

**Commonwealth of Kentucky
Energy and Environment Cabinet
Department for Environmental Protection
Division for Air Quality
300 Sower Boulevard, 2nd Floor
Frankfort, Kentucky 40601
(502) 564-3999**

Draft

**AIR QUALITY PERMIT
Issued under 401 KAR 52:030**

Permittee Name: Givaudan Flavors Corporation
Mailing Address: 9500 Sam Neace Drive,
Florence, KY 41042

Source Name: Givaudan Flavors Corporation
Mailing Address: 9500 Sam Neace Drive
Florence, KY 41042

Source Location: 9500 Sam Neace Drive
Florence, KY 41042

Permit ID: F-24-048
Agency Interest #: 4590
Activity ID: APE20230002, APE20240001
Review Type: Conditional Major, Operating
Source ID: 21-015-00150

Regional Office: Florence Regional Office
8020 Veterans Memorial Drive, Suite 110
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County: Boone

**Application
Complete Date:** September 23, 2024
Issuance Date:
Expiration Date:

**For Michael J. Kennedy, P.E.
Director
Division for Air Quality**

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Permit	Permit Type	Activity#	Complete Date	Issuance Date	Summary of Action
F-24-048	Renewal	APE20230002	2/28/2024		Renewal, updates to insignificant activities
	Minor Revision	APE20240001	9/27/2024		Addition of two new reactors under P014

SECTION A - PERMIT AUTHORIZATION

Pursuant to a duly submitted application the Kentucky Energy and Environment Cabinet (Cabinet) hereby authorizes the operation of the equipment described herein in accordance with the terms and conditions of this permit. This permit was issued under the provisions of Kentucky Revised Statutes (KRS) Chapter 224 and regulations promulgated pursuant thereto.

The permittee shall not construct, reconstruct, or modify any affected facilities without first submitting a complete application and receiving a permit for the planned activity from the permitting authority, except as provided in this permit or in 401 KAR 52:030, Federally-enforceable permits for non-major sources.

Issuance of this permit does not relieve the permittee from the responsibility of obtaining any other permits, licenses, or approvals required by the Cabinet or any other federal, state, or local agency.

SECTION B - EMISSION POINTS, EMISSION UNITS, APPLICABLE REGULATIONS, AND OPERATING CONDITIONS

01(P01) Filtermat

One (1) Filtermat Spray/Belt Dryer: Batch Process

Description:

Construction Date: August 2006

Maximum operating rate: 0.6 tons material output/hr calculated as an average over 30 days of operation on a rolling basis 5,256 tons material output/yr
7.04 mmBtu/hr natural gas consumption

Control Equipment: Regenerative Thermal Oxidizer (RTO) and Hinsilblon Odor Control System for Odor only and Scrubber/ Demister for PM₁₀; exhaust through Stack S01

Specific Control Equipment:

Equipment ID	Description	Controls
P01 Filtermat Givaudan Process-Stack S01	1 Filtermat Spray/ Belt Dryer	RTO for odor control only; Scrubber/demister C01 for PM ₁₀ control

07(P07) Spray Dryer #1

One (1) Spray Dryer: Batch Process

Description:

Construction Date: August 2008

Maximum operating rate: 1.75 tons material output/hr calculated as an average over 30 days of operation on a rolling basis
6.7 mmBtu/hr natural gas consumption

Control Equipment: Regenerative Thermal Oxidizer (RTO) and Hinsilblon Odor Control System for odor only and Scrubber/Demister for PM₁₀; exhaust through Stack S01

Specific Control Equipment:

Equipment ID	Description	Controls
P07 Spray Dryer #1 Givaudan Process-Stack S01	Spray Dryer #1	RTO for odor control only; Scrubber/demister C07 for PM ₁₀ control

APPLICABLE REGULATIONS:

401 KAR 59:010, New process operations.

401 KAR 59:015, New indirect heat exchangers

STATE-ORIGIN REQUIREMENT:

401 KAR 63:020, Potentially hazardous matter or toxic substances

1. Operating Limitations:

- a. Refer to **Section D** and **Section E**.

SECTION B - EMISSION POINTS, EMISSION UNITS, APPLICABLE REGULATIONS, AND OPERATING CONDITIONS (CONTINUED)

- b. In order to preclude the applicability of 401 KAR 52:020, Title V permits, all air pollution control equipment and all pollution control measures proposed by the application in response to which this permit is issued shall be in place, properly maintained, and in operation in accordance with the manufacturer's specifications and/or standard operating procedures at any time an affected facility for which the equipment and measures are designed is operated.

Compliance Demonstration Method:

Refer to **4. Specific Monitoring Requirements** a.

- c. During a startup or shutdown period, the permittee shall comply with the work practice standards established in 401 KAR 59:015, Section 7. [401 KAR 59:015, Section 7]
- (1) The permittee shall comply with 401 KAR 50:055, Section 2(5); [401 KAR 59:015, Section 7(1)(a)]
 - (2) The frequency and duration of startup periods or shutdown periods shall be minimized by the affected facility; [401 KAR 59:015, Section 7(1)(b)]
 - (3) All reasonable steps shall be taken by the permittee to minimize the impact of emissions on ambient air quality from the affected facility during startup periods and shutdown periods; [401 KAR 59:015, Section 7(1)(c)]
 - (4) The actions, including duration of the startup period, of the permittee during startup and shutdown periods, shall be documented in signed, contemporaneous logs or other relevant evidence; [401 KAR 59:015, Section 7(1)(d)]
 - (5) Startups and shutdowns shall be conducted according to either: [401 KAR 59:015, Section 7(1)(e)]
 - i. The manufacturer's recommended procedures; or [401 KAR 59:015, Section 7(1)(e)1.]
 - ii. Recommended procedures for a unit of similar design, for which manufacturer's recommended procedures are available, as approved by the cabinet based on documentation provided by the permittee. [401 KAR 59:015, Section 7(1)(e)2.]

Compliance Demonstration Method:

See **5. Specific Recordkeeping Requirements**, e.

- d. The permittee shall operate the RTO or Hinsilblon odor control system at all times that Emission unit 01 (P01) or 07 (P07) is in operation. [401 KAR 52:030, Section 10]

2. Emission Limitations:

- a. Emissions of particulate matter shall not exceed the allowable rate limit as calculated by the following equations: [401 KAR 59:010, Section 3(2)]
- (1) $E = 2.34 \text{ lbs/hr}$ for process rates up to 1,000 lbs/hr
 - (2) $E = 3.59 P^{0.62}$ for process rates greater than 1,000 lbs/hr up to 60,000 lbs/hr
 - (3) $E = 17.31P^{0.16}$ for process rates greater than 60,000 lb/hr

Where: E = rate of particulate emissions in lb(s)/hr, and
 P = process weight rate in tons/hr.

- b. No person shall cause, suffer, allow, or permit any continuous emission into the open air from a control device or stack associated with any affected facility which is equal to or

SECTION B - EMISSION POINTS, EMISSION UNITS, APPLICABLE REGULATIONS, AND OPERATING CONDITIONS (CONTINUED)

greater than twenty (20) percent opacity, except: [401 KAR 59:010, Section 3(1)(a) and 401 KAR 59:015, Section 4(2)]

- (1) A maximum of 40 percent opacity shall be allowed for a maximum of 6 consecutive minutes in any 60 minutes during fire box cleaning or soot blowing; and [401 KAR 59:015, Section 4(2)(b)]
 - (2) For emissions from an affected facility caused by building a new fire, emissions during the period required to bring the boiler up to operating conditions shall be allowed, if the method used is recommended by the manufacturer and the time does not exceed the manufacturer's recommendations. [401 KAR 59:015, Section 4(2)(c)]
- c. Emissions of particulate matter from emission unit 01(P01) shall not exceed 0.43 lb/mmBtu. [401 KAR 59:015, Section 4(1)]
 - d. Emissions of sulfur dioxide from emission unit 01(P01) shall not exceed 1.86 lb/mmBtu. [401 KAR 59:015, Section 5(1)]
 - e. Emissions of particulate matter from emission unit 07(P07) shall not exceed 0.40 lb/mmBtu. [401 KAR 59:015, Section 4(1)]
 - f. Emissions of sulfur dioxide from emission unit 07(P07) shall not exceed 1.65 lb/mmBtu. [401 KAR 59:015, Section 5(1)]

Compliance Demonstration Method:

- a. The source is assumed to be in compliance when the wet scrubber/demister is operating and properly maintained. Refer to **4. Specific Monitoring Requirements**.
 - b. For the limits under 401 KAR 59:015, compliance is assumed by burning natural gas.
 - c. For compliance with the opacity limitations, refer to **4. Specific Monitoring Requirements** and **5. Specific Recordkeeping Requirements**.
- g. Persons responsible for a source from which hazardous matter or toxic substances may be emitted shall provide the utmost care and consideration, in the handling of these materials, to the potentially harmful effects of the emissions resulting from such activities. No owner or operator shall allow any affected facility to emit potentially hazardous matter or toxic substances in such quantities or duration as to be harmful to the health and welfare of humans, animals and plants. Evaluation of such facilities as to adequacy of controls and/or procedures and emission potential will be made on an individual basis by the cabinet. [401 KAR 63:020, Section 3]

Compliance Demonstration Method:

Based upon the emission rates of toxics and hazardous air pollutants determined by the Cabinet using information provided in the application and supplemental information submitted by the source, the Cabinet determines the affected facility to be in compliance with 401 KAR 63:020.

3. Testing Requirements:

Testing shall be conducted at such times as may be requested by the Cabinet. [401 KAR 50:045, Section 1, and 401 KAR 59:005, Section 2(2)]

SECTION B - EMISSION POINTS, EMISSION UNITS, APPLICABLE REGULATIONS, AND OPERATING CONDITIONS (CONTINUED)

4. Specific Monitoring Requirements:

The permittee shall monitor the following parameters:

- a. Scrubbing liquid flow rate readings in gallons per minute (gpm) and pressure drop in inches of water (in H₂O) for the following control devices taken once daily and recorded when affected equipment is in operation. [401 KAR 52:030, Section 10]

Device	Emission Unit (Point)
C01 Wet Scrubber/Demister	01(P01)
C07 Wet Scrubber/Demister	07(P07)

- b. The permittee shall perform a qualitative visual observation of the opacity of emissions at each stack no less than weekly while the affected facility is operating. If visible emissions from the stacks are observed (not including condensed water in the plume), the permittee shall determine the opacity using U.S. EPA Reference Method 9. In lieu of determining the opacity using U.S. EPA Reference Method 9, the permittee shall immediately perform a corrective action which results in no visible emissions (not including condensed water in the plume). [401 KAR 52:030, Section 10]

5. Specific Recordkeeping Requirements:

- a. A daily record of scrubbing liquid flow rate in gpm of the above-mentioned wet scrubber/demister shall be kept, noting periods where no liquid flow rate readings were taken due to affected equipment not being in operation. [401 KAR 52:030, Section 10]
- b. All routine and non-routine maintenance activities performed on the wet scrubber/demister shall be recorded. [401 KAR 52:030, Section 10]
- c. A daily record of respective pressure drops shall be maintained for each control device listed in **4. Specific Monitoring Requirements** a. [401 KAR 52:030, Section 10]
- d. A log of the qualitative visual observations made as specified in **4. Specific Monitoring Requirements** including the date, time, initials of observer, whether any emissions were observed (yes/no), and any U.S. EPA Reference Method 9 readings taken. [401 KAR 52:030, Section 10]
- e. The permittee shall keep records of the manufacturer's recommended procedures for startup and shutdown. [401 KAR 52:030, Section 10]

6. Specific Reporting Requirements:

Refer to **Section F**.

SECTION B - EMISSION POINTS, EMISSION UNITS, APPLICABLE REGULATIONS, AND OPERATING CONDITIONS (CONTINUED)

03(P03) Three (3) Mixer/Blenders 1, 2, & 3 (2nd, 2nd and 3rd Floor): Batch Process

Description:

Construction Date: August 2006

Maximum operating rate: 4.5 tons material output/hr calculated as an average over 30 days of operation on a rolling basis; 21,263 tons material output/yr

Control Equipment: Rotoclones C04 and C05 to control PM₁₀; exhaust through Stack S08

04(P04) Three (3) Post Blend Fillers: 1, 2, & 3 (1st Floor): Batch Process

Description:

Construction Date: August 2006

Maximum operating rate: 4.5 tons material output/hr calculated as an average over 30 days of operation on a rolling basis; 21,263 tons material output/yr

Control Equipment: Dust Collector C06 to control PM₁₀ (vents indoors)
Rotoclone C05 to control PM₁₀; exhaust through Stack S08

05(P05) Two (2) Packaging Lines 1 & 2: Batch Process

Description:

Construction Date: August 2006

Maximum operating rate: 9.0 tons material output/hr calculated as an average over 30 days of operation on a rolling basis; 21,263 tons material output/yr

Control Equipment: Rotoclone C04 to control PM₁₀; exhaust through Stack S08

Specific Control Equipment:

Givaudan Process-Stack S08		
Equipment ID	Description	Controls
P03 Mixer/Blenders	3 Mixer/Blenders (Silo Transfer)	Rotoclone C04 to control PM ₁₀
	3 Mixer/Blenders	Rotoclone C05 to control PM ₁₀
P04 Post blend fillers	3 Post Blend Fillers	Rotoclone C05 to control PM ₁₀
P05 Packaging	2 Packaging Lines	Rotoclone C04 to control PM ₁₀

APPLICABLE REGULATIONS:

401 KAR 59:010, New process operations.

STATE-ORIGIN REQUIREMENTS:

401 KAR 63:020, Potentially hazardous matter or toxic substances.

1. Operating Limitations:

a. Refer to **Section D** and **Section E**.

b. In order to preclude the applicability of 401 KAR 52:030, Title V permits, all air pollution control equipment and all pollution control measures proposed by the application in response to which this permit is issued shall be in place, properly maintained, and in operation in

SECTION B - EMISSION POINTS, EMISSION UNITS, APPLICABLE REGULATIONS, AND OPERATING CONDITIONS (CONTINUED)

accordance with the manufacturer's specifications and/or standard operating procedures at any time an affected facility for which the equipment and measures are designed is operated.

Compliance Demonstration Method:

Refer to **4. Specific Monitoring Requirements** a.

2. Emission Limitations:

- a. Emissions of particulate matter shall not exceed the allowable rate limit as calculated by the following equations: [401 KAR 59:010, Section 3(2)]
 - (1) $E = 2.34 \text{ lbs/hr}$ for process rates up to 1,000 lbs/hr
 - (2) $E = 3.59 P^{0.62}$ for process rates greater than 1,000 lbs/hr up to 60,000 lbs/hr
 - (3) $E = 17.31P^{0.16}$ for process rates greater than 60,000 lb/hr

Where: E = rate of particulate emissions in lb(s)/hr, and
 P = process weight rate in tons/hr.

- b. No person shall cause, suffer, allow, or permit any continuous emission into the open air from a control device or stack associated with any affected facility which is equal to or greater than twenty (20) percent opacity. [401 KAR 59:010, Section 3(1)(a)]

Compliance Demonstration Method:

- a. The source is assumed to be in compliance when the control devices on P03 through P05 are operating and properly maintained. Refer to **4. Specific Monitoring Requirements**.
- b. For compliance with the opacity limitations, refer to **4. Specific Monitoring Requirements** and **5. Specific Recordkeeping Requirements**.
- c. Persons responsible for a source from which hazardous matter or toxic substances may be emitted shall provide the utmost care and consideration, in the handling of these materials, to the potentially harmful effects of the emissions resulting from such activities. No owner or operator shall allow any affected facility to emit potentially hazardous matter or toxic substances in such quantities or duration as to be harmful to the health and welfare of humans, animals and plants. Evaluation of such facilities as to adequacy of controls and/or procedures and emission potential will be made on an individual basis by the cabinet. [401 KAR 63:020, Section 3]

Compliance Demonstration Method:

Based upon the emission rates of toxics and hazardous air pollutants determined by the Cabinet using information provided in the application and supplemental information submitted by the source, the Cabinet determines the affected facility to be in compliance with 401 KAR 63:020.

3. Testing Requirements:

Testing shall be conducted at such times as may be requested by the Cabinet. [401 KAR 50:045, Section 1, and 401 KAR 59:005, Section 2(2)]

SECTION B - EMISSION POINTS, EMISSION UNITS, APPLICABLE REGULATIONS, AND OPERATING CONDITIONS (CONTINUED)

4. Specific Monitoring Requirements:

- a. Refer to **5. Specific Recordkeeping Requirements** for documentation of monitoring from the following devices:

Device	Emission Unit (Point)
C04 Rotoclone	03(P03), 05(P05)
C05 Rotoclone	03(P03), 04(P04)
C06 Dust Collector (vented indoors)	03(P03)

- b. The permittee shall perform a qualitative visual observation of the opacity of emissions at each stack no less than weekly while the affected facility is operating. If visible emissions from the stacks are observed (not including condensed water in the plume), the permittee shall determine the opacity using U.S. EPA Reference Method 9. In lieu of determining the opacity using U.S. EPA Reference Method 9, the permittee shall immediately perform a corrective action which results in no visible emissions (not including condensed water in the plume). [401 KAR 52:030, Section 10]

5. Specific Recordkeeping Requirements:

- a. A daily record of liquid flow rate in gpm of the above-mentioned rotoclones shall be kept, noting periods where no liquid flow rate readings were taken due to affected equipment not being in operation. [401 KAR 52:030, Section 10]
- b. All routine and non-routine maintenance activities performed on the control devices shall be recorded. [401 KAR 52:030, Section 10]
- c. A daily record of respective pressure drops shall be maintained for each control device listed in **4. Specific Monitoring Requirements** a. [401 KAR 52:030, Section 10]
- d. A log of the qualitative visual observations made as specified in **4. Specific Monitoring Requirements** including the date, time, initials of observer, whether any emissions were observed (yes/no), and any U.S. EPA Reference Method 9 readings taken. [401 KAR 52:030, Section 10]

6. Specific Reporting Requirements:

Refer to **Section F**.

SECTION B - EMISSION POINTS, EMISSION UNITS, APPLICABLE REGULATIONS, AND OPERATING CONDITIONS (CONTINUED)

06(P06) Cheese Food Process

Fifteen (15) Process Vessels for Cheese Food Production: Batch Process

Description:

Construction Date: November 2006
 Maximum operating rate: 5.117 tons material output/hr total; 44,826 tons material output /yr total
 Control Equipment: Packed Tower Wet Scrubber, for odor control only; exhaust through Stack S03

Specific Control Equipment:

Equipment ID	Description	Controls
P06 Cheese Food Process Givaudan Process-Stack S03	14 Process Vessels for Cheese Food Production	Scrubber for odor control

APPLICABLE REGULATIONS:

401 KAR 59:010, New process operations.

STATE-ORIGIN REQUIREMENTS:

401 KAR 63:020, Potentially hazardous matter or toxic substances.

1. Operating Limitations:

The permittee shall operate the scrubber at all times the Emission unit 06 (P06) is in operation.
 [401 KAR 52:030, Section 10]

2. Emission Limitations:

- a. Emissions of particulate matter from 06 (P06) shall not exceed the allowable rate limit as calculated by the following equations: [401 KAR 59:010, Section 3(2)]
 - (1) $E = 2.34$ lbs/hr for process rates up to 1,000 lbs/hr
 - (2) $E = 3.59 P^{0.62}$ for process rates greater than 1,000 lbs/hr up to 60,000 lbs/hr
 - (3) $E = 17.31P^{0.16}$ for process rates greater than 60,000 lb/hr

Where: E = rate of particulate emissions in lb(s)/hr, and
 P = process weight rate in tons/hr.

- b. No person shall cause, suffer, allow, or permit any continuous emission into the open air from a control device or stack associated with any affected facility which is equal to or greater than twenty (20) percent opacity. [401 KAR 59:010, Section 3(1)(a)]

Compliance Demonstration Method:

- a. For the particulate matter emission limit, compliance is demonstrated by the uncontrolled potential to emit, which is calculated to be 0.25 lb/hr.
- b. For compliance with the opacity limitations, refer to **4. Specific Monitoring Requirements.**

SECTION B - EMISSION POINTS, EMISSION UNITS, APPLICABLE REGULATIONS, AND OPERATING CONDITIONS (CONTINUED)

- c. Persons responsible for a source from which hazardous matter or toxic substances may be emitted shall provide the utmost care and consideration, in the handling of these materials, to the potentially harmful effects of the emissions resulting from such activities. No owner or operator shall allow any affected facility to emit potentially hazardous matter or toxic substances in such quantities or duration as to be harmful to the health and welfare of humans, animals and plants. Evaluation of such facilities as to adequacy of controls and/or procedures and emission potential will be made on an individual basis by the cabinet. [401 KAR 63:020, Section 3]

Compliance Demonstration Method:

- a. Based upon the emission rates of toxics and hazardous air pollutants determined by the Cabinet using information provided in the application and supplemental information submitted by the source, the Cabinet determines the affected facility to be in compliance with 401 KAR 63:020.
- b. See **1. Operating Limitations.**

3. Testing Requirements:

Testing shall be conducted at such times as may be requested by the Cabinet. [401 KAR 50:045, Section 1, and 401 KAR 59:005, Section 2(2)]

4. Specific Monitoring Requirements:

The permittee shall perform a qualitative visual observation of the opacity of emissions at each stack no less than weekly while the affected facility is operating. If visible emissions from the stacks are observed (not including condensed water in the plume), the permittee shall determine the opacity using U.S. EPA Reference Method 9. In lieu of determining the opacity using U.S. EPA Reference Method 9, the permittee shall immediately perform a corrective action which results in no visible emissions (not including condensed water in the plume). [401 KAR 52:030, Section 10]

5. Specific Recordkeeping Requirements:

A log of the qualitative visual observations made as specified in **4. Specific Monitoring Requirements** including the date, time, initials of observer, whether any emissions were observed (yes/no), and any U.S. EPA Reference Method 9 readings taken. [401 KAR 52:030, Section 10]

6. Specific Reporting Requirements:

Refer to **Section F.**

SECTION B - EMISSION POINTS, EMISSION UNITS, APPLICABLE REGULATIONS, AND OPERATING CONDITIONS (CONTINUED)

08(P08) Spray Dry Batching System Batching System: Batch Process

Description:

Construction Date: August 2008

Maximum operating rate: 1.35 tons material output/hr calculated as an average over 30 days of operation on a rolling basis

Control Equipment: Dust Collector to control PM₁₀; exhaust through Stack S04; wet material to biofilter (for odor control only) and exhaust through S09

Specific Control Equipment:

Equipment ID	Description	Controls
P08 Batching System		
Givaudan Process-Stack S04	Dry Material Feed System for Spray Dryer #1 consisting of Gravity Material Feed System and Weigh Hopper	Dust collector C08 to control PM ₁₀
Givaudan Process-Stack S09	Wet Material Batching System consisting of Scanima Mixer, Holding Tank & Drum Pumping Station	Biofilter for odor control only

APPLICABLE REGULATIONS:

401 KAR 59:010, New Process Operations.

1. Operating Limitations:

a. Refer to **Section D** and **Section E**.

b. In order to preclude the applicability of 401 KAR 52:020, Title V permits, all air pollution control equipment and all pollution control measures proposed by the application in response to which this permit is issued shall be in place, properly maintained, and in operation in accordance with the manufacturer's specifications and/or standard operating procedures at any time an affected facility for which the equipment and measures are designed is operated.

Compliance Demonstration Method:

Refer to **4. Specific Monitoring Requirements** a.

c. The permittee shall operate the biofilter at all times that the Wet Material Batching System is in operation. [401 KAR 52:030, Section 10]

2. Emission Limitations:

a. Emissions of particulate matter from 08 (P08) shall not exceed the allowable rate limit as calculated by the following equations: [401 KAR 59:010, Section 3(2)]

(1) $E = 2.34$ lbs/hr for process rates up to 1,000 lbs/hr

(2) $E = 3.59 P^{0.62}$ for process rates greater than 1,000 lbs/hr up to 60,000 lbs/hr

(3) $E = 17.31P^{0.16}$ for process rates greater than 60,000 lb/hr

Where: E = rate of particulate emissions in lb(s)/hr, and
 P = process weight rate in tons/hr.

SECTION B - EMISSION POINTS, EMISSION UNITS, APPLICABLE REGULATIONS, AND OPERATING CONDITIONS (CONTINUED)

- b. No person shall cause, suffer, allow, or permit any continuous emission into the open air from a control device or stack associated with any affected facility which is equal to or greater than twenty (20) percent opacity. [401 KAR 59:010, Section 3(1)(a)]

Compliance Demonstration Method:

- a. The source is assumed to be in compliance when the dust collector is operating and properly maintained. Refer to **4. Specific Monitoring Requirements**.
- b. For compliance with the opacity limitations, refer to **4. Specific Monitoring Requirements** and **5. Specific Recordkeeping Requirements**.

3. Testing Requirements:

Testing shall be conducted at such times as may be requested by the Cabinet. [401 KAR 50:045, Section 1, and 401 KAR 59:005, Section 2(2)]

4. Specific Monitoring Requirements:

The permittee shall perform a qualitative visual observation of the opacity of emissions at each stack no less than weekly while the affected facility is operating. If visible emissions from the stacks are observed (not including condensed water in the plume), the permittee shall determine the opacity using U.S. EPA Reference Method 9. In lieu of determining the opacity using U.S. EPA Reference Method 9, the permittee shall immediately perform a corrective action which results in no visible emissions (not including condensed water in the plume). [401 KAR 52:030, Section 10]

5. Specific Recordkeeping Requirements:

- a. All routine and non-routine maintenance activities performed on the dust collector shall be recorded. [401 KAR 52:030, Section 10]
- b. A daily record of the pressure drops shall be maintained for the control device. [401 KAR 52:030, Section 10]
- c. A log of the qualitative visual observations made as specified in **4. Specific Monitoring Requirements** including the date, time, initials of observer, whether any emissions were observed (yes/no), and any U.S. EPA Reference Method 9 readings taken. [401 KAR 52:030, Section 10]

6. Specific Reporting Requirements:

Refer to **Section F**.

SECTION B - EMISSION POINTS, EMISSION UNITS, APPLICABLE REGULATIONS, AND OPERATING CONDITIONS (CONTINUED)

010(P010) Three (3) Mixer/Blenders #4, #5 and #6 (All Floors): Batch Process

Description:

Construction Date: November 2009
 Maximum operating rate: 0.94 tons material output/hr
 Control Equipment: Rotoclone C12 to control PM₁₀; exhaust through Stack S06

012(P012) One Packaging Line #3A: Batch Process

Description:

Construction Date: November 2009
 Maximum operating rate: 4.5 tons material output/hr
 Control Equipment: Rotoclone C12 to control PM₁₀; exhaust through Stack S06

Specific Control Equipment:

Equipment ID	Description	Controls
P010 Mixer/Blenders - Stack S06	3 Mixer/Blenders (#4 of 2000 liter, #5 of 1000 liter and #6 of 500 liter)	Rotoclone C12 to control PM ₁₀
P012 Packaging Line #3A - Stack S06	1 Packaging Line #3A	Rotoclone C12 to control PM ₁₀

APPLICABLE REGULATIONS:

401 KAR 59:010, New process operations.

1. Operating Limitations:

- a. Refer to **Section D** and **Section E**.
- b. In order to preclude the applicability of 401 KAR 52:020, Title V permits, all air pollution control equipment and all pollution control measures proposed by the application in response to which this permit is issued shall be in place, properly maintained, and in operation in accordance with the manufacturer's specifications and/or standard operating procedures at any time an affected facility for which the equipment and measures are designed is operated.

Compliance Demonstration Method:

Refer to **4. Specific Monitoring Requirements** a.

2. Emission Limitations:

- a. Emissions of particulate matter from 010 (P010) and 012 (P012) shall not exceed the allowable rate limit as calculated by the following equations: [401 KAR 59:010, Section 3(2)]
 - (1) $E = 2.34 \text{ lbs/hr}$ for process rates up to 1,000 lbs/hr
 - (2) $E = 3.59 P^{0.62}$ for process rates greater than 1,000 lbs/hr up to 60,000 lbs/hr
 - (3) $E = 17.31P^{0.16}$ for process rates greater than 60,000 lb/hr

Where: E = rate of particulate emissions in lb(s)/hr, and
 P = process weight rate in tons/hr.

SECTION B - EMISSION POINTS, EMISSION UNITS, APPLICABLE REGULATIONS, AND OPERATING CONDITIONS (CONTINUED)

- b. No person shall cause, suffer, allow, or permit any continuous emission into the open air from a control device or stack associated with any affected facility which is equal to or greater than twenty (20) percent opacity. [401 KAR 59:010, Section 3(1)(a)]

Compliance Demonstration Method:

- a. The source is assumed to be in compliance when the Rotoclone C12 is operating and properly maintained. Refer to **4. Specific Monitoring Requirements**.
- b. For compliance with the opacity limitations, refer to **4. Specific Monitoring Requirements** and **5. Specific Recordkeeping Requirements**.

3. Testing Requirements:

Testing shall be conducted at such times as may be requested by the Cabinet. [401 KAR 50:045, Section 1, and 401 KAR 59:005, Section 2(2)]

4. Specific Monitoring Requirements:

- a. Refer to **5. Specific Recordkeeping Requirements** for documentation of monitoring from the Rotoclone C12.
- b. The permittee shall perform a qualitative visual observation of the opacity of emissions at each stack no less than weekly while the affected facility is operating. If visible emissions from the stacks are observed (not including condensed water in the plume), the permittee shall determine the opacity using U.S. EPA Reference Method 9. In lieu of determining the opacity using U.S. EPA Reference Method 9, the permittee shall immediately perform a corrective action which results in no visible emissions (not including condensed water in the plume). [401 KAR 52:030, Section 10]

5. Specific Recordkeeping Requirements:

- a. A daily record of liquid flow rate in gpm in the Rotoclone shall be kept, noting periods where no liquid flow rate readings were taken due to the Rotoclone not being in operation. [401 KAR 52:030, Section 10]
- b. All routine and non-routine maintenance activities performed on the Rotoclone shall be recorded. [401 KAR 52:030, Section 10]
- c. A daily record of the pressure drop shall be maintained for the Rotoclone listed in **4. Specific Monitoring Requirements** a. above. [401 KAR 52:030, Section 10]
- d. A log of the qualitative visual observations made as specified in **4. Specific Monitoring Requirements** including the date, time, initials of observer, whether any emissions were observed (yes/no), and any U.S. EPA Reference Method 9 readings taken. [401 KAR 52:030, Section 10]

6. Specific Reporting Requirements:

Refer to **Section F**.

SECTION B - EMISSION POINTS, EMISSION UNITS, APPLICABLE REGULATIONS, AND OPERATING CONDITIONS (CONTINUED)**10(P013) Emergency Generator****Description:**

Make/Model: Kohler Model 60 RZG;

Type: 105 HP; 4 cycle lean burn, natural gas fired; spark ignition;

Displacement: 5.7 L (total)

Manufacture date: December 2005

Date installed: September 2006

APPLICABLE REGULATIONS:

401 KAR 63:002 Section 2(4)(eeee), 40 C.F.R. 63.6580 through 63.6675, Tables 1a through 8, and Appendix A (Subpart ZZZZ), National Emission Standards for Hazardous Air Pollutants for Stationary Reciprocating Internal Combustion Engines

1. Operating Limitations:

A new or reconstructed stationary RICE located at an area source must meet the requirements of 40 CFR 63, Subpart ZZZZ by meeting the requirements of 40 CFR 60, Subpart JJJJ, for spark ignition engines. No further requirements apply for such engines under 40 CFR 63, Subpart ZZZZ. [40 CFR 63.6590(c)]

2. Emission Limitations:

None

3. Testing Requirements:

Testing shall be conducted at such times as may be requested by the Cabinet. [401 KAR 50:045, Section 1, and 401 KAR 59:005, Section 2(2)]

4. Specific Monitoring Requirements:

The permittee shall monitor hours of operation for the unit. [401 KAR 52:030, Section 10]

5. Specific Recordkeeping Requirements:

The permittee shall maintain records of hours of operation. [401 KAR 52:030, Section 10]

6. Specific Reporting Requirements:

Refer to **Section F**.

SECTION B - EMISSION POINTS, EMISSION UNITS, APPLICABLE REGULATIONS, AND OPERATING CONDITIONS (CONTINUED)

014(P014) Seventeen (Filtermat, Paste, & MID) Batch Reactors controlled by Biofilter for Odor & H₂S emissions

Description:

Filter Mat: Reactor 1, Reactor 2 and Reactor 3 (1000 gallons each)
 Paste Reactors: T9R (1500 gal); T11R (1500 gal); T8R (400 gal); T14R (50 gal); T13R (400 gal); T12R (500 gal); T7R (1500 gal); T6R (500 gal); and T21TOR (10 gal)
 MID Reactors: M7R (1000 gal); M8R (1000 gal); M6R (560 gal); M9R (100 gal); and M10TOR (10 gal)
 Paste Tanks: T1 (800 gal), T2 (800 gal), T3 (800 gal), T4 (800 gal), T5 (300 gal), T17 (30 gal), T18 (80 gal), T19 (200 gal), T20 (60 gal), T15 (200 gal), T10 (1000 gal), T16 (Liquefier, 300 gal)
 MID Tanks: M1 (200 gal), M2 (500 gal), M3 (800 gal), M4 (1000 gal), M5 (60 gal)
 Construction Date of biofilter: December 2012
 Maximum operating rate: 5.088 tons material output/hr
 Control Equipment: Biofilter S07, Rotoclones

Specific Control Equipment:

Equipment	Description	Controls
Seventeen (17) Batch Reactors	Paste, Filtermat, and MID	Biofilter, Rotoclones

APPLICABLE REGULATIONS:

401 KAR 53:010, Ambient air quality standards

401 KAR 59:010, New process operations.

1. Operating Limitations:

- a. The biofilter shall be operated at all times when H₂S emitting raw materials are used in the reactors or the batch reactors are manufacturing H₂S-emitting products. [401 KAR 52:030 Section 10]
- b. The biofilter shall be operated in accordance with the manufacturer's recommendations for H₂S control. [401 KAR 52:030 Section 10]
- c. The biofilter will be designed to remove H₂S emissions to a value not to exceed 0.1 ppm_v H₂S from the biofilter stack, as a 24-hour average. [401 KAR 52:030 Section 10]

Compliance Demonstration Method:

- a. The permittee shall maintain a copy of the manufacturer's recommendations for operation of the biofilter on site.
- b. The source is assumed to be in compliance with the manufacturer's recommendations for H₂S control with regards to H₂S inlet concentration based on the emission factor and process rate provided by the facility.

SECTION B - EMISSION POINTS, EMISSION UNITS, APPLICABLE REGULATIONS, AND OPERATING CONDITIONS (CONTINUED)**2. Emission Limitations:**

- a. Emissions of particulate matter from 014(P014) shall not exceed the allowable rate limit as calculated by the following equations: [401 KAR 59:010, Section 3(2)]
 - (1) $E = 2.34 \text{ lbs/hr}$ for process rates up to 1,000 lbs/hr
 - (2) $E = 3.59 P^{0.62}$ for process rates greater than 1,000 lbs/hr up to 60,000 lbs/hr
 - (3) $E = 17.31P^{0.16}$ for process rates greater than 60,000 lb/hrWhere: E = rate of particulate emissions in lb(s)/hr, and
P = process weight rate in tons/hr.
- b. No person shall cause, suffer, allow, or permit any continuous emission into the open air from a control device or stack associated with any affected facility which is equal to or greater than twenty (20) percent opacity. [401 KAR 59:010, Section 3(1)(a)]

Compliance Demonstration Method:

- a. The source is assumed to be in compliance based on the emission factor and process rate provided by the facility.
- b. For compliance with the opacity limitations, refer to **4. Specific Monitoring Requirements** and **5. Specific Recordkeeping Requirements**.
- c. The permittee shall ensure that the one hour average concentration of Hydrogen Sulfide does not exceed $14 \mu\text{g}/\text{m}^3$ (0.01 ppm) more than once per calendar year. [401 KAR 53:010, Section 4, Appendix A]

Compliance Demonstration Method:

See **1. Operating Limitations a. through c.**

3. Testing Requirements:

Testing shall be conducted at such times as may be requested by the Cabinet. [401 KAR 50:045, Section 1, and 401 KAR 59:005, Section 2(2)]

4. Specific Monitoring Requirements:

- a. Conduct a weekly visual inspection for moisture on the biofilter media. [401 KAR 52:030 Section 10]
- b. Conduct a test of the pH of the biofilter effluent once per month. [401 KAR 52:030 Section 10]
- c. The permittee shall perform a qualitative visual observation of the opacity of emissions at each stack no less than weekly while the affected facility is operating. If visible emissions from the stacks are observed (not including condensed water in the plume), the permittee shall determine the opacity using U.S. EPA Reference Method 9. In lieu of determining the opacity using U.S. EPA Reference Method 9, the permittee shall immediately perform a corrective action which results in no visible emissions (not including condensed water in the plume). [401 KAR 52:030 Section 10]

5. Specific Recordkeeping Requirements:

- a. A record of each weekly moisture inspection shall be maintained. [401 KAR 52:030 Section 10]

SECTION B - EMISSION POINTS, EMISSION UNITS, APPLICABLE REGULATIONS, AND OPERATING CONDITIONS (CONTINUED)

- b. A record of each monthly pH test shall be maintained. [401 KAR 52:030 Section 10]
- c. The permittee shall keep the vendor guaranteed performance test results and specifications on file at the site to show the proper operation of the biofilter to reduce H₂S emissions from the reactor, when H₂S emitting raw materials are used in the reactors or the batch reactors are manufacturing H₂S-emitting products. [401 KAR 52:030 Section 10]
- d. A log of the qualitative visual observations made as specified in **4. Specific Monitoring Requirements** including the date, time, initials of observer, whether any emissions were observed (yes/no), and any U.S. EPA Reference Method 9 readings taken. [401 KAR 52:030 Section 10]

6. Specific Reporting Requirements:
Refer to **Section F**.

SECTION B - EMISSION POINTS, EMISSION UNITS, APPLICABLE REGULATIONS, AND OPERATING CONDITIONS (CONTINUED)**002(P002) Four (4) Boilers:****Description:**

Construction Date:	Boilers 1, 2, & 3: 2001 Boiler 4: 2006
Maximum operating rate:	Boiler 1, 2, & 3: 8.4mmBtu/hr (each) Boiler 4: 4.2 mmBtu/hr
Control Equipment:	None
Fuel:	Natural Gas

APPLICABLE REGULATIONS:

401 KAR 59:015, New Indirect Heat Exchangers

STATE ORIGIN REQUIREMENTS:

401 KAR 63:020, Potentially Hazardous Matter or Toxic Substances.

1. Operating Limitations:

During a startup period or shutdown period, the permittee shall comply with the work practice standards established in 401 KAR 59:015, Section 7. [401 KAR 59:015, Section 7]

- a. The permittee shall comply with 401 KAR 50:055, Section 2(5). [401 KAR 59:015, Section 7(1)(a)]
- b. The frequency and duration of startup periods or shutdown periods shall be minimized by the affected facility. [401 KAR 59:015, Section 7(1)(b)]
- c. All reasonable steps shall be taken by the permittee to minimize the impact of emissions on ambient air quality from the affected facility during startup periods and shutdown periods; [401 KAR 59:015, Section 7(1)(c)]
- d. The actions, including duration of the startup period, of the permittee during startup and shutdown periods, shall be documented in signed, contemporaneous logs or other relevant evidence; [401 KAR 59:015, Section 7(1)(d)]
- e. Startups and shutdowns shall be conducted according to either [401 KAR 59:015, Section 7(1)(e)]
 - (1) The manufacturer's recommended procedures; or [401 KAR 59:015, Section 7(1)(e)1.]
 - (2) Recommended procedures for a unit of similar design, for which manufacturer's recommended procedures are available, as approved by the cabinet based on documentation provided by the permittee. [401 KAR 59:015, Section 7(1)(e)2.]

Compliance Demonstration Method:

See **5. Specific Recordkeeping Requirements b.**

SECTION B - EMISSION POINTS, EMISSION UNITS, APPLICABLE REGULATIONS, AND OPERATING CONDITIONS (CONTINUED)

2. Emission Limitations:

- a. The emissions of particulate matter from emission point 002(P002) are limited to the following: [401 KAR 59:015, Section 4(1)]
 - (1) 0.45 lb/mmBtu for boilers 1, 2, & 3.
 - (2) 0.41 lb/mmBtu for boiler 4.
- b. The emissions of sulfur dioxide from emission point 002(P002) are limited to the following: [401 KAR 59:015, Section 5(1)]
 - (1) 2.05 lb/mmBtu for boilers 1, 2, & 3.
 - (2) 1.76 lb/mmBtu for boiler 4.
- c. The permittee shall not cause emissions of particulate matter in excess of 20 percent opacity, except: [401 KAR 59:015, Section 4(2)]
 - (1) A maximum of 40 percent opacity shall be allowed for a maximum of 6 consecutive minutes in any 60 minutes during fire box cleaning or soot blowing; and [401 KAR 59:015, Section 4(2)(b)]
 - (2) For emissions from an affected facility caused by building a new fire, emissions during the period required to bring the boiler up to operating conditions shall be allowed, if the method used is recommended by the manufacturer and the time does not exceed the manufacturer's recommendations. [401 KAR 59:015, Section 4(2)(c)]

Compliance Demonstration Method:

Compliance with the 401 KAR 59:015 emission standards is assumed. [401 KAR 50:045, Section 4(3)(c)1.]

- d. Persons responsible for a source from which hazardous matter or toxic substances may be emitted shall provide the utmost care and consideration, in the handling of these materials, to the potentially harmful effects of the emissions resulting from such activities. No owner or operator shall allow any affected facility to emit potentially hazardous matter or toxic substances in such quantities or duration as to be harmful to the health and welfare of humans, animals and plants. Evaluation of such facilities as to adequacy of controls and/or procedures and emission potential will be made on an individual basis by the cabinet. [401 KAR 63:020, Section 3]

Compliance Demonstration Method:

Based upon the emission rates of toxics and hazardous air pollutants determined by the Cabinet using information provided in the application and supplemental information submitted by the source, the Cabinet determines the affected facility to be in compliance with 401 KAR 63:020.

3. Testing Requirements:

Testing shall be conducted at such times as may be requested by the Cabinet. [401 KAR 50:045, Section 1, and 401 KAR 59:005, Section 2(2)]

4. Specific Monitoring Requirements:

The permittee shall monitor the amount of natural gas combusted, in MMscf, on a monthly basis. [401 KAR 52:030, Section 10]

SECTION B - EMISSION POINTS, EMISSION UNITS, APPLICABLE REGULATIONS, AND OPERATING CONDITIONS (CONTINUED)

5. Specific Recordkeeping Requirements:

- a. The permittee shall maintain records of the amount of natural gas combusted, in MMscf, on a monthly basis. [401 KAR 52:030, Section 10]
- b. The permittee shall keep records of the manufacturer's recommended procedures for startup and shutdown, any instance in which the recommended procedures were not followed, and any corrective action taken. [401 KAR 52:030, Section 10]

6. Specific Reporting Requirements:

See **Section F**.

SECTION C – INSIGNIFICANT ACTIVITIES

The following listed activities have been determined to be insignificant activities for this source pursuant to 401 KAR 52:030, Section 6. Although these activities are designated as insignificant the permittee must comply with the applicable regulation. Process and emission control equipment at each insignificant activity subject to an opacity standard shall be inspected monthly and a qualitative visible emissions evaluation made. Results of the inspection, evaluation, and any corrective action shall be recorded in a log.

<u>Description</u>	<u>Generally Applicable Regulation</u>
1. Quick Water Heater (Direct Fired, 2.95 MMBtu/hr)	401 KAR 63:020
2. Mixers/Blender A	401 KAR 59:010
3. Wastewater Pretreatment Plant and EQ Tanks	401 KAR 53:010 – Appendix A
4. Silicon Dioxide/TCP Addition (for No. 1 SD)	401 KAR 59:010
5. Multiverter	401 KAR 59:010
6. 4,000 Cubic Foot Salt Unloading Silo with Vent Filter	401 KAR 59:010
7. 4,000 Cubic Foot Salt Unloading Silo with Vent Filter	401 KAR 59:010
8. Cheese Department Laboratory Hoods (2)	401 KAR 59:010
9. Quality Control Laboratory Hoods (2)	401 KAR 59:010
10. Powder Pre-Station #1 with Integral Rotoclone	401 KAR 59:010
11. Powder Pre-Station #2 with Integral Rotoclone	401 KAR 59:010
12. Powder Pre-Station #3 with Integral Rotoclone	401 KAR 59:010
13. Powder Pre-Station #4 with Integral Rotoclone	401 KAR 59:010
14. Super Sack Powder Unloading Station (3 rd Floor)	401 KAR 59:010
15. Liquid Pre-Kitting Station	401 KAR 53:010 – Appendix A
16. Griller 1	None
17. Griller 2	None

SECTION D – SOURCE EMISSION LIMITATIONS AND TESTING REQUIREMENTS

1. As required by Section 1b of the *Cabinet Provisions and Procedures for Issuing Federally-Enforceable Permits for Non-Major Sources* incorporated by reference in 401 KAR 52:030, Section 26; compliance with annual emissions and processing limitations contained in this permit, shall be based on emissions and processing rates for any twelve (12) consecutive months.
2. Particulate matter emissions, measured by applicable reference methods, or an equivalent or alternative method specified in 40 C.F.R. Chapter I, or by a test method specified in the state implementation plan shall not exceed the respective limitations specified herein.
3. To preclude the applicability of 401 KAR 52:020, *Title V permits* emissions, the total annual source-wide particulate matter (PM₁₀) emissions (from all units in Section B and C of the permit) shall not exceed 90 tons per year based on a twelve (12) month rolling total.
4. To preclude the applicability of 401 KAR 51:017, *Prevention of significant deterioration* for particulate matter emissions, the total annual source-wide PM (from all units in Section B and C of the permit) shall not exceed 225 tons per year based on a twelve (12) month rolling total.

Compliance Demonstration:

Compliance shall be demonstrated by keeping records of monthly and 12-month rolling totals of source-wide particulate matter (PM/PM₁₀) emissions from all units in Section B and C of the permit.

SECTION E - SOURCE CONTROL EQUIPMENT REQUIREMENTS

Pursuant to 401 KAR 50:055, Section 2(5), at all times, including periods of startup, shutdown and malfunction, owners and operators shall, to the extent practicable, maintain and operate any affected facility including associated air pollution control equipment in a manner consistent with good air pollution control practice for minimizing emissions. Determination of whether acceptable operating and maintenance procedures are being used will be based on information available to the Division which may include, but is not limited to, monitoring results, opacity observations, review of operating and maintenance procedures, and inspection of the source.

SECTION F - MONITORING, RECORDKEEPING, AND REPORTING REQUIREMENTS

1. Pursuant to Section 1b-IV-1 of the *Cabinet Provisions and Procedures for Issuing Federally-Enforceable Permits for Non-Major Sources* incorporated by reference in 401 KAR 52:030 Section 26, when continuing compliance is demonstrated by periodic testing or instrumental monitoring, the permittee shall compile records of required monitoring information that include:
 - a. Date, place (as defined in this permit), and time of sampling or measurements;
 - b. Analyses performance dates;
 - c. Company or entity that performed analyses;
 - d. Analytical techniques or methods used;
 - e. Analyses results; and
 - f. Operating conditions during time of sampling or measurement.
2. Records of all required monitoring data and support information, including calibrations, maintenance records, and original strip chart recordings, and copies of all reports required by the Division for Air Quality, shall be retained by the permittee for a period of five (5) years and shall be made available for inspection upon request by any duly authorized representative of the Division for Air Quality [401 KAR 52:030, Section 3(1)(f)1a, and Section 1a-7 of the *Cabinet Provisions and Procedures for Issuing Federally-Enforceable Permits for Non-Major Sources* incorporated by reference in 401 KAR 52:030, Section 26].
3. In accordance with the requirements of 401 KAR 52:030, Section 3(1)f, the permittee shall allow authorized representatives of the Cabinet to perform the following during reasonable times:
 - a. Enter upon the premises to inspect any facility, equipment (including air pollution control equipment), practice, or operation;
 - b. To access and copy any records required by the permit;
 - c. Sample or monitor, at reasonable times, substances or parameters to assure compliance with the permit or any applicable requirements.Reasonable times are defined as during all hours of operation, during normal office hours; or during an emergency.
4. No person shall obstruct, hamper, or interfere with any Cabinet employee or authorized representative while in the process of carrying out official duties. Refusal of entry or access may constitute grounds for permit revocation and assessment of civil penalties.
5. Summary reports of any monitoring required by this permit shall be submitted to the Regional Office listed on the front of this permit at least every six (6) months during the life of this permit, unless otherwise stated in this permit. For emission units that were still under construction or which had not commenced operation at the end of the 6-month period covered by the report and are subject to monitoring requirements in this permit, the report shall indicate that no monitoring was performed during the previous six months because the emission unit was not in operation [Sections 1b-V-1 of the *Cabinet Provisions and Procedures for Issuing Federally-Enforceable Permits for Non-Major Sources* incorporated by reference in 401 KAR 52:030, Section 26].

SECTION F - MONITORING, RECORDKEEPING, AND REPORTING REQUIREMENTS (CONTINUED)

6. The semi-annual reports are due by January 30th and July 30th of each year. All reports shall be certified by a responsible official pursuant to 401 KAR 52:030, Section 22. If continuous emission and opacity monitors are required by regulation or this permit, data shall be reported in accordance with the requirements of 401 KAR 59:005, General Provisions, Section 3(3). All deviations from permit requirements shall be clearly identified in the reports.
7. In accordance with the provisions of 401 KAR 50:055, Section 1, the owner or operator shall notify the Regional Office listed on the front of this permit concerning startups, shutdowns, or malfunctions as follows:
 - a. When emissions during any planned shutdowns and ensuing startups will exceed the standards, notification shall be made no later than three (3) days before the planned shutdown, or immediately following the decision to shut down, if the shutdown is due to events which could not have been foreseen three (3) days before the shutdown.
 - b. When emissions due to malfunctions, unplanned shutdowns and ensuing startups are or may be in excess of the standards, notification shall be made as promptly as possible by telephone (or other electronic media) and shall be submitted in writing upon request.
8. The permittee shall promptly report deviations from permit requirements, including those attributable to upset conditions as defined in the permit, the probable cause of such deviations, and any corrective actions or preventive measures taken shall be submitted to the Regional Office listed on the front of this permit. Where the underlying applicable requirement contains a definition of prompt or otherwise specifies a time frame for reporting deviations, that definition or time frame shall govern. Where the underlying applicable requirement does not identify a specific time frame for reporting deviations, prompt reporting, as required by Sections 1b-V, 3 and 4 of the *Cabinet Provisions and Procedures for Issuing Federally-Enforceable Permits for Non-Major Sources* incorporated by reference in 401 KAR 52:030, Section 26 shall be defined as follows:
 - a. For emissions of a hazardous air pollutant or a toxic air pollutant (as identified in an applicable regulation) that continue for more than an hour in excess of permit requirements, the report must be made within 24 hours of the occurrence.
 - b. For emissions of any regulated air pollutant, excluding those listed in F.8.a., that continue for more than two hours in excess of permit requirements, the report must be made within 48 hours.
 - c. All deviations from permit requirements, including those previously reported, shall be included in the semiannual report required by F.6.
9. Pursuant to 401 KAR 52:030, Section 21, the permittee shall annually certify compliance with the terms and conditions contained in this permit by completing and returning a Compliance Certification Form (DEP 7007CC) (or an alternative approved by the regional office) to the Regional Office listed on the front of this permit in accordance with the following requirements:
 - a. Identification of each term or condition;
 - b. Compliance status of each term or condition of the permit;
 - c. Whether compliance was continuous or intermittent;
 - d. The method used for determining the compliance status for the source, currently and over the reporting period.
 - e. For an emissions unit that was still under construction or which has not commenced operation

SECTION F - MONITORING, RECORDKEEPING, AND REPORTING REQUIREMENTS (CONTINUED)

- at the end of the 12-month period covered by the annual compliance certification, the permittee shall indicate that the unit is under construction and that compliance with any applicable requirements will be demonstrated within the timeframes specified in the permit.
- f. The certification shall be submitted by January 30th of each year. Annual compliance certifications shall be sent to the Division for Air Quality, Florence Regional Office, 8020 Veterans Memorial Drive, Suite 110, Florence, KY 41042.
10. In accordance with 401KAR 52:030, Section 3(1)(d), the permittee shall provide the Division with all information necessary to determine its subject emissions within 30 days of the date the Kentucky Emissions Inventory System (KYEIS) emissions survey is mailed to the permittee. If a KYEIS emissions survey is not mailed to the permittee, then the permittee shall comply with all other emissions reporting requirements in this permit.
11. The Cabinet may authorize the temporary use of an emission unit to replace a similar unit that is taken off-line for maintenance, if the following conditions are met:
- a. The owner or operator shall submit to the Cabinet, at least ten (10) days in advance of replacing a unit, the appropriate Forms DEP7007AI to DD that show:
 - (1) The size and location of both the original and replacement units; and
 - (2) Any resulting change in emissions;
 - b. The potential to emit (PTE) of the replacement unit shall not exceed that of the original unit by more than twenty-five (25) percent of a major source threshold, and the emissions from the unit shall not cause the source to exceed the emissions allowable under the permit;
 - c. The PTE of the replacement unit or the resulting PTE of the source shall not subject the source to a new applicable requirement;
 - d. The replacement unit shall comply with all applicable requirements; and
 - e. The source shall notify the Regional office of all shutdowns and start-ups.
 - f. Within six (6) months after installing the replacement unit, the owner or operator shall:
 - (1) Re-install the original unit and remove or dismantle the replacement unit; or
 - (2) Submit an application to permit the replacement unit as a permanent change.

SECTION G - GENERAL PROVISIONS

1. General Compliance Requirements

- a. The permittee shall comply with all conditions of this permit. A noncompliance shall be a violation of 401 KAR 52:030, Section 3(1)(b), and a violation of Federal Statute 42 USC 7401 through 7671q (the Clean Air Act). Noncompliance with this permit is grounds for enforcement action including but not limited to the termination, revocation and reissuance, revision, or denial of a permit [Section 1a-2 of the *Cabinet Provisions and Procedures for Issuing Federally-Enforceable Permits for Non-Major Sources* incorporated by reference in 401 KAR 52:030, Section 26].
- b. The filing of a request by the permittee for any permit revision, revocation, reissuance, or termination, or of a notification of a planned change or anticipated noncompliance, shall not stay any permit condition [Section 1a-5 of the *Cabinet Provisions and Procedures for Issuing Federally-Enforceable Permits for Non-Major Sources* incorporated by reference in 401 KAR 52:030, Section 26].
- c. This permit may be revised, revoked, reopened and reissued, or terminated for cause in accordance with 401 KAR 52:030, Section 18. The permit will be reopened for cause and revised accordingly under the following circumstances:
 - (1) If additional applicable requirements become applicable to the source and the remaining permit term is three (3) years or longer. In this case, the reopening shall be completed no later than eighteen (18) months after promulgation of the applicable requirement. A reopening shall not be required if compliance with the applicable requirement is not required until after the date on which the permit is due to expire, unless this permit or any of its terms and conditions have been extended pursuant to 401 KAR 52:030, Section 12;
 - (2) The Cabinet or the United States Environmental Protection Agency (U. S. EPA) determines that the permit must be revised or revoked to assure compliance with the applicable requirements;
 - (3) The Cabinet or the U. S. EPA determines that the permit contains a material mistake or that inaccurate statements were made in establishing the emissions standards or other terms or conditions of the permit.

Proceedings to reopen and reissue a permit shall follow the same procedures as apply to initial permit issuance and shall affect only those parts of the permit for which cause to reopen exists. Reopenings shall be made as expeditiously as practicable. Reopenings shall not be initiated before a notice of intent to reopen is provided to the source by the Division, at least thirty (30) days in advance of the date the permit is to be reopened, except that the Division may provide a shorter time period in the case of an emergency.
- d. The permittee shall furnish information upon request of the Cabinet to determine if cause exists for modifying, revoking and reissuing, or terminating the permit; or to determine compliance with the conditions of this permit [Sections 1a- 6 and 7 of the *Cabinet Provisions and Procedures for Issuing Federally-Enforceable Permits for Non-Major Sources* incorporated by reference in 401 KAR 52:030, Section 26].
- e. Emission units described in this permit shall demonstrate compliance with applicable requirements if requested by the Division [401 KAR 52:030, Section 3(1)(c)].

- f. 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 to the permitting authority [401 KAR 52:030, Section 7(1)].
- g. Any condition or portion of this permit which becomes suspended or is ruled invalid as a result of any legal or other action shall not invalidate any other portion or condition of this permit [Section 1a-11 of the *Cabinet Provisions and Procedures for Issuing Federally-Enforceable Permits for Non-Major Sources* incorporated by reference in 401 KAR 52:030, Section 26].
- h. The permittee shall not use as a defense in an enforcement action the contention that it would have been necessary to halt or reduce the permitted activity in order to maintain compliance [Section 1a-3 of the *Cabinet Provisions and Procedures for Issuing Federally-Enforceable Permits for Non-Major Sources* incorporated by reference in 401 KAR 52:030, Section 26].
- i. All emission limitations and standards contained in this permit shall be enforceable as a practical matter. All emission limitations and standards contained in this permit are enforceable by the U.S. EPA and citizens except for those specifically identified in this permit as state-origin requirements. [Section 1a-12 of the *Cabinet Provisions and Procedures for Issuing Federally-Enforceable Permits for Non-Major Sources* incorporated by reference in 401 KAR 52:030, Section 26].
- j. This permit shall be subject to suspension if the permittee fails to pay all emissions fees within 90 days after the date of notice as specified in 401 KAR 50:038, Section 3(6) [Section 1a-9 of the *Cabinet Provisions and Procedures for Issuing Federally-Enforceable Permits for Non-Major Sources* incorporated by reference in 401 KAR 52:030, Section 26].
- k. Nothing in this permit shall alter or affect the liability of the permittee for any violation of applicable requirements prior to or at the time of permit issuance [401 KAR 52:030, Section 11(3)].
- l. This permit does not convey property rights or exclusive privileges [Section 1a-8 of the *Cabinet Provisions and Procedures for Issuing Federally-Enforceable Permits for Non-Major Sources* incorporated by reference in 401 KAR 52:030, Section 26].
- m. Issuance of this permit does not relieve the permittee from the responsibility of obtaining any other permits, licenses, or approvals required by the Cabinet or any other federal, state, or local agency.
- n. Nothing in this permit shall alter or affect the authority of U.S. EPA to obtain information pursuant to Federal Statute 42 USC 7414, Inspections, monitoring, and entry.
- o. Nothing in this permit shall alter or affect the authority of U.S. EPA to impose emergency orders pursuant to Federal Statute 42 USC 7603, Emergency orders.

- p. This permit consolidates the authority of any previously issued PSD, NSR, or Synthetic Minor source preconstruction permit terms and conditions for various emission units and incorporates all requirements of those existing permits into one single permit for this source.
- q. Pursuant to 401 KAR 52:030, Section 11, a permit shield shall not protect the owner or operator from enforcement actions for violating an applicable requirement prior to or at the time of permit issuance. Compliance with the conditions of this permit shall be considered compliance with:
 - (1) Applicable requirements that are included and specifically identified in this permit; and
 - (2) Non-applicable requirements expressly identified in this permit.

2. Permit Expiration and Reapplication Requirements

- a. This permit shall remain in effect for a fixed term of five (5) years following the original date of issue. Permit expiration shall terminate the source's right to operate unless a timely and complete renewal application has been submitted to the Division at least six (6) months prior to the expiration date of the permit. Upon a timely and complete submittal, the authorization to operate within the terms and conditions of this permit, including any permit shield, shall remain in effect beyond the expiration date, until the renewal permit is issued or denied by the Division [401 KAR 52:030, Section 12].
- b. The authority to operate granted through this permit shall cease to apply if the source fails to submit additional information requested by the Division after the completeness determination has been made on any application, by whatever deadline the Division sets [401 KAR 52:030, Section 8(2)].

3. Permit Revisions

- a. Minor permit revision procedures specified in 401 KAR 52:030, Section 14(3), may be used for permit revisions involving the use of economic incentive, marketable permit, emission trading, and other similar approaches, to the extent that these minor permit revision procedures are explicitly provided for in the State Implementation Plan (SIP) or in applicable requirements and meet the relevant requirements of 401 KAR 52:030, Section 14(2).
- b. This permit is not transferable by the permittee. Future owners and operators shall obtain a new permit from the Division for Air Quality. The new permit may be processed as an administrative amendment if no other change in this permit is necessary, and provided that a written agreement containing a specific date for transfer of permit responsibility coverage and liability between the current and new permittee has been submitted to the permitting authority within ten (10) days following the transfer.

4. Construction, Start-Up, and Initial Compliance Demonstration Requirements

No construction authorized by permit F-24-028.

5. Testing Requirements

- a. Pursuant to 401 KAR 50:045, Section 2, a source required to conduct a performance test shall submit a completed Compliance Test Protocol form, DEP form 6028, or a test protocol a source has developed for submission to other regulatory agencies, in a format approved by the cabinet, to the Division's Frankfort Central Office a minimum of sixty (60) days prior to the scheduled test date. Pursuant to 401 KAR 50:045, Section 7, the Division shall be notified of the actual test date at least Thirty (30) days prior to the test.
- b. Pursuant to 401 KAR 50:045, Section 5, in order to demonstrate that a source is capable of complying with a standard at all times, any required performance test shall be conducted under normal conditions that are representative of the source's operations and create the highest rate of emissions. If [When] the maximum production rate represents a source's highest emissions rate and a performance test is conducted at less than the maximum production rate, a source shall be limited to a production rate of no greater than 110 percent of the average production rate during the performance tests. If and when the facility is capable of operation at the rate specified in the application, the source may retest to demonstrate compliance at the new production rate. The Division for Air Quality may waive these requirements on a case-by-case basis if the source demonstrates to the Division's satisfaction that the source is in compliance with all applicable requirements.
- c. Results of performance test(s) required by the permit shall be submitted to the Division by the source or its representative within forty-five days or sooner if required by an applicable standard, after the completion of the fieldwork.

6. Acid Rain Program Requirements

If an applicable requirement of Federal Statute 42 USC 7401 through 7671q (the Clean Air Act) is more stringent than an applicable requirement promulgated pursuant to Federal Statute 42 USC 7651 through 7651o (Title IV of the Act), both provisions shall apply, and both shall be state and federally enforceable.

7. Emergency Provisions

- a. Pursuant to 401 KAR 52:030, Section 23(1), an emergency shall constitute an affirmative defense to an action brought for noncompliance with the technology-based emission limitations if the permittee demonstrates through properly signed contemporaneous operating logs or other relevant evidence that:
 - (1) An emergency occurred and the permittee can identify the cause of the emergency;
 - (2) The permitted facility was at the time being properly operated;
 - (3) During an emergency, the permittee took all reasonable steps to minimize levels of emissions that exceeded the emissions standards or other requirements in the permit; and,
 - (4) The permittee notified the Division as promptly as possible and submitted written notice of the emergency to the Division within two (2) working days of the time when emission limitations were exceeded due to an emergency. The notice shall include a

description of the emergency, steps taken to mitigate emissions, and the corrective actions taken.

(5) Notification of the Division does not relieve the source of any other local, state or federal notification requirements.

- b. Emergency conditions listed in General Provision G.7.a above are in addition to any emergency or upset provision(s) contained in an applicable requirement [401 KAR 52:030, Section 23(3)].
- c. In an enforcement proceeding, the permittee seeking to establish the occurrence of an emergency shall have the burden of proof [401 KAR 52:030, Section 23(2)].

8. Ozone depleting substances

- a. The permittee shall comply with the standards for recycling and emissions reduction pursuant to 40 CFR 82, Subpart F, except as provided for Motor Vehicle Air Conditioners (MVACs) in Subpart B:
 - (1) Persons opening appliances for maintenance, service, repair, or disposal shall comply with the required practices contained in 40 CFR 82.156.
 - (2) Equipment used during the maintenance, service, repair, or disposal of appliances shall comply with the standards for recycling and recovery equipment contained in 40 CFR 82.158.
 - (3) Persons performing maintenance, service, repair, or disposal of appliances shall be certified by an approved technician certification program pursuant to 40 CFR 82.161.
 - (4) Persons disposing of small appliances, MVACs, and MVAC-like appliances (as defined at 40 CFR 82.152) shall comply with the recordkeeping requirements pursuant to 40 CFR 82.166.
 - (5) Persons owning commercial or industrial process refrigeration equipment shall comply with the leak repair requirements pursuant to 40 CFR 82.156.
 - (6) Owners/operators of appliances normally containing 50 or more pounds of refrigerant shall keep records of refrigerant purchased and added to such appliances pursuant to 40 CFR 82.166.
- b. If the permittee performs service on motor (fleet) vehicle air conditioners containing ozone-depleting substances, the source shall comply with all applicable requirements as specified in 40 CFR 82, Subpart B, *Servicing of Motor Vehicle Air Conditioners*.

9. Risk Management Provisions

- a. The permittee shall comply with all applicable requirements of 401 KAR Chapter 68, Chemical Accident Prevention, which incorporates by reference 40 CFR Part 68, Risk Management Plan provisions. If required, the permittee shall comply with the Risk Management Program and submit a Risk Management Plan to U.S. EPA using the RMP* eSubmit software.
- b. If requested, submit additional relevant information to the Division or the U.S. EPA.

SECTION H - ALTERNATE OPERATING SCENARIOS

None

SECTION I - COMPLIANCE SCHEDULE

None