





## 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 Compliance Certification
- #025 Recordkeeping Requirements
- #026 Reporting Requirements
- #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

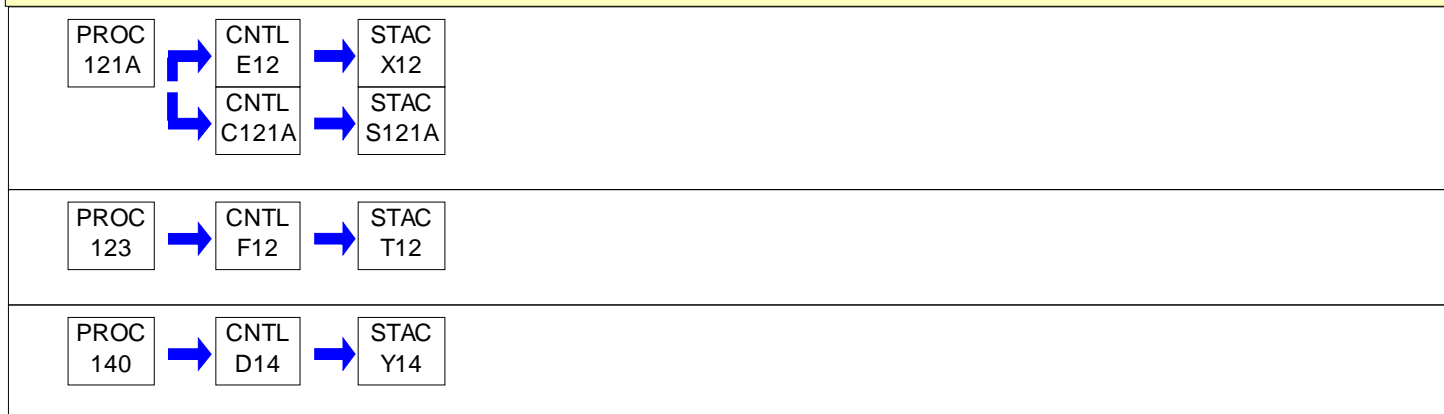
### Section H. Miscellaneous

**SECTION A. Site Inventory List**

Source ID	Source Name	Capacity/Throughput	Fuel/Material
121A	LIMESTONE SILO PNEUMATIC	100.000 Tons/HR	LIMESTONE DUST
123	STONE/CLAY HANDLING SYSTEM	100.000 Tons/HR	STONE/CLAY
140	RAW MILL FEED SYSTEM	160.000 Tons/HR	CLAY, ETC.
181	SOLID FUEL DELIVERY SYSTEM	50.000 Tons/HR	SOLID FUEL
200	WHITE CEMENT KILN		
205	CKD RETURN BIN 34 TON	10.000 Tons/HR	KILN ESP DUST
207	WASTEDUST HANDLING SYSTEM	15.000 Tons/HR	KILN ESP DUST
220	CLINKER DISCHARGE SYSTEM	25.000 Tons/HR	CEMENT CLINKER
230A	8TH FLOOR BLDG TRANSFER	25.000 Tons/HR	CEMENT CLINKER
232	FRINGE BIN	25.000 Tons/HR	CEMENT
300	FINISH MILL GRINDING SYSTEM	30.000 Tons/HR	CEMENT
370	TRUCK SILOS RCVNG	100.000 Tons/HR	CEMENT
380	TWO TRUCK LOADOUTS	188.000 Tons/HR	CEMENT
390	RAILCAR SILO/BULK TRUCK LOADOUT	112.000 Tons/HR	CEMENT
450	1956 SILOS RECEIVING	50.000 Tons/HR	CEMENT
580	PACKHOUSE	100.000 Tons/HR	CEMENT
C121A	BHA BAGHOUSE		
C230A	FULLER BAGHOUSE		
C380A	UAS BAGHOUSE 1		
C380B	UAS BAGHOUSE 2		
D14	UAS COLLECTOR		
D18	DALAMATIC COLLECTOR		
D20	WESTERN PRECIP. ESP		
D22	SURGE HOPPER/SETTLING BOX		
D30	NORBLO BAGHOUSE		
D37	TECH AIRE BAGHOUSE		
D39	BHA BAGHOUSE		
D45	FULLER BAGHOUSE		
E12	DUCON COLLECTOR		
E18	DALAMATIC COLLECTOR		
E20	FULLER BAGHOUSE		
E21	NORBLO BUELL BAGHOUSE		
E22	NORBLO BAGHOUSE		
E37	TECH AIRE BAGHOUSE		
E58	FULLER BAGHOUSE		
F12	PANGBORN CM60-1		
F20	FULLER BAGHOUSE		
F23	FULLER BAGHOUSE		
F45	FULLER BAGHOUSE		
F58	FULLER BAGHOUSE		

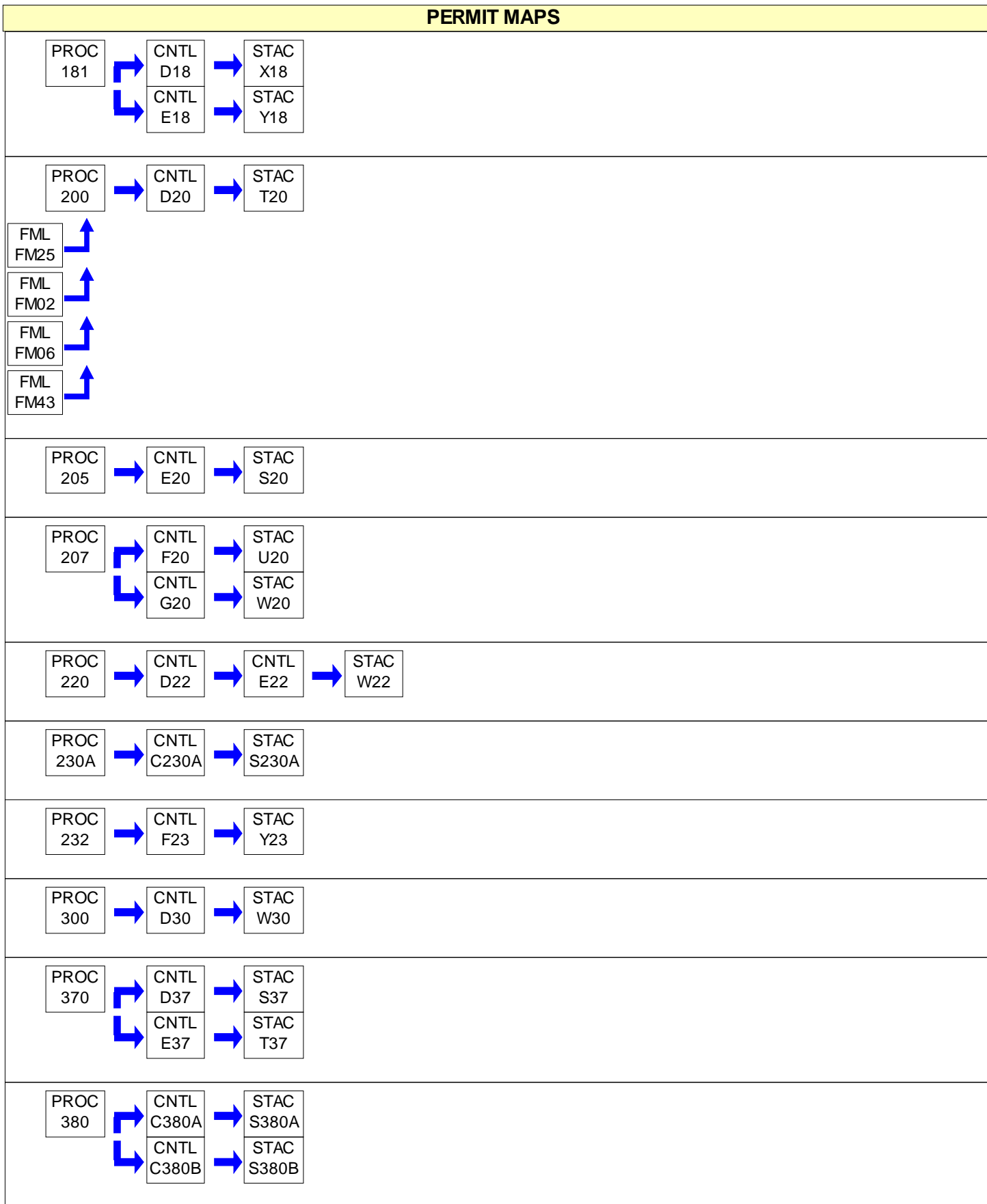
**SECTION A. Site Inventory List**

Source ID	Source Name	Capacity/Throughput	Fuel/Material
G20	FULLER BAGHOUSE		
FM02	NO. 2 FUEL OIL SUPPLY		
FM06	NOS. 5 & 6 FUEL OIL SUPPLY		
FM25	NATURAL GAS SUPPLY		
FM43	SOLID FUEL SUPPLY		
S121A	BHA BAGHOUSE STACK		
S20	FULLER BAGHOUSE STACK		
S230A	UNSPECIFIED NAME		
S37	TECH AIRE BQHSE EXHAUST		
S380A	UAS BAGHOUSE 1 STACK		
S380B	UAS BAGHOUSE 2 STACK		
S39	BHA BAGHOUSE EXHAUST		
S45	FULLER BAGHOUSE EXHAUST		
S58	FULLER BAGHOUSE EXHAUST		
T12	PANGBORN COLLECTOR STACK		
T20	WP ESP STACK		
T37	TECH AIRE BAGHSE EXHUAST		
T58	FULLER BAGHOUSE EXHAUST		
U20	FULLER BAGHOUSE STACK		
U45	FULLER BAGHOUSE EXHAUST		
W20	FULLER BAGHOUSE STACK		
W22	NORBLO BAGHOUSE STACK		
W30	NORBLO BAGHOUSE EXHAUST		
X12	DUCON COLLECTOR EXHAUST		
X18	DALAMATIC COLLECTOR STACK		
Y14	UAS COLLECTOR STACK		
Y18	DALAMATIC COLLECTOR STACK		
Y23	FULLER BAGHOUSE EXHAUST		

**PERMIT MAPS**

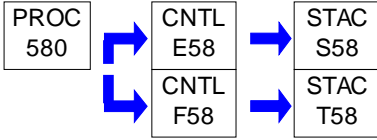
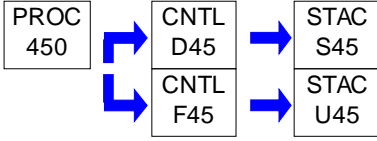


PERMIT MAPS





### 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 § 127.513]****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

**SECTION B. General Title V Requirements**

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.

**#025 [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.
- (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.

**#026 [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.



**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**

No person shall permit the emission into the outdoor atmosphere of any fugitive air contaminant from a source other than the following:

- (a) Construction or demolition of buildings or structures.
- (b) Grading, paving and maintenance of roads and streets.
- (c) 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.
- (d) Clearing of land.
- (e) Stockpiling of materials.
- (f) Sources and classes of sources other than those identified above, for which the operator has obtained a determination from the Department that fugitive emissions from the source, after appropriate control, meet the following requirements:
  - 1) the emissions are of minor significance with respect to causing air pollution;
  - 2) the emissions are not preventing or interfering with the attainment or maintenance of any ambient air standard.

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

No person shall permit the emission into the outdoor atmosphere of particulate matter from a source specified in Section C, Condition #001 if the emissions are visible at the point the emissions pass outside the person's property.

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

No person shall permit the emission into the outdoor atmosphere of malodorous air contaminants from any source in such a manner that malodors are detectable outside the property of the person on whose land the source is being operated.

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

No person shall permit the emission into the outdoor atmosphere of visible air contaminants in such a manner that the opacity of the emission is either of the following:

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

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

The emission limitations of Section 123.41 shall not apply when:

- (1) The presence of uncombined water is the only reason for failure of the emission to meet the limitation;
- (2) The emission results from the operation of equipment used solely to train and test persons in observing the opacity of visible emissions;
- (3) The emission results from sources specified in 25 Pa. Section 123.1(a) (relating to prohibition of certain fugitive emissions).

**SECTION C. Site Level Requirements****# 006 [25 Pa. Code §129.14]****Open burning operations**

No person shall conduct the open burning of materials in an air basin except for the following:

- (1) A fire set to prevent or abate a fire hazard, when approved by the Department and set by or under the supervision of a public officer.
- (2) A fire set for the purpose of instructing personnel in fire fighting, when approved by the Department.
- (3) A fire set for the prevention and control of disease or pests, when approved by the Department.
- (4) A fire set solely for recreational or ceremonial purposes.
- (5) A fire set solely for cooking food.

This permit does not constitute authorization to burn solid waste pursuant to Section 610 (3) of the Solid Waste Management Act, 35 P.S. Section 6018.610 (3), or any other provision of the Solid Waste Management Act.

**II. TESTING REQUIREMENTS.****# 007 [25 Pa. Code §127.511]****Monitoring and related recordkeeping and reporting requirements.**

The Department reserves the right to require exhaust stack testing of the sources and control devices referenced in this permit as necessary during the permit term to verify emissions for purposes including emission fees, malfunctions or permit condition violations.

**# 008 [25 Pa. Code §139.1]****Sampling facilities.**

Upon the request of the Department, the permittee shall provide adequate sampling ports, safe sampling platforms and adequate utilities for the performance by the Department of tests on such sources. In the request, the Department will set forth the time period in which the facilities shall be provided, as well as the specifications for the facilities.

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

Visible air contaminants may be measured using either of the following:

- (1) A device approved by the Department and maintained to provide accurate opacity measurements.
- (2) Observers, trained and certified in EPA Method 9, 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 permit condition is also derived from 25 Pa. Code Section 127.511]

The permittee shall conduct a daily inspection around the plant periphery during daylight hours when the plant is in production to detect visible stack emissions, visible emissions leaving the premises and odorous air emissions as follows:

- (a) Stack emissions in excess of the limits stated in Section C, Condition #004. Visible stack emissions may be measured according to the methods specified in Section C, Condition #009, or alternatively, plant personnel who observe visible stack emissions may report the incidence of visible stack emissions to the Department within two (2) hours of the incident and make arrangements for a certified observer to measure the visible stack emissions.
- (b) The presence of visible emissions beyond the plant boundaries as stated in Section C, Condition #002.

**SECTION C. Site Level Requirements**

(c) The presence of odorous air emissions beyond the plant boundaries as stated in Section C, Condition #003.

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

(a) The permittee shall monitor and record the pressure drop across each fabric filter or other particulate matter control device listed in the Section A Inventory List. At a minimum, these readings shall be taken once per week while the sources and control devices are in operation. These recordings shall be maintained on-site for the most recent five-year period.

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

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

The permittee shall maintain a record of each daily inspection conducted in accordance with Section C, Condition #010. At a minimum, these records shall include the following information:

- (1) The name of the company representative conducting each inspection.
- (2) The date and time of each inspection.
- (3) The wind direction during each inspection.
- (4) A description of the emissions and/or malodors observed and the actions taken to mitigate them.

The permittee shall maintain these records for a minimum of five years and shall make them available to Department representatives upon request.

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

The permittee shall maintain detailed records of all maintenance performed on the air emissions control systems for the most recent five-year period.

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

An annual report as per Section 129.95 containing, but not limited to, the following data for the cement kiln and boilers shall be submitted to the Air Quality District Supervisor:

- a. identification of each unit
- b. hours of operation per month
- c. fuel combusted per month
- d. fuel analysis or fuel supplier certification for each liquid fuel shipment received
- e. pounds of NOx emitted per month

The report for each January 1 through December 31 period is due no later than March 1 of the following year for each year authorized by this operating permit or its renewal.

[The above requirement was included in Operating Permit No. 67-2024]

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

The permittee shall report malfunctions to the Department. 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. Failures that are caused in part by poor maintenance or careless operation are not malfunctions. Malfunctions

**SECTION C. Site Level Requirements**

shall be reported as follows:

(a) Malfunction which poses an imminent danger to the public health, safety, welfare, and environment, shall be immediately reported to the Department by telephone. The telephone report of such malfunctions shall occur no later than two (2) hours after the incident. Telephone reports can be made to the Air Quality Program at 717-705-4886 during normal business hours, or to the Department's Emergency Hotline at any time. The Emergency Hotline phone number is changed/updated periodically. The current Emergency Hotline phone number can be found at <https://www.dep.pa.gov/About/Regional/SouthcentralRegion/Pages/default.aspx>. The permittee shall submit a written report of instances of such malfunctions to the Department within three (3) days of the telephone report.

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

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

The permittee shall take all reasonable actions to prevent particulate matter from the sources identified in Section C, Condition #001 (a) through (e) from becoming airborne. These actions shall include, but are not limited to, the following:

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

**# 017 [25 Pa. Code §127.444]****Compliance requirements.**

The permittee shall operate and maintain the emission sources and air cleaning devices referenced in this permit in accordance with the manufacturer's general recommendations and good air pollution control practices.

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

Operation of any air emissions source is contingent upon proper operation of its associated emissions control system.

**# 019 [25 Pa. Code §127.511]****Monitoring and related recordkeeping and reporting requirements.**

Per Site Level Category VIII 'COMPLIANCE CERTIFICATION' below, forward the annual compliance certification report electronically to EPA, in lieu of the hard copy version, to the following email address: 'R3\_APD\_Permits@epa.gov'

**VIII. COMPLIANCE CERTIFICATION.**

The permittee shall submit within thirty days of 01/01/2020 a certificate of compliance with all permit terms and conditions set forth in this Title V permit as required under condition #026 of section B of this permit, and annually thereafter.

**IX. COMPLIANCE SCHEDULE.**

No compliance milestones exist.

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

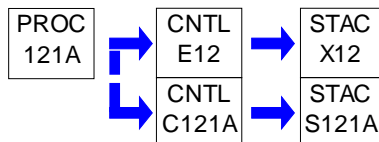
**SECTION D. Source Level Requirements**

Source ID: 121A

Source Name: LIMESTONE SILO PNEUMATIC

Source Capacity/Throughput: 100.000 Tons/HR LIMESTONE DUST

Conditions for this source occur in the following groups: 001 MATERIALS HANDLING EQUIPMENT  
002 CAM SOURCES  
007 BART LIMITS

**I. RESTRICTIONS.**

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

**II. TESTING REQUIREMENTS.**

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

**III. MONITORING REQUIREMENTS.**

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

**IV. RECORDKEEPING REQUIREMENTS.**

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

**V. REPORTING REQUIREMENTS.**

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

**VI. WORK PRACTICE REQUIREMENTS.**

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

**VII. ADDITIONAL REQUIREMENTS.**

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

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

**SECTION D. Source Level Requirements**

Source ID: 123

Source Name: STONE/CLAY HANDLING SYSTEM

Source Capacity/Throughput: 100.000 Tons/HR STONE/CLAY

Conditions for this source occur in the following groups: 001 MATERIALS HANDLING EQUIPMENT  
002 CAM SOURCES  
007 BART LIMITS

**I. RESTRICTIONS.**

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

**II. TESTING REQUIREMENTS.**

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

**III. MONITORING REQUIREMENTS.**

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

**IV. RECORDKEEPING REQUIREMENTS.**

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

**V. REPORTING REQUIREMENTS.**

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

**VI. WORK PRACTICE REQUIREMENTS.**

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

**VII. ADDITIONAL REQUIREMENTS.**

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

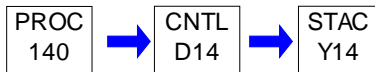
**\*\*\* Permit Shield in Effect. \*\*\***

**SECTION D. Source Level Requirements**

Source ID: 140

Source Name: RAW MILL FEED SYSTEM

Source Capacity/Throughput: 160.000 Tons/HR CLAY, ETC.

Conditions for this source occur in the following groups: 002 CAM SOURCES  
007 BART LIMITS**I. RESTRICTIONS.****Emission Restriction(s).**

# 001 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

Particulate matter emissions from the Source ID 140 raw mill feed system shall not exceed an exhaust gas concentration of 0.02 grain per dry standard cubic foot of effluent gas.

**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: 181

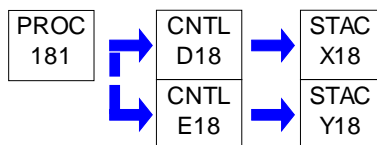
Source Name: SOLID FUEL DELIVERY SYSTEM

Source Capacity/Throughput:

50.000 Tons/HR

SOLID FUEL

Conditions for this source occur in the following groups: 001 MATERIALS HANDLING EQUIPMENT  
002 CAM SOURCES

**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. \*\*\***

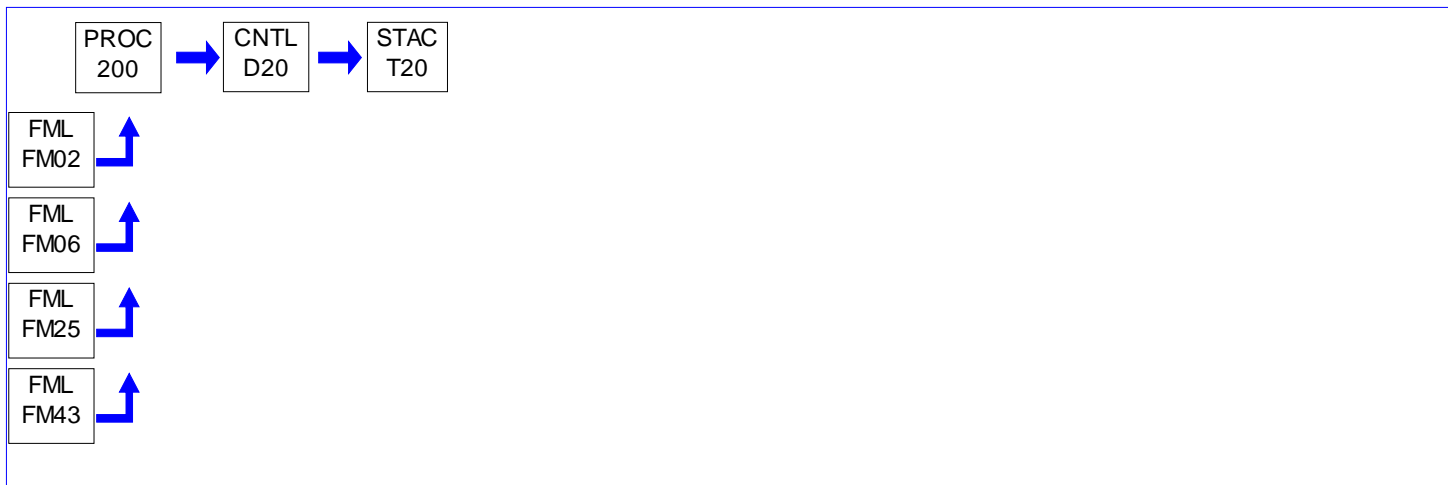
**SECTION D. Source Level Requirements**

Source ID: 200

Source Name: WHITE CEMENT KILN

Source Capacity/Throughput:

Conditions for this source occur in the following groups: 003 SUBPART LLL MACT REQUIREMENTS  
 004 CEMS REQUIREMENTS  
 006 RACT 2 REQUIREMENTS  
 007 BART LIMITS

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

Particulate matter emissions from the Source ID 200 white cement kiln shall not exceed the rate determined by the following formula or an effluent gas concentration of 0.02 grains per dry standard cubic foot, whichever is greater:

$$A = 0.76 E^{0.42}$$

Where

A = allowable emissions in pounds per hour

E = emission index = F X W pounds per hour

F = 150 = process factor in pounds per unit

W = production or charging rate in units per hour

0.42 = exponent

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

Sulfur oxides emissions, expressed as sulfur dioxide, from the Source ID 200 white cement kiln shall not exceed a concentration of 500 parts per million, by volume, dry basis in the effluent gas.

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

145.143. Standard requirements.

(a) By October 31, 2005, and each year thereafter, the owner or operator of a Portland cement kiln shall calculate the difference between the actual emissions from the unit during the period from May 1 through September 30 and the allowable emissions for that period.

**SECTION D. Source Level Requirements**

(b) The owner or operator of a Portland cement kiln may not operate a Portland cement kiln in a manner that results in NO<sub>x</sub> emissions in excess of its allowable emissions, except as otherwise specified in this section.

(1) Beginning May 1 through September 30, 2005, and each year thereafter, the owner or operator shall determine allowable emissions by multiplying the tons of clinker produced by the Portland cement kiln for the period by 6 pounds per ton of clinker produced.

(2) Beginning May 1 through September 30, 2011, and each year thereafter, the owner or operator of a Portland cement kiln shall determine allowable emissions of NO<sub>x</sub> by multiplying the tons of clinker produced by the Portland cement kiln for the period by:

- (i) 3.88 pounds of NO<sub>x</sub> per ton of clinker produced for long wet-process cement kilns.
- (ii) 3.44 pounds of NO<sub>x</sub> per ton of clinker produced for long dry-process cement kilns. [NOT APPLICABLE]
- (iii) 2.36 pounds of NO<sub>x</sub> per ton of clinker produced for:
  - (A) Preheater cement kilns. [NOT APPLICABLE]
  - (B) Precalciner cement kilns. [NOT APPLICABLE]

(c) The owner or operator of a Portland cement kiln subject to subsection (b)(1) shall install and operate a CEMS, and shall report CEMS emissions data, in accordance with the CEMS requirements of either Chapter 139 or 145 (relating to sampling and testing; and interstate pollution transport reduction) and calculate actual emissions using the CEMS data reported to the Department. Any data invalidated under Chapter 139 shall be substituted with data calculated using the potential emission rate for the unit or, if approved by the Department in writing, an alternative amount of emissions that is more representative of actual emissions that occurred during the period of invalid data.

(d) The owner or operator of a Portland cement kiln subject to this section shall surrender to the Department one CAIR NO<sub>x</sub> allowance and one CAIR NO<sub>x</sub> Ozone Season allowance, as defined in 40 CFR 96.102 and 96.302 (relating to definitions), for each ton of NO<sub>x</sub> by which the combined actual emissions exceed the allowable emissions of the Portland cement kilns subject to this section at a facility from May 1 through September 30. The surrendered allowances shall be of current year vintage. For the purposes of determining the amount of allowances to surrender, any remaining fraction of a ton equal to or greater than 0.50 ton is deemed to equal 1 ton and any fraction of a ton less than 0.50 ton is deemed to equal zero tons.

(e) If the combined allowable emissions from Portland cement kilns at a facility from May 1 through September 30 exceed the combined actual emissions from Portland cement kilns subject to this section at the facility during the same period, the owner or operator may deduct the difference or any portion of the difference from the amount of actual emissions from Portland cement kilns at the owner or operator's other facilities located in this Commonwealth for that period.

(f) By November 1, 2005, and each year thereafter, an owner or operator subject to this subchapter shall surrender the required NO<sub>x</sub> allowances to the Department's designated NO<sub>x</sub> allowance tracking system account, as defined in § 121.1 (relating to definitions), and shall provide in writing to the Department, the following:

- (1) The serial number of each NO<sub>x</sub> allowance surrendered.
- (2) The calculations used to determine the quantity of NO<sub>x</sub> allowances required to be surrendered.

(g) If an owner or operator fails to comply with subsection (f), the owner or operator shall by December 31 surrender three NO<sub>x</sub> allowances of the current or later year vintage for each NO<sub>x</sub> allowance that was required to be surrendered by November 1.

(h) The surrender of NO<sub>x</sub> allowances under subsection (g) does not affect the liability of the owner or operator of the Portland cement kiln for any fine, penalty or assessment, or an obligation to comply with any other remedy for the same violation, under the CAA or the act.

**SECTION D. Source Level Requirements**

(1) For purposes of determining the number of days of violation, if a facility has excess emissions for the period May 1 through September 30, each day in that period (153 days) constitutes a day in violation unless the owner or operator of the Portland cement kiln demonstrates that a lesser number of days should be considered.

(2) Each ton of excess emissions is a separate violation.

**# 004 [25 Pa. Code §127.441]**

**Operating permit terms and conditions.**

NOx emissions from the Source ID 200 white cement kiln shall not exceed 8.2 pounds per ton of clinker produced.

[The above requirement was previously included in Operating Permit No. 67-2024]

**Fuel Restriction(s).**

**# 005 [25 Pa. Code §127.441]**

**Operating permit terms and conditions.**

The Source 200 white cement kiln may only be fired with the following fuels:

Petroleum coke	Natural gas
No. 6 fuel oil	Reclaimed oil
No. 2 fuel oil*	

The reclaimed oil fired in the Source 200 white cement kiln shall meet the following specifications:

Constituent	Acceptable Level	Analytical Technique*
Arsenic	less than or equal to 5 ppmw	EPA Method 6010, 6020, 7010, 7061, or 7062
Cadmium	less than or equal to 2 ppmw	EPA Method 6010, 6020, 7000, or 7010
Chromium	less than or equal to 10 ppmw	EPA Method 6010, 7000, or 7010
Lead	less than or equal to 100 ppmw	EPA Method 6010, 7000, or 7010
PCB	Not Detectable	EPA Method 8082
Flash Point	greater than or equal to 100 F.	EPA Method 1010 or ASTM D-93
Total Halides	less than or equal to 1,000 ppmw	EPA Method 9075, 9076, or 9077
Ash	less than or equal to 1.0% (by weight)	ASTM D482

Should the total halides exceed 1,000 ppm, the company shall demonstrate that the total organic halides do not exceed 1,000 ppm.

Alternative methods may be used when approved in writing by the Department.

An analysis for the constituents specified above shall be performed for each reclaimed oil shipment received. These analyses shall be maintained on-site for the most recent five-year period and shall be made available to Department representatives upon request.

The sulfur content of the reclaimed oil shall not exceed 1.0% by weight as fired.

\*No. 2 oil shall comply with 25 Pa. Code 123.22. As of July 1, 2016 the maximum allowable sulfur content for No. 2 fuel oil is 500 ppm (0.05%).

**II. TESTING REQUIREMENTS.**

**# 006 [25 Pa. Code §127.441]**

**Operating permit terms and conditions.**

Particulate matter emissions from the Source ID 200 white cement kiln shall be verified annually by a stack test or other means approved by the Department, except for pollutants where that specific pollutant is monitored using CEMS.

**SECTION D. Source Level Requirements**

Testing shall be conducted in accordance with the provisions of Chapter 139 of the Department's Rules and Regulations.

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

145.144. Compliance determination.

(a) By April 15, 2011, the owner or operator of a Portland cement kiln subject to § 145.143(b)(2) (relating to standard requirements) shall:

- (1) Install, operate and maintain CEMS for NO<sub>x</sub> emissions.
- (2) Report CEMS emissions data, in accordance with the CEMS requirements of Chapter 139, Subchapter C (relating to requirements for source monitoring for stationary sources), to the Department.
- (3) Calculate actual emissions using the CEMS data reported to the Department.

(b) If approved by the Department in writing, data invalidated under Chapter 139, Subchapter C, shall be substituted with one of the following:

- (1) The highest valid 1-hour emission value that occurred under similar source operating conditions during the reporting quarter for an invalid data period during that quarter.
- (2) If no valid data were collected during the reporting quarter, one of the following shall be reported to the Department:
  - (i) The highest valid 1-hour emission value that occurred under similar source operating conditions during the most recent quarter for which valid data were collected.
  - (ii) The highest valid 1-hour emission value that occurred under similar source operating conditions during an alternative reporting period.
- (3) An alternative method of data substitution.

(c) The owner or operator of a Portland cement kiln subject to this section shall submit to the Department quarterly reports of CEMS monitoring data in pounds of NO<sub>x</sub> emitted per hour, in a format approved by the Department, which is in compliance with Chapter 139, Subchapter C.

(d) The CEMS for NO<sub>x</sub> installed under the requirements of this section must meet the minimum data availability requirements in Chapter 139, Subchapter C.

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

The permittee shall monitor the following parameters for the Source ID 200 white cement kiln:

- (a) daily kiln feed rate in gallons per minute
- (b) daily operating hours
- (c) daily clinker production
- (d) monthly consumption of all fuels
- (e) monthly analysis of petroleum coke sulfur content and ash content
- (f) monthly analyses of overall fuel blend heating value and sulfur content

The permittee shall maintain an automated system to monitor the following parameters for the Source ID 200 white cement kiln and shall record these parameters on an hourly basis:

**SECTION D. Source Level Requirements**

- (1) kiln feed moisture content
- (2) primary airflow rate
- (3) exhaust gas temperature
- (4) exhaust gas oxygen content
- (5) electrostatic precipitator voltage for each field

The permittee shall maintain records of the above monitored parameters on-site for the most recent five-year period and shall make them available to Department representatives upon request.

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

145.146. Recordkeeping.

(a) The owner or operator of a Portland cement kiln shall maintain an operating log for each Portland cement kiln. The operating log must include the following on a monthly basis:

- (1) The total hours of operation.
- (2) The type and quantity of fuel used.
- (3) The quantity of clinker produced.

(b) The records maintained by the owner or operator of a Portland cement kiln must include the following:

- (1) Source tests and operating parameters established during the initial source test and subsequent testing.
- (2) The date, time and duration of any start-up, shutdown or malfunction of a Portland cement kiln or emissions monitoring system.
- (3) The date and type of maintenance, repairs or replacements performed on the kilns, control devices and emission monitoring systems.

(c) The owner or operator of a Portland cement kiln shall maintain the records required under this section onsite for 5 years. The records shall be made available to the Department upon request.

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

145.145. Compliance demonstration and reporting requirements.

(a) By October 31, 2011, and each year thereafter, the owner or operator of a Portland cement kiln subject to § 145.143(b)(2) (relating to standard requirements) shall submit a written report to the Department, in a format approved by the Department, which includes the following:

(1) The difference between the actual NO<sub>x</sub> emissions from the kiln during the interval from May 1 through September 30 and the allowable emissions for that period.

(2) The calculations used to determine the difference in emissions, including the CEMS data and clinker production data used to show compliance with the allowable emission limits in § 145.143(b)(2). The clinker production data must consist of the quantity of clinker, in tons, produced per day for each kiln.

(b) The owner or operator of a Portland cement kiln shall demonstrate compliance with the standard requirements in § 145.143(b)(2) on one of the following:

**SECTION D. Source Level Requirements**

- (1) A kiln-by-kiln basis.
- (2) A facility-wide basis.
- (3) A system-wide basis.

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

An annual report containing, but not limited to, monthly fuel consumption data, kiln operating hours per month, clinker production per month and reclaimed oil analyses shall be submitted to the Air Quality District Supervisor. The report for each January 1 through December 31 period is due not later than March 1 of the following year for each year authorized by this operating permit or its renewal.

[The above requirement was previously included in Operating Permit No. 67-2024]

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

The permittee shall operate the Source ID 200 white cement kiln such that the temperature of the exhaust gases at the inlet to the D20 electrostatic precipitator is below the temperature limit established during the most recent dioxin/furan testing.

Note: The current limit is 591.4 degrees F. based upon testing on May 1-2, 2018 and may change as dictated by future testing.

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

145.141. Applicability.

Beginning May 1, 2005, an owner or operator of a Portland cement kiln shall comply with this subchapter.

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

The Source ID 200 white cement kiln is subject to the 25 Pa. Code Chapter 145 NOx Budget Trading Program and shall comply with all applicable parts of the chapter to include continuous emissions monitoring and NOx allowance transactions.

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

[Additional authority for this permit condition is derived from the Consent Decree for United States v. Lehigh Cement Co., No. 5:19-cv-05688, (E.D. Pa. Nov. 18, 2020). The definitions and provisions in this permit condition are limited to this permit condition, and do not apply to other conditions in this permit.]

**III. DEFINITIONS**

8. Terms used in this [permit condition] that are defined in the [Clean Air] Act or in regulations promulgated by U.S. EPA pursuant to the Act shall have the meanings assigned to them in the Act or such regulations, unless otherwise provided in this [permit condition]. Whenever the terms set forth below are used in this [permit condition], the following definitions shall apply:

a. "30-Day Rolling Average Emission Limit" shall mean, with respect to any Kiln at a Facility, the maximum allowable rate of emission of a specified air pollutant from such Kiln or Kilns, as applicable, and shall be expressed as pounds (lbs) of such air pollutant emitted per Ton of clinker produced. Compliance with the 30-Day Rolling Average Emission Limit shall be determined by calculating the 30-Day Rolling Average Emission Rate and comparing that with the 30-Day Rolling Average Emission Limit.

**SECTION D. Source Level Requirements**

- b. "30-Day Rolling Average Emission Rate" shall mean, with respect to each Kiln, the rate of emission of NO<sub>x</sub> or SO<sub>2</sub>, respectively, expressed as pounds (lbs) per Ton of clinker produced at such Kiln and calculated in accordance with the following procedure: first, sum the total pounds of the pollutant in question emitted from the specified Kiln during an Operating Day and the previous twenty-nine (29) Operating Days, as measured pursuant to Section V.B (NO<sub>x</sub> Continuous Emission Monitoring Systems) and Section VI.C (SO<sub>2</sub> Continuous Emission Monitoring Systems); second, sum the total Tons of clinker produced by that Kiln during the same Operating Day and previous twenty-nine (29) Operating Days; and third, divide the total number of pounds of that pollutant emitted from the Kiln in question during the thirty (30) Operating Days referred to above by the total Tons of clinker produced at such Kiln during the same thirty (30) Operating Days. A new 30-Day Rolling Average Emission Rate shall be calculated for each new Operating Day. Only emission data determined to be valid under 40 C.F.R. § 60.13 or substituted data in accordance with Paragraphs 19 and 28 shall be included. In calculating each 30-Day Rolling Average Emission Rate, the total pounds of that pollutant emitted from a Kiln during a specified period (Operating Day or 30-Day Period) shall include all emissions of that pollutant from the subject Kiln that occur during the specified period, including emissions during each Malfunction;
- e. "CD Emissions Reductions" shall mean any emissions reductions that result from any projects, controls, or any other actions utilized to comply with [the] Consent Decree or [this permit condition];
- f. "CEMS" or "Continuous Emission Monitoring System" shall mean, for obligations involving NO<sub>x</sub> and SO<sub>2</sub> under [the] Consent Decree [or this permit condition], the total equipment and software required to sample and condition (if applicable), to analyze, and to provide a record of NO<sub>x</sub> and SO<sub>2</sub> emission rates, and the raw data necessary to support the reported emission rates, and that have been installed and calibrated in accordance with 40 C.F.R. § 60.13 and 40 C.F.R. Part 60 Appendix B and Appendix F;
- g. "Combustion Control" is the method used to maintain NO<sub>x</sub> emissions below a prescribed limitation through management of combustion parameters at the Kiln;
- h. "Commence" or "Commencement" of operation of a Control Technology shall mean to begin the introduction of the reagent employed by the Control Technology, as applicable to that technology, or when the technology is otherwise activated;
- k. "Continuously Operate" or "Continuous Operation" shall mean, except as provided below, that when a Control Technology is installed at a Kiln, it shall be operated at all times of Kiln Operation, consistent with the technological limitations, manufacturers' specifications, and good engineering and maintenance practices for such Control Technology and the Kiln, except during: (1) Malfunction of the Control Technology, (2) periods where the Kiln is operating below the minimum temperature required for operation of the Control Technology, as specified in writing by the manufacturer or installation contractor (to include [the Permittee] when it serves as manufacturer, installer or designer of the Control Technology), or (3) for Selective Non-Catalytic Reduction System operation, Detached Plume Events. Provided, however, wherever a Control Technology involves the injection or addition of reagent, then the reagent shall be injected or added as necessary to achieve the emissions limits referenced in Table 2 and Table 3.
- m. "Control Technology" shall mean those technologies specified in Sections V and VI of [the Consent] Decree [or this permit condition], which may include a Selective Non-Catalytic Reduction System; Wet or Dry Scrubbers; Combustion Controls; Kiln Inherent Scrubbing (including scrubbing in the in-line raw mill); or a Lime Injection System;
- n. "Day" shall mean a calendar day unless expressly stated to be a Business Day;
- q. "Effective Date" shall [mean December 19, 2020]
- r. "Emission Limit" or "Emission Limits" shall mean the maximum allowable rate of emission of a specified air pollutant from a Kiln as specified in Paragraph 12, Table 2 (NO<sub>x</sub>) and Paragraph 20, Table 3 (SO<sub>2</sub>);
- t. "Kiln" shall have the same meaning as defined at 40 C.F.R. § 63.1341.
- u. "Kiln Operation" shall mean any period when any raw materials are fed into the Kiln or any combustion is occurring in the Kiln or Calciner burners;



**SECTION D. Source Level Requirements**

v. "Lime Injection" or "Lime Injection System" shall mean a pollution control system that injects lime or another reagent that has been demonstrated as effective in reducing SO<sub>2</sub> emissions into the gas stream for the purpose of reducing SO<sub>2</sub> emissions (including but not limited to, Hydrated Lime (Ca(OH)<sub>2</sub>), Soda Ash - Sodium Carbonate (Na<sub>2</sub>CO<sub>3</sub>), Sodium Bicarbonate (NaHCO<sub>3</sub>), and Trona – Trisodium hydrogencarbonate dihydrate (Na<sub>2</sub>CO<sub>3</sub>·NaHCO<sub>3</sub>·2H<sub>2</sub>O));

w. "Malfunction" as used in [the] Consent Decree [or this permit condition] shall have the same meaning as defined at 40 C.F.R. § 60.2;

y. "NO<sub>x</sub>" shall mean oxides of nitrogen, measured in accordance with the provisions of [the] Consent Decree [or this permit condition];

z. "Non-attainment NSR" or "NNSR" shall mean the non-attainment area New Source Review ("NSR") program within the meaning of Part D of Subchapter I of the Act, 42 U.S.C. §§ 7501-7515, 40 C.F.R. Part 51, and any applicable State Implementation Plan;

aa. "Operating Day" shall mean any Day on which Kiln Operation has occurred;

bb. "Paragraph" shall mean a portion of [the Consent] Decree [or this permit condition] identified by an Arabic numeral and "Subparagraph" shall mean a portion of [the Consent] Decree [or this permit condition] identified by a lower case letter;

ff. "Section" shall mean a portion of [the Consent] Decree [or this permit condition] identified by a Roman numeral;

gg. "Selective Non-Catalytic Reduction" or "SNCR" shall mean a pollution control system that injects ammonia, monomethylamine, cyanuric acid, and/or urea into the gas stream without the use of a catalyst for the purpose of reducing NO<sub>x</sub> emissions;

hh. "SO<sub>2</sub>" means the pollutant sulfur dioxide, measured in accordance with the provisions of [the] Consent Decree [or this permit condition];

jj. "Temporary Cessation," "Temporary Cessation of Kiln Operation" or "Temporarily Cease Kiln Operation," except for planned and/or maintenance or repair outages at plants, shall mean the period when a Kiln is not in a state of Kiln Operation and the [Permittee] has provided the required notice pursuant to Paragraph 37 of Section VIII (Temporary Cessation of Kiln Operation) of [the] Consent Decree;

kk. "Title V permit" shall mean a permit required by and issued in accordance with the requirements of 42 U.S.C. §§ 7661 - 7661f;

ll. "Ton" or "Tons" shall mean short ton or short tons;

oo. "Scrubber" shall mean a pollution control system that employs an absorber vessel and wet or dry scrubbing technology to achieve the reduction of sulfur dioxide emissions. This is distinct from Lime Injection;

**V. NO<sub>x</sub> CONTROL TECHNOLOGY, EMISSION LIMITS AND MONITORING REQUIREMENTS****A. NO<sub>x</sub> Control Technology and Emission Limits**

12. Subject to Section VIII (Temporary Cessation of Kiln Operation), [the Permittee] shall install and Commence Continuous Operation of each NO<sub>x</sub> Control Technology and comply with the Emission Limits for [York Kiln 1] within [its] respective system according to Table 2 below by no later than the date specified in Table 2 below. [The Permittee] shall Continuously Operate each specified NO<sub>x</sub> Control Technology as applicable to [York Kiln 1], at all times of Kiln Operation, by no later than the date specified in Table 2 below.

**APPLICABLE TABLE 2 REQUIREMENTS**

Kiln: York Kiln 1

NO<sub>x</sub> Control Technology to be Continuously Operated: Combustion Controls and/or SNCR

Deadline for Installation and Commencement of Continuous Operation of NO<sub>x</sub> Control Technology and Compliance with 30-

**SECTION D. Source Level Requirements**

Day Rolling Average Emission Limit for NO<sub>x</sub>: Effective Date plus 6 months

30-Day Rolling Average Emission Limit (lbs NO<sub>x</sub>/Ton of clinker): 3.88

END OF TABLE 2 REQUIREMENTS

13. For each Kiln in Table 2, beginning on the Operating Day which is the 30th Operating Day after the date specified in Table 2, the [Permittee] shall demonstrate compliance, and thereafter maintain compliance, with the 30-Day Rolling Average Emission Limit for NO<sub>x</sub> specified in Table 2 for that Kiln.

**B. NO<sub>x</sub> Continuous Emission Monitoring Systems**

15. At [York Kiln 1], [the Permittee] shall install and make operational by no later than (a) 12 months after the Effective Date or (b) the Deadline indicated in Table 2, whichever is earlier, a NO<sub>x</sub> continuous emissions monitoring system ("CEMS") at each stack, or other outlet if no stack exists, which collects emissions from such Kiln in accordance with the requirements of 40 C.F.R. Part 60.

16. For [York Kiln 1], beginning on or before the date that a NO<sub>x</sub> CEMS is required pursuant to Paragraph 15, [the Permittee] shall determine and record the daily clinker production rates by either one of the two following methods:

a. Install, calibrate, maintain, and operate a permanent weigh scale system to measure and record weight rates of the amount of clinker produced in tons of mass per hour. The system of measuring hourly clinker production must be maintained within  $\pm 5$  percent accuracy; or

b. Install, calibrate, maintain, and operate a permanent weigh scale system to measure and record weight rates of the amount of feed to the Kiln in tons of mass per hour. The system of measuring feed must be maintained within  $\pm 5$  percent accuracy.

If [the Permittee] chooses the methodology set forth in Paragraph 16.b to determine the daily clinker production rates at a Kiln, it shall calculate the hourly clinker production rate using a kiln-specific feed-to-clinker ratio based on reconciled clinker production determined for accounting purposes and recorded feed rates. This ratio should be updated no less frequently than once per month. If this ratio changes at clinker reconciliation, the new ratio must be used going forward, but shall not be applied retroactively to change clinker production rates previously estimated.

17. Except during CEMS breakdowns, repairs, calibration checks, zero span adjustments, and any stack repairs that require the removal and recalibration of the CEMS, the CEMS required pursuant to Paragraph 15 shall be operated at all times during Kiln Operation. Each such CEMS shall be used at [York Kiln 1], to demonstrate compliance with the NO<sub>x</sub> Emission Limits established in Section V.A (NO<sub>x</sub> Control Technology and Emission Limits), as applicable, of this [permit condition].

18. Each NO<sub>x</sub> CEMS required pursuant to Paragraph 15 shall monitor and record the applicable NO<sub>x</sub> emission rate from [York Kiln 1] stack in units of parts per million (ppm), lbs of NO<sub>x</sub> per hour, and lbs of NO<sub>x</sub> per Ton of clinker produced at such Kiln and shall be installed, certified, calibrated, maintained, and operated in accordance with the applicable requirements of 40 C.F.R. Part 60.

19. For purposes of this [permit condition], all emissions of NO<sub>x</sub> from Kilns shall be measured by CEMS. During any time when the CEMS is inoperable or otherwise not measuring emissions of NO<sub>x</sub> from any Kiln, the [Permittee] shall apply the missing data substitution procedures used by [Pennsylvania] or the missing data substitution procedures in 40 C.F.R. Part 75, Subpart D.

**VI. SO<sub>2</sub> CONTROL TECHNOLOGY, EMISSION LIMITS AND MONITORING REQUIREMENTS****A. SO<sub>2</sub> Control Technology and Emission Limits**

20. Subject to Section VIII (Temporary Cessation of Kiln Operation), [the Permittee] shall install and Commence Continuous Operation of each SO<sub>2</sub> Control Technology and comply with the Emission Limits for [York Kiln 1], within [its] respective system according to Table 3 below by no later than the date specified in Table 3 below. [The Permittee] shall Continuously Operate each SO<sub>2</sub> Control Technology as applicable to [York Kiln 1], at all times of Kiln Operation by no later than the date specified in Table 3 below.

**SECTION D. Source Level Requirements****TABLE 3 REQUIREMENTS**

Kiln: York Kiln 1

SO<sub>2</sub> Control Technology to be Continuously Operated: Kiln inherent scrubbingDeadline for Installation and Commencement of Continuous Operation of SO<sub>2</sub> Control Technology and Compliance with 30-Day Rolling Average Emission Limit for SO<sub>2</sub>: Effective Date + 30 Days30-Day Rolling Average Emission Limit (lbs SO<sub>2</sub> /Ton of clinker): 2.8

END OF TABLE 3 REQUIREMENTS

21. For [York Kiln 1], beginning on the Operating Day which is the 30th Operating Day after the deadline specified in Table 3, the [Permittee] shall demonstrate compliance and thereafter maintain compliance with the 30-Day Rolling Average Emission Limit for SO<sub>2</sub> specified in Table 3 at that Kiln.

**C. SO<sub>2</sub> Continuous Emission Monitoring Systems**

26. At [York Kiln 1], [the Permittee] shall install and make operational by no later than (a) 12 months after the Effective Date; [or] (b) the Deadline indicated in Table 3;... whichever is earlier for each Kiln, an SO<sub>2</sub> CEMS at each stack, or other outlet if no stack exists, which collects emissions from such Kiln in accordance with the requirements of 40 C.F.R. Part 60.

27. Except during CEMS breakdowns, repairs, calibration checks, zero span adjustments, and any stack repairs that require the removal and recalibration of the CEMS, the CEMS required pursuant to Paragraph 26 shall be operated at all times during Kiln Operation. Each such CEMS shall be used at [York Kiln 1] to demonstrate compliance with the SO<sub>2</sub> Emission Limits established in Sections VI.A and B (SO<sub>2</sub> Control Technology and Emission Limits) of this [permit condition].

28. Each SO<sub>2</sub> CEMS required pursuant to Paragraph 26 shall monitor and record the applicable SO<sub>2</sub> emission rate from [York Kiln 1] stack in units of ppm, lbs of SO<sub>2</sub> per hour, and lbs of SO<sub>2</sub> per Ton of clinker produced at such Kiln and shall be installed, certified, calibrated, maintained, and operated in accordance with the applicable requirements of 40 C.F.R. Part 60.

29. For purposes of this [permit condition], all emissions of SO<sub>2</sub> from [York Kiln 1] shall be measured by CEMS.

30. During any time when the CEMS is inoperable or otherwise not measuring emissions of SO<sub>2</sub> from any Kiln, the [Permittee] shall apply the missing data substitution procedures used by [Pennsylvania] or the missing data substitution procedures in 40 C.F.R. Part 75, Subpart D.

**VIII. TEMPORARY CESSATION OF KILN OPERATION**

39. [If the Permittee] Temporarily Ceases Kiln Operation for 24 consecutive months subsequent to the Effective Date of [the] Consent Decree, then prior to recommencing Kiln Operation at [York Kiln 1], the [Permittee] shall first apply for and obtain applicable permits required under: (1) the PSD provisions of the Act, 42 U.S.C. §§ 7470-7492 and/or the Non-attainment NSR provisions of the Act, 42 U.S.C. §§ 7501-7515; or (2) the federally-approved and enforceable SIPs that incorporate and/or implement the federal PSD and/or Non-attainment NSR requirements, as applicable.

**IX. PROHIBITION ON NETTING CREDITS OR OFFSETS FROM REQUIRED CONTROLS**

40. Prohibition. [The Permittee] shall neither generate nor use any [Consent Decree] CD Emissions Reductions: as netting reductions; as emissions offsets; or to apply for, obtain, trade, or sell any emission reduction credits. Baseline actual emissions for each unit during any 24-month period selected by [the Permittee] shall be adjusted downward to exclude any portion of the baseline emissions that would have been eliminated as CD Emissions Reductions had [the Permittee] been complying with [the] Consent Decree [or this permit condition] during that 24-month period. Any plant-wide applicability limits ("PALs") or PAL-like limits that apply to emissions units addressed by [the] Consent Decree [or this permit condition] must be adjusted downward to exclude any portion of the baseline emissions used in establishing such limit(s) that would have been eliminated as CD Emissions Reductions had the [Permittee] been complying with [the] Consent Decree [or this permit condition] during such baseline period.

41. Outside the Scope of the Prohibition. Nothing in this Section IX is intended to prohibit [the Permittee] from seeking to:

**SECTION D. Source Level Requirements**

- a. Use or generate emission reductions from emissions units that are covered by [the] Consent Decree [or this permit condition] to the extent that the proposed emission reductions represent the difference between CD Emissions Reductions and more stringent control requirements that the [Permittee] may elect to accept for those emissions units in a permitting process;
- b. Use or generate emission reductions from emissions units that are not subject to an emission limitation or control requirement pursuant to [the] Consent Decree [or this permit condition]; or
- c. Use CD Emissions Reductions for compliance with any rules or regulations designed to address regional haze or the non-attainment status of any area (excluding PSD and non-attainment NSR rules, but including, for example, Reasonably Available Control Technology (RACT) rules) that apply to the Facility; provided, however, that the [Permittee] shall not be allowed to trade or sell any CD Emissions Reductions.

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

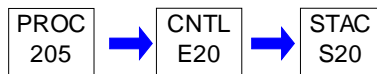
**SECTION D. Source Level Requirements**

Source ID: 205

Source Name: CKD RETURN BIN 34 TON

Source Capacity/Throughput: 10.000 Tons/HR KILN ESP DUST

Conditions for this source occur in the following groups: 001 MATERIALS HANDLING EQUIPMENT  
007 BART LIMITS

**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. \*\*\***

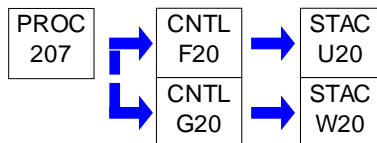
**SECTION D. Source Level Requirements**

Source ID: 207

Source Name: WASTEDUST HANDLING SYSTEM

Source Capacity/Throughput: 15.000 Tons/HR KILN ESP DUST

Conditions for this source occur in the following groups: 001 MATERIALS HANDLING EQUIPMENT  
002 CAM SOURCES

**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. \*\*\***

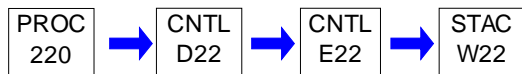
**SECTION D. Source Level Requirements**

Source ID: 220

Source Name: CLINKER DISCHARGE SYSTEM

Source Capacity/Throughput: 25.000 Tons/HR CEMENT CLINKER

Conditions for this source occur in the following groups: 001 MATERIALS HANDLING EQUIPMENT  
002 CAM SOURCES  
007 BART LIMITS

**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: 230A

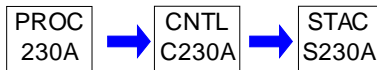
Source Name: 8TH FLOOR BLDG TRANSFER

Source Capacity/Throughput:

25.000 Tons/HR

CEMENT CLINKER

Conditions for this source occur in the following groups: 002 CAM SOURCES  
007 BART LIMITS

**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: 232

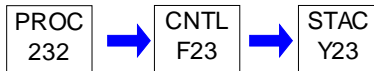
Source Name: FRINGE BIN

Source Capacity/Throughput:

25.000 Tons/HR

CEMENT

Conditions for this source occur in the following groups: 005 NSPS SUBPART F REQUIREMENTS

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

# 001 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

No person shall permit the emission into the outdoor atmosphere of particulate matter from the Source ID 232 Fringe Bin in excess of 0.02 grain per dry standard cubic foot of effluent gas.

**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: 300

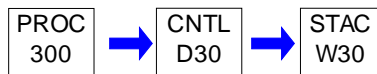
Source Name: FINISH MILL GRINDING SYSTEM

Source Capacity/Throughput:

30.000 Tons/HR

CEMENT

Conditions for this source occur in the following groups: 001 MATERIALS HANDLING EQUIPMENT  
007 BART LIMITS

**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).

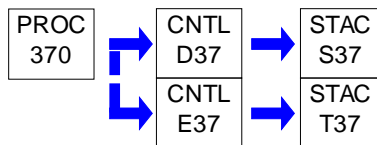
**\*\*\* Permit Shield in Effect. \*\*\***

**SECTION D. Source Level Requirements**

Source ID: 370

Source Name: TRUCK SILOS RCVNG

Source Capacity/Throughput: 100.000 Tons/HR CEMENT

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

# 001 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

No person shall permit the emission into the outdoor atmosphere of particulate matter from the Source ID 370 receiving truck silos in excess of 0.02 grain per dry standard cubic foot of effluent gas.

**II. TESTING REQUIREMENTS.**

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

**III. MONITORING REQUIREMENTS.**

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

**IV. RECORDKEEPING REQUIREMENTS.**

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

**V. REPORTING REQUIREMENTS.**

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

**VI. WORK PRACTICE REQUIREMENTS.**

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

**VII. ADDITIONAL REQUIREMENTS.**

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

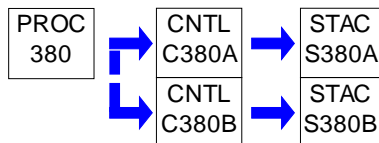
**\*\*\* Permit Shield in Effect. \*\*\***

**SECTION D. Source Level Requirements**

Source ID: 380

Source Name: TWO TRUCK LOADOUTS

Source Capacity/Throughput: 188.000 Tons/HR CEMENT

Conditions for this source occur in the following groups: 002 CAM SOURCES  
007 BART LIMITS**I. RESTRICTIONS.****Emission Restriction(s).**

# 001 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

No person shall permit the emission into the outdoor atmosphere of particulate matter from the Source ID 380 truck loadouts in excess of 0.02 grain per dry standard cubic foot of effluent gas.

**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. \*\*\***

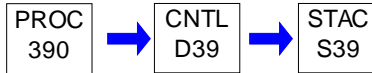
**SECTION D. Source Level Requirements**

Source ID: 390

Source Name: RAILCAR SILO/BULK TRUCK LOADOUT

Source Capacity/Throughput: 112.000 Tons/HR CEMENT

Conditions for this source occur in the following groups: 002 CAM SOURCES

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

# 001 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

Particulate matter emissions from the Source ID 390 railcar silo/bulk truck loadout shall not exceed an exhaust gas concentration of 0.02 grains per dry standard cubic foot of exhaust.

**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. \*\*\***

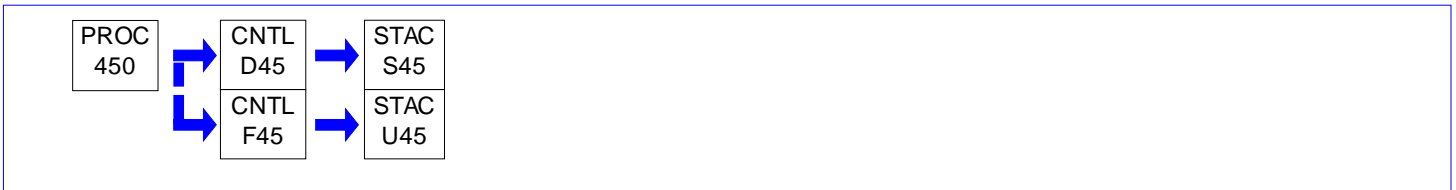
**SECTION D. Source Level Requirements**

Source ID: 450

Source Name: 1956 SILOS RECEIVING

Source Capacity/Throughput: 50.000 Tons/HR CEMENT

Conditions for this source occur in the following groups: 001 MATERIALS HANDLING EQUIPMENT  
007 BART LIMITS

**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. \*\*\***

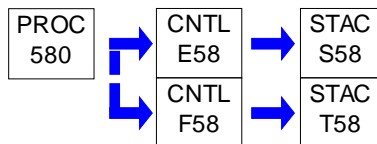
**SECTION D. Source Level Requirements**

Source ID: 580

Source Name: PACKHOUSE

Source Capacity/Throughput: 100.000 Tons/HR CEMENT

Conditions for this source occur in the following groups: 005 NSPS SUBPART F REQUIREMENTS

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

# 001 [25 Pa. Code §127.441]

**Operating permit terms and conditions.**

No person shall permit the emission into the outdoor atmosphere of particulate matter from the Source ID 580 white cement packhouse in excess of 0.02 grain per dry standard cubic foot of exhaust.

**II. TESTING REQUIREMENTS.**

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

**III. MONITORING REQUIREMENTS.**

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

**IV. RECORDKEEPING REQUIREMENTS.**

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

**V. REPORTING REQUIREMENTS.**

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

**VI. WORK PRACTICE REQUIREMENTS.**

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

**VII. ADDITIONAL REQUIREMENTS.**

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

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

**SECTION E. Source Group Restrictions.**

Group Name: 001 MATERIALS HANDLING EQUIPMENT

Group Description:

Sources included in this group

ID	Name
121A	LIMESTONE SILO PNEUMATIC
123	STONE/CLAY HANDLING SYSTEM
181	SOLID FUEL DELIVERY SYSTEM
205	CKD RETURN BIN 34 TON
207	WASTEDUST HANDLING SYSTEM
220	CLINKER DISCHARGE SYSTEM
300	FINISH MILL GRINDING SYSTEM
450	1956 SILOS RECEIVING

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

# 001 [25 Pa. Code §123.13]

**Processes**

Particulate matter emissions from the individual Group 001 materials handling units shall not exceed 0.04 grains per dry standard cubic foot of effluent gas.

**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: 002 CAM SOURCES

Group Description:

Sources included in this group

ID	Name
121A	LIMESTONE SILO PNEUMATIC
123	STONE/CLAY HANDLING SYSTEM
140	RAW MILL FEED SYSTEM
181	SOLID FUEL DELIVERY SYSTEM
207	WASTEDUST HANDLING SYSTEM
220	CLINKER DISCHARGE SYSTEM
230A	8TH FLOOR BLDG TRANSFER
380	TWO TRUCK LOADOUTS
390	RAILCAR SILO/BULK TRUCK LOADOUT

**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 following are compliance assurance monitoring (CAM) requirements for the Group 002 CAM sources:

- (a) The pressure differential across each baghouse associated with the Group 002 sources shall be continuously measured and recorded once daily.
- (b) Visible emissions from each baghouse associated with the Group 002 sources shall be monitored once per day according to EPA Method 22.

The above requirements are supported by the Section C Site Level and Section D Source Level requirements for work practices, monitoring, recordkeeping and reporting.

**IV. RECORDKEEPING REQUIREMENTS.**

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

**V. REPORTING REQUIREMENTS.**

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

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

[Additional authority for this Compliance Assurance Monitoring (CAM) permit condition is also derived from 40 CFR Part 64, Sections 64.3 and 64.6]

- (a) The permittee shall use the following criteria to evaluate the Group 002 sources and baghouses for proper operation:
  1. Baghouse pressure drop ranges:

**SECTION E. Source Group Restrictions.**

D22, E12, F12, F20, G20, E22 and D39 pressure drops shall be maintained between 1 and 9 inches w.g.

D14, C380A and C380B pressure drops shall be maintained between 1 and 20 inches w.g.

D18 and E18 pressure drops shall be maintained between 1 and 7 inches w.g.

C230A pressure drop shall be maintained between 1 and 8 inches w.g.

2. Opacity from the baghouse exhaust stacks shall not equal or exceed 20% for a period or periods aggregating more than 3 minutes in any 1 hour, or equal to or greater than 60% at any time.

(b) Each departure from the pressure drop and stack opacity ranges specified above shall be defined as an excursion. Each failure to measure these parameters at the specified interval with the approved method shall be defined as an excursion.

**VII. ADDITIONAL REQUIREMENTS.**

**# 003 [25 Pa. Code §127.441]**

**Operating permit terms and conditions.**

[Additional authority for this Compliance Assurance Monitoring (CAM) permit condition is also derived from 40 CFR Part 64, Sections 64.8 and 64.9]

(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 for any given unit-parameter combination in a six-month reporting period.
2. Department review indicates that the permittee has not responded acceptably to an excursion.

(b) The QIP shall be developed and submitted to the Department within 60 days from the date the QIP became necessary. Furthermore, the permittee shall notify the Department if the implementation of the improvements in the QIP require more than 180 days from the date the QIP became necessary.

(c) The permittee shall record actions taken to implement the QIP during each reporting period and all related actions including, but not limited to, inspections, repairs and maintenance of the monitoring equipment.

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

1. Improved preventive maintenance practices
2. Process changes.
3. Appropriate improvements to control methods
4. Other appropriate measures.

(e) Following the implementation of a QIP, the Department will require reasonable revisions to the QIP if the plan:

1. Fails to address the control device performance problem.
2. Fails to correct control device performance 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 complying with all applicable emission limits, monitoring, recordkeeping, reporting and other requirements of federal, state and local laws, and the Clean Air Act.

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

**SECTION E. Source Group Restrictions.**

Group Name: 003 SUBPART LLL MACT REQUIREMENTS

Group Description:

Sources included in this group

ID	Name
200	WHITE CEMENT KILN
D20	WESTERN PRECIP. ESP

**I. RESTRICTIONS.**

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

**II. TESTING REQUIREMENTS.**

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

**III. MONITORING REQUIREMENTS.**

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

**IV. RECORDKEEPING REQUIREMENTS.**

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

**V. REPORTING REQUIREMENTS.**

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

**VI. WORK PRACTICE REQUIREMENTS.**

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

**VII. ADDITIONAL REQUIREMENTS.**

**# 001 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1340]**

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

**What parts of my plant does this subpart cover?**

§63.1340 What parts of my plant does this subpart cover?

(a) The provisions of this subpart apply to each new and existing portland cement plant which is a major source or an area source as defined in §63.2.

(b) The affected sources subject to this subpart are:

(1) Each kiln including alkali bypasses and inline coal mills, except for kilns that burn hazardous waste and are subject to and regulated under subpart EEE of this part;

(2) Each clinker cooler at any portland cement plant;

(3) Each raw mill at any portland cement plant;

(4) Each finish mill at any portland cement plant;

(5) [NA – NO RAW MATERIAL DRYERS]

**SECTION E. Source Group Restrictions.**

- (6) Each raw material, clinker, or finished product storage bin at any portland cement plant that is a major source;
  - (7) Each conveying system transfer point including those associated with coal preparation used to convey coal from the mill to the kiln at any portland cement plant that is a major source;
  - (8) Each bagging and bulk loading and unloading system at any portland cement plant that is a major source; and
  - (9) Each open clinker storage pile at any portland cement plant.
- (c) Onsite sources that are subject to standards for nonmetallic mineral processing plants in subpart OOO, part 60 of this chapter are not subject to this subpart. Crushers are not covered by this subpart regardless of their location.
- (d) If you are subject to any of the provisions of this subpart you are also subject to title V permitting requirements.

[75 FR 55051, Sept. 9, 2010, as amended at 78 FR 10036, Feb. 12, 2013]

§63.1341 Definitions. [INCORPORATED BY REFERENCE]

**# 002 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1340]**

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

**What parts of my plant does this subpart cover?**

EMISSION STANDARDS AND OPERATING LIMITS

§63.1342 Standards: General.

Table 1 to this subpart provides cross references to the 40 CFR part 63, subpart A, general provisions, indicating the applicability of the general provisions requirements to subpart LLL.

[71 FR 76549, Dec. 20, 2006]

§63.1343 What standards apply to my kilns, clinker coolers, raw material dryers, and open clinker storage piles?

(a) General. The provisions in this section apply to each kiln and any alkali bypass associated with that kiln, clinker cooler, raw material dryer, and open clinker storage pile. All D/F, HCl, and total hydrocarbon (THC) emissions limit are on a dry basis. The D/F, HCl, and THC limits for kilns are corrected to 7 percent oxygen. All THC emissions limits are measured as propane. Standards for mercury and THC are based on a rolling 30-day average. If using a CEMS to determine compliance with the HCl standard, this standard is based on a rolling 30-day average. You must ensure appropriate corrections for moisture are made when measuring flow rates used to calculate mercury emissions. The 30-day period means all operating hours within 30 consecutive kiln operating days excluding periods of startup and shutdown. All emissions limits for kilns, clinker coolers, and raw material dryers currently in effect that are superseded by the limits below continue to apply until the compliance date of the limits below, or until the source certifies compliance with the limits below, whichever is earlier.

(b) Kilns, clinker coolers, raw material dryers, raw mills, and finish mills. (1) The emissions limits for these sources are shown in Table 1.

**TABLE 1 REQUIREMENTS**

Item 1: If your source is an existing kiln, and the operating mode is normal operation, and if it is located at a major or area source, your emissions limits are:

- a. PM: 0.07 lb/ton clinker with no oxygen correction factor. The initial and subsequent PM performance tests are performed using Method 5 or 5I and consist of three test runs.
- b. D/F: 0.2 ng/dscm (TEQ) with an oxygen correction factor of 7%. If the average temperature at the inlet to the first PM control device (fabric filter or electrostatic precipitator) during the D/F performance test is 400 °F or less, this limit is changed to 0.40 ng/dscm (TEQ).

**SECTION E. Source Group Restrictions.**

- c. Mercury: 55 lb/MM tons clinker with no oxygen correction factor  
e. THC 24 ppmvd (measured as propane) with an oxygen correction factor of 7%. Any source subject to the 24 ppmvd THC limit may elect to meet an alternative limit of 12 ppmvd for total organic HAP.

Item 2: [NA – NOT A MAJOR HAP FACILITY]

Item 3: If your source is an existing kiln, and the operating mode is startup and shutdown, and if it is located at a major or area source, your emissions limits are work practices, per 63.1346(g).

Items 4-6: [NA – KILN IS EXISTING]

Items 7-10: [NA – NO CLINKER COOLERS]

Items 11-13: [NA – NO RAW MATERIAL DRYERS]

END OF TABLE 1 REQUIREMENTS

(2) [NA – NO ALKALI BYPASS OR INLINE COAL MILL]

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

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

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

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

[78 FR 10037, Feb. 12, 2013, as amended at 80 FR 44779, July 27, 2015; 83 FR 35132, July 25, 2018]

§63.1344 [Reserved]

§63.1345 Emissions limits for affected sources other than kilns; clinker coolers; new and reconstructed raw material dryers.

The owner or operator of each new or existing raw material, clinker, or finished product storage bin; conveying system transfer point; bagging system; bulk loading or unloading system; raw and finish mills; and each existing raw material dryer, at a facility which is a major source subject to the provisions of this subpart must not cause to be discharged any gases from these affected sources which exhibit opacity in excess of 10 percent.

[78 FR 10039, Feb. 12, 2013]

§63.1346 Operating limits for kilns.

**SECTION E. Source Group Restrictions.**

(a) The owner or operator of a kiln subject to a D/F emissions limitation under §63.1343 must operate the kiln such that the temperature of the gas at the inlet to the kiln PM control device (PMCD) and alkali bypass PMCD, if applicable, does not exceed the applicable temperature limit specified in paragraph (b) of this section. The owner or operator of an in-line kiln/raw mill subject to a D/F emissions limitation under §63.1343 must operate the in-line kiln/raw mill, such that:

(1) When the raw mill of the in-line kiln/raw mill is operating, the applicable temperature limit for the main in-line kiln/raw mill exhaust, specified in paragraph (b) of this section and established during the performance test when the raw mill was operating, is not exceeded, except during periods of startup and shutdown when the temperature limit may be exceeded by no more than 10 percent.

(2) When the raw mill of the in-line kiln/raw mill is not operating, the applicable temperature limit for the main in-line kiln/raw mill exhaust, specified in paragraph (b) of this section and established during the performance test when the raw mill was not operating, is not exceeded, except during periods of startup/shutdown when the temperature limit may be exceeded by no more than 10 percent.

(3) [NA – NO ALKALI BYPASS]

(b) The temperature limit for affected sources meeting the limits of paragraph (a) of this section or paragraphs (a)(1) through (a)(3) of this section is determined in accordance with §63.1349(b)(3)(iv).

(c) [NA – NO SORBENT INJECTION FOR D/F CONTROL]

(d) – (e) [NA – NO CARBON INJECTION FOR D/F CONTROL]

(f) No kiln may use as a raw material or fuel any fly ash where the mercury content of the fly ash has been increased through the use of activated carbon, or any other sorbent, unless the facility can demonstrate that the use of that fly ash will not result in an increase in mercury emissions over baseline emissions (i.e., emissions not using the fly ash). The facility has the burden of proving there has been no emissions increase over baseline. Once the kiln is in compliance with a mercury emissions limit specified in §63.1343, this paragraph no longer applies.

(g) During periods of startup and shutdown you must meet the requirements listed in (g)(1) through (4) of this section.

(1) During startup you must use any one or combination of the following clean fuels: natural gas, synthetic natural gas, propane, distillate oil, synthesis gas (syngas), and ultra-low sulfur diesel (ULSD) until the kiln reaches a temperature of 1200 degrees Fahrenheit.

(2) Combustion of the primary kiln fuel may commence once the kiln temperature reaches 1200 degrees Fahrenheit.

(3) All dry sorbent and activated carbon systems that control hazardous air pollutants must be turned on and operating at the time the gas stream at the inlet to the baghouse or ESP reaches 300 degrees Fahrenheit (five minute average) during startup. Temperature of the gas stream is to be measured at the inlet of the baghouse or ESP every minute. Such injection systems can be turned off during shutdown. Particulate control and all remaining devices that control hazardous air pollutants should be operational during startup and shutdown.

(4) You must keep records as specified in §63.1355 during periods of startup and shutdown.

[75 FR 55054, Sept. 9, 2010, as amended at 78 FR 10039, Feb. 12, 2013; 80 FR 44781, July 27, 2015]

§63.1347 Operation and maintenance plan requirements.

(a) You must prepare, for each affected source subject to the provisions of this subpart, a written operations and maintenance plan. The plan must be submitted to the Administrator for review and approval as part of the application for a part 70 permit and must include the following information:

(1) Procedures for proper operation and maintenance of the affected source and air pollution control devices in order to meet the emissions limits and operating limits, including fugitive dust control measures for open clinker piles of §§63.1343, 63.1345, and 63.1346. Your operations and maintenance plan must address periods of startup and shutdown.

**SECTION E. Source Group Restrictions.**

(2) Corrective actions to be taken when required by paragraph §63.1350(f)(3);

(3) Procedures to be used during an inspection of the components of the combustion system of each kiln and each in-line kiln raw mill located at the facility at least once per year.

(b) Failure to comply with any provision of the operations and maintenance plan developed in accordance with this section is a violation of the standard.

[75 FR 55054, Sept. 9, 2010, as amended at 78 FR 10040, Feb. 12, 2013; 80 FR 44781, July 27, 2015]

§63.1348 Compliance requirements.

(a) [INITIAL PERFORMANCE TEST IS IN THE PAST]

(b) Continuous Monitoring Requirements. You must demonstrate compliance with the emissions standards and operating limits by using the performance test methods and procedures in §§63.1350 and 63.8 for each affected source.

(1) General Requirements. (i) You must monitor and collect data according to §63.1350 and the site-specific monitoring plan required by §63.1350(p).

(ii) Except for periods of startup and shutdown, monitoring system malfunctions, repairs associated with monitoring system malfunctions, and required monitoring system quality assurance or quality control activities (including, as applicable, calibration checks and required zero and span adjustments), you must operate the monitoring system and collect data at all required intervals at all times the affected source is operating.

(iii) You may not use data recorded during monitoring system startup, shutdown or malfunctions or repairs associated with monitoring system malfunctions in calculations used to report emissions or operating levels. A monitoring system malfunction is any sudden, infrequent, not reasonably preventable failure of the monitoring system to provide valid data. Monitoring system failures that are caused in part by poor maintenance or careless operation are not malfunctions. You must use all the data collected during all other periods in assessing the operation of the control device and associated control system.

(iv) Clinker Production. If you are subject to limitations on mercury emissions (lb/MM tons of clinker) under §63.1343(b), you must determine the hourly production rate of clinker according to the requirements of §63.1350(d).

(2) PM Compliance. If you are subject to limitations on PM emissions under §63.1343(b), you must use the monitoring methods and procedures in §63.1350(b) and (d).

(3) [NA – NO OPACITY LIMIT UNDER 63.1343]

(4) D/F Compliance. If you are subject to a D/F emissions limitation under §63.1343(b), you must demonstrate compliance using a continuous monitoring system (CMS) that is installed, operated and maintained to record the temperature of specified gas streams in accordance with the requirements of §63.1350(g).

(5) [NA – NO CARBON INJECTION FOR D/F CONTROL]

(6) THC Compliance. (i) - (ii) [NA - NO COAL MILL OR COAL MILL STACK]

(7) Mercury Compliance. (i) If you are subject to limitations on mercury emissions in §63.1343(b), you must demonstrate compliance using the monitoring methods and procedures in §63.1350(k). If you use an integrated sorbent trap monitoring system to determine ongoing compliance, use the procedures described in §63.1348(a)(5) to assign hourly mercury concentration values and to calculate rolling 30 operating day emissions rates. Since you assign the mercury concentration measured with the sorbent trap to each relevant hour respectively for each operating day of the integrated period, you may schedule the sorbent trap change periods to any time of the day (i.e., the sorbent trap replacement need not be scheduled at 12:00 midnight nor must the sorbent trap replacements occur only at integral 24-hour intervals).

(ii) Mercury must be measured either upstream of the coal mill or in the coal mill stack.

**SECTION E. Source Group Restrictions.**

(8) [NA – NO HCL LIMIT UNDER 63.16430]

(9) [NA – NO CARBON/SORBENT INJECTION FOR D/F CONTROL]

(c) Changes in operations. (1) If you plan to undertake a change in operations that may adversely affect compliance with an applicable standard, operating limit, or parametric monitoring value under this subpart, the source must conduct a performance test as specified in §63.1349(b).

(2) In preparation for and while conducting a performance test required in §63.1349(b), you may operate under the planned operational change conditions for a period not to exceed 360 hours, provided that the conditions in (c)(2)(i) through (c)(2)(iv) of this section are met. You must submit temperature and other monitoring data that are recorded during the pretest operations.

(i) You must provide the Administrator written notice at least 60 days prior to undertaking an operational change that may adversely affect compliance with an applicable standard under this subpart for any source, or as soon as practicable where 60 days advance notice is not feasible. Notice provided under this paragraph must include a description of the planned change, the emissions standards that may be affected by the change, and a schedule for completion of the performance test required under paragraph (c)(1) of this section, including when the planned operational change period would begin.

(ii) The performance test results must be documented in a test report according to §63.1349(a).

(iii) A test plan must be made available to the Administrator prior to performance testing, if requested.

(iv) The performance test must be completed within 360 hours after the planned operational change period begins.

(d) General duty to minimize emissions. At all times you must 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. 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.

[75 FR 55055, Sept. 9, 2010, as amended at 78 FR 10040, Feb. 12, 2013; 80 FR 44781, July 27, 2015; 83 FR 35132, July 25, 2018]

**# 003 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1340]**

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

**What parts of my plant does this subpart cover?**

MONITORING AND COMPLIANCE PROVISIONS

§63.1349 Performance testing requirements.

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

(1) A brief description of the process and the air pollution control system;

(2) Sampling location description(s);



**SECTION E. Source Group Restrictions.**

- (3) A description of sampling and analytical procedures and any modifications to standard procedures;
  - (4) Test results;
  - (5) Quality assurance procedures and results;
  - (6) Records of operating conditions during the performance test, preparation of standards, and calibration procedures;
  - (7) Raw data sheets for field sampling and field and laboratory analyses;
  - (8) Documentation of calculations;
  - (9) All data recorded and used to establish parameters for monitoring; and
  - (10) Any other information required by the performance test method.
- (b)(1) PM emissions tests. The owner or operator of a kiln and clinker cooler subject to limitations on PM emissions shall demonstrate initial compliance by conducting a performance test using Method 5 or Method 5I at appendix A-3 to part 60 of this chapter. You must also monitor continuous performance through use of a PM continuous parametric monitoring system (PM CPMS).
- (i) For your PM CPMS, you will establish a site-specific operating limit. If your PM performance test demonstrates your PM emission levels to be below 75 percent of your emission limit you will use the average PM CPMS value recorded during the PM compliance test, the milliamp or digital equivalent of zero output from your PM CPMS, and the average PM result of your compliance test to establish your operating limit. If your PM compliance test demonstrates your PM emission levels to be at or above 75 percent of your emission limit you will use the average PM CPMS value recorded during the PM compliance test to establish your operating limit. You will use the PM CPMS to demonstrate continuous compliance with your operating limit. You must repeat the performance test annually and reassess and adjust the site-specific operating limit in accordance with the results of the performance test.
- (A) Your PM CPMS must provide a 4-20 milliamp or digital signal output and the establishment of its relationship to manual reference method measurements must be determined in units of milliamperes or the monitor's digital equivalent.
- (B) Your PM CPMS operating range must be capable of reading PM concentrations from zero to a level equivalent to three times your allowable emission limit. If your PM CPMS is an auto-ranging instrument capable of multiple scales, the primary range of the instrument must be capable of reading PM concentration from zero to a level equivalent to three times your allowable emission limit.
- (C) During the initial performance test or any such subsequent performance test that demonstrates compliance with the PM limit, record and average all milliamp or digital output values from the PM CPMS for the periods corresponding to the compliance test runs (e.g., average all your PM CPMS output values for three corresponding Method 5I test runs).
- (ii) Determine your operating limit as specified in paragraphs (b)(1)(iii) through (iv) of this section. If your PM performance test demonstrates your PM emission levels to be below 75 percent of your emission limit you will use the average PM CPMS value recorded during the PM compliance test, the milliamp or digital equivalent of zero output from your PM CPMS, and the average PM result of your compliance test to establish your operating limit. If your PM compliance test demonstrates your PM emission levels to be at or above 75 percent of your emission limit you will use the average PM CPMS value recorded during the PM compliance test to establish your operating limit. You must verify an existing or establish a new operating limit after each repeated performance test. You must repeat the performance test at least annually and reassess and adjust the site-specific operating limit in accordance with the results of the performance test.
- (iii) If the average of your three Method 5 or 5I compliance test runs is below 75 percent of your PM emission limit, you must calculate an operating limit by establishing a relationship of PM CPMS signal to PM concentration using the PM CPMS instrument zero, the average PM CPMS values corresponding to the three compliance test runs, and the average PM concentration from the Method 5 or 5I compliance test with the procedures in (b)(1)(iii)(A) through (D) of this section.
- (A) Determine your PM CPMS instrument zero output with one of the following procedures:

**SECTION E. Source Group Restrictions.**

- (1) Zero point data for in-situ instruments should be obtained by removing the instrument from the stack and monitoring ambient air on a test bench.
- (2) Zero point data for extractive instruments should be obtained by removing the extractive probe from the stack and drawing in clean ambient air.
- (3) The zero point may also be established by performing manual reference method measurements when the flue gas is free of PM emissions or contains very low PM concentrations (e.g., when your process is not operating, but the fans are operating or your source is combusting only natural gas) and plotting these with the compliance data to find the zero intercept.
- (4) If none of the steps in paragraphs (b)(1)(iii)(A)(1) through (3) of this section are possible, you must use a zero output value provided by the manufacturer.
- (B) Determine your PM CPMS instrument average in milliamps or digital equivalent, and the average of your corresponding three PM compliance test runs, using equation 3. [SEE REGULATION FOR EQUATION]
- (C) With your instrument zero expressed in milliamps or a digital value, your three run average PM CPMS milliamp or digital signal value, and your three run PM compliance test average, determine a relationship of lb/ton-clinker per milliamp or digital signal value with Equation 4. [SEE REGULATION FOR EQUATION]
- (D) Determine your source specific 30-day rolling average operating limit using the lb/ton-clinker per milliamp or digital signal value from Equation 4 in Equation 5, below. This sets your operating limit at the PM CPMS output value corresponding to 75 percent of your emission limit. [SEE REGULATION FOR EQUATION]
- (iv) If the average of your three PM compliance test runs is at or above 75 percent of your PM emission limit you must determine your operating limit by averaging the PM CPMS milliamp or digital equivalent output corresponding to your three PM performance test runs that demonstrate compliance with the emission limit using Equation 6. [SEE REGULATION FOR EQUATION]
- (v) To determine continuous operating compliance, you must record the PM CPMS output data for all periods when the process is operating, and use all the PM CPMS data for calculations when the source is not out-of-control. You must demonstrate continuous compliance by using all quality-assured hourly average data collected by the PM CPMS for all operating hours to calculate the arithmetic average operating parameter in units of the operating limit (milliamps or the digital equivalent) on a 30 operating day rolling average basis, updated at the end of each new kiln operating day. Use Equation 7 to determine the 30 kiln operating day average. [SEE REGULATION FOR EQUATION]
- (vi) For each performance test, conduct at least three separate test runs under the conditions that exist when the affected source is operating at the level reasonably expected to occur. Conduct each test run to collect a minimum sample volume of 2 dscm for determining compliance with a new source limit and 1 dscm for determining compliance with an existing source limit. Calculate the time weighted average of the results from three consecutive runs, including applicable sources as required by paragraph (b)(1)(viii) of this section, to determine compliance. You need not determine the particulate matter collected in the impingers "back half" of the Method 5 or Method 5I particulate sampling train to demonstrate compliance with the PM standards of this subpart. This shall not preclude the permitting authority from requiring a determination of the "back half" for other purposes. For kilns with inline raw mills, testing must be conducted while the raw mill is on and while the raw mill is off. If the exhaust streams of a kiln with an inline raw mill and a clinker cooler are comingled, then the comingled exhaust stream must be tested with the raw mill on and the raw mill off.
- (vii) For PM performance test reports used to set a PM CPMS operating limit, the electronic submission of the test report must also include the make and model of the PM CPMS instrument, serial number of the instrument, analytical principle of the instrument (e.g. beta attenuation), span of the instruments primary analytical range, milliamp value or digital equivalent to the instrument zero output, technique by which this zero value was determined, and the average milliamp or digital equivalent signals corresponding to each PM compliance test run.
- (viii) [NA – NO ALKALI BYPASS OR INLINE COAL MILL]
- (ix) [NA – NO INLINE RAW MILL]

**SECTION E. Source Group Restrictions.**

(2) [NA – NO OPACITY LIMIT UNDER THIS SECTION]

(3) D/F Emissions Tests. If you are subject to limitations on D/F emissions under this subpart, you must conduct a performance test using Method 23 of appendix A-7 to part 60 of this chapter. If your kiln or in-line kiln/raw mill is equipped with an alkali bypass, you must conduct simultaneous performance tests of the kiln or in-line kiln/raw mill exhaust and the alkali bypass. You may conduct a performance test of the alkali bypass exhaust when the raw mill of the in-line kiln/raw mill is operating or not operating.

(i) Each performance test must consist of three separate runs conducted under representative conditions. The duration of each run must be at least 3 hours, and the sample volume for each run must be at least 2.5 dscm (90 dscf).

(ii) The temperature at the inlet to the kiln or in-line kiln/raw mill PMCD, and, where applicable, the temperature at the inlet to the alkali bypass PMCD must be continuously recorded during the period of the Method 23 test, and the continuous temperature record(s) must be included in the performance test report.

(iii) Average temperatures must be calculated for each run of the performance test.

(iv) The run average temperature must be calculated for each run, and the average of the run average temperatures must be determined and included in the performance test report and will determine the applicable temperature limit in accordance with §63.1346(b).

(v) [NA – NO SORBENT INJECTION FOR D/F CONTROL]

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

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

(iii) [NA – NO ALKALI BYPASS OR INLINE COAL MILL]

(iv) [NA - NO COAL MILL OR COAL MILL STACK]

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

(5) Mercury Emissions Tests. If you are subject to limitations on mercury emissions, you must operate a mercury CEMS or a sorbent trap monitoring system in accordance with the requirements of §63.1350(k). The initial compliance test must be based on the first 30 kiln operating days in which the affected source operates using a mercury CEMS or a sorbent trap monitoring system after the compliance date of the rule. See §63.1348(a).

(i) If you are using a mercury CEMS or a sorbent trap monitoring system, you must install, operate, calibrate, and maintain an instrument for continuously measuring and recording the exhaust gas flow rate to the atmosphere according to the requirements in §63.1350(k)(5).

(ii) Calculate the emission rate using Equation 10 of this section: [SEE REGULATION FOR EQUATION]

(6) [NA – NO HCL LIMIT UNDER THIS SECTION]

(7) [TOTAL ORGANIC HAP EMISSIONS TEST OPTION NOT USED]

(8) [NA – NO HCL LIMIT UNDER THIS SECTION]

(c) Performance test frequency. Except as provided in §63.1348(b), performance tests are required at regular intervals for affected sources that are subject to a dioxin, organic HAP or HCl emissions limit. Performance tests required every 30

**SECTION E. Source Group Restrictions.**

months must be completed no more than 31 calendar months after the previous performance test except where that specific pollutant is monitored using CEMS; performance tests required every 12 months must be completed no more than 13 calendar months after the previous performance test.

(d) [Reserved]

(e) Conditions of performance tests. Conduct performance tests under such conditions as the Administrator specifies to the owner or operator based on representative performance of the affected source for the period being tested. Upon request, you must make available to the Administrator such records as may be necessary to determine the conditions of performance tests.

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

§63.1350 Monitoring requirements.

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

(2) [Reserved]

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

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

(b) PM monitoring requirements. (1)(i) PM CPMS. You will use a PM CPMS to establish a site-specific operating limit corresponding to the results of the performance test demonstrating compliance with the PM limit. You will conduct your performance test using Method 5 or Method 5I at appendix A-3 to part 60 of this chapter. You will use the PM CPMS to demonstrate continuous compliance with this operating limit. You must repeat the performance test annually and reassess and adjust the site-specific operating limit in accordance with the results of the performance test using the procedures in §63.1349(b)(1) (i) through (vi) of this subpart. You must also repeat the test if you change the analytical range of the instrument, or if you replace the instrument itself or any principle analytical component of the instrument that would alter the relationship of output signal to in-stack PM concentration.

(ii) To determine continuous compliance, you must use the PM CPMS output data for all periods when the process is operating and the PM CPMS is not out-of-control. You must demonstrate continuous compliance by using all quality-assured hourly average data collected by the PM CPMS for all operating hours to calculate the arithmetic average operating parameter in units of the operating limit (milliamps) on a 30 operating day rolling average basis, updated at the end of each new kiln operating day.

(iii) For any exceedance of the 30 process operating day PM CPMS average value from the established operating parameter limit, you must:

(A) Within 48 hours of the exceedance, visually inspect the APCD;

(B) If inspection of the APCD identifies the cause of the exceedance, take corrective action as soon as possible and return the PM CPMS measurement to within the established value; and

(C) Within 30 days of the exceedance or at the time of the annual compliance test, whichever comes first, conduct a PM emissions compliance test to determine compliance with the PM emissions limit and to verify or re-establish the PM CPMS operating limit within 45 days. You are not required to conduct additional testing for any exceedances that occur between the time of the original exceedance and the PM emissions compliance test required under this paragraph.

(iv) PM CPMS exceedances leading to more than four required performance tests in a 12-month process operating period

**SECTION E. Source Group Restrictions.**

(rolling monthly) constitute a presumptive violation of this subpart.

(2) [Reserved]

(c) [Reserved]

(d) Clinker production monitoring requirements. In order to determine clinker production, you must:

(1) Determine hourly clinker production by one of two methods:

(i) Install, calibrate, maintain, and operate a permanent weigh scale system to measure and record weight rates in tons-mass per hour of the amount of clinker produced. The system of measuring hourly clinker production must be maintained within  $\pm 5$  percent accuracy, or

(ii) Install, calibrate, maintain, and operate a permanent weigh scale system to measure and record weight rates in tons-mass per hour of the amount of feed to the kiln. The system of measuring feed must be maintained within  $\pm 5$  percent accuracy. Calculate your hourly clinker production rate using a kiln-specific feed to clinker ratio based on reconciled clinker production determined for accounting purposes and recorded feed rates. Update this ratio monthly. Note that if this ratio changes at clinker reconciliation, you must use the new ratio going forward, but you do not have to retroactively change clinker production rates previously estimated.

(iii) [Reserved]

(2) Determine, record, and maintain a record of the accuracy of the system of measuring hourly clinker production (or feed mass flow if applicable) before initial use (for new sources) or by the effective compliance date of this rule (for existing sources). During each quarter of source operation, you must determine, record, and maintain a record of the ongoing accuracy of the system of measuring hourly clinker production (or feed mass flow).

(3) If you measure clinker production directly, record the daily clinker production rates; if you measure the kiln feed rates and calculate clinker production, record the hourly kiln feed and clinker production rates.

(4) Develop an emissions monitoring plan in accordance with paragraphs (p)(1) through (p)(4) of this section.

(e) [Reserved]

(f) [NA – NO OPACITY LIMIT UNDER THIS SECTION]

(g) D/F monitoring requirements. If you are subject to an emissions limitation on D/F emissions, you must comply with the monitoring requirements of paragraphs (g)(1) through (5) and (m)(1) through (4) of this section to demonstrate continuous compliance with the D/F emissions standard. You must also develop an emissions monitoring plan in accordance with paragraphs (p)(1) through (4) of this section.

(1) You must install, calibrate, maintain, and continuously operate a CMS to record the temperature of the exhaust gases from the kiln and alkali bypass, if applicable, at the inlet to, or upstream of, the kiln and/or alkali bypass PMCDs.

(i) The temperature recorder response range must include zero and 1.5 times the average temperature established according to the requirements in §63.1349(b)(3)(iv).

(ii) The calibration reference for the temperature measurement must be a National Institute of Standards and Technology calibrated reference thermocouple-potentiometer system or alternate reference, subject to approval by the Administrator.

(iii) The calibration of all thermocouples and other temperature sensors must be verified at least once every three months.

(2) You must monitor and continuously record the temperature of the exhaust gases from the kiln and alkali bypass, if applicable, at the inlet to the kiln and/or alkali bypass PMCD.

(3) The required minimum data collection frequency must be one minute.

**SECTION E. Source Group Restrictions.**

- (4) Every hour, record the calculated rolling three-hour average temperature using the average of 180 successive one-minute average temperatures. See §63.1349(b)(3).
- (5) When the operating status of the raw mill of the in-line kiln/raw mill is changed from off to on or from on to off, the calculation of the three-hour rolling average temperature must begin anew, without considering previous recordings.
- (h) [NA – NO SORBENT INJECTION FOR D/F CONTROL]
- (i) THC Monitoring Requirements. If you are subject to an emissions limitation on THC emissions, you must comply with the monitoring requirements of paragraphs (i)(1) and (i)(2) and (m)(1) through (m)(4) of this section. You must also develop an emissions monitoring plan in accordance with paragraphs (p)(1) through (p)(4) of this section.
- (1) You must install, operate, and maintain a THC continuous emission monitoring system in accordance with Performance Specification 8 or Performance Specification 8A of appendix B to part 60 of this chapter and comply with all of the requirements for continuous monitoring systems found in the general provisions, subpart A of this part. The owner or operator must operate and maintain each CEMS according to the quality assurance requirements in Procedure 1 of appendix F in part 60 of this chapter. For THC continuous emission monitoring systems certified under Performance Specification 8A, conduct the relative accuracy test audits required under Procedure 1 in accordance with Performance Specification 8, Sections 8 and 11 using Method 25A in appendix A to 40 CFR part 60 as the reference method; the relative accuracy must meet the criteria of Performance Specification 8, Section 13.2.
- (2) Performance tests on alkali bypass and coal mill stacks must be conducted using Method 25A in appendix A to 40 CFR part 60 and repeated every 30 months.
- (j) [TOTAL ORGANIC HAP MONITORING OPTION NOT USED]
- (k) Mercury monitoring requirements. If you have a kiln subject to an emissions limitation on mercury emissions, you must install and operate a mercury continuous emissions monitoring system (Hg CEMS) in accordance with Performance Specification 12A (PS 12A) of appendix B to part 60 of this chapter or an integrated sorbent trap monitoring system in accordance with Performance Specification 12B (PS 12B) of appendix B to part 60 of this chapter. You must monitor mercury continuously according to paragraphs (k)(1) through (5) of this section. You must also develop an emissions monitoring plan in accordance with paragraphs (p)(1) through (4) of this section.
- (1) - (2) [NA - PERMITTEE OPERATES AN INTEGRATED SORBENT TRAP MONITORING SYSTEM]
- (3) You must operate and maintain each Hg CEMS or an integrated sorbent trap monitoring system according to the quality assurance requirements in Procedure 5 of appendix F to part 60 of this chapter. During the RATA of integrated sorbent trap monitoring systems required under Procedure 5, you may apply the appropriate exception for sorbent trap section 2 breakthrough in (k)(3)(i) through (iv) of this section:
- (i) For stack Hg concentrations  $>1 \mu\text{g/dscm}$ , =10% of section 1 mass;
- (ii) For stack Hg concentrations  $=1 \mu\text{g/dscm}$  and  $>0.5 \mu\text{g/dscm}$ , =20% of section 1 mass;
- (iii) For stack Hg concentrations  $=0.5 \mu\text{g/dscm}$  and  $>0.1 \mu\text{g/dscm}$ , =50% of section 1 mass; and
- (iv) For stack Hg concentrations  $=0.1 \mu\text{g/dscm}$ , no breakthrough criterion assuming all other QA/QC specifications are met.
- (4) Relative accuracy testing of mercury monitoring systems under PS 12A, PS 12B, or Procedure 5 must be conducted at normal operating conditions. If a facility has an inline raw mill, the testing must occur with the raw mill on.
- (5) If you use a Hg CEMS or an integrated sorbent trap monitoring system, you must install, operate, calibrate, and maintain an instrument for continuously measuring and recording the exhaust gas flow rate to the atmosphere according to the requirements in paragraphs (n)(1) through (10) of this section. If kiln gases are diverted through an alkali bypass or to a coal mill and exhausted through separate stacks, you must account for the mercury emitted from those stacks by following the procedures in (k)(5)(i) through (iv) of this section:

**SECTION E. Source Group Restrictions.**

- (i) Develop a mercury hourly mass emissions rate by conducting performance tests annually, within 11 to 13 calendar months after the previous performance test, using Method 29, or Method 30B, to measure the concentration of mercury in the gases exhausted from the alkali bypass and coal mill.
- (ii) On a continuous basis, determine the mass emissions of mercury in lb/hr from the alkali bypass and coal mill exhausts by using the mercury hourly emissions rate and the exhaust gas flow rate to calculate hourly mercury emissions in lb/hr.
- (iii) Sum the hourly mercury emissions from the kiln, alkali bypass and coal mill to determine total mercury emissions. Using hourly clinker production, calculate the hourly emissions rate in pounds per ton of clinker to determine your 30 day rolling average.
- (iv) If mercury emissions from the coal mill and alkali bypass are below the method detection limit for two consecutive annual performance tests, you may reduce the frequency of the performance tests of coal mills and alkali bypasses to once every 30 months. If the measured mercury concentration exceeds the method detection limit, you must revert to testing annually until two consecutive annual tests are below the method detection limit.
- (6) If you operate an integrated sorbent trap monitoring system conforming to PS 12B, you may use a monitoring period at least 24 hours but no longer than 168 hours in length. You should use a monitoring period that is a multiple of 24 hours (except during relative accuracy testing as allowed in PS 12B).
- (l) [NA – NO HCL LIMIT UNDER THIS SECTION]
- (m) Parameter monitoring requirements. If you have an operating limit that requires the use of a CMS, you must install, operate, and maintain each continuous parameter monitoring system (CPMS) according to the procedures in paragraphs (m)(1) through (4) of this section by the compliance date specified in §63.1351. You must also meet the applicable specific parameter monitoring requirements in paragraphs (m)(5) through (11) that are applicable to you.
- (1) The CMS must complete a minimum of one cycle of operation for each successive 15-minute period. You must have a minimum of four successive cycles of operation to have a valid hour of data.
- (2) You must conduct all monitoring in continuous operation at all times that the unit is operating.
- (3) Determine the 1-hour block average of all recorded readings.
- (4) Record the results of each inspection, calibration, and validation check.
- (5) [NA – NO LIQUID FLOW RATE MONITORING REQUIRED]
- (6) [NA - NO PRESSURE MONITORING REQUIREMENTS]
- (7) [NA - NO PH MONITORING REQUIREMENTS]
- (8) [Reserved]
- (9) [NA – NO MASS FLOW RATE (FOR SORBENT INJECTION) MONITORING REQUIREMENTS]
- (10) [NA – NO OPACITY LIMIT UNDER THIS SECTION]
- (11) [NA – NO OPACITY LIMIT UNDER THIS SECTION]
- (n) [NA – NO CONTINUOUS FLOW RATE MONITORING SYSTEM REQUIRED]
- (o) [NA – NO ALTERNATE MONITORING REQUIREMENTS]
- (p) Development and submittal (upon request) of monitoring plans. If you demonstrate compliance with any applicable emissions limit through performance stack testing or other emissions monitoring, you must develop a site-specific monitoring plan according to the requirements in paragraphs (p)(1) through (4) of this section. This requirement also

**SECTION E. Source Group Restrictions.**

applies to you if you petition the EPA Administrator for alternative monitoring parameters under paragraph (o) of this section and §63.8(f). If you use a BLDS, you must also meet the requirements specified in paragraph (p)(5) of this section.

(1) For each CMS required in this section, you must develop, and submit to the permitting authority for approval upon request, a site-specific monitoring plan that addresses paragraphs (p)(1)(i) through (iii) of this section. You must submit this site-specific monitoring plan, if requested, at least 30 days before your initial performance evaluation of your CMS.

(i) Installation of the CMS sampling probe or other interface at a measurement location relative to each affected process unit such that the measurement is representative of control of the exhaust emissions (e.g., on or downstream of the last control device);

(ii) Performance and equipment specifications for the sample interface, the pollutant concentration or parametric signal analyzer, and the data collection and reduction systems; and

(iii) Performance evaluation procedures and acceptance criteria (e.g., calibrations).

(2) In your site-specific monitoring plan, you must also address paragraphs (p)(2)(i) through (iii) of this section.

(i) Ongoing operation and maintenance procedures in accordance with the general requirements of §63.8(c)(1), (c)(3), and (c)(4)(ii);

(ii) Ongoing data quality assurance procedures in accordance with the general requirements of §63.8(d); and

(iii) Ongoing recordkeeping and reporting procedures in accordance with the general requirements of §63.10(c), (e)(1), and (e)(2)(i).

(3) You must conduct a performance evaluation of each CMS in accordance with your site-specific monitoring plan.

(4) You must operate and maintain the CMS in continuous operation according to the site-specific monitoring plan.

(5) [NA – NO OPACITY LIMITS UNDER THIS SECTION]

[75 FR 55059, Sept. 9, 2010, as amended at 76 FR 2836, Jan. 18, 2011; 78 FR 10048, Feb. 12, 2013; 80 FR 44788, July 27, 2015; 80 FR 54729, Sept. 11, 2015; 81 FR 48361, July 25, 2016; 82 FR 28565, June 23, 2017; 82 FR 39673, Aug. 22, 2017; 83 FR 35133, July 25, 2018]

§63.1351 Compliance dates.

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

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

(2) [NA – COMMENCED CONSTRUCTION BEFORE 3/24/98]

(b) [NA – COMMENCED CONSTRUCTION BEFORE 3/24/98]

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

(d) [NA – SOURCE IS EXISTING]

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

[76 FR 2836, Jan. 18, 2011, as amended at 78 FR 10053, Feb. 12, 2013]



**SECTION E. Source Group Restrictions.**

§63.1352 Additional test methods. [LISTED METHODS NOT APPLICABLE]

**# 004 [40 CFR Part 63 NESHAPS for Source Categories §40 CFR 63.1340]**

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

**What parts of my plant does this subpart cover?**

NOTIFICATION, REPORTING AND RECORDKEEPING

§63.1353 Notification requirements.

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

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

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

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

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

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

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

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

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

§63.1354 Reporting requirements.

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

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

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

(2) [NA – NO OPACITY LIMIT UNDER THIS SECTION]

(3) [NA – NO EXTENSION OF COMPLIANCE]

**SECTION E. Source Group Restrictions.**

(4)-(5) [Reserved]

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

(7) [NA – NO OPACITY LIMIT UNDER THIS SECTION]

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

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

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

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

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

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

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

(vi) For each PM CPMS, HCl, Hg, and THC CEMS, SO<sub>2</sub> CEMS, or Hg sorbent trap monitoring system, within 60 days after the reporting periods, you must report all of the calculated 30-operating day rolling average values derived from the CPMS, CEMS, CMS, or Hg sorbent trap monitoring systems.

(vii) In response to each violation of an emissions standard or established operating parameter limit, the date, duration and description of each violation and the specific actions taken for each violation including inspections, corrective actions and repeat performance tests and the results of those actions.

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

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

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

(B) The values for the site-specific operating limits or parameters established pursuant to §63.1349(b)(1), (3), (6), (7), and

**SECTION E. Source Group Restrictions.**

(8), as applicable, and a description, including sample calculations, of how the operating parameters were established during the initial performance test.

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

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

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

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

[64 FR 31925, June 14, 1999, as amended at 75 FR 55063, Sept. 9, 2010; 78 FR 10053, Feb. 12, 2013; 80 FR 44790, July 27, 2015; 83 FR 35135, July 25, 2018]

**§63.1355 Recordkeeping requirements.**

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

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

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

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

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

(c) In addition to the recordkeeping requirements in paragraph (b) of this section, the owner or operator of an affected source equipped with a continuous monitoring system shall maintain all records required by §63.10(c).

**SECTION E. Source Group Restrictions.**

(d) [Reserved]

(e) You must keep records of the daily clinker production rates according to the clinker production monitoring requirements in §63.1350(d).

(f) You must keep records of the date, time and duration of each startup or shutdown period for any affected source that is subject to a standard during startup or shutdown that differs from the standard applicable at other times, and the quantity of feed and fuel used during the startup or shutdown period.

(g)(1) You must keep records of the date, time and duration of each malfunction that causes an affected source to fail to meet an applicable standard; if there was also a monitoring malfunction, the date, time and duration of the monitoring malfunction; the record must list the affected source or equipment, an estimate of the volume of each regulated pollutant emitted over the standard for which the source failed to meet a standard, and a description of the method used to estimate the emissions.

(2) You must keep records of actions taken during periods of malfunction to minimize emissions in accordance with §63.1348(d) including corrective actions to restore malfunctioning process and air pollution control and monitoring equipment to its normal or usual manner of operation.

(h) For each exceedance from an emissions standard or established operating parameter limit, you must keep records of the date, duration and description of each exceedance and the specific actions taken for each exceedance including inspections, corrective actions and repeat performance tests and the results of those actions.

[64 FR 31925, June 14, 1999, as amended at 71 FR 76552, Dec. 20, 2006; 75 FR 55064, Sept. 9, 2010; 78 FR 10053, Feb. 12, 2013; 80 FR 44791, July 27, 2015; 81 FR 48362, July 25, 2016; 83 FR 35135, July 25, 2018]

**OTHER**

§63.1356 Sources with multiple emissions limit or monitoring requirements.

If you have an affected source subject to this subpart with a different emissions limit or requirement for the same pollutant under another regulation in title 40 of this chapter, once you are in compliance with the most stringent emissions limit or requirement, you are not subject to the less stringent requirement. Until you are in compliance with the more stringent limit, the less stringent limit continues to apply.

[80 FR 44791, July 27, 2015]

§63.1357 [Reserved]

§63.1358 Implementation and enforcement. [INCORPORATED BY REFERENCE]

§63.1359 [Reserved]

**Regulatory Changes**

Individual sources within this source group that are subject to 40 CFR Part 63 Subpart LLL shall comply with all applicable requirements of the Subpart. 40 CFR 63.13(a) requires submission of copies of all requests, reports and other communications to both the Department and the EPA. The EPA copies shall be forwarded to:

Director  
Air Protection Division (3AP00)  
U.S. EPA Region III  
1650 Arch Street  
Philadelphia, PA 19103-2029

The Department copies shall be forwarded to:

**SECTION E. Source Group Restrictions.**

Regional Air Program Manager  
PA Department of Environmental Protection  
909 Elmerton Avenue  
Harrisburg, PA 17110-8200

In the event that the Federal Subpart that is the subject of this Source Group is revised, the permittee shall comply with the revised version of the subpart, and shall not be required to comply with any provisions in this permit designated as having the subpart as their authority, to the extent that such permit provisions would be inconsistent with the applicable provisions of the revised subpart.

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

**SECTION E. Source Group Restrictions.**

Group Name: 004 CEMS REQUIREMENTS

Group Description:

Sources included in this group

ID	Name
200	WHITE CEMENT KILN

**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 following continuous emission monitoring system (CEMS) and components must be installed, approved by the Department, operated and maintained in accordance with the requirements of 25 Pa. Code Chapter 139, Subchapter C (relating to requirements for source monitoring for stationary sources), and the Submittal and Approval, Record Keeping and Reporting, and Quality Assurance requirements of Revision No. 8 of the Department's Continuous Source Monitoring Manual, 274-0300-001.

## 1. Exhaust Gas Flow CEMS

- Source Combination to be Monitored: Source 200
- Parameter to be Reported: Exhaust Gas Flow
- Units of Measurement to be Reported: SCFM
- Moisture Basis of Measurement to be Reported: NA
- Correction basis of Measurements to be Reported: NA
- Data Substitution Required: No
- Emission Standard: NA
- Averaging Period: NA

2. NO<sub>x</sub> CEMS

- Source Combination to be Monitored: Source 200
- Parameter to be Reported: NO<sub>x</sub> (as NO<sub>2</sub>)
- Units of Measurement to be Reported: lb/hr
- Moisture Basis of Measurement to be Reported: NA
- Correction basis of Measurements to be Reported: NA
- Data Substitution Required: Yes, for NO<sub>x</sub> lbs/hr as per 40 CFR Part 75
- NO<sub>x</sub> Emission Standard: There is not a NO<sub>x</sub> lb/hr emission standard. The NO<sub>x</sub> CEMS (CMS) data will be used to determine compliance with RACT 2, to determine compliance with Condition 003 in Section D for Source 200, and to develop emission inventories.
- Averaging Period: NO<sub>x</sub> data to be collected and recorded as one-hour averages to be summarized daily and then used in the calculation of a 30-day rolling daily average and expressed as pounds of NO<sub>x</sub> emitted per ton of clinker produced. The RACT 2 requirement for a wet-process kiln in Pennsylvania is to not exceed 3.88 lbs NO<sub>x</sub> per ton of clinker produced in a 30-day rolling average for all operating periods in a calendar year.

3. SO<sub>2</sub> CEMS

- Source Combination to be Monitored: Source 200
- Parameter to be Reported: SO<sub>2</sub>
- Units of Measurement to be Reported: ppm
- Moisture Basis of Measurement to be Reported: Dry
- Correction basis of Measurements to be Reported: None
- Data Substitution Required: No

**SECTION E. Source Group Restrictions.**

- g. SO<sub>2</sub> Emission Standards (See Condition 002 in Section D, for Source 200)
- h. Averaging Period: one-hour average, block

4. O<sub>2</sub> CEMS

- a. Source Combination to be Monitored: Source 200
- b. Parameter to be Reported: O<sub>2</sub>
- c. Units of Measurement to be Reported: percent
- d. Moisture Basis of Measurement to be Reported: NA
- e. Correction basis of Measurements to be Reported: NA
- f. Data Substitution Required: NA
- g. Emission Standard: NA
- h. Averaging Period: NA

## 5. Clinker Production CMS [Continuous Monitoring System]

- a. Source Combination to be Monitored: Source 200
- b. Parameter to be Reported: clinker production
- c. Units of Measurement to be Reported: ton/hr
- d. Moisture Basis of Measurement to be Reported: NA
- e. Correction basis of Measurements to be Reported: NA
- f. Data Substitution Required: Yes, for NO<sub>x</sub> lbs/hr as per 40 CFR Part 75
- g. NO<sub>x</sub> Emission Standard: There is not a clinker ton/hr emission standard. The clinker production CEMS (CMS) data will be used to determine compliance with RACT 2, and to determine compliance with Condition 003 in Section D for Source 200.
- h. Averaging Period: Clinker Production data to be collected and recorded as one-hour averages. The clinker production will be summarized daily and then used in the calculation of a 30-day rolling daily average and expressed as pounds of NO<sub>x</sub> emitted per ton of clinker produced. The RACT 2 requirement for a wet-process kiln in Pennsylvania is to not exceed 3.88 lbs NO<sub>x</sub> per ton of clinker produced in a 30-day rolling average for all operating periods in a calendar year.

Compliance with any subsequently issued revisions to the Continuous Source Monitoring Manual will constitute compliance with the regulations.

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

Continuous emission monitoring for NO<sub>x</sub> (lb/hr), and SO<sub>2</sub> (ppm) shall meet the following minimum data availability requirements

a.) In accordance with 25 Pa. Code Section 139.101(12), required monitoring shall, at a minimum, meet one of the following data availability requirements unless otherwise stipulated in this permit, a plan approval, Title 25 or an order issued under Section 4 of the Air Pollution Control Act:

- 1.) In each calendar month, at least 90% of the time periods for which each emission standard applies, shall be valid as set forth in the Quality Assurance section of Revision No.8 of the Department's Continuous Source Monitoring Manual, 274-0300-001, or
- 2.) In each calendar quarter, at least 95% of the hours shall be valid as set forth in the Quality Assurance section of Revision No. 8 of the Department's Continuous Source Monitoring Manual, 274-0300-001.

Compliance with any subsequently issued revisions to the Continuous Source Monitoring Manual will constitute compliance with the regulations.

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

1. The permittee shall comply with the recordkeeping requirements established in 25 Pa. Code Chapter 139, Subchapter C (relating to requirements for source monitoring for stationary sources), the "Record Keeping and Reporting" requirements in the Department's Continuous Source Monitoring Manual, Revision No. 8, 274-0300-001.
2. Records shall be retained for at least 5 years and shall be made available to the Department upon request.

**SECTION E. Source Group Restrictions.**

Note: Compliance with any subsequently issued revision to the Continuous Source Monitoring Manual will constitute compliance with this condition.

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

The permittee shall submit quarterly reports of continuous emission monitoring to the Department in accordance with the requirements established in 25 Pa. Code Chapter 139, Subchapter C (relating to requirements for source monitoring for stationary sources), and the Record Keeping and Reporting requirements as established in Revision No. 8 of the Department's Continuous Source Monitoring Manual, 274-0300-001, and

The permittee shall report emissions for all periods of unit operation, including startup, shutdown and malfunction.

Initial quarterly reports following system certification shall be submitted to the Department within 35 days following the date upon which the Department notifies the owner or operator, in writing, of the approval of the continuous source monitoring system for use in determining compliance with applicable emission standards.

Subsequent quarterly reports shall be submitted to the Department within 30 days after the end of each calendar quarter.

Failure to submit required reports of continuous emission monitoring within the time periods specified in this Condition, shall constitute violations of this Permit, unless approved in advance by the Department in writing.

Compliance with any subsequently issued revision to the Continuous Source Monitoring Manual will constitute compliance with this permit condition.

**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: 005 NSPS SUBPART F REQUIREMENTS

Group Description:

Sources included in this group

ID	Name
232	FRINGE BIN
580	PACKHOUSE

**I. RESTRICTIONS.**

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

**II. TESTING REQUIREMENTS.**

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

**III. MONITORING REQUIREMENTS.**

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

**IV. RECORDKEEPING REQUIREMENTS.**

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

**V. REPORTING REQUIREMENTS.**

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

**VI. WORK PRACTICE REQUIREMENTS.**

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

**VII. ADDITIONAL REQUIREMENTS.****# 001 [40 CFR Part 60 Standards of Performance for New Stationary Sources §40 CFR 60.60]****Subpart F - Standards of Performance for Portland Cement Plants****Applicability and designation of affected facility.**

§60.60 Applicability and designation of affected facility.

(a) The provisions of this subpart are applicable to the following affected facilities in portland cement plants: Kiln, clinker cooler, raw mill system, finish mill system, raw mill dryer, raw material storage, clinker storage, finished product storage, conveyor transfer points, bagging and bulk loading and unloading systems.

(b) Any facility under paragraph (a) of this section that commences construction or modification after August 17, 1971, is subject to the requirements of this subpart.

[42 FR 37936, July 25, 1977]

§60.61 Definitions. [INCORPORATED BY REFERENCE]

§60.62 Standards.

(a) [NA – KILN IS NOT PRESENTLY SUBJECT TO THIS REGULATION]

(b) [NA – CLINKER COOLER IS NOT PRESENTLY SUBJECT TO THIS REGULATION]

**SECTION E. Source Group Restrictions.**

(c) On and after the date on which the performance test required to be conducted by §60.8 is completed, you may not discharge into the atmosphere from any affected facility other than the kiln and clinker cooler any gases which exhibit 10 percent opacity, or greater.

(d) If you have an affected source subject to this subpart with a different emissions limit or requirement for the same pollutant under another regulation in title 40 of this chapter, once you are in compliance with the most stringent emissions limit or requirement, you are not subject to the less stringent requirement. Until you are in compliance with the more stringent limit, the less stringent limit continues to apply.

(e) The compliance date for all revised monitoring and recordkeeping requirements contained in this rule will be the same as listed in 63.1351(c) unless you commenced construction as of June 16, 2008, at which time the compliance date is November 8, 2010 or upon startup, whichever is later.

[75 FR 55034, Sept. 9, 2010, as amended at 78 FR 10032, Feb. 12, 2013; 80 FR 44777, July 27, 2015]

**§60.63 Monitoring of operations.**

(a) [Reserved]

(b) –(h) [NA – KILN/CLINKER COOLER NOT PRESENTLY SUBJECT TO THIS REGULATION]

(i) [NA – PERFORMANCE STACK TESTING/CPMS NOT REQUIRED]

**§60.64 Test methods and procedures.**

(a) In conducting the performance tests and relative accuracy tests required in §60.8, you must use reference methods and procedures and the test methods in appendix A of this part or other methods and procedures as specified in this section, except as provided in §60.8(b).

(b)(1) [NA – NO PMLIMIT]

(2) Use Method 9 and the procedures in §60.11 to determine opacity.

(3) Any sources other than kilns (including associated alkali bypass and clinker cooler) that are subject to the 10 percent opacity limit must follow the appropriate monitoring procedures in §63.1350(f), (m)(1) through (4), (10) and (11), (o), and (p) of this chapter.

(c) [NA – NOT SUBJECT TO NOX/SO2 STANDARD]

(d)(1) Within 60 days after the date of completing each performance test (see §60.8) as required by this subpart you must submit the results of the performance tests conducted to demonstrate compliance under this subpart to the EPA's WebFIRE database by using the Compliance and Emissions Data Reporting Interface (CEDRI) that is accessed through the EPA's Central Data Exchange (CDX) (<http://www.epa.gov/cdx>). Performance test data must be submitted in the file format generated through use of the EPA's Electronic Reporting Tool (ERT) (see <http://www.epa.gov/ttn/chief/ert/index.html>). Only data collected using test methods on the ERT Web site are subject to this requirement for submitting reports electronically to WebFIRE. Owners or operators who claim that some of the information being submitted for performance tests is confidential business information (CBI) must submit a complete ERT file including information claimed to be CBI on a compact disk, flash drive or other commonly used electronic storage media to the EPA. The electronic media must be clearly marked as CBI and mailed to U.S. EPA/OAPQS/CORE CBI Office, Attention: WebFIRE Administrator, MD C404-02, 4930 Old Page Rd., Durham, NC 27703. The same ERT file with the CBI omitted must be submitted to the EPA via CDX as described earlier in this paragraph. At the discretion of the delegated authority, you must also submit these reports, including the CBI, to the delegated authority in the format specified by the delegated authority. For any performance test conducted using test methods that are not listed on the ERT Web site, you must submit the results of the performance test to the Administrator at the appropriate address listed in §63.13.

(2) [NA – NSPS CEMS NOT REQUIRED]

**SECTION E. Source Group Restrictions.**

(3) [NA – NO PM STANDARD]

(4) All reports required by this subpart not subject to the requirements in paragraphs (d)(1) and (2) of this section must be sent to the Administrator at the appropriate address listed in §63.13. The Administrator or the delegated authority may request a report in any form suitable for the specific case (e.g., by commonly used electronic media such as Excel spreadsheet, on CD or hard copy). The Administrator retains the right to require submittal of reports subject to paragraph (d)(1) and (2) of this section in paper format.

[78 FR 10035, Feb. 12, 2013, as amended at 80 FR 44778, July 27, 2015]

§60.65 Recordkeeping and reporting requirements.

(a) [NA – NO CPMS OR CEMS]

(b) [NA – NOT SUBJECT TO §60.63(c) - (e)]

(c) The requirements of this section remain in force until and unless the Agency, in delegating enforcement authority to a State under section 111(c) of the Clean Air Act, 42 U.S.C. 7411, approves reporting requirements or an alternative means of compliance surveillance adopted by such States. In that event, affected sources within the State will be relieved of the obligation to comply with this section, provided that they comply with the requirements established by the State.

[78 FR 10035, Feb. 12, 2013]

§60.66 Delegation of authority. [INCORPORATED BY REFERENCE]

#### Regulatory Changes

Individual sources within this source group that are subject to 40 CFR Part 60 Subpart F shall comply with all applicable requirements of the Subpart. 40 CFR 60.4 requires submission of copies of all requests, reports and other communications to both the Department and the EPA. The EPA copies shall be forwarded to:

Director  
Air Protection Division (3AP00)  
U.S. EPA Region III  
1650 Arch Street  
Philadelphia, PA 19103-2029

The Department copies shall be forwarded to:

Regional Air Program Manager  
PA Department of Environmental Protection  
909 Elmerton Avenue  
Harrisburg, PA 17110-8200

In the event that the Federal Subpart that is the subject of this Source Group is revised, the permittee shall comply with the revised version of the subpart, and shall not be required to comply with any provisions in this permit designated as having the subpart as their authority, to the extent that such permit provisions would be inconsistent with the applicable provisions of the revised subpart.

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

**SECTION E. Source Group Restrictions.**

Group Name: 006 RACT 2 REQUIREMENTS

Group Description: (25 Pa Code 129.96 -129-100)

**Sources included in this group**

ID	Name
200	WHITE CEMENT KILN

**I. RESTRICTIONS.**

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

**II. TESTING REQUIREMENTS.**

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

**III. MONITORING REQUIREMENTS.**

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

**IV. RECORDKEEPING REQUIREMENTS.**

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

**V. REPORTING REQUIREMENTS.**

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

**VI. WORK PRACTICE REQUIREMENTS.**

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

**VII. ADDITIONAL REQUIREMENTS.****# 001 [25 Pa. Code §129.96]****Applicability**

§ 129.96. Applicability.

(a) The NO<sub>x</sub> requirements of this section and §§ 129.97—129.100 apply Statewide to the owner and operator of a major NO<sub>x</sub> emitting facility and the VOC requirements of this section and §§ 129.97—129.100 apply Statewide to the owner and operator of a major VOC emitting facility that were in existence on or before July 20, 2012, for which a requirement or emission limitation, or both, has not been established in §§ 129.51—129.52c, 129.54—129.63, 129.64—129.69, 129.71—129.75, 129.77, 129.101—129.107 and 129.301—129.310.

(b) [NA – FACILITY IS ALREADY MAJOR FOR NO<sub>x</sub>]

(c) This section and §§ 129.97—129.100 do not apply to the owner and operator of a NO<sub>x</sub> air contamination source located at a major NO<sub>x</sub> emitting facility that has the potential to emit less than 1 TPY of NO<sub>x</sub> or a VOC air contamination source located at a major VOC emitting facility that has the potential to emit less than 1 TPY of VOC.

(d) [NA – FACILITY IS ALREADY MAJOR FOR NO<sub>x</sub>]

§ 129.97. Presumptive RACT requirements, RACT emission limitations and petition for alternative compliance schedule.

(a) The owner and operator of a source listed in one or more of subsections (b)—(h) located at a major NO<sub>x</sub> emitting

**SECTION E. Source Group Restrictions.**

facility or major VOC emitting facility subject to § 129.96 (relating to applicability) shall comply with the applicable presumptive RACT requirement or RACT emission limitation, or both, beginning with the specified compliance date as follows, unless an alternative compliance schedule is submitted and approved under subsections (k)—(m) or § 129.99 (relating to alternative RACT proposal and petition for alternative compliance schedule):

- (1) January 1, 2017, for a source subject to § 129.96(a).
- (2) [NA – SOURCE IS EXISTING]
- (b) [NA – SOURCE IS A CEMENT KILN]
- (c) The owner and operator of a source specified in this subsection, which is located at a major NO<sub>x</sub> emitting facility or major VOC emitting facility subject to § 129.96 shall install, maintain and operate the source in accordance with the manufacturer's specifications and with good operating practices:
  - (1) A NO<sub>x</sub> air contamination source that has the potential to emit less than 5 TPY of NO<sub>x</sub>.
  - (2) A VOC air contamination source that has the potential to emit less than 2.7 TPY of VOC.
  - (3) A boiler or other combustion source with an individual rated gross heat input less than 20 million Btu/hour.
  - (4) A combustion turbine with a rated output less than 1,000 bhp.
  - (5) A stationary internal combustion engine rated at less than 500 bhp (gross).
  - (6) An incinerator, thermal oxidizer or catalytic oxidizer used primarily for air pollution control.
  - (7) [NA – CAPACITY FACTOR NOT USED]
  - (8) An emergency standby engine operating less than 500 hours in a 12-month rolling period.
- (d) [NA – FACILITY IS NOT MAJOR FOR VOC]
- (e) [NA – NOT A LANDFILL]
- (f) [NA – NOT A MWI]
- (g) [NA – SPECIFIED SOURCE CATEGORIES DO NOT APPLY]
- (h) The owner and operator of a Portland cement kiln subject to § 129.96 shall comply with the following applicable presumptive RACT emission limitation:
  - (1) 3.88 pounds of NO<sub>x</sub> per ton of clinker produced for a long wet-process cement kiln as defined in § 145.142 (relating to definitions).
  - (2) - (3) [NA - KILN IS WET PROCESS]
- (i) The requirements and emission limitations of this section supersede the requirements and emission limitations of a RACT permit issued to the owner or operator of an air contamination source subject to one or more of subsections (b)—(h) prior to April 23, 2016, under §§ 129.91—129.95 (relating to stationary sources of NO<sub>x</sub> and VOCs) to control, reduce or minimize NO<sub>x</sub> emissions or VOC emissions, or both, from the air contamination source unless the permit contains more stringent requirements or emission limitations, or both.
- (j) The requirements and emission limitations of this section supersede the requirements and emission limitations of §§ 129.201—129.205, 145.111—145.113 and 145.141—145.146 (relating to additional NO<sub>x</sub> requirements; emissions of NO<sub>x</sub> from stationary internal combustion engines; and emissions of NO<sub>x</sub> from cement manufacturing) unless the requirements or emission limitations of §§ 129.201—129.205, §§ 145.111—145.113 or § 145.141—145.146 are more stringent.

**SECTION E. Source Group Restrictions.**

(k) – (m) [NA- KILN CAN MEET PRESUMPTIVE RACT]

§ 129.98. [NA – NO AVERAGING PLAN]

§ 129.99. [NA – NO ALTERNATIVE RACT OR COMPLIANCE SCHEDULE]

§ 129.100. Compliance demonstration and recordkeeping requirements.

(a) Except as provided in subsection (c), the owner and operator of an air contamination source subject to a NO<sub>x</sub> RACT requirement or RACT emission limitation or VOC RACT requirement or RACT emission limitation, or both, listed in § 129.97 (relating to presumptive RACT requirements, RACT emission limitations and petition for alternative compliance schedule) shall demonstrate compliance with the applicable RACT requirement or RACT emission limitation by performing the following monitoring or testing procedures:

(1) For an air contamination source with a CEMS, monitoring and testing in accordance with the requirements of Chapter 139, Subchapter C (relating to requirements for source monitoring for stationary sources) using a 30-day rolling average, except municipal waste combustors.

(i) A 30-day rolling average emission rate for an air contamination source that is a combustion unit shall be expressed in pounds per million Btu and calculated in accordance with the following procedure:

(A) Sum the total pounds of pollutant emitted from the combustion unit for the current operating day and the previous 29 operating days.

(B) Sum the total heat input to the combustion unit in million Btu for the current operating day and the previous 29 operating days.

(C) Divide the total number of pounds of pollutant emitted by the combustion unit for the 30 operating days by the total heat input to the combustion unit for the 30 operating days.

(ii) A 30-day rolling average emission rate for each applicable RACT emission limitation shall be calculated for an affected air contamination source for each consecutive operating day.

(iii) Each 30-day rolling average emission rate for an affected air contamination source must include the emissions that occur during the entire operating day, including emissions from start-ups, shutdowns and malfunctions.

(2) For a Portland cement kiln with a CEMS, monitoring of clinker production rates in accordance with 40 CFR 63.1350(d) (relating to monitoring requirements).

(3) [NA – NOT A MWI]

(4) [NA – SOURCE HAS CEMS]

(b) Except as provided in § 129.97(k) and § 129.99(i) (relating to alternative RACT proposal and petition for alternative compliance schedule), the owner and operator of an air contamination source subject to subsection (a) shall demonstrate compliance with the applicable RACT requirement or RACT emission limitation in accordance with the procedures in subsection (a) not later than:

(1) January 1, 2017, for a source subject to § 129.96(a) (relating to applicability).

(2) [NA – SOURCE IS ALREADY MAJOR FOR NO<sub>x</sub>]

(c) [NA – NO COMPLIANCE WAIVER]

(d) The owner and operator of an air contamination source subject to this section and § § 129.96—129.99 shall keep records to demonstrate compliance with § § 129.96—129.99 in the following manner:

**SECTION E. Source Group Restrictions.**

- (1) The records must include sufficient data and calculations to demonstrate that the requirements of §§ 129.96—129.99 are met.
- (2) Data or information required to determine compliance shall be recorded and maintained in a time frame consistent with the averaging period of the requirement.
- (e) Beginning with the compliance date specified in § 129.97(a), the owner or operator of an air contamination source claiming that the air contamination source is exempt from the applicable NO<sub>x</sub> emission rate threshold specified in § 129.99(b) and the requirements of § 129.97 based on the air contamination source's potential to emit shall maintain records that demonstrate to the Department or appropriate approved local air pollution control agency that the air contamination source is not subject to the specified emission rate threshold.
- (f) Beginning with the compliance date specified in § 129.97(a), the owner or operator of an air contamination source claiming that the air contamination source is exempt from the applicable VOC emission rate threshold specified in § 129.99(c) and the requirements of § 129.97 based on the air contamination source's potential to emit shall maintain records that demonstrate to the Department or appropriate approved local air pollution control agency that the air contamination source is not subject to the specified emission rate threshold.
- (g) [NA – SOURCE IS A CEMENT KILN]
- (h) The owner or operator of a Portland cement kiln subject to § 129.97(h) shall maintain a daily operating log for each Portland cement kiln. The record for each kiln must include:
  - (1) The total hours of operation.
  - (2) The type and quantity of fuel used.
  - (3) The quantity of clinker produced.
  - (4) The date, time and duration of a start-up, shutdown or malfunction of a Portland cement kiln or emissions monitoring system.
- (i) The records shall be retained by the owner or operator for 5 years and made available to the Department or appropriate approved local air pollution control agency upon receipt of a written request from the Department or appropriate approved local air pollution control agency.

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

**SECTION E. Source Group Restrictions.**

Group Name: 007 BART LIMITS

Group Description:

Sources included in this group

ID	Name
121A	LIMESTONE SILO PNEUMATIC
123	STONE/CLAY HANDLING SYSTEM
140	RAW MILL FEED SYSTEM
200	WHITE CEMENT KILN
205	CKD RETURN BIN 34 TON
220	CLINKER DISCHARGE SYSTEM
230A	8TH FLOOR BLDG TRANSFER
300	FINISH MILL GRINDING SYSTEM
380	TWO TRUCK LOADOUTS
450	1956 SILOS RECEIVING

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

# 001 [25 Pa. Code §127.512]

**Operating permit terms and conditions.**

The combined emissions from all Group 007 sources shall be limited to less than 250 tons during any consecutive 12-month rolling period for each of the following visibility impairing pollutants:

- (a) Nitrogen oxides (NO<sub>x</sub>)
- (b) PM-10 (particulate matter having an effective aerodynamic diameter less than or equal to a nominal 1 micron body)
- (c) Sulfur dioxide (SO<sub>2</sub>)

**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).



**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.**

No emission restrictions listed in this section of the permit.

**SECTION H. Miscellaneous.**

The Source ID FM43 solid fuel supply provides the following fuel materials to the Source ID 200 white cement kiln:

Petroleum coke

The following sources and activities are not subject to any specific emission limitations, restrictions, work practice standards, testing, monitoring, recordkeeping or reporting requirements:

1. Air conditioning and ventilation systems
2. Office equipment (copiers, printers, FAX, etc.)
3. Janitorial activities
4. Plant maintenance (painting, welding, paving, VOC cold cleaning, etc.)
5. Mobile sources (trucks, forklifts, snowblowers, etc.)
6. Boiler water treatment
7. Fuel oil, gasoline, kerosene and diethylene glycol storage tanks
8. Material storage areas
9. Clay mill/clay wash grizzly (Source 135)
10. Maintenance shop boiler (0.83 mmBtu/hour)
11. Kiln emergency engine (0.98 mmBtu/hour)
12. Raw mill (Source 150)
13. Fugitive sources, material handling (Source ID Nos. 122, 124, 221, & 231)
14. Quality control laboratory
15. Wind erosion of storage piles and open areas
16. Kiln backhousing cleaning
17. Fabric filters which vent indoors
18. York-Shipley Boilers #63 and #64

This permit incorporates requirements from the following:

- OP No. 67-05024 (previous versions)
- OP No. 67-2024 (RACT)
- Plan Approvals Nos. 67-05024A thru G

RFDs

- On 8/13/14, RFD 1015: for replacement of electrostatic precipitator (ESP) transformer/rectifiers unit (Source ID 200).



\*\*\*\*\* End of Report \*\*\*\*\*

---