used to comply with this section.

**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 §129.63]****Degreasing operations**

(a). Cold cleaning machines shall be operated in accordance with the following procedures:

- (1). Waste solvent shall be collected and stored in closed containers. The closed containers may contain a device that allows pressure relief, but does not allow liquid solvent to drain from the container.
- (2). Flushing of parts using a flexible hose or other flushing device shall be performed only within the cold cleaning

**SECTION D. Source Level Requirements**

machine. The solvent spray shall be a solid fluid stream, not a atomized or shower spray.

(3). Sponges, fabric, wood, leather, paper products and other absorbent material may not be cleaned in the cold cleaning machine.

(4). Air agitated solvent baths may not be used.

(5). Spills during solvent transfer and use of the cold cleaning machine shall be cleaned up immediately.

(b). Immersion cold cleaning machines shall:

(1). Have a permanent conspicuous label summarizing the operating procedures in paragraphs (a)(1) - (a)(5) listed above. In addition, the label shall include the following discretionary good operating practices:

(i). Cleaned parts should be drained for at least 15 seconds or until dripping ceases, whichever is longer. Parts having cavities or blind holes shall be tipped or rotated while the part is draining. During the draining tipping, or rotating, the parts should be positioned so that the solvent drains directly back into the cold cleaning machine.

(ii). When a pump-agitated solvent bath is used, the agitator should be operated to produce a rolling motion of the solvent with no observable splashing of the solvent against the tank walls or the parts being cleaned.

(iii). Work area fans should be located and positioned so that they do not blow across the opening of the degreaser unit.

(2). Be equipped with a cover that shall be closed at all times except during cleaning of parts or the addition or removal of solvent.

**# 003 [25 Pa. Code §129.63]****Degreasing operations**

(a). The permittee shall not use, sell, or offer for sale for use in a cold cleaning machine any solvent with a vapor pressure of 1.0 millimeter of mercury (mm Hg) or greater and containing greater than 5 % VOC by weight, measured at 20 degrees C (68 degrees F) containing VOCs.

(b). Paragraph (a) does not apply:

(1). To cold cleaning machines used in extreme cleaning service.

(2). If the owner or operator of the cold cleaning machine demonstrates, and the Department approves in writing, that compliance with paragraph (a) will result in unsafe operating conditions.

(3). To immersion cold cleaning machines with a freeboard ratio equal to or greater than 0.75.

**# 004 [25 Pa. Code §129.63]****Degreasing operations**

The immersion cold cleaning machine shall have a freeboard ratio of 0.50 or greater.

**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**

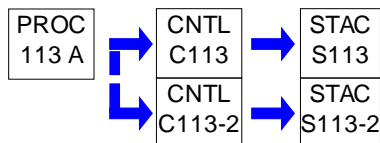
Source ID: 113 A

Source Name: BEAN CLEANING - UPGRADE A

Source Capacity/Throughput:

N/A

COCOA BEANS

**I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §123.41]****Limitations**

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

- (1). Equal to or greater than 20% for a period or periods aggregating more than 3 minutes in any 1 hour.
- (2). Equal to or greater than 60% at any time.

**# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The allowable filterable particulate matter emissions from each baghouse associated with this source shall not exceed 0.02 grains per dry standard cubic foot.

[Compliance with the above streamlined condition also demonstrates compliance with the applicable requirements of 25 Pa. Code § 123.13(c)(1)(i).]

**Control Device Efficiency Restriction(s).****# 003 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

- (a). Exhaust from the Bean Cleaning process (Source ID 113A) shall be treated for PM removal in the following baghouses:
- (1). Source ID 113 - Bean Cleaning Baghouse 1, or
  - (2). Source ID 113-2 – Bean Cleaning Baghouse 2

- (b). The permittee shall maintain the pressure drop across the baghouses associated with this source within the following ranges:

- (1). Source ID C113 – Bean Cleaning Baghouse 1: 0.5 to 5.0 inches of water gauge
- (2). Source ID C113-2 – Bean Cleaning Baghouse 2: 0.3 to 5.0 inches of water gauge

**II. TESTING REQUIREMENTS.****# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

- (a). The permittee shall perform a stack test using the Department-approved procedures once every five (5) calendar years, where five calendar years is defined as beginning with the calendar year the latest stack test was performed and ending on December 31, five years later. Performance tests shall be conducted while the source is operating at normal operating conditions or under such other conditions, within the capacity of the equipment, as may be requested by the Department. When testing of a source is required on a recurring basis, a single procedural protocol may be submitted for approval; thereafter, a letter referencing the previously approved procedural protocol is sufficient. However, if modifications are made to the process(es), if a different stack testing company is used, or if an applicable section of the stack testing manual has been revised since approval, a new protocol must be submitted for approval.



**SECTION D. Source Level Requirements**

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

(c). The stack test shall be conducted at the stack outlets for Source IDs C113 and C113-2, at a minimum, tested for

- Opacity
- Particulate matter (filterable PM)

Tests shall be conducted in accordance with the provisions of applicable EPA Methods 5, 9 and/or 201, or other Department approved methodology and 25 Pa. Code Chapter 139.

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

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

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

(g). Reporting for Stack testing

(1). The permittee shall email all source test submissions (notifications, protocols, reports, supplemental information, etc.) to both the AQ Program Manager for the Southeast Regional Office and the PSIMS Administrator in Central Office.

Southeast Region  
RA-EPSEstacktesting@pa.gov

PSIMS Administrator  
RA-EPstacktesting@pa.gov

Any questions or concerns about source testing submissions can be sent to the PSIMS Administrator (RA-EPstacktesting@pa.gov).

(2). The following pertinent information shall be listed on the title page of source test submissions.

1. Test Date(s)

- a. For protocols, provide the proposed date on which testing will commence or "TBD"
- b. For reports, provide the first and last day of testing

2. Facility Identification Number (Facility - ID): For test programs that were conducted under a multi-site protocol, also include the PF ID under which the protocol was stored in PSIMS, as indicated in the protocol response letter.

3. Source ID(s) for the applicable source(s) and air pollution control device(s): The term Source ID is used in the permit but "Other Id" is used in the Department electronic systems. They are the same number and must also be listed for control equipment.

4. Operating permit number.

**III. MONITORING REQUIREMENTS.**

**# 005 [25 Pa. Code §127.441]**

**Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 40 C.F.R. § 64.6.]

**SECTION D. Source Level Requirements**

Visible emissions may be measured using any of the following:

- (a). A device approved by the Department and maintained to provide accurate opacity measurements; or
- (b). Observers trained and qualified to measure plume opacity with the naked eye or with the aid of any devices approved by the Department.
- (c). Observers shall be familiar with the procedures of U.S. EPA Reference Method 22 – Visual Determination of Fugitive Emissions from Material Sources and Smoke Emissions from Flares.

**# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

For this source, the permittee shall monitor the process production and the usage of raw materials, on a monthly basis.

**# 007 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 40 C.F.R. §§ 64.3 and 64.6.]

- (a). When Source ID 113A is in operation, the permittee shall monitor the following daily:
  - (1). the static pressure drop reading across Bean Cleaning Baghouse 1 (Source ID C113), and
  - (2). the static pressure drop reading across Bean Cleaning Baghouse 2 (Source ID C113-2).
- (b). When Source ID 113A is in operation, the permittee shall monitor visible emissions for Source IDs C113 and C113-2 at least one minute on a daily basis (once per calendar day), using U.S. EPA Reference Method 22 procedures, as specified in Condition #005(c) under this source.
- (c). If visible emissions are observed during daily monitoring, the permittee shall conduct opacity emission observation for both Source IDs 113 and 113-2 for an hour to demonstrate compliance with 25 Pa. Code Section 123.41.

**IV. RECORDKEEPING REQUIREMENTS.****# 008 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 40 C.F.R. § 64.9.]

The permittee shall maintain records of all inspections, repair, replacement, and maintenance performed on the baghouses and the monitoring equipment of the baghouses (Source IDs C113 and C113-2), including:

- (1). date of inspection and inspection results,
- (2). the repairs made to the baghouse(s) and associated equipment (such as air compressor), and
- (3). the items replaced in the baghouse(s).

**# 009 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 40 C.F.R. § 64.9.]

For Source IDs C113 and C113-2, the permittee shall maintain records of the following information for each excursion, exceedance and monitoring downtime incident:

- (a). The date, time, and duration of the excursion(s)/exceedance(s)/incident(s).
- (b). The probable cause(s).
- (c). The corrective action(s) taken.

Notes:

**SECTION D. Source Level Requirements**

1. Excursion is when the pressure drop readings are out of the permitted range (as specified in Condition #003) and visible emissions are in compliance with the limits as specified in Condition #001, under this source.

2. Exceedance is when visible emissions are out of compliance with the limits as specified in Condition #001, under this source.

**# 010 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

For this source, the permittee shall maintain records of the process production and the usage of raw materials, on a monthly basis.

**# 011 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 40 C.F.R. § 64.9.]

(a). When Source ID 113A is in operation, the permittee shall record the following daily:

- (1). the static pressure drop reading across Bean Cleaning Baghouse 1 (Source ID C113), and
- (2). the static pressure drop reading across Bean Cleaning Baghouse 2 (Source ID C113-2).

(b). When Source ID 113A is in operation, the permittee shall maintain daily emissions records for Source IDs C113 and C113-2 as specified in Condition #007(b) and (c) under this source, including:

- (1). date and time of each observation,
- (2). source names and Source IDs, and
- (3). results of each observation.

**V. REPORTING REQUIREMENTS.****# 012 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 40 C.F.R. §§ 64.9 and 70.6(a)(3)(iii)(A).]

For Source IDs C113 and C113-2, the permittee shall report the following information for each excursion, exceedance, and monitoring downtime incident (other than downtime associated with zero and span or other daily calibration checks, if applicable), on a semi-annual basis:

- (a). The date, time, and duration of the excursion(s)/exceedance(s)/incident(s).
- (b). The probable cause(s).
- (c). The corrective action(s) taken.

Semi-annual reports shall be submitted to both DEP and EPA and are due:

- by October 1, of each year, for the period covering January 1 through June 30 of the same year;
- by April 1, of next year, for the period covering July 1 through December 30 of the last year.

**VI. WORK PRACTICE REQUIREMENTS.****# 013 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 40 C.F.R. §§ 64.3 and 64.6.]

For the baghouses (Source IDs C113 and C113-2), the permittee shall

- (a). ensure that the baghouses are in good operating condition at all times while operating Bean Cleaning - Upgrade A (Source ID 113A);
- (b). maintain all monitoring equipment and stock spare parts/bags as necessary for routine on-site repairs; and

**SECTION D. Source Level Requirements**

(c). ensure that the monitoring data has been properly and accurately collected and recorded.

**# 014 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 40 C.F.R. §§ 64.3 and 64.6.]

The permittee shall utilize approved QA/QC practices that are adequate to ensure the continuing validity of data and proper performance of the baghouses associated with this source.

(a). The permittee shall operate and maintain detectors or sensors at a location approved by the Department for obtaining data that is representative of the monitored indicator (visible emissions), or have trained/qualified staff to monitor the indicator.

(b). The permittee shall develop verification procedures to confirm that the operational status of the monitoring devices is within the expected range, or document staff training/qualification records.

(c). The permittee shall calibrate and check the accuracy of the monitoring equipment, according to the manufacturer's recommended procedures, or have staff taking refresh classes according to EPA test method's requirements.

**# 015 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 40 C.F.R. § 64.7.]

Upon detecting an excursion or exceedance, the permittee shall restore operation of this source, including the control devices, to its normal or usual manner of operation as expeditiously as practicable in accordance with good air pollution control practices for minimizing emissions. The response shall include minimizing the period of any startup, shutdown or malfunction and taking any necessary corrective actions to restore normal operation and prevent the likely recurrence of the cause of an excursion or exceedance. Such actions may include inspection and evaluation.

**VII. ADDITIONAL REQUIREMENTS.****# 016 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 40 C.F.R. § 64.8.]

(a). The permittee shall develop and implement a Quality Improvement Plan (QIP) as expeditiously as practicable if any of the following occur:

(1) Six excursions occur in a 6-month reporting period.

(2) The Department determines after review of all reported information that the permittee has not responded acceptably to an excursion.

(b). The QIP plan should be developed within 60 days and the permittee shall provide a copy of the QIP to the Department. Furthermore, the permittee shall notify the Department if the period for completing the improvements contained in the QIP exceeds 180 days from the date on which the need to implement the QIP was determined.

(c). The permittee shall maintain records of any written quality improvement plan, actions taken to implement a QIP during a reporting period, as well as all related actions, including, but not limited to: inspections, repairs, and maintenance performed on the monitoring equipment of the Baghouses (Source IDs C113 and C113-2).

(d). The QIP shall include procedures for evaluating performance problems for the baghouses. Based on the results of the evaluation procedures, the permittee shall modify the QIP and provide the Department with a copy, to include procedures for conducting more frequent, or improved, monitoring in conjunction with one or more of the following:

**SECTION D. Source Level Requirements**

- (1) Improved preventive maintenance practices.
- (2) Process operation changes.
- (3) Appropriate improvements to the control methods.
- (4) Other steps appropriate to correct performance.

(e). Following implementation of a QIP, the Department will require reasonable revisions to the QIP if it has failed to perform either of the following:

- (1) Address the cause of performance problems for the baghouses.
- (2) Provide adequate procedures for correcting performance problems for the baghouses as expeditiously as practicable, in accordance with good air pollution control practices for minimizing emissions.

(f). Implementation of a QIP shall not excuse the permittee from compliance with any existing emission limitation or standard or any existing monitoring, testing, reporting, or recordkeeping requirements that may apply under any federal, state, or local laws or any other applicable requirements under the Clean Air Act.

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

**SECTION D. Source Level Requirements**

Source ID: 117A

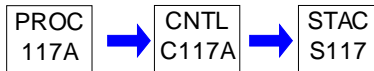
Source Name: LINE 2/3 WINNOWER

Source Capacity/Throughput:

N/A

COCOA BEANS

Conditions for this source occur in the following groups: WINNOWERS

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

# 001 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

(a). The permittee shall limit the annual volatile organic compound (VOC) emissions to the maximum rate of 0.87 tons per year on a 12-month rolling sum basis.

(b). Particulate matter emissions shall not exceed 0.02 grains per dry standard cubic feet from the Line 2/3 Winnower.

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

# 002 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The permittee shall maintain the pressure drop across this baghouse between 0.1 inches of water gauge and 5 inches of water gauge.

**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.**

# 003 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The permittee shall monitor the amount of cocoa beans processed through the Line 2/3 Winnower on a monthly basis.

**IV. RECORDKEEPING REQUIREMENTS.**

# 004 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

(a). The permittee shall keep records of the amount of cocoa beans processed through the Line 2/3 Winnower on a monthly basis, and the permittee shall calculate and record the amount of volatile organic compounds (VOC) emitted from the Line 2/3 Winnower on a monthly basis.

(b). The permittee shall calculate and record the total amount of VOCs emitted from the Line 2/3 Winnower on a 12-month rolling sum basis.

**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.****# 005 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a). The storage and handling of the material collected in the Line 2/3 Winnower Baghouse 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.

(b). The company shall keep on hand a sufficient quantity of spare fabric collector bags for the fabric collector associated with the aforementioned source(s) in order to be able to immediately replace any bags because of deterioration resulting from routine operation of the sources(s) and fabric collector(s).

**# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The dust collector on Line 2/3 Winnower must be equipped with a device for monitoring the pressure differential across the baghouse.

**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: 118A

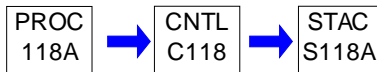
Source Name: LINE 3 GRINDER

Source Capacity/Throughput:

N/A

COCOA BEAN NIBS

Conditions for this source occur in the following groups: GRINDERS  
 RACT II & III A

**I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.99(c) and 129.114(c).]

The permittee shall limit the annual volatile organic compound (VOC) emissions to the maximum rate of 7.78 tons per year on a 12-month rolling sum 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) and/or Section E (Source Group Restrictions).

**III. MONITORING REQUIREMENTS.****# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall monitor the amount of nibs processed through the Line 3 Grinder on a monthly basis.

**IV. RECORDKEEPING REQUIREMENTS.****# 003 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.100(d) and 129.115(f).]

(a). The permittee shall keep records of the amount of nibs processed through the Line 3 Grinder on a monthly basis, and the permittee shall calculate and record the amount of volatile organic compounds (VOC) emitted from the Line 3 Grinder on a monthly basis.

(b). The permittee shall calculate the total amount of VOCs emitted from the Line 3 Grinder on a 12-month rolling sum basis.

**# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.100(i) and 129.115(k).]

The permittee shall keep records of the data collected for this source on file for a period of five (5) years, and these files 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) 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: 119

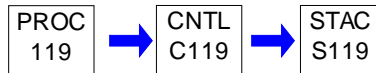
Source Name: MILL COLLECTOR 1

Source Capacity/Throughput:

N/A

COCOA POWDER

Conditions for this source occur in the following groups: MILL COLLECTORS

**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: 120

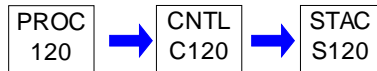
Source Name: MILL COLLECTOR 2

Source Capacity/Throughput:

N/A

COCOA POWDER

Conditions for this source occur in the following groups: MILL COLLECTORS

**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: 121

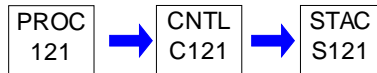
Source Name: MILL COLLECTOR 3

Source Capacity/Throughput:

N/A

COCOA POWDER

Conditions for this source occur in the following groups: MILL COLLECTORS

**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**

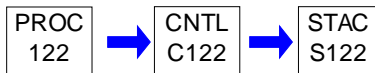
Source ID: 122

Source Name: RED CAKE QUAD BIN 1-4

Source Capacity/Throughput:

N/A

KIBBLED COCOA

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

# 001 [25 Pa. Code §123.13]

**Processes**

No person may permit the emission into the outdoor atmosphere of particulate matter from this source at any time, in excess of 0.04 grains per dry standard cubic foot, pursuant to 25 Pa. Code Section 123.13(c)(1)(i).

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

# 002 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The permittee shall maintain the pressure drop across each baghouse between 0.1 inches of water gauge and 8 inches of water gauge.

**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 §127.441]

**Operating permit terms and conditions.**

The permittee shall monitor the static pressure drop across each baghouse on a weekly basis when this source is in operation.

**IV. RECORDKEEPING REQUIREMENTS.**

# 004 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

(a). The permittee shall keep records of the static pressure drop across each baghouse on a weekly basis when this source is in operation.

(b). The permittee shall keep records of the following on a weekly basis:

- (1). Inspections made.
- (2). The repairs made to the baghouse(s) and the items replaced in the baghouse(s).
- (3). Bag failure (location and frequency) in the baghouse(s).
- (4). Frequency of bag cleaning.

**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).

**VI. WORK PRACTICE REQUIREMENTS.****# 005 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

To ensure proper operation of each baghouse, the permittee shall perform inspections and maintenance on a weekly basis. The inspections shall include, but are not limited to the following items:

- (a). Bags.
- (b). Tube sheets.
- (c). Hopper.
- (d). Bag cages.
- (e). Valves used for compressed air.
- (f). Integrity of each baghouse structure (no holes in the structure which will allow ambient air to flow into the baghouse).
- (g). The floor of the clean side of the baghouse(s).

**# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The fabric collector(s) must be equipped with a device for monitoring the pressure drop across the collector(s).

**# 007 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

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

**# 008 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The storage and handling of the material collected in the fabric collector shall not at any time result in the emission of fugitive air contaminants in excess of the limitations specified in 25 Pa. Code § 123.1 and Section C - Condition #002 of this permit.

**VII. ADDITIONAL REQUIREMENTS.****# 009 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

This source consists of 4 individual red cake quad bins, and each red cake quad bin is equipped with a baghouse.

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

**SECTION D. Source Level Requirements**

Source ID: 124A

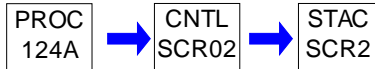
Source Name: ALKALIZATION PROCESSES

Source Capacity/Throughput:

N/A

KIBBLED COCOA

Conditions for this source occur in the following groups: RACT II &amp; III A

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

# 001 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.99(c) and 129.114(c).]

Nauta Mixers, Red and Black Reactors, Potassium carbonate storage and mix tank, and Alkalization Processes Condenser (line 3) shall limit its volatile organic compound (VOC) emissions to 13.05 tons on a 12-month rolling sum basis.

**Throughput Restriction(s).**

# 002 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The permittee shall maintain the water flow rate to the Alkalization Processes Condenser between 20 to 60 gpm.

**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.**

# 003 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The permittee shall monitor the amount of cocoa or kibbled cocoa processed through this source on a monthly basis.

# 004 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The permittee shall monitor the water flow rate into the condenser weekly when this source is in operation.

**IV. RECORDKEEPING REQUIREMENTS.**

# 005 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.100(d) and 129.115(f).]

(a). The permittee shall keep records of the amount of cocoa or kibbled cocoa processed through the reactors on a monthly basis.

(b). The permittee shall determine the amount of volatile organic compounds (VOC) emitted from this source on a monthly basis using a Department approved method.

**SECTION D. Source Level Requirements**

(c). The permittee shall calculate and record the total amount of VOCs emitted from this source on a 12-month rolling sum basis.

**# 006 [25 Pa. Code §127.441]**

**Operating permit terms and conditions.**

The permittee shall keep records of the water flow rate into the condenser weekly when this source is in operation.

**# 007 [25 Pa. Code §127.441]**

**Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.100(i) and 129.115(k).]

The permittee shall keep records of the data collected for this source on file for a period of five (5) years, and these files 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) and/or Section E (Source Group Restrictions).

**VI. WORK PRACTICE REQUIREMENTS.**

**# 008 [25 Pa. Code §127.441]**

**Operating permit terms and conditions.**

The permittee shall equip the source with a rotameter or an equivalent device to monitor the water flow rate to the condenser. This equipment shall be made available for observing the water flow rate at the request of the Department.

**VII. ADDITIONAL REQUIREMENTS.**

**# 009 [25 Pa. Code §127.441]**

**Operating permit terms and conditions.**

Source ID No. 124A consists of the following equipment:

- (a). A total of 8 Black Cake Reactors.
- (b). A total of 6 Nauta Mixers.
- (c). A Red Cake Reactor.
- (d). Potassium Carbonate Storage and Mix Tanks.
- (e). A scale hopper with the atmospheric bin vent controlled by a filter.

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



**SECTION D. Source Level Requirements**

Source ID: 125

Source Name: LINE 3 ROASTER

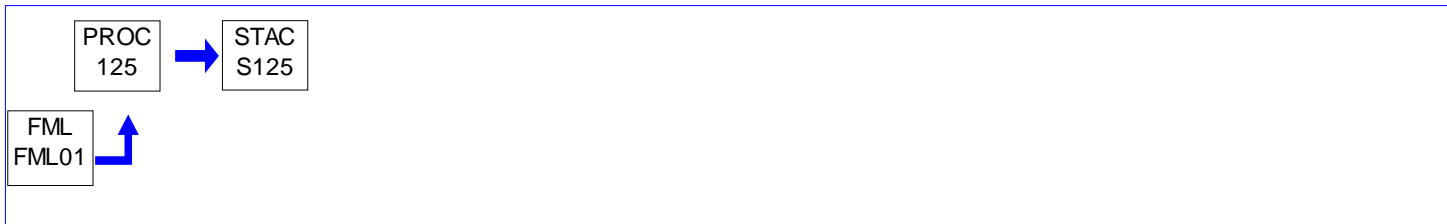
Source Capacity/Throughput: 5.000 MMBTU/HR

N/A

COCOA BEAN NIBS

4,762.000 CF/HR

Natural Gas

Conditions for this source occur in the following groups: RACT II & III A  
ROASTERS**I. RESTRICTIONS.****Emission Restriction(s).**

# 001 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.99(c) and 129.114(c).]

The permittee shall limit the volatile organic compound (VOC) emissions to the maximum rate of 21.31 tons per year on a 12-month rolling sum basis.

**Fuel Restriction(s).**

# 002 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The owner or operator shall use only natural gas as the fuel for this source.

**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.**

# 003 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The permittee shall monitor the amount of cocoa beans processed through the Line 3 Roaster on a monthly basis.

**IV. RECORDKEEPING REQUIREMENTS.**

# 004 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.100(d) and 129.115(f).]

(a). The permittee shall keep records of the amount of cocoa beans processed through the Line 3 Roaster on a monthly basis, and the permittee shall calculate and record the amount of volatile organic compounds (VOC) emitted from the Line 3 Roaster on a monthly basis.

(b). The permittee shall calculate and record the total amount of VOCs emitted from the Line 3 Roaster on a 12-month



**SECTION D. Source Level Requirements**

rolling sum basis.

**# 005 [25 Pa. Code §127.441]**  
**Operating permit terms and conditions.**  
 [Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.100(i) and 129.115(k).]  
 The permittee shall keep records of the data collected for this source on file for a period of five (5) years, and these files 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) 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**

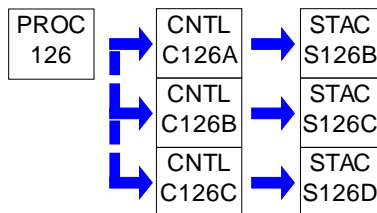
Source ID: 126

Source Name: LOW FAT SHELL BIN

Source Capacity/Throughput:

N/A

COCOA BEAN SHELLS

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

# 001 [25 Pa. Code §123.13]

**Processes**

No person may permit the emission into the outdoor atmosphere of particulate matter from this source at any time, in excess of 0.04 grains per dry standard cubic foot, pursuant to 25 Pa. Code Section 123.13(c)(1)(i).

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

# 002 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The permittee shall maintain the pressure drop across the baghouses connected to this source between 0.1 inches of water gauge and 8 inches of water gauge.

**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 §127.441]

**Operating permit terms and conditions.**

The permittee shall monitor the static pressure drop across the baghouse(s) on a weekly basis when this source is in operation.

**IV. RECORDKEEPING REQUIREMENTS.**

# 004 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

(a). The permittee shall keep records of the static pressure drop across the baghouse(s) on a weekly basis when this source is in operation.

(b). The permittee shall keep records of the following on a weekly basis:

- (1). Inspections made.
- (2). The repairs made to the baghouse(s) and the items replaced in the baghouse(s).
- (3). Bag failure (location and frequency) in the baghouse(s).
- (4). Frequency of bag cleaning.

**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).

**VI. WORK PRACTICE REQUIREMENTS.****# 005 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

To ensure proper operation of the baghouse(s), the permittee shall perform inspections and maintenance on a weekly basis. The inspections shall include, but are not limited to the following items:

- (a). Bags.
- (b). Tube sheets.
- (c). Hopper.
- (d). Bag cages.
- (e). Valve used for compressed air.
- (f). Integrity of the baghouse structure (no holes in the structure which will allow ambient air to flow into the baghouse).
- (g). The floor of the clean side of the baghouse.

**# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The fabric collector(s) must be equipped with a device for monitoring the pressure drop across the collector(s).

**# 007 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

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

**# 008 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The storage and handling of the material collected in the fabric collector shall not at any time result in the emission of fugitive air contaminants in excess of the limitations specified in 25 Pa. Code § 123.1 and Section C - Condition #002 of this permit.

**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: 127

Source Name: HIGH FAT SHELL BIN

Source Capacity/Throughput:

N/A

COCOA BEAN SHELLS

**I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

- (a). Emissions from the high fat shell bin shall be controlled by Baghouse 6BH8x42 or equivalent as approved by the Department.
- (b). The company shall limit the annual particulate Matter (PM) emissions to the maximum rate of 2.25 tons per year on a 12-month rolling sum basis.
- (c). PM emissions shall not exceed 0.02 grains per dry standard cubic feet from the high fat shell bin.

**Control Device Efficiency Restriction(s).****# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall maintain the pressure drop across this baghouse between 0.1 inches water gauge and 8 inches of water gauge.

**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 §127.441]****Operating permit terms and conditions.**

The company shall monitor the pressure drop across the baghouse on a weekly basis when this source is in operation.

**# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall monitor the throughput of cocoa bean shells through this source on a monthly basis when this source is in operation.

**IV. RECORDKEEPING REQUIREMENTS.****# 005 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

- (a). The company shall keep a record of pressure drop across the baghouse on a weekly basis when this source is in operation.
- (b). Records shall be maintained to show compliance with Condition #001(b), under this source.

**SECTION D. Source Level Requirements****# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

- (a). The permittee shall keep records of the throughput of cocoa bean shells through this source on a monthly basis when this source is in operation.
- (b). The permittee shall calculate and record the total amount of particulate matter emitted from this source on a monthly and a 12-month rolling basis.

**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.****# 007 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall not operate the High Fat Shell Bins without the bag filters in place.

**# 008 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

Equipment shall be provided, so that the pressure drop across the baghouse can be measured.

**# 009 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

- (a). The company shall keep on hand a sufficient quantity of spare fabric collector bags for the baghouse 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).
- (b). All sources, monitoring, sampling, and testing equipments shall be maintained and operated according to manufacturer's specifications. The source shall also be operated and maintained in accordance with good air pollution control practice.
- (c). The owner/operator shall minimize fugitive emissions with good housekeeping and shall practice good air pollution control.

**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**

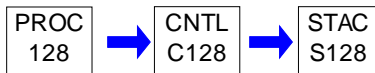
Source ID: 128

Source Name: SUGAR SILOS (2 TOTAL)

Source Capacity/Throughput:

N/A

SUGAR

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

# 001 [25 Pa. Code §123.13]

**Processes**

No person may permit the emission into the outdoor atmosphere of particulate matter from this source at any time, in excess of 0.04 grains per dry standard cubic foot, pursuant to 25 Pa. Code Section 123.13(c)(1)(i).

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

# 002 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The permittee shall maintain the pressure drop across this baghouse between 0.1 inches of water gauge and 8 inches of water gauge.

**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 §127.441]

**Operating permit terms and conditions.**

The permittee shall monitor the static pressure drop across each baghouse on a daily basis when this source is in operation.

**IV. RECORDKEEPING REQUIREMENTS.**

# 004 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

(a). The permittee shall keep records of the static pressure drop across each baghouse on a daily basis when this source is in operation.

(b). The permittee shall keep records of the following on a weekly basis:

- (1). Inspections made.
- (2). The repairs made to the baghouse(s) and the items replaced in the baghouse(s).
- (3). Bag failure (location and frequency) in the baghouse(s).
- (4). Frequency of bag cleaning.

**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).

**VI. WORK PRACTICE REQUIREMENTS.****# 005 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

To ensure proper operation of each baghouse, the permittee shall perform inspections and maintenance on a weekly basis. The inspections shall include, but are not limited to the following items:

- (a). Bags.
- (b). Tube sheets.
- (c). Hopper.
- (d). Bag cages.
- (e). Valve used for compressed air.
- (f). Integrity of each baghouse structure (no holes in the structure which will allow ambient air to flow into the baghouse).
- (g). The floor of the clean side of the baghouse.

**# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The fabric collector(s) must be equipped with a device for monitoring the pressure drop across the collector(s).

**# 007 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

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

**# 008 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The storage and handling of the material collected in the fabric collector shall not at any time result in the emission of fugitive air contaminants in excess of the limitations specified in 25 Pa. Code § 123.1 and Section C - Condition #002 of this permit.

**VII. ADDITIONAL REQUIREMENTS.****# 009 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

This source consists of two (2) sugar silos. Each sugar silo has its own bin vent filter.

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



**SECTION D. Source Level Requirements**

Source ID: 129

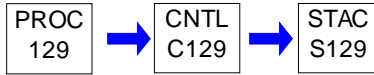
Source Name: BEAN UNLOADING 1

Source Capacity/Throughput:

N/A

COCOA BEANS

Conditions for this source occur in the following groups: UNLOADING

**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: 130

Source Name: BEAN UNLOADING 2

Source Capacity/Throughput:

N/A

COCOA BEANS

Conditions for this source occur in the following groups: UNLOADING

**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: 131A

Source Name: LINE 2/3 MICRONIZER &amp; BUCKET ELEVATOR

Source Capacity/Throughput: 2.440 MMBTU/HR

N/A

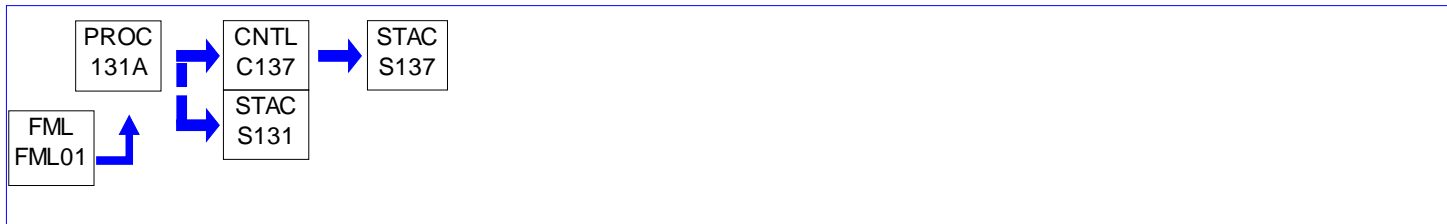
COCOA BEANS

2,324.000 MMCF/HR

Natural Gas

Conditions for this source occur in the following groups: MICRONIZERS

RACT II &amp; III B

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

# 001 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The permittee shall limit the annual volatile organic compound (VOC) emissions to the maximum rate of 2.60 tons per year on a 12-month rolling sum basis.

**Fuel Restriction(s).**

# 002 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The owner or operator shall use only natural gas as the fuel for this source.

**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.**

# 003 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The following equipment is included under Source ID No. 131A:

- (a). Line 2/3 Micronizer.
- (b). Two Bucket Elevators.

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

**SECTION D. Source Level Requirements**

Source ID: 132A

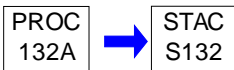
Source Name: LINE 1 GRINDER

Source Capacity/Throughput:

N/A

COCOA BEAN NIBS

Conditions for this source occur in the following groups: GRINDERS  
 RACT II & III A

**I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.99(c) and 129.114(c).]

The permittee shall limit the annual volatile organic compound (VOC) emissions to the maximum rate of 5.5 tons per year on a 12-month rolling sum 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) and/or Section E (Source Group Restrictions).

**III. MONITORING REQUIREMENTS.****# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall monitor the amount of nibs processed through the Line 1 Grinder on a monthly basis.

**IV. RECORDKEEPING REQUIREMENTS.****# 003 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.100(i) and 129.115(f).]

The permittee shall keep records of the data collected for this source on file for a period of five (5) years, and these files shall be made available to the Department upon request.

**# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.100(d) and 129.115(k).]

(a). The permittee shall keep records of the amount of nibs processed through the Line 1 Grinder on a monthly basis, and the permittee shall calculate and record the amount of volatile organic compounds (VOC) emitted from the Line 1 Grinder on a monthly basis.

(b). The permittee shall calculate the total amount of VOCs emitted from the Line 1 Grinder on a 12-month rolling sum basis.

**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: 135

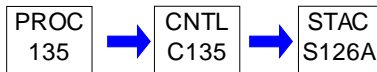
Source Name: LINE 1 WINNOWER

Source Capacity/Throughput:

N/A

COCOA BEANS

Conditions for this source occur in the following groups: RACT II & III B  
WINNOWERS

**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 in excess of 0.04 grains per dry standard cubic foot, pursuant to 25 Pa. Code Section 123.13(c)(1)(i).

**Control Device Efficiency Restriction(s).****# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall maintain the pressure drop across this baghouse between 0.1 inches of water gauge and 8 inches of water gauge.

**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 §127.441]****Operating permit terms and conditions.**

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

**SECTION D. Source Level Requirements****# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The fabric collector(s) must be equipped with a device for monitoring the pressure drop across the collector(s).

**# 005 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The storage and handling of the material collected in the fabric collector shall not at any time result in the emission of fugitive air contaminants in excess of the limitations specified in 25 Pa. Code § 123.1 and Section C - Condition #002 of this 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: 142

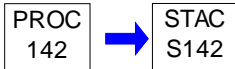
Source Name: LINE 2 ALKALIZATION MIXER

Source Capacity/Throughput:

N/A

COCOA BEAN NIBS

Conditions for this source occur in the following groups: RACT II &amp; III B

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

# 001 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The owner or operator shall limit the emissions of volatile organic compounds (VOCs) from this source to less than or equal to 1.08 tons per year on a 12-month rolling sum 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) and/or Section E (Source Group Restrictions).

**III. MONITORING REQUIREMENTS.**

# 002 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The owner or operator shall monitor the amount of cocoa nibs processed through this source on a monthly basis.

**IV. RECORDKEEPING REQUIREMENTS.**

# 003 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

(a). The owner or operator shall keep records of the amount of cocoa nibs processed through this source on a monthly basis.

(b). The owner or operator shall determine the amount of volatile organic compounds (VOC) emitted from this source on a monthly basis using a Department approved method.

(c). The owner or operator shall calculate and record the total amount of VOCs emitted from this source on a 12-month rolling sum basis.

**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: 143

Source Name: LINE 4 MICRONIZER

Source Capacity/Throughput: 4.300 MMBTU/HR

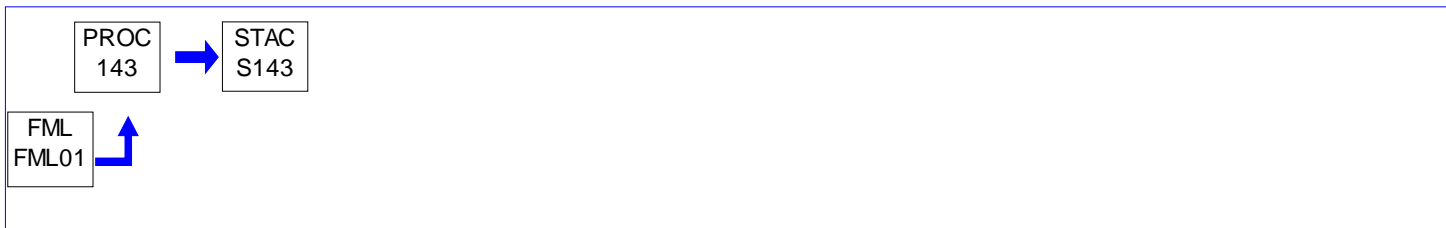
N/A

COCOA BEAN NIBS

4,095.000 CF/HR

Natural Gas

Conditions for this source occur in the following groups: RACT II &amp; III A

**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 in excess of 0.04 grains per dry standard cubic foot, pursuant to 25 Pa. Code Section 123.13(c)(1)(i).

# 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 SO<sub>2</sub>, in the effluent gas exceeds 500 parts per million, by volume, dry basis, pursuant to 25 Pa. Code Section 123.21(b).

# 003 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.99(c) and 129.114(c).]

The owner or operator shall limit the emissions of volatile organic compounds (VOCs) from this source to less than or equal to 3.29 tons per year on a 12-month rolling sum basis.

**Fuel Restriction(s).**

# 004 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The owner or operator shall use only natural gas as the fuel for this source.

**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.**

# 005 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The owner or operator shall monitor the following on a monthly basis:

(a). The type of fuel used.

**SECTION D. Source Level Requirements**

- (b). The amount of fuel used.
- (c). The hours of operation.
- (d). The amount of beans processed by this micronizer.

**IV. RECORDKEEPING REQUIREMENTS.****# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.100(d) and 129.115(f).]

(a). The owner or operator shall keep records for the following on a monthly basis:

- (1). The type of fuel used.
- (2). The amount of fuel used.
- (3). The hours of operation.
- (4). The amount of beans processed by this micronizer.

(b). The owner or operator shall calculate and record the amount of particulate matter, sulfur dioxide, nitrogen oxides, carbon monoxide, and volatile organic compound emissions from this source on a monthly basis.

(c). The owner or operator shall calculate and record the total amount of fuel used, the total hours of operation, the total amount of cocoa beans processed, and the total amount of each pollutant emitted from this source on a 12-month rolling sum basis.

**# 007 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.100(i) and 129.115(k).]

The permittee shall keep records of the data collected for this source on file for a period of five (5) years, and these files 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) 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

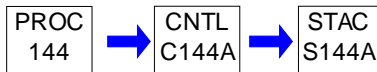
Source Name: LINE 4 WINNOWER

Source Capacity/Throughput:

N/A

COCOA BEANS

Conditions for this source occur in the following groups: LINE 4 BAGHOUSE  
 RACT II & III B

**I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The owner or operator shall limit the emissions of volatile organic compounds (VOCs) from this source to less than or equal to 1.10 tons per year on a 12-month rolling sum 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) and/or Section E (Source Group Restrictions).

**III. MONITORING REQUIREMENTS.****# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The owner or operator shall monitor the amount of cocoa beans processed through the Line 4 Winnower on a monthly basis.

**IV. RECORDKEEPING REQUIREMENTS.****# 003 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a). The owner or operator shall keep records of the amount of cocoa beans processed through the Line 4 Winnower on a monthly basis, and the owner or operator shall calculate and record the amount of volatile organic compounds (VOC) emitted from the Line 4 Winnower on a monthly basis.

(b). The owner or operator shall calculate and record the total amount of VOCs emitted from the Line 4 winnower on a 12-month rolling sum basis.

**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**

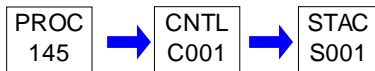
Source ID: 145

Source Name: LINE 4 ROASTER

Source Capacity/Throughput:

N/A

COCOA BEAN NIBS

**I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The owner or operator shall limit the emissions of volatile organic compounds (VOCs) from this source to less than or equal to 0.70 tons per year on a 12-month rolling sum 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.****# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The owner or operator shall monitor the following for this source:

- (a). Amount of cocoa bean nibs that are processed by this source on a monthly basis.
- (b). The number of hours of operation on a monthly basis.

**IV. RECORDKEEPING REQUIREMENTS.****# 003 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a). The owner or operator shall record the following for this source:

- (1). Amount of cocoa bean nibs that are processed by this source on a monthly basis.
- (2). Number of hours of operation for this source on a monthly basis.

(b). The owner or operator shall calculate and record the amount of volatile organic compounds (VOCs) emitted from this source and the total number of hours of operation for this source a monthly and on a 12-month rolling sum basis.

**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).

**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: 146

Source Name: LINE 4 ROASTER BURNER

Source Capacity/Throughput: 3.970 MMBTU/HR

N/A

COCOA BEAN NIBS

3,781.000 CF/HR

Natural Gas

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

No person may permit the emission into the outdoor atmosphere of particulate matter from this source at any time, in excess of 0.04 grains per dry standard cubic foot, pursuant to 25 Pa. Code Section 123.13(c)(1)(i).

**# 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 SO<sub>2</sub>, in the effluent gas exceeds 500 parts per million, by volume, dry basis, pursuant to 25 Pa. Code Section 123.21(b).

**# 003 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The owner or operator shall limit the emissions of volatile organic compounds (VOCs) from this source to less than or equal to 0.29 tons per year on a 12-month rolling sum basis.

**Fuel Restriction(s).****# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The owner or operator shall use only natural gas as the fuel for this source.

**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.****# 005 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall monitor the following on a monthly basis:

- The type of fuel used.
- The amount of fuel used.
- The hours of operation.

**SECTION D. Source Level Requirements****IV. RECORDKEEPING REQUIREMENTS.****# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a). The permittee shall keep records of the following on a monthly basis:

- (1). The type of fuel used.
- (2). The amount of fuel used.
- (3). The hours of operation.

(b). The owner or operator shall calculate and record the amount of particulate matter, sulfur dioxide, nitrogen oxides, carbon monoxide, and volatile organic compound emissions from this source on a monthly basis.

(c). The owner or operator shall calculate and record the total amount of fuel used, the total hours of operation, and the total amount of each pollutant emitted from this source on a 12-month rolling sum basis.

**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: 147

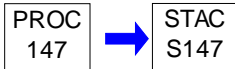
Source Name: LINE 4 COOLER

Source Capacity/Throughput:

N/A

COCOA BEAN NIBS

Conditions for this source occur in the following groups: RACT II &amp; III A

**I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.99(c) and 129.114(c).]

The owner or operator shall limit the emissions of volatile organic compounds (VOCs) from this source to less than or equal to 6.42 tons per year on a 12-month rolling sum 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) and/or Section E (Source Group Restrictions).

**III. MONITORING REQUIREMENTS.****# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The owner or operator shall monitor the amount of cocoa nibs processed through the Line 4 Cooler on a monthly basis.

**IV. RECORDKEEPING REQUIREMENTS.****# 003 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.100(d) and 129.115(f).]

(a). The owner or operator shall keep records of the amount of cocoa nibs processed through the Line 4 Cooler on a monthly basis, and the owner or operator shall calculate and record the amount of volatile organic compounds (VOC) emitted from the Line 4 Cooler on a monthly basis.

(b). The owner or operator shall calculate and record the total amount of VOCs emitted from the Line 4 Cooler on a 12-month rolling sum basis.

**# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.100(i) and 129.115(k).]

The permittee shall keep records of the data collected for this source on file for a period of five (5) years, and these files 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) 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**

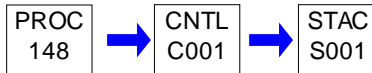
Source ID: 148

Source Name: LINE 4 GRINDING

Source Capacity/Throughput:

N/A

COCOA BEAN NIBS

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

# 001 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The owner or operator shall limit the emissions of volatile organic compounds (VOCs) from this source to less than or equal to 0.32 tons per year on a 12-month rolling sum 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.**

# 002 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The owner or operator shall monitor the amount of nibs processed through this source on a monthly basis.

**IV. RECORDKEEPING REQUIREMENTS.**

# 003 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

(a). The owner or operator shall keep records of the amount of nibs processed through this source on a monthly basis, and the owner or operator shall calculate and record the amount of volatile organic compounds (VOC) emitted from this source.

(b). The owner or operator shall calculate the total amount of VOCs emitted from this source on a 12-month rolling sum basis.

**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.**

# 004 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The equipment included under Source ID No. 148 includes the following:

(a). Line 4 Grinders.

(b). Diffusion Collector System Knockout Box.



**SECTION D. Source Level Requirements**

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

**SECTION D. Source Level Requirements**

Source ID: 150

Source Name: LINE 2/3 ASPIRATION BOX

Source Capacity/Throughput:

N/A

COCOA BEANS

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

# 001 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

No person may permit the emission into the outdoor atmosphere of particulate matter in excess of 0.01 grains per dry standard cubic foot.

[Compliance with the condition above also demonstrates compliance with the applicable requirements from 25 Pa. Code § 123.13(c)(1)(i) and Best Available Technology (BAT).]

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

# 002 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The permittee shall maintain the pressure differential across the baghouse associated with this source between 0.1 and 5.5 inches water gauge.

**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 §127.441]

**Operating permit terms and conditions.**

The owner or operator shall monitor the amount of cocoa beans processed through the Line 2/3 Aspiration Box on a monthly basis.

# 004 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The owner or operator shall monitor the static pressure drop across the baghouse(s) on a weekly basis when this source is in operation.

**IV. RECORDKEEPING REQUIREMENTS.**

# 005 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

(a). The owner or operator shall keep records of the static pressure drop across the baghouse(s) on a weekly basis when this source is in operation.

(b). The owner or operator shall keep records of the following on a weekly basis:

**SECTION D. Source Level Requirements**

- (1). Inspections made to the baghouse(s).
- (2). Repairs made to the baghouse(s) and items that were replaced in the baghouse(s).
- (3). Bag failure (location and frequency) in the baghouse(s).
- (4). Frequency of bag cleaning.

**# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The owner or operator shall keep records of the amount of cocoa beans processed through the Line 2/3 Aspiration Box on a monthly basis.

**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.****# 007 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The owner or operator of this source and associated dust collector shall keep on hand a sufficient quantity of spare fabric filters for the dust collector in order to immediately replace any fabric filters that require replacement due to deterioration resulting from the routine operation of the dust collector.

**# 008 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

To ensure proper operation of the baghouse(s), the owner or operator shall perform inspections and maintenance of the baghouse(s) on a weekly basis. The inspections shall include, but are not limited to the following items:

- (a). Bags.
- (b). Tube sheets.
- (c). Hopper.
- (d). Bag cages.
- (e). Valves used for compressed air.
- (f). Integrity of the baghouse structure (no holes in the structure in which ambient air can enter the baghouse).
- (g). Floor of the clean side of the baghouse.

**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: 151

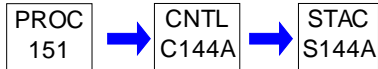
Source Name: LINE 4 ASPIRATION BOX

Source Capacity/Throughput:

N/A

COCOA BEANS

Conditions for this source occur in the following groups: LINE 4 BAGHOUSE

**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 §127.441]

**Operating permit terms and conditions.**

The owner or operator shall monitor the amount of cocoa beans processed through the Line 4 Aspiration Box on a monthly basis.

**IV. RECORDKEEPING REQUIREMENTS.**

# 002 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The owner or operator shall keep records of the amount of cocoa beans processed through the Line 4 Aspiration Box on a monthly basis.

**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**

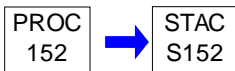
Source ID: 152

Source Name: LINE 2 COLLECTOR

Source Capacity/Throughput:

2.000 Lbs/HR

COCOA BEANS

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

# 001 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The owner or operator shall limit the emissions of VOC from this source to less than 0.09 tons per year on a 12-month rolling sum 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.**

# 002 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The permittee shall monitor the amount of cocoa beans processed through the Line 2 Collector on a monthly basis.

**IV. RECORDKEEPING REQUIREMENTS.**

# 003 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

(a). The permittee shall keep records of the amount of cocoa beans processed through the Line 2 Collector on a monthly basis, and the permittee shall calculate and record the amount of volatile organic compounds (VOC) emitted from the Line 2 Collector on a monthly basis.

(b). The permittee shall calculate and record the total amount of VOCs emitted from the Line 2 Collector on a 12-month rolling sum basis.

**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**

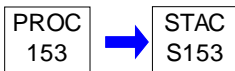
Source ID: 153

Source Name: LINE 4 COLLECTOR

Source Capacity/Throughput:

N/A

COCOA BEANS

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

# 001 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The owner or operator shall limit the emissions of VOC from this source to less than 0.29 tons per year on a 12-month rolling sum 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.**

# 002 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The permittee shall monitor the amount of cocoa beans processed through the Line 4 Collector on a monthly basis.

**IV. RECORDKEEPING REQUIREMENTS.**

# 003 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

(a). The permittee shall keep records of the amount of cocoa beans processed through the Line 4 Collector on a monthly basis, and the permittee shall calculate and record the amount of volatile organic compounds (VOC) emitted from the Line 4 Collector on a monthly basis.

(b). The permittee shall calculate and record the total amount of VOCs emitted from the Line 4 Collector on a 12-month rolling sum basis.

**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).



## 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**

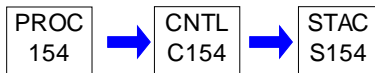
Source ID: 154

Source Name: LINE 4 MATERIAL HANDLING SOURCES

Source Capacity/Throughput:

N/A

COCOA BEAN NIBS

**I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

No person may permit the emission into the outdoor atmosphere of particulate matter in excess of 0.01 grains per dry standard cubic foot.

{Compliance with the condition above also demonstrates compliance with the applicable requirements from 25 Pa. Code § 123.13(c)(1)(i) and Best Available Technology (BAT) [25 Pa. Code § 127.12(a)(5)].}

**Control Device Efficiency Restriction(s).****# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall maintain the static pressure drop across the baghouse associated with this source between 0.1 and 8.0 inches water gauge.

**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 §127.441]****Operating permit terms and conditions.**

The permittee shall monitor the amount of cocoa beans processed through the Line 4 material handling sources on a monthly basis.

**# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall monitor the static pressure drop across the baghouse(s) on a weekly basis.

**IV. RECORDKEEPING REQUIREMENTS.****# 005 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a). The permittee shall keep records of the static pressure drop across the baghouse(s) on a weekly basis.

(b). The permittee shall keep records of the following on a weekly basis:

- (1). Inspections made to the baghouse(s).
- (2). Repairs made to the baghouse(s) and items that were replaced in the baghouse(s).

**SECTION D. Source Level Requirements**

- (3). Bag failure (location and frequency) in the baghouse(s).
- (4). Frequency of bag cleaning.

**# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall keep records of the amount of cocoa beans processed through the Line 4 material handling sources on a monthly basis.

**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.****# 007 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

To ensure proper operation of the baghouse(s), the permittee shall perform inspections and maintenance of the baghouse(s) on a weekly basis. The inspections shall include, but are not limited to the following items:

- (a). Bags.
- (b). Tube sheets.
- (c). Hopper.
- (d). Bag cages.
- (e). Valves used for compressed air.
- (f). Integrity of the baghouse structure (no holes in the structure in which ambient air can enter the baghouse).
- (g). Floor of the clean side of the baghouse.

**# 008 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The owner or operator of this source and associated dust collector shall keep on hand a sufficient quantity of spare fabric filters for the dust collector in order to immediately replace any fabric filters that require replacement due to deterioration resulting from the routine operation of the dust collector.

**VII. ADDITIONAL REQUIREMENTS.****# 009 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

Source ID No. 154 includes the following material handling sources:

- (a). Bucket Elevator.
- (b). Runaround Drag Conveyor.
- (c). Two (2) Bean Weigh Hoppers.
- (d). Rotex.

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

**SECTION D. Source Level Requirements**

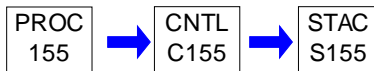
Source ID: 155

Source Name: LINE 1 ASPIRATION CHANNEL

Source Capacity/Throughput:

N/A

COCOA BEANS

**I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

No person may permit the emission into the outdoor atmosphere of particulate matter from the baghouse associated with this source in excess of 0.01 grains per dry standard cubic foot.

{Compliance with the condition above also demonstrates compliance with the applicable requirements from 25 Pa. Code § 123.13(c)(1)(i) and Best Available Technology (BAT) [25 Pa. Code § 127.12(a)(5)].}

**Control Device Efficiency Restriction(s).****# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall maintain the pressure drop across the dust collector (Source ID No. C155) associated with this source between 0.1 and 5 inches water gauge when the source and dust collector are in operation.

**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 §127.441]****Operating permit terms and conditions.**

The permittee shall monitor the amount of cocoa beans processed through the Line 1 Aspiration Channel on a monthly basis.

**# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall monitor the static pressure drop across the baghouse(s) on a weekly basis when this source is in operation.

**IV. RECORDKEEPING REQUIREMENTS.****# 005 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The owner or operator shall keep records of the following on a weekly basis:

- Inspections made to the baghouse(s).
- Repairs made to the baghouse(s) and items that were replaced in the baghouse(s).
- Bag failure (location and frequency) in the baghouse(s).

**SECTION D. Source Level Requirements**

(d). Frequency of bag cleaning.

**# 006 [25 Pa. Code §127.441]**

**Operating permit terms and conditions.**

The permittee shall keep records of the amount of cocoa beans processed through the Line 1 Aspiration Channel on a monthly basis.

**# 007 [25 Pa. Code §127.441]**

**Operating permit terms and conditions.**

The permittee shall keep records of the static pressure drop across the baghouse(s) on a weekly basis when this source is in operation.

**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.**

**# 008 [25 Pa. Code §127.441]**

**Operating permit terms and conditions.**

To ensure proper operation of the baghouse(s), the permittee shall perform inspections and maintenance of the baghouse(s) on a weekly basis. The inspections shall include, but are not limited to the following items:

- (a). Bags.
- (b). Tube sheets.
- (c). Hopper.
- (d). Bag cages.
- (e). Valves used for compressed air.
- (f). Integrity of the baghouse structure (no holes in the structure in which ambient air can enter the baghouse).
- (g). Floor of the clean side of the baghouse.

**# 009 [25 Pa. Code §127.441]**

**Operating permit terms and conditions.**

The owner or operator of this source and associated dust collector shall keep on hand a sufficient quantity of spare fabric filters for the dust collector in order to immediately replace any fabric filters that require replacement due to deterioration resulting from the routine operation of the dust 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: 700

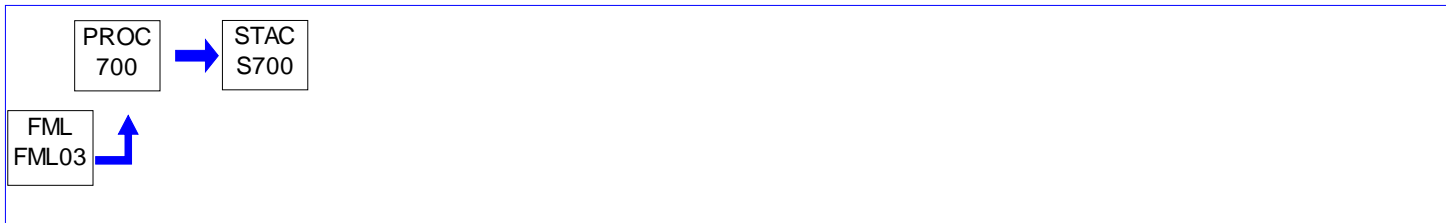
Source Name: EMERGENCY GENERATOR

Source Capacity/Throughput:

5.700 Gal/HR

Diesel Fuel

Conditions for this source occur in the following groups: RACT II &amp; III B

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

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

**# 002 [25 Pa. Code §123.21]****General**

No person may permit the emission into the outdoor atmosphere of sulfur oxides from this source in a manner that the concentration of the sulfur oxides, expressed as SO<sub>2</sub>, in the effluent gas exceeds 500 ppmvd.

**Fuel Restriction(s).****# 003 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall use diesel fuel that meets the requirements of 40 CFR §1090.305 for nonroad diesel fuel:

- (a) A sulfur content of 15 ppm maximum, and
- (b) A minimum cetane index of 40; or maximum aromatic content of 35% volume.

[Compliance with this condition assures compliance with 25 Pa. Code §123.21.]

**Operation Hours Restriction(s).****# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 25 Pa. Code §§ 129.93(c), 129.97(c) and 129.112(c).]

The permittee shall limit the operation of this compression ignition, reciprocating internal combustion engine (CI RICE) to less than 500 hours per year on a 12-month rolling sum basis.

**# 005 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 40 C.F.R. § 63.6640(f)(2)(i) and 63.6640(f)(4).]

- (a). The permittee may operate the emergency stationary RICE for a maximum of 100 hours per calendar year for the purpose of maintenance checks and readiness testing, provided that the tests are recommended by the manufacturer, the vendor, the regional transmission organization or equivalent balancing authority and transmission operator, or the insurance company associated with the engine. The permittee may petition the Administrator for approval of additional hours to be used for maintenance checks and readiness testing, but a petition is not required if the owner or operator

**SECTION D. Source Level Requirements**

maintains records indicating that federal, state, or local standards require maintenance and testing of emergency RICE beyond 100 hours per calendar year.

(b). The permittee may operate the emergency stationary RICE for up to 50 hours per calendar year in non-emergency situations. The 50 hours per year for non-emergency situations are counted as part of the 100 hours per calendar year for maintenance and testing and cannot be used for peak shaving or non-emergency demand response or to generate income for a facility to supply power to an electric grid or otherwise supply power as part of a financial arrangement with another entity, except as allowed in 40 CFR Section 63.6640(f)(4).

**# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 40 C.F.R. § 63.6625(h).]

The permittee shall minimize the engine's time spent at idle during startup and minimize the engine's startup time to a period needed for appropriate and safe loading of the engine, not to exceed 30 minutes.

**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.****# 007 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a). The permittee shall monitor the hours of operation of the engine that is recorded through the non-resettable hour meter. The owner or operator must monitor how many hours are spent for emergency operation, including what classified the operation as emergency and how many hours are spent for non-emergency operation. If the engine is used for the purposes specified in 40 CFR Section 63.6640(f)(4)(ii), the owner or operator must monitor events of the notification of the emergency situation, and the date, start time and end time of engine operation for these purposes.

(b). The permittee shall monitor the hours of operation of the engine during the engine's time spent at idle during startup.

**IV. RECORDKEEPING REQUIREMENTS.****# 008 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 40 C.F.R. §§ 63.6655(a)(4), 63.6655(d) and 63.6655(e).]

The permittee shall keep records of all inspections and/or maintenance that is performed on this CI RICE in order to demonstrate that the CI RICE was operated and maintained in accordance with manufacturer's or company's own maintenance plan.

**# 009 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall keep a record of either the manufacturer's specifications and instructions or the permittee's own preventive maintenance plan for the entire time period that the permitted CI RICE is at this facility. These maintenance plans shall be made available to the Department upon request.

**# 010 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

**SECTION D. Source Level Requirements**

[Additional authority for this permit condition is also derived from 40 C.F.R. § 63.6655(a).]

The permittee shall keep records of the following in the event of a malfunction of this CI RICE:

- (a). Records of the occurrence and duration of each malfunction of operation ( i.e., process equipment) or the air pollution control and monitoring equipment.
- (b). Records of actions taken during periods of malfunction to minimize emissions in accordance with 40 C.F.R. § 63.6605(b), including corrective actions to restore malfunctioning process and air pollution control and monitoring equipment to its normal or usual manner of operation.

**# 011 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 40 C.F.R. § 63.6655(a).]

The permittee shall keep a copy of all reports submitted to the Administrator for compliance with 40 C.F.R. Part 63, Subpart ZZZZ.

**# 012 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 40 C.F.R. § 63.6660.]

- (a). The records must be kept in a form suitable and readily available for expeditious review according to 40 C.F.R. § 63.10(b)(1).
- (b). As specified in 40 C.F.R. § 63.10(b)(1), the records shall be kept for five (5) years following the date of each occurrence, measurement, maintenance, corrective action, report, or record.
- (c). The permittee shall keep each record readily accessible in hard copy or electronic form for at least five (5) years after the date of each occurrence, measurement, maintenance, corrective action, report, or record, according to 40 C.F.R. § 63.10(b)(1).

**# 013 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall demonstrate through calculation or equivalent means compliance with the applicable requirements of 25 Pa. Code §§ 123.13(c)(1)(i) and 123.21. This demonstration can include a one-time only calculation to prove that the emission limits will never be exceeded under normal operation of this source, if applicable. The calculations shall be kept on file for the life of the operation of this source.

**# 014 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 40 C.F.R. § 63.6625(i).]

If the permittee choose the oil analysis program to meet the requirements for the maintenance of the CI RICE, then the permittee shall keep records of the Total Base Number, viscosity, and percent water content of the oil for each analysis performed, the results of the analysis, and the oil changes performed for the engine.

**# 015 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 40 C.F.R. § 63.6655(f).]

- (a). The permittee shall keep records of the hours of operation of the engine that is recorded through the non-resettable

**SECTION D. Source Level Requirements**

hour meter. The owner or operator must document how many hours are spent for emergency operation, including what classified the operation as emergency and how many hours are spent for non-emergency operation. If the engine is used for the purposes specified in 40 CFR Section 63.6640(f)(4)(ii), the owner or operator must monitor events of the notification of the emergency situation, and the date, start time and end time of engine operation for these purposes.

(b). The permittee shall keep records of the hours of operation of the engine during the engine's time spent at idle during startup.

(c). The total hours of operation shall be compiled on a monthly and on a 12-month rolling basis.

**V. REPORTING REQUIREMENTS.****# 016 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 40 C.F.R. §§ 63.6640(b) and 63.6650(f).]

(a). The permittee shall report to the Administrator each instance in which the requirements from 40 C.F.R. Part 63, Subpart ZZZZ, Table 2d.4 were not met. The reports shall be submitted as per the requirements of paragraph (b) below.

(b). Each affected source that has obtained a Title V Operating Permit pursuant to 40 C.F.R. Part 70 or 71 must report all deviations as defined in 40 C.F.R. Part 63, Subpart ZZZZ in the semiannual monitoring report required by 40 C.F.R. § 70.6(a)(3)(iii)(A) or 40 C.F.R. § 71.6(a)(3)(iii)(A). If an affected source submits a Compliance report pursuant to Table 7 of 40 C.F.R. Part 63, Subpart ZZZZ along with, or as part of, the semiannual monitoring report required by 40 C.F.R. § 70.6(a)(3)(iii)(A) or 40 C.F.R. § 71.6(a)(3)(iii)(A), and the Compliance report includes all required information concerning deviations from any emission or operating limitation in this subpart, submission of the Compliance report shall be deemed to satisfy any obligation to report the same deviations in the semiannual monitoring report. However, submission of a Compliance report shall not otherwise affect any obligation the affected source may have to report deviations from permit requirements to the permit authority.

**VI. WORK PRACTICE REQUIREMENTS.****# 017 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional Authority for this permit condition is also derived from 40 C.F.R. § 63.6603(a), 40 C.F.R. Part 63, Subpart ZZZZ, Table 2d.4, 40 C.F.R. § 63.6605, and 40 C.F.R. § 63.6625(i).]

(a). The following maintenance activities shall be performed by the permittee at the frequency described below:

(1). The permittee shall change the oil and filter in this CI RICE every 500 hours of operation or annually, whichever comes first.

(2). The permittee shall inspect the air cleaner in this CI RICE every 1,000 hours of operation or annually, whichever comes first.

(3). The permittee shall inspect all hoses and belts in this CI RICE every 500 hours of operation or annually, whichever comes first, and replace these items as necessary.

(b). The permittee may choose the option of utilizing an oil analysis program in order to extend the specified oil change requirement in paragraph (a)(1) above. If the oil analysis program is chosen, the oil analysis shall occur at a frequency of every 500 hours of operation or annually, whichever comes first, and the oil analysis, at a minimum, shall include Total Base Number, viscosity, and percent water content. The condemning limits for these parameters are as follows: Total Base Number is less than 30 percent of the Total Base Number of the oil when new; viscosity of the oil has changed by more than 20 percent from the viscosity of the oil when new; or percent water content (by volume) is greater than 0.5. If all of these

**SECTION D. Source Level Requirements**

condemning limits are not exceeded, the engine owner or operator is not required to change the oil. If any of the limits are exceeded, the engine owner or operator must change the oil within 2 days of receiving the results of the analysis; if the engine is not in operation when the results of the analysis are received, the engine owner or operator must change the oil within 2 days or before commencing operation, whichever is later. If the oil analysis program is chosen for compliance with 40 C.F.R. Part 63, Subpart ZZZZ, the analysis program shall be part of the maintenance plan for the engine.

(c). The requirements in paragraphs (a) and (b) above apply to this CI RICE at all times.

**# 018 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 40 C.F.R. §§ 63.6605(b), 63.6625(e), 63.6640(a), and 40 C.F.R. Part 63, Subpart ZZZZ, Table 6.]

(a). At all times the permittee shall operate and maintain any affected source, including associated air pollution control equipment and monitoring equipment, in a manner consistent with safety and good air pollution control practices for minimizing emissions.

(b). The permittee shall operate and maintain the stationary RICE and after-treatment control device (if any) according to the manufacturer's emission-related written instructions or develop a maintenance plan for the CI RICE which shall provide to the extent practicable for the maintenance and operation of the engine in a manner consistent with good air pollution control practice for minimizing emissions.

(c). The general duty to minimize emissions does not require the permittee to make any further efforts to reduce emissions if levels required by this 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, review of operation and maintenance records, and inspection of the source.

**# 019 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is derived from 40 C.F.R. § 63.6625(f).]

The permittee shall install a non-resettable hour meter if one is not already installed on this CI RICE.

**VII. ADDITIONAL REQUIREMENTS.****# 020 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

[Additional authority for this permit condition is also derived from 40 C.F.R. § 63.6640(e) and 40 C.F.R. Part 63, Subpart ZZZZ, Table 8.]

(a). The permittee is subject to the following general MACT requirements as referenced and specified in 40 C.F.R. Part 63, Subpart ZZZZ, Table 8: 40 C.F.R. §§ 63.1, 63.2, 63.3, 63.4, 63.5, 63.6 [except for 40 C.F.R. § 63.6(h)], 63.7 [except 40 C.F.R. § 63.7(e)(1)], 63.8 [except for 40 C.F.R. §§ 63.8(a)(4), 63.8 (c)(5), and 63.8(e)(5)(ii)], 63.9 [except for 40 C.F.R. §§ 63.9(f) and (g)(2)], 63.10 [except for 40 C.F.R. §§ 63.10(b)(2)(i) - (v), 63.10(d)(3), 63.10(d)(5), 63.10(e)(2)(ii), and 63.10(e)(4)], 63.12, 63.13, 63.14, and 63.15.

(b). The permittee shall report each instance in which the requirements listed in 40 C.F.R. Part 63, Subpart ZZZZ, Table 8 and summarized above were not met.

**# 021 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

This source is an emergency generator set engine, manufacturer: Katolight, Model No. SED75FRJ4, rated 100.5 HP and installed in January 2006.



**SECTION D. Source Level Requirements**

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

**SECTION D. Source Level Requirements**

Source ID: C001

Source Name: REGENERATIVE THERMAL OXIDIZER

Source Capacity/Throughput:

N/A

Natural Gas

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

# 001 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The owner or operator shall use only natural gas as the fuel for this source.

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

# 002 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

(a). The owner or operator shall maintain the regenerative thermal oxidizer (RTO) combustion zone temperature at a minimum of 1,525 degrees Fahrenheit.

(b). The owner or operator shall either maintain a minimum destruction efficiency of 98 percent for volatile organic compounds (VOCs) for this RTO or control the VOC emissions to a concentration less than or equal to 20 ppm<sub>v</sub> as methane (6 ppm<sub>v</sub> as propane) as determined through stack testing of this RTO.

(c). The Department reserves the right to re-evaluate and/or adjust the allowable minimum combustion zone temperature in paragraph (a) above for this RTO pursuant to the results of a Department approved stack test from the requirements of Condition #003 for this source in order to maintain the minimum destruction efficiency or the concentration limits in paragraph (b) above.

(d). The owner or operator shall maintain the retention time through this regenerative thermal oxidizer at or above 0.3 seconds.

**II. TESTING REQUIREMENTS.**

# 003 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

(a). The permittee shall perform a stack test using the Department-approved procedures once every five (5) calendar years, where five calendar years is defined as beginning with the calendar year the latest stack test was performed and ending on December 31, five years later. Performance tests shall be conducted while the source is operating at normal operating conditions or under such other conditions, within the capacity of the equipment, as may be requested by the Department. When testing of a source is required on a recurring basis, a single procedural protocol may be submitted for approval; thereafter, a letter referencing the previously approved procedural protocol is sufficient. However, if modifications are made to the process(es), if a different stack testing company is used, or if an applicable section of the stack testing manual has been revised since approval, a new protocol must be submitted for approval.

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

**SECTION D. Source Level Requirements**

(c). The stack test shall, at a minimum, test for the emissions of volatile organic compounds (VOCs). Tests shall be conducted in accordance with the provisions of U.S. EPA Methods 1, 2, 3, 3A, 4, and 25A or other Department approved methodology and 25 Pa. Code Chapter 139.

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

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

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

(g). Reporting for Stack testing

(1). The permittee shall email all source test submissions (notifications, protocols, reports, supplemental information, etc.) to both the AQ Program Manager for the Southeast Regional Office and the PSIMS Administrator in Central Office.

Southeast Region  
RA-EPSEstacktesting@pa.gov

PSIMS Administrator  
RA-EPstacktesting@pa.gov

Any questions or concerns about source testing submissions can be sent to the PSIMS Administrator (RA-EPstacktesting@pa.gov).

(2). The following pertinent information shall be listed on the title page of source test submissions.

1. Test Date(s)

- a. For protocols, provide the proposed date on which testing will commence or "TBD"
- b. For reports, provide the first and last day of testing

2. Facility Identification Number (Facility - ID): For test programs that were conducted under a multi-site protocol, also include the PF ID under which the protocol was stored in PSIMS, as indicated in the protocol response letter.

3. Source ID(s) for the applicable source(s) and air pollution control device(s): The term Source ID is used in the permit but "Other Id" is used in the Department electronic systems. They are the same number and must also be listed for control equipment.

4. Operating permit number.

**III. MONITORING REQUIREMENTS.**

**# 004 [25 Pa. Code §127.441]**

**Operating permit terms and conditions.**

The owner or operator shall monitor the amount of fuel that is consumed by this source on a monthly basis when this source is in operation.

**# 005 [25 Pa. Code §127.441]**

**Operating permit terms and conditions.**

The owner or operator of this regenerative thermal oxidizer shall continuously monitor the temperature of the combustion zone when this source is in operation.



**SECTION D. Source Level Requirements****IV. RECORDKEEPING REQUIREMENTS.****# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The owner or operator shall record the amount of fuel that is consumed by this source on a monthly basis when this source is in operation.

**# 007 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The owner or operator shall keep on file the as built drawings and as built manufacturer's specifications for this source to demonstrate compliance with the applicable residence time limit in Condition #002 (b) for this source.

**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.****# 008 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The owner or operator of this source shall ensure that this regenerative thermal oxidizer is preheated to 1,525 degrees Fahrenheit or to the minimum combustion zone temperature determined as a result of a current Department approved stack test prior to introducing exhausts from the processes associated with this thermal oxidizer. The allowable minimum combustion zone temperature shall be maintained throughout the duration of grinding and roasting activities in Source ID Nos. 145 and 148 and until at least 5 minutes after all grinding and roasting activities from Source ID Nos. 145 and 148 have been completed.

**# 009 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The regenerative thermal oxidizer shall be equipped with a temperature monitoring and recording device, which continuously measures, indicates, and records the combustion zone temperature according to the manufacturer's specifications. The temperature monitoring device shall be installed in the combustion zone or in the ductwork immediately downstream of the combustion zone in a position before any substantial heat exchange occurs.

**# 010 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall operate this Regenerative Thermal Oxidizer (RTO) when the sources controlled by this RTO are in operation.

**# 011 [25 Pa. Code §129.97]****Presumptive RACT requirements, RACT emission limitations and petition for alternative compliance schedule.**

[Additional authority for this permit condition is also derived from 25 Pa. Code Section 129.112.]

The permittee shall install, maintain, and operate each source in accordance with the manufacturer's specifications and good operating practices.

**VII. ADDITIONAL REQUIREMENTS.****# 012 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The owner or operator shall operate an Anguil Environmental Systems, Inc. Model No. 75 regenerative thermal oxidizer or equivalent with a design inlet volume flow rate of 8,000 scfm.



**SECTION D. Source Level Requirements**

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

**SECTION E. Source Group Restrictions.**

Group Name: GRINDERS

Group Description: Grinder Group

Sources included in this group

ID	Name
108	LINE 2 GRINDER
118A	LINE 3 GRINDER
132A	LINE 1 GRINDER

**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 in excess of 0.04 grains per dry standard cubic foot, pursuant to 25 Pa. Code Section 123.13(c)(1)(i).

**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 E. Source Group Restrictions.**

Group Name: LINE 4 BAGHOUSE

Group Description: Requirements for baghouse associated with Source ID Nos. 144 and 151.

Sources included in this group

ID	Name
144	LINE 4 WINNOWER
151	LINE 4 ASPIRATION BOX

**I. RESTRICTIONS.****Emission Restriction(s).****# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

No person may permit the emission into the outdoor atmosphere of particulate matter in excess of 0.01 grains per dry standard cubic foot.

[Compliance with the condition above also demonstrates compliance with the applicable requirements from 25 Pa. Code § 123.13(c)(1)(i) and Best Available Technology (BAT).]

**Control Device Efficiency Restriction(s).****# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall maintain the pressure differential across the baghouse associated with this source between 0.1 and 5.5 inches water gauge.

**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 §127.441]****Operating permit terms and conditions.**

The owner or operator shall monitor the static pressure drop across the baghouse(s) on a weekly basis when this source is in operation.

**IV. RECORDKEEPING REQUIREMENTS.****# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a). The owner or operator shall keep records of the static pressure drop across the baghouse(s) on a weekly basis when this source is in operation.

(b). The owner or operator shall keep records of the following on a weekly basis:

- (1). Inspections made to the baghouse(s).
- (2). Repairs made to the baghouse(s) and items that were replaced in the baghouse(s).
- (3). Bag failure (location and frequency) in the baghouse(s).
- (4). Frequency of bag cleaning.

**V. REPORTING REQUIREMENTS.**

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

**SECTION E. Source Group Restrictions.****VI. WORK PRACTICE REQUIREMENTS.****# 005 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

To ensure proper operation of the baghouse(s), the owner or operator shall perform inspections and maintenance of the baghouse(s) on a weekly basis. The inspections shall include, but are not limited to the following items:

- (a). Bags.
- (b). Tube sheets.
- (c). Hopper.
- (d). Bag cages.
- (e). Valves used for compressed air.
- (f). Integrity of the baghouse structure (no holes in the structure in which ambient air can enter the baghouse).
- (g). Floor of the clean side of the baghouse.

**# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The owner or operator of this source and associated dust collector shall keep on hand a sufficient quantity of spare fabric filters for the dust collector in order to immediately replace any fabric filters that require replacement due to deterioration resulting from the routine operation of the dust collector.

**VII. ADDITIONAL REQUIREMENTS.****# 007 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The baghouse associated with this source shall be a MAC Model No. 120MCF255 (or equivalent) with a capacity of 17,000 acfm.

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

**SECTION E. Source Group Restrictions.**

Group Name: MICRONIZERS  
 Group Description: Micronizer Group  
 Sources included in this group

ID	Name
131A	LINE 2/3 MICRONIZER & BUCKET ELEVATOR

**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 in excess of 0.04 grains per dry standard cubic foot, pursuant to 25 Pa. Code Section 123.13(c)(1)(i).

**# 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 SO<sub>2</sub>, in the effluent gas exceeds 500 parts per million, by volume, dry basis, pursuant to 25 Pa. Code Section 123.21(b).

**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 §127.441]****Operating permit terms and conditions.**

The permittee shall monitor the following on a monthly basis:

- (a). The type of fuel used.
- (b). The amount of fuel used.
- (c). The hours of operation.
- (d). The amount of beans processed by the micronizer.

**IV. RECORDKEEPING REQUIREMENTS.****# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a). The permittee shall keep records for the following on a monthly basis:

- (1). The type of fuel used.
  - (2). The amount of fuel used.
  - (3). The hours of operation.
  - (4). The amount of beans processed by the micronizer.
- (b). The owner or operator shall calculate and record the amount of particulate matter, sulfur dioxide, nitrogen oxides, carbon monoxide, and volatile organic compound emissions from this source on a monthly basis.
- (c). The owner or operator shall calculate and record the total amount of fuel used, the total hours of operation, the total amount of cocoa beans processed, and the total amount of each pollutant emitted from this source on a 12-month rolling sum basis.

**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: MILL COLLECTORS

Group Description: Mill Collectors

Sources included in this group

ID	Name
119	MILL COLLECTOR 1
120	MILL COLLECTOR 2
121	MILL COLLECTOR 3

**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 in excess of 0.04 grains per dry standard cubic foot, pursuant to 25 Pa. Code Section 123.13(c)(1)(i).

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

# 002 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

The permittee shall maintain the pressure drop across this baghouse between 0.1 inches of water gauge and 8 inches of water gauge.

**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 §127.441]

**Operating permit terms and conditions.**

The permittee shall monitor the static pressure drop across the baghouse(s) on a weekly basis when this source is in operation.

**IV. RECORDKEEPING REQUIREMENTS.**

# 004 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

(a). The permittee shall keep records of the static pressure drop across the baghouse(s) on a weekly basis when this source is in operation.

(b). The permittee shall keep records of the following on a weekly basis:

- (1). Inspections made to the baghouse(s).
- (2). Repairs made to the baghouse(s) and items that were replaced in the baghouse(s).
- (3). Bag failure (location and frequency) in the baghouse(s).
- (4). Frequency of bag cleaning.

**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 §127.441]

**Operating permit terms and conditions.**

The permittee shall keep on hand a sufficient quantity of spare fabric collector bags for the fabric collector(s) associated with this source in order to be able to immediately replace any bags requiring replacement due to deterioration resulting



**SECTION E. Source Group Restrictions.**

from routine operation of this source and fabric collector(s).

**# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

To ensure proper operation of the baghouse(s), the permittee shall perform inspections and maintenance of the baghouse(s) on a weekly basis. The inspections shall include, but are not limited to the following items:

- (a). Bags.
- (b). Tube sheets.
- (c). Hopper.
- (d). Bag cages.
- (e). Valves used for compressed air.
- (f). Integrity of the baghouse structure (no holes in the structure in which ambient air can enter the baghouse).
- (g). Floor of the clean side of the baghouse.

**# 007 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The fabric collector(s) must be equipped with a device for monitoring the pressure drop across the collector(s).

**# 008 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The storage and handling of the material collected in the fabric collector shall not at any time result in the emission of fugitive air contaminants in excess of the limitations specified in 25 Pa. Code § 123.1 and Section C - Condition #002 of this permit.

**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: RACT II &amp; III A

Group Description: Alternative Case-by-Case RACT II &amp; III WPS Requirement

**Sources included in this group**

ID	Name
105	LINE 2 ROASTER
108	LINE 2 GRINDER
109	LINE 1 ROASTER
118A	LINE 3 GRINDER
124A	ALKALIZATION PROCESSES
125	LINE 3 ROASTER
132A	LINE 1 GRINDER
143	LINE 4 MICRONIZER
147	LINE 4 COOLER

**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.****# 001 [25 Pa. Code §129.99]****Alternative RACT proposal and petition for alternative compliance schedule.**

The permittee shall install, maintain and operate each source in accordance with the manufacturer's specifications and with good operating practices.

[Compliance with this condition assures compliance with 25 Pa. Code § 129.114.]

**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: RACT II &amp; III B

Group Description: Presumptive RACT II &amp; III WPS Requirement

Sources included in this group

ID	Name
033	HURST BOILER NO. 1
034	HURST BOILER NO. 2
107	LINE 2 COOLER
110A	LINE 1 FEED HOPPER
110B	LINE 1 RETENTION CHAMBER
131A	LINE 2/3 MICRONIZER & BUCKET ELEVATOR
135	LINE 1 WINNOWER
142	LINE 2 ALKALIZATION MIXER
144	LINE 4 WINNOWER
700	EMERGENCY GENERATOR

**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.****# 001 [25 Pa. Code §129.97]****Presumptive RACT requirements, RACT emission limitations and petition for alternative compliance schedule.**

The permittee shall install, maintain and operate each source in accordance with the manufacturer's specifications and with good operating practices.

[Compliance with this condition assures compliance with 25 Pa. Code § 129.112.]

**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: ROASTERS

Group Description: Roaster Group

Sources included in this group

ID	Name
109	LINE 1 ROASTER
125	LINE 3 ROASTER

**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 in excess of 0.04 grains per dry standard cubic foot, pursuant to 25 Pa. Code Section 123.13(c)(1)(i).

**# 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 SO<sub>2</sub>, in the effluent gas exceeds 500 parts per million, by volume, dry basis, pursuant to 25 Pa. Code Section 123.21(b).

**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 §127.441]****Operating permit terms and conditions.**

The permittee shall monitor the following on a monthly basis:

- (a). The type of fuel used.
- (b). The amount of fuel used.
- (c). The hours of operation.

**IV. RECORDKEEPING REQUIREMENTS.****# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a). The permittee shall keep records of the following on a monthly basis:

- (1). The type of fuel used.
- (2). The amount of fuel used.
- (3). The hours of operation.

(b). The owner or operator shall calculate and record the amount of particulate matter, sulfur dioxide, nitrogen oxides, carbon monoxide, and volatile organic compound emissions from this source on a monthly basis.

(c). The owner or operator shall calculate and record the total amount of fuel used, the total hours of operation, the total amount of cocoa beans processed, and the total amount of each pollutant emitted from this source on a 12-month rolling sum basis.

**V. REPORTING REQUIREMENTS.**

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

**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).

**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: UNLOADING  
 Group Description: Bean Unloading  
 Sources included in this group

ID	Name
129	BEAN UNLOADING 1
130	BEAN UNLOADING 2

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

No person may permit the emission into the outdoor atmosphere of particulate matter from this source at any time, in excess of 0.04 grains per dry standard cubic foot, pursuant to 25 Pa. Code Section 123.13(c)(1)(i).

**Control Device Efficiency Restriction(s).****# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall maintain the pressure drop across this baghouse between 0.1 inches of water gauge and 8 inches of water gauge.

**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 §127.441]****Operating permit terms and conditions.**

The permittee shall monitor the static pressure drop across the baghouse(s) on a weekly basis when this source is in operation.

**IV. RECORDKEEPING REQUIREMENTS.****# 004 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a). The permittee shall keep records of the static pressure drop across the baghouse(s) on a weekly basis when this source is in operation.

(b). The permittee shall keep records of the following on a weekly basis:

- (1). Inspections made to the baghouse(s).
- (2). Repairs made to the baghouse(s) and items that were replaced in the baghouse(s).
- (3). Bag failure (location and frequency) in the baghouse(s).
- (4). Frequency of bag cleaning.

**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 §127.441]****Operating permit terms and conditions.**

To ensure proper operation of the baghouse(s), the permittee shall perform inspections and maintenance of the baghouse(s) on a weekly basis. The inspections shall include, but are not limited to the following items:

**SECTION E. Source Group Restrictions.**

- (a). Bags.
- (b). Tube sheets.
- (c). Hopper.
- (d). Bag cages.
- (e). Valves used for compressed air.
- (f). Integrity of the baghouse structure (no holes in the structure in which ambient air can enter the baghouse).
- (g). Floor of the clean side of the baghouse.

**# 006 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

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

**# 007 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The storage and handling of the material collected in the fabric collector shall not at any time result in the emission of fugitive air contaminants in excess of the limitations specified in 25 Pa. Code § 123.1 and Section C - Condition #002 of this permit.

**# 008 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The fabric collector(s) must be equipped with a device for monitoring the pressure drop across the collector(s).

**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: WINNOWERS

Group Description: Winnower Group

Sources included in this group

ID	Name
117A	LINE 2/3 WINNOWER
135	LINE 1 WINNOWER

**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.****# 001 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

The permittee shall monitor the static pressure drop across the baghouse(s) on a weekly basis when this source is in operation.

**IV. RECORDKEEPING REQUIREMENTS.****# 002 [25 Pa. Code §127.441]****Operating permit terms and conditions.**

(a). The permittee shall keep records of the static pressure drop across the baghouse(s) on a weekly basis when this source is in operation.

(b). The permittee shall keep records of the following on a weekly basis:

- (1). Inspections made to the baghouse(s).
- (2). Repairs made to the baghouse(s) and items that were replaced in the baghouse(s).
- (3). Bag failure (location and frequency) in the baghouse(s).
- (4). Frequency of bag cleaning.

**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 §127.441]****Operating permit terms and conditions.**

To ensure proper operation of the baghouse(s), the permittee shall perform inspections and maintenance of the baghouse(s) on a weekly basis. The inspections shall include, but are not limited to the following items:

- (a). Bags.
- (b). Tube sheets.
- (c). Hopper.
- (d). Bag cages.
- (e). Valves used for compressed air.
- (f). Integrity of the baghouse structure (no holes in the structure in which ambient air can enter the baghouse).
- (g). Floor of the clean side of the baghouse.



**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 F. Alternative Operation Requirements.**

No Alternative Operations exist for this Title V facility.

**SECTION G. Emission Restriction Summary.**

Source Id	Source Description		
033	HURST BOILER NO. 1		
<b>Emission Limit</b>		<b>Pollutant</b>	
300.000	PPMV	3 % O <sub>2</sub> ; dry standard conditions	CO
30.000	PPMV	3% O <sub>2</sub> ; dry standard conditions	NOX
1.200	Lbs/MMBTU		SOX
0.400	Lbs/MMBTU		TSP
034	HURST BOILER NO. 2		
<b>Emission Limit</b>		<b>Pollutant</b>	
300.000	PPMV	at 3% O <sub>2</sub> ; dry standard conditions	CO
30.000	PPMV	at 3% O <sub>2</sub> ; dry standard conditions	NOX
1.200	Lbs/MMBTU		SOX
0.400	Lbs/MMBTU		TSP
105	LINE 2 ROASTER		
<b>Emission Limit</b>		<b>Pollutant</b>	
0.040	gr/DRY FT <sup>3</sup>		TSP
10.410	Tons/Yr	on a 12-month rolling sum basis	VOC
106	LINE 2 ROASTER BURNER		
<b>Emission Limit</b>		<b>Pollutant</b>	
500.000	PPMV	dry standard conditions	SOX
0.040	gr/CF	dry standard conditions	TSP
0.090	Tons/Yr	on a 12-month rolling sum basis	VOC
107	LINE 2 COOLER		
<b>Emission Limit</b>		<b>Pollutant</b>	
0.040	gr/CF	dry standard conditions	TSP
1.910	Tons/Yr	on a 12-month rolling sum basis	VOC
108	LINE 2 GRINDER		
<b>Emission Limit</b>		<b>Pollutant</b>	
0.040	gr/CF	dry standard conditions	TSP
4.680	Tons/Yr	on a 12-month rolling sum basis	VOC
109	LINE 1 ROASTER		
<b>Emission Limit</b>		<b>Pollutant</b>	
500.000	PPMV	dry standard conditions	SOX
0.040	gr/CF	dry standard conditions	TSP
110A	LINE 1 FEED HOPPER		
<b>Emission Limit</b>		<b>Pollutant</b>	
0.040	gr/CF	dry standard conditions	TSP

**SECTION G. Emission Restriction Summary.**

Source Id	Source Descriptor		
110B	LINE 1 RETENTION CHAMBER		
<b>Emission Limit</b>			
0.040	gr/CF	dry standard conditions	TSP
113 A	BEAN CLEANING - UPGRADE A		
<b>Emission Limit</b>			
0.020	gr/CF		TSP
117A	LINE 2/3 WINNOWER		
<b>Emission Limit</b>			
0.020	gr/DRY FT3		TSP
0.870	Tons/Yr	a 12-month rolling sum basis	VOC
118A	LINE 3 GRINDER		
<b>Emission Limit</b>			
0.040	gr/CF	dry standard conditions	TSP
7.780	Tons/Yr	on a 12-month rolling sum basis	VOC
119	MILL COLLECTOR 1		
<b>Emission Limit</b>			
0.040	gr/CF	dry standard conditions	TSP
120	MILL COLLECTOR 2		
<b>Emission Limit</b>			
0.040	gr/CF	dry standard conditions	TSP
121	MILL COLLECTOR 3		
<b>Emission Limit</b>			
0.040	gr/CF	dry standard conditions	TSP
122	RED CAKE QUAD BIN 1-4		
<b>Emission Limit</b>			
0.040	gr/CF	dry standard conditions	TSP
124A	ALKALIZATION PROCESSES		
<b>Emission Limit</b>			
13.050	Tons/Yr	on a 12-month rolling sum basis	VOC
125	LINE 3 ROASTER		
<b>Emission Limit</b>			
500.000	PPMV	dry standard conditions	SOX
0.040	gr/CF	dry standard conditions	TSP
21.310	Tons/Yr	on a 12-month rolling sum basis	VOC

**SECTION G. Emission Restriction Summary.**

Source Id	Source Descriptor		
126	LOW FAT SHELL BIN		
<b>Emission Limit</b>		<b>Pollutant</b>	
0.040	gr/CF	dry standard conditions	TSP
127	HIGH FAT SHELL BIN		
<b>Emission Limit</b>		<b>Pollutant</b>	
0.020	gr/DRY FT3		TSP
2.250	Tons/Yr	on a 12-month rolling sum basis	TSP
128	SUGAR SILOS (2 TOTAL)		
<b>Emission Limit</b>		<b>Pollutant</b>	
0.040	gr/CF	dry standard conditions	TSP
129	BEAN UNLOADING 1		
<b>Emission Limit</b>		<b>Pollutant</b>	
0.040	gr/CF	dry standard conditions	TSP
130	BEAN UNLOADING 2		
<b>Emission Limit</b>		<b>Pollutant</b>	
0.040	gr/CF	dry standard conditions	TSP
131A	LINE 2/3 MICRONIZER & BUCKET ELEVATOR		
<b>Emission Limit</b>		<b>Pollutant</b>	
500.000	PPMV	dry standard conditions	SOX
0.040	gr/CF	dry standard conditions	TSP
2.600	Tons/Yr	on a 12-month rolling sum basis	VOC
132A	LINE 1 GRINDER		
<b>Emission Limit</b>		<b>Pollutant</b>	
0.040	gr/CF	dry standard conditions	TSP
5.500	Tons/Yr	based on a 12-month rolling sum	VOC
135	LINE 1 WINNOWER		
<b>Emission Limit</b>		<b>Pollutant</b>	
0.040	gr/DRY FT3		TSP
142	LINE 2 ALKALIZATION MIXER		
<b>Emission Limit</b>		<b>Pollutant</b>	
1.080	Tons/Yr	on a 12-month rolling sum basis	VOC
143	LINE 4 MICRONIZER		
<b>Emission Limit</b>		<b>Pollutant</b>	
500.000	PPMV	dry standard conditions	SOX
0.040	gr/DRY FT3		TSP
3.290	Tons/Yr	on a 12-month rolling sum basis	VOC

**SECTION G. Emission Restriction Summary.**

Source Id	Source Description			
144	LINE 4 WINNOWER			
<b>Emission Limit</b>				<b>Pollutant</b>
0.010	gr/DRY FT3			TSP
1.100	Tons/Yr	on a 12-month rolling sum basis		VOC
145	LINE 4 ROASTER			
<b>Emission Limit</b>				<b>Pollutant</b>
0.700	Tons/Yr	on a 12-month rolling sum basis		VOC
146	LINE 4 ROASTER BURNER			
<b>Emission Limit</b>				<b>Pollutant</b>
500.000	PPMV	dry standard conditions		SOX
0.040	gr/DRY FT3			TSP
0.290	Tons/Yr	on a 12-month rolling sum basis		VOC
147	LINE 4 COOLER			
<b>Emission Limit</b>				<b>Pollutant</b>
6.420	Tons/Yr	on a 12-month rolling sum basis		VOC
148	LINE 4 GRINDING			
<b>Emission Limit</b>				<b>Pollutant</b>
0.320	Tons/Yr	on a 12-month rolling sum basis		VOC
150	LINE 2/3 ASPIRATION BOX			
<b>Emission Limit</b>				<b>Pollutant</b>
0.010	gr/DRY FT3			TSP
151	LINE 4 ASPIRATION BOX			
<b>Emission Limit</b>				<b>Pollutant</b>
0.010	gr/DRY FT3			TSP
152	LINE 2 COLLECTOR			
<b>Emission Limit</b>				<b>Pollutant</b>
0.090	Tons/Yr	on a 12-month rolling sum basis		VOC
153	LINE 4 COLLECTOR			
<b>Emission Limit</b>				<b>Pollutant</b>
0.290	Tons/Yr	on a 12-month rolling sum basis		VOC

**SECTION G. Emission Restriction Summary.**

Source Id	Source Description
154	LINE 4 MATERIAL HANDLING SOURCES
<b>Emission Limit</b>	
0.010 gr/DRY FT3	Pollutant TSP
155	LINE 1 ASPIRATION CHANNEL
<b>Emission Limit</b>	
0.010 gr/DRY FT3	Pollutant TSP
700	EMERGENCY GENERATOR
<b>Emission Limit</b>	
500.000 PPMV	dry standard conditions SOX
0.040 gr/DRY FT3	TSP

**Site Emission Restriction Summary**

Emission Limit	Pollutant
----------------	-----------

**SECTION H. Miscellaneous.**

## (1). Insignificant Activities

The Department has determined that the emissions from the following activities, excluding those indicated as site level requirements, in Section C, of this permit, do not require additional limitations, monitoring, or recordkeeping:

- (a). Deodorizing.
- (b). Five Kibbled Cocoa Bins with Bin Vent Bag Filters.
- (c). Mill Collector No. 4 (closed vent; air is recirculated in collector).
- (d). A continuous railcar sugar unloading system comprising:
  - a vacuum filter receiver with 8 filter bags
  - a blower with an in-line filter cartridge
  - lump breaker
  - surge hopper
  - broken bag detection and interlock system
- (e). Scale Hopper and Scale Hopper Baghouse (Source IDs 115 and C115)

(2). APS #: 346422; Authorization #: 383264. This permit was revised to incorporate changes as per an administrative amendment. The following items have been changed in the permit:

- (a). Permit Contact name.
- (b). Pressure drop ranges across all baghouses in the facility were changed to the specifications of the manufacturer.
- (c). Water flow rates through the BT Scrubber.
- (d). Language was placed into the permit for the Red Cake Quad Bin baghouses (Source ID No. C122) that states the control consists of 4 total baghouses.
- (e). The permit mapping for the Line 1 Winnower and Low Fat Shell Bins (Source ID Nos. 135 and 126) was corrected.
- (f). The language of the permit was changed to indicate that there were two sugar silos at the facility.
- (g). The Line 1 Roaster Skin Exhaust was removed from the permit because the stack was removed from the facility.
- (h). Compliance schedule dates were changed to try to match what the Department is doing.
- (i). The name of the dutching reactors was changed to "alkalization processes."
- (j). A nuisance dust collector and bucket elevators were added to the Line 3 Micronizer as per RFD 46-A01-1833.
- (k). Five Kibbled Cocoa Bins and their bin vent filters were added to the insignificant sources list in Section G as per RFD 46-A01-1812.
- (l). Some terms and conditions were incorporated into this Title V Permit from plan approval PA-46-0198.

(3). APS #: 346422; Authorization #: 516535. This permit has been revised to incorporate conditions from Plan Approval PA-46-0198D for Source ID 113 (Bean Cleaning) and its associated baghouse (Source ID No. C113). The following changes have been made to the Title V Permit:

- (a). The particulate matter emissions limit has been changed from 0.04 gr/dscf to 0.02 gr/dscf.
- (b). Work practice standards for equipping the baghouse with a pressure gauge, keeping fabric collector bags on hand, and storage and handling of materials were added to the permit.
- (c). Monitoring and recordkeeping of the process production and usage of raw materials were added to the permit.

(4). APS No. 346422; Authorization No. 573292 - This permit has been revised in accordance with 25 Pa. Code § 127.462(b) to remove a Line 1 Spark Arrestor (Source ID No. 110) and replace the source with a Line 1 Feed Hopper (Source ID No. 110A) and a Line 1 Retention Chamber (Source ID No. 110B). There is no increase of emissions resulting from this change, and the monitoring and record keeping remain the same.

The parts washer was made a source and the applicable requirements of 25 Pa. Code § 129.63(a) were added to the source.

(5). APS No. 346422; Authorization No. 640385: Title V Renewal Permit. Some revisions were made to add the Hurst Boiler No. 1 from 46-302-227GP and Hurst Boiler No. 2 from 46-302-233GP to Section D and the mill collector from RFD 46-AO1-2096 as an insignificant source, rename Source ID No. 106 for clarity, and remove duplicate Source ID Nos. 139 and 140, and remove Source ID No. 032 from the permit (inactivated source). A condition was added to record the findings when the facility is monitored for odors, visible emissions, and fugitive particulate matter emissions. A condition was added to specify April 1 of each year as the date by which a compliance certification for the previous calendar year is submitted to the Department. The contact phone number for the Department has changed, and the new contact number was added to the condition on reporting malfunctions to the



**SECTION H. Miscellaneous.**

Department. The conditions from PA-46-0198J were incorporated into this Title V Permit through an administrative amendment in accordance with 25 Pa. Code Section 127.450(a)(5).

- (6). APS No. 346422; Authorization No. 748214: The Title V Permit was modified to incorporate plan approvals 46-0198K, 46-0198L, and 46-0198M in accordance with 25 Pa. Code Section 127.450(a)(5). These plan approvals were issued for an expansion project which involved the installation of sources for a new production line, Line 4, and the modification of existing Production Lines 2 and 3 to share a micronizer, an aspiration box, and a winnower prior to dividing off into dedicated types of production for this facility. Language was added to some sources with baghouses to assure that sufficient bags were available to replace bags when needed. The temperature for the Regenerative Thermal Oxidizer and the pressure drop ranges for the Line 4 Winnower and Aspiration Box Baghouse and the 2/3 Aspiration Box Baghouse were established and placed into this operating permit.
- (7). The information in Section F is a summary of the restrictions placed on the facility and each source at the facility. This summary is for informational purposes only, and this summary does not impose further restrictions other than those already indicated in Sections C and D of this permit.
- (8). APS No. 660068; Authorization No. 850649: The Title V Permit was revised to incorporate plan approval 46-0198N for a Nuisance Dust Collector on Production Line 4 in accordance with the requirements of 25 Pa. Code Section 127.450(a)(5).
- (9). APS No. 346422; Authorization No. 913886: The Title V Permit was revised to incorporate plan approval 46-0198O for the addition of a dust collector on the Line 1 Aspiration Box (Source ID Nos. 155 and C155). This administrative amendment was performed in accordance with 25 Pa. Code Section 127.450(a)(5).
- (10). APS No. 346422; Authorization No. 928876: This action is for the renewal of the Title V Operating Permit for Blommer Chocolate Company. In this action, language was added to the permit under the RTO (Source ID No. C001) to address issues with low loading of VOC into the RTO, which allows the concentration of VOC from the RTO to be less than or equal to 20 ppm<sub>dv</sub>, as methane (6 ppm<sub>dv</sub> as propane) if a destruction efficiency of 98% cannot be achieved. The requirements of 40 C.F.R. Part 63, Subpart ZZZZ was applied to the emergency generator (Source ID No. 700) located at this facility. An analysis was performed on the data collected for pressure drops across dust collectors, and the frequency of monitoring and recordkeeping was changed from daily to weekly as a result of this analysis.
- (11). APS No. 346422; Authorization No. 1156504: Significant Modification to address RACT II.
- (a) The permit has been revised to incorporate Alternative RACT II requirements for the following sources in accordance with 25 Pa. Code § 129.99: Source ID 105 (Line Roaster), Source ID 108 (Line 2 Grinder), Source ID 109 (Line 1 Roaster), Source ID 118A (Line 3 Grinder), Source ID 124A (Alkalization Processes), Source ID 125 (Line 3 Roaster), Source ID 132A (Line 1 Grinder), Source ID 143 (Line 4 Micronizer), Source ID 147 (Line 4 Cooler).
- (b) The permit has been revised to incorporate Presumptive RACT II requirements for the following sources in accordance with 25 Pa. Code § 129.97: Source ID 107 (Line 2 Cooler), Source ID 110A/110B (Line 1 Feed Hopper/Retention Chamber), Source ID 131A (Line 2/3 Micronizer & Bucket Elevator Process and Combustion), Source ID 135 (Line 1 Winnower), Source ID 142 (Line 2 Alkalization Mixer), Source ID 144 (Line 4 Winnower), Source ID 033 (Hurst Boiler No. 1), Source ID 034 (Hurst Boiler No. 2), Source ID 109 (Line 1 Roaster Combustion), Source ID 125 (Line 3 Roaster Combustion), Source ID 143 (Line 4 Micronizer), Source ID 700 (Emergency Generator), Source ID C001 (RTO).
- (c) The responsible official has been updated from Chris Milligan (Continuous Improvement Manager) to Michael Krieger (Operations Manager).
- (12) APS No. 346422; Authorization No. 1187206. October, 2018. The Operating Permit is renewed.
- The following changes were made with the renewal. Condition numbers refer to the current issuance.
- (a) Bean Cleaning, Source ID 113 was removed from the Section A Site Inventory and Permit maps and replaced with Bean Cleaning Upgrade A (Source ID 113A). Conditions in Section D for Source 113 were removed and replaced with a reference to follow the requirements of Plan Approval 46-0198P. The company is authorized to operate an upgraded Bean Cleaning process under Plan Approval 46-0198P. Plan Approval 46-0198P was incorporated by reference in Section C Condition #024.
- (b) Infrastructure for the alternate fuel propane, FML02, was removed from the facility. FML02 was removed from the Section A Site Inventory and permit maps, and from the section D fuel restriction, monitoring and recordkeeping conditions for the following sources: 033, 034, 106, 109, 125, 131A, 143, 146 and C001.

**SECTION H. Miscellaneous.**

(c) Names of the following stacks in Section A Site Inventory and permit maps were changed for consistency with the sources discharging to them: S06, S108, S117, S126A, S131, S137, S144A, Z111.

(d) C118 was added to the Section A permit map of Source 118A.

(e) RFD's 907 and 6921 were incorporated.

907 – a scale hopper with an atmospheric bin vent controlled by a filter. The source was listed with other units comprising the Alkylation Processes Source ID, 124A in Section D

6921- a new railcar continuous sugar unloading system, which includes  
a vacuum filter receiver with 8 filter bags  
a blower with an in-line filter cartridge  
lump breaker  
surge hopper  
broken bag detection and interlock system

was added to the insignificant sources in Section G

(f) Section C changes

The following standard conditions were updated to reflect current DEP guidelines:

#002 - This condition lists the sources from which fugitive emissions are allowed in accordance with 25 Pa. Code 123.1. Blasting in open pit mines, and coke oven batteries were added to the list in the permit in order to correspond to the list in the regulation.

#003 - This condition prohibits fugitive emissions, allowed in Condition #002, from leaving the property line of the owner on which the source is operated. The references to Condition #002 were re-numbered to correspond to the additions to Condition #002.

#006 – This condition describes the exceptions to the applicability of visible emissions restrictions, in accordance with 25 Pa. Code Section 123.42. The condition was revised to include only the cases of uncombined water and emissions resulting from emissions specified in Condition #002, in accordance with current DEP guidelines. Emissions from opacity training or agricultural commodities, as also specified in the regulation, are not applicable to this facility.

#007 – This condition lists the exceptions to the open burning prohibition, in accordance with 25 Pa. Code Section 129.14(c). Two additional sources, agricultural commodities and domestic refuse, were added to the Condition to correspond to the list in the regulation.

#020 (a) – This condition specifies that each source is to be operated in accordance with manufacturer's specifications and with good operating practices. To conform to the DEP standard condition and to be more inclusive, "and control devices" was added to the condition.

Also the authority of RACT II 25 Pa. Code Section 129.97(c) was added.

References to Section B conditions in the following Section C conditions were re-numbered.

#015, #023

(g) Section D changes

Source ID 108

Conditions #002, #003 and #004

the outdated source name "Line 2 Grinder No. 1 and Line 2 Grinder No. 2" was replaced in the conditions with the current source name "Line 2 Grinder."

Source ID 111

Condition #001

"Material Safety Data Sheets (MSDS)" was replaced by "Safety Data Sheets (SDS)" in the condition since SDS have replaced MSDS in actual practice.

Source ID 117A

Condition #001(b), #009

The reference to the source name in these conditions was changed to "Line 2/3 Winnower" to correspond to the source name.

Source ID 127

**SECTION H. Miscellaneous.**

Conditions for this source include weekly pressure drop monitoring and recording for the associated baghouse but no allowable pressure drop range. The company has indicated that the baghouse associated with this source (C127) is most like the baghouse (C129) associated with Source ID 129. Since C129 has a pressure drop range of 0.1 - 8 in. w.c., this range was set for C127 as well.

Source ID 700  
Condition #004

\*The condition was re-worded to conform more closely to the language in 40 CFR Part 63 Subpart ZZZZ.

\*This condition allows the IC engine to operate for 50 hours per calendar year for non-emergency reasons, subject to certain restrictions. The condition was corrected to specify that the 50 hours allowed are counted in the 100 hours per year allowed for maintenance and testing.

Condition #006, #008

The US Court of Appeals on May 1, 2016 vacated 40 CFR Sections 6640(f)(2)(ii)-(iii), allowing use of emergency engines for emergency demand response. "Emergency demand response" was therefore removed from the conditions and replaced with use as provided in 40 CFR Section 63.6640(f)(4).

Condition #020

The condition specifying the compliance date (May 3, 2013) was removed since the date is past. Compliance has been demonstrated.

Source ID C001  
Condition #003

\*Testing of the RTO was included for once in 5 years, in accordance with the Department's new standard condition. The condition includes submission of protocols 90 days in advance of testing, waiver of protocol under certain conditions, an allowance to request additional time for deliverables.

\*Additional

The presumptive RACTII good work practice condition pursuant to 25 Pa. Code Section 197.97(c)(6) was added.

(h) Section G changes

The Emergency Generator was removed from the insignificant activities (1), since the applicable conditions are now in Section D.

(13) APS No. 346422 AUTH No. 1280174 September 2019

The Operating Permit is amended for a change in responsible official to Drew Hoben.

(14) APS No. 346422 AUTH No. 1340198 December 2021

Significant Modification to the Operating Permit for incorporating Plan Approval No. 46-0198P into the permit.

(15) APS No.346422 AUTH No. 1424547 January 2024

- The Operating Permit is renewed.

- Source ID 115 (Scale Hopper), determined to be an insignificant emission source during the initial Title V Operating Permit review, is moved from Section D to Section H, of the Permit.

- The alternative case-by-case RACT III requirement citations are incorporated for the following sources in accordance with 25 Pa. Code § 129.114 and RACT II = RACT III review:

Source ID 105 Line 1 Roaster,  
Source ID 108 Line 2 Grinder,  
Source ID 109 Line 1 Roaster,  
Source ID 118A Line 3 Grinder,  
Source ID 124A Alkanization Processes,  
Source ID 125 Line 3 Roaster,  
Source ID 132A Line 1 Grinder,  
Source ID 143 Line 4 Micronizer, and  
Source ID 147 Line 4 Cooler.

- The presumptive RACT III requirement citations are incorporated for the following sources in accordance with 25 Pa. Code § 129.112:

Source ID 107 Line 2 Cooler,

**SECTION H. Miscellaneous.**

Source ID 110A/110B Line 1 Feed Hopper/Retention Chamber,  
Source ID 131A Line 2/3 Micronizer & Bucket Elevator (Process),  
Source ID 135 Line 1 Winnower,  
Source ID 142 Line 2 Alkanization Mixer,  
Source ID 144 Line 4 Winnower,  
Source ID 033 Hurst Boiler No. 1,  
Source ID 034 Hurst Boiler No. 2,  
Source ID 700 Emergency Generator – Internal Combustion Engine (ICE), and  
Source ID C001 Regenerative Thermal Oxidizer (RTO).



\*\*\*\*\* End of Report \*\*\*\*\*

---