

ADEQ

OPERATING

AIR PERMIT

Pursuant to the Regulations of the Arkansas Operating Air Permit Program, Regulation No. 26:

Permit No. : 597-AOP-R9

IS ISSUED TO:

Georgia-Pacific LLC – Crossett Paper Operations

Crossett, AR 71635

Ashley County

AFIN: 02-00013

THIS PERMIT AUTHORIZES THE ABOVE REFERENCED PERMITTEE TO
INSTALL, OPERATE, AND MAINTAIN THE EQUIPMENT AND EMISSION UNITS
DESCRIBED IN THE PERMIT APPLICATION AND ON THE FOLLOWING PAGES.

THIS PERMIT IS VALID BETWEEN:

November 12, 2003 AND November 11, 2008

IS SUBJECT TO ALL LIMITS AND CONDITIONS CONTAINED HEREIN.

Signed:

Mike Bates
Chief, Air Division

Date Modified

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Table 1 - List of Acronyms

A.C.A.	Arkansas Code Annotated
CFR	Code of Federal Regulations
CO	Carbon Monoxide
CSN	County Serial Number
HAP	Hazardous Air Pollutant
lb/hr	Pound per hour
MVAC	Motor Vehicle Air Conditioner
No.	Number
NO _x	Nitrogen Oxide
PM	Particulate matter
PM ₁₀	Particulate matter smaller than ten microns
SNAP	Significant New Alternatives Program (SNAP)
SO ₂	Sulfur dioxide
SSM	Startup, Shutdown, and Malfunction Plan
Tpy	Ton per year
UTM	Universal Transverse Mercator
VOC	Volatile Organic Compound

Section I: FACILITY INFORMATION

PERMITTEE: Georgia-Pacific LLC - Crossett Paper Operations
AFIN: 02-00013
PERMIT NUMBER: 597-AOP-R9

FACILITY ADDRESS: 100 Paper Mill Road
Crossett, AR 71635

MAILING ADDRESS Same as Above

COUNTY: Ashley

CONTACT POSITION: Ms. Karen Dickinson
TELEPHONE NUMBER: (870) 567-8305

REVIEWING ENGINEER: Paula Parker

UTM North - South (Y): Zone 15 3667.5
UTM East - West (X): Zone 15 595.8

Section II: INTRODUCTION

The Georgia-Pacific LLC - Paper Operations facility operates a kraft paper mill at 100 Paper Mill Road, Crossett, Arkansas 71635. This facility produces a variety of paper products on eight paper machines and two paper extruding machines. The paper machines include two fine paper machines, one board paper machine, and five tissue machines.

Summary of Proposed Modification

This revision is to incorporate the provisions of the Health-Based Compliance Alternatives for Manganese for Total Selected Metals (TSM). This provision is contained within Appendix A to 40 CFR 63, Subpart DDDDD—*National Emission Standards for Hazardous Air Pollutants for Industrial, Commercial, and Institutional Boilers and Process Heaters*.

Process Description

Chips are received at the Mill by truck and rail. Upon unloading, the chips are pneumatically blown to the distribution tower and are then dropped onto the chip piles. Round logs are also received at the facility. After storage, the logs are transported to the debarking drums for bark removal. The debarked logs are fed to the chipper and the produced chips are then conveyed to the chip piles. The chips from the chip piles are screened prior to entering the chip silos. Rejected chips from the screening are burned in the Mill's combination boiler. The removed bark is pneumatically sent to bark piles for storage and eventual use in the Mill's boilers.

The chips from the silos are conveyed to the Mill's thirteen batch digesters. The function of the digesters is to cook the chips using white liquor, black liquor, and the steam from the boilers. In the digestion process, these products are combined and cooked at a set pressure and temperature until the quality pulp is obtained. At the end of each "cook", the blow valves at the bottom of the digesters are opened, with the resulting pressure forcing the pulp mass through a blow line into one of the two blow tanks.

The blow tanks are at atmospheric pressure and the contents of the digesters enter the blow tanks tangentially at the top. When the chips hit the lower pressure in the tank, the liquor and water flash, blowing the chips apart to produce the pulp fibers. The vapors from the blow tanks are sent to the blow heat condensing system, where non-condensable gases (NCGs) are removed. The steam vapors are condensed in the accumulator. The accumulator water is sent to the stripper and returned to the washers as cleaned condensate. Knots (e.g. undercooked wood chips, irregularly shaped or overly thick pieces of wood, etc.) are removed with the use of vibrating knotters/screens.

The pulp is washed to remove spent cooking chemicals. The Mill has two horizontal washers. In the washers, the wash water and pulp move in counter current directions. The washed pulp is passed through screening and cleaning stages which remove debris from the stock. After screening, the pulp passes through the decker system, which thickens the pulp for storage in high density storage chests.

The unbleached Kraft pulp is taken from the high density storage chests for further processing in the bleach plant. The bleaching process removes the remaining lignin and Kraft color from the unbleached pulp. Bleaching is performed in several stages using chlorine dioxide, caustic soda, oxygen, and hydrogen peroxide.

Recovery describes the set of operations that recovers the spent cooking chemicals for reuse in the digesters. The recovery process utilizes a multi-effect evaporator to concentrate weak black liquor. The concentrated black liquor is burned in the Mill's recovery furnace. The spent chemicals leave the recovery furnace from the bottom in a molten form and enter the smelt dissolving tanks. The causticizing operation reacts molten inorganic salts from the smelt dissolving tanks with weak wash water to form green liquor. This green liquor is then treated with slaked lime to form white liquor. The white liquor is then ready for use as the main cooking liquor in the digesters.

The facility, in order to accommodate production levels, may export black liquor to another mill with excess recovery capacity in exchange for white or green liquor. The 'liquor-swapping' is considered routine and normal for the industry, and equipment needed for the exchange has been present since the facility has been built.

Paper products are currently manufactured on eight paper machines and two paper extruding machines. The paper machines include two fine paper machines, one board paper machine, and five tissue machines. Each machine has its own stock preparation, head box, wire section, press section, dryer sections, coater section, calendar stacks, reel, and drum winder. The two fine paper machines produce a variety of products including but not limited to bond, envelope, tablet, and copier paper.

Tissue and towel converting includes the operations involved with converting large parent rolls of tissue/towel from the machines into finished product. This includes rewinding onto smaller sized rolls, folding, printing, cutting, packaging, and shipping.

The two extruding machines receive board from the board paper machine and from outside board customers and apply a polymer coating. Rolls of board are loaded onto an unwind stand before passing through a calendar stack, where they are subjected to burners which flame seal the board. An extruded poly sheet is then pressed together with the board.

Regulations

The following table contains the regulations applicable to this permit.

Table 2 – Regulations

Source (SN)	Regulation
All Sources	Arkansas Air Pollution Code (Regulation 18) effective February 15, 1999

Comment: Page: 6
This section must contain any NSPS requirements and all sources that apply.

Source (SN)	Regulation
All Sources	Regulations of the Arkansas Plan of Implementation for Air Pollution Control (Regulation 19) effective May 28, 2006
All Sources	Regulations of Arkansas Air Permit Operating Program (Regulation 26) effective September 26, 2002
SN-03	NSPS Subpart D
SN-25	NSPS Subpart BB NESHAP Subpart MM
SN-26	NSPS Subpart BB NESHAP Subpart MM
SN-27A & 27B	NSPS Subpart BB NESHAP Subpart MM
SN-30	NESHAP Part S
SN-33 and SN-34	NSPS Subpart BB
SN-40	NSPS Subpart Kb
SN-59	NSPS Subpart BB
SN-03, SN-18, SN-19, and SN-22	NESHAP Subpart DDDDD. Section 63.7545 and Table 10 requires Initial Notification (submitted) and compliance with Subpart DDDDD before September 13, 2007

Georgia-Pacific LLC -Crossett Paper Operations is classified as a major stationary source under the regulations of 40 CFR Part 52.21, *Prevention of Significant Deterioration of Air Quality (PSD)*. Georgia-Pacific is potentially subject to 40 CFR Part 61 *National Emissions Standards for Hazardous Air Pollutants (NESHAP) Subpart M--National Emission Standard for Asbestos*, depending on future asbestos removal and demolition activities.

The following table is a summary of emissions from the facility. The following table contains cross-references to the pages containing specific conditions and emissions for each source. This table, in itself, is not an enforceable condition of the permit.

Table 3 – Emission Summary

Source No.	Description	Pollutant	Emission Rates		Cross Reference Page
			lb/hr	tpy	
Total Allowance Emissions		PM	437.8	1,844.8	N/A
		PM ₁₀	405.3	1,708.5	
		SO ₂	2,084.7	4,246.4	
		VOC	1,131.9	4,606.7	
		CO	3,488.4	15,271.9	
		NO _x	1,345.4	5,846.4	
		TRS	40.9	170.6	
		Pb	6.4	23.5	

Source No.	Description	Pollutant	Emission Rates		Cross Reference Page
			lb/hr	tpy	
03	10A Boiler	PM	103.0	451.2	36
		PM ₁₀	103.0	451.2	
		SO ₂	21.0	92.0	
		VOC	151.0	661.4	
		CO	600.0	2,628.0	
		NO _x	500.5	2,192.2	
		Pb	2.6	11.1	
		Acetone	0.3	1.0	
		Acetaldehyde	0.84	3.64	
		Acrolein	4.01	17.54	
		Arsenic	0.03	0.12	
		Benzene	4.21	18.42	
		Beryllium	0.01	0.01	
		Cadmium	0.02	0.06	
		Carbon Tetrachloride	0.05	0.20	
		Chlorine	0.80	3.47	
		Chloroform	0.03	0.13	
		Chromium, Hex	0.01	0.02	
		Chromium, Total	0.04	0.15	
		Cobalt	0.01	0.03	
		Formaldehyde	4.41	19.30	
		Hexane	1.77	7.74	
		Hydrogen Chloride	24.31	106.45	
		Manganese	0.94	4.12	
		Mercury	0.01	0.03	
		Naphthalene	0.10	0.43	
		Nickel	0.04	0.15	
		Pentachlorophenol	0.01	0.01	
		Phenol	0.06	0.23	
		Selenium	0.03	0.13	
		Styrene	1.91	8.31	
		2,3,7,8-tetrachlorodibenzo-p-dioxin	8.61E-09	3.77E-08	
		Tetrachloroethylene	0.04	0.17	
		Toluene	0.93	4.04	
		Vinyl Chloride	0.02	0.08	

Source No.	Description	Pollutant	Emission Rates		Cross Reference Page
			lb/hr	tpy	
18	5A Boiler	PM	2.1	8.8	47
		PM ₁₀	2.1	8.8	
		SO ₂	0.2	0.9	
		VOC	0.4	1.6	
		CO	14.0	61.0	
		NO _x	74.0	323.8	
		Pb	0.1	0.1	
		Arsenic	0.01	0.01	
		Benzene	0.01	0.01	
		Beryllium	0.01	0.01	
		Cadmium	0.01	0.01	
		Chromium, Total	0.01	0.01	
		Cobalt	0.01	0.01	
		Formaldehyde	0.02	0.08	
		n-Hexane	0.39	1.71	
		Mercury	0.01	0.01	
		Naphthalene	0.01	0.01	
19	6A Boiler	Nickel	0.01	0.01	49
		Toluene	0.01	0.01	
		PM	36.8	117.5	
		PM ₁₀	36.8	117.5	
		SO ₂	431.1	1,888.3	
		VOC	2.4	10.2	
		CO	35.3	154.7	
		NO _x	117.6	515.1	
		Pb	0.1	0.3	
		Sulfuric Acid	15.4	45.0	
		Acrolein	0.01	0.01	
		Arsenic	0.01	0.01	
		Benzene	0.01	0.01	
		Beryllium	0.01	0.01	
		Cadmium	0.01	0.01	
		Chromium, Total	0.01	0.01	
		Chromium, Hex	0.01	0.01	
		Cobalt	0.02	0.05	
		Formaldehyde	0.06	0.27	
		n-Hexane	0.63	2.76	
		Manganese	0.02	0.09	
		Mercury	0.01	0.01	

Source No.	Description	Pollutant	Emission Rates		Cross Reference Page
			lb/hr	tpy	
		Naphthalene	0.01	0.01	
		Nickel	0.16	0.67	
		Phosphorus	0.02	0.08	
		Selenium	0.01	0.01	
		Toluene	0.02	0.05	
22	9A Boiler	PM	90.0	394.2	
		PM ₁₀	90.0	394.2	
		SO ₂	613.3	1,679.6	
		VOC	49.7	217.7	
		CO	518.4	2,270.6	
		NO _x	345.0	1,511.1	
		Pb	2.6	11.2	
		TRS	2.6	1.2	
		Sulfuric Acid	27.0	74.0	
		Acetone	0.2	0.8	
		Acetaldehyde	0.60	2.62	
		Acrolein	2.88	12.62	
		Arsenic	0.02	0.09	
		Benzene	3.03	13.25	
		Beryllium	0.01	0.01	
		Cadmium	0.02	0.06	
		Carbon Tetrachloride	0.04	0.15	53
		Chlorine	0.59	2.50	
		Chloroform	0.03	0.09	
		Chromium, Hex	0.01	0.02	
		Chromium, Total	0.03	0.13	
		Cobalt	0.02	0.07	
		Formaldehyde	3.17	13.88	
		Hexane	0.79	3.45	
		Hydrogen Chloride	18.97	83.06	
		Manganese			
		Mercury	0.01	0.04	
		Naphthalene	0.07	0.31	
		Nickel	0.17	0.74	
		Pentachlorophenol	0.01	0.01	
		Phenol	0.04	0.17	
		Selenium	0.03	0.09	
		Styrene	1.37	6.00	
		2,3,7,8-			

Source No.	Description	Pollutant	Emission Rates		Cross Reference Page
			lb/hr	tpy	
		tetrachlorodibenzo-p-dioxin	6.19E-09	2.71E-08	
		Tetrachloroethylene	0.03	0.12	
		Toluene	0.67	2.91	
		Vinyl Chloride	0.02	0.06	
25	No. 4 Lime Kiln	PM	28.3	124.0	86
		PM ₁₀	28.3	124.0	
		SO ₂	14.3	54.1	
		VOC	7.2	27.2	
		CO	11.0	41.9	
		NO _x	66.3	252.1	
		Pb	0.1	0.1	
		TRS	2.2	9.6	
		Sulfuric Acid	0.7	2.5	
		Acetone	0.1	0.1	
		Acetaldehyde	0.17	0.64	
		Acrolein	0.01	0.01	
		Arsenic	0.01	0.01	
		Benzene	0.01	0.04	
		Beryllium	0.01	0.01	
		Cadmium	0.01	0.01	
		Chloroform	0.01	0.01	
		Chromium, Hex	0.01	0.01	
		Chromium, Total	0.01	0.03	
		Cobalt	0.01	0.01	
		Formaldehyde	0.17	0.64	
		Hexane	0.01	0.01	
		Hydrogen Chloride	0.01	0.03	
		Manganese	0.01	0.04	
		Methanol	0.37	1.39	
		Mercury	0.01	0.01	
		Methylene Chloride	0.01	0.01	
		Naphthalene	0.40	1.50	
		Nickel	0.01	0.02	
		Phenol	0.01	0.03	
		Selenium	0.01	0.01	
		Styrene	0.01	0.01	
		Tetrachloroethylene	0.01	0.03	
		Toluene	0.01	0.01	

Source No.	Description	Pollutant	Emission Rates		Cross Reference Page
			lb/hr	tpy	
26	8R Recovery Furnace	PM	93.0	407.3	74
		PM ₁₀	93.0	407.3	
		SO ₂	989.1	464.4	
		VOC	16.1	60.9	
		CO	2,272.4	9,953.0	
		NO _x	190.0	832.2	
		TRS	12.4	54.2	
		Pb	0.1	0.1	
		Sulfuric Acid	7.0	26.4	
		Acetone	0.5	1.8	
		Acetaldehyde	0.09	0.32	
		Arsenic	0.01	0.01	
		Benzene	0.11	0.40	
		Beryllium	0.01	0.01	
		Cadmium	0.01	0.01	
		Chloroform	0.01	0.03	
		Chromium, Hex	0.01	0.02	
		Chromium, Total	0.01	0.01	
		Formaldehyde	1.30	4.90	
		Hexane	0.07	0.24	
		Hydrogen Chloride	9.90	37.70	
		Manganese	0.01	0.04	
		Methanol	8.30	31.40	
		Mercury	0.01	0.02	
		Methylene Chloride	0.13	0.50	
		Nickel	0.01	0.03	
		PAH	0.07	0.24	
		Selenium	0.01	0.01	
		Styrene	0.10	0.36	
		Tetrachloroethylene	0.10	0.36	
		Toluene	0.05	0.19	
		1,2,4-Trichlorobenzene	0.19	0.70	

Source No.	Description	Pollutant	Emission Rates		Cross Reference Page
			lb/hr	tpy	
27A	Smelt Dissolving Tank (East)	PM	11.0	41.9	81
		PM ₁₀	11.0	41.9	
		SO ₂	3.0	13.2	
		VOC	1.5	5.3	
		NO _X	5.4	20.4	
		TRS	2.4	8.8	
		Pb	0.1	0.1	
		Acetone	0.1	0.1	
		Acetaldehyde	0.05	0.18	
		Acrolein	0.01	0.01	
		Arsenic	0.01	0.01	
		Benzene	0.01	0.01	
		Beryllium	0.01	0.01	
		Chloroform	0.01	0.01	
		Chromium , Hex	0.01	0.01	
		Chromium, total	0.01	0.01	
		Formaldehyde	0.43	1.64	
		n-Hexane	0.01	0.01	
		Manganese	0.01	0.02	
		Mercury	0.01	0.01	
		Methanol	0.85	3.15	
		Methylene Chloride	0.01	0.01	
		Naphthalene	0.05	0.16	
		Selenium	0.01	0.01	
		Styrene	0.01	0.02	
		Tetrachloroethylene	0.01	0.01	
		Toluene	0.01	0.01	
		1,2,4-Trichlorobenzene	0.01	0.05	
27B	Smelt Dissolving Tank (West)	PM	11.0	41.9	81
		PM ₁₀	11.0	41.9	
		SO ₂	3.0	13.2	
		VOC	1.5	5.3	
		NO _X	5.4	20.4	
		TRS	2.4	8.8	
		Pb	0.1	0.1	
		Acetone	0.1	0.1	
		Acetaldehyde	0.05	0.18	
		Acrolein	0.01	0.01	
		Arsenic	0.01	0.01	

Source No.	Description	Pollutant	Emission Rates		Cross Reference Page
			lb/hr	tpy	
		Benzene	0.01	0.01	
		Beryllium	0.01	0.01	
		Chloroform	0.01	0.01	
		Chromium , Hex	0.01	0.01	
		Chromium, total	0.01	0.01	
		Formaldehyde	0.43	1.64	
		n-Hexane	0.01	0.01	
		Manganese	0.01	0.02	
		Mercury	0.01	0.01	
		Methanol	0.85	3.15	
		Methylene Chloride	0.01	0.01	
		Naphthalene	0.05	0.16	
		Selenium	0.01	0.01	
		Styrene	0.01	0.02	
		Tetrachloroethylene	0.01	0.01	
		Toluene	0.01	0.01	
		1,2,4-Trichlorobenzene	0.01	0.05	
30	Bleach Plant	VOC	20.9	79.1	
		CO	136.1	596.1	
		Acetone	0.4	1.3	
		Acetaldehyde	0.10	0.37	
		Acrolein	0.01	0.01	
		Benzene	0.01	0.01	
		Carbon tetrachloride	0.01	0.01	
		Chlorine	2.53	9.63	
		Chloroform	6.82	26.00	
		Formaldehyde	0.03	0.11	
		Hexane	0.01	0.01	69
		Hexachlorocyclopentadiene	0.18	0.67	
		Hexachloroethane	0.24	0.88	
		Hydrogen chloride	2.53	9.63	
		o-Cresol	0.07	0.24	
		Methanol	13.20	50.20	
		Methylene Chloride	0.06	0.25	
		Phenol	0.04	0.12	
		Propionaldehyde	0.06	0.22	
		Styrene	0.03	0.10	
		Tetrachloroethylene	0.02	0.04	

Source No.	Description	Pollutant	Emission Rates		Cross Reference Page
			lb/hr	tpy	
		Toluene Trichloroethylene 1,2,4-Trichlorobenzene	0.01 0.01 0.01	0.01 0.02 0.03	
33	Line 1 Washer	VOC TRS Acetophenone Acrolein o-Cresol Methanol Phenol	10.4 2.9 0.08 0.01 0.24 3.24 0.26	45.6 12.6 0.35 0.01 1.04 14.20 1.13	66
34	Line 2 Washer	VOC TRS Acetone Acetaldehyde Acrolein Benzene Carbon Tetrachloride Chloroform 1,2 Dichloroethylene Formaldehyde n-Hexane Methanol Styrene Toluene Trichloroethylene 1,2,4-Trichlorobenzene	8.7 8.8 0.5 0.22 0.01 0.01 0.01 0.01 0.01 0.01 0.02 8.25 0.02 0.02 0.01 0.05	32.8 38.2 2.4 0.84 0.02 0.01 0.03 0.01 0.02 0.02 0.05 31.40 0.07 0.07 0.01 0.18	66
35F	Aeration Stabilization Basin	VOC Chloroform Methanol Naphthalene	16.5 1.53 0.08 0.01	70.8 6.69 0.36 0.05	122
40	Methanol Storage Tank	VOC Methanol	37.5 37.50	1.2 1.20	123

Source No.	Description	Pollutant	Emission Rates		Cross Reference Page
			lb/hr	tpy	
46	Tissue Machine No. 4 Burners	PM	0.2	0.8	100
		PM ₁₀	0.2	0.8	
		SO ₂	0.1	0.1	
		VOC	1.2	5.0	
		CO	4.3	18.8	
		NO _x	2.4	10.6	
		Pb	0.1	0.1	
		Arsenic	0.01	0.01	
		Benzene	0.01	0.01	
		Cadmium	0.01	0.01	
		Chromium, total	0.01	0.01	
		Cobalt	0.01	0.01	
		Formaldehyde	0.01	0.01	
		Hexane	0.05	0.19	
		Manganese	0.01	0.01	
		Mercury	0.01	0.01	
47	Tissue Machine No. 5 Burners	Naphthalene	0.01	0.01	103
		Nickel	0.01	0.01	
		Toluene	0.01	0.01	
		PM	0.4	1.5	
		PM ₁₀	0.4	1.5	
		SO ₂	0.1	0.1	
		VOC	1.2	5.2	
		CO	4.5	19.7	
		NO _x	2.0	8.4	
		Pb	0.1	0.1	
		Arsenic	0.01	0.01	
		Benzene	0.01	0.01	
		Cadmium	0.01	0.01	
		Chromium, total	0.01	0.01	
		Cobalt	0.01	0.01	
		Formaldehyde	0.01	0.01	
		Hexane	0.05	0.20	
		Manganese	0.01	0.01	
		Mercury	0.01	0.01	
		Naphthalene	0.01	0.01	
		Nickel	0.01	0.01	
		Toluene	0.01	0.01	

Source No.	Description	Pollutant	Emission Rates		Cross Reference Page
			lb/hr	tpy	
48	Tissue Machine No. 6 Burners	PM	1.0	4.2	107
		PM ₁₀	1.0	4.2	
		SO ₂	0.1	0.2	
		VOC	1.2	4.9	
		CO	6.7	29.1	
		NO _x	5.4	23.4	
		Pb	0.1	0.1	
		Arsenic	0.01	0.01	
		Benzene	0.01	0.01	
		Cadmium	0.01	0.01	
		Chromium, total	0.01	0.01	
		Cobalt	0.01	0.01	
		Formaldehyde	0.01	0.01	
		Hexane	0.05	0.20	
		Manganese	0.01	0.01	
		Mercury	0.01	0.01	
		Naphthalene	0.01	0.01	
49	Tissue Machine No. 7 Burners	Nickel	0.01	0.01	111
		Toluene	0.01	0.01	
		PM	0.4	1.8	
		PM ₁₀	0.4	1.8	
		SO ₂	0.1	0.1	
		VOC	2.4	10.1	
		CO	8.8	38.5	
		NO _x	2.3	9.7	
		Pb	0.1	0.1	
		Arsenic	0.01	0.01	
		Benzene	0.01	0.01	
		Cadmium	0.01	0.01	
		Chromium, total	0.01	0.01	
		Cobalt	0.01	0.01	
		Formaldehyde	0.01	0.02	
		Hexane	0.09	0.39	
		Manganese	0.01	0.01	
		Mercury	0.01	0.01	
		Naphthalene	0.01	0.01	
		Nickel	0.01	0.01	
		Toluene	0.01	0.01	

Source No.	Description	Pollutant	Emission Rates		Cross Reference Page
			lb/hr	tpy	
50	Tissue Machine No. 7 Dust System	PM PM ₁₀	0.5 0.5	2.1 2.1	111
51	Tissue Machine No. 6 Rewinder	PM PM ₁₀	0.5 0.5	1.9 1.9	107
52	Tissue Machine No. 6 Dust System	PM PM ₁₀	0.5 0.5	1.9 1.9	107
54	Tissue Machine No. 5 Dust System	PM PM ₁₀	0.3 0.3	1.1 1.1	103
55F	Slaker Vent #1	PM PM ₁₀ VOC TRS Acetone Acetaldehyde Benzene Methanol Styrene Toluene	0.5 0.5 1.7 0.7 0.1 0.81 0.01 0.81 0.02 0.01	1.8 1.8 6.3 2.6 0.4 3.10 0.01 3.10 0.07 0.02	92
56F	Slaker Vent #2	PM PM ₁₀ VOC TRS Acetone Acetaldehyde Benzene Methanol Styrene Toluene	0.5 0.5 1.7 0.7 0.1 0.81 0.01 0.81 0.02 0.01	1.8 1.8 6.3 2.6 0.4 3.10 0.01 3.10 0.07 0.02	92
57F	Woodyard Debarking Drum and Associated Woodyard Chip Handling System	PM PM ₁₀ VOC	1.2 0.6 640.2	5.3 2.6 2,803.7	61

Source No.	Description	Pollutant	Emission Rates		Cross Reference Page
			lb/hr	tpy	
58F	Woodyard Chip Storage Piles & Chippers	PM	2.1	9.0	
		PM ₁₀	1.1	4.5	
		VOC	2.1	8.8	
59	Batch Digesters (13)	VOC	55.9	244.7	
		TRS	4.3	18.9	
		Acetone	0.1	0.2	
		Acetaldehyde	0.03	0.08	
		Acrolein	0.01	0.01	
		Benzene	0.01	0.01	
		Carbon Tetrachloride	0.01	0.01	
		Chloroform	0.03	0.10	
		1,2 Dichloroethylene	0.01	0.01	
		Formaldehyde	0.01	0.01	
		Hexane	0.01	0.01	
		Methanol	0.57	2.16	
		Methylene Chloride	0.01	0.01	
		Styrene	0.01	0.02	
		Tetrachloroethylene	0.01	0.01	
		Toluene	0.01	0.01	
		Trichloroethylene	0.01	0.01	
		1,2,4-Trichlorobenzene	0.01	0.01	
60	Line 1 Decker	Emissions are routed to the Incinerator (SN-83)			
61	Line 2 Decker	VOC	7.0	26.3	
		TRS	1.4	6.0	
		Acetone	0.8	4.0	
		Acetaldehyde	0.13	0.46	
		Acrolein	0.01	0.04	
		Benzene	0.01	0.01	
		Carbon Tetrachloride	0.04	0.13	
		1,2 Dichloroethylene	0.01	0.01	
		Formaldehyde	0.01	0.04	
		o-Cresol	0.57	2.13	
		Methanol	5.61	21.30	
		Propionaldehyde	0.18	0.67	
		Styrene	0.03	0.10	
		Tetrachloroethylene	0.05	0.18	
		Toluene	0.01	0.03	
		Trichloroethylene	0.10	0.36	

Source No.	Description	Pollutant	Emission Rates		Cross Reference Page
			lb/hr	tpy	
		1,2,4-Trichlorobenzene	0.16	0.59	
62	Fine Paper Machine No. 1	VOC	2.1	8.9	93
		Acetone	0.8	3.3	
		Acetaldehyde	1.00	4.38	
		Acrolein	0.04	0.17	
		1,2 Dichloroethylene	0.10	0.40	
		Methanol	0.86	3.75	
		Tetrachloroethylene	0.05	0.22	
		1,2,4-Trichlorobenzene	0.04	0.15	
63	Fine Paper Machine No. 2	VOC	2.3	10.0	93
		Acetone	0.9	3.9	
		Acetaldehyde	1.10	4.82	
		Acrolein	0.05	0.19	
		1,2 Dichloroethylene	0.10	0.44	
		Methanol	0.94	4.12	
		Tetrachloroethylene	0.06	0.25	
		1,2,4-Trichlorobenzene	0.04	0.17	
64	Board Paper Machine No. 3	VOC	3.6	15.5	97
		Acetone	1.3	5.6	
		Acetaldehyde	1.70	7.45	
		Acrolein	0.07	0.29	
		1,2 Dichloroethylene	0.16	0.68	
		Methanol	1.46	6.37	
		Tetrachloroethylene	0.09	0.38	
		1,2,4-Trichlorobenzene	0.06	0.25	
65	Board Paper Machine No. 3 Burners	PM	0.2	0.5	97
		PM ₁₀	0.2	0.5	
		SO ₂	0.1	0.1	
		VOC	0.1	0.4	
		CO	1.3	5.4	
		NO _x	1.5	6.5	
		Pb	0.1	0.1	
		Arsenic	0.01	0.01	
		Benzene	0.01	0.01	
		Cadmium	0.01	0.01	
		Chromium, total	0.01	0.01	
		Cobalt	0.01	0.01	

Source No.	Description	Pollutant	Emission Rates		Cross Reference Page
			lb/hr	tpy	
		Formaldehyde	0.01	0.02	
		Hexane	0.03	0.12	
		Manganese	0.01	0.01	
		Mercury	0.01	0.01	
		Naphthalene	0.01	0.01	
		Nickel	0.01	0.01	
		Toluene	0.01	0.01	
66	Tissue Machine No. 4	VOC	0.9	3.6	
		TRS	0.1	0.2	
		Acetone	0.3	1.2	
		Acetaldehyde	0.35	1.52	
		Acrolein	0.02	0.06	
		1,2 Dichloroethylene	0.04	0.14	
		Formaldehyde	0.05	0.21	
		Methanol	0.35	1.53	
		Methylene Chloride	0.03	0.12	
		Tetrachloroethylene	0.02	0.08	
		1,2,4-Trichlorobenzene	0.02	0.06	
67	Tissue Machine No. 4 Dust System	PM	0.3	1.1	
		PM ₁₀	0.3	1.1	100
68	Tissue Machine No. 5	VOC	0.5	2.0	
		TRS	0.1	0.2	
		Acetone	0.2	0.7	
		Acetaldehyde	0.20	0.85	
		Acrolein	0.01	0.04	
		1,2 Dichloroethylene	0.02	0.08	
		Formaldehyde	0.03	0.12	
		Methanol	0.20	0.86	
		Methylene Chloride	0.02	0.08	
		Tetrachloroethylene	0.01	0.05	
		1,2,4-Trichlorobenzene	0.01	0.03	
69	Tissue Machine No. 6	VOC	1.3	5.5	
		TRS	0.1	0.3	
		Acetone	0.5	1.9	
		Acetaldehyde	0.54	2.37	
		Acrolein	0.03	0.09	

Source No.	Description	Pollutant	Emission Rates		Cross Reference Page
			lb/hr	tpy	
		1,2 Dichloroethylene	0.05	0.22	
		Formaldehyde	0.08	0.32	
		Methanol	0.55	2.39	
		Methylene Chloride	0.05	0.19	
		Tetrachloroethylene	0.03	0.12	
		1,2,4-Trichlorobenzene	0.02	0.08	
70	Tissue Machine No. 7	VOC	1.2	5.1	
		TRS	0.1	0.3	
		Acetone	0.4	1.8	
		Acetaldehyde	0.50	2.19	
		Acrolein	0.02	0.09	
		1,2 Dichloroethylene	0.05	0.20	111
		Formaldehyde	0.07	0.30	
		Methanol	0.51	2.21	
		Methylene Chloride	0.04	0.17	
		Tetrachloroethylene	0.03	0.11	
		1,2,4-Trichlorobenzene	0.02	0.08	
71	No. 8 Extruder Electrostatic Treaters (A&B)	PM	0.4	1.4	120
		PM ₁₀	0.4	1.4	
		Ozone	1.8	7.9	
72	No. 9 Extruder Electrostatic Treater	PM	0.6	2.5	120
		PM ₁₀	0.6	2.5	
		Ozone	1.5	6.3	
75	Pulp Storage Chests	VOC	9.3	40.7	123
		Methanol	2.16	9.47	
76F	Black Liquor Storage Basin No. 1	VOC	28.1	122.8	123
		Acetaldehyde	1.31	5.72	
		Acetone	2.3	9.9	
		Methanol	16.07	70.38	
78F	Road Emissions	PM	44.8	195.8	123
		PM ₁₀	15.3	67.1	
79	Tissue Machine No. 8 Burners	PM	0.9	3.6	115
		PM ₁₀	0.9	3.6	
		SO ₂	0.1	0.2	
		VOC	1.0	4.2	

Source No.	Description	Pollutant	Emission Rates		Cross Reference Page
			lb/hr	tpy	
		CO	5.7	24.9	
		NO _x	4.6	20.0	
		Pb	0.1	0.1	
		Arsenic	0.01	0.01	
		Benzene	0.01	0.01	
		Cadmium	0.01	0.01	
		Chromium, total	0.01	0.01	
		Cobalt	0.01	0.01	
		Formaldehyde	0.01	0.02	
		Hexane	0.11	0.47	
		Manganese	0.01	0.01	
		Mercury	0.01	0.01	
		Naphthalene	0.01	0.01	
		Nickel	0.01	0.01	
		Toluene	0.01	0.01	
80	Tissue Machine No. 8	VOC	0.5	1.8	
		TRS	0.1	0.3	
		Acetone	0.4	1.5	
		Acetaldehyde	0.43	1.86	
		Acrolein	0.02	0.08	
		1,2 Dichloroethylene	0.04	0.17	
		Formaldehyde	0.06	0.25	
		Methanol	0.43	1.88	
		Methylene Chloride	0.04	0.15	
		Tetrachloroethylene	0.03	0.10	
		1,2,4-Trichlorobenzene	0.02	0.07	
81	Tissue Machine No. 8 Dust System	PM	1.7	7.2	
		PM ₁₀	1.7	7.2	
82F	Landfill Operations	PM	2.7	0.5	
		PM ₁₀	1.3	0.3	
		VOC	4.3	18.7	
83	Incinerator	PM	2.7	11.8	
		PM ₁₀	2.7	11.8	
		SO ₂	9.1	39.9	
		VOC	0.8	3.5	
		CO	6.0	26.3	

Source No.	Description	Pollutant	Emission Rates		Cross Reference Page
			lb/hr	tpy	
		NO _x TRS Methanol	23.0 0.9 0.80	100.7 3.8 3.50	
84 through 92	Sources Removed – Never Installed				
93	Repulper C (All VOCs are Chloroform)	VOC Chloroform	0.6 0.60	2.3 2.3	126
94	Green Liquor Clarifier	VOC Acetone Acetaldehyde Benzene Chloroform Hexane Methanol Tetrachloroethylene	2.0 0.1 0.01 0.01 0.01 0.01 0.04 0.01	7.6 0.1 0.01 0.01 0.01 0.01 0.13 0.01	92
95	White Liquor Clarifier	VOC Acetone Benzene Formaldehyde Methanol Styrene	0.6 0.1 0.01 0.07 0.45 0.01	2.1 0.1 0.01 0.26 1.73 0.01	92
96	Salt Cake Mix Tank	VOC TRS Acetone Acetaldehyde Acrolein Benzene Formaldehyde Methanol Styrene Tetrachloroethylene Toluene 1,2,4-trichlorobenzene	0.7 0.7 0.1 0.03 0.01 0.01 0.01 0.52 0.01 0.01 0.01	2.2 2.5 0.2 0.11 0.01 0.01 0.01 1.95 0.01 0.01 0.01	74
97	Storage Tanks	VOC	33.0	6.8	123

Source No.	Description	Pollutant	Emission Rates		Cross Reference Page
			lb/hr	tpy	
		Methanol	1.5	6.0	
98	"A" Side Causticizers	VOC	0.1	0.2	92
		TRS	0.4	1.2	
		Acetone	0.1	0.1	
		Acetaldehyde	0.02	0.06	
		Benzene	0.01	0.01	
		Methanol	0.01	0.04	
		Styrene	0.01	0.01	
99	"B" Side Causticizers	VOC	0.1	0.2	92
		TRS	0.4	1.2	
		Acetone	0.1	0.1	
		Acetaldehyde	0.02	0.06	
		Benzene	0.01	0.01	
		Methanol	0.01	0.04	
		Styrene	0.01	0.01	
100	White Liquor Storage Tanks (4 total)	VOC	0.6	2.2	92
		Acetone	0.1	0.1	
		Benzene	0.01	0.01	
		Formaldehyde	0.07	0.26	
		Methanol	0.50	1.80	
		Styrene	0.01	0.10	
101	10A Boiler Bark Transfer System	PM	0.1	0.3	61
		PM ₁₀	0.1	0.1	
102	9A Boiler Bark Transfer System	PM	0.1	0.1	61
		PM ₁₀	0.1	0.1	

*HAPs included in the VOC totals. Other HAPs are not included in any other totals unless specifically stated.

**Air Contaminants such as ammonia, acetone, and certain halogenated solvents are not VOCs or HAPs.

Section III: PERMIT HISTORY

The first paper machine at Georgia-Pacific Crossett Paper Operations was constructed in 1937.

On March 27, 1970, Georgia-Pacific was issued its first permit, Permit #16-A. On August 30, 1971 Georgia-Pacific was issued its second permit, Permit #68-A.

Permit #133-A, issued on December 15, 1972, allowed the installation of an extrusion and a laminating machine.

Permit #137-A was also issued on December 15, 1972. It permitted the installation of a fume scrubber on the digester feed system to control emissions from the digester and the installation of a cyclone and baghouse to control emissions from the sanding operations.

Permit #144-A, issued on March 28, 1973, allowed the installation of the 9A power boiler.

Permit #149-A was also issued on March 28, 1973. It permitted the installation of an odor control system to collect, hold and distribute gases which are normally vented from the pulp mill digesters. The gases are burned in the lime kiln.

Permit #140-A was issued on July 23, 1976. This permit dealt with equipment maintenance problems such as the repair of boilers and the replacement of control devices. This permit allowed Georgia-Pacific to operate an additional boiler to provide steam while the existing boilers are taken out of service for repairs.

Permit #411-A, issued to Georgia-Pacific on May 27, 1977, permitted the installation of a venturi scrubber for the control of lime dust emissions from the lime slaker and lime handling system at the mill.

Permit #597-A, issued to Georgia-Pacific on March 6, 1980, permitted the installation of new equipment in the pulping and power utility areas. In the pulping area the 8R Recovery Furnace, the No. 4 Lime Kiln, a set of evaporators, new digesters and new washers were installed. In the power utility area two wood fire boilers each equipped with a multiclone and a venturi scrubber were installed.

Permit #597-AR-1 was issued on July 23, 1982. It was modified by Permit #597-AR-2, issued on November 1, 1984. Permit #597-AR-2 superseded all previously issued air permits. Permit #597-AR-2 allowed Georgia-Pacific to convert a recovery furnace to a power boiler, the 10A Boiler. This was a major modification of a major stationary source and therefore was subject to PSD review. Only NO_x and CO became subject to the PSD requirements because of reductions in all the other pollutants. Modeling predicted that the ambient air concentrations due to the increase in NO_x and CO emission would be less than the de minimis levels. Therefore, preconstruction ambient air monitoring was not required.

Permit #597-AR-3 was issued to Georgia-Pacific on August 18, 1988. Emission limits for the 10A Boiler, 8R Recovery Furnace and the No. 4 Lime Kiln were revised as the result of testing.

Permit #597-AR-4 was issued on July 11, 1989. Expansions at the bleach plant were permitted.

Permit #597-AR-5 was issued to Georgia-Pacific on March 18, 1993. This permit included sources at the mill that were not previously permitted. It allowed Georgia-Pacific to burn Tire Derived Fuel (TDF), other scrap rubber products and Refuse Derived Fuel (RDF) in the 10A and 9A Boilers. In addition, a new hardwood brownstock washer system was installed to replace the existing drum washers installed in 1968.

Georgia-Pacific was issued a Prevention of Significant Deterioration (PSD) permit, Permit #1449-A, on May 18, 1993. Stack testing of the 8R Recovery Furnace showed that the current permitted emission rate for NO_x was not attainable. The allowable emission rate of NO_x from the 8R Recovery Furnace was increased by 402.1 tons per year, thus triggering PSD review.

Permit #597-AOP-R0, issued on February 28, 1997, was the first operating air permit issued to Georgia-Pacific Corporation Crossett Paper Operations under Regulation #26. This permit incorporated sources that were not previously permitted. Some allowable emission rates were modified from the previous permit to reflect new emission factors, new test data and/or alternate fuel. This permit also incorporated the Prevention of Significant Deterioration (PSD) permit application submitted in relation to the installation of the new No. 8 Tissue Machine.

Permit #597-AOP-R1, issued on June 29, 1999, was the second Title V operating permit issued to Georgia-Pacific Corporation --Crossett Paper Operations under Regulation #26. The changes in this permit were solely related to air pollutant emission rates and did not affect the Mill's production limits established in the original Title V permit. One purpose of this modification was to address the requirements of a CAO regarding carbon monoxide emissions from the Bleach Plant Scrubber (SN-30). Due to a lack of industry or regulatory information suggesting otherwise, carbon monoxide emissions from the bleach plant were not included in Permit #597-AOP-R0. Specific Condition #73 of that permit required Georgia-Pacific to test for carbon monoxide emissions from SN-30. The required stack testing was performed on September 24, 1997. Emission rates were derived from the stack tests and were added to the permit.

On February 15, 1999, revised versions of Regulations #18 and #19 became effective. All regulatory citations in the permit were changed in 597-AOP-R1 to reflect the new regulations. Compliance demonstrations for all opacity limits have been added to the permit. Opacity demonstrations include, but are not limited to, daily or weekly observations and monitoring of control equipment operating parameters. The compliance demonstrations for all emission limits have been specifically identified in the permit. Applicable provisions of NSPS and NESHAP Subparts have been written into the permit.

The second purpose of this modification was to address the addition of pollution control equipment to comply with the requirements of 40 CFR Part 63 Subpart S -- National Emission Standards for Hazardous Air Pollutants from the Pulp and Paper Industry (NESHAP Subpart S or "Cluster Rule"). This modification qualified as a Pollution Control Project (PCP), and thus the new point source (an Incinerator, SN-83) was exempt from PSD.

Section 19.8 of Regulation #19 provides that the Lime Kiln at GP Crossett should have a TRS emission limit of 8 ppm. Because a source limited to 5 ppm was routed to the Lime Kiln, the lime kiln was assigned a 5 ppm limit. 597-AOP-R1 stipulated that once the HVLC system was outed to collect the emissions from the 5 ppm source, the emission rate for the Lime Kiln could be raised back to 8 ppm. This change has been completed.

597-AOP-R2 was finalized on December 14, 1999. A typographical error was made in a previous permit application which listed the minimum scrubbing liquid flow rate to the #4 tissue machine scrubber (SN-67) as 300 gpm. The actual minimum scrubber flow rate was 70 gpm. Note that the #4 and #5 tissue machine scrubbers are similar and that the #5 tissue machine minimum scrubbing flow rate was also 70 gpm. There was no emission increase associated with this minor modification.

On March 29, 1999, EPA Region 6 issued GP Crossett Paper Operations a NOV addressing the failure to install a continuous opacity monitor for SN-03, the 10A boiler. The current permit will be revised, in a timely manner, to assure compliance with any new applicable requirements resulting from the resolution of this issue.

597-AOP-R3 was finalized on December 14, 2001. This modification, which required PSD review, allowed the Crossett Mill to add the No. 9 Machine to produce tissue and towel. The No. 9 Machine was projected to have a production capacity of 250 Machine Dried Tons of paper (MDT) per day. The installation included the machine itself along with associated stock preparation and converting equipment. The proposed modification exceeded the PSD significant rate thresholds for PM₁₀, VOC, CO, and NO_x.

597-AOP-R4 was finalized on November 12, 2003. The Georgia-Pacific Crossett - Paper Operations facility renewed their Title V permit and included CAM requirements for SN-03, SN-22, SN-50, SN-81, and SN-83. Also included with the renewal permit were four modifications, two of which were minor.

The first modification was to rebuild a Repulper (SN-93) damaged by a fire. The second minor modification involved the installation of an additional electrostatic treater and associated burner to the No. 8 Extruder, SN-71.

Previous to this modification, particulate emissions for the incinerator were underestimated. The assumed stack gas temperature and moisture content were also assumed incorrectly. In addition, the scrubber removal efficiency for particulate was actually 93% instead of 95% as stated in the application. Air Permit 597-AOP-R4 corrected these values.

Carbon monoxide emissions from the bleach plant, resulting from the converting of bleaching operations to elemental chlorine free (ECF) bleaching, were also previously underestimated. The new permit acknowledged that the source required a permitted increase of 242.6 tons of CO per year. Limited data was available at the time of the modification to illustrate any potential increase in CO emissions and none was assumed. The bleach plant conversion was part of a modification which included a PCP (Pollution Control Project) involving an incinerator (SN-83). Both of these changes allowed the facility to comply with Cluster Rule requirements.

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597-AOP-R5 was finalized on November 12, 2003. The permit was modified to include applicable requirements of NESHAP Subpart MM - *National Emission Standards for Hazardous Air Pollutants for Chemical Recovery Combustion Sources at Kraft, Sulfite, and Stand-Alone Semicommercial Pulp Mills*. Affected sources include Smelt Dissolving Tank (East and West, SN-27A and B), the No. 4 Lime Kiln (SN-25), and the 8R Recovery Furnace (SN-26). The permitted particulate emissions at the lime kiln were reduced to comply with the standards of the subpart. The current controls at SN-25, as indicated by stack test data, were sufficient to comply with the more stringent PM emission limit. The permitted particulate emission rate at SN-25 was decreased by 20.5 tons per year. Permitted limits, at the time, were sufficient to meet the established standards set forth in the subpart for the recovery furnace and smelt dissolving tanks.

597-AOP-R6 was finalized on May 31, 2005. The facility modified their permit in order to allow for the relaxation of the O₂ limits for the 10A Boiler (SN-03) during periods of startup, shutdown, and malfunction. There is no actual or permitted emission increase as a result of this modification.

Furthermore, two activities were added to the Insignificant Activity list. First, the baghouse for the Perini Towel Rewinder and Spectrum Towel Printer has been included as an A-13 activity. The Spectrum Towel Printer, which uses inks of low weight percent VOC and no HAPs, were also added as an A-13 activity.

597-AOP-R7 was finalized on December 5, 2005. An allowance to the permit was added for the continued operation of the No. 4 Tissue Machine (SN-66) during the repair of its dust control equipment (SN-67). This allowance has been granted to the facility's other paper machines since the renewal permit.

597-AOP-R8 was finalized May 12, 2006. This revision allowed the facility to modify nine of their Digesters (SN-59) by replacing the six-inch blow valves with eight-inch valves. The modification resulted in an increase in hardwood pulp production of approximately 50 tons per day. The facility is also requested the ability to receive 1.5% sulfur fuel oil while still keeping a 1.0% sulfur average on a 30-day basis. This change affected SN-19, SN-22, SN-25, and SN-26. The facility is also recalculated both criteria and non-criteria pollutants from many of their permitted sources. This recalculation has resulted in a significant drop in annual permitted rates for most criteria pollutants. Several small, existing sources were added to the permit, which were overlooked in the initial and renewal permits: A and B Side Causticizers (SN-98 and 99), White Liquor Storage Tanks (SN-100), and the 9A and 10A Boiler Bark Transfer systems (SN-101 and SN-102). The facility has also requested to remove the No. 9 Paper Machine sources, SN-84 through SN-92 from the permit. The machine was never installed.

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Section IV: EMISSION UNIT INFORMATION

SN-# 03

10A Boiler

Source Description

The 10A Boiler is capable of firing woodwaste, refuse derived fuel (RDF), agriculture derived fuel (ADF), tire derived fuel (TDF) and natural gas. A woodwaste storage pile is associated with the 10A Boiler. Woodwaste consists of bark, wood scraps, wax coated paper, wax coated cardboard, wax coated sawdust, creosote treated railroad crossties and paper pellets (waste paper and wax paper). The majority of the woodwaste for the boiler is delivered by truck and occasionally by rail. It is then transferred by conveyors to either the 9A or the 10A woodwaste storage pile.

RDF and ADF are directly added to the chip piles. RDF consists of pelletized paper, lawn clippings and similar materials that will not have a plastics content greater than 10%. TDF and other scrap rubber products are stored in segregated piles near the woodwaste piles. TDF is loaded several times a day by a front end loader into feeder bins in the vicinity. These solid fuels are then fed onto a conveyor system and delivered to the boilers. ADF consists of, but is not limited to, corn cobs, shucks, and vegetable starch.

The 7R Recovery Boiler was originally constructed in 1968. In 1984 it was converted to the 10A Boiler. The 10A Boiler (SN-03) is a 1001 million Btu per hour combination fuel boiler used to generate steam. This boiler is equipped with a wet venturi scrubber.

The 10A Boiler can operate under three different operating scenarios. The boiler can fire up to 1001 million Btu per hour of which only 669 million Btu per hour can be from natural gas. The first fuel firing scenario consists of the 10A Boiler burning just natural gas. The second fuel firing scenario consists of the 10A Boiler burning a combination of fuels none of which is natural gas. The third fuel firing scenario consists of the 10A Boiler burning a combination of fuels of which the contribution of natural gas can not exceed 669 million Btu per hour.

The 10A boiler is subject to NSPS Subpart D, Standards of Performance for Fossil-Fuel-Fired Steam Generators for Which Construction is Commenced after August 17, 1971. Monitoring of NO_x is not required since the results of a performance test showed emissions of less than 70% of the applicable standard (40 CFR 60.45 (b)(3)). Monitoring of SO₂ is not required under 40 CFR 60.45(b)(1). The CO and NO_x emissions from this boiler are regulated under PSD.

The 10A Boiler is subject to the requirements of Subpart DDDDD—National Emission Standards for Hazardous Air Pollutants for Industrial, Commercial, and Institutional Boilers and Process Heaters.

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Specific Conditions

1. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #14 through #18. [Regulation No. 19 §19.501 et seq. May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 4 - Maximum SO₂, VOC, and Pb Emission Rates for SN-03

Pollutant	lb/hr	ton/yr
Scenario #1: Natural gas only (669 MMBtu/hr)		
SO ₂	1.0	4.4
VOC	2.0	8.8
Pb	0.1	0.1
Scenario #2: Any combination of woodwaste, sludge, TDF, RDF & ADF (1001 MMBtu/hr)		
SO ₂	21.0	92.0
VOC	151.0	661.4
Pb	0.3	1.2
Scenario #3: Natural gas and any combination of woodwaste, sludge, TDF, RDF & ADF (1001 MMBtu/hr)		
SO ₂	21.0	92.0
VOC	151.0	661.4
Pb	0.3	1.2

2. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #12 and #13 [§19.304, §19.501 et seq. and §19.901 of Regulation #19, 40 CFR Part 52 Subpart E, and 40 CFR §60.44]

Table 5 - Maximum NO_x Emission Rates for SN-03

Pollutant	lb/hr	ton/yr
Scenario #1: Natural gas only (669 MMBtu/hr)		
NO _x	200.2	586.1
	0.2 lb/MMBtu	
Scenario #2: Any combination of woodwaste, sludge, TDF, RDF & ADF (1001 MMBtu/hr)		

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Pollutant	lb/hr	ton/yr
sludge, TDF, RDF & ADF (1001 MMBtu/hr)		
NO _x	500.5	2,192.2
		0.5 lb/MMBtu
Scenario #3: Natural gas and any combination of woodwaste, sludge, TDF, RDF & ADF (1001 MMBtu/hr)		
NO _x	300.3	1,315.4
		0.3 lb/MMBtu

3. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #12 and #13 [§19.501 et seq. and §19.901 of Regulation #19, and 40 CFR Part 52 Subpart E]

Table 6 - Maximum CO Emission Rates for SN-03

Pollutant	lb/hr	ton/yr
Scenario #1: Natural gas only (669 MMBtu/hr)		
CO	133.8	596.1
		0.2 lb/MMBtu
Scenario #2: Any combination of woodwaste, sludge, TDF, RDF & ADF (1001 MMBtu/hr)		
CO	600.0	2,628.0
		0.6 lb/MMBtu
Scenario #3: Natural gas and any combination of woodwaste, sludge, TDF, RDF & ADF (1001 MMBtu/hr)		
CO	600.0	2,628.0
		0.6 lb/MMBtu

4. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #14 through #18 and #20. [§19.304 and §19.501 et seq. of Regulation #19, 40 CFR Part 52 Subpart E, and 40 CFR §60.42]

Table 7 - Maximum Particulate Emission Rates for SN-03

Pollutant	lb/hr	ton/yr
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Pollutant	lb/hr	ton/yr
Scenario #1: Natural gas only (669 MMBtu/hr)		
PM	66.9	293.1
PM ₁₀	0.1 lb/MMBtu	
Scenario #2: Any combination of woodwaste, sludge, TDF, RDF & ADF (1001 MMBtu/hr)		
PM	103.0	451.2
Scenario #3: Natural gas and any combination of woodwaste, sludge, TDF, RDF & ADF (1001 MMBtu/hr)		
PM	100.1	438.4
PM ₁₀	0.1 lb/MMBtu	

5. The 10A Boiler shall not exceed the emission rates set forth in the following table.

Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #14 through #18. [§18.801 of Regulation #18 effective February 15, 1999, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 8 - Maximum Non-Criteria Emission Rates for SN-03

Pollutant	lb/hr	ton/yr
Acetone	0.3	1.0
Acetaldehyde	0.84	3.64
Acrolein	4.01	17.54
Arsenic	0.03	0.12
Benzene	4.21	18.42
Beryllium	0.01	0.01
Cadmium	0.02	0.06
Carbon Tetrachloride	0.05	0.20
Chlorine	0.80	3.47
Chloroform	0.03	0.13
Chromium, Hex	0.01	0.02
Chromium, Total	0.04	0.15
Cobalt	0.01	0.03
Formaldehyde	4.41	19.30
Hexane	1.77	7.74
Hydrogen Chloride	24.31	106.45
Manganese	0.21	0.92
Mercury	0.01	0.03
Naphthalene	0.10	0.43
Nickel	0.04	0.15

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Pollutant	lb/hr	ton/yr
Pentachlorophenol	0.01	0.01
Phenol	0.06	0.23
Selenium	0.03	0.13
Styrene	1.91	8.31
2,3,7,8-tetrachlorodibenzo-p-dioxin	8.61E-09	3.77E-08
Tetrachloroethylene	0.04	0.17
Toluene	0.93	4.04
Vinyl Chloride	0.02	0.08

6. When operating under any scenario, the permittee shall not cause to be discharged to the atmosphere from the 10A Boiler gases which exhibit opacity greater than 20% except for one six-minute period per hour of not more than 27% opacity. [§19.304 of Regulation #19 and 40 CFR 60.42(a)(2)]

When operating under Scenario #1, the permittee shall not cause to be discharged to the atmosphere from the 10A Boiler gases which exhibit opacity greater than 5%. [§18.501 of Regulation #18 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Compliance shall be demonstrated by compliance with Specific Condition #20 for fuel Scenarios #2 and #3. Compliance shall be demonstrated during fuel Scenario #1 by the use of natural gas only. The opacity shall be measured in accordance with EPA Reference Method 9.

7. The permittee shall conduct weekly observations of the opacity at SN-03. Observations shall be conducted by personnel familiar with the permittee's visible emissions and certified in the EPA Reference Method 9. If visible emissions appear to be in excess of the permitted opacity are detected, the permittee shall:

- Take immediate action to identify the cause of the visible emissions.
- Implement all necessary corrective action.
- Reassess the visible emissions after corrective action is taken.
 - If excessive visible emissions are still detected, an opacity reading shall be conducted in accordance with EPA Reference Method 9. If the opacity reading exceeds the permitted limit, further corrective measures shall be taken.
 - If no excessive visible emissions are detected, the incident shall be noted in the records as described below.

The permittee shall maintain records related to all Method 9 Readings, to be updated on a weekly basis. The records shall be kept on site and made available to Department personnel upon request. The records shall contain the following items:

1) The date and time of each observation/reading.

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- 2) Any observance of visible emissions appearing to be above permitted limits, or any Method 9 reading which indicates exceedance.
- 3) The cause of any observed exceedance of opacity limits, corrective action taken, and results of the reassessment.
- 4) The name of the person conducting the observation/reading.

[§19.705 of Regulation 19 and 40 CFR Part 52, Subpart E]

8. The 10A Boiler (SN-03) is subject to and shall comply with all applicable provisions of 40 CFR Part 60 Subpart D Standards of Performance for Fossil-Fuel-Fired Steam Generators for Which Construction is Commenced After August 17, 1971, because it burns natural gas, was constructed after August 17, 1971, and is greater than 250 million Btu per hour.

- A. The permittee shall not cause to be discharged into the atmosphere gases which contain particulate matter in excess of 0.10 lb per million Btu derived from gaseous fossil fuel of fossil fuel and wood residue. [§19.304 of Regulation #19 and 40 CFR §60.42(a)(1)]
- B. Compliance with the sulfur dioxide standard shall be based on the total heat input from all fossil fuels burned, including gaseous fuels. [§19.304 of Regulation #19 and 40 CFR §60.43(c)]
- C. The permittee shall not cause to be discharged into the atmosphere gases which contain nitrogen oxides, expressed as NO₂, in excess of 0.20 lb per million Btu derived from gaseous fossil fuel. [§19.304 of Regulation #19 and 40 CFR §60.44(a)(1)]
- D. The permittee shall not cause to be discharged into the atmosphere gases which contain nitrogen oxides, expressed as NO₂, in excess of 0.30 lb per million Btu derived from gaseous fossil fuel and wood residue. [§19.304 of Regulation #19 and 40 CFR §60.44(a)(2)]
- E. The permittee shall install, calibrate, maintain, and operate continuous monitoring systems for measuring opacity and either oxygen or carbon dioxide. In an Alternative Monitoring exemption granted by the EPA in 1999, the facility is not required to install a continuous monitoring system for opacity provided the facility conducts periodic testing, scrubber parameter monitoring, and weekly opacity observations. This exemption is included in appendix G. [§19.304 of Regulation #19 and 40 CFR §60.45(a)]
- F. The permittee shall submit excess emission and monitoring system performance reports to the Department for every calendar quarter. All quarterly reports shall be postmarked by the 30th day following the end of each calendar quarter. Each excess emission and MSP report shall include the information required in 40 CFR §60.7(c). [§19.304 of Regulation #19 and 40 CFR §60.45(g)]
- G. The permittee shall use as reference methods and procedures the test methods in appendix A of this part or other methods and procedures as specified in this section, except as provided in 40 CFR §60.8(b) in conducting the performance

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tests required in 40 CFR §60.8. [§19.304 of Regulation #19 and 40 CFR §60.46(a)]

9. The permittee shall continue to submit quarterly excess emission reports to the following address:

Arkansas Department of Environmental Quality
Air Division
Attn: Air Enforcement Branch
Post Office Box 8913
Little Rock, Arkansas 72119

[§19.304 of Regulation #19 and 40 CFR §60.7(c)]

10. The permittee shall operate the Continuous Emission Monitor (CEM) for CO using O₂ monitoring on the 10A Boiler in accordance with the Department Continuous Emission Monitoring Systems Conditions (Appendix A) and the applicable Performance Standards of 40 CFR Part 60 Appendix B. [§19.703 of Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
11. The permittee shall properly maintain and operate the following existing continuous monitoring instrumentation: O₂, pressure drop across the scrubber and the liquid supply flow at the 10A Boiler (SN-03). [§19.703 and §19.901 Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
12. All continuous monitoring data for O₂ may, at the discretion of the Department, be used to determine violations of NO_X or CO emissions limits. Continuous monitoring data shall be used to demonstrate compliance with the three different fuel firing scenarios of the 10A Boiler. [§19.703 of Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
13. Compliance with the NO_X and CO limits for the 10A Boiler shall be demonstrated by monitoring flue gas O₂ and maintaining the hourly average percent O₂ within the following limits when the steam flow is greater than 100,000 pounds per hour (at actual stack gas moisture contents) and fuel is being fired :
 - A. Full load on natural gas and any combination of woodwaste, sludge, RDF, TDF and ADF: not less than 2.0% nor more than 7.5% O₂
 - B. Reduced load (100,000 to 400,000 pounds per hour steam) on natural gas and any combination of woodwaste, sludge, RDF, TDF and ADF: not less than 2.2% not more than 8.0% O₂
 - C. Full load on gas only: not less than 1.5% nor more than 6.0% O₂
 - D. Reduced load (100,000 to 400,000 pounds per hour steam) on gas only: not less than 1.5% nor more than 4.5% O₂

[§19.703 and §19.901 of Regulation #19, and 40 CFR Part 52 Subpart E]

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The above limits for gas shall not apply when firing gas only for periods of two consecutive hours or less due to an unscheduled outage of woodwaste feed, instead, the above limits for natural gas and any combination of woodwaste, sludge, RDF, TDF and ADF shall apply. Records shall be kept of each unscheduled outage. An operation outside of these average limits shall constitute noncompliance with this Specific Condition and shall be reported quarterly along with excess emissions. The permittee shall maintain records of all flue gas O₂ for the 10A Boiler, including those readings which are to be excluded from the hourly average due to steam flow and fuel firing requirements. The permittee shall make these records available to Department personnel upon request.

14. The permittee may use as fuel in the 10A Boiler, TDF, ADF, RDF, woodwaste, sludge, and natural gas. Creosote treated railroad crossties shall not constitute more than 22.5% of the fuel requirement of the 10A Boiler. [§19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]
15. The permittee shall not burn in excess of 669 thousand standard cubic feet (scf) of natural gas per hour or 5860.5 million scf of natural gas per twelve consecutive months in the 10A Boiler (SN-03). [§19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]
16. The permittee shall not burn in excess of 100 pounds of TDF per minute in the 10A Boiler (SN-03). [§19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]
17. The permittee shall not burn in excess of 250 tons of RDF per day in the 10A Boiler. [§19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]
18. The permittee shall not burn in excess of 62.5 BDT sludge per hour in the 10A Boiler. [§19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]
19. The permittee shall maintain records which demonstrate compliance with Specific Conditions #14, #15, #16, #17, and #18. The permittee shall maintain records of the types and quantities of fuels being used in the 10A Boiler. These records shall be sufficient to demonstrate compliance with the three fuel firing scenarios of the 10A Boiler. The records shall be updated on a monthly basis. These records shall be kept on site, provided to Department personnel upon request and may be used by the Department for enforcement purposes. A twelve month total and each month's individual data shall be submitted to the Department in accordance with General Provision #7. [§19.705 of Regulation #19 and 40 CFR Part 52 Subpart E]
20. The 10A Boiler (SN-03) is subject to and shall comply with all applicable provisions §19.304 of Regulation 19, 40 CFR Part 52 Subpart E, and Part §64.6 for Compliance Assurance Monitoring.

- A. The permittee shall maintain a scrubber liquid flowrate of at least 1500 gallons per minute. [40 CFR Part §64.6(c)(1)]

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- B. The permittee shall maintain a gas pressure drop of at least 5 inches of water. [40 CFR Part §64.6(c)(1)]
- C. The permittee shall monitor and maintain daily records to demonstrate compliance with Specific Condition #20 (A) and (B). Records shall be kept onsite and made available to the Department upon request. [40 CFR Part §64.6(c)(3)]
- D. The permittee shall maintain the scrubber in good working condition at all times so that pollutant removal is maintained. [40 CFR Part §64.6(c)(1)]

21. The 10A Boiler (SN-03) is subject to and shall comply with all applicable provisions §19.304 of Regulation 19, 40 CFR Part 52 Subpart E, and Part §64.9 for Compliance Assurance Monitoring. The following information pertaining to exceedances or excursions from permitted values shall be submitted in semi-annual reports in accordance with General Provision #7 as outlined in 40 CFR §70.6.

- A. The permittee shall maintain records for SN-03 that summarizes the number, duration, and cause of excursions or exceedances of emission limits as well as corrective action taken. [40 CFR §64.9(a)(2)(i) and §64.9(b)]
- B. The permittee shall maintain records for SN-03 that summarizes the number, duration, and cause of monitoring equipment downtime incidents, other than routine downtime for calibration checks. [40 CFR §64.9(a)(2)(ii) and §64.9(b)]
- C. The permittee shall maintain a quality improvement plan (QIP) threshold for each indicator of no more than nine excursions or 5% of the daily averages in a six-month period. [40 CFR §64.9(a)(2)(iii) and §64.9(b)]
- D. The permittee shall develop and implement a new QIP if the threshold is exceeded during any six-month period. [40 CFR §64.9(a)(2)(iii) and §64.9(b)]
- E. The permittee shall maintain records for SN-03 that describes the actions taken to implement the QIP. Upon completion of the QIP, documentation shall be maintained to confirm that the plan was completed and reduced the likelihood of similar excursions or exceedances. [40 CFR §64.9(a)(2)(iii) and §64.9(b)]

22. The permittee shall annually test particulate matter emissions from the 10A Boiler (SN-03) using Method 5 and 202. The permittee shall test at the minimum scrubber parameters of Specific Condition 20. Testing shall be completed no later than 180 days from the date of permit issuance. Results from the Method 5 test shall be compared to the NSPS limit of 0.1 lb/MMBTU for compliance purposes. The permittee shall submit an application to correct emission rates, if corrections are necessary. The testing shall be conducted using a representative fuel mixture. The proportions of each permitted fuel in the representative fuel mixture shall be based upon the month during which the fuel that generates the highest particulate matter emissions was used in greatest proportion. During the test the permittee shall operate the boiler within 10 percent of the rated throughput capacity. If 90 percent of the rated throughput capacity cannot be achieved, the permittee shall be limited to 11 percent. [§19.702 of Regulation #19 and 40 CFR Part 52 Subpart E]

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23. The permittee shall test sulfur dioxide emissions from the 10A Boiler (SN-03). Testing shall be performed in accordance with Plantwide Condition #3 and EPA Reference Method 6. The testing shall be conducted using the maximum TDF and RDF firing rates. During the test the permittee shall operate the boiler within 10 percent of the rated throughput capacity. If 90 percent of the rated throughput capacity cannot be achieved, the permittee shall be limited to 11 percent above the actual tested throughput. Testing on these fuels shall be completed within 30 days upon achieving sufficient inventory levels but no later than 180 days after permit issuance. This condition was satisfied as a requirement of Air Permit #597-AOP-R8. [§19.702 of Regulation #19 and 40 CFR Part 52 Subpart E]
24. After the compliance date of September 13, 2007, the 10A Boiler (SN-03) may not combust papermaking sludge or creosote-treated wood until a site-specific test plan or fuel analysis plan to incorporate these materials is submitted. [§19.304 of Regulation 19 and 40 CFR Part 63, Subpart DDDDD, Appendix A, Section 11(b)]
25. The following parameters were used to determine the eligibility for the health-based compliance alternative for TSM. The permittee is limited to these parameters. [§19.304 of Regulation 19 and 40 CFR Part 63, Subpart DDDDD, Appendix A]
 - a. Fuel types: wood waste, ADF, RDF, TDF
 - b. Maximum heat input rate of 1001 MMBTU/hr
 - c. Control device of a wet venturi scrubber;
 - d. Fuel mix (annual average) with Mn content that is no higher than that which is present in 100% wood waste;
 - e. Maximum emission rate of 0.21 lb/hr manganese (three-hour average);
 - f. Minimum Stack Heights of 53.34 meters;
26. The permittee must update the eligibility demonstration and resubmit it each time that any of the parameters that defined the affected source as eligible for the health-based compliance alternatives changes in a way that could result in increased manganese emissions or increased risk from exposure to emissions. These parameters include, but are not limited to, fuel type, fuel mix (annual average), type of control devices, manganese emission rate, stack height, process parameters (e.g., heat input capacity), relevant reference values, and locations where people live. [§19.304 of Regulation 19 and 40 CFR Part 63, Subpart DDDDD, Appendix A, Section 11(a)]
27. If the permittee is updating the eligibility demonstration to account for an action that is under the permittee's control (e.g. change in heat input capacity of your boiler), the permittee must submit the revised eligibility demonstration to the permitting authority prior to making the change and revise this permit to incorporate the change. If the affected source is no longer eligible for the health-based compliance alternatives, then the permittee must comply with the applicable emission limits, operating limits, and compliance requirements in 40 CFR Part 63, Subpart DDDDD prior to making the process change and revising the permit. If the permittee is updating the eligibility demonstration to account for an action that is outside of the permittee's control (e.g. change in a reference value), and that change causes the source to no

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longer be able to meet the criteria for the health-based compliance alternatives, the source must comply with the applicable emission limits, operating limits, and compliance requirements in 40 CFR Part 63, Subpart DDDDD within 3 years. [§19.304 of Regulation 19 and 40 CFR Part 63, Subpart DDDDD, Appendix A, Section 11(b)]

28. The permittee must keep records of the information used in developing the eligibility demonstration for the affected source, including all of the information specified in Section 8 of Appendix A to 40 CFR Part 63, Subpart DDDDD. [§19.304 of Regulation 19 and 40 CFR Part 63, Subpart DDDDD, Appendix A, Section 12]

29. The permittee shall test for manganese while operating at maximum normal operating load and firing wood-waste only. If the test is conducted at less than the maximum rated capacity of the source, the permittee shall provide an explanation in the site specific test plan. Emission results shall be extrapolated to correlate with 100% of the permitted capacity to determine compliance. The manganese tests shall be performed using EPA Reference Method 29. These tests shall be conducted in accordance with Plantwide Condition #3. The permittee shall operate the control equipment for this source at the minimum parameters specified in Condition 20. Subsequent tests shall be performed every five years from the date of the previous test. Results of this testing shall be submitted to the address listed in General Provision #7. [§19.304 of Regulation 19 and 40 CFR Part 63, Subpart DDDDD, Appendix A]

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30. The permittee shall submit a Title V Air Permit application to modify the CAM parameters contained in Specific Condition 20. The proposed parameters must assure compliance with the maximum particulate, manganese, and sulfur dioxide emission rates of Specific Conditions 1, 4, and 25. The parameters must be based upon recent stack tests while operating at 90% or greater capacity and while firing a representative, worst-case fuel mixture. This application shall be submitted no later than 180 days from issuance of Air Permit #597-AOP-R9. [§19.304 of Regulation 19 and 40 CFR Part 52 Subpart E and Part §64.6]

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SN-18

5A Boiler

Source Description

The 5A Boiler (SN-18) is a 220 million Btu per hour boiler. The boiler is able to burn natural gas. The 5A Boiler was manufactured in 1953 and has never been modified. Therefore it is not subject to NSPS regulations.

The 5A Boiler is subject to the requirements of Subpart DDDDD—National Emission Standards for Hazardous Air Pollutants for Industrial, Commercial, and Institutional Boilers and Process Heaters.

Specific Conditions

31. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #33. [Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 9 - Maximum Criteria Pollutant Emission Rates for SN-18

Pollutant	lb/hr	tpy
PM ₁₀	2.1	8.8
SO ₂	0.2	0.9
VOC	0.4	1.6
CO	14.0	61.0
NO _X	74.0	323.8
Pb	0.1	0.1

32. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Condition #33. [Regulation No. §18.801 effective February 15, 1999, and A.C.A. §8 4 203 as referenced by §8 4 304 and §8 4 311]

Table 10 - Maximum Non-Criteria Pollutant Emission Rates for SN-18

Pollutant	lb/hr	tpy
PM	2.1	8.8
Arsenic	0.01	0.01
Benzene	0.01	0.01
Beryllium	0.01	0.01
Cadmium	0.01	0.01
Chromium, Total	0.01	0.01
Cobalt	0.01	0.01
Formaldehyde	0.02	0.08

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Pollutant	lb/hr	tpy
n-Hexane	0.39	1.71
Mercury	0.01	0.01
Naphthalene	0.01	0.01
Nickel	0.01	0.01
Toluene	0.01	0.01

33. The permittee shall not cause to be discharged to the atmosphere from the 5A Boiler gases which exhibit opacity greater than 5%. Compliance with this opacity limit while using natural gas only shall be demonstrated by the use of natural gas. [§18.501 of Regulation #18 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

34. Natural gas may only be used as fuel in the 5A Boiler. [§18.1004 of Regulation #18, §19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]

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SN-#19

6A Boiler

Source Description

The 6A Boiler (SN-19) is a 357 million Btu per hour boiler. The boiler is able to burn natural gas. The 6A Boiler was manufactured in 1962 and has never been modified. Therefore it is not subject to NSPS regulations. The 6A Boiler can use specification grade oil and natural gas as fuel. Specification grade oil consists of new oil, used oil, used oil absorbent material and pitch from the production of tall oil. However, used oil absorbent material is not used as a fuel in the 6A Boiler.

The 6A Boiler is subject to the requirements of Subpart DDDDD—National Emission Standards for Hazardous Air Pollutants for Industrial, Commercial, and Institutional Boilers and Process Heaters.

Specific Conditions

35. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #39 and #40. [Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 11 - Maximum Criteria Pollutant Emission Rates for SN-19

Pollutant	lb/hr	ton/yr
PM ₁₀	36.8	117.5
SO ₂	431.1	1,888.3
VOC	2.4	10.2
CO	35.3	154.7
NO _x	117.6	515.1
Pb	0.1	0.3

36. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Condition #39. [Regulation No. §18.801 effective February 15, 1999, and A.C.A. §8-4-203 as referenced by §8-4 304 and §8 4 311]

Table 12 - Maximum Non-Criteria Pollutant Emission Rates for SN-19

Pollutant	lb/hr	ton/yr
PM	36.8	117.5
Sulfuric Acid	15.4	45.0
Acrolein	0.01	0.01
Arsenic	0.01	0.01
Benzene	0.01	0.01

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Pollutant	lb/hr	ton/yr
Beryllium	0.01	0.01
Cadmium	0.01	0.01
Chromium, Total	0.01	0.01
Chromium, Hex	0.01	0.01
Cobalt	0.02	0.05
Formaldehyde	0.06	0.27
n-Hexane	0.63	2.76
Manganese	0.02	0.04
Mercury	0.01	0.01
Naphthalene	0.01	0.01
Nickel	0.16	0.67
Phosphorus	0.02	0.08
Selenium	0.01	0.01
Toluene	0.02	0.05

37. When using specification grade oils or a combination of specification grade oils and natural gas, the permittee shall not cause to be discharged to the atmosphere from the 6A Boiler gases which exhibit opacity greater than 20%. Emissions not exceeding 60% opacity will be allowed for six (6) minutes in any consecutive 60-minute period and no more than three (3) times during any 24-hour period. [§19.503 of Regulation #19 and 40 CFR Part 52 Subpart E]

When operating using natural gas only, the permittee shall not cause to be discharged to the atmosphere from the 6A Boiler gases which exhibit opacity greater than 5%. [§18.501 of Regulation #18 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Compliance with this opacity limit while using specification grade oils or a combination of specification grade oils and natural gas shall be demonstrated by compliance with Specific Condition #39. Compliance with this opacity limit while using natural gas only shall be demonstrated by the use of natural gas. The opacity shall be measured in accordance with EPA Reference Method 9 as found in 40 CFR Part 60 Appendix A.

38. When using specification grade oils or a combination of specification grade oils and natural gas, the permittee shall conduct daily observations of the opacity from the 6A Boiler, and keep a record of these observations. If visible emissions are detected, then the permittee shall conduct a 6-minute opacity reading in accordance with EPA Reference Method 9. The results of these observations shall be kept on site and shall be made available to Department personnel upon request. [§19.705 of Regulation #19 and 40 CFR Part 52 Subpart E]

39. Specification grade oils and natural gas may be used as fuel in the 6A Boiler. [§18.1004 of Regulation #18, §19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]

40. The sulfur content of the specification grade oils used at this source shall not exceed 1.5% by weight. [§19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]

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41. The permittee is limited to 1,800 gallons per hour of specification grade oils. [§19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]
42. The sulfur content of the fuel oil shall be verified by testing or vendors' guarantees. The permittee shall maintain a record of each fuel shipment and the associated sulfur content. This record shall be updated with each shipment, kept on site, shall be made available to Department personnel upon request and may be used by the Department for enforcement purposes. This report shall be submitted to the Department in accordance with General Provision #7. [§19.705 of Regulation #19 and 40 CFR Part 52 Subpart E]
43. The permittee shall maintain records which demonstrate compliance with Specific Condition #33. The permittee shall maintain records of the types and quantities of fuels being used in the 6A Boiler. The records shall be updated on a monthly basis. These records shall be kept on site, provided to Department personnel upon request and may be used by the Department for enforcement purposes. A twelve month total and each month's individual data shall be submitted to the Department in accordance with General Provision #7. [§19.705 of Regulation #19 and 40 CFR Part 52 Subpart E]
44. The following parameters were used to determine the eligibility for the health-based compliance alternative for TSM. The permittee is limited to these parameters. [§19.304 of Regulation 19 and 40 CFR Part 63, Subpart DDDDD, Appendix A]
 - a. Fuel types: natural gas, specification grade oil
 - b. Maximum heat input rates: 357 MMBTU/hr;
 - c. Control device: none;
 - d. Fuel mix (annual average) of 100% specification grade oil;
 - e. Maximum emission rate of 0.019 lb/hr (three-hour average);
 - f. Minimum Stack Heights of 42.67 meters;
45. The permittee must update the eligibility demonstration and resubmit it each time that any of the parameters that defined the affected source as eligible for the health-based compliance alternatives changes in a way that could result in increased manganese emissions or increased risk from exposure to emissions. These parameters include, but are not limited to, fuel type, fuel mix (annual average), type of control devices, manganese emission rate, stack height, process parameters (e.g., heat input capacity), relevant reference values, and locations where people live. [§19.304 of Regulation 19 and 40 CFR Part 63, Subpart DDDDD, Appendix A, Section 11(a)]
46. If the permittee is updating the eligibility demonstration to account for an action that is under the permittee's control (e.g. change in heat input capacity of your boiler), the permittee must submit the revised eligibility demonstration to the permitting authority prior to making the change and revise this permit to incorporate the change. If the affected source is no longer eligible for the health-based compliance alternatives, then the permittee must comply with the applicable emission limits, operating limits, and compliance requirements in 40 CFR Part 63, Subpart DDDDD prior to making the process change and revising the permit. If the permittee

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is updating the eligibility demonstration to account for an action that is outside of the permittee's control (e.g. change in a reference value), and that change causes the source to no longer be able to meet the criteria for the health-based compliance alternatives, the source must comply with the applicable emission limits, operating limits, and compliance requirements in 40 CFR Part 63, Subpart DDDDD within 3 years. [§19.304 of Regulation 19 and 40 CFR Part 63, Subpart DDDDD, Appendix A, Section 11(b)]

47. The permittee must keep records of the information used in developing the eligibility demonstration for the affected source, including all of the information specified in Section 8 of Appendix A to 40 CFR Part 63, Subpart DDDDD. [§19.304 of Regulation 19 and 40 CFR Part 63, Subpart DDDDD, Appendix A, Section 12]
48. The permittee shall test SN-19 for manganese while operating at maximum normal operating load and firing specification grade oil. Emission results shall be extrapolated to correlate with 100% of the permitted capacity to determine compliance. The manganese tests shall be performed using EPA Reference Method 29. This test shall be conducted in accordance with Plantwide Condition #3. Subsequent tests shall be performed every five years from the date of the initial test. Results of this testing shall be submitted to the address listed in General Provision #7.

The source does not currently utilize specification oil as fuel. Therefore, the initial test is required prior to any firing of specification oil at SN-19. [§19.304 of Regulation 19 and 40 CFR Part 63, Subpart DDDDD, Appendix A]

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SN#-22

9A Boiler

Source Description

The 9A Boiler is a 720 million Btu per hour combination fuel boiler used to generate steam. The source is equipped with a wet venturi scrubber. The boiler may serve as backup combustion unit during times when the incinerator (SN-83) is offline.

The 9A Boiler is capable of firing tire derived fuel (TDF), agriculture derived fuel (ADF), refuse derived fuel (RDF), non-condensable gases (NCGs), woodwaste, specification grade oil, natural gas and sludge. A woodwaste storage pile is associated with the 9A Boiler. Woodwaste consists of bark, wood scraps, wax coated paper, wax coated cardboard, wax coated sawdust, creosote treated railroad crossties and paper pellets (waste paper and wax paper). Bark from the debarker in the Woodyard is pneumatically transferred to the 9A pile. A cyclone is located at the end of the pneumatic transfer line to control particulate matter emissions. The majority of the woodwaste is delivered by truck and occasionally by rail. It is then transferred by conveyors to either the 9A or the 10A woodwaste storage pile.

RDF, ADF and sludge are directly added to the chip piles. RDF consists of pelletized paper, lawn clippings and similar materials that will not have a plastics content greater than 10%. TDF and other scrap rubber products are stored in segregated piles near the woodwaste piles. TDF is loaded several times a day by a front end loader into feeder bins in the vicinity. These solid fuels are then fed onto a conveyor system and delivered to the boilers. ADF consists of, but is not limited to, corn cobs, shucks, and vegetable starch.

Specification grade oil consists of new oil, used oil, used oil absorbent material and pitch from the production of tall oil. Used oil absorbent material shall include used oil filter paper, used rags, sorbant booms, etc. that meet the specification grade oil criteria (40 CFR 279.11).

The 9A Boiler is subject to the requirements of Subpart DDDDD—National Emission Standards for Hazardous Air Pollutants for Industrial, Commercial, and Institutional Boilers and Process Heaters.

Specific Conditions

49. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #60 through #64, #66, #67, #69 and #70. [Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 13 - Maximum Criteria Pollutant Emission Rates for SN-22

Pollutant	lb/hr	ton/yr
PM ₁₀	90.0	394.2
SO ₂	613.3	1,679.6
VOC	49.7	217.7

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Pollutant	lb/hr	ton/yr
CO	518.4	2,270.6
NO _x	345.0	1,511.1
Pb	2.6	11.2
TRS	2.6	1.2

50. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Condition #60 thru #64 and #67. [Regulation No. §18.801 effective February 15, 1999, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 14 - Maximum Non-Criteria Pollutant Emission Rates for SN-22

Pollutant	lb/hr	ton/yr
PM	90.0	394.2
Sulfuric Acid	27.0	74.0
Acetone	0.2	0.8
Acetaldehyde	0.60	2.62
Acrolein	2.88	12.62
Arsenic	0.02	0.09
Benzene	3.03	13.25
Beryllium	0.01	0.01
Cadmium	0.02	0.06
Carbon Tetrachloride	0.04	0.15
Chlorine	0.59	2.50
Chloroform	0.03	0.09
Chromium, Hex	0.01	0.02
Chromium, Total	0.03	0.13
Cobalt	0.02	0.07
Formaldehyde	3.17	13.88
Hexane	0.79	3.45
Hydrogen Chloride	18.97	83.06
Manganese	0.29	1.28
Mercury	0.01	0.04
Naphthalene	0.07	0.31
Nickel	0.17	0.74
Pentachlorophenol	0.01	0.01
Phenol	0.04	0.17
Selenium	0.03	0.09
Styrene	1.37	6.00
2,3,7,8-tetrachlorodibenzo-p-dioxin	6.19E-09	2.71E-08
Tetrachloroethylene	0.03	0.12
Toluene	0.67	2.91
Vinyl Chloride	0.02	0.06

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51. For all fuel scenarios except natural gas only, the permittee shall not cause to be discharged to the atmosphere from the 9A Boiler, gases which exhibit opacity greater than 20%. Emissions not exceeding 60% opacity will be allowed for six (6) minutes in any consecutive 60-minute period and no more than three (3) times during any 24-hour period. [§19.503 of Regulation #19 and 40 CFR Part 52 Subpart E]

When operating using natural gas only, the permittee shall not cause to be discharged to the atmosphere from the 9A Boiler gases which exhibit opacity greater than 5%. [§18.501 of Regulation #18 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Compliance with this opacity limit shall be demonstrated by compliance with Specific Condition #57 for all fuel scenarios other than using natural gas only. Compliance with the opacity limit while using natural gas only shall be demonstrated by the use of natural gas. The opacity shall be measured in accordance with EPA Reference Method 9 as found in 40 CFR Part 60 Appendix A.

52. SN-22, as a wood fired boiler, shall meet all visible emissions of this chapter except that visible emissions may exceed the permitted opacity for up to 45 minutes once in any consecutive 8 hour period, three times in any consecutive 24 hour period for soot blowing, grate cleaning, ash raking, and refiring necessary for proper operation of these units. This practice is to be scheduled for the same specific time each day and shall be recorded. The Department shall be notified in advance and in writing of the schedule or any changes. The process of soot blowing, grate cleaning, ash raking, and refiring or any part thereof is considered one activity and the time limit on this activity is 45 minutes. [§18.501(A)(4) of Regulation #18 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

53. The Continuous Emission Monitor (CEM) for CO using O₂ monitoring on the 9A Boiler shall be operated in accordance with the Department Continuous Emission Monitoring Systems Conditions (Appendix A) and the applicable Performance Standards of 40 CFR Part 60 Appendix B. [§19.703 of Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

54. The permittee shall properly maintain and operate the following existing continuous monitoring instrumentation: O₂, pressure drop across the scrubber and liquid supply flow at the 9A Boiler. [§19.703 of Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

55. Continuous monitoring data from the continuous monitoring instrumentation listed in Specific Condition #54 may, at the discretion of the Department, be used to determine violations of the emissions limits or conditions of this permit. [§19.703 of Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

56. Compliance with the CO limit for the 9A Boiler shall be demonstrated by monitoring flue gas O₂ and maintaining the O₂ setpoint at not less than 2.0% O₂ (dry basis). Any operation outside this hourly average limit shall constitute noncompliance with this Specific Condition. The permittee shall maintain records of flue gas O₂ for the 9A Boiler and shall make them available to Department personnel upon request. These limits do not apply during startup and shutdown of the 9A Boiler. ~~Startup and shutdown shall be defined as when the steam flow is~~

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less than 100,000 pounds per hour. [§19.703 of Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311,

57. The 9A Boiler (SN-22) is subject to and shall comply with all applicable provisions §19.304 of Regulation 19, 40 CFR Part 52 Subpart E, and Part §64.6 for Compliance Assurance Monitoring:

- A. The permittee shall maintain a scrubber liquid flowrate of at least 1500 gallons per minute. [40 CFR Part §64.6(c)(1)]
- B. The permittee shall maintain a gas pressure drop of at least 5 inches of water. [40 CFR Part §64.6(c)(1)]
- C. The permittee shall monitor and maintain daily records to demonstrate compliance with Specific Condition #57 (A) and (B). Records shall be kept onsite and made available to the Department upon request. [40 CFR Part §64.6(c)(3)]
- D. The permittee shall maintain the scrubber in good working condition at all times so that pollutant removal is maintained. [40 CFR Part §64.6(c)(1)]

58. The 9A Boiler (SN-22) is subject to and shall comply with all applicable provisions §19.304 of Regulation 19, 40 CFR Part 52 Subpart E, and Part §64.9 for Compliance Assurance Monitoring. The following information pertaining to exceedances or excursions from permitted values shall be submitted in semi-annual reports in accordance with General Provision 7 as outlined in 40 CFR §70.6.

- A. The permittee shall maintain records for SN-22 that summarizes the number, duration, and cause of excursions or exceedances of emission limits as well as corrective action taken. [40 CFR §64.9(a)(2)(i) and §64.9(b)]
- B. The permittee shall maintain records for SN-22 that summarizes the number, duration, and cause of monitoring equipment downtime incidents, other than routine downtime for calibration checks. [40 CFR §64.9(a)(2)(ii) and §64.9(b)]
- C. The permittee shall maintain a quality improvement plan (QIP) threshold for each indicator of no more than nine excursions or 5% of the daily averages in a six-month period. [40 CFR §64.9(a)(2)(iii) and §64.9(b)]
- D. The permittee shall develop and implement a new QIP if the threshold is exceeded during any six-month period. [40 CFR §64.9(a)(2)(iii) and §64.9(b)]
- E. The permittee shall maintain records for SN-22 that describes the actions taken to implement the QIP. Upon completion of the QIP, documentation shall be maintained to confirm that the plan was completed and reduced the likelihood of similar excursions or exceedances. [40 CFR §64.9(a)(2)(iii) and §64.9(b)]

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59. The permittee may use the 9A Boiler as an alternate incinerator for NCGs and SOGs during periods when the Incinerator (SN-83) or its associated control equipment is inoperative. [§19.304 of Regulation #19 and 40 CFR §63.443(d)(4)]
60. Specification grade oils, natural gas, woodwaste, TDF, ADF, RDF and wastewater sludge may be used as fuel in the 9A Boiler. Creosote treated railroad crossties shall not constitute more than 25% of the fuel requirement of the 9A Boiler. [§18.1004 of Regulation #18, §19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]
61. The permittee shall not burn in excess of 35 pounds per minute of TDF in the 9A Boiler. [§18.1004 of Regulation #18, §19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]
62. The permittee shall not burn in excess of 250 tons of RDF per day in the 9A Boiler. [§18.1004 of Regulation #18, §19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]
63. The permittee shall not burn in excess of 45 BDT sludge per hour in the 9A Boiler. [§19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]
64. The permittee shall not burn in excess of 200 tons of used oil absorbent material per month in the 9A Boiler. The used oil absorbent material shall meet the specification grade oil criteria found in 40 CFR 279.11. [§18.1004 of Regulation #18, §19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]
65. The permittee shall maintain records which demonstrate compliance with Specific Conditions #60, #61, #62, #63, and #64. The records shall be updated on a monthly basis. These records shall be kept on site, provided to Department personnel upon request and may be used by the Department for enforcement purposes. A twelve month total and each individual month's data shall be submitted in accordance with General Provision #7. [§18.1004 of Regulation #18, §19.705 of Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
66. The sulfur content of the specification grade oils used at this source shall not exceed 1.5% by weight. [§19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]
67. The sulfur content of the fuel oil shall be verified by testing or vendors' guarantees. The permittee shall maintain a record of each fuel shipment and the associated sulfur content. This record shall be updated with each shipment, kept on site, shall be made available to Department personnel upon request and may be used by the Department for enforcement purposes. This report shall be submitted to the Department in accordance with General Provision #7. [§19.705 of Regulation #19 and 40 CFR Part 52 Subpart E]
68. The permittee shall annually test particulate matter emissions from the 9A Boiler (SN-22) using Method 5 and 202. The permittee shall test at the minimum scrubber parameters of Specific Condition 57. Testing shall be completed no later than 180 days from the date of permit issuance. The permittee shall submit an application to correct emission rates, if

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corrections are necessary. The testing shall be conducted using a representative fuel mixture. The proportions of each permitted fuel in the representative fuel mixture shall be based upon the month during which the fuel that generates the highest particulate matter emissions was used in greatest proportion. During the test the permittee shall operate the boiler within 10 percent of the rated throughput capacity. If 90 percent of the rated throughput capacity cannot be achieved, the permittee shall be limited to 11 percent above the actual tested throughput. This test was completed as a requirement of Air Permit #597-AOP-R8. [§18.1002 of Regulation #18, §19.702 of Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

69. Sulfur dioxide emission shall be determined through a mass balance based on incoming materials, worst-case firing of specification grade oil based on the limits in Condition #66, and periods where the source is used as an alternate incinerator. This mass balance shall be submitted to the Department in accordance with General Provision #7. [§19.703 of Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
70. The permittee shall annually test nitrogen oxides emissions from the 9A Boiler (SN-22). Testing shall be performed in accordance with Plantwide Condition #3 and EPA Reference Method 7E as found in 40 CFR Part 60 Appendix A. The testing shall be done using a representative fuel mixture. The proportions of each permitted fuel in the representative fuel mixture shall be based upon the month during which the fuel that generates the highest nitrogen oxides emissions was used in greatest proportion. During the test the permittee shall operate the boiler within 10 percent of the rated throughput capacity. If 90 percent of the rated throughput capacity can not be achieved, the permittee shall be limited to 11 percent above the actual tested throughput. [§19.702 of Regulation #19 and 40 CFR Part 52 Subpart E]
71. The permittee shall test sulfur dioxide emissions from the 9A Boiler (SN-22). Testing shall be performed in accordance with Plantwide Condition #3 and EPA Reference Method 6. The testing shall be conducted using the maximum TDF and RDF firing rates. During the test the permittee shall operate the boiler within 10 percent of the rated throughput capacity. If 90 percent of the rated throughput capacity cannot be achieved, the permittee shall be limited to 11 percent above the actual tested throughput. Testing on these fuels shall be completed within 30 days upon achieving sufficient inventory levels but no later than 180 days after permit issuance. [§19.702 of Regulation #19 and 40 CFR Part 52 Subpart E]
72. The permittee shall submit a request to EPA for a determination regarding the applicability of NSPS Subpart D limits and testing requirements during fossil fuel firing scenarios. Within 30 days of permit issuance, this request shall be submitted to EPA and a copy shall be submitted to the Department. The permittee may burn any currently permitted fossil fuel until a determination is made by EPA. This condition was satisfied as a requirement of Air Permit #597-AOP-R8. [A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
73. The following parameters were used to determine the eligibility for the health-based compliance alternative for TSM. The permittee is limited to these parameters. [§19.304 of Regulation 19 and 40 CFR Part 63, Subpart DDDDD, Appendix A]

- a. Fuel types: wood waste, ADF, RDF, TDF, specification grade oil

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- b. Maximum heat input rates of 720 MMBTU/hr;
- c. Control device of a wet venturi scrubber;
- d. Fuel mix (annual average) with Mn content that is no higher than that which is present in 100% wood waste;
- e. Maximum emission rate of 0.29 lb/hr (three-hour average);
- f. Minimum Stack Heights of 53.34 meters;

74. The permittee must update the eligibility demonstration and resubmit it each time that any of the parameters that defined the affected source as eligible for the health-based compliance alternatives changes in a way that could result in increased manganese emissions or increased risk from exposure to emissions. These parameters include, but are not limited to, fuel type, fuel mix (annual average), type of control devices, manganese emission rate, stack height, process parameters (e.g., heat input capacity), relevant reference values, and locations where people live. [§19.304 of Regulation 19 and 40 CFR Part 63, Subpart DDDDD, Appendix A, Section 11(a)]

75. If the permittee is updating the eligibility demonstration to account for an action that is under the permittee's control (e.g. change in heat input capacity of your boiler), the permittee must submit the revised eligibility demonstration to the permitting authority prior to making the change and revise this permit to incorporate the change. If the affected source is no longer eligible for the health-based compliance alternatives, then the permittee must comply with the applicable emission limits, operating limits, and compliance requirements in 40 CFR Part 63, Subpart DDDDD prior to making the process change and revising the permit. If the permittee is updating the eligibility demonstration to account for an action that is outside of the permittee's control (e.g. change in a reference value), and that change causes the source to no longer be able to meet the criteria for the health-based compliance alternatives, the source must comply with the applicable emission limits, operating limits, and compliance requirements in 40 CFR Part 63, Subpart DDDDD within 3 years. [§19.304 of Regulation 19 and 40 CFR Part 63, Subpart DDDDD, Appendix A, Section 11(b)]

76. The permittee must keep records of the information used in developing the eligibility demonstration for the affected source, including all of the information specified in Section 8 of Appendix A to 40 CFR Part 63, Subpart DDDDD. [§19.304 of Regulation 19 and 40 CFR Part 63, Subpart DDDDD, Appendix A, Section 12]

77. After the compliance date of September 13, 2007, the 9A Boiler (SN-22) may not combust papermaking sludge, creosote-treated wood, used oil absorbent material, NCGs, or SOGs until a site-specific test plan or fuel analysis plan to incorporate these materials is submitted. [§19.304 of Regulation 19 and 40 CFR Part 63, Subpart DDDDD, Appendix A, Section 11(b)]

78. The permittee shall test for manganese while operating at maximum normal operating load and firing wood-waste only. If the test is conducted at less than the maximum rated capacity of the source, the permittee shall provide an explanation in the site specific test plan. Emission results shall be extrapolated to correlate with 100% of the permitted capacity to determine compliance. The manganese tests shall be performed using EPA Reference Method 29.

▼ These tests shall be conducted in accordance with Plantwide Condition #3. The permittee

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shall operate the control equipment for this source at the minimum parameters specified in Condition 57. Subsequent tests shall be performed every five years from the date of the previous test. Results of this testing shall be submitted to the address listed in General Provision #7. [§19.304 of Regulation 19 and 40 CFR Part 63, Subpart DDDDD, Appendix A]

79. The permittee shall submit a Title V Air Permit application to modify the CAM parameters contained in Specific Condition 57. The proposed parameters must assure compliance with the maximum particulate, sulfur dioxide, and manganese emission rates of Specific Conditions 49 and 73. The parameters must be based upon recent stack tests while operating at 90% or greater capacity and while firing a representative, worst-case fuel mixture. This application shall be submitted no later than 180 days from issuance of Air Permit #597-AOP-R9. [§19.304 of Regulation 19 and 40 CFR Part 52 Subpart E and Part §64.6]

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SN-#57F, #58F, 101, and 102

Woodyard

Source Description

Activities in the Woodyard include unloading incoming chips and wood, wood transferring, debarking (SN-57F), chipping (SN-58F), chip storage (SN-58F) and chip screening. Emissions are controlled by the use of water sprays.

Chips are delivered either by trucks or rail cars. The truck shipments are unloaded at an inclining truck dump. The rail car shipments are emptied by rolling the rail car over. From these two delivery points the chips are conveyed to the distribution tower and are then dropped into the chip piles. Water is added to the pneumatic transfer system to control dust.

In addition to chips, Georgia-Pacific also receives round logs. After storage, the logs are transported to the debarking drum for bark removal. The removed bark is pneumatically sent to the bark piles for storage and eventual use in the 9A and 10A Boilers of the Utilities Operations. The debarked logs are fed to the chipper. The chips that are produced are conveyed to the distribution tower and deposited onto the chip piles.

Chips from the chip piles are screened prior to entering the chip silo. Rejected chips from the screening process are sent to the combination boilers for use in steam production.

Bark either purchased or from the Woodyard is transferred by enclosed conveyors to the 9A and 10A Boilers' associated fuel storage piles. Emissions for these sources are calculated using drop transfer points.

Specific Conditions

80. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Condition #82. [Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 15 - Maximum Criteria Pollutant Emission Rates for SN-57F, 58F, 101, and 102

SN	Description	Pollutant	lb/hr	ton/yr
57F	Woodyard Debarking Drum and Associated Woodyard Chip Handling System	PM ₁₀ VOC	0.6 640.2	2.6 2,803.7
58F	Woodyard Chip Storage Piles & Chipper	PM ₁₀ VOC	1.1 2.1	4.5 8.8
101	10A Boiler Bark Transfer System	PM ₁₀	0.1	0.1

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SN	Description	Pollutant	lb/hr	ton/yr
102	9A Boiler Bark Transfer System	PM ₁₀	0.1	0.1

81. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Condition #84. [Regulation No. §18.801 effective February 15, 1999, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 16 - Maximum Non-Criteria Pollutant Emission Rates for SN-57F, 58F, 101, and 102

SN	Pollutant	lb/hr	ton/yr
57F	PM	1.2	5.3
58F	PM	2.1	9.0
101	PM	0.1	0.3
102	PM	0.1	0.1

82. The permittee shall not process in excess of 8400 tons of wet wood as received in the Woodyard per day, 30 day rolling average. [§18.1004 of Regulation #18, §19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]

83. The permittee shall maintain records which demonstrate compliance with the limit in Specific Condition #82. The records shall be updated on a monthly basis. These records shall be kept on site, provided to Department personnel upon request and may be used by the Department for enforcement purposes. A twelve month total and each individual month's data shall be submitted in accordance with General Provision #7. [§18.1004 of Regulation #18, §19.705 of Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

84. The permittee shall use water sprays in the discharge from the conveyance system in the Woodyard area to reduce particulate matter emissions except during periods when rain provides equivalent dust suppression, or when inclement weather creates a safety hazard to operators. [§19.303 of Regulation #19 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

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SN-#59

Batch Digesters

Source Description

Chips from the Woodyard are sent to the pulp mill where they are converted to pulp using the chemical Kraft process. The chip conveying system regulates the flow of chips from the silos in the Woodyard to one of the thirteen batch digesters (SN-59). The function of the digesters is to cook chips using white liquor, black liquor and steam from the boilers. In the digestion process these products are combined and cooked at a set pressure and temperature until a quality pulp is obtained. At the end of each cook the blow valve at the bottom of the digester is opened. The pressure in the digester forces the pulp mass through a blow line into the blow tanks.

The mill has two large cylindrical blow tanks. All remaining process equipment in the Pulp Mill is divided into two parallel but separate lines. The blow tanks are at atmospheric pressure. When the chips hit the lower pressure in the tank, the liquor and water flash, blowing apart the chips to produce the pulp fibers. The fibers and the spent cooking liquor fall to the bottom of the blow tank.

The vapors from the blow tanks exit through a vapor line at the top of each blow tank. The vapors from each tank are combined and sent to the blow heat condensing system. Flow to the condensing system is maintained in the absence of blow downs by steam supplements. There is a series of condensers that remove condensable gases (primarily turpentine) from the blow gas. The steam vapors are condensed in the accumulator tank and used as hot water for the washers. Gases that do not condense are sent to the Incinerator (primary), or the Lime Kiln (primary until the Incinerator is installed, backup afterwards) and/or the 9A Boiler (backup) for thermal destruction.

During the loading of chips the digester caps are opened allowing for emissions.

Specific Conditions

85. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Condition #90. [Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 17 - Maximum Criteria Pollutant Emission Rates for SN-59

Pollutant	lb/hr	ton/yr
VOC	55.9	244.7
TRS	4.3	18.9

86. The permittee estimates the pollutant emission rates set forth in the following table will not be exceeded. The pollutant emission rates are effectively limited by Specific Condition #90.

[Regulation No. §18.801 effective February 15, 1999, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 18 - Maximum Non-Criteria Pollutant Emission Rates for SN-59

Pollutant	lb/hr	ton/yr
Acetone	0.1	0.2
Acetaldehyde	0.03	0.08
Acrolein	0.01	0.01
Benzene	0.01	0.01
Carbon Tetrachloride	0.01	0.01
Chloroform	0.03	0.10
1,2 Dichloroethylene	0.01	0.01
Formaldehyde	0.01	0.01
Hexane	0.01	0.01
Methanol	0.57	2.16
Methylene Chloride	0.01	0.01
Styrene	0.01	0.02
Tetrachloroethylene	0.01	0.01
Toluene	0.01	0.01
Trichloroethylene	0.01	0.01
1,2,4-Trichlorobenzene	0.01	0.01

87. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Condition #88. [§19.304 and §19.501 et seq. of Regulation #19, 40 CFR Part 52 Subpart E, and 40 CFR §60.283]

Table 19 - Maximum TRS Emission Rates for SN-59

Pollutant	lb/hr	ton/yr
TRS	4.3	18.9
5 ppm dv corrected to 10% O ₂		

88. The Batch Digesters (SN-59) are subject to and shall comply with all applicable provisions of §19.304 of Regulation 19 and 40 CFR Part 60 BB - *Standards of Performance for Kraft Pulp and Paper Mills*. A copy of Subpart BB is provided in Appendix C. Applicable provisions of Subpart BB include, but are not limited to, the following:

- A. The permittee shall not cause to be discharged into the atmosphere from the digester system any gases which contain TRS in excess of 5 ppm by volume on a dry basis, corrected to 10 percent oxygen, unless the conditions of 40 CFR §60.283(a)(1)(i)-(vi) are met. [40 CFR §60.283(a)(1)]
- B. The permittee shall install, calibrate, maintain, and operate a continuous monitoring system to monitor and record the concentration of TRS emissions on

a dry basis and the percent of oxygen by volume on a dry basis in the gases discharged into the atmosphere from the digester system, except where the provisions of 40 CFR §60.283(a)(1)(iii) or (iv) apply. This system shall be located downstream of the control device and the span shall be set at a TRS concentration of 30 ppm for the TRS continuous monitoring system and at 20 percent oxygen for the continuous oxygen monitoring system. [40 CFR §60.284(a)(2)]

- C. The permittee shall calculate and record on a daily basis 12-hour average TRS concentrations for the two consecutive periods of each operating day. Each 12-hour average shall be determined as the arithmetic mean of the appropriate 12 contiguous 1-hour average total reduced sulfur concentrations provided by each continuous monitoring system installed under paragraph (a)(2) of this section. [40 CFR §284(c)(1), except where the provisions of 40 CFR §60.283(a)(1)(iv) or (a)(4) apply]
- D. The permittee shall report semiannually periods of excess emissions. [40 CFR §60.284(d)]
- E. The permittee shall use as reference methods and procedures the test methods in appendix A of this part or other methods and procedures in this section, except as provided in 40 CFR §60.8(b). Acceptable alternative methods and procedures are given in paragraph (f) of this section. [40 CFR §60.285(a)]

89. The permittee may use the 9A Boiler or Lime Kiln (SN-25) as an incinerator for Low Volume High Concentration (LVHC) NCGs only during periods when the incinerator (SN-83) or its associated control equipment is inoperative. [§19.801 of Regulation #19]

90. The permittee shall not process in excess of 8,757 tons of wood chips per day, 30 day rolling average. [§19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70]

91. The permittee shall maintain records which demonstrate compliance with the limits specified in Specific Condition #90. The records shall be updated on a monthly basis. These records shall be kept on site, provided to Department personnel upon request and may be used by the Department for enforcement purposes. A twelve month total and each individual month's data shall be submitted in accordance with General Provision #7. [§19.705 of Regulation #19 and 40 CFR Part 52 Subpart E]

SN-#33, #34, #60 and #61

Pulp Mill Operations

Source Description

When the pulp and black liquor exit the blow tank, the pulp goes through several processing steps before it is stored in the unbleached high density storage chest. First, knots are removed prior to washing. The knots are recovered and used as woodwaste fuel. Second, the pulp is washed to separate the pulp from the spent cooking chemicals and the black liquor. There are two horizontal washers. The emissions from the associated black liquor storage tank and Line 1 Decker (SN-60) are routed to the Incinerator (SN-83), with the Lime Kiln scrubber operating as a backup control device. The Line 1 and Line 2 Washers (SN-33 and SN-34) are not equipped with any control equipment. Next, the pulp passes through the decker system. The decker system (SN-60 and 61) thickens the pulp for storage in the high density storage chests.

Although the operations at the pulp mill are in parallel, the two lines are run separately.

Specific Conditions

92. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Condition #90. [Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 20 - Maximum Criteria Pollutant Emission Rates for SN-33, 34, 60, and 61

SN	Description	Pollutant	lb/hr	ton/yr
33	Line 1 Washer	VOC	10.4	45.6
		TRS	2.9	12.6
34	Line 2 Washer	VOC	8.7	32.8
		TRS	8.8	38.2
60	Line 1 Decker	Emissions are routed to the Incinerator (SN-83)		
61	Line 2 Decker	VOC	7.0	26.3
		TRS	1.4	6.0

93. The permittee estimates the emission rates set forth in the following table will not be exceeded. The pollutant emission rates are effectively limited by Specific Condition #90. [Regulation No. §18.801 effective February 15, 1999, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 21 - Maximum Non-Criteria Pollutant Emission Rates for SN-33, 34, 60, and 61

SN	Description	Pollutant	lb/hr	ton/yr
33	Line 1 Washer	Acetophenone	0.08	0.35
		Acrolein	0.01	0.01
		o-Cresol	0.24	1.04
		Methanol	3.24	14.20
		Phenol	0.26	1.13
34	Line 2 Washer	Acetone	0.5	2.4
		Acetaldehyde	0.22	0.84
		Acrolein	0.01	0.02
		Benzene	0.01	0.01
		Carbon Tetrachloride	0.01	0.03
		Chloroform	0.01	0.01
		1,2 Dichloroethylene	0.01	0.02
		Formaldehyde	0.01	0.02
		n-Hexane	0.02	0.05
		Methanol	8.25	31.40
		Styrene	0.02	0.07
		Toluene	0.02	0.07
		Trichloroethylene	0.01	0.01
		1,2,4-Trichlorobenzene	0.05	0.18
60	Line 1 Decker	Emissions are routed to the Incinerator (SN-83)		
61	Line 2 Decker	Acetone	0.8	4.0
		Acetaldehyde	0.13	0.46
		Acrolein	0.01	0.04
		Benzene	0.01	0.01
		Carbon Tetrachloride	0.04	0.13
		1,2 Dichloroethylene	0.01	0.01
		Formaldehyde	0.01	0.04
		o-Cresol	0.57	2.13
		Methanol	5.61	21.30
		Propriionaldehyde	0.18	0.67
		Styrene	0.03	0.10
		Tetrachloroethylene	0.05	0.18
		Toluene	0.01	0.03
		Trichloroethylene	0.10	0.36
		1,2,4-Trichlorobenzene	0.16	0.59

94. The Line 1 Washer (SN-33) and the Line 2 Washer (SN-34) are subject to and shall comply with all applicable provisions of §19.304 of Regulation 19 and 40 CFR Part 60 Subpart BB - *Standards of Performance for Kraft Pulp and Paper Mills*.

A copy of Subpart BB is provided in Appendix C. See also Compliance Plan on page 136. Applicable provisions of Subpart BB include, but are not limited to, the following:

- A. The permittee shall not cause to be discharged into the atmosphere from SN-33 and SN-34 any gases which contain TRS in excess of 5 ppm by volume on a dry basis, corrected to 10 percent oxygen, unless the conditions of 40 CFR §60.283(a)(1)(i)-(vi) are met. [40 CFR §60.283(a)(1)]
- B. The permittee shall install, calibrate, maintain, and operate a continuous monitoring system to monitor and record the concentration of TRS emissions on a dry basis and the percent of oxygen by volume on a dry basis in the gases discharged into the atmosphere from SN-33 and SN-34, except where the provisions of 40 CFR §60.283(a)(1)(iii) or (iv) apply. This system shall be located downstream of the control device and the span shall be set at a TRS concentration of 30 ppm for the TRS continuous monitoring system and at 20 percent oxygen for the continuous oxygen monitoring system. [40 CFR §60.284(a)(2)]
- C. The permittee shall calculate and record on a daily basis 12-hour average TRS concentrations for the two consecutive periods of each operating day. Each 12-hour average shall be determined as the arithmetic mean of the appropriate 12 contiguous 1-hour average total reduced sulfur concentrations provided by each continuous monitoring system installed under paragraph (a)(2) of this section. [40 CFR §60.284(c)(1), except where the provisions of 40 CFR §60.283(a)(1)(iv) or (a)(4) apply]
- D. For the purpose of reports required under 40 CFR §60.7(c), the permittee shall report semiannually periods of excess emissions. The applicant must also report the nature and cause of the excess emissions in accordance with 40 CFR §60.7(c)(2). [40 CFR §60.284(d)]
- E. In conducting the performance tests required in 40 CFR §60.8, the permittee shall use as reference methods and procedures the test methods in appendix A of this part or other methods and procedures in this section, except as provided in 40 CFR §60.8(b). Acceptable alternative methods and procedures are given in paragraph (f) of this section. [40 CFR §60.285(a)]

95. The Line 1 Washer (SN-33) and the Line 2 Washer (SN-34) shall comply with applicable provisions of §19.304 of Regulation 19 and 40 CFR Part 63 Subpart S – *National Emission Standards for Hazardous Air Pollutants from the Pulp and Paper Industry*.

A copy of Subpart S is provided in Appendix F. Applicable provisions include, but are not limited to, the following:

- A. The permittee shall visually inspect each closed-vent system every 30 days. The visual inspection shall include inspection of ductwork, piping, enclosures, and connections to covers for visible evidence of defects. [40 CFR §63.453(k)(2)]
- B. The permittee shall demonstrate no detectable leaks as specified in §63.450(c)

measured initially and annually by the procedures specified in §63.457(d). [40 CFR §63.453(k)(3)]

- C. The permittee shall operate the closed-vent system with no detectable leaks as indicated by an instrument reading of less than 500 parts per million by volume (ppm) above background as specified by §63.457(d). [40 CFR §63.450(c)]
- D. The permittee shall perform corrective action, in the event of visible leak detection or instrument reading of 500 ppm above background, according to §63.453(k)(6)(i) and (ii). [40 CFR §63.457(k)(6)]

As part of an alternative monitoring requirement approved by the EPA, a copy of which is located in Appendix J, the permittee shall comply with the following:

- E. In lieu of monthly visual monitoring, the permittee shall conduct monthly Method 21 monitoring of leaks found around the feed and exit roll seals and along the side gaskets of the washers. [40 CFR §63.453(d)(4)]

SN-#30

Bleach Plant

Source Description

The unbleached Kraft pulp is taken from the high density storage chest for further processing in the bleach plant. The bleaching process removes lignin and Kraft color from the unbleached pulp.

Bleaching is performed in several stages using chlorine/chlorine dioxide, caustic soda, oxygen, acid, hydrogen peroxide, and other non-chlorine bleaching aids. Chlorine dioxide is generated using sodium chlorate, methanol and sulfuric acid. The chlorine dioxide gas that is produced is absorbed in chilled water and sent to storage for further use in the bleaching operations.

The bleach plant uses a scrubber (SN-30) to control chlorine/chlorine dioxide emissions. All equipment in the bleach plant is either pressurized or is kept under negative pressure and connected to the scrubbing system. The Bleach Plant scrubber is a packed tower with mist eliminators. In order to satisfy Cluster Rule requirements, Crossett Paper Operations has phased out Cl₂ and hypochlorite usage by the Cluster Rule compliance date of deadline of April 16, 2001.

As part of permit revision 597-AOP-R4, the Bleach Plant was required to undergo BACT for CO. Due to the phasing out of hypochlorite and limited available data concerning the resulting carbon monoxide emissions, the facility was required to modify the permit. The increase was above the PSD significance threshold for CO. BACT was determined to be no controls.

Specific Conditions

96. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Condition #98. [Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 22 - Maximum Criteria Pollutant Emission Rates for SN-30

Pollutant	lb/hr	ton/yr
VOC	20.9	79.1
CO	136.1	596.1

97. The permittee shall not exceed the pollutant emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Condition #98. [Regulation No. §18.801 effective February 15, 1999, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 23 - Maximum Non-Criteria Pollutant Emission Rates for SN-30

Pollutant	lb/hr	ton/yr
Acetone	0.4	1.3
Acetaldehyde	0.10	0.37
Acrolein	0.01	0.01
Benzene	0.01	0.01
Carbon tetrachloride	0.01	0.01
Chlorine	2.53	9.63
Chloroform	6.82	26.00
Formaldehyde	0.03	0.11
Hexane	0.01	0.01
Hexachlorocyclo- pentadiene	0.18	0.67
Hexachloroethane	0.24	0.88
Hydrogen chloride	2.53	9.63
o-Cresol	0.07	0.24
Methanol	13.20	50.20
Methylene Chloride	0.06	0.25
Phenol	0.04	0.12
Propionaldehyde	0.06	0.22
Styrene	0.03	0.10
Tetrachloroethylene	0.02	0.04
Toluene	0.01	0.01
Trichloroethylene	0.01	0.02
1,2,4-trichlorobenzene	0.01	0.03

98. The permittee shall not produce in excess of 2,150 air dried tons of bleached pulp per day, 30 day rolling average. [§19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]

99. The permittee shall maintain records which demonstrate compliance with the limits listed in Specific Condition #98. The records shall be updated on a monthly basis. These records shall be kept on site, provided to Department personnel upon request and may be used by the Department for enforcement purposes. A twelve month total and each individual month's data shall be submitted in accordance with General Provision #7. [§19.705 of Regulation #19 and 40 CFR Part 52 Subpart E]

100. The permittee shall annually determine emissions of chlorine and chloroform using NCASI Methods TB 520 and TB 531 or an alternative method approved by the Air Division. Records of emission tests shall be kept onsite, provided to Department personnel upon request and may be used for enforcement purposes. The annual total shall be submitted in accordance with General Provision #7. During the test the permittee shall operate the plant within 10 percent of the rated throughput capacity. If 90 percent of the rated throughput capacity can not be achieved, the permittee shall be limited to 11 percent above the actual tested throughput. [§18.1002 of Regulation #18 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

101. The permittee shall annually test for carbon monoxide emissions from the Bleach Plant Scrubber (SN-30). Testing shall be performed in accordance with Plantwide Condition #3 and EPA Reference Method 10 as found in 40 CFR Appendix A. During the test the permittee shall operate the plant within 10 percent of the rated throughput capacity. If 90 percent of the rated throughout capacity cannot be achieved, the permittee shall be limited to 11 percent above the actual tested throughput. [§19.702 of Regulation #19 and 40 CFR Part 52 Subpart E]

102. The Bleach Plant is subject to and shall comply with applicable provisions of §19.304 of Regulation 19 and 40 CFR Part 63 Subpart S – *National Emission Standards for Hazardous Air Pollutants from the Pulp and Paper Industry*.

A copy of Subpart S is provided in Appendix F. Applicable provisions include, but are not limited to, the following.

- A. The equipment at each bleaching stage, of the bleaching systems listed in paragraph (a) of 40 CFR §63.445, where chlorinated compounds are introduced shall be enclosed and vented into a closed-vent system and routed to a control device that meets the requirements specified in paragraph (c) of 40 CFR §63.445. The enclosures and closed-vent system shall meet the requirements specified in 40 CFR §63.450. [40 CFR §63.445(b)]
- B. The control device used to reduce chlorinated HAP emission (not including chloroform) from the equipment specified in paragraph (b) of 40 CFR §63.445, the permittee shall comply with the emissions limitations required for bleaching systems by one of the following methods 1) achieving a 99% reduction efficiency across the scrubber or 2) achieving <10 ppm HAPs or 0.002 lbs/ODTP, measured as chlorine. [40 CFR §63.445(c)(3)]
- C. The owner or operator of each bleaching system subject to paragraph (a)(2) of 40 CFR §63.445 shall comply with paragraph (d)(1) or (d)(2) of 40 CFR §63.445 to reduce chloroform air emissions to the atmosphere, except where the owner or operator of each bleaching system complying with extended compliance under 40 CFR §63.440(d)(3)(ii) shall comply with paragraph (d)(1) of 40 CFR §63.445. [40 CFR §63.445(d)]
- D. The permittee shall use no hypochlorite or elemental chlorine for bleaching in the bleaching system or line. [40 CFR §63.445(d)(2)]

103. The Bleach Plant is subject to and shall comply with applicable provisions of §19.304 of Regulation 19 and 40 CFR Part 63 Subpart S – *National Emission Standards for Hazardous Air Pollutants from the Pulp and Paper Industry*. A copy of Subpart S is provided in Appendix F. Applicable provisions include, but are not limited to, the following.

The scrubber shall be kept in good working condition at all times and shall meet the following conditions as part of an alternative monitoring requirement approved by the EPA on July 26, 2001. A copy of this letter is included in appendix H. [40 CFR 63.453(m)]

- A. Perform a successful initial performance test to determine an acceptable range of electrical current (amps) within which the fan needs to be operated. Testing shall be completed and reported to the Department no more than six months from final permit.
- B. Continuously record and monitor the fan motor amperage loading to ensure proper rotational fan speed and pressure drop for the bleach plant scrubber fan.
- C. Conduct monthly visual inspections under the Leak Detection and Repair plan provisions for the scrubber fan and associated process.
- D. Conduct annual negative pressure checks to ensure that the bleach plant scrubber fan induces the desired negative pressure across the system.
- E. Conduct periodic preventative maintenance of the bleach plant scrubber fan to ensure safe and proper operation of the system.
- F. Respond immediately to any signs or indications of visible emissions from the scrubber stack, washer hoods, or towers at the bleach plant.
- G. Replacement of fan blades or fan motor will require a demonstration by the facility that gas flow rate to the scrubber has not increased or a performance test to ensure that the scrubber meets the emission limitations.

SN-26 and 96

8R Recovery Furnace and Salt Cake Mix Tank

Source Description

Recovery is the set of operations that recover spent cooking chemicals for reuse in the digesters. The recovery process uses a multi-effect evaporator to concentrate weak black liquor. Concentrated black liquor is burned in the 8R Recovery Furnace (SN-26) to recover spent chemicals, the inorganic chemicals that are necessary for pulp making. Auxiliary fuels, such as oil, may be used by the furnace for startup or to augment liquor combustion. Exhaust gases from the recovery furnace are treated in an electrostatic wet bottom precipitator. The spent chemicals leave the recovery furnace in a molten form and enter the smelt dissolving tanks.

Evaporation and concentration operations remove water from the black liquor in order to facilitate combustion in the recovery furnace. The solids in the liquor are generated from the digester and washing filtrates. The evaporators convert the weak black liquor to strong (heavy) black liquor.

There are six effects in the evaporator train at the mill, each effect operating at a different pressure. Plant steam flows countercurrent to the black liquor through the evaporators. Combined condensate from the evaporator is used in washing and recausticizing. A Low Energy Environmental Pre-evaporator and Stripper (LEEPS) system added to the evaporator system treats the foul (or strip) condensates produced in the evaporation process. The LEEPS system also treats foul condensates generated from the pulping process. The clean water produced is re-used for pulp washing. The stripped condensate (methanol) is routed to the incinerator as a liquid for destruction. The stripper overhead gases (SOGs) are routed to the incinerator for destruction, or as a backup, to the No. 4 Lime Kiln or the 9A Boiler.

Black liquor of varying concentration is stored in above ground storage tanks. There are two large weak black liquor tanks and one weak black liquor storage basin (approximately 4 acres, SN-76F). In addition, there are two strong black liquor tanks and two concentrated strong black liquor holding tanks. There are also seven multiple service tanks that may store black liquor. There are also additional, smaller black liquor storage tanks.

The concentrated black liquor is burned in the 8R Recovery Furnace with the heat being used to produce steam and electricity. Flue gas from the furnace is sent through an economizer followed by an electrostatic precipitator (ESP). The ESP is used to control particulate matter emissions. The 8R Recovery Furnace was installed in 1981. It is subject to regulation under NSPS Subpart BB and NESHAP Subpart MM. The NO_x emissions from the furnace are also regulated under PSD. Salt cake from the ESP is sent to the Salt Cake Mix Tank (SN-96).

Specific Conditions

104. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #113 and #116. [Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 24 - Maximum Criteria Pollutant Emission Rates for SN-26 and SN-96

SN	Description	Pollutant	lb/hr	ton/yr
26	8R Recovery Furnace	VOC CO Pb	16.1 2,272.4 0.1	60.9 9,953.0 0.1
96	Salt Cake Mix Tank	VOC TRS	0.7 0.7	2.2 2.5

105. The permittee shall not exceed the emission rates set forth in the following table.

Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #113, #114, #116, #117, #118. [Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 25- Maximum SO₂Emission Rates for SN-26 and SN-96

Pollutant	lb/hr	ton/yr
Startup – Specification Oil Only		
SO ₂	989.1	464.4
Normal Operation – BLS with Supplemental Specification Oil Firing		
SO ₂	122.1	464.4

106. The permittee shall not exceed the emission rates set forth in the following table.

Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #113, #114, and #120. [Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 26 - Maximum NO_x Emission Rates for SN-26

Pollutant	lb/hr	ton/yr
NO _x	190.0	832.2
	110 ppmdv @ 8% O ₂	

107. The permittee shall not exceed the emission rates set forth in the following table.

Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #113, #114, #116, and #119. [§19.304 and §19.501 et seq. of Regulation #19, 40 CFR Part 52 Subpart E, 40 CFR §60.282, and 40 CFR §63.862(a)(i)(A)]

Table 27 - Maximum PM/PM₁₀ Emission Rates for SN-26

Pollutant	lb/hr	ton/yr
PM	93.0	407.3
PM ₁₀	0.044 gr/dscf @ 8% O ₂	

108. The permittee shall not exceed the emission rates set forth in the following table.

Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #113 and #124. [§19.304, §19.501 et seq., and §19.801 of Regulation #19; 40 CFR Part 52 Subpart E; and 40 CFR §60.283]

Table 28 - Maximum TRS Emission Rates for SN-26

Pollutant	lb/hr	ton/yr
TRS	12.4	54.2
	5 ppm @ 8% O ₂	

109. The permittee shall not exceed the emission rates set forth in the following table.

Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #113 #114, and #116. [Regulation No. §18.801 effective February 15, 1999, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 29- Maximum Non-Criteria Pollutant Emission Rates for SN-26 and SN-96

SN	Pollutant	lb/hr	ton/yr
26	Sulfuric Acid	7.0	26.4
	Acetone	0.5	1.8
	Acetaldehyde	0.09	0.32
	Arsenic	0.01	0.01
	Benzene	0.11	0.40
	Beryllium	0.01	0.01
	Cadmium	0.01	0.01
	Chloroform	0.01	0.03
	Chromium, Hex	0.01	0.02
	Chromium, Total	0.01	0.01
	Formaldehyde	1.30	4.90
	Hexane	0.07	0.24
	Hydrogen Chloride	9.90	37.70
	Manganese	0.01	0.04
	Methanol	8.30	31.40
	Mercury	0.01	0.02
	Methylene Chloride	0.13	0.50
	Nickel	0.01	0.03
	PAH	0.07	0.24

SN	Pollutant	lb/hr	ton/yr
	Selenium	0.01	0.01
	Styrene	0.10	0.36
	Tetrachloroethylene	0.10	0.36
	Toluene	0.05	0.19
	1,2,4-trichlorobenzene	0.19	0.70
96	Acetone	0.1	0.2
	Acetaldehyde	0.03	0.11
	Acrolein	0.01	0.01
	Benzene	0.01	0.01
	Formaldehyde	0.01	0.01
	Methanol	0.52	1.95
	Styrene	0.01	0.01
	Tetrachloroethylene	0.01	0.01
	Toluene	0.01	0.01
	1,2,4-trichlorobenzene	0.01	0.01

110. The permittee shall not cause to be discharged to the atmosphere from the 8R Recovery Furnace gases which exhibit opacity greater than 20%. The opacity shall be measured in accordance with EPA Reference Method 9 as found in 40 CFR Part 60 Appendix A. Compliance shall be demonstrated by the use of the Recovery Furnace's continuous opacity monitor. [§19.503 of Regulation #19 and 40 CFR Part 52 Subpart E]

111. The 8R Recovery Furnace (SN-26) is subject to and shall comply with all applicable provisions of §19.304 of Regulation 19, 40 CFR Part 60 Subpart BB - *Standards of Performance for Kraft Pulp and Paper Mills*, and 40 CFR Part 63 Subpart MM - *National Emission Standards for Hazardous Air Pollutants for Chemical Recovery Combustion Sources at Kraft, Sulfite, and Stand-Alone Semicomical Pulp Mills*.

A copy of Subpart BB is provided in Appendix C. A copy of Subpart MM is provided in Appendix I. Applicable provisions of both subparts include, but are not limited to, the following:

- A. The permittee shall not cause to be discharged into the atmosphere from the recovery furnace gases which contain particulate matter in excess of 0.044 gr/dscf corrected to 8 percent oxygen. [40 CFR §60.282(a)(1)(i) and 40 CFR §63.862(a)(i)(A)]
- B. The permittee shall not cause to be discharged into the atmosphere from the recovery furnace gases which exhibit 35 percent opacity or greater. [40 CFR §60.282(a)(1)(ii)]

- C. The permittee shall not cause to be discharged into the atmosphere from the recovery furnace gases which contain TRS in excess of 5 ppm by volume on a dry basis, corrected to 8 percent oxygen. [40 CFR §60.283(a)(2)]
- D. The permittee shall install, calibrate, maintain, and operate continuous monitoring systems (CEMs) to monitor and record the concentration of TRS emissions on a dry basis and the percent of oxygen by volume on a dry basis in the gases discharged into the atmosphere from the recovery furnace. This system shall be located downstream of the control device and the span shall be set at a TRS concentration of 50 ppm for the TRS continuous monitoring system and at 20 percent oxygen for the continuous oxygen monitoring system. [40 CFR §60.284(a)(2)]
- E. The permittee shall calculate and record on a daily basis 12-hour average TRS concentrations for the two consecutive periods of each operating day. Each 12-hour average shall be determined as the arithmetic mean of the appropriate 12 contiguous 1-hour average total reduced sulfur concentrations provided by each continuous monitoring system installed under paragraph (a)(2) of this section. [40 CFR §60.284(c)(1)]
- F. The permittee shall calculate and record on a daily basis 12-hour average oxygen concentrations for the two consecutive periods of each operating day for the recovery furnace. These 12-hour averages shall correspond to the 12-hour average TRS concentrations under paragraph (c)(1) of this section and shall be determined as an arithmetic mean of the appropriate 12 contiguous 1-hour average oxygen concentrations provided by each continuous monitoring system installed under paragraph (a)(2) of this section. [40 CFR §60.284(c)(2)]
- G. The permittee shall report semiannually periods of excess emissions. [40 CFR §60.284(d)]
- H. The permittee shall use as reference methods and procedures the test methods in appendix A of this part or other methods and procedures in this section, except as provided in 40 CFR §60.8(b). Acceptable alternative methods and procedures are given in paragraph (f) of this section. [40 CFR §60.285(a)]

112. In accordance with §19.304 of Regulation #19, 40 CFR §60.7(c), and 40 CFR §60.284, the permittee shall continue to quarterly submit excess emission reports to the following address:

Arkansas Department of Environmental Quality
Air Division
Attn: Air Enforcement Branch
Post Office Box 8913
Little Rock, Arkansas 72119

113. The permittee shall not fire in excess of 1.04 million tons of black liquor solids to the recovery furnace per twelve consecutive months. [§19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]

114. Specification grade oil may be used as fuel in the 8R Recovery Furnace (SN-26) during startup and to supplement BLS firing during periods deemed necessary by operations. [§19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]
115. The permittee shall maintain records which demonstrate compliance with Specific Conditions #113 and #114. These records shall be updated monthly, kept on site, provided to Department personnel upon request and may be used by the Department for enforcement purposes. A twelve month total and each month's individual data shall be submitted to the Department in accordance with General Provision #7. [§19.705 of Regulation #19 and 40 CFR Part 52 Subpart E]
116. The sulfur content of the specification grade oils received by the facility shall not exceed 1.5% by weight. [§19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]
117. The sulfur content of the fuel oil shall be verified by testing or vendors' guarantees. The permittee shall maintain a record of each fuel shipment and the associated sulfur content. This record shall be updated with each shipment, kept on site, shall be made available to Department personnel upon request and may be used by the Department for enforcement purposes. This report shall be submitted to the Department in accordance with General Provision #7. [§19.705 of Regulation #19 and 40 CFR Part 52 Subpart E]
118. Sulfur dioxide emission shall be determined through a mass balance based on incoming materials and worst-case firing of specification grade oil based on the limits in Condition #116. This mass balance shall be submitted to the Department in accordance with General Provision #7. [§19.703 of Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
119. The permittee shall annually test particulate matter emissions from the 8R Recovery Furnace (SN-26). Annual testing shall be performed in accordance with Plantwide Condition #3 and EPA Reference Method 5 as found in 40 CFR Part 60 Appendix A. During the test the permittee shall operate the source within 10 percent of the rated throughput capacity. If 90 percent of the rated throughput capacity can not be achieved, the permittee shall be limited to 11 percent above the actual tested throughput. [§19.702 of Regulation #19 and 40 CFR Part 52 Subpart E]
120. The permittee shall continue to perform annual testing of the hourly NO_x emissions rate on the 8R Recovery Furnace (SN-26) for compliance and enforcement purposes. Compliance with the NO_x limit will be based on the average of three one-hour tests. Testing shall be performed in accordance with Plantwide Condition #3 and EPA Reference Method 7E as found in 40 CFR Part 60 Appendix A. During the test, the permittee shall operate the source within 10 percent of the rated throughput capacity. If 90 percent of the rated throughput capacity cannot be achieved, the permittee shall be rated to 11 percent above the actual tested throughput. [§19.702 and §19.901 Regulation #19, and 40 CFR Part 52, Subpart E]

121. The permittee shall continue to operate and maintain opacity, TRS and O₂ continuous emission monitors at the 8R Recovery Furnace (SN-26). [§19.304 and §19.703 of Regulation #19, 40 CFR Part 52 Subpart E, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §60.284]
122. The continuous emission monitors for TRS and O₂ at the 8R Recovery Furnace shall be operated in accordance with the Department Continuous Emission Monitoring Systems Conditions (Appendix A) and the applicable Performance Standards of 40 CFR Part 60 Appendix B. [§19.703 of Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
123. All continuous monitoring data may, at the discretion of the Department, be used to determine violations of the emissions limits or conditions of this permit. [§19.703 of Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
124. The TRS concentration of gases leaving the 8R Recovery Furnace (SN-26) shall not exceed 5 ppm, measured as H₂S on a dry basis and on a 12 hour average, corrected to 8% volume oxygen. The permittee shall continue to operate and maintain CEMs which record the TRS concentration of gases leaving the 8R Recovery Furnace (SN-26). The TRS monitors shall be operated in accordance with the requirements of 40 CFR §60.284 (date of installation notwithstanding) and the Department Continuous Emission Monitoring Systems Conditions (Appendix A). [§19.304 and §19.801 of Regulation #19, 40 CFR §60.283, and 40 CFR §60.284]

SN-#27A and #27B

Smelt Dissolving Tanks

Source Description

The combusted black liquor generates molten salts that are drained from the bottom of the 8R Recovery Furnace into one of two smelt dissolving tanks (SN-27A and SN-27B) on either side of the 8R Recovery Furnace. The smelt dissolving tanks cool the molten salts in large water tanks. Each smelt dissolving tank has an independent stack that is routed through a wet scrubber. The smelt dissolving tanks are subject to NSPS Subpart BB - *National Emission Standards for Hazardous Air Pollutants from the Pulp and Paper Industry* and NESHAP Subpart MM - *National Emission Standards for Hazardous Air Pollutants for Chemical Recovery Combustion Sources at Kraft, Sulfite, and Stand-Alone Semicomical Pulp Mills*.

Specific Conditions

125. The permittee shall not exceed the emission rates set forth in the following table.

Compliance with this Specific Condition shall be demonstrated by compliance with Specific Condition #113. [Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 30 - Maximum Criteria Pollutant Emission Rates for SN-27A and B

SN	Description	Pollutant	lb/hr	ton/yr
27A	Smelt Dissolving Tank (East)	SO ₂	3.0	13.2
		VOC	1.5	5.3
		NO _X	5.4	20.4
		Pb	0.1	0.1
27B	Smelt Dissolving Tank (West)	SO ₂	3.0	13.2
		VOC	1.5	5.3
		NO _X	5.4	20.4
		Pb	0.1	0.1

126. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Condition #113 and #134. [§19.304 and §19.501 et seq. of Regulation #19, and 40 CFR Part 52 Subpart E, and 40 CFR §63.862(a)(i)(B)]

Table 31 - Maximum PM/PM₁₀ Emission Rates for SN-27A and B

SN	Description	Pollutant	lb/hr	ton/yr
27A	Smelt Dissolving Tank (East)	PM ₁₀	11.0	41.9

SN	Description	Pollutant	lb/hr	ton/yr
			0.2 lb PM/PM ₁₀ per ton of black liquor solids(TBLS)	
27B	Smelt Dissolving Tank (West)	PM PM ₁₀	11.0	41.9
			0.2 lb PM/PM ₁₀ per ton of black liquor solids (TBLS)	

127. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Condition #113 and #135. [§19.304, §19.501 et seq., and §19.801 of Regulation #19; 40 CFR Part 52 Subpart E, 40 CFR §60.283]

Table 32 - Maximum TRS Emission Rates for SN-27A and B

SN	Description	Pollutant	lb/hr	ton/yr
27A	Smelt Dissolving Tank (East)	TRS	2.4	8.8
			0.016 g TRS per kg of black liquor solids (0.033 lb/TBLS) as H ₂ S	
27B	Smelt Dissolving Tank (West)	TRS	2.4	8.8
			0.016 g TRS per ton of black liquor solids (0.033 lb/TBLS) as H ₂ S	

128. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Condition #113. [Regulation No. §18.801 effective February 15, 1999, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 33 - Maximum Non-Criteria Pollutant Emission Rates for SN-27A and B

SN	Description	Pollutant	lb/hr	ton/yr
27A	Smelt Dissolving Tank (East)	Acetone	0.1	0.1
		Acetaldehyde	0.05	0.18
		Acrolein	0.01	0.01
		Arsenic	0.01	0.01
		Benzene	0.01	0.01
		Beryllium	0.01	0.01
		Chloroform	0.01	0.01

SN	Description	Pollutant	lb/hr	ton/yr
		Chromium, Hex	0.01	0.01
		Chromium, Total	0.01	0.01
		Formaldehyde	0.43	1.64
		n-Hexane	0.01	0.01
		Manganese	0.01	0.02
		Mercury	0.01	0.01
		Methanol	0.85	3.15
		Methylene Chloride	0.01	0.01
		Naphthalene	0.05	0.16
		Selenium	0.01	0.01
		Styrene	0.01	0.02
		Tetrachloroethylene	0.01	0.01
		Toluene	0.01	0.01
		1,2,4-Trichlorobenzene	0.01	0.05
27B	Smelt Dissolving Tank (West)	Acetone	0.1	0.1
		Acetaldehyde	0.05	0.18
		Acrolein	0.01	0.01
		Arsenic	0.01	0.01
		Benzene	0.01	0.01
		Beryllium	0.01	0.01
		Chloroform	0.01	0.01
		Chromium, Hex	0.01	0.01
		Chromium, Total	0.01	0.01
		Formaldehyde	0.43	1.64
		n-Hexane	0.01	0.01
		Manganese	0.01	0.02
		Mercury	0.01	0.01
		Methanol	0.85	3.15
		Methylene Chloride	0.01	0.01
		Naphthalene	0.05	0.16
		Selenium	0.01	0.01
		Styrene	0.01	0.02
		Tetrachloroethylene	0.01	0.01
		Toluene	0.01	0.01
		1,2,4-Trichlorobenzene	0.01	0.05

129. The permittee shall not cause to be discharged from the Smelt Dissolving Tanks (SN-27A and 27B) gases which exhibit opacity greater than 20%. Compliance with this opacity limit shall be demonstrated by compliance with Specific Condition #131. The opacity shall be measured in accordance with EPA Reference Method 9 as found in 40 CFR Part 60 Appendix A. [§19.503 of Regulation #19 and 40 CFR Part 52 Subpart E]

130. The permittee shall continue to operate and maintain a monitoring device for the continuous measurement of the differential pressure drop across the scrubber. [§19.304 and §19.703 of

Regulation #19, 40 CFR Part 52 Subpart E, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §60.284]

131. The scrubbers shall be kept in good working condition at all times and shall meet the conditions shown in the following table. The scrubber liquid flow rate and the gas pressure drop across the units shall be measured daily. The results shall be kept on site and be available to the Department personnel upon request. Future compliance tests may be used to establish the daily average pressure drop and flowrate values that are contained in the permit. The pressure drop and flow rate values recorded during a compliant test event may be used as subsequent minimum values. [§19.303 of Regulation #19 and A.C.A §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 34 - Control Equipment Parameters for SN-27A and B

SN	Control Equipment	Parameter	Units	Operation Limits (minimum)
27A	scrubber	liquid flow rate, top	gal/min	35
		liquid flow rate, bottom	gal/min	100
		gas pressure drop across unit	inches, H ₂ O	5
27B	scrubber	liquid flow rate, top	gal/min	35
		liquid flow rate, bottom	gal/min	100
		gas pressure drop across unit	inches, H ₂ O	5

132. The permittee shall abide by the following alternative scenario only during emergency maintenance for scrubbers for the Smelt Dissolving Tanks (SN-27A and 27B). [§19.303 of Regulation #19 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

- Black liquor solids feed to the 8R Boiler (SN-26) shall be reduced to 3.91 MM lb/day.
- Uncontrolled emissions shall be quantified and recorded.
- Repair time must not extend beyond a 6 hour period.
- Down time of the equipment will be monitored and submitted to the Department in accordance with General Provision 8.

133. The Smelt Dissolving Tanks (SN-27A and 27B) are subject to and shall comply with all applicable provisions of §19.304 of Regulation 19, 40 CFR Part 60 Subpart BB - *Standards of*

Performance for Kraft Pulp and Paper Mills and 40 CFR Part 63 Subpart MM - National Emission Standards for Hazardous Air Pollutants for Chemical Recovery Combustion Sources at Kraft, Sulfite, and Stand-Alone Semicommercial Pulp Mills.

A copy of Subpart BB is provided in Appendix C. A copy of Subpart MM is provided in Appendix I. Applicable provisions of both subparts include, but are not limited to, the following:

- A. The permittee shall not cause to be discharged into the atmosphere from the smelt dissolving tanks any gases which contain particulate matter in excess of 0.2 lb/ton black liquor solids (dry weight). [40 CFR §60.282(a)(2) and 40 CFR §63.862(a)(i)(B)]
- B. The permittee shall not cause to be discharged into the atmosphere from the smelt dissolving tanks any gases which contain TRS in excess of 0.033 lb/ton black liquor solids as H₂S. [40 CFR §60.283(a)(4)]
- C. The permittee shall install, calibrate, maintain, and operate continuous monitoring devices for the smelt dissolving tanks because they use a scrubber emission control device. [40 CFR §60.284(b)(2)]
- D. The permittee shall report semiannually periods of excess emissions. [40 CFR §60.284(d)]
- E. The permittee shall use as reference methods and procedures the test methods in appendix A of this part or other methods and procedures in this section, except as provided in 40 CFR §60.8(b). Acceptable alternative methods and procedures are given in paragraph (f) of this section. [40 CFR §60.285(a)]

134. The permittee shall annually test particulate matter emissions from the Smelt Dissolving Tanks (SN-27A and 27B). Testing shall be performed in accordance with Plantwide Condition #3 and EPA Reference Method 5 as found in 40 CFR Part 60 Appendix A. During the test the permittee shall operate the sources within 10 percent of the rated throughput capacity. If 90 percent of the rated throughput capacity cannot be achieved, the permittee shall be limited to 11 percent above the actual tested throughput. [§19.702 of Regulation #19 and 40 CFR Part 52 Subpart E]

135. The TRS concentration of gases leaving the Smelt Dissolving Tanks (SN-27A and 27B) shall not exceed 0.0168 g TRS per kg of black liquor solids. The permittee shall conduct annual compliance testing of TRS emissions from the Smelt Dissolving Tanks (SN-27A and 27B). Data reduction shall be performed as set forth in 40 CFR 60.8. Testing shall be performed in accordance with Plantwide Condition #3 and EPA Reference Method 16 as found in 40 CFR Part 60 Appendix A. During the test the permittee shall operate the source within 10 percent of the rated throughput capacity. If 90 percent of the rated throughput capacity cannot be achieved, the permittee shall be limited to 11 percent above the actual tested throughput. [§19.702 and §19.801 et seq of Regulation #19, and 40 CFR Part 52 Subpart E]

SN-#25

No. 4 Lime Kiln

Source Description

The lime kiln heats calcium carbonate (lime mud) to form calcium oxide (lime product). Fuels used in the lime kiln include specification grade oil and natural gas. Emissions from the lime kiln are controlled by a wet scrubber. Non-condensable gases (NCGs) from processes are routed to the lime kiln for thermal destruction. The lime kiln is subject to NSPS Subpart BB and NESHAP Subpart MM. The maximum firing rate of the lime kiln is 150 million Btu per hour.

NCGs from several pulp mill sources are collected and routed to the lime kiln for combustion. The evaporator vents, digester vents and blow tank condensers are all part of the NCG system at the Crossett Paper Operations.

Reburnt lime product from the lime kiln is conveyed to a lime bin where it is fed into the slaker. The lime handling and storage system includes elevators, conveyors and lime bins. Conveyors transport lime from the storage silos to the slakers. Fresh lime is added to the system from delivery trucks by pneumatic conveyance to the two lime silos.

Specific Conditions

136. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #144 and #145. [Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 35 - Maximum Criteria Pollutant Emission Rates for SN-25

Pollutant	lb/hr	ton/yr
SO ₂	14.3	54.1
VOC	7.2	27.2
CO	11.0	41.9
NO _X	66.3	252.1
Pb	0.1	0.1

137. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Condition #144 and #147. [§19.304 and §19.501 et seq. of Regulation #19, 40 CFR Part 52 Subpart E, and 40 CFR §63.862(a)(i)(C)]

Table 36 - Maximum PM/PM₁₀ Emission Rates for SN-25

Pollutant	lb/hr	ton/yr
Natural gas or natural gas and specification oil		
PM	28.3	124.0
PM ₁₀	0.064 gr/dscf corrected to 10% oxygen	

138. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #146 and #152. [§19.304, §19.501 et seq., §19.801 of Regulation #19; CFR Part 52 Subpart E; and 40 CFR §60.283]

Table 37 - Maximum TRS Emission Rates for SN-25

Pollutant	lb/hr	ton/yr
Natural gas or natural gas and specification oil firing.		
TRS	2.2	9.6
	8 ppm measured as H ₂ S on a dry basis, on a 12-hour average, corrected to 10% O ₂	

139. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Condition #144. [Regulation No. §18.801 effective February 15, 1999, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 38 - Maximum Non-Criteria Pollutant Emission Rates for SN-25

Pollutant	lb/hr	ton/yr
Sulfuric Acid	0.7	2.5
Acetone	0.1	0.1
Acetaldehyde	0.17	0.64
Acrolein	0.01	0.01
Arsenic	0.01	0.01
Benzene	0.01	0.04
Beryllium	0.01	0.01
Cadmium	0.01	0.01
Chloroform	0.01	0.01
Chromium, Hex	0.01	0.01
Chromium, Total	0.01	0.03
Cobalt	0.01	0.01
Formaldehyde	0.17	0.64

Pollutant	lb/hr	ton/yr
Hexane	0.01	0.01
Hydrogen Chloride	0.01	0.03
Manganese	0.01	0.04
Methanol	0.37	1.39
Mercury	0.01	0.01
Methylene Chloride	0.01	0.01
Naphthalene	0.40	1.50
Nickel	0.01	0.02
Phenol	0.01	0.03
Selenium	0.01	0.01
Styrene	0.01	0.01
Tetrachloroethylene	0.01	0.03
Toluene	0.01	0.01

140. The permittee shall not cause to be discharged to the atmosphere gases which exhibit opacity greater than 20%. Compliance with this opacity limit shall be demonstrated by compliance with Specific Condition #141. The opacity shall be measured in accordance with EPA Reference Method 9 as found in 40 CFR Part 60 Appendix A. [§19.503 of Regulation #19 and 40 CFR Part 52 Subpart E]

141. The scrubbers shall be kept in good working condition at all times and shall meet the conditions shown in the following table. The scrubber liquid flow rate and the gas pressure drop across the units shall be measured daily. The results shall be kept on site and be available to the Department personnel upon request. [§19.303 of Regulation #19 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 39 – Control Equipment Parameters for SN-25

SN	Control Equipment	Parameter	Units	Operation Limits (minimum)
25	scrubber	liquid flow rate	gal/min	500
		gas pressure drop across unit	inches, H ₂ O	25

142. The No. 4 Lime Kiln (SN-25) is subject to and shall comply with all applicable provisions of §19.304 of Regulation 19, 40 CFR Part 60 Subpart BB - *Standards of Performance for Kraft Pulp and Paper Mills* and 40 CFR Part 63 Subpart MM - *National Emission Standards for Hazardous Air Pollutants for Chemical Recovery Combustion Sources at Kraft, Sulfite, and Stand-Alone Semicomical Pulp Mills*.

A copy of Subpart BB is provided in Appendix C. A copy of Subpart MM is provided in Appendix I. Applicable provisions of both subparts include, but are not limited to, the following:

- A. The permittee shall not cause to be discharged into the atmosphere from the lime kiln any gases which contain particulate matter in excess of 0.064 gr/dscf corrected to 10 percent oxygen, when gaseous fossil fuel is burned. [40 CFR §63.862(a)(i)(C)]
- B. The permittee shall not cause to be discharged into the atmosphere from the lime kiln gases which contain TRS in excess of 8 ppm by volume on a dry basis, corrected to 10 percent oxygen. [40 CFR §60.283(a)(5)]
- C. The permittee shall install, calibrate, maintain, and operate continuous monitoring systems to monitor and record the concentration of TRS emissions on a dry basis and the percent of oxygen by volume on a dry basis in the gases discharged into the atmosphere from the lime kiln. This system shall be located downstream of the control device and the span shall be set at a TRS concentration of 30 ppm for the TRS continuous monitoring system and at 20 percent oxygen for the continuous oxygen monitoring system. [40 CFR §60.284(a)(2)]
- D. The permittee shall install, calibrate, maintain, and operate continuous monitoring devices (CEMs) for the lime kiln because it uses a scrubber emission control device. [40 CFR §60.284(b)(2)]
- E. The permittee shall calculate and record on a daily basis 12-hour average TRS concentrations for the two consecutive periods of each operating day. Each 12-hour average shall be determined as the arithmetic mean of the appropriate 12 contiguous 1-hour average total reduced sulfur concentrations provided by each continuous monitoring system installed under paragraph (a)(2) of this section. [40 CFR §60.284(c)(1)]
- F. The permittee shall calculate and record on a daily basis 12-hour average oxygen concentrations for the two consecutive periods of each operating day for the lime kiln. These 12-hour averages shall correspond to the 12-hour average TRS concentrations under paragraph (c)(1) of this section and shall be determined as an arithmetic mean of the appropriate 12 contiguous 1-hour average oxygen concentrations provided by each continuous monitoring system installed under paragraph (a)(2) of this section. [40 CFR §60.284(c)(2)]
- G. The permittee shall report semiannually periods of excess emissions. [40 CFR §60.284(d)]
- H. The permittee shall use as reference methods and procedures the test methods in appendix A of this part or other methods and procedures in this section, except as provided in 40 CFR §60.8(b). Acceptable alternative methods and procedures are given in paragraph (f) of this section. [40 CFR §60.285(a)]

143. The permittee shall continue to quarterly submit excess emission reports to the following address:

Arkansas Department of Environmental Quality
Air Division
Attn: Air Enforcement Branch
Post Office Box 8913
Little Rock, Arkansas 72119

[§19.304 of Regulation #19, 40 CFR §60.7(c), and 40 CFR §60.284]

144. Either natural gas, specification oil, or a combination of natural gas and specification oil may be used as fuel in the No. 4 Lime Kiln. [§19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]
145. The permittee may not use specification grade oil at this source unless it contains no more than 1.5% sulfur by weight. [§19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]
146. The sulfur content of the specification grade oil shall be verified by testing or vendors' guarantees. The permittee shall maintain a record of each fuel shipment and the associated sulfur content. This record shall be updated with each shipment, kept on site, shall be made available to Department personnel upon request and may be used by the Department for enforcement purposes. [§19.705 of Regulation #19 and 40 CFR Part 52 Subpart E]
147. The permittee shall annually test particulate matter emissions from the No. 4 Lime Kiln (SN-25). Testing shall be performed in accordance with Plantwide Condition #3 and EPA Reference Method 5 as found in 40 CFR Part 60 Appendix A. During the test the permittee shall operate the source within 10 percent of the rated throughput capacity. If 90 percent of the rated throughput capacity can not be achieved, the permittee shall be limited to 11 percent above the actual tested throughput. [§19.702 of Regulation #19 and 40 CFR Part 52 Subpart E]
148. The permittee shall continue to operate and maintain for the No. 4 Lime Kiln a continuous monitoring system to monitor and record TRS concentration on a dry basis, percent of O₂ by volume on a dry basis, pressure drop across the scrubber and liquid supply pressure. [§19.304 and §19.703 of Regulation #19, 40 CFR Part 52 Subpart E, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §60.284]
149. The continuous emission monitors at the No. 4 Lime Kiln shall be operated in accordance with the Department Continuous Emission Monitoring Systems Conditions (Appendix A) and the applicable Performance Standards of 40 CFR Part 60 Appendix B. [§19.703 of Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
150. All continuous monitoring data may, at the discretion of the Department, be used to determine violations of the emissions limits or conditions of this permit. [§19.703 of Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
151. The permittee may use the No. 4 Lime Kiln (SN-25) as an alternate incinerator for NCGs and SOGs during periods when the Incinerator (SN-83) or its associated control equipment is inoperative. [§19.304 of Regulation #19 and 40 CFR §63.443(d)(4)]

152. The TRS concentration of gases leaving the No. 4 Lime Kiln (SN-25) shall not exceed 8 ppm, measured as H₂S on a dry basis and on a 12 hour average, corrected to 10% volume oxygen. The permittee shall continue to operate and maintain CEMs which record the TRS concentration of gases leaving the No. 4 Lime Kiln (SN-25). The TRS monitors shall be operated in accordance with the requirements of 40 CFR §60.284 (date of installation notwithstanding) and the Department Continuous Emission Monitoring Systems Conditions (Appendix A). [§19.304, §19.501 et seq., and §19.801 et seq of Regulation #19; 40 CFR §60.283; and 40 CFR §60.284]

SN-#55F, 56F, SN-94, SN-95, SN-98, SN-99, and SN-100

Slaker Vents, Green Liquor Clarifier, White Liquor Clarifier, “A” and “B” Side Causticizers, and White Liquor Storage Tanks

Source Description

Causticizing vents contributions are also included with the slaker emission estimates. The causticizing operation reacts molten inorganic salts from the smelt dissolving tanks with weak wash to form green liquor. Undissolved particles in the green liquor are allowed to settle out in the Green Liquor Clarifier (SN-94).

The mixing of green liquor with lime to form a slurry is termed slaking. The slaking process is designed to combine green liquor and burnt lime (CaO). This mixing, which involves an exothermic chemical reaction, takes place in one of two Slakers. The emissions are exhausted through two adjacent Slaker Vents, SN-55 and SN-56. After being mixed with lime in the slakers the green liquor goes through a series of causticizing tanks. These causticizers provide the residence time necessary for the lime to react with the green liquor and form white liquor.

White liquor is used as the main cooking liquor in the digester. The white liquor is allowed to settle in the White Liquor Clarifier (SN-95).

The facility also has four white liquor storage tanks (SN-100) of approximately 1 million (3) and 5 million (1) gallons.

Specific Conditions

153. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition is demonstrated by compliance with Specific Condition #90.
[Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 40– Maximum Criteria Pollutant Emission Rates for SN-55F, 56F, 94, 95, 98, 99, and 100

SN	Description	Pollutant	lb/hr	ton/yr
55F	Lime Slaker Vent #1	VOC	1.7	6.3
56F	Lime Slaker Vent #2	VOC	1.7	6.3
94	Green Liquor Clarifier	VOC	2.0	7.6
95	White Liquor Clarifier	VOC	0.6	2.1
98	“A” Side Causticizers	VOC TRS	0.1 0.4	0.2 1.2
99	“B” Side Causticizers	VOC TRS	0.1 0.4	0.3 1.2

SN	Description	Pollutant	lb/hr	ton/yr
100	White Liquor Storage Tanks (4 total)	VOC	0.6	2.2

154. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition is demonstrated by compliance with Specific Condition #90. [Regulation No. §18.801 effective February 15, 1999, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 41—Maximum Non-Criteria Pollutant Emission Rates for SN-55F, 56F, 94, 95, 98, 99, and 100

SN	Description	Pollutant	lb/hr	ton/yr
55F	Lime Slaker Vent #1	PM	0.5	1.8
		Acetone	0.1	0.4
		Acetaldehyde	0.81	3.10
		Benzene	0.01	0.01
		Methanol	0.81	3.10
		Styrene	0.02	0.07
		Toluene	0.01	0.02
56F	Lime Slaker Vent #2	PM	0.5	1.8
		Acetone	0.1	0.4
		Acetaldehyde	0.81	3.10
		Benzene	0.01	0.01
		Methanol	0.81	3.10
		Styrene	0.02	0.07
		Toluene	0.01	0.02
94	Green Liquor Clarifier	Acetone	0.1	0.1
		Acetaldehyde	0.01	0.01
		Benzene	0.01	0.01
		Chloroform	0.01	0.01
		Hexane	0.01	0.01
		Methanol	0.04	0.13
		Tetrachloroethylene	0.01	0.01
95	White Liquor Clarifier	Acetone	0.1	0.1
		Benzene	0.01	0.01
		Formaldehyde	0.07	0.26
		Methanol	0.45	1.73
		Styrene	0.01	0.01
98	“A” Side Causticizers	Acetone	0.1	0.1
		Acetaldehyde	0.02	0.06
		Benzene	0.01	0.01
		Methanol	0.01	0.04

SN	Description	Pollutant	lb/hr	ton/yr
		Styrene	0.01	0.01
99	"B" Side Causticizers	Acetone	0.1	0.1
		Acetaldehyde	0.02	0.06
		Benzene	0.01	0.01
		Methanol	0.01	0.04
		Styrene	0.01	0.01
100	White Liquor Storage Tanks (4 total)	Acetone	0.1	0.1
		Benzene	0.01	0.01
		Formaldehyde	0.07	0.26
		Methanol	0.50	1.80
		Styrene	0.01	0.10

SN-#62 and #63

Fine Paper Machines No. 1 and No. 2

Source Description

Communication paper is made on the two fine paper machines (No. 1 and 2 Fine Paper Machines). Each machine includes its own stock preparation, head box, wire section, press section, dryer sections, coater section, calendar stacks, reel and drum winder. The fine paper machines produce a variety of products, including but not limited to, bond paper, envelope, tablet and copier paper. Emissions from Fine Paper Machine No. 1 (SN-62) occur primarily from the fourdrinier vacuum pump exhausts, press section vents, dryer exhaust and coating section. Fine Paper Machine No. 2 (SN-63) is nearly identical to Fine Paper Machine No. 1.

Specific Conditions

155. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Condition #157. [Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 42 – Maximum Criteria Pollutant Emission Rates for SN-62 and 63

SN	Description	Pollutant	lb/hr	ton/yr
62	Fine Paper Machine No. 1	VOC	2.1	8.9
63	Fine Paper Machine No. 2	VOC	2.3	10.0

156. The permittee estimates the emission rates set forth in the following table will not be exceeded. The pollutant emission rates are effectively limited by Specific Condition #157. [Regulation No. §18.801 effective February 15, 1999, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 43 – Maximum Non-Criteria Pollutant Emission Rates for SN-62 and 63

SN	Description	Pollutant	lb/hr	ton/yr
62	Fine Paper Machine No. 1	Acetone	0.8	3.3
		Acetaldehyde	1.00	4.38
		Acrolein	0.04	0.17
		1,2 Dichloroethylene	0.10	0.40
		Methanol	0.86	3.75
		Tetrachloroethylene	0.05	0.22
		1,2,4-Trichlorobenzene	0.04	0.15

SN	Description	Pollutant	lb/hr	ton/yr
63	Fine Paper Machine No. 2	Acetone	0.9	3.9
		Acetaldehyde	1.10	4.82
		Acrolein	0.05	0.19
		1,2 Dichloroethylene	0.10	0.44
		Methanol	0.94	4.12
		Tetrachloroethylene	0.06	0.25
		1,2,4-Trichlorobenzene	0.04	0.17

157. The permittee shall not produce in excess of 1050 machine dried tons of paper per day from the Fine Paper Machines No. 1 and No. 2 combined, 30 day rolling average. [§19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]

158. The permittee shall maintain records which demonstrate compliance with the limits listed in Specific Condition #157. The records shall be updated on a monthly basis. These records shall be kept on site, provided to Department personnel upon request and may be used by the Department for enforcement purposes. A twelve month total and each individual month's data shall be submitted in accordance with General Provision #7. [§19.705 of Regulation #19 and 40 CFR Part 52 Subpart E]

SN-#64 and #65

Board Machine No. 3

Source Description

The Board Machine No. 3 produces bleached board using the wet end, dry end and broke systems. The board is used primarily as cup stock and liner board for boxes. Emissions from Board Machine No. 3 occur primarily from the vacuum pump exhausts, press section vents, dryer exhausts, coating section and combustion sources in the coating section. Emissions from the wet end, dry end and coating operations of Board Machine No. 3 are bubbled together (SN-64). There are sixteen gas burners (SN-65) with a total heating value of 12.3 million Btu per hour located on the board machine following the coating operations.

Specific Conditions

159. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #162 and #163. [Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 44 – Maximum Criteria Pollutant Emission Rates for SN-64 and 65

SN	Description	Pollutant	lb/hr	ton/yr
64	Board Machine No. 3	VOC	3.6	15.5
65	Board Machine No. 3 Burners	PM ₁₀	0.2	0.5
		SO ₂	0.1	0.1
		VOC	0.1	0.4
		CO	1.3	5.4
		NO _X	1.5	6.5

160. The permittee estimates the emission rates set forth in the following table will not be exceeded. The pollutant emission rates are effectively limited by Specific Conditions #162 and #163. [Regulation No. §18.801 effective February 15, 1999, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 45 – Maximum Non-Criteria Pollutant Emission Rates for SN-64 and 65

SN	Description	Pollutant	lb/hr	ton/yr
64	Board Machine No. 3	Acetone	1.3	5.6
		Acetaldehyde	1.70	7.45
		Acrolein	0.07	0.29
		1,2 Dichloroethylene	0.16	0.68
		Methanol	1.46	6.37
		Tetrachloroethylene	0.09	0.38

SN	Description	Pollutant	lb/hr	ton/yr
		1,2,4-Trichlorobenzene	0.06	0.25
65	Board Machine No. 3 Burners	PM	0.2	0.5
		Arsenic	0.01	0.01
		Benzene	0.01	0.01
		Cadmium	0.01	0.01
		Chromium, total	0.01	0.01
		Cobalt	0.01	0.01
		Formaldehyde	0.01	0.02
		Hexane	0.03	0.12
		Manganese	0.01	0.01
		Mercury	0.01	0.01
		Naphthalene	0.01	0.01
		Nickel	0.01	0.01
		Toluene	0.01	0.01

161. The permittee shall not cause to be discharged to the atmosphere from the Board Machine No. 3 Burners (SN-65) gases which exhibit opacity greater than 5%. The opacity shall be measured in accordance with EPA Reference Method 9 as found in 40 CFR Part 60 Appendix A. Compliance with this opacity limit shall be demonstrated by the use of natural gas. [§18.501 of Regulation #18 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-11]

162. Natural gas shall be the only fuel used for the Board Machine No. 3 Burners (SN-65). [§18.1004 of Regulation #18, §19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]

163. The permittee shall not produce in excess of 850 machine dried tons of paper per day, 30 day rolling average, from the Board Machine No. 3. [§18.1004 of Regulation #18, §19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]

164. The permittee shall maintain records which demonstrate compliance with the limits listed in Specific Condition #163. The records shall be updated on a monthly basis. These records shall be kept on site, provided to Department personnel upon request and may be used by the Department for enforcement purposes. A twelve month total and each individual month's data shall be submitted in accordance with General Provision #7. [§18.1004 of Regulation #18, §19.705 of Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Tissue Machines No. 4 through No. 8

Source Description

There are currently five tissue machines (Tissue Machines No. 4 through No. 8) at the Georgia-Pacific Crossett Paper Mill which manufacture tissue for conversion into bathroom tissue, towel, facial tissues, and napkins. In addition, the Mill also has an additional three machines that produce communications papers and bleached paperboard.

Pulp is supplied to the five tissue machines in varying proportions depending upon the desired product. The tissue papermaking process involves stock preparation, wet end - fourdrinier, press sections mix tanks and blend tanks, dry end - dryer sections with air hoods, reel and winder, and broke system finishing operations. Pulp stock is made into paper by forming a sheet on a continuously moving wire screen (the fourdrinier); removing water by gravity, vacuum and pressing, and drying with heated rolls. The water removed from the stock is called white water. The white water is collected for reuse in stock preparation or sewer as wastewater. Scrubbers control particulate from the reel sections of the No. 4 through No. 8 Tissue machines as well as the Rewinder of the No. 6 Tissue Machine.

Tissue converting includes the operations involved in converting large parent rolls of tissue from the tissue machines into finished products. This includes rewinding into smaller sized rolls, folding, printing, cutting, packaging and shipping.

Dust in the tissue converting area is controlled using filters with the exhaust air being recycled back into the building. Trim from the converting operations is sent to the repulpers by pneumatic systems. A cyclone removes the trim from the air stream prior to discharging the air through the roof. Minimal amounts of VOCs may be emitted from the glue that is used to seal boxes, the lubricants used on the machines and the dye used for printing patterns on the material.

SN-#46, #66 and #67

Tissue Machine No. 4

Emissions from the wet end and dry end of Tissue Machine No. 4 (SN-66) have been bubbled together. The Tissue Machine No. 4 Burners (SN-46) combust natural gas at a total heating rate of 20 million Btu per hour. Tissue Machine No. 4 Dust System (SN-67) uses a 20,000 cfm scrubber to control particulate matter emissions.

Specific Conditions

165. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #168 and #169. [Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 46 – Maximum Criteria Pollutant Emission Rates for SN-46, 66, and 67

SN	Description	Pollutant	lb/hr	ton/yr
46	Tissue Machine No. 4 Burners	PM ₁₀	0.2	0.8
		SO ₂	0.1	0.1
		VOC	1.2	5.0
		CO	4.3	18.8
		NO _x	2.4	10.6
		Pb	0.1	0.1
66	Tissue Machine No. 4	VOC	0.9	3.6
		TRS	0.1	0.2
67	Tissue Machine No. 4 Dust System	PM ₁₀	0.3	1.1

166. The permittee estimates the emission rates set forth in the following table will not be exceeded. The pollutant emission rates are effectively limited by Specific Conditions #168 and #169. [Regulation No. §18.801 effective February 15, 1999, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 47 – Maximum Non-Criteria Pollutant Emission Rates for SN-46, 66, and 67

SN	Description	Pollutant	lb/hr	ton/yr
46	Tissue Machine No. 4 Burners	PM	0.2	0.8
		Arsenic	0.01	0.01
		Benzene	0.01	0.01
		Cadmium	0.01	0.01
		Chromium, total	0.01	0.01
		Cobalt	0.01	0.01
		Formaldehyde	0.01	0.01

SN	Description	Pollutant	lb/hr	ton/yr
		Hexane	0.05	0.19
		Manganese	0.01	0.01
		Mercury	0.01	0.01
		Naphthalene	0.01	0.01
		Nickel	0.01	0.01
		Toluene	0.01	0.01
66	Tissue Machine No. 4	Acetone	0.3	1.2
		Acetaldehyde	0.35	1.52
		Acrolein	0.02	0.06
		1,2 Dichloroethylene	0.04	0.14
		Formaldehyde	0.05	0.21
		Methanol	0.35	1.53
		Methylene Chloride	0.03	0.12
		Tetrachloroethylene	0.02	0.08
		1,2,4-Trichlorobenzene	0.02	0.06
67	Tissue Machine No. 4 Dust System	PM	0.3	1.1

167. The permittee shall not cause to be discharged to the atmosphere from SN-46 gases which exhibit opacity greater than 5%. Compliance with this opacity limit shall be demonstrated by the use of natural gas.

The permittee shall not cause to be discharged to the atmosphere from SN-67 gases which exhibit opacity greater than 5%. Compliance with this opacity limit shall be demonstrated by compliance with Specific Condition #171.

The opacity shall be measured in accordance with EPA Reference Method 9 as found in 40 CFR Appendix A. [§18.501 of Regulation #18 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

168. Natural gas shall be the only fuel used for Tissue Machine No. 4 Burners (SN-46). [§18.1004 of Regulation #18, §19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]

169. The permittee shall not produce in excess of 173 machine dried tons of paper per day, 30 day rolling average, from the Tissue Machine No. 4. [§18.1004 of Regulation #18, §19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6,

170. The permittee shall maintain records which demonstrate compliance with the limits listed in Specific Condition #169. The records shall be updated on a monthly basis. These records shall be kept on site, provided to Department personnel upon request and may be used by the Department for enforcement purposes. A twelve month total and each individual month's data shall be submitted in accordance with General Provision #7. [§18.1004 of Regulation #18,

§19.705 of Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

171. The scrubber shall be kept in good working condition at all times and shall meet the conditions shown in the following table. The scrubber liquid flow rate shall be measured daily. The results shall be kept on site and be available to Department personnel upon request. [§18.1104 of Regulation #18, §19.303 of Regulation #19, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 48 – Control Equipment Parameters for SN-67

SN	Control Equipment	Parameter	Units	Minimum Operating Limits
67	scrubber	liquid flow rate	gal/min	70

172. The permittee may, in the event of emergency maintenance on SN-67 (Tissue No. 4 Dust System), shut down the dust collection system and contain the tissue dust within the building during the continued operation of the paper machine. Good housekeeping practices shall be used to control tissue dust and prevent visible emissions to the atmosphere. In the event that repairs on a scrubber extend beyond 12 hours, then a 6-minute observation for visible emissions shall be conducted once per 12-hour shift. The observation shall be a yes/no check and shall be conducted at the outside corners of the affected Tissue Machine building. If visible tissue dust emissions are detected for more than 6 minutes per hour, then corrective action shall be taken to reduce emissions and document that visible emissions do not appear after corrective action is taken. [§19.303 of Regulation #19 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

SN-#47, #54 and #68

Tissue Machine No. 5

Emissions from the wet end and dry end of Tissue Machine No. 5 (SN-68) have been bubbled together. The Tissue Machine No. 5 Burners (SN-47) are rated at 21 million Btu per hour. The burners are low NO_x burners. The Tissue Machine No. 5 Dust System (SN-54) uses a 20,000 cfm scrubber to control particulate matter emissions. The No. 5 Tissue Machine Burners (SN-47) under went a BACT review in Air Permit 597-AOP-R0. Clean fuel, good combustion practice, and low NO_x burners were chosen as BACT at the time.

Specific Conditions

173. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Condition #180 and #181. [Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 49 – Maximum Criteria Pollutant Emission Rates for SN-47, SN-54, and 68

SN	Description	Pollutant	lb/hr	ton/yr
47	Tissue Machine No. 5 Burners	PM ₁₀	0.2	0.9
		NO _x	1.2	5.0
		Pb	0.1	0.1
54	Tissue Machine No. 5 Dust System	PM ₁₀	0.3	1.1
68	Tissue Machine No. 5	VOC	0.5	2.0
		TRS	0.1	0.2

174. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #180, #181, and #183. [§19.501 et seq. and §19.901 of Regulation #19, and 40 CFR Part 52 Subpart E]

Table 50–BACT Emission Rates for SN-47

SN	Description	Pollutant	lb/hr	ton/yr
47	Tissue Machine No. 5 Burners	PM	0.4	1.5
			PM ₁₀	0.0164 lb/MMBtu
		SO ₂	0.1	0.1
			0.0007 lb/MMBtu	

SN	Description	Pollutant	lb/hr	ton/yr
		VOC	1.2	5.2
			0.0564 lb/MMBtu	
		CO	4.5	19.7
			0.2142 lb/MMBtu	
		NO _x	2.0	8.4
			0.0913 lb/MMBtu	

175. The permittee estimates the emission rates set forth in the following table will not be exceeded. The pollutant emission rates are effectively limited by Specific Conditions #180 and #181. [Regulation No. §18.801 effective February 15, 1999, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 51 – Maximum Non-Criteria Pollutant Emission Rates for SN-46, 47, 66, and 67

SN	Description	Pollutant	lb/hr	ton/yr
47	Tissue Machine No. 5 Burners	Arsenic	0.01	0.01
		Benzene	0.01	0.01
		Cadmium	0.01	0.01
		Chromium, total	0.01	0.01
		Cobalt	0.01	0.01
		Formaldehyde	0.01	0.01
		Hexane	0.05	0.20
		Manganese	0.01	0.01
		Mercury	0.01	0.01
		Naphthalene	0.01	0.01
		Nickel	0.01	0.01
		Toluene	0.01	0.01
54	Tissue Machine No. 5 Dust System	PM	0.3	1.1
68	Tissue Machine No. 5	Acetone	0.2	0.7
		Acetaldehyde	0.20	0.85
		Acrolein	0.01	0.04
		1,2 Dichloroethylene	0.02	0.08
		Formaldehyde	0.03	0.12
		Methanol	0.20	0.86
		Methylene Chloride	0.02	0.08
		Tetrachloroethylene	0.01	0.05
		1,2,4-Trichlorobenzene	0.01	0.03

176. The permittee shall not cause to be discharged to the atmosphere from SN-54 gases which exhibit opacity greater than 5%. Compliance with this opacity limit shall be demonstrated by compliance with Specific Condition #177. The opacity shall be measured in accordance with EPA Reference Method 9 as found in 40 CFR Part 60 Appendix A. [§18.501 of Regulation #18 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

177. The scrubber shall be kept in good working condition at all times and shall meet the conditions shown in the following table. The scrubber liquid flow rate and the gas pressure drop across the unit shall be measured daily. The results shall be kept on site and be available to the Department personnel upon request. [§18.1104 of Regulation #18 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 52 – Control Equipment Parameters for SN-54

SN	Control Equipment	Parameter	Units	Minimum Operating Limits
54	scrubber	liquid flow rate	gal/min	70
		gas pressure drop across unit	inches, H ₂ O	8

178. The permittee may, in the event of emergency maintenance on SN-54, shut down the dust collection system and contain the tissue dust within the building during the continued operation of the paper machine. Good housekeeping practices shall be used to control tissue dust and prevent visible emissions to the atmosphere. In the event that repairs on a scrubber extend beyond 12 hours, then a 6-minute observation for visible emissions shall be conducted once per 12-hour shift. The observation shall be a yes/no check and shall be conducted at the outside corners of the affected Tissue Machine building. If visible tissue dust emissions are detected for more than 6 minutes per hour, then corrective action shall be taken to reduce emissions and document that visible emissions do not appear after corrective action is taken. [§19.303 of Regulation #19 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

179. The permittee shall not cause to be discharged to the atmosphere from SN-47 gases which exhibit opacity greater than 5%. The opacity shall be measured in accordance with EPA Reference Method 9 as found in 40 CFR Part 60 Appendix A. Compliance with this opacity limit shall be demonstrated by the use of natural gas. [§19.503 and §19.901 et seq of Regulation #19, and 40 CFR Part 52 Subpart E]

180. Natural gas shall be the only fuel used for the Tissue Machine No. 5 Burners (SN-47). [§19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]

181. The permittee shall not produce in excess of 97 machine dried tons of paper per day, 30 day rolling average, from the Tissue Machine No. 5. [§18.1004 of Regulation #18, §19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]

182. The permittee shall maintain records which demonstrate compliance with the limits listed in Specific Condition #181. The records shall be updated on a monthly basis. These records shall be kept on site, provided to Department personnel upon request and may be used by the

Department for enforcement purposes. A twelve month total and each individual month's data shall be submitted in accordance with General Provision #7. [§18.1004 of Regulation #18, §19.705 of Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311,

183. The permittee shall test SN-47 for CO and NO_X to verify compliance with the BACT emission limits specified in Specific Condition #174 initially and once every three years thereafter. The first test shall be conducted within 60 days of achieving the maximum production rate, but in no event later than 180 days after initial start-up of the modified permitted source. Testing shall be performed in accordance with Plantwide Condition #3. Testing for CO and NO_X shall also be performed in accordance with EPA Reference Methods 10 and 7E respectively. During the test the permittee shall operate the source within 10 percent of the rated throughput capacity. If 90 percent of the rated throughput capacity can not be achieved, the permittee shall be limited to 11 percent above the actual tested throughput. [§19.702 and §19.901 et seq of Regulation #19, and 40 CFR Part 52 Subpart E]

SN-#48, #51, #52 and #69

Tissue Machine No. 6

Emissions from the wet end and dry end of Tissue Machine No. 6 (SN-69) have been bubbled together. The Tissue Machine No. 6 Burners (SN-48) are rated at 58.4 million Btu per hour. The burners are low NO_x burners. Tissue Machine No. 6 Dust System (SN-52) uses a 47,000 cfm scrubber to control particulate matter emissions. A 47,000 cfm scrubber is used to control particulate emissions from the rewinder (SN-51) near Tissue Machine No. 6. The No. 6 Tissue Machine Burners (SN-48) under went a BACT review in Air Permit 597-AOP-R0. Clean fuel, good combustion practice, and low NO_x burners were chosen as BACT at the time.

Specific Conditions

184. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #192 and #194. [Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 53– Maximum Criteria Pollutant Emission Rates for SN-48, SN-51, 52, and 69

SN	Description	Pollutant	lb/hr	ton/yr
48	Tissue Machine No. 6 Burners (58.4 MMBtu/hr)	PM ₁₀ NO _x	0.6 3.2	2.3 13.8
51	Tissue Machine No. 6 Rewinder	PM ₁₀	0.5	1.9
52	Tissue Machine No. 6 Dust System	PM ₁₀	0.5	1.9
69	Tissue Machine No. 6	VOC TRS	1.3 0.1	5.5 0.3

185. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #193. [§19.501 et seq. and §19.901 of Regulation #19, and 40 CFR Part 52 Subpart E]

Table 54 – BACT Emission Rates for SN-48

SN	Description	Pollutant	lb/hr	ton/yr
48	Tissue Machine No. 6 Burners	PM	1.0	4.2
		PM ₁₀	0.0164 lb/MMBtu	

SN	Description	Pollutant	lb/hr	ton/yr
	(58.4 MMBtu/hr)	SO ₂	0.1	0.2
			0.0007 lb/MMBtu	
		VOC	1.2	4.9
			0.0192 lb/MMBtu	
		CO	6.7	29.1
			0.1139 lb/MMBtu	
		NO _x	5.4	23.5
			0.0913 lb/MMBtu	

186. The permittee estimates the emission rates set forth in the following table will not be exceeded. The pollutant emission rates are effectively limited by Specific Conditions #192 and #194. [Regulation No. §18.801 effective February 15, 1999, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 55 – Maximum Non-Criteria Pollutant Emission Rates for SN-48, 51, 52, and 69

SN	Description	Pollutant	lb/hr	ton/yr
48	Tissue Machine No. 6 Burners	Arsenic	0.01	0.01
		Benzene	0.01	0.01
		Cadmium	0.01	0.01
		Chromium, total	0.01	0.01
		Cobalt	0.01	0.01
		Formaldehyde	0.01	0.01
		Hexane	0.05	0.20
		Manganese	0.01	0.01
		Mercury	0.01	0.01
		Naphthalene	0.01	0.01
		Nickel	0.01	0.01
		Toluene	0.01	0.01
51	Tissue Machine No. 6 Rewinder	PM	0.5	1.9
52	Tissue Machine No. 6 Dust System	PM	0.5	1.9
69	Tissue Machine No. 6	Acetone	0.5	1.9
		Acetaldehyde	0.54	2.37
		Acrolein	0.03	0.09

SN	Description	Pollutant	lb/hr	ton/yr
		1,2 Dichloroethylene	0.05	0.22
		Formaldehyde	0.08	0.32
		Methanol	0.55	2.39
		Methylene Chloride	0.05	0.19
		Tetrachloroethylene	0.03	0.12
		1,2,4-Trichlorobenzene	0.02	0.08

187. The permittee shall not cause to be discharged to the atmosphere from SN-51 or SN-52 gases which exhibit opacity greater than 5%. Compliance with this opacity limit shall be demonstrated by compliance with Specific Conditions #188 and #189. The opacity shall be measured in accordance with EPA Reference Method 9 as found in 40 CFR Part 60 Appendix A. [§18.501 of Regulation #18 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

188. The permittee shall conduct weekly observations of the opacity from SN-51 and keep a record of these observations. If visible emissions are detected, then the permittee shall conduct a 6-minute opacity reading in accordance with EPA Reference Method 9. The results of these observations shall be kept on site and shall be made available to Department personnel upon request. [§18.1004 of Regulation #18, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

189. The permittee shall keep the scrubber on SN-52 in good working condition at all times and shall meet the conditions shown in the following table. The scrubber liquid flow rate and the gas pressure drop across the unit shall be measured daily. The results shall be kept on site and be available to the Department personnel upon request. [§18.1104 of Regulation #18 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 56 –Control Equipment Parameters for SN-52

SN	Control Equipment	Parameter	Units	Minimum Operating Limits
52	scrubber	liquid flow rate	gal/min	300
		gas pressure drop across unit	inches, H ₂ O	8

190. The permittee may, in the event of emergency maintenance on SN-52, shut down the dust collection system and contain the tissue dust within the building during the continued operation of the paper machine. Good housekeeping practices shall be used to control tissue dust and prevent visible emissions to the atmosphere. In the event that repairs on a scrubber extend beyond 12 hours, then a 6-minute observation for visible emissions shall be conducted once per 12-hour shift. The observation shall be a yes/no check and shall be conducted at the outside corners of the affected Tissue Machine building. If visible tissue dust emissions are detected for more than 6 minutes per hour, then corrective action shall be taken to reduce emissions and document that visible emissions do not appear after corrective action is taken. [§19.303 of Regulation #19 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

191. The permittee shall not cause to be discharged to the atmosphere from SN-48 gases which exhibit opacity greater than 5%. The opacity shall be measured in accordance with EPA Reference Method 9 as found in 40 CFR Part 60 Appendix A. Compliance with this opacity limit shall be demonstrated by the use of natural gas. [§19.503 and §19.901 et seq of Regulation #19, and 40 CFR Part 52 Subpart E]
192. Natural gas shall be the only fuel used for the Tissue Machine No. 6 Burners (SN-48). [§19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]
193. The permittee shall test SN-48 for CO and NO_x to verify compliance with the BACT emission limits specified in Specific Condition #185 initially and once every three years thereafter. The first test shall be conducted within 60 days of achieving the maximum production rate, but in no event later than 180 days after initial start-up of the modified permitted source. Testing shall be performed in accordance with Plantwide Condition #3. Testing for CO and NO_x shall also be performed in accordance with EPA Reference Methods 10 and 7E respectively. During the test the permittee shall operate the source within 10 percent of the rated throughput capacity. If 90 percent of the rated throughput capacity can not be achieved, the permittee shall be limited to 11 percent above the actual tested throughput. [§19.702 and §19.901 of Regulation #19, and 40 CFR Part 52 Subpart E]
194. The permittee shall not produce in excess of 270 machine dried tons of paper per day, 30 day rolling average, from the Tissue Machine No. 6. [§18.1004 of Regulation #18, §19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by A.C.A. §8-4-304 and §8-4-311, and 40 CFR §70.6]
195. The permittee shall maintain records which demonstrate compliance with the limits listed in Specific Condition #194. The records shall be updated on a monthly basis. These records shall be kept on site, provided to Department personnel upon request and may be used by the Department for enforcement purposes. A twelve month total and each individual month's data shall be submitted in accordance with General Provision #7. [§18.1004 of Regulation #18, §19.705 of Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

SN-#49, #50 and #70

Tissue Machine No. 7

Emissions from the wet end and dry end of Tissue Machine No. 7 (SN-70) have been bubbled together. The Tissue Machine No. 7 Burners (SN-49) combust natural gas at a total heating rate of 41 million Btu per hour. The burners are low NO_x burners. Tissue Machine No. 7 Dust System (SN-50) uses a 44,000 cfm scrubber to control particulate matter emissions.

Specific Conditions

196. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #199 and #200. [Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 57 – Maximum Criteria Pollutant Emission Rates for SN-49, 50, and 70

SN	Description	Pollutant	lb/hr	ton/yr
49	Tissue Machine No. 7 Burners	PM ₁₀	0.4	1.8
		SO ₂	0.1	0.1
		VOC	2.4	10.1
		CO	8.8	38.5
		NO _x	2.3	9.7
50	Tissue Machine No. 7 Dust System	PM ₁₀	0.5	2.1
70	Tissue Machine No. 7	VOC	1.2	5.1
		TRS	0.1	0.3

197. The permittee estimates the emission rates set forth in the following table will not be exceeded. The pollutant emission rates are effectively limited by Specific Conditions #199 and #200. [Regulation No. §18.801 effective February 15, 1999, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 58 – Maximum Non-Criteria Pollutant Emission Rates for SN-49, 50, and 70

SN	Description	Pollutant	lb/hr	ton/yr
49	Tissue Machine No. 7 Burners	PM	0.4	1.8
		Arsenic	0.01	0.01
		Benzene	0.01	0.01
		Cadmium	0.01	0.01
		Chromium, total	0.01	0.01
		Cobalt	0.01	0.01
		Formaldehyde	0.01	0.02

SN	Description	Pollutant	lb/hr	ton/yr
		Hexane	0.09	0.39
		Manganese	0.01	0.01
		Mercury	0.01	0.01
		Naphthalene	0.01	0.01
		Nickel	0.01	0.01
		Toluene	0.01	0.01
50	Tissue Machine No. 7 Dust System	PM	0.5	2.1
70	Tissue Machine No. 7	Acetone	0.4	1.8
		Acetaldehyde	0.50	2.19
		Acrolein	0.02	0.09
		1,2 Dichloroethylene	0.05	0.20
		Formaldehyde	0.07	0.30
		Methanol	0.51	2.21
		Methylene Chloride	0.04	0.17
		Tetrachloroethylene	0.03	0.11
		1,2,4-Trichlorobenzene	0.02	0.08

198. The permittee shall not cause to be discharged to the atmosphere from SN-49 gases which exhibit opacity greater than 5%. Compliance with this opacity limit shall be demonstrated by the use of natural gas.

The permittee shall not cause to be discharged to the atmosphere from SN-50 gases which exhibit opacity greater than 5%. Compliance with this opacity limit shall be demonstrated by compliance with Specific Condition #202.

The opacity shall be measured in accordance with EPA Reference Method 9 as found in 40 CFR Appendix A. [§18.501 of Regulation #18 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

199. Natural gas shall be the only fuel used for Tissue Machine No. 7 Burners (SN-49). [§18.1004 of Regulation #18, §19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]

200. The permittee shall not produce in excess of 250 machine dried tons of paper per day, 30 day rolling average, from the Tissue Machine No. 7. [§18.1004 of Regulation #18, §19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]

201. The permittee shall maintain records which demonstrate compliance with the limits listed in Specific Condition #200. The records shall be updated on a monthly basis. These records shall be kept on site, provided to Department personnel upon request and may be used by the Department for enforcement purposes. A twelve month total and each individual month's data shall be submitted in accordance with General Provision #7. [§18.1004 of Regulation #18,

§19.705 of Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

202. The Tissue Machine No. 7 Dust System (SN-50) is subject to and shall comply with all applicable provisions of §19.304 of Regulation 19, 40 CFR Part 52 Subpart E, and Part §64.6 for Compliance Assurance Monitoring.

- A. The permittee shall maintain a scrubber liquid flowrate of at least 300 gallons per minute. [40 CFR Part §64.6(c)(1)]
- B. The permittee shall monitor and maintain daily records to demonstrate compliance with Specific Condition #202 (A). Records shall be kept onsite and made available to the Department upon request. [40 CFR Part §64.6(c)(3)]
- C. The permittee shall maintain the scrubber in good working condition at all times so that pollutant removal is maintained. [40 CFR Part §64.6(c)(1)]

203. The Tissue Machine No. 7 Dust System (SN-50) is subject to and shall comply with all applicable provisions §19.304 of Regulation 19, 40 CFR Part 52 Subpart E, and Part §64.6 for Compliance Assurance Monitoring. The following information pertaining to exceedances or excursions from permitted values shall be submitted in semi-annual reports in accordance with General Provision #7 as outlined in 40 CFR §70.6.

- A. The permittee shall maintain records for SN-50 that summarizes the number, duration, and cause of excursions or exceedances of emission limits as well as corrective action taken. [40 CFR §64.9(a)(2)(i) and §64.9(b)]
- B. The permittee shall maintain records for SN-50 that summarizes the number, duration, and cause of monitoring equipment downtime incidents, other than routine downtime for calibration checks. [40 CFR §64.9(a)(2)(ii) and §64.9(b)]
- C. The permittee shall maintain a quality improvement plan (QIP) threshold for each indicator of no more than nine excursions or 5% of the daily averages in a six-month period. [40 CFR §64.9(a)(2)(iii) and §64.9(b)]
- D. The permittee shall develop and implement a new QIP if the threshold is exceeded during any six-month period. [40 CFR §64.9(a)(2)(iii) and §64.9(b)]
- E. The permittee shall maintain records for SN-50 that describes the actions taken to implement the QIP. Upon completion of the QIP, documentation shall be maintained to confirm that the plan was completed and reduced the likelihood of similar excursions or exceedances. [40 CFR §64.9(a)(2)(iii) and §64.9(b)]

204. The permittee may, in the event of emergency maintenance on SN-50, shut down the dust collection system and contain the tissue dust within the building during the continued operation of the paper machine. Good housekeeping practices shall be used to control tissue dust and prevent visible emissions to the atmosphere. In the event that repairs on a scrubber extend beyond 12 hours, then a 6-minute observation for visible emissions shall be conducted once per 12-hour shift. The observation shall be a yes/no check and shall be conducted at the

outside corners of the affected Tissue Machine building. If visible tissue dust emissions are detected for more than 6 minutes per hour, then corrective action shall be taken to reduce emissions and document that visible emissions do not appear after corrective action is taken. [§19.303 of Regulation #19 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

SN-79, 80 and 81

Tissue Machine No. 8

Proposed emissions from the wet end and dry end of Tissue Machine No. 8 (SN-80) have been bubbled together. The Tissue Machine No. 8 Burners (SN-79) combusts natural gas at a total heating rate of 50 million Btu per hour. The burners are low NO_x burners. Tissue Machine No. 8 Dust System (SN-81) is equipped with a 55,000 cfm wet venturi scrubber dust system to control particulate matter emissions.

The No. 8 Tissue Machine and associate equipment under went a BACT review in Air Permit 597-AOP-R0. Clean fuel, good combustion practice, and low NO_x burners were chosen as BACT for the burners. For particulate control on the dust system, a wet scrubber was determined as BACT.

Specific Conditions

205. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #209 and #214. [Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 59 – Maximum Pb Emission Rates for SN-79

SN	Description	Pollutant	lb/hr	ton/yr
79	Tissue Machine No. 8 Burners	Pb	0.1	0.1

206. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #209, #214, #216, and #217. [§19.501 et seq. and §19.901 of Regulation #19, and 40 CFR Part 52 Subpart E]

Table 60 –BACT Emission Rates for SN-79, 80, and 81

SN	Description	Pollutant	lb/hr	ton/yr
79	Tissue Machine No. 8 Burners (50 MMBtu/hr)	PM ₁₀	0.9	3.6
			0.0164 lb/MMBtu	
		SO ₂	0.1	0.2
			0.0007 lb/MMBtu	
		VOC	1.0	4.2

SN	Description	Pollutant	lb/hr	ton/yr
			0.0192 lb/MMBtu	
		CO	5.7	24.9
			0.1139 lb/MMBtu	
		NO _x	4.6	20.0
			0.0913 lb/MMBtu	
80	Tissue Machine No. 8	VOC	0.5	1.8
			0.045 lb/MDT	
		TRS	0.1	0.3
81	Tissue Machine No. 8 Dust System	PM ₁₀	1.7	7.2
			0.0035 gr/dscf	

207. The permittee estimates the emission rates set forth in the following table will not be exceeded. The pollutant emission rates are effectively limited by Specific Condition #209 and #214. [Regulation No. §18.801 effective February 15, 1999, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 61 – Maximum Non-Criteria Pollutant Emission Rates for SN-79 and 80

SN	Description	Pollutant	lb/hr	ton/yr
79	Tissue Machine No. 8 Burners	Arsenic	0.01	0.01
		Benzene	0.01	0.01
		Cadmium	0.01	0.01
		Chromium, total	0.01	0.01
		Cobalt	0.01	0.01
		Formaldehyde	0.01	0.02
		Hexane	0.11	0.47
		Manganese	0.01	0.01
		Mercury	0.01	0.01
		Naphthalene	0.01	0.01
		Nickel	0.01	0.01
		Toluene	0.01	0.01
80	Tissue Machine No. 8	Acetone	0.4	1.5
		Acetaldehyde	0.43	1.86
		Acrolein	0.02	0.08
		1,2 Dichloroethylene	0.04	0.17
		Formaldehyde	0.06	0.25
		Methanol	0.43	1.88

SN	Description	Pollutant	lb/hr	ton/yr
		Methylene Chloride Tetrachloroethylene 1,2,4-Trichlorobenzene	0.04 0.03 0.02	0.15 0.10 0.07
81	Tissue Machine No. 8 Dust System	PM	1.7	7.2

208. The permittee shall not cause to be discharged to the atmosphere from SN-79 gases which exhibit opacity greater than 5%. Compliance with this opacity limit shall be demonstrated by the use of natural gas.

The permittee shall not cause to be discharged to the atmosphere from SN-81 gases which exhibit opacity greater than 5%. Compliance with this opacity limit shall be demonstrated by Specific Condition #211.

The opacity shall be measured in accordance with EPA Reference Method 9 as found in 40 CFR Part 60 Appendix A. [§19.503 and §19.901 of Regulation #19, and 40 CFR Part 52 Subpart E]

209. Natural gas shall be the only fuel used for Tissue Machine No. 8 Burners (SN-79). [§19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]

210. The permittee shall operate and maintain a device to measure the pressure drop across the wet venturi scrubber on the Tissue Machine No. 8 Dust System (SN-81). [§19.703 and §19.901 et seq of Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

211. The Tissue Machine No. 8 Dust System (SN-81) is subject to and shall comply with all applicable provisions of §19.304 of Regulation 19, 40 CFR Part 52 Subpart E, and Part §64.6 for Compliance Assurance Monitoring

- A. The permittee shall maintain a scrubber liquid pressure of at least 8 inches of water. [40 CFR Part §64.6(c)(1)]
- B. The permittee shall monitor and maintain daily records to demonstrate compliance with Specific Condition #211(A). Records shall be kept onsite and made available to the Department upon request. [40 CFR Part §64.6(c)(3)]
- C. The permittee shall maintain the scrubber in good working condition at all times so that pollutant removal is maintained. [40 CFR Part §64.6(c)(1)]

212. The Tissue Machine No. 8 Dust System (SN-81) is subject to and shall comply with all applicable provisions of §19.304 of Regulation 19, 40 CFR Part 52 Subpart E, and Part §64.6 for Compliance Assurance Monitoring. The following information pertaining to exceedances

or excursions from permitted values shall be submitted in semi-annual reports in accordance with General Provision 7 as outlined in 40 CFR §70.6.

- A. The permittee shall maintain records for SN-81 that summarizes the number, duration, and cause of excursions or exceedances of emission limits as well as corrective action taken. [40 CFR §64.9(a)(2)(i) and §64.9(b)]
- B. The permittee shall maintain records for SN-81 that summarizes the number, duration, and cause of monitoring equipment downtime incidents, other than routine downtime for calibration checks. [40 CFR §64.9(a)(2)(ii) and §64.9(b)]
- C. The permittee shall maintain a quality improvement plan (QIP) threshold for each indicator of no more than nine excursions or 5% of the daily averages in a six-month period. [40 CFR §64.9(a)(2)(iii) and §64.9(b)]
- D. The permittee shall develop and implement a new QIP if the threshold is exceeded during any six-month period. [40 CFR §64.9(a)(2)(iii) and §64.9(b)]
- E. The permittee shall maintain records for SN-81 that describes the actions taken to implement the QIP. Upon completion of the QIP, documentation shall be maintained to confirm that the plan was completed and reduced the likelihood of similar excursions or exceedances. [40 CFR §64.9(a)(2)(iii) and §64.9(b)]

213. The permittee may, in the event of emergency maintenance on SN-81, shut down the dust collection system and contain the tissue dust within the building during the continued operation of the paper machine. Good housekeeping practices shall be used to control tissue dust and prevent visible emissions to the atmosphere. In the event that repairs on a scrubber extend beyond 12 hours, then a 6-minute observation for visible emissions shall be conducted once per 12-hour shift. The observation shall be a yes/no check and shall be conducted at the outside corners of the affected Tissue Machine building. If visible tissue dust emissions are detected for more than 6 minutes per hour, then corrective action shall be taken to reduce emissions and document that visible emissions do not appear after corrective action is taken. [§19.303 of Regulation #19 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

214. The permittee shall not produce in excess of 212 machine dried tons of paper per day, 30 day rolling average, from the Tissue Machine No. 8. [§18.1004 of Regulation #18, §19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]

215. The permittee shall maintain records which demonstrate compliance with the limits listed in Specific Condition #214. The records shall be updated on a monthly basis. These records shall be kept on site, provided to Department personnel upon request and may be used by the Department for enforcement purposes. A twelve month total and each individual month's data shall be submitted in accordance with General Provision #7. [§18.1004 of Regulation #18, §19.705 of Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

216. The permittee shall test SN-79 for CO and NO_X to verify compliance with the BACT emission limits specified in Specific Condition #205 initially and once every three years

thereafter. The first test shall be conducted within 60 days of achieving the maximum production rate, but in no event later than 180 days after initial start-up of the permitted source. Testing for CO and NO_X shall be performed in accordance with Plantwide Condition #3 and EPA Reference Methods 10 and 7E respectively. During the test the permittee shall operate the source within 10 percent of the rated throughput capacity. If 90 percent of the rated throughout capacity can not be achieved, the permittee shall be limited to 11 percent above the actual tested throughput. [§19.702 and §19.901 et seq of Regulation #19, and 40 CFR Part 52 Subpart E]

217. The permittee shall test SN-81 for PM/PM₁₀ to verify compliance with the BACT emission limit specified in Specific Conditions #205 initially and once every three years thereafter. Testing shall be performed in accordance with Plantwide Condition #3 and EPA Reference Method 5 with inclusion of back half sampling train particulate. During the test the permittee shall operate the source within 10 percent of the rated throughput capacity. If 90 percent of the rated throughout capacity can not be achieved, the permittee shall be limited to 11 percent above the actual tested throughput. [§19.702 and §19.901 et seq of Regulation #19, and 40 CFR Part 52 Subpart E]

SN-71 and SN-72

No. 8 and No. 9 Extruder Machines

Source Description

The extrusion plant includes the No. 8 and No. 9 extruder machines which polycoat board. The extrusion plant receives board from the board machine and outside board customers and applies a polymer coating. Rolls of board are loaded onto an unwind stand. The board passes through a calender stack and is subjected to a burner which flame seals the board. An extruded poly sheet is then pressed together with the board. The combined product is then passed through an electrostatic treater (SN-71 for No. 8 Extruder and SN-72 for No. 9 Extruder) which enhances the surface quality of the product. Each extruder has two electrostatic treaters which emit ozone.

Both extrusion lines also include rewinding facilities which can be used to cut the extruded product to size and rewind the material so poly can be applied to the opposite side. The extrusion plant also performs shredding, trim chopping and spool cutting. Particulate matter emissions from these activities are controlled by cyclones.

Specific Conditions

218. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Conditions #220. [§19.501 et seq. and §19.901 et seq of Regulation #19, and 40 CFR Part 52 Subpart E]

Table 62 – Maximum Criteria Pollutant Emission Rates for SN-71 and 72

SN	Description	Pollutant	lb/hr	ton/yr
71	No. 8 Extruder Electrostatic Treaters (A&B)	PM ₁₀	0.4	1.4
72	No. 9 Extruder Electrostatic Treater	PM ₁₀	0.6	2.5

219. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Condition #220. [Regulation No. §18.801 effective February 15, 1999, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 63 – Maximum Non-Criteria Pollutant Emission Rates for SN-71 and 72

SN	Description	Pollutant	lb/hr	ton/yr
71	No. 8 Extruder Electrostatic Treaters (A&B)	PM Ozone	0.4 1.8	1.4 7.9

SN	Description	Pollutant	lb/hr	ton/yr
72	No. 9 Extruder Electrostatic Treater	PM Ozone	0.6 1.5	2.5 6.3

220. The permittee shall not produce in excess of 750 machine dried tons of coated paper per day, 30 day rolling average, from the No. 8 and No. 9 Extruder Machines combined. [§18.1004 of Regulation #19 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

221. The permittee shall maintain records which demonstrate compliance with the limits listed in Specific Condition #220. The records shall be updated on a monthly basis. These records shall be kept on site, provided to Department personnel upon request and may be used by the Department for enforcement purposes. A twelve month total and each individual month's data shall be submitted in accordance with General Provision #7. [§18.1004 of Regulation #18 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

SN-35F

Aeration Stabilization Basin

Source Description

Wastewater is treated by the Crossett Paper Operations treatment plant. The wastewater is gathered in two open sewers, a bleach plant/utilities sewer and a process sewer. Wastewater Treatment System nutrients are added to the bleach plant/utilities sewer to enhance biological activity. After primary clarification, the process sewer and the bleach plant/utilities sewer combine and flow into one of two settling basins. The effluent travels through a surge basin and is combined with the City of Crossett's treated effluent as it enters a 265 acre extended aeration stabilization basin (ASB, SN-35F). The effluent from the ASB is sent to a holding basin called Mossy Lake, which has a surface area that varies from 200 to 600 acres. Treated effluent is discharged from Mossy Lake to the Ouachita River via Coffee Creek.

Air emissions result from the biological wastewater treatment processes. The air emissions are a factor of such things as the flow to the secondary treatment, the volume of the aeration stabilization basin, the temperature of the aeration stabilization basin and the surface area of the aeration stabilization basin. Also included in the estimation, are contributions from the wastewater clarifier, settling ponds, and sludge dewatering. These potential emissions were not accounted for in the initial permit.

Specific Conditions

222. The permittee shall not exceed the emission rates set forth in the following table. The emissions from this source are limited by the production levels of the mill. [Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 64 – Maximum Criteria Pollutant Emission Rates for SN-35F

Pollutant	lb/hr	ton/yr
VOC	16.5	70.8

223. The permittee shall not exceed the emission rates set forth in the following table. The emissions from this source are limited by the production levels of the mill. [Regulation No. §18.801 effective February 15, 1999, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 65 – Maximum Non-Criteria Pollutant Emission Rates for SN-35F

Pollutant	lb/hr	ton/yr
Chloroform	1.53	6.69
Methanol	0.08	0.36
Naphthalene	0.01	0.05

SN-40, 75, 76F, 78F, 82F, and SN-97

Tanks and Miscellaneous Activities

Source Description

There are nine large pulp storage tanks located at Crossett Paper Operations (SN-75). An open storage basin (SN-76F) at the facility stores black liquor. The front black liquor storage basin at the facility was closed in 1996.

Fugitive emissions from unpaved roads (SN-78F) are generated by vehicle traffic. Unpaved roads are located in the utilities area, woodyard, laydown area, contractors area and around the wastewater treatment system.

The Methanol Tank (SN-40) is subject to regulation under NSPS Subpart Kb. The emissions are due to the working and standing losses from the tank.

There are two landfills at Crossett Paper Operations, the East Landfill and the North Landfill. The East Landfill is permitted to operate as a Class IV Landfill and accepts only woodwaste and concrete debris. The North Landfill is an industrial landfill which accepts general waste from the mill. No municipal waste is disposed in either landfill. The only significant source of emissions expected from these landfills is VOC emissions from the North Landfill. The North Landfill was permitted by the Department and began operation on September 1, 1998. The North Landfill is located approximately two miles north of the mill. The West Landfill ceased operation on September 1, 1998. The West Landfill is currently undergoing closure activities.

Specific Conditions

224. The permittee shall not exceed the emission rates set forth in the following table.

Compliance with the pollutant emission rates associated with the Methanol Tank are demonstrated by compliance with Specific Condition #227. The emissions from the other sources are limited by the production levels of the mill. [Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 66 – Maximum Criteria Pollutant Emission Rates for SN-40, 75, 76F, 78F, 82F, and SN-97

SN	Description	Pollutant	lb/hr	ton/yr
40	Methanol Storage Tank	VOC	37.5	1.2
75	Pulp Storage Chests	VOC	9.3	40.7
97	Storage Tanks	VOC	33.0	6.8
76F	Black Liquor Storage Basin No. 1	VOC	28.1	122.8
78F	Road Emissions	PM ₁₀	15.3	67.1

SN	Description	Pollutant	lb/hr	ton/yr
82F	Landfill Operations	PM ₁₀ VOC	1.3 4.3	0.3 18.7

225. The permittee estimates the emission rates set forth in the following table will not be exceeded. The pollutant emission rates associated with the Methanol Tank are effectively limited by Specific Condition #227. The emissions from the other sources are limited by the production levels of the mill. [Regulation No. §18.801 effective February 15, 1999, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 67– Maximum Non-Criteria Pollutant Emission Rates for SN-40, 75, 76F, 78F, 82F, and SN-97

SN	Description	Pollutant	lb/hr	ton/yr
40	Methanol Storage Tank	Methanol	37.50	1.20
97	Storage Tanks	Methanol	1.5	6.0
75	Pulp Storage Chests	Methanol	2.16	9.47
76F	Black Liquor Storage Basin No. 1	Acetaldehyde Acetone Methanol	1.31 2.3 16.07	5.72 9.9 70.38
78F	Road Emissions	PM	44.8	195.8
82F	Landfill Operations	PM	2.7	0.5

226. The Methanol Tank is subject to and shall comply with all applicable provisions of 40 CFR Part 60 Subpart Kb - *Standards of Performance for Volatile Organic Liquid Storage Vessels*. A copy of Subpart Kb is provided in Appendix D.

Applicable provisions include, but are not limited to, maintaining records showing the dimension of the storage vessel, and an analysis showing the design capacity of the storage vessel. [§19.304 of Regulation #19 and 40 CFR 60.116b (a) and (b)]

227. Throughput of methanol at SN-40 shall not exceed 40,000 barrels per twelve consecutive months. [§19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]

228. The permittee shall maintain records which demonstrate compliance with the limits listed in Specific Condition #227. These records shall be updated on a monthly basis. These records shall be kept on site, provided to Department personnel upon request and may be used by the Department for enforcement purposes. A twelve month total and each individual month's data shall be submitted in accordance with General Provision #7. [§19.705 of Regulation #19 and 40 CFR Part 52 Subpart E]

229. The permittee shall maintain sufficient records to demonstrate compliance with the throughput limits listed in the Tanks Table. These records shall be updated on a monthly basis. These records shall be kept on site, provided to Department personnel upon request and may be used by the Department for enforcement purposes. An annual total and each individual month's data shall be submitted in accordance with General Provision #7.
[§19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]

Table 68 – Tanks Table

Contents	Capacity (bbl)	Throughput (bbl/yr)
Gasoline	71	857

SN-#93

Repulpers A, B, and C

Source Description

Three repulpers are used to reprocess broke. These are identified as Repulpers A, B, and C. Each repulper is identical. The repulpers operate without any hoods or fans. The repulpers apply a sodium hypochlorite pulping aid which is added subsurface. All VOC emissions are non-stack in nature. The broke that is repulped is stored in the existing broke stock chests. As part of the permit renewal, the repulpers were added as permitted sources. A minor modification allowed the reconstruction of Repulper A.

Specific Conditions

230. The permittee shall not exceed the emission rates set forth in the following table. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Condition #232. [Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 69 – Maximum Criteria Pollutant Emission Rates for SN-93

Pollutant	lb/hr	ton/yr
VOC	0.6	2.3

231. The permittee estimates the emission rates set forth in the following table will not be exceeded. Compliance with this Specific Condition shall be demonstrated by compliance with Specific Condition #232. [Regulation No. §18.801 effective February 15, 1999, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 70 – Maximum Non-Criteria Pollutant Emission Rates for SN-93

Pollutant	lb/hr	ton/yr
Chloroform	0.60	2.30

232. The permittee shall not use in excess of 1,971,000 pounds per year of hypochlorite at SN-93. This limit is based on a 12-month rolling total. [§18.1004 of Regulation #18, §19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]

233. The permittee shall maintain records which demonstrate compliance with the limits listed in Specific Condition #232. These records shall be updated on a monthly basis. These records shall be kept on site, provided to Department personnel upon request and may be used by the Department for enforcement purposes. A twelve month total and each individual month's data shall be submitted in accordance with General Provision #7. [§19.705 of Regulation #19 and 40 CFR Part 52 Subpart E]

CLUSTER RULE PULPING REQUIREMENTS

The Cluster Rule imposes HAP control on the pulping system, which is comprised of all pulping process equipment beginning with the digester system, up to and including the last piece of pulp conditioning equipment prior to the bleaching system. Total HAP control (as methanol) is divided into three source groups: the low volume – high concentration (LVHC) system, the high volume – low concentration (HVLC) system, and the pulping process condensates.

The incinerator (SN-83) is the only source of additional emissions. The incinerator is collecting emissions from other sources for combustion. The emissions from the new Incinerator will be an increase to actual emissions. The Incinerator will be combusting new (natural gas, SOGs, and HVLC NCGs) and existing (LVHC NCGs) fuels. The additional equipment will not increase the emissions or the pulp throughput limits.

Low Volume – High Concentration (LVHC) Collection System

Crossett Paper Operations has an existing LVHC Collection System that routes HAP emissions from the Digester, Turpentine Recovery, and the Evaporator System to the No. 4 Lime Kiln (SN-25) for control. Per the requirements of the Cluster Rule, the only additional LVHC sources that need to be added to the collection system are the Turpentine Decanter and the Foul Condensate Collection Tank.

At Crossett Paper Operations, the digestion of wood chips occurs in a batch operation rather than on a continuous basis. In batch digesters, NCGs, along with steam and HAPs, are removed from the digesters while the chips “cook” – convert to pulp. This stream is cooled to produce batch digester relief steam condensate. When Crossett Paper Operations pulps softwood, especially pine, the resulting condensates contain turpentine. These condensates are sent to the Turpentine Recovery System for extraction of the turpentine. The foul condensates will leave the turpentine recovery area as turpentine decanter underflow. In the Turpentine Recovery System, underflow from both the decanter and storage tanks are considered Kraft pulping condensates.

At the end of the cook, the pulp, cooking chemicals, and gases from the digesters are sent to the Blow Tank where large quantities of steam and some HAPs are released. This steam is condensed to form batch digester blow steam condensate. The fraction of HAPs that do not leave with the relief and blow steam continue with the pulp and weak black liquor to be collected by the HVLC Collection System and Evaporator Liquor Feed Stages described below.

Weak black liquor is fed to multiple effects in the evaporator. When the liquor is initially subjected to evaporation, the majority of the HAPs are removed from the liquor along with water vapor. The HAPs and water vapor are then condensed, thereby producing evaporator foul condensate which is routed along with the rest of the pulp process condensates to the LEEPS System described below.

The LVHC gas sources that will be collected and routed to the Incinerator (SN-83) are as follows. Crossett Paper Operations will design and operate this equipment as a closed-vent system that will have no detectable leaks. These sources have a Cluster Rule compliance deadline of April 16, 2001.

- Turpentine decanter
- Turpentine underflow tank
- Foul condensate storage tank
- NCG condensate seal tank

High Volume – Low Concentration (HVLC) Collection System

The HVLC System will be constructed as a closed-vent system. The intent is to control HAP emissions from the Pulp Washing Systems, Knotter Systems, Screening Systems, and Decker Systems. The emissions will be controlled as outlined in 40 CFR §63.443. HVLC sources are required to be controlled within eight years from the publication date of the Cluster Rule in the Federal Register – i.e. April 17, 2006.

The following sources are planned to be collected and controlled as part of the HVLC Collection System. Pursuant to 40 CFR §63.455, the permittee shall update the Department with a Non-Binding Strategy Report, which identifies the sources to be collected and the scheduled compliance date. The table below contains the current list of sources planned for collection and their associated dates.

The Line 1 weak black liquor tank and the Line 1 Decker/Decker seal tank emissions are required to be collected by April 16, 2006. However, these two sources have been collected and routed to the NCG collection system by the voluntary April 16, 2001 deadline.

Table 71 – HVLC Collection System Sources

HVLC Gas Source	Compliance Due Date
<u>Line 2 Washing System</u>	
Vibrating drainer	April 17, 2006
Knotter surge tank	April 17, 2006
Separator Drain Tank	April 17, 2006
<u>Line 1 Washing System</u>	
Pressate tank	April 17, 2006 (Completed)
Weak black liquor tank *	April 16, 2001 (Completed)
Separator drain tank	April 17, 2006 (Completed)
Washer stock chest	April 17, 2006 (Completed)
Decker and decker seal tank *	April 16, 2001 (Completed)

HVLC Gas Source	Compliance Due Date
<u>No. 2 Screening System</u>	
Secondary screen supply tank	April 17, 2006
Tertiary screen supply tank	April 17, 2006
Quaternary screen supply tank	April 17, 2006

* Compliance date voluntarily moved to April 16, 2001. [§19.304 of Regulation #10 and 40 CFR §63.443]

Small amounts of HVLC condensates form in the HVLC Collection System. The condensates will be removed at low points in the system. Although this condensate has a low volume, it is usually foul with TRS compounds. The collected HVLC condensates will be routed to the LEEPS System.

Low Energy Environmental Pre-Evaporator & Stripper (LEEPS) System

In order to meet the Cluster Rule condensate standards, Crossett Paper Operations will install a LEEPS System that will be comprised of pre-evaporators, a concentrator, and a steam stripper. Pulping condensates from the Digester System, Turpentine Recovery System, Evaporator Liquor Feed Stages, and The LVHC and HVLC Collection Systems are sent directly to the steam stripper. At the same time, condensates from the new pre-evaporators/ concentrator are also routed to the steam stripper. Steam from the stripper drives off the HAPs and TRS from the condensate. The clean condensates are then recycled to various processes in the Mill. The liquid and gaseous (SOGs) phases of the stripped portion are segregated. The liquid portion is routed to a storage tank from which it is routed to the Incinerator for destruction. Meanwhile, the SOGs are routed to the Incinerator (SN-83) for control. The No. 4 Lime Kiln or the 9A Boiler serve as backup destruction devices for the SOGs.

Incinerator (SN-83)

Gas streams from the LVHC Collection System, the HVLC Collection System, and SOGs from the LEEPS System are fed into the Incinerator via a common burner. The HVLC system is diluted with combustion air before being fed to the combustion chamber. The Incinerator consists of a horizontal combustion chamber followed by a vertical SO₂ caustic packed-tower scrubber which, in turn, is followed by several mist eliminators.

Minimum incineration temperature in the primary combustion zone is required for efficient oxidation. For this Kraft mill application, combustion requirements dictate a minimum temperature of 1,600°F with a 0.75 second retention time (see 40 CFR §63.443(d)(3)).

Since the Incinerator combusts NCGs from both LVHC and HVLC Collection Systems, it has to meet a 96% uptime requirement. Crossett Paper Operations complies by using the Incinerator as the primary combustion device with the No. 4 Lime Kiln (SN-25) and the 9A Boiler (SN-22) as backup combustion devices for the LVHC NCGs and SOGs only. The HVLC gases, which by definition have lower concentrations of NCGs, are vented to the atmosphere when the Incinerator

is down. In the event that downtime occurs, excess emissions will be reported as required by 40 CFR §63.455.

Under normal operation, the fuel flow is controlled by the operating temperature in the Incinerator. The fuel requirements will vary with the amount of waste gases introduced into the collection system. Maximum fuel consumption will be required to bring the system up to temperature, but the consumption will be greatly reduced during normal incineration of the NCGs and SOGs. The NCGs have some heat content which reduces fuel consumption once normal incineration begins.

The Incinerator system consists of a refractory lined Incinerator, a waste heat boiler, a cooler section, an SO₂ scrubber, a sulfuric acid removal system, and a discharge stack.

The waste heat boiler is located between the Incinerator outlet and the scrubber inlet. This boiler is a fire-tube type boiler with three passes. The boiler does not combust fuels, rather it scavenges the waste heat from the Incinerator to produce steam.

The gases exiting the Incinerator are in excess of 1,600°F. In order to scrub the SO₂ from these gases, the temperature is lowered. The gases pass through a waste heat boiler. The boiler is followed by a vertical SO₂ scrubber that continues to lower the temperature as it removes most of the sulfur gases from the combustion exhaust.

The adsorption tower is followed by a sulfuric acid removal system that uses a caustic solution. A recirculation loop is used to minimize caustic use. The makeup caustic is controlled by scrubber pH to maintain scrubbing effectiveness and efficiency.

The primary fuels for the Incinerator are methanol recovered from the foul condensates via the steam stripper and the LVHC gases. Natural gas is used as a backup fuel. For a given pollutant, the combustion of methanol produces the highest emission rates. The Incinerator is equipped with low-NO_x burners to control NO_x emissions and a scrubber to control PM/PM₁₀ and SO₂ emissions.

Specific Conditions

The Incinerator (SN-83)

234. The permittee shall not exceed the emission rates set forth in the following table for the Incinerator (SN-83). Emissions are based on maximum capacity. Initial compliance with the PM₁₀ and VOC emission rates shall be demonstrated by Specific Conditions #243 and #245, respectively. Annual compliance with the SO₂, CO, NO_x, and TRS emission rates shall be demonstrated by Specific Conditions #244, #246, #247, #248 respectively. [Regulation No. 19 §19.501 et seq. effective May 28, 2006 and 40 CFR Part 52, Subpart E]

Table 72 – Maximum Criteria Pollutant Emission Rates for SN-83

Pollutant	lb/hr	ton/yr
PM ₁₀	2.7	11.8

Pollutant	lb/hr	ton/yr
SO ₂	9.1	39.9
VOC	0.8	3.5
CO	6.0	26.3
NO _x	23.0	100.7
TRS	0.9	3.8

235. The permittee estimates the emission rates set forth in the following table for the Incinerator (SN-83) will not be exceeded. Emissions are based on maximum capacity. Initial compliance with the PM and Methanol emissions shall be demonstrated by Specific Conditions #243 and #249, respectively. [Regulation No. §18.801 effective February 15, 1999, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Table 73 – Maximum Non-Criteria Pollutant Emission Rates for SN-83

Pollutant	lb/hr	ton/yr
PM	2.7	11.8
Methanol	0.80	3.50

236. The permittee shall not cause to be discharged to the atmosphere from the Incinerator gases which exhibit opacity greater than 20% as measured by EPA Reference Method 9. Compliance shall be demonstrated by the proper operation of the scrubber per Specific Condition #237. [§19.503 of Regulation #19 and 40 C.F.R. Part 52 Subpart E]

237. Natural gas may be used as a backup fuel for the Incinerator. [§19.705 of Regulation #19, A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR §70.6]

238. The permittee shall maintain records which demonstrate compliance with Specific Condition #237. These records shall be updated on a monthly basis and shall include periods of usage of natural gas, (not quantities) of fuel used. These records shall be kept on site, provided to Department personnel upon request and may be used by the Department for enforcement purposes. A twelve month total and each individual month's data shall be submitted in accordance with General Provision #7. [§19.705 of Regulation #19 and 40 CFR Part 52 Subpart E]

239. Incinerator (SN-83) is subject to and shall comply with all applicable provisions §19.304 of Regulation 19, 40 CFR Part 52 Subpart E, and Part §64.6 for Compliance Assurance Monitoring. Future compliance tests may be used to establish the daily average pressure drop and flowrate values that are contained in the permit. The pressure drop and flow rate values recorded during a compliant test event may be used as subsequent minimum values.

- The permittee shall maintain a scrubber liquid flowrate of at least 768 gallons per minute. [40 CFR Part §64.6(c)(1)]
- The permittee shall maintain pH of at least 7.6. [40 CFR Part §64.6(c)(1)]

- C. The permittee shall monitor and maintain daily records to demonstrate compliance with Specific Condition #239 (A) and (B). Records shall be kept onsite and made available to the Department upon request. [40 CFR Part §64.6(c)(3)]
- D. The permittee shall maintain the caustic scrubber in good working condition at all times so that SO₂ removal is maintained. [40 CFR Part §64.6(c)(1)]

240. The Incinerator (SN-83) is subject to and shall comply with all applicable provisions §19.304 of Regulation 19, 40 CFR Part 52 Subpart E, and Part §64.9 for Compliance Assurance Monitoring. The following information pertaining to exceedances or excursions from permitted values shall be submitted in semi-annual reports in accordance with General Provision 7 as outlined in 40 CFR §70.6.

- A. The permittee shall maintain records for SN-83 that summarizes the number, duration, and cause of excursions or exceedances of emission limits as well as corrective action taken. [40 CFR §64.9(a)(2)(i) and §64.9(b)]
- B. The permittee shall maintain records for SN-83 that summarizes the number, duration, and cause of monitoring equipment downtime incidents, other than routine downtime for calibration checks. [40 CFR §64.9(a)(2)(ii) and §64.9(b)]
- C. The permittee shall maintain a quality improvement plan (QIP) threshold for each indicator of no more than nine excursions or 5% of the total daily averages in a six-month period.
- D. The permittee shall develop and implement a new QIP if the threshold is exceeded during any six-month period. [40 CFR §64.9(a)(2)(iii) and §64.9(b)]
- E. The permittee shall maintain records for SN-83 that describe the actions taken to implement the QIP. Upon completion of the QIP, documentation shall be maintained to confirm that the plan was completed and reduced the likelihood of similar excursions or exceedances. [40 CFR §64.9(a)(2)(iii) and §64.9(b)]

241. The Incinerator (SN-83) is subject to and shall comply with applicable provisions of §19.804 of Regulation #19, NSPS Subpart BB, and NESHAP Subpart S. Section 19.804 of Regulation #19 and NSPS Subpart BB both require incineration of NCGs at a minimum temperature of 1200°F for at least 0.5 seconds. NESHAP Subpart S requires incineration at a minimum temperature of 1600°F for at least 0.75 seconds. [§19.804 of Regulation #19, NSPS Subpart BB, and NESHAP Subpart S]

242. The permittee shall maintain records which demonstrate compliance with Specific Condition #241. These records shall be kept on site, provided to Department personnel upon request and may be used by the Department for enforcement purposes. [§19.705 of Regulation #19 and 40 CFR Part 52 Subpart E]

243. The permittee shall initially test particulate matter emissions from the Incinerator. Testing shall be performed in accordance with Plantwide Condition #3 and EPA Reference Method 5 as found in 40 CFR Part 60 Appendix A. [§18.1002 of Regulation #18, §19.702 of

Regulation #19, 40 CFR Part 52 Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

244. The permittee shall annually test sulfur dioxide emissions from the Incinerator. Testing shall be performed in accordance with Plantwide Condition #3 and EPA Reference Method 6C as found in 40 CFR Part 60 Appendix A. [§19.702 of Regulation #19 and 40 CFR Part 52 Subpart E]
245. The permittee shall initially test volatile organic compound emissions from the Incinerator. Testing shall be performed in accordance with Plantwide Condition #3 and EPA Reference Method 25A as found in 40 CFR Part 60 Appendix A. This initial test was completed in September 2001. [§19.702 of Regulation #19 and 40 CFR Part 52 Subpart E]
246. The permittee shall annually test carbon monoxide emissions from the Incinerator. Testing shall be performed in accordance with Plantwide Condition #3 and EPA Reference Method 10 as found in 40 CFR Part 60 Appendix A. [§19.702 of Regulation #19 and 40 CFR Part 52 Subpart E]
247. The permittee shall annually test nitrogen oxides emissions from the Incinerator. Testing shall be performed in accordance with Plantwide Condition #3 and EPA Reference Method 7E as found in 40 CFR Part 60 Appendix A. [§19.702 of Regulation #19 and 40 CFR Part 52 Subpart E]
248. The permittee shall annually test total reduced sulfur emissions from the Incinerator. Testing shall be performed in accordance with Plantwide Condition #3 and EPA Reference Method 16 as found in 40 CFR Part 60 Appendix A. [§19.702 of Regulation #19 and 40 CFR Part 52 Subpart E]
249. The permittee shall initially test methanol emissions from the Incinerator. Testing shall be performed in accordance with Plantwide Condition #3 and EPA Reference Method 18 as found in 40 CFR Part 60 Appendix A. This initial test was completed in September 2001. [§18.1002 of Regulation #18 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

The Pulping System

250. The pulping system (which is comprised of all pulping process equipment beginning with the digester system, up to and including the last piece of pulp conditioning equipment prior to the bleaching system) is subject to and shall comply with applicable provisions of 40 CFR Part 63 Subpart S – National Emission Standards for Hazardous Air Pollutants from the Pulp and Paper Industry. A copy of Subpart S is provided in Appendix F. Applicable provisions include, but are not limited to, the following:

Standards for the Kraft pulping systems.

- A. The permittee shall control the total HAP emissions from the equipment systems listed in 40 CFR §63.443(a), as specified in paragraphs (c) and (d) of 40 CFR §63.443. [§19.304 of Regulation #19 and 40 CFR §63.443(a)]

- B. The equipment systems listed in paragraphs (a) and (b) of 40 CFR §63.443 shall be enclosed and vented into a closed-vent system and routed to a control device that meets the requirements specified in paragraph (d) of 40 CFR §63.443. The enclosure and closed-vent system shall meet the requirements specified in 40 CFR §63.450. [§19.304 of Regulation #19 and 40 CFR §63.443(c)]
- C. The control device used to reduce total HAP emissions from each equipment system listed in paragraphs (a) and (b) of 40 CFR §63.443 shall reduce total HAP emissions using a thermal oxidizer designed and operated at a minimum temperature of 871 °C (1600°F) and a minimum residence time of 0.75 seconds. [§19.304 of Regulation #19 and 40 CFR §63.443(d)(3)]
- D. Periods of excess emissions reported under 40 CFR §63.455 shall not be a violation of 40 CFR §63.443 (c) and (d) provided that the time of excess emissions (excluding periods of startup, shutdown, or malfunction) divided by the total process operating time in a semi-annual period does not exceed the following levels: (1) one percent for control devices used to reduce the total HAP emissions from the LVHC system; and (2) four percent for control devices used to reduce the total HAP emissions from the HVLC system; and (3) four percent for control devices used to reduce the total HAP emissions from both the LVHC and HVLC systems. [§19.304 of Regulation #19 and 40 CFR §63.443(e)]

Standards for kraft pulping process condensates.

- E. The pulping process condensates from the equipment systems listed in 40 CFR §63.446(b) shall be treated to meet the requirements specified in paragraphs (c), (d), and (e) of 40 CFR §63.446. [§19.304 of Regulation #19 and 40 CFR §63.446(b)]
- F. One of the combinations of HAP-containing pulping process condensates listed in 40 CFR §63.446(c) which is generated, produced, or associated with the equipment systems listed in paragraph (b) of 40 CFR §63.446 shall be subject to the requirements of paragraph (d) and (e) of 40 CFR §63.446. [§19.304 of Regulation #19 and 40 CFR §63.446(c)]
- G. The pulping process condensates from the equipment systems listed in paragraph (b) of 40 CFR §63.446 shall be conveyed in a closed collection system that is designed and operated to meet the requirements specified in paragraphs (d)(1) and (d)(2) of 40 CFR §63.446. [§19.304 of Regulation #19 and 40 CFR §63.446(d)]
- H. Each pulping process condensate from the equipment systems listed in paragraph (b) of 40 CFR §63.446 shall be treated according to the following option: at mills that perform bleaching, treat the pulping process condensates to remove 5.1 kilograms or more of total HAP per megagram (10.2 pounds per ton) of ODP (bleached), or achieve a total HAP concentration of 330 parts per million or less by weight at the outlet of the control device. [§19.304 of Regulation #19 and 40 CFR §63.446(e)(5)]

- I. Each HAP removed from a pulping process condensate stream during treatment and handling under paragraph (d) or (e) of 40 CFR §63.446 shall be controlled as specified in 40 CFR §43.443(c) and (d). [§19.304 of Regulation #19 and 40 CFR §63.446(f)]
- J. The permittee shall evaluate all new or modified pulping process condensates or changes in the annual bleached or non-bleached ODP used to comply with paragraph (i) of 40 CFR §63.446, to determine if they meet the applicable requirements of 40 CFR §63.446. [§19.304 of Regulation #19 and 40 CFR §63.446(h)]
- K. For the purposes of meeting the requirements in paragraphs (c)(2), (e)(4), or (e)(5) of 40 CFR §63.446 at mills producing both bleached and unbleached pulp products, the permittee may meet a prorated mass standard that is calculated by prorating the applicable mass standards (kilograms of total HAP per megagram of ODP) for bleached and unbleached specified in paragraphs (c)(2), (e)(4), or (e)(5) of 40 CFR §63.446 by the ratio of annual megagrams of bleached and unbleached ODP. [§19.304 of Regulation #19 and 40 CFR §63.446(i)]

Monitoring Requirements

- L. The Incinerator shall meet the monitoring requirements set forth in 40 CFR §63.453(b). [§19.304 of Regulation #19 and 40 CFR §63.453(b)]
- M. The Steam Stripper shall meet the monitoring requirements set forth in 40 CFR §63.453(g). [§19.304 of Regulation #19 and 40 CFR §63.453(g)]
- N. The Closed Vent System shall meet the monitoring requirements set forth in 40 CFR §63.453(k). [§19.304 of Regulation #19 and 40 CFR §63.453(k)]

Recordkeeping and Reporting Requirements

- O. The permittee shall prepare and maintain a site-specific inspection plan for the closed vent LVHC, HVLC, and SOG collection systems. [§19.304 of Regulation #19 and 40 CFR §63.454(b)]
- P. Excess emissions shall be reported as required by 40 CFR §63.455. [§19.304 of Regulation #19 and 40 CFR §63.455]

251. The permittee may allow emissions from the incinerator and associated scrubber to be released to the atmosphere bypassing the associated candle filter sulfuric acid mist eliminator. Bypass shall only be allowed during periods of emergency maintenance to the sulfuric acid mist eliminator system. [A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Section V: COMPLIANCE PLAN AND SCHEDULE

Georgia-Pacific Corporation - Crossett Paper Operations will continue to operate in compliance with those identified regulatory provisions. The facility will examine and analyze future regulations that may apply and determine their applicability with any necessary action taken on a timely basis.

The following is a list of the Cluster Rule compliance dates that must be met by the permittee.

Pursuant to 40 CFR §63.455, the permittee shall update the Department with a Non-Binding Strategy Report, which identifies the sources to be collected and the scheduled compliance date. The table below contains the current list of sources planned for collection and their associated dates (updated May 9, 2003).

Comment: Page: 1
Insert a compliance plan and schedule if applicable

Table 74 – Compliance Dates for Sources

HVLC Gas Source	Compliance Due Date
<u>Line 2 Washing System</u>	
Knotter surge chest	April 17, 2006
Vibrating drainer	April 17, 2006
Separator Drain Tank	April 17, 2006
<u>Line 1 Washing System</u>	
Pressate tank	April 17, 2006
Separator drain tank	April 17, 2006
Washer stock chest	April 17, 2006
<u>No. 1 Screening System</u>	
Secondary screen supply tank	April 17, 2006
Tertiary screen supply tank	April 17, 2006
Quaternary screen supply tank	April 17, 2006

Section VI: PLANT WIDE CONDITIONS

1. The permittee will notify the Director in writing within thirty (30) days after commencing construction, completing construction, first placing the equipment and/or facility in operation, and reaching the equipment and/or facility target production rate. [Regulation No. 19 '19.704, 40 CFR Part 52, Subpart E, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
2. If the permittee fails to start construction within eighteen months or suspends construction for eighteen months or more, the Director may cancel all or part of this permit. [Regulation No.19 §19.410(B) and 40 CFR Part 52, Subpart E]
3. The permittee must test any equipment scheduled for testing, unless stated in the Specific Conditions of this permit or by any federally regulated requirements, within the following time frames: (1) New Equipment or newly modified equipment within sixty (60) days of achieving the maximum production rate, but no later than 180 days after initial start-up of the permitted source or (2) operating equipment according to the time frames set forth by the Department or within 180 days of permit issuance if no date is specified. The permittee must notify the Department of the scheduled date of compliance testing at least fifteen (15) days in advance of such test. The permittee will submit the compliance test results to the Department within thirty (30) days after completing the testing. [Regulation No.19 §19.702 and/or Regulation No. 18 §18.1002 and A.C.A. §8-4-203 as referenced by A.C.A. §8-4-304 and §8-4-311]
4. The permittee must provide: [Regulation No.19 §19.702 and/or Regulation No.18 §18.1002 and A.C.A. §8-4-203 as referenced by A.C.A. §8-4-304 and §8-4-311]
 - a. Sampling ports adequate for applicable test methods
 - b. Safe sampling platforms
 - c. Safe access to sampling platforms
 - d. Utilities for sampling and testing equipment.
5. The permittee must operate the equipment, control apparatus and emission monitoring equipment within the design limitations. The permittee will maintain the equipment in good condition at all times. [Regulation No.19 §19.303 and A.C.A. §8-4-203 as referenced by A.C.A. §8-4-304 and §8-4-311]
6. This permit subsumes and incorporates all previously issued air permits for this facility. [Regulation No. 26 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
7. The permittee must prepare and implement a Startup, Shutdown, and Malfunction Plan (SSM). If the Department requests a review of the SSM, the permittee will make the SSM available for review. The permittee must keep a copy of the SSM at the source's location and retain all previous versions of the SSM plan for five years. [Regulation No. 19 §19.304 and 40 CFR 63.6(e)(3)]

Comment: Page: 13
Include this condition if the source is subject to a MACT. Delete this condition if no MACT applies.

Chemical Accident Prevention Provisions

8. The permittee shall comply with all applicable provisions of 40 CFR §68.1 through §68.220. [40 CFR Part 68]

Acid Rain (Title IV)

9. The Director prohibits the permittee to cause any emissions exceeding any allowances the source lawfully holds under Title IV of the Act or the regulations promulgated under the Act. No permit revision is required for increases in emissions allowed by allowances acquired pursuant to the acid rain program, if such increases do not require a permit revision under any other applicable requirement. This permit establishes no limit on the number of allowances held by the permittee. However, the source may not use allowances as a defense for noncompliance with any other applicable requirement of this permit or the Act. The permittee will account for any such allowance according to the procedures established in regulations promulgated under Title IV of the Act. [Regulation No. 26 §26.701 and 40 CFR 70.6(a)(4)]

Title VI Provisions

10. The permittee must comply with the standards for labeling of products using ozone-depleting substances. [40 CFR Part 82, Subpart E]

- a. All containers containing a class I or class II substance stored or transported, all products containing a class I substance, and all products directly manufactured with a class I substance must bear the required warning statement if it is being introduced to interstate commerce pursuant to §82.106.
- b. The placement of the required warning statement must comply with the requirements pursuant to §82.108.
- c. The form of the label bearing the required warning must comply with the requirements pursuant to §82.110.
- d. No person may modify, remove, or interfere with the required warning statement except as described in §82.112.

11. The permittee must comply with the standards for recycling and emissions reduction, except as provided for MVACs in Subpart B. [40 CFR Part 82, Subpart F]

- a. Persons opening appliances for maintenance, service, repair, or disposal must comply with the required practices pursuant to §82.156.
- b. Equipment used during the maintenance, service, repair, or disposal of appliances must comply with the standards for recycling and recovery equipment pursuant to §82.158.

- c. Persons performing maintenance, service repair, or disposal of appliances must be certified by an approved technician certification program pursuant to §82.161.
- d. Persons disposing of small appliances, MVACs, and MVAC-like appliances must comply with record keeping requirements pursuant to §82.166. (“MVAC-like appliance” as defined at §82.152.)
- e. Persons owning commercial or industrial process refrigeration equipment must comply with leak repair requirements pursuant to §82.156.
- f. Owners/operators of appliances normally containing 50 or more pounds of refrigerant must keep records of refrigerant purchased and added to such appliances pursuant to §82.166.

12. If the permittee manufactures, transforms, destroys, imports, or exports a class I or class II substance, the permittee is subject to all requirements as specified in 40 CFR Part 82, Subpart A, Production and Consumption Controls.

13. If the permittee performs a service on motor (fleet) vehicles when this service involves ozone-depleting substance refrigerant (or regulated substitute substance) in the motor vehicle air conditioner (MVAC), the permittee is subject to all the applicable requirements as specified in 40 CFR part 82, Subpart B, Servicing of Motor Vehicle Air Conditioners.

The term “motor vehicle” as used in Subpart B does not include a vehicle in which final assembly of the vehicle has not been completed. The term “MVAC” as used in Subpart B does not include the air-tight sealed refrigeration system used as refrigerated cargo, or the system used on passenger buses using HCFC-22 refrigerant.

14. The permittee can switch from any ozone-depleting substance to any alternative listed in the Significant New Alternatives Program (SNAP) promulgated pursuant to 40 CFR Part 82, Subpart G, "Significant New Alternatives Policy Program".

Oil Tank Requirement for SN-19, SN-22, SN-25, and SN-26

15. The permittee shall monitor and record on a daily basis the fuel oil storage tank level which will be used to calculate the as fired sulfur content on a 30-day rolling average. The recorded 30-day rolling average value shall not exceed 1.0% by weight. This record shall be updated on a monthly basis. This report shall be submitted to the Department in accordance with General Provision #7 [§19.705 of Regulation #19 and 40 CFR Part 52 Subpart E]

Future MACT Requirements

16. The permittee shall submit a permit modification application demonstrating how the facility will comply with 40 CFR Part 63, Subpart DDDDD – *National Emission Standards for Industrial, Commercial, and Institutional Boilers and Process Heaters* or submit a notification citing how the current permit demonstrates compliance with the subpart. The Department may extend this deadline by up to one year if so requested by the permittee. Such a request shall detail why such an extension is necessary and shall contain a schedule

for compliance with the MACT rule and submittal of the required application. The application must be submitted by March 13, 2007. [§19.304 of Regulation 19, 40 CFR Part 63, Subpart DDDDD, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Section VII: INSIGNIFICANT ACTIVITIES

The following sources are insignificant activities. Any activity that has a state or federal applicable requirement is a significant activity even if this activity meets the criteria of §304 of Regulation 26 or listed in the table below. Insignificant activity determinations rely upon the information submitted by the permittee in an application dated October 23, 2003.

Table 75 - Insignificant Activities

Description	Category
9A Cyclone	A-13
Trim Paper Cyclone	A-13
Perini Towel Rewinder and Spectrum Towel Printer Baghouse	A-13
Spectrum Towel Printer, utilizing 0.21 wt% VOC, no HAP inks	A-13
Diesel Fuel Tank	A-3
Xylene Tank	A-3
Turpentine Tank	A-3
No. 8 Extruder Burner, 1.55 MMBTU/hr	A-1
No. 8 Extruder Burner, 0.85 MMBTU/hr	A-1
No. 9 Extruder Burners, 1.0 MMBTU/hr (total)	A-1

Pursuant to §26.304 of Regulation 26, the Department determined the emission units, operations, or activities contained in Regulation 19, Appendix A, Group B, to be insignificant activities. Activities included in this list are allowable under this permit and need not be specifically identified.

Section VIII: GENERAL PROVISIONS

1. Any terms or conditions included in this permit which specify and reference Arkansas Pollution Control & Ecology Commission Regulation No. 18 or the Arkansas Water and Air Pollution Control Act (A.C.A. §8-4-101 *et seq.*) as the sole origin of and authority for the terms or conditions are not required under the Clean Air Act or any of its applicable requirements, and are not federally enforceable under the Clean Air Act. Arkansas Pollution Control & Ecology Commission Regulation 18 was adopted pursuant to the Arkansas Water and Air Pollution Control Act (A.C.A. §8-4-101 *et seq.*). Any terms or conditions included in this permit which specify and reference Arkansas Pollution Control & Ecology Commission Regulation 18 or the Arkansas Water and Air Pollution Control Act (A.C.A. §8-4-101 *et seq.*) as the origin of and authority for the terms or conditions are enforceable under this Arkansas statute.[40 CFR 70.6(b)(2)]
2. This permit shall be valid for a period of five (5) years beginning on the date this permit becomes effective and ending five (5) years later. [40 CFR 70.6(a)(2) and §26.701(B) of the Regulations of the Arkansas Operating Air Permit Program (Regulation 26), effective August 10, 2000]
3. The permittee must submit a complete application for permit renewal at least six (6) months before permit expiration. Permit expiration terminates the permittee's right to operate unless the permittee submitted a complete renewal application at least six (6) months before permit expiration. If the permittee submits a complete application, the existing permit will remain in effect until the Department takes final action on the renewal application. The Department will not necessarily notify the permittee when the permit renewal application is due. [Regulation No. 26 §26.406]
4. Where an applicable requirement of the Clean Air Act, as amended, 42 U.S.C. 7401, *et seq.* (Act) is more stringent than an applicable requirement of regulations promulgated under Title IV of the Act, the permit incorporates both provisions into the permit, and the Director or the Administrator can enforce both provisions. [40 CFR 70.6(a)(1)(ii) and Regulation No. 26 §26.701(A)(2)]
5. The permittee must maintain the following records of monitoring information as required by this permit. [40 CFR 70.6(a)(3)(ii)(A) and Regulation No. 26 §26.701(C)(2)]
 - a. The date, place as defined in this permit, and time of sampling or measurements;
 - b. The date(s) analyses performed;
 - c. The company or entity performing the analyses;
 - d. The analytical techniques or methods used;
 - e. The results of such analyses; and
 - f. The operating conditions existing at the time of sampling or measurement.

6. The permittee must retain the records of all required monitoring data and support information for at least 5 years from the date of the monitoring sample, measurement, report, or application. Support information includes all calibration and maintenance records and all original strip-chart recordings for continuous monitoring instrumentation, and copies of all reports required by this permit. [40 CFR 70.6(a)(3)(ii)(B) and Regulation No. 26 §26.701(C)(2)(b)]
7. The permittee must submit reports of all required monitoring every 6 months. If permit establishes no other reporting period, the reporting period shall end on the last day of the anniversary month of the initial Title V permit. The report is due within 30 days of the end of the reporting period. Although the reports are due every six months, each report shall contain a full year of data. The report must clearly identify all instances of deviations from permit requirements. A responsible official as defined in Regulation No. 26 §26.2 must certify all required reports. The permittee will send the reports to the address below: [40 C.F.R. 70.6(a)(3)(iii)(A) and §26.701(C)(3)(a) of Regulation #26]

Arkansas Department of Environmental Quality
Air Division
ATTN: Compliance Inspector Supervisor
Post Office Box 8913
Little Rock, AR 72219

8. The permittee will report to the Department all deviations from permit requirements, including those attributable to upset conditions as defined in the permit.
 - a. For all upset conditions (as defined in Regulation 19.601), the permittee will make an initial report to the Department by the next business day after the discovery of the occurrence. The initial report may be made by telephone and shall include:
 - i. The facility name and location,
 - ii. The process unit or emission source deviating from the permit limit,
 - iii. The permit limit, including the identification of pollutants, from which deviation occurs,
 - iv. The date and time the deviation started,
 - v. The duration of the deviation,
 - vi. The average emissions during the deviation,
 - vii. The probable cause of such deviations,
 - viii. Any corrective actions or preventive measures taken or being taken to prevent such deviations in the future, and
 - ix. The name of the person submitting the report.

The permittee will make a full report in writing to the Department within five (5) business days of discovery of the occurrence. The report must include, in addition to the information required by the initial report, a schedule of actions taken or planned to eliminate future occurrences and/or to minimize the amount the permit's limits were exceeded and to reduce the length of time the limits were exceeded. The permittee may submit a full report in writing (by facsimile, overnight courier, or other means) by the next business day after discovery of the occurrence, and the report will serve as both the initial report and full report.

For all deviations, the permittee will report such events in semi-annual reporting and annual certifications required in this permit. This includes all upset conditions reported in 8a. above. The semi-annual report must include all the information as required in the initial and full report required in 8a. [40 CFR 70.6(a)(3)(iii)(B), Regulation No. 26 §26.701(C)(3)(b), Regulation No. 19 §19.601 and §19.602]

9. If any provision of the permit or the application thereof to any person or circumstance is held invalid, such invalidity will not affect other provisions or applications hereof which can be given effect without the invalid provision or application, and to this end, provisions of this Regulation are declared to be separable and severable. [40 CFR 70.6(a)(5), §26.701(E) of Regulation No. 26, and A.C.A. §8-4-203, as referenced by §8-4-304 and §8-4-311]
10. The permittee must comply with all conditions of this Part 70 permit. Any permit noncompliance with applicable requirements as defined in Regulation No. 26 constitutes a violation of the Clean Air Act, as amended, 42 U.S.C. §7401, *et seq.* and is grounds for enforcement action; for permit termination, revocation and reissuance, for permit modification; or for denial of a permit renewal application. [40 CFR 70.6(a)(6)(i) and Regulation No. 26 §26.701(F)(1)]
11. 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 to maintain compliance with the conditions of this permit. [40 CFR 70.6(a)(6)(ii) and Regulation No. 26 §26.701(F)(2)]
12. The Department may modify, revoke, reopen and reissue the permit or terminate the permit for cause. The filing of a request by the permittee for a permit modification, revocation and reissuance, termination, or of a notification of planned changes or anticipated noncompliance does not stay any permit condition. [40 CFR 70.6(a)(6)(iii) and Regulation No. 26 §26.701(F)(3)]
13. This permit does not convey any property rights of any sort, or any exclusive privilege. [40 CFR 70.6(a)(6)(iv) and Regulation No. 26 §26.701(F)(4)]
14. The permittee must furnish to the Director, within the time specified by the Director, any information that the Director 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. Upon request, the permittee must also furnish to the Director copies of records required by the permit. For information the permittee claims confidentiality, the Department

may require the permittee to furnish such records directly to the Director along with a claim of confidentiality. [40 CFR 70.6(a)(6)(v) and Regulation No. 26 §26.701(F)(5)]

15. The permittee must pay all permit fees in accordance with the procedures established in Regulation No. 9. [40 CFR 70.6(a)(7) and Regulation No. 26 §26.701(G)]
16. No permit revision shall be required, under any approved economic incentives, marketable permits, emissions trading and other similar programs or processes for changes provided for elsewhere in this permit. [40 CFR 70.6(a)(8) and Regulation No. 26 §26.701(H)]
17. If the permit allows different operating scenarios, the permittee will, contemporaneously with making a change from one operating scenario to another, record in a log at the permitted facility a record of the operational scenario. [40 CFR 70.6(a)(9)(i) and Regulation No. 26 §26.701(I)(1)]
18. The Administrator and citizens may enforce under the Act all terms and conditions in this permit, including any provisions designed to limit a source's potential to emit, unless the Department specifically designates terms and conditions of the permit as being federally unenforceable under the Act or under any of its applicable requirements. [40 CFR 70.6(b) and Regulation No. 26 §26.702(A) and (B)]
19. Any document (including reports) required by this permit must contain a certification by a responsible official as defined in Regulation No. 26 §26.2. [40 CFR 70.6(c)(1) and Regulation No. 26 §26.703(A)]
20. The permittee must allow an authorized representative of the Department, upon presentation of credentials, to perform the following: [40 CFR 70.6(c)(2) and Regulation No. 26 §26.703(B)]
 - a. Enter upon the permittee's premises where the permitted source is located or emissions-related activity is conducted, or where records must be kept under the conditions of this permit;
 - b. Have access to and copy, at reasonable times, any records required under the conditions of this permit;
 - c. Inspect at reasonable times any facilities, equipment (including monitoring and air pollution control equipment), practices, or operations regulated or required under this permit; and
 - d. As authorized by the Act, sample or monitor at reasonable times substances or parameters for assuring compliance with this permit or applicable requirements.
21. The permittee will submit a compliance certification with the terms and conditions contained in the permit, including emission limitations, standards, or work practices. The permittee must submit the compliance certification annually within 30 days following the last day of the anniversary month of the initial Title V permit. The permittee must also submit the compliance certification to the Administrator as well as to the Department. All compliance

certifications required by this permit must include the following: [40 CFR 70.6(c)(5) and Regulation No. 26 §26.703(E)(3)]

- a. The identification of each term or condition of the permit that is the basis of the certification;
- b. The compliance status;
- c. Whether compliance was continuous or intermittent;
- d. The method(s) used for determining the compliance status of the source, currently and over the reporting period established by the monitoring requirements of this permit; and
- e. Such other facts as the Department may require elsewhere in this permit or by §114(a)(3) and §504(b) of the Act.

22. Nothing in this permit will alter or affect the following: [Regulation No. 26 §26.704(C)]

- a. The provisions of Section 303 of the Act (emergency orders), including the authority of the Administrator under that section;
- b. The liability of the permittee for any violation of applicable requirements prior to or at the time of permit issuance;
- c. The applicable requirements of the acid rain program, consistent with §408(a) of the Act or,
- d. The ability of EPA to obtain information from a source pursuant to §114 of the Act.

23. This permit authorizes only those pollutant-emitting activities addressed in this permit.
[A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]