Colorado Department
of Public Health
and Environment

OPERATING PERMIT

The Western Sugar Cooperative
Fort Morgan Facility

First Issued: May 1, 1998
Renewed: March 1, 2003
Last Revised: April 13, 2007

AIR POLLUTION CONTROL DIVISION
COLORADO OPERATING PERMIT

FACILITY NAME:	Fort Morgan Facility	OPERATING PERMIT NUMBER
FACILITY ID:	0870001	**95OPMR050**
ISSUE DATE:	May 1, 1998	
RENEWAL DATE:	March 1, 2003	
EXPIRATION DATE:	February 28, 2008	
MODIFICATIONS:	See Appendix F of Permit	

Issued in accordance with the provisions of Colorado Air Pollution Prevention and Control Act, 25-7-101 et seq. and applicable rules and regulations.

ISSUED TO:	PLANT SITE LOCATION:
The Western Sugar Cooperative	**18317 Highway 144**
7555 E. Hampden Avenue, Suite 600	**Fort Morgan, Morgan County**
Denver, CO 80231	**Colorado**

INFORMATION RELIED UPON

Operating Permit Application Received: March 27, 2002

And Additional Information Received: Admin Amend Letter of 4/2/03

Nature of Business:	Manufacture of sugar and by-products from sugar beets
Primary SIC:	2063

RESPONSIBLE OFFICIAL		FACILITY CONTACT PERSON	
Name:	Mr. Inder K. Mathur	Name:	Ms. Patricia Fuller-Pratt
Title:	President & Chief Executive Officer	Title:	Manager of Environmental Affairs
Phone:	(410) 752-6150	Phone:	(303) 813-3519

SUBMITTAL DEADLINES

Semi-Annual Monitoring Period:	March 1 – August 31, September 1 – February 28/29
Semi-Annual Monitoring Report:	October 1, 2003 & April 1, 2004 and subsequent years
Annual Compliance Period:	March 1 – February 28
Annual Compliance Certification:	April 1, 2004 and subsequent years

NOTE: The Semi-Annual Monitoring reports and the Annual Compliance report must be received at the Division office by 5:00 PM on the due date. Postmarked dates will not be accepted for the purposes of determining the timely receipt of those reports.

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SECTION I - General Activities and Summary

1. Permitted Activities

1.1 This facility consists of two coal fired steam boilers with venturi scrubbers, two natural gas fired dryers with cyclones, four beet pulp pellet mills, four sugar granulators (two dryers and two coolers), one natural gas fired boiler, a sugar storage bin dust collection system, lime slaker, powdered sugar production/packaging, and fugitive particulate emissions from truck transport and factory grounds.

The facility is located on the northern edge of the town of Fort Morgan. State Highway 144 borders the southern edge of the site. State Highway 52 borders part of the eastern edge of the site. There is no affected state within 50 miles of the plant. There is no Federal Class I designated area within 100 kilometers of the plant.

1.2 Until such time as this permit expires or is modified or revoked, the permittee is allowed to discharge air pollutants from this facility in accordance with the requirements, limitations, and conditions of this permit.

1.3 This Operating Permit incorporates the applicable requirements contained in the underlying construction permits, and does not affect those applicable requirements, except as modified during review of the application or as modified subsequent to permit issuance using the modification procedures found in Regulation No. 3, Part C. These Part C procedures meet all applicable substantive New Source Review requirements of Part B. Any revisions made using the provisions of Regulation No. 3, Part C shall become new applicable requirements for purposes of this Operating Permit and shall survive reissuance. This Operating Permit incorporates the applicable requirements (except as noted in Section II) from the following Colorado Construction Permit(s):

11MR262 (formerly issued to The Western Sugar Company)
96MR006 (formerly issued to The Western Sugar Company)

1.4 All conditions in this permit are enforceable by the US Environmental Protection Agency, Colorado Air Pollution Control Division (hereinafter Division) and its agents, and citizens unless otherwise specified. **State-only enforceable conditions are:**

Section IV - Condition 14 (Odor)
Condition 18 (Ozone Depleting Compounds as noted)

1.5 All information gathered pursuant to the requirements of this permit is subject to the Record keeping and Reporting requirements listed under Condition 22 of the General Conditions in Section IV of this permit.

2. Alternative Operating Scenarios

2.1 The permittee shall be allowed to make the following changes to its method of operation without applying for a revision of this permit.

2.1.1.1 The facility is scheduled to replace and upgrade the control equipment for the conveyor transfer points and silo filling (S006).

2.1.1.2 For the conveyor transfer points and silo filling (S006), Section II, Conditions 6.1 - 6.4 (S006a) shall apply so long as the Wheelabrator control device is in place and operating.

2.1.1.3 For the conveyor transfer points and silo filling (S006), Section II, Conditions 6.5 - 6.8 (S006b) shall apply after the removal of the Wheelabrator control device and the installation of replacement control equipment.

3. Accidental Release 112(r)

3.1 Based on the information provided by the applicant, this facility is not subject to the provisions of the Accidental Release Prevention Program (Section 112(r) of the Federal Clean Air Act).

4. Prevention of Significant Deterioration (PSD)

4.1 This facility is located in an area designated as attainment for all pollutants. It is categorized as a major stationary source (Potential to Emit > 250 tons per year) for nitrogen oxides, carbon monoxide, sulfur dioxide, and particulate matter small than 10 microns (PM_{10}). Future modifications at this facility resulting in a significant net emissions increase (see Colorado Regulation No. 3, Part A, Section I.B.37 and 58) for any pollutant as listed in Colorado Regulation No. 3, Part A, Section I.B.58 or a modification that is major by itself may result in the application of the PSD review requirements.

4.2 No other Operating Permits are associated with this facility for purposes of determining the applicability of Prevention of Significant Deterioration regulations.

5. Compliance Assurance Monitoring (CAM)

5.1 The following emission units at this facility use a control device to achieve compliance with an emission limitation or standard to which they are subject and have pre-control emissions that exceed or are equivalent to the major source threshold. They are therefore subject to the provisions of the CAM program as set forth in 40 CFR Part 64 as adopted by reference into Colorado Regulation No. 3, Part C, Section XIV.

S001: Venturi Scrubbers for the two Babcock and Wilcox coal-fired steam boilers – See Appendix G of this Operating Permit for the CAM plan for the wet scrubbers used to control the particulate and sulfur dioxide emissions.

6. Summary of Emission Units

6.1 The emission units regulated by this permit are the following:

Emission Unit Number	AIRS Stack Number	Facility Identifier	Description	Pollution Control Device	Existing Construction Permit
S001	001		Two Babcock and Wilcox Stoker-Coal-Fired Steam Boilers with Detroit Stoker Model Rotograte RG-4 #2016 and 2017 (Job # RG 859), Each with a Maximum Heat Input Rate of 196 MMBtu/hr.	Two Venturi (Wet) Scrubbers, Chevron Type Mist Eliminator, Two American Standard Series 361 Fly Ash Collectors.	11MR262
S002	003		Two Stearns/Rogers, Peabody Type MU24 (Order # 32971, 34882 -1952), Natural Gas Fired Beet Pulp Dryers (Boilers) Each With a Maximum Heat Input Rate of 50 MMBtu/hr. Two Sets of Four Emtrol, Model 72VL800, Cyclones are used to capture the dried pulp.	None	Grandfathered
S003	006		Four Beet Pulp Pellet mills and Coolers.	In-House Designed Cyclone	Grandfathered
S004	004	S004a	East Sugar Granulator consisting of a steam heated rotary dryers and ambient air cooled rotary cooler.	In-House Designed Dust Box and In-House Designed Wet Scrubber on Each Dryer One Sly TubeJet Pulse Jet Baghouse serves both Coolers	Grandfathered
		S004b	West Sugar Granulator consisting of a steam heated rotary dryers and ambient air cooled rotary cooler.		Grandfathered

Emission Unit Number	AIRS Stack Number	Facility Identifier	Description	Pollution Control Device	Existing Construction Permit
S006	011	S006a	Conveyor Transfer Points and Silo Filling. Dust is picked up from the transfer points, loading areas, and from the displacement of air from silo filling. (EXISTING)	Wheelabrator 126-D, Sock Type Dust Collector (For 9 Bins)	Grandfathered
S006	011	S006b	Conveyor Transfer Points and Silo Filling (13 Silos). Dust is picked up from the transfer points, loading areas, and from the displacement of air from silo filling. (PLANNED)	Two Sly PleatJet Baghouses for Dust Collection from Conveying, Elevators, Production Scales, Screens, and Bins Model 5-5-SB MikroPulsaire Baghouse, or equivalent, for Powered Bin Vents Model 9S-4-5	Grandfathered
S007	007		Slaking/Hydration of Calcium Oxide from Lime Kiln.	Ducon Wet Scrubber	Grandfathered
S008	012		Fugitive Dust Emissions from Truck Traffic and Exposed Grounds.	Watering, Speed Limits, Gravel, Minimal Disturbance, Natural Vegetation	Grandfathered
S010	010		Two Powdered Sugar Mills	Two Fabric Filter Air Systems Baghouses, Model 121R-10-TRL Serial Number 5222-A	96MR006
S013	013		Powdered Sugar Production Line Packer	One Hosakawa/Mikro-Pulsair Baghouse, Model 64S-8 20 Serial Number 701H-98	
S014	014		Fine Granulated Sugar Industrial Bag Packaging Line & Warehouse	Torit/Day (Donaldson) 3-18 Cartridge Dust Collector Serial Number IG404332-001	
S015	015		Starch unloading & Selected Powdered Sugar Packaging Line Points including bag blow-off housing, ultrasonic sealer, packaging alignment conveyors, packaging fill station hood and other associated equipment	Sly STJ-1215-10WIP, Serial Number RP6-0460	
S017	017		Facility-wide ammonia emissions	None	Grandfathered

SECTION II - Specific Permit Terms

1. S001 - Two Babcock and Wilcox Coal-Fired Steam Boilers

With Detroit Stoker Model Rotograte RG-4 #2016 and 2017 (Job # RG 859)

NOTE: The terms and conditions apply to each boiler separately

Parameter	Permit Condition Number	Limitations	Emission Factor	Monitoring	
				Method	Interval
PM	1.1	$0.5(FI)^{-0.26}$ lb/MMBtu 0.13 lb/MMBtu	1.76 lbs/Ton	Record keeping and calculation, Heat Content Monitoring	Monthly
SO_2	1.2	1.8 lb/MMBtu	0.777 lbs/Ton	Record keeping and calculation, Sulfur and Heat Content Monitoring	
NOx	1.3		14.0 lbs/Ton	Record keeping & Calculation	Annually
CO			5.0 lbs/Ton		
VOC			0.07 lbs/Ton		
PM_{10}			0.29 lbs/Ton		
Fuel Composition	1.4	Sodium content of ash < 0.25 lb/MMBtu Ash to sodium Ratio > 40; Measurement of fuel heat content, MMBtu/Ton, Ash and sulfur weight percent, Sulfur Content		ASTM or Division approved methods	Per Fuel Shipment
CAM Plan	1.5			DAS	Per Approved Plan
Fuel Use	1.6			Tracking, Coal Shipment Data	Daily
Opacity	1.7	Not to exceed 30% for a period or periods aggregating more than six (6) minutes in any sixty (60) consecutive minutes		EPA Method 9	See Condition 1.7
	1.8	Not to exceed 20%			See Condition 1.8
Compliance Test	1.9	PM = 0.13 lbs/MMBtu SO_2 =1.8 lbs/MMBtu		Stack Test	Within 60 days of issuance and within 18 months prior to permit expiration

1.1 This source shall not emit or cause to be emitted total particulate emissions in excess of the limitation set by the Colorado Regulation No. 1, Section III, A.1.b. where the limit in pounds per million Btu of heat input is calculated from the equation $PE = 0.5(FI)^{-0.26}$, where PE = Particulate Emissions in lbs/MMBtu and FI = Fuel input in million Btu per hour.

The total particulate emission limit is set at 0.13 pounds per million Btu of heat input by a direct modification of Colorado Construction Permit 11MR262 in this Operating Permit in accordance with Section I, Condition 1.3 of this Operating Permit.

1.1.1 Particulate matter emissions in lbs/MMBtu shall be calculated once per month using the most recent heat content value and the emission factor listed in the summary table above. Particulate matter emissions shall be calculated using the equation below and compared to 0.13 lbs/MMBtu of heat input to determine compliance.

$$PM = \frac{\text{lbs}}{\text{MMBtu}} = \frac{1.76 \ \frac{\text{lbs PM}}{\text{ton coal}}}{\text{Heat Content of Coal} \ (\frac{\text{MMBtu}}{\text{ton}})}$$

1.1.2 The emission factor listed in the summary table above and the annual coal consumption shall be used to calculate annual particulate emissions for each boiler.

Tons/Year = [(EF) X (Fuel Use in Tons/Year) / (2000 lbs/Ton)]

1.2 This source shall not emit or cause to be emitted sulfur dioxide emissions in excess of the limitation stated in the summary table above based upon the manufacturer's guaranteed maximum heat input rate for each boiler (Colorado Regulation 1, Section VI, A.3.a.i and Colorado Construction Permit 11MR262).

1.2.1 Emissions of sulfur dioxide in lbs/MMBtu shall be calculated once per month using the most recent heat content value and the emission factor listed in the summary table above. Sulfur dioxide emissions shall be calculated using the equation listed below and compared to 1.8 lb/MMBtu of heat input to determine compliance.

$$SO_2 = \frac{\text{lbs}}{\text{MMBtu}} = \frac{0.777 \ \frac{\text{lbs } SO_2}{\text{ton coal}}}{\text{Heat Content of Coal} \ (\frac{\text{MMBtu}}{\text{ton}})}$$

1.2.2 The emission factor listed in the summary table above and annual fuel consumption shall be used to calculate the annual sulfur dioxide emissions.

Tons/Year = (EF) X (Fuel Use in Tons/Year) / (2000 lbs/Ton)

1.3 The emission factors listed in the summary table above and the annual fuel consumption shall be used to calculate the annual nitrogen oxides, carbon monoxide and particulate matter small than 10 microns.

Tons/Year = (EF) X (Fuel Use in Tons/Year) / (2000 lbs/Ton)

1.4 The heat content (MMBtu/Ton), sulfur, sodium, and ash content of the coal used to fuel the boilers shall be determined with each delivery of coal. The sodium in the coal ash shall not exceed 0.25 lbs/MMBtu or the ash to sodium ratio shall be greater than 40.

1.4.1 The appropriate ASTM method or equivalent method approved in writing by the Division shall be used to perform the following tests:

1. Coal sampling
2. Sample preparation and air dry loss
3. Total moisture in the coal sample
4. Fusibility of coal and coke ash
5. Btu analysis
6. Sulfur analysis
7. Ash analysis
8. Sodium analysis

1.4.2 Calculation of emissions shall be made using the Btu value derived from the current running average of fuel shipment results for the month.

1.5 The American Standard multiclones, venturi scrubbers, and chevron type mist eliminator shall be maintained and operated in accordance with the manufacturer's instructions and good engineering practices to minimize emissions and ensure compliance with the particulate matter, sulfur dioxide, and opacity standards. The approved Compliance Assurance Monitoring (CAM) plan is provided in Appendix G of this Operating Permit.

1.5.1. Process equipment and associated piping/duct work for all control equipment shall be maintained and operated so there is no leakage of air contaminants to the atmosphere prior to treatment by the control devices.

1.5.2. Records of control equipment and associated piping/ducts maintenance shall be maintained and made available for Division review upon request.

1.6 Fuel use shall be determined by tracking the number of coal cars used per day. Annual use of coal shall be estimated based upon the number of coal cars used, coal shipment data, and coal remaining at the end of the campaign.

1.7 Opacity of emissions during fire building, cleaning of fireboxes, soot blowing, start-up, process modifications, or adjustment of control equipment shall not exceed 30% for a period or periods aggregating more than six (6) minutes in any sixty (60) consecutive minutes (Colorado Regulation No. 1, Section II.A.4). Compliance with this standard shall be determined by conducting opacity observations in accordance with EPA Reference Method 9. Readings shall be conducted within one hour of commencement of any of the above activities and every 24 hours thereafter during the activity.

1.7.1 A Method 9 opacity observation shall be performed within 24 hours of the commencement of any of the above activities, including startup. The startup period shall begin when a fire is first lit and end when sufficient steam pressure is present to operate the wet scrubbers.

1.7.2 A Method 9 opacity observation shall be performed every calendar day during the activity period. For startup, this includes any period when the boilers are backed-down such that steam pressure is unavailable for the wet scrubbers. The startup parameter report previously approved by the Division shall be used in identification of when the emission unit is in a startup mode.

1.8 Opacity shall not exceed 20% as stated in Colorado Regulation No. 1, Section II.A. Opacity observations shall be performed using EPA Method 9.

1.8.1 A Method 9 opacity observation of emissions shall be performed within one calendar day of the completion of startup.

1.8.2 Following each startup, Method 9 opacity observations shall be performed every other week during boiler operation, except as noted below.

1.8.2.1 If after eight (8) weeks no Method 9 result (6 minute average) has exceeded 10% opacity, then the required frequency of Method 9 opacity observations shall become monthly. The frequency shall revert back to every other week should any Method 9 opacity observation result (6 minute average) indicate opacity exceeding 10%. The required frequency of this monitoring will again go to monthly should observations indicate no Method 9 result (6 minute average) has exceeded 10% opacity for eight (8) weeks.

(Note: The 10% opacity level is used only to govern monitoring frequency - it is not a limit)

1.9 A compliance test shall be conducted within eighteen (18) calendar months prior to the expiration date of this Operating Permit.

The compliance test shall be performed at the maximum production rate. The compliance test shall measure the emission rate(s) for the pollutants listed below. The test protocol must be in accordance with the requirements of the Air Pollution Control Division Compliance Test Manual and shall be submitted to the Division for review and approval at least thirty (30) calendar days prior to the compliance test. No compliance test for an official demonstration of compliance shall be conducted without prior approval from the Division.

Particulate Matter using EPA or Division approved methods.

Sulfur Dioxide using EPA or Division approved methods.

A stack testing protocol shall be submitted for Division approval at least thirty (30) calendar days prior to any performance of the test required under this condition. No stack test required herein shall be performed without prior written approval by the Division. The Division reserves the right to witness the test. In order to facilitate the Division's ability to make plans to witness the test, notice of the date(s) for the stack test shall be submitted to the Division at least thirty (30) calendar days prior to the test. The Division may for good cause shown, waive this thirty (30) day notice requirement. In instances when a scheduling conflict is presented, the Division shall immediately contact Western Sugar in order to explore the possibility of making modifications to the stack test schedule. The required number of copies of the compliance test results shall be submitted to the Division within forty-five (45) calendar days of the completion of the test unless a longer period is approved by the Division. **(ver 4/18/02)**

1.9.1 Particulate matter and sulfur dioxide emission rates shall be measured in pounds per hour and pounds per million Btu of heat input and compared to the pounds per hour and pounds per million Btu limit in the summary table above for compliance purposes.

1.9.2 The Btu content of the coal used shall be measured in accordance with the most appropriate ASTM method or an equivalent method approved in writing by the Division.

1.9.3 In the event that the compliance test demonstrates non-compliance for either particulate matter or sulfur dioxide emissions, the Division may re-open this permit to adjust the frequency and/or stringency of monitoring in order to ensure compliance with the particulate and sulfur dioxide standards.

2. S002 - Two Stearns/Rogers, Peabody Type MU24 (Order # 32971, 34882-1952)

Natural Gas Fired Beet Pulp Dryers (Boilers)

NOTE: The following terms and conditions apply to each boiler separately

Parameter	Permit Condition Number	Limitations	Emission Factor	Monitoring	
				Method	Interval
NOx	2.1		0.189 lb/ton	Record keeping and calculation	Annually
SO_2			0.0288 lb/ton		
VOC			0.376 lb/ton		
CO			2.244 lb/ton		
PM_{10}			0.564 lb/ton		
Natural Gas Fuel Use				Fuel Meter, Record keeping	Annually
PM	2.2	$3.59(P)^{0.62}$ pounds/hour	0.564 lb/ton	Fuel Restriction & Record keeping	Monthly
Opacity	2.3	Less than or equal to 20%		EPA Method 9 & Visual Checks	Monthly - Then 1 per Campaign
Cyclone Operation	2.4	Mftrs Recommendations & Good Engineering Practices		Maintenance & Record keeping	As Needed
Pulp Throughput	2.5	25 ton/hour		Record keeping and calculation	Annually
Hours of Operation	2.6			Record keeping and calculation	As Operated

2.1 Source shall perform the following annually:

2.1.1 Annual emissions for each boiler/dryer unit shall be calculated using the emission factor listed in the summary table above and annual beet pulp throughput.

2.1.2 Natural gas fuel use shall be measured and recorded annually.

2.2 Particulate Matter (PM) emissions shall not exceed the limit set by the Colorado Regulation No. 1, Section III.C.1.a equation $PE = 3.59(P)^{0.62}$ where PE = particulate matter emission rate in pounds per hour and P = Process Weight Rate in tons per hour.

2.2.1 Emissions for each boiler/dryer unit shall be calculated monthly using the emission factor listed in the summary table above and monthly beet pulp

throughput. Emissions shall also be calculated annually for fee and inventory purposes.

2.3 Opacity shall not exceed 20% as stated in Colorado Regulation No. 1, Section II.A. Opacity observations shall be performed using EPA Method 9. The following monitoring requirements apply during periods of operation:

2.3.1 An opacity observation of emissions shall be performed monthly, during normal operations, for the first campaign following the issuance of this permit. After the one year period, EPA Method 9 observations shall be on a frequency as described below:

2.3.1.1 If after one (1) campaign no Method 9 result (6 minute average) has exceeded 10% opacity, then the required frequency of Method 9 opacity observations shall become once per campaign. The frequency shall revert back to monthly for a one (1) year period should any Method 9 opacity observation result (6 minute average) indicate opacity exceeding 10%. The required frequency of this monitoring will again go to once per campaign should observations indicate no Method 9 result (6 minute average) has exceeded 10% opacity for one (1) year.

(Note: The 10% opacity level is used only to govern monitoring frequency - it is not a limit)

2.3.2 A check for visible emissions (**not** EPA Method 9) shall be performed monthly. If visible emissions, other than steam, are observed, the source shall:

2.3.2.1 Verify that the process and control equipment are operating properly.

2.3.2.2 Perform any maintenance or adjustments needed to minimize visible emissions and ensure that the process and control equipment are operating properly.

2.3.2.3 Record any maintenance or adjustments performed in order to minimize visible emissions and ensure proper operation.

2.3.2.4 Conduct an additional check of visible emissions (**not** EPA Method 9) after performing the above activities. Should visible emissions still persist, the source shall perform an Method 9 observation within 24 hours.

2.4 The Emtrol cyclones shall be maintained and operated in accordance with the manufacturer's recommendations and good engineering practices to minimize emissions and ensure compliance with the particulate and opacity standards. Specifically:

2.4.1 Combustion air and exhaust fans shall be operated when boiler/dryers are in use.

2.4.2 Process equipment shall be maintained and operated so that there is no leakage of air contaminants to the atmosphere prior to treatment by the cyclones.

2.4.3 Records of cyclone maintenance shall be maintained and made available for Division review upon request.

2.5 Records of the actual beet pulp throughput shall be maintained for use in emissions calculations.

2.5.1 The design rate of 25 tons per hour for each boiler/dryer unit shall not be exceeded.

2.6 Records of the run-time operating hours for each boiler/dryer shall be maintained for use in emissions calculations.

3. S003 - Four Beet Pulp Pellet Mills and Coolers

Parameter	Permit Condition Number	Limitations	Emission Factors	Monitoring	
				Method	Interval
PM	3.1	$3.59(P)^{0.62}$ lbs/hr	0.75 lbs/Ton	Record keeping, Calculation	Monthly
PM_{10}			0.45 lbs/Ton		
Pulp Throughput	3.2		N/A	By Calculation	Monthly
Opacity	3.3	Less than or equal to 20%	N/A	EPA Method 9 & Visual Checks	Monthly - Then 1 per Campaign
Cyclone Operation	3.4	Good Engineering Practices	N/A	Maintenance & Record keeping	As Needed
Hours of Operation	3.5		N/A	Record keeping	As Operated

3.1. Particulate Matter (PM) emissions shall not exceed the Colorado Regulation No. 1, Section III.C.1.a. limit calculated from the equation $PE = 3.59(P)^{0.62}$, where PE = particulate emissions in pounds per hour, and P = Process weight rate in tons per hour

3.1.1 Emissions of particulate matter shall be calculated using the emission factors listed in the summary table above, beet pulp processed, and hours of operation. Since each mill is identical, total emissions are the equivalent of a single mill processing all of the pulp. The following equation is used:

Tons/Month = (EF) X (Total Beet Pulp Processed in Tons/Month) / (2000 lbs/ton)

3.1.2 Average hourly emissions shall be calculated monthly from the monthly emissions (pounds/month) divided by the monthly hours of operation. Annual emissions shall be calculated from the sum of the monthly emissions for the respective calendar year.

3.2 Beet pulp throughput shall be determined on a monthly basis as follows:

3.2.1 The tonnage of beet pulp sent to the pulp dryers (S002) shall be measured.

3.2.2 The moisture content of the wet pulp going into the dryers and dry pulp coming out of the dryers shall both be measured.

3.2.3 The tonnage of dry beet pulp sent to the pellet mills shall then be calculated using the initial tonnage of Condition 3.2.1 and the change in moisture content determined by Condition 3.2.2. The monthly throughput shall be used to calculate the annual throughput for emissions calculation purposes.

3.3 Opacity shall not exceed 20% as stated in Colorado Regulation No. 1, Section II.A. Opacity observations shall be performed using EPA Method 9. The following monitoring requirements apply during periods of operation:

3.3.1 An opacity observation of emissions shall be performed monthly, during normal operations, for the first campaign following the issuance of this permit. After the one year period, Method 9 observations shall be on a frequency as described below:

3.3.1.1 If after one (1) campaign no Method 9 result (6 minute average) has exceeded 10% opacity, then the required frequency of Method 9 visual observations shall become once per campaign. The frequency shall revert back to monthly for a one (1) year period should any Method 9 observation result (6 minute average) indicate opacity exceeding 10%. The required frequency of this monitoring will again go to once per campaign should observations indicate no Method 9 result (6 minute average) has exceeded 10% opacity for one (1) year.

(Note: The 10% opacity level is used only to govern monitoring frequency - it is not a limit)

3.3.2 A check for visible emissions (not Method 9) shall be performed monthly. If visible emissions, other than steam, are observed, the source shall:

3.3.2.1 Verify that the process and control equipment are operating properly.

3.3.2.2 Perform any maintenance or adjustments needed to minimize visible emissions and ensure that the process and control equipment are operating properly.

3.3.2.3 Record any maintenance or adjustments performed in order to minimize visible emissions and ensure proper operation.

3.3.2.4 Conduct an additional check of visible emissions (**not** Method 9) after performing the above activities. Should visible emissions still persist, the source shall perform an Method 9 observation within 24 hours.

3.4 The cyclone shall be maintained and operated in accordance with good engineering practices to minimize emissions and ensure compliance with the particulate and opacity standards. Specifically:

3.4.1 Exhaust fans shall be operated when mills are in use.

3.4.2 Process equipment shall be maintained and operated so that there is no leakage of air contaminants to the atmosphere prior to treatment by the cyclones.

3.4.3 Records of cyclone and associated duct maintenance shall be maintained and made available for Division review upon request.

3.5 Records of the run-time operating hours shall be maintained for use in emissions calculations.

4. S004a - East and West Sugar Granulators -Two Steam Heated Rotary Dryers

NOTE: The following terms and conditions apply to each granulator separately

Parameter	Permit Condition Number	Limitations	Emission Factors	Monitoring	
				Method	Interval
PM	4.1	$3.59(P)^{0.62}$ pounds/hour	0.128 pounds/Ton	Record keeping and Calculation	Monthly
PM_{10}					
Opacity	4.2	Less than or equal to 20%		Visual Checks, Maintenance, EPA Method 9	Monthly Checks and EPA Method 9 as Needed
Dust Box Operation	4.3	Good Engineering Practices		Maintenance & Record keeping	As Needed
Hours of Operation	4.4			Record keeping and calculation	As Operated

4.1. Particulate Matter (PM) emissions from each dryer shall not exceed the Colorado Regulation No. 1, Section III.C.1.a. limit set by the equation $PE = 3.59(P)^{0.62}$ where PE = particulate emissions in pounds per hour lbs/hr and P = Process weight rate in tons per hour.

4.1.1 Annual and average hourly emissions of particulate matter and particulate matter smaller than 10 microns for each dryer shall be calculated using the emission factors listed in the summary table above, sugar processed, and monthly hours of operation in the following equation:

Lbs/Month = (EF) X (Sugar Processed in Tons/Month)

4.1.2 Average hourly emissions shall be calculated monthly from the monthly emissions (pounds/month) divided by monthly hours of operation. Annual emissions shall be calculated from the sum of the monthly emissions for the respective calendar year.

4.1.3 Sugar throughput tonnage shall be measured and recorded annually.

4.2 Opacity shall not exceed 20% as stated in Colorado Regulation No. 1, Section II.A. Opacity observations shall be performed using Method 9. The following monitoring requirements apply during periods of operation:

4.2.1 A check of visible emissions (not EPA Method 9) shall be performed monthly. If visible emissions, other than steam, are observed, the source shall:

4.2.1.1 Verify that the process and control equipment are operating properly.

4.2.1.2 Perform any maintenance or adjustments needed to minimize visible emissions and ensure that the process and control equipment are operating properly.

4.2.1.3 Record any maintenance or adjustments performed in order to minimize visible emissions and ensure proper operation.

4.2.1.4 Conduct an additional check of visible emissions (**not** Method 9) after performing the above activities. Should visible emissions still persist, the source shall perform an Method 9 observation within 24 hours.

4.2.2 Should any Method 9 observation result (6 minute average) indicate opacity exceeding 10%, the source shall perform monthly Method 9 visual observations for the subsequent four (4) months. The source shall continue the visual observations into the next campaign (or period of operation) should the existing campaign end before all required observations are performed.

(Note: The 10% opacity level is used only to govern monitoring frequency - it is not a limit)

4.3 The dryer control equipment shall be maintained and operated in accordance with good engineering practices to minimize emissions and ensure compliance with the particulate and opacity standards. Specifically:

4.3.1 Inlet air and exhaust fans shall be operated when granulators are in use. Water spray shall be sufficient to minimize opacity and/or particulate emissions.

4.3.2 Process equipment shall be maintained and operated so that there is no leakage of air contaminants to the atmosphere prior to treatment by the cyclones.

4.3.3 Records of dust box maintenance shall be maintained and made available for Division review upon request.

4.4 Records of the run-time operating hours for each dryer shall be maintained for use in emissions calculations.

5. S004b - East and West Sugar Granulators - Two Ambient Air Coolers

NOTE: The following terms and conditions apply to each granulator separately

Parameter	Permit Condition Number	Limitations	Compliance Emission Factors	Monitoring	
				Method	Interval
PM	5.1	$3.59(P)^{0.62}$ pounds/hour	0.008 lbs/Ton	Record keeping Calculation	Monthly
PM_{10}			0.008 lbs/Ton		
Opacity	5.2	Less than or equal to 20%		Visual Checks, Maintenance, EPA Method 9	Monthly Checks and EPA Method 9 as Needed
Dust Box Operation	5.3	Mftrs Recommendations & Good Engineering Practices		Maintenance & Record keeping	As Needed
Hours of Operation	5.4			Record keeping	As Operated

5.1 Particulate Matter (PM) emissions from each dryer shall not exceed the Colorado Regulation No. 1, Section III.C.1.a. limit set by the equation $PE = 3.59(P)^{0.62}$ where PE = particulate emissions in pounds per hour lbs/hr and P = Process weight rate in tons per hour.

5.1.1 For the coolers, the allowable Particulate Emissions (PE) rate shall be calculated using the process weight rate for both coolers combined (coolers are connected to a single control device).

5.1.2 Annual and average hourly emissions of PM and PM_{10}, for the coolers, shall be calculated using the emission factors listed above (Source Provided Emission Factors - Includes Control Efficiency), sugar processed, and monthly hours of operation in the following equation:

Lbs/Month = (EF) X (Sugar Processed in Tons/Month)

5.1.3 Average hourly emissions shall be calculated monthly from the monthly emissions (lbs/month) divided by monthly hours of operation. Annual emissions shall be calculated yearly from the sum of the monthly emissions for the respective calendar year.

5.1.4 Sugar throughput tonnage shall be measured and recorded annually.

5.2 Opacity shall not exceed 20% as stated in Colorado Regulation No. 1, Section II, A. Visual observations shall be performed using EPA Method 9. The following monitoring requirements apply during periods of operation:

5.2.1 A check of visible emissions (**not** EPA Method 9) shall be performed monthly. Should visible emissions, other than steam, be observed, the source shall:

5.2.1.1 Verify that the process and control equipment are operating properly.

5.2.1.2 Perform any maintenance or adjustments needed to minimize visible emissions and ensure that the process and control equipment are operating properly.

5.2.1.3 Record any maintenance or adjustments performed in order to minimize visible emissions and ensure proper operation.

5.2.1.4 Conduct an additional check of visible emissions (not EPA Method 9) after performing the above activities. Should visible emissions still persist, the source shall perform an EPA Method 9 observation within 24 hours.

5.2.2 Should any EPA Method 9 observation result (6 minute average) indicate opacity exceeding 10%, the source shall perform monthly Method 9 visual observations for the subsequent four (4) months. The source shall continue the visual observations into the next campaign (or period of operation) should the existing campaign end before all required observations are performed.

(Note: The 10% opacity level is used only to govern monitoring frequency - it is not a limit)

5.3 The cooler's control equipment shall be maintained and operated in accordance with manufacturer's recommendations and good engineering practices to minimize emissions and ensure compliance with the particulate and opacity standards. Specifically:

5.3.1 Inlet air and exhaust fans shall be operated when coolers are in use.

5.3.2 Process equipment shall be maintained and operated so that there is no leakage of air contaminants to the atmosphere prior to treatment by the baghouse.

5.3.3 Records of baghouse maintenance shall be maintained and made available for Division review upon request.

5.4 Records of the run-time operating hours for the coolers shall be maintained for use in emissions calculations.

6. S006a - Conveyor Transfer Points and Silo Filling

Wheelabrator as Control Equipment (Existing)

Parameter	Permit Condition Number	Limitations	Compliance Emission Factors	Monitoring	
				Method	Interval
PM	6.1*	$17.31(P)^{0.16}$ pounds/hour	0.057 lb/ton	Record keeping, Calculation	Monthly
PM_{10}			0.029 lb/ton		
Sugar Production or Sugar Shipped				Record keeping	Monthly
Opacity	6.2*	Less than or equal to 20%		Visual Checks, Maintenance, EPA Method 9	Monthly Checks and EPA Method 9 as Needed
Control Equipment Operation	6.3*	Mftrs Recommendations & Good Engineering Practices		Maintenance & Record keeping	As Needed
Hours of Operation	6.4*			Record keeping	Annually

*Conditions under S006b apply after the removal of the Wheelabrator control device. (See Section I, Condition 2.1 of this Operating Permit)

6.1 Particulate Matter (PM) emissions shall not exceed the Colorado Regulation No. 1, Section III.C.1.b limit set by the equation $PE = 17.31(P)^{0.16}$ where PE = particulate emissions in pounds per hour lbs/hr and P = Process weight rate in tons per hour.

6.1.1 Emissions shall be calculated monthly using the emission factor listed in the summary table above (EPA AP-42 reference document, Section 13.2.4 Ver1/95) and monthly sugar production or quantity of sugar shipped. Monthly production shall be recorded during the Beet campaign and sugar shipments during the "Inter" campaign. Emissions shall also be calculated annually for fee and inventory purposes.

6.2 Opacity shall not exceed 20% as stated in Regulation No. 1, Section II, A. Visual observations shall be performed using EPA Method 9. The following monitoring requirements apply during periods of operation:

6.2.1 A check of visible emissions (**not** EPA Method 9) shall be performed monthly. Should visible emissions, other than steam, be observed, the source shall:

6.2.1.1 Verify that the process and control equipment are operating properly.

6.2.1.2 Perform any maintenance or adjustments needed to minimize visible emissions and ensure that the process and control equipment are operating properly.

6.2.1.3 Record any maintenance or adjustments performed in order to minimize visible emissions and ensure proper operation.

6.2.1.4 Conduct an additional check of visible emissions (not EPA Method 9) after performing the above activities. Should visible emissions still persist, the source shall perform an EPA Method 9 observation within 24 hours.

6.2.2 Should any EPA Method 9 observation result (6 minute average) indicate opacity exceeding 10%, the source shall perform monthly Method 9 visual observations for the subsequent four (4) months. The source shall continue the visual observations into the next campaign (or period of operation) should the existing campaign end before all required observations are performed.

(Note: The 10% opacity level is used only to govern monitoring frequency - it is not a limit)

6.3 The Wheelabrator 126-D shall be maintained and operated in accordance with the manufacturer's recommendations and good engineering practices to minimize emissions and ensure compliance with the particulate and opacity standards. Specifically:

6.3.1 Exhaust fans shall be operated whenever "fugitive" type emissions are present.

6.3.2 Equipment and storage vessels shall be maintained and operated to minimize leakage of air contaminants to the atmosphere prior to treatment by the Wheelabrator.

6.3.3 The device shall be inspected monthly to ensure that no tears or leaks are present. Records of maintenance shall be maintained and made available for Division review upon request.

6.4 The source shall track the hours of operation for purposes of determining lbs/hr emissions under Condition 6.1

7. S006b - Conveyor Transfer Points and Silo Filling

Baghouse Upgrade as Control Equipment (Future)

Parameter	Permit Condition Number	Limitations	Compliance Emission Factors	Monitoring	
				Method	Interval
PM & PM_{10}	7.1*	$17.31(P)^{0.16}$ pounds/hour	Dust Collectors - 0.013 lb/ton ---------- Bin Vent Collector- 0.0064 lbs/ton	Record keeping, Calculation	Monthly
Sugar Production or Sugar Shipped				Record keeping	Monthly
Opacity	7.2*	Less than or equal to 20%		Visual Checks, Maintenance, EPA Method 9	Monthly Checks and EPA Method 9 as Needed
Control Equipment Operation	7.3*	Mftrs Recommendations & Good Engineering Practices		Maintenance & Record keeping	As Needed
Hours of Operation	7.4*			Record keeping	Annually

*Conditions under S006a apply while the Wheelabrator control device is in place and operating. (See Section I, Condition 2.1 of this Operating Permit)

7.1 Particulate Matter (PM) emissions shall not exceed the Colorado Regulation No. 1, Section III.C.1.b limit set by the equation PE = $17.31(P)^{0.16}$ where PE = particulate emissions in pounds per hour lbs/hr and P = Process weight rate in tons per hour.

7.1.1 Emissions from each unit shall be calculated monthly using the emission factor listed above (Manufacturer Derived and Include Control efficiency) and monthly sugar production or quantity of sugar shipped. Source will record monthly production during the Beet campaign and sugar shipments during the "Inner" campaign. Emissions shall also be calculated annually for fee and inventory purposes.

7.1.2 Note that "Dust Collectors" refers to the two (2) Sly PleatJet control devices while "Bin Vent Collector" refers to the MicroPulseaire unit.

7.2 Opacity shall not exceed 20% as stated in Regulation No. 1, Section II, A. Visual observations shall be performed using EPA Method 9. The following monitoring requirements apply during periods of operation:

7.2.1 A check of visible emissions (**not** EPA Method 9) shall be performed monthly. Should visible emissions, other than steam, be observed, the source shall:

7.2.1.1 Verify that the process and control equipment are operating properly.

7.2.1.2 Perform any maintenance or adjustments needed to minimize visible emissions and ensure that the process and control equipment are operating properly.

7.2.1.3 Record any maintenance or adjustments performed in order to minimize visible emissions and ensure proper operation.

7.2.1.4 Conduct an additional check of visible emissions (not EPA Method 9) after performing the above activities. Should visible emissions still persist, the source shall perform an EPA Method 9 observation within 24 hours.

7.2.2 Should any EPA Method 9 observation result (6 minute average) indicate opacity exceeding 10%, the source shall perform monthly Method 9 visual observations for the subsequent four (4) months. The source shall continue the visual observations into the next campaign (or period of operation) should the existing campaign end before all required observations are performed.

(Note: The 10% opacity level is used only to govern monitoring frequency - it is not a limit)

7.3 The dust collectors and bin dust collector shall be maintained and operated in accordance with manufacturer's recommendations and good engineering practices to minimize emissions and ensure compliance with the particulate and opacity standards. Specifically:

7.3.1 The two Sly PleatJet dust collectors shall be operated when sugar is being conveyed through the systems connected to the dust collectors. The bin vent filters shall be operated while the particular bin is in use.

7.3.2 Equipment and storage vessels shall be maintained and operated to minimize leakage of air contaminants to the atmosphere prior to treatment by the dust collectors.

7.3.3 The dust collectors shall be inspected monthly to ensure that no tears or leaks are present. Records of maintenance shall be maintained.

7.4 The source shall track the hours of silo/bin operation for purposes of determining emissions under Condition 7.1.

8. S007 - Slaking/Hydration of Calcium Oxide from Lime Kiln

Parameter	Permit Condition Number	Limitations	Compliance Emission Factors	Monitoring	
				Method	Interval
PM & PM_{10}	8.1	$3.59(P)^{0.62}$ lbs/hr	0.055 lb/ton	Record keeping, Calculation	Monthly
CaO Consumption				Record keeping	Monthly
Opacity	8.2	Less than or equal to 20%		Visual Checks, Maintenance, EPA Method 9	Monthly Checks and EPA Method 9 as Needed
Control Equipment Operation	8.3	Mftrs Recommendations & Good Engineering Practices		Maintenance & Record keeping	As Needed
Hours of Operation	8.4			Record keeping	As Operated

8.1 Particulate Matter (PM) emissions shall not exceed the Colorado Regulation No. 1, Section III.C.1.a. limit set by the equation PE = $3.59(P)^{0.62}$ where PE = particulate emissions in pounds per hour lbs/hr and P = Process weight rate in tons per hour.

8.1.1 Emissions shall be calculated monthly using the emission factor listed above (January 1995 Stack Test of Slaker Vent Without Controls at Western Sugar's Scottsbluff, Nebraska Facility), monthly CaO consumption, and a control efficiency of 50% in the following equation:

Lbs/Month = (EF) X (Monthly CaO Consumption) X (100%-50%)/100

Emissions shall also be calculated annually for fee and inventory purposes.

8.2 Opacity shall not exceed 20% as stated in Regulation No. 1, Section II, A. Visual observations shall be performed using EPA Method 9. The following monitoring requirements apply during periods of operation:

8.2.1 A check of visible emissions (**not** EPA Method 9) shall be performed monthly. Should visible emissions, other than steam, be observed, the source shall:

8.2.1.1 Verify that the process and control equipment are operating properly.

8.2.1.2 Perform any maintenance or adjustments needed to minimize visible emissions and ensure that the process and control equipment are operating properly.

8.2.1.3 Record any maintenance or adjustments performed in order to minimize visible emissions and ensure proper operation.

8.2.1.4 Conduct an additional check of visible emissions (not EPA Method 9) after performing the above activities. Should visible emissions still persist, the source shall perform an EPA Method 9 observation within 24 hours.

8.2.2 Should any EPA Method 9 observation result (6 minute average) indicate opacity exceeding 10%, the source shall perform monthly Method 9 visual observations for the subsequent four (4) months. The source shall continue the visual observations into the next campaign (or period of operation) should the existing campaign end before all required observations are performed.

(Note: The 10% opacity level is used only to govern monitoring frequency - it is not a limit)

8.3 The Ducon wet scrubber shall be maintained and operated in accordance with manufacturer's recommendations and good engineering practices to minimize emissions and ensure compliance with the particulate and opacity standards. Specifically:

8.3.1 The scrubber and exhaust fans shall be operated whenever the lime slaker is in operation. Water spray shall be sufficient to minimize opacity and/or particulate emissions.

8.3.2 Process equipment shall be maintained and operated so that there is no leakage of air contaminants to the atmosphere prior to treatment by the wet scrubber

8.3.3 Records of scrubber maintenance shall be maintained and made available for Division review upon request.

8.4 Records of the run-time operating hours shall be maintained for use in emissions calculations.

9. S008 - Fugitive Dust Emissions from Truck Traffic and Exposed Grounds

Parameter	Permit Condition Number	Limitations	Emission Factors	Monitoring	
				Method	Interval
PM and PM_{10}	9.1			Record keeping	As Needed
Control Measures		Minimize Fugitive Particulate Emissions		Measures as Necessary	As Needed

9.1 Control measures and operating procedures shall be employed as necessary to minimize fugitive particulate emissions into the atmosphere (Colorado Regulation No. 1, Section III, Part D).

9.1.1 A fugitive dust control plan, or modification to an existing plan, shall be required to be submitted if the Division determines that for this source or activity visible emissions are in excess of 20% opacity; or visible emissions are being transported off the property; or if this source or activity is operating with emissions that create a nuisance. The control plan shall be submitted to the Division within the time period specified by the Division. (Colorado Regulation No. 1, Section III, Part D.1.c.)

9.1.2 In the event that a control plan is required, it shall be a violation of this permit to operate an activity for which a control plan has been disapproved or to fail to comply with the provisions of an approved control plan. (Colorado Regulation No. 1, Section III, Part D.1.e.(ii) (B)&(C))

10. Granulated & Powdered Sugar Production

S010 – Two Powdered Sugar Mills

S013 - Powdered Sugar Production Line Packer

S014 - Fine Granulated Sugar Industrial Bag Packaging Line & Warehouse

S015 – Starch Unloading & Selected Powdered Sugar Packing Line Points

Parameter	Permit Condition Number	Limitations	Compliance Emission Factors	Monitoring	
				Method	Interval
Fine Granulated Sugar Production Powdered Sugar Production	10.1	175,200 tons per year 66,000 tons per year		Record keeping and calculation 12 month rolling total	Monthly
Two Powdered Sugar Mills (S010) PM_{10}		6.30 tons per year	0.1909 pounds per ton of sugar		
Powdered Sugar Production Line Packer (S013) PM_{10}		0.57 tons per year	0.01727 pounds per ton of sugar		
Fine Granulated Sugar Industrial Bag Packaging Line and Warehouse (S014) PM_{10}		0.084 tons per year	0.00096 pounds per ton of sugar		
Selected Powdered Sugar Packaging Line Points (S015) PM_{10}		2.30 tons per year	0.06970 pounds per ton of sugar		
Opacity	10.2	Less than or equal to 20%		Visual Checks, Maintenance, EPA Method 9	Monthly Checks and EPA Method 9 as Needed
Control Equipment Operation	10.3	Mftrs Recommendations & Good Engineering Practices		Maintenance & Record keeping	As Needed

10.1 PM_{10} emissions from the activities associated with the production, packaging, and handling of powdered sugar shall not exceed the limitations stated above (Colorado Construction Permit 96MR006 as modified in accordance with Section I, Condition 1.3 of this Operating Permit).

10.1.1 Monthly emissions of each pollutant shall be calculated using the listed compliance emission factors (EF) (From Applicant and Manufacturer Guaranteed Values for Control Equipment) and monthly fine granulated or powdered sugar production.

10.1.2 A twelve month rolling total shall be maintained for demonstration of compliance with the annual limitations. During the period when sugar is produced, by the end of each new month, a new twelve month total shall be calculated using the previous twelve months data. Records of the produced fine granulated and powdered sugar tonnages shall be kept on a rolling twelve month total and made available for Division review upon request.

10.2 Opacity shall not exceed 20% as stated in Regulation No. 1, Section II, A. Visual observations shall be performed using EPA Method 9. The following monitoring requirements apply during periods of operation:

10.2.1 A check of visible emissions (**not** EPA Method 9) shall be performed monthly. A record of the check shall be maintained and made available for Division review upon request. Should visible emissions, other than steam, be observed, the source shall:

10.2.1.1 Verify that the process and control equipment are operating properly.

10.2.1.2 Perform any maintenance or adjustments needed to minimize visible emissions and ensure that the process and control equipment are operating properly.

10.2.1.3 Record any maintenance or adjustments performed in order to minimize visible emissions and ensure proper operation.

10.2.1.4 Conduct an additional check of visible emissions (**not** EPA Method 9) after performing the above activities. Should visible emissions still persist, the source shall perform an EPA Method 9 observation within 24 hours.

10.2.2 Should any EPA Method 9 observation result (6 minute average) indicate opacity exceeding 10%, the source shall perform monthly Method 9 visual observations for the subsequent four (4) months. The source shall continue the visual observations into the next campaign (or period of operation) should the existing campaign end before all required observations are performed.

(Note: The 10% opacity level is used only to govern monitoring frequency - it is not a limit)

10.3 Control devices shall be in place for the two powdered sugar mills, the production line, general warehouse, and starch unloading. The control devices shall be maintained and operated in accordance with manufacturer's recommendations and good engineering practices to minimize emissions and ensure compliance with the particulate and opacity standards. Specifically, during sugar production periods:

10.3.1 Exhaust fans shall be operated when powdered sugar is in production. Control equipment shall be in operation while powdered sugar is handled.

10.3.2 Process equipment shall be maintained and operated to minimize leakage of air contaminants to the atmosphere prior to treatment by the control equipment. Control equipment shall be maintained according to manufacturer's guidelines and good engineering practices. Control equipment shall be inspected periodically, but no less frequently than monthly, to ensure proper operation.

10.3.3 Records of control equipment and process equipment maintenance shall be maintained and made available for Division review upon request.

11. State-Only - Construction Permit Exempt/APEN Required

Parameter	Permit Condition Number	Limitations	Monitoring	
			Method	Interval
Ammonia	11.1 11.2	**State-only** Bin C chemical with reporting thresholds of 1000, 2500 or 5000 pounds per year	Record keeping and calculation	Annual
Opacity	11.3	Not to exceed 20%	Type of Source	None

11.1 **State-only** Ammonia is a non-criteria reportable pollutant required to be reported when the estimated emissions exceed described thresholds (Colorado Regulation No. 3, Part A, 'II.B.3.b and Colorado Regulation No. 3, Appendix A).

11.2 The estimated actual annual uncontrolled emissions of the pollutant for the previous calendar year shall be calculated by April 30 of each new calendar year. A revised APEN shall be submitted as needed. The calculations shall be kept on file and available for Division review upon request. An application for a Construction Permit shall be submitted whenever any of the criteria pollutant threshold values requiring a Construction Permit are exceeded.

11.3 In the absence of evidence to the contrary, the Division accepts that this source does not create opacity.

SECTION III - Permit Shield

Colorado Regulation No. 3, 5 CCR 1001-5, Part A, §I.B.44; Part C, §§V.C.1.b. & V.D., XIII.B; §§25-7-111(2)(I), 25-7-114.4(3)(a), C.R.S.

1. Specific Non-Applicable Requirements

Based upon information available to the Division and supplied by the applicant, the following parameters and requirements have been specifically identified as non-applicable to the facility to which this permit has been issued. This shield does not protect the source from any violations that occurred prior to or at the time of permit issuance. In addition, this shield does not protect the source from any violations that occur as a result of any modifications or reconstruction on which construction commenced prior to permit issuance.

Emission Unit Description & Number	Applicable Requirement	Justification
S001	Colorado Regulation No. 1, Section VI.B, New Sources of Sulfur Dioxide.	This unit was an existing source as of the Regulation No. 1 October 27, 1977, applicability date.
S001	Colorado Regulation No. 6, Part B, II.D.1., Standards of Performance for New Stationary Sources, Standard for Sulfur Dioxide.	This unit was an existing source as of the Regulation No. 6 January 30, 1979, applicability date.
S001	Colorado Regulation No. 6, Part B, II.C.1., Standards of Performance for New Stationary Sources, Standard for Particulate Matter.	This unit was an existing source as of the Regulation No. 6 January 30, 1979, applicability date.
S002 - S007	Colorado Regulation No. 6, Part B, III., Standards of Performance for New Stationary Sources, Standards of Performance for New Manufacturing Processes.	This unit was an existing source as of the Regulation No. 6 January 30, 1979, applicability date.

2. General Conditions

Compliance with this Operating Permit shall be deemed compliance with all applicable requirements specifically identified in the permit and other requirements specifically identified in the permit as not applicable to the source. This permit shield shall not alter or affect the following:

2.1 The provisions of ' ' 25-7-112 and 25-7-113, C.R.S., or ' 303 of the federal act, concerning enforcement in cases of emergency;

2.2 The liability of an owner or operator of a source for any violation of applicable requirements prior to or at the time of permit issuance;

2.3 The applicable requirements of the federal Acid Rain Program, consistent with § 408(a) of the federal act;

2.4 The ability of the Air Pollution Control Division to obtain information from a source pursuant to § 25-7-111(2)(I), C.R.S., or the ability of the Administrator to obtain information pursuant to § 114 of the federal act;

2.5 The ability of the Air Pollution Control Division to reopen the Operating Permit for cause pursuant to Colorado Regulation No. 3, Part C, § XIII.

2.6 Sources are not shielded from terms and conditions that become applicable to the source subsequent to permit issuance.

3. Streamlined Conditions

The following applicable requirements have been subsumed within this operating permit using the pertinent streamlining procedures approved by the U.S. EPA. For purposes of the permit shield, compliance with the listed permit conditions will also serve as a compliance demonstration for purposes of the associated subsumed requirements.

Permit Condition	Streamlined (Subsumed) Requirements
NONE	

Section IV - General Permit Conditions (Ver 01/07/03)

1. Administrative Changes

Regulation No. 3, 5 CCR 1001-5, Part A, III.

The permittee shall submit an application for an administrative permit amendment to the Division for those permit changes that are described in Regulation No. 3, Part A, § I.B.36.a. The permittee may immediately make the change upon submission of the application to the Division.

2. Certification Requirements

Regulation No. 3, 5 CCR 1001-5, Part C, §§ III.B.9., V.C.16.a.&e. and V.C.17.

a. Any application, report, document and compliance certification submitted to the Air Pollution Control Division pursuant to Regulation No. 3 or the Operating Permit shall contain a certification by a responsible official of the truth, accuracy and completeness of such form, report or certification stating that, based on information and belief formed after reasonable inquiry, the statements and information in the document are true, accurate and complete.

b. All compliance certifications for terms and conditions in the Operating Permit shall be submitted to the Air Pollution Control Division at least annually unless the Division in the Operating Permit specifies in the applicable requirement or a more frequent period.

c. Compliance certifications shall contain:

(i) the identification of each permit term and condition that is the basis of the certification;

(ii) the compliance status of the source;

(iii) whether compliance was continuous or intermittent;

(iv) the method(s) used for determining the compliance status of the source, currently and over the reporting period; and

(v) such other facts as the Air Pollution Control Division may require to determine the compliance status of the source.

d. All compliance certifications shall be submitted to the Air Pollution Control Division and to the Environmental Protection Agency at the addresses listed in Appendix D of this Permit.

e. If the permittee is required to develop and register a risk management plan pursuant to § 112(r) of the federal act, the permittee shall certify its compliance with that requirement; the Operating Permit shall not incorporate the contents of the risk management plan as a permit term or condition.

3. Common Provisions

Common Provisions Regulation, 5 CCR 1001-2 §§ II.A., II.B., II.C., II,.E., II.F., II.I, and II.J

a. To Control Emissions Leaving Colorado

When emissions generated from sources in Colorado cross the State boundary line, such emissions shall not cause the air quality standards of the receiving State to be exceeded, provided reciprocal action is taken by the receiving State.

b. Emission Monitoring Requirements

The Division may require owners or operators of stationary air pollution sources to install, maintain, and use instrumentation to monitor and record emission data as a basis for periodic reports to the Division.

c. Performance Testing

(i) The owner or operator of any air pollution source shall, upon request of the Division, conduct performance test(s) and furnish the Division a written report of the results of such test(s) in order to determine compliance with applicable emission control regulations.

(ii) Performance test(s) shall be conducted and the data reduced in accordance with the applicable reference test methods unless the Division:

A. specifies or approves, in specific cases, the use of a test method with minor changes in methodology;

B. approves the use of an equivalent method;

C. approves the use of an alternative method the results of which the Division has determined to be adequate for indicating where a specific source is in compliance; or

D. waives the requirement for performance test(s) because the owner or operator of a source has demonstrated by other means to the Division's satisfaction that the affected facility is in compliance with the standard. Nothing in this paragraph shall be construed to abrogate the Commission's or Division's authority to require testing under the Colorado Revised Statutes, Title 25, Article 7 1973, and pursuant to regulations promulgated by the Commission.

(iii) Compliance test(s) shall be conducted under such conditions as the Division shall specify to the plant operator based on representative performance of the affected facility. The owner or operator shall make available to the Division such records as may be necessary to determine the conditions of the performance test(s). Operations during period of startup, shutdown, and malfunction shall not constitute representative conditions of performance test(s) unless otherwise specified in the applicable standard.

(iv) The owner or operator of an affected facility shall provide the Division thirty days prior notice of the performance test to afford the Division the opportunity to have an observer present. The Division may waive the thirty day notice requirement provided that arrangements satisfactory to the Division are made for earlier testing.

(v) The owner or operator of an affected facility shall provide, or cause to be provided, performance testing facilities as follows:

A. Sampling ports adequate for test methods applicable to such facility,

B. Safe sampling platform(s),

C. Safe access to sampling platform(s).

D. Utilities for sampling and testing equipment.

(vi) Each performance test shall consist of at least three separate runs using the applicable test method. Each run shall be conducted for the time and under the conditions specified in

the applicable standard. For the purpose of determining compliance with an applicable standard the arithmetic mean of results of at least three runs shall apply. In the event that a sample is accidentally lost or conditions occur in which one of the runs must be discontinued because of forced shutdown, failure of an irreplaceable portion of the sample train, extreme meteorological conditions, or other circumstances beyond the owner or operator's control, compliance may, upon the Division's approval, be determined using the arithmetic mean of the results of the two (2) other runs.

(vii) Criteria shall be established by the Division for the implementation of the requirements specified by Section II.D. of the Common Provisions Regulations.

(viii) Nothing in this section shall abrogate the Division's authority to conduct its own performance test(s) if so warranted.

d. Upset Conditions and Breakdowns

Upset conditions, as defined, shall not be deemed to be in violation of the Colorado regulations, provided that the Division is notified as soon as possible, but no later than two (2) hours after the start of the next working day, followed by a written notice to the Division explaining the cause of the occurrence and that proper action has been or is being taken to correct the conditions causing the violation and to prevent such excess emission in the future.

e. Circumvention Clause

A person shall not build, erect, install, or use any article, machine, equipment, condition, or any contrivance, the use of which, without resulting in a reduction in the total release of air pollutants to the atmosphere, reduces or conceals an emission which would otherwise constitute a violation of this regulation. No person shall circumvent this regulation by using more openings than is considered normal practice by the industry or activity in question.

f. Compliance Certifications

For the purpose of submitting compliance certifications or establishing whether or not a person has violated or is in violation of any standard in the Colorado State Implementation Plan, nothing in the Colorado State Implementation Plan shall preclude the use, including the exclusive use, of any credible evidence or information, relevant to whether a source would have been in compliance with applicable requirements if the appropriate performance or compliance test or procedure had been performed. Evidence that has the effect of making any relevant standard or permit term more stringent shall not be credible for proving a violation of the standard or permit term.

g. Affirmative Defense Provision for Excess Emissions During Startup and Shutdown

(i) An affirmative defense is provided to owners and operators for civil penalty actions for excess emissions during periods of startup and shutdown. To establish the affirmative defense and to be relieved of a civil penalty in any action to enforce an applicable requirement, the owner or operator of the facility must meet the notification requirements below in a timely manner and prove by a preponderance of the evidence that:

A. The periods of excess emissions that occurred during startup and shutdown were short and infrequent and could not have been prevented through careful planning and design;

B. The excess emissions were not part of a recurring pattern indicative of inadequate design, operation or maintenance;

C. If the excess emissions were caused by a bypass (an intentional diversion of control equipment), then the bypass was unavoidable to prevent loss of life, personal injury, or severe property damage;

D. The frequency and duration of operation in startup and shutdown periods were minimized to the maximum extent practicable;

E. All possible steps were taken to minimize the impact of excess emissions on ambient air quality;

F. All emissions monitoring systems were kept in operation (if at all possible);

G. The owner or operator's actions during the period of excess emissions were documented by properly signed, contemporaneous operating logs or other relevant evidence; and,

H. At all times, the facility was operated in a manner consistent with good practices for minimizing emissions. This subparagraph is intended solely to be a factor in determining whether an affirmative defense is available to an owner or operator, and shall not constitute an additional applicable requirement.

(ii) The owner or operator of the facility experiencing excess emissions during startup and shutdown shall notify the Division verbally as soon as possible, but no later than two (2) hours after the start of the next working day, and shall submit written quarterly notification following the initial occurrence of the excess emissions. The notification shall address the criteria set forth above.

(iii) The Affirmative Defense Provision contained in this section shall not be available to claims for injunctive relief.

(iv) The Affirmative Defense Provision does not apply to State Implementation Plan provisions or other requirements that derive from new source performance standards (NSPS) or national emissions standards for hazardous air pollutants (NESHAPS), any other federally enforceable performance standard or emission limit with an averaging time greater than twenty-four hours. In addition, an affirmative defense cannot be used by a single source or small group of sources where the excess emissions have the potential to cause an exceedance of the ambient air quality standards or Prevention of Significant Deterioration (PSD) increments.

(v) Affirmative Defense Determination: In making any determination whether a source established an affirmative defense, the Division shall consider the information within the notification required above and any other information the Division deems necessary, which may include, but is not limited to, physical inspection of the facility and review of documentation pertaining to the maintenance and operation of process and air pollution control equipment.

4. Compliance Requirements

Regulation No. 3 and 5 CCR 1001-5, Part C, §§ III.C.9., V.C.11. & 16.d., § 25-7-122.1(2), C.R.S.

a. The permittee must comply with all conditions of the Operating Permit. Any permit noncompliance relating to federally-enforceable terms or conditions constitutes a violation of the federal act, as well as the state act and Regulation No. 3. Any permit noncompliance relating to state-only terms or conditions constitutes a violation of the state act and Regulation No. 3, shall be enforceable pursuant to state law, and shall not be enforceable by citizens under § 304 of the

federal act. Any such violation of the federal act, the state act or regulations implementing either statute is grounds for enforcement action, for permit termination, revocation and reissuance or modification or for denial of a permit renewal application.

b. It shall not be a defense for a permittee in an enforcement action or a consideration in favor of a permittee in a permit termination, revocation or modification action or action denying a permit renewal application that it would have been necessary to halt or reduce the permitted activity in order to maintain compliance with the conditions of the permit.

c. The permit may be modified, revoked, reopened, and reissued, or terminated for cause. The filing of any request by the permittee for a permit modification, revocation and reissuance, or termination, or any notification of planned changes or anticipated noncompliance does not stay any permit condition, except as provided in §§ X. and XI. of Regulation No. 3, Part C.

d. The permittee shall furnish to the Air Pollution Control Division, within a reasonable time as specified by the Division, any information that the Division 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 shall also furnish to the Division copies of records required to be kept by the permittee, including information claimed to be confidential. Any information subject to a claim of confidentiality shall be specifically identified and submitted separately from information not subject to the claim.

e. Any schedule for compliance for applicable requirements with which the source is not in compliance at the time of permit issuance shall be supplemental, and shall not sanction noncompliance with, the applicable requirements on which it is based.

f. For any compliance schedule for applicable requirements with which the source is not in compliance at the time of permit issuance, the permittee shall submit, at least every 6 months unless a more frequent period is specified in the applicable requirement or by the Air Pollution Control Division, progress reports which contain the following:

(i) dates for achieving the activities, milestones, or compliance required in the schedule for compliance, and dates when such activities, milestones, or compliance were achieved; and

(ii) an explanation of why any dates in the schedule of compliance were not or will not be met, and any preventive or corrective measures adopted.

g. The permittee shall not knowingly falsify, tamper with, or render inaccurate any monitoring device or method required to be maintained or followed under the terms and conditions of the Operating Permit.

5. Emergency Provisions

Regulation No. 3, 5 CCR 1001-5, Part C, § VII.

An emergency means any situation arising from sudden and reasonably unforeseeable events beyond the control of the source, including acts of God, which situation requires immediate corrective action to restore normal operation, and that causes the source to exceed the technology-based emission limitation under the permit due to unavoidable increases in emissions attributable to the emergency. "Emergency" does not include noncompliance to the extent caused by improperly designed equipment, lack of preventative maintenance, careless or improper operation, or operator error. An emergency constitutes an affirmative defense to an enforcement action brought for noncompliance with a technology-based emission limitation if

the permittee demonstrates, through properly signed, contemporaneous operating logs, or other relevant evidence that:

a. an emergency occurred and that the permittee can identify the cause(s) of the emergency;

b. the permitted facility was at the time being properly operated;

c. during the period of the emergency the permittee took all reasonable steps to minimize levels of emissions that exceeded the emission standards, or other requirements in the permit; and

d. the permittee submitted oral notice of the emergency to the Air Pollution Control Division no later than noon of the next working day following the emergency, and followed by written notice within one month of the time when emissions limitations were exceeded due to the emergency. This notice must contain a description of the emergency, any steps taken to mitigate emissions, and corrective actions taken.

This emergency provision is in addition to any emergency or upset provision contained in any applicable requirement.

6. Emission Standards for Asbestos

Regulation No. 8, 5 CCR 1001-10, Part B

The permittee shall not conduct any asbestos abatement activities except in accordance with the provisions of Regulation No. 8, Part B, "emission standards for asbestos."

7. Emissions Trading, Marketable Permits, Economic Incentives

Regulation No. 3, 5 CCR 1001-5, Part C, § V.C.13.

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

8. Fee Payment

C.R.S §§ 25-7-114.1(6) and 25-7-114.7

a. The permittee shall pay an annual emissions fee in accordance with the provisions of C.R.S. § 25-7-114.7. A 1% per month late payment fee shall be assessed against any invoice amounts not paid in full on the 91st day after the date of invoice, unless a permittee has filed a timely protest to the invoice amount.

b. The permittee shall pay a permit processing fee in accordance with the provisions of C.R.S. § 25-7-114.7. If the Division estimates that processing of the permit will take more than 30 hours, it will notify the permittee of its estimate of what the actual charges may be prior to commencing any work exceeding the 30 hour limit.

c. The permittee shall pay an APEN fee in accordance with the provisions of C.R.S. § 25-7-114.1(6) for each APEN or revised APEN filed.

9. Fugitive Particulate Emissions

Regulation No. 1, 5 CCR 1001-3, § III.D.1.

The permittee shall employ such control measures and operating procedures as are necessary to minimize fugitive particulate emissions into the atmosphere, in accordance with the provisions of Regulation No. 1, § III.D.1.

10. Inspection and Entry

Regulation No. 3, 5 CCR 1001-5, Part C, § V.C.16.b.

Upon presentation of credentials and other documents as may be required by law, the permittee shall allow the Air Pollution Control Division, or any authorized representative, to perform the following:

a. enter upon the permittee's premises where an Operating Permit source is located, or emissions-related activity is conducted, or where records must be kept under the terms of the permit;

b. have access to, and copy, at reasonable times, any records that must be kept under the conditions of the permit;

c. inspect at reasonable times any facilities, equipment (including monitoring and air pollution control equipment), practices, or operations regulated or required under the Operating Permit;

d. sample or monitor at reasonable times, for the purposes of assuring compliance with the Operating Permit or applicable requirements, any substances or parameters.

11. Minor Permit Modifications

Regulation No. 3, 5 CCR 1001-5, Part C, §§ X. & XI.

The permittee shall submit an application for a minor permit modification before making the change requested in the application. The permit shield shall not extend to minor permit modifications.

12. New Source Review

Regulation No. 3, 5 CCR 1001-5, Part B

The permittee shall not commence construction or modification of a source required to be reviewed under the New Source Review provisions of Regulation No. 3, Part B, without first receiving a construction permit.

13. No Property Rights Conveyed

Regulation No. 3, 5 CCR 1001-5, Part C, § V.C.11.d.

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

14. Odor

Regulation No. 2, 5 CCR 1001-4, Part A

As a matter of state law only, the permittee shall comply with the provisions of Regulation No. 2 concerning odorous emissions.

15. Off-Permit Changes to the Source

Regulation No. 3, 5 CCR 1001-5, Part C, § XII.B.

The permittee shall record any off-permit change to the source that causes the emissions of a regulated pollutant subject to an applicable requirement, but not otherwise regulated under the permit, and the emissions resulting from the change, including any other data necessary to show compliance with applicable ambient air quality standards. The permittee shall provide contemporaneous notification to the Air Pollution Control Division and to the Environmental Protection Agency at the addresses listed in Appendix D of this Permit . The permit shield shall not apply to any off-permit change.

16. Opacity

Regulation No. 1, 5 CCR 1001-3, §§ I., II.

The permittee shall comply with the opacity emissions limitation set forth in Regulation No. 1, §§ I.-II.

17. Open Burning

Regulation No. 9, 5 CCR 1001-11

The permittee shall obtain a permit from the Division for any regulated open burning activities in accordance with provisions of Regulation No. 9.

18. Ozone Depleting Compounds

Regulation No. 15, 5 CCR 1001-17

The permittee shall comply with the provisions of Regulation No. 15 concerning emissions of ozone depleting compounds.

19. Permit Expiration and Renewal

Regulation No. 3, 5 CCR 1001-5, Part C, §§ III.B.6., IV.C., V.C.2.

a. The permit term shall be five (5) years. The permit shall expire at the end of its term. Permit expiration terminates the permittee's right to operate unless a timely and complete renewal application is submitted.

b. Applications for renewal shall be submitted at least twelve months, but not more than 18 months, prior to the expiration of the Operating Permit. An application for permit renewal may address only those portions of the permit that require revision, supplementing, or deletion, incorporating the remaining permit terms by reference from the previous permit. A copy of any materials incorporated by reference must be included with the application.

20. Portable Sources

Regulation No. 3, 5 CCR 1001-5, Part C, § II.D.

Portable Source permittees shall notify the Air Pollution Control Division at least 10 days in advance of each change in location.

21. Prompt Deviation Reporting

Regulation No. 3, 5 CCR 1001-5, Part C, § V.C.7.b.

The permittee shall promptly report any deviation from permit requirements, including those attributable to upset conditions as defined in the permit, the probable cause of such deviations, and any corrective actions or preventive measures taken. Unless required by a permit term or condition to report deviations on a more frequent basis, "prompt" reporting shall entail submission of reports of deviations from permit requirements every six (6) months in accordance with paragraph 21.d. below. "Prompt reporting" does not constitute an exception to the requirements of "Emergency Provisions" for the purpose of avoiding enforcement actions.

22. Record Keeping and Reporting Requirements

Regulation No. 3, 5 CCR 1001-5, Part A, § II.; Part C, §§ V.C.6., V.C.7.

a. Unless otherwise provided in the source specific conditions of this Operating Permit, the permittee shall maintain compliance monitoring records that include the following information:

(i) date, place as defined in the Operating Permit, and time of sampling or measurements;

(ii) date(s) on which analyses were performed;

(iii) the company or entity that performed the analysis;

(iv) the analytical techniques or methods used;

(v) the results of such analysis; and

(vi) the operating conditions at the time of sampling or measurement.

b. The permittee shall retain records of all required monitoring data and support information for a period of at least five (5) years from the date of the monitoring sample, measurement, report or application. Support information, for this purpose, includes all calibration and maintenance records and all original strip-chart recordings for continuous monitoring instrumentation, and copies of all reports required by the Operating Permit. With prior approval of the Air Pollution Control Division, the permittee may maintain any of the above records in a computerized form.

c. Permittees must retain records of all required monitoring data and support information for the most recent twelve (12) month period, as well as compliance certifications for the past five (5) years on-site at all times. A permittee shall make available for the Air Pollution Control Division's review all other records of required monitoring data and support information required to be retained by the permittee upon 48 hours advance notice by the Division.

d. The permittee shall submit to the Air Pollution Control Division all reports of any required monitoring at least every six (6) months, unless an applicable requirement, the enhanced monitoring rule, or the Division requires submission on a more frequent basis. All instances of deviations from any permit requirements must be clearly identified in such reports.

e. The permittee shall file an Air Pollutant Emissions Notice ("APEN") prior to constructing, modifying, or altering any facility, process, activity which constitutes a stationary source from which air pollutants are or are to be emitted, unless such source is exempt from the APEN filing requirements of Regulation No. 3, Part A, § II.D. A revised APEN shall be filed annually whenever a significant change in emissions, as defined in Regulation No. 3, Part A, § II.C.2., occurs; whenever there is a change in owner or operator of any facility, process, or activity; whenever new control equipment is installed; whenever a different type of control equipment

replaces an existing type of control equipment; whenever a permit limitation must be modified; or before the APEN expires. An APEN is valid for a period of five years. The five-year period recommences when a revised APEN is received by the Air Pollution Control Division. Revised APENs shall be submitted no later than 30 days before the five-year term expires. Permittees submitting revised APENs to inform the Division of a change in actual emission rates must do so by April 30 of the following year. Where a permit revision is required, the revised APEN must be filed along with a request for permit revision. APENs for changes in control equipment must be submitted before the change occurs. Annual fees are based on the most recent APEN on file with the Division.

23. Reopenings for Cause

Regulation No. 3, 5 CCR 1001-5, Part C, § XIII.

a. The Air Pollution Control Division shall reopen, revise, and reissue Operating Permits; permit reopenings and reissuance shall be processed using the procedures set forth in Regulation No. 3, Part C, § III., except that proceedings to reopen and reissue permits affect only those parts of the permit for which cause to reopen exists.

b. The Division shall reopen a permit whenever additional applicable requirements become applicable to a major source with a remaining permit term of three or more years, unless the effective date of the requirements is later than the date on which the permit expires, or unless a general permit is obtained to address the new requirements; whenever additional requirements (including excess emissions requirements) become applicable to an affected source under the acid rain program; whenever the Division determines the permit contains a material mistake or that inaccurate statements were made in establishing the emissions standards or other terms or conditions of the permit; or whenever the Division determines that the permit must be revised or revoked to assure compliance with an applicable requirement.

c. The Division shall provide 30 days' advance notice to the permittee of its intent to reopen the permit, except that a shorter notice may be provided in the case of an emergency.

d. The permit shield shall extend to those parts of the permit that have been changed pursuant to the reopening and reissuance procedure.

24. Section 502(b)(10) Changes

Regulation No. 3, 5 CCR 1001-5, Part C, § XII.A.

The permittee shall provide a minimum 7-day advance notification to the Air Pollution Control Division and to the Environmental Protection Agency at the addresses listed in Appendix D of this Permit. The permittee shall attach a copy of each such notice given to its Operating Permit.

25. Severability Clause

Regulation No. 3, 5 CCR 1001-5, Part C, § V.C.10.

In the event of a challenge to any portion of the permit, all emissions limits, specific and general conditions, monitoring, record keeping and reporting requirements of the permit, except those being challenged, remain valid and enforceable.

26. Significant Permit Modifications

Regulation No. 3, 5 CCR 1001-5, Part C, §III.B.2.

The permittee shall not make a significant modification required to be reviewed under Regulation No. 3, Part B ("Construction Permit" requirements) without first receiving a construction permit. The permittee shall submit a complete Operating Permit application or application for an Operating Permit revision for any new or modified source within twelve months of commencing operation, to the address listed in Item 1 in Appendix D of this permit. If the permittee chooses to use the "Combined Construction/Operating Permit" application procedures of Regulation No. 3, Part C, then the Operating Permit must be received prior to commencing construction of the new or modified source.

27. Special Provisions Concerning the Acid Rain Program

Regulation No. 3, 5 CCR 1001-5, Part C, §§ V.C.1.b. & 8

a. Where an applicable requirement of the federal act is more stringent than an applicable requirement of regulations promulgated under Title IV of the federal act, 40 Code of Federal Regulations (CFR) Part 72, both provisions shall be incorporated into the permit and shall be federally enforceable.

b. Emissions exceeding any allowances that the source lawfully holds under Title IV of the federal act or the regulations promulgated thereunder, 40 CFR Part 72, are expressly prohibited.

28. Transfer or Assignment of Ownership

Regulation No. 3, 5 CCR 1001-5, Part C, § II.C.

No transfer or assignment of ownership of the Operating Permit source will be effective unless the prospective owner or operator applies to the Air Pollution Control Division on Division-supplied Administrative Permit Amendment forms, for reissuance of the existing Operating Permit. No administrative permit shall be complete until a written agreement containing a specific date for transfer of permit, responsibility, coverage, and liability between the permittee and the prospective owner or operator has been submitted to the Division.

29. Volatile Organic Compounds

Regulation No. 7, 5 CCR 1001-9, §§ III & V.

a. For sources located in an ozone non-attainment area or the Denver Metro Attainment Maintenance Area, all storage tank gauging devices, anti-rotation devices, accesses, seals, hatches, roof drainage systems, support structures, and pressure relief valves shall be maintained and operated to prevent detectable vapor loss except when opened, actuated, or used for necessary and proper activities (e.g. maintenance). Such opening, actuation, or use shall be limited so as to minimize vapor loss.

Detectable vapor loss shall be determined visually, by touch, by presence of odor, or using a portable hydrocarbon analyzer. When an analyzer is used, detectable vapor loss means a VOC concentration exceeding 10,000 ppm. Testing shall be conducted as in Regulation No. 7, Section VIII.C.3.

b. Except when otherwise provided by Regulation No. 7, all volatile organic compounds, excluding petroleum liquids, transferred to any tank, container, or vehicle compartment with a capacity exceeding 212 liters (56 gallons), shall be transferred using submerged or bottom filling

equipment. For top loading, the fill tube shall reach within six inches of the bottom of the tank compartment. For bottom-fill operations, the inlet shall be flush with the tank bottom.

c. The permittee shall not dispose of volatile organic compounds by evaporation or spillage unless Reasonably Available Control Technology (RACT) is utilized.

d. No owner or operator of a bulk gasoline terminal, bulk gasoline plant, or gasoline dispensing facility as defined in Colorado Regulation No. 7, Section VI, shall permit gasoline to be intentionally spilled, discarded in sewers, stored in open containers, or disposed of in any other manner that would result in evaporation.

30. Wood Stoves and Wood burning Appliances

Regulation No. 4, 5 CCR 1001-6

The permittee shall comply with the provisions of Regulation No. 4 concerning the advertisement, sale, installation, and use of wood stoves and wood burning appliances.

END OF PERMIT REQUIREMENTS

OPERATING PERMIT APPENDICIES

A - INSPECTION INFORMATION
B - COMPLIANCE MONITORING REPORT FORMAT
C - COMPLIANCE CERTIFICATION REPORT FORMAT
D - NOTIFICATION ADDRESSES
E - PERMIT ACRONYMS
F - PERMIT MODIFICATIONS
G - COMPLIANCE ASSURANCE MONITORING PLANS

***DISCLAIMER:**

None of the information found in these Appendices shall be considered to be State or Federally enforceable, except as otherwise provided in the permit, and is presented to assist the source, permitting authority, inspectors, and citizens.

APPENDIX A

Inspection Information

1. Directions to Plant

Interstate 25 North to East Interstate 76. East approximately 90 miles to the town of Fort Morgan. Exit onto South State Highway 52. Right (West) onto State Highway 144. Turn into the main plant area.

2. Safety Equipment Required

Hard Hat
Hearing Protection
Safety Glasses with Side Shields

3. Facility Plot Plan

The attached figures gives the plot plan as submitted on March 1, 1995 with the source's Title V Operating Permit Application.

4. List of Insignificant Activities

The following list of insignificant activities was provided by the source to assist in the understanding of the facility layout. Since there is no requirement to update such a list, activities may have changed since the last filing.

Insignificant activities and/or sources of emissions as submitted in the application are as follows:

4.1. In house laboratory equipment
4.2. Landscaping and site housekeeping devices
4.3. Fuel storage and dispensing equipment (under 400 gallons per day)
4.4 Storage tanks with annual throughput less than 400,000 gallons and liquid stored is diesel fuels 1-D, 2-D, 4-D; or Fuel oils #1 - #6; or gas turbine fuels 1-GT through 4-GT; or an oil/water mixture with a vapor pressure lower than that of diesel fuel (0.025 PSIA).
4.5 10.46 MMBtu/hr Cleaver Brooks natural gas fired boiler, Serial Number L-35634

APPENDIX B
Monitoring and Permit Deviation Reporting

with codes ver 2/1/01

Reporting Requirements and Definitions

Please note that, pursuant to 113(c)(2) of the federal Clean Air Act, any person who knowingly:

(A) makes any false material statement, representation, or certification in, or omits material information from, or knowingly alters, conceals, or fails to file or maintain any notice, application, record, report, plan, or other document required pursuant to the Act to be either filed or maintained (whether with respect to the requirements imposed by the Administrator or by a State);

(B) fails to notify or report as required under the Act; or

(C) falsifies, tampers with, renders inaccurate, or fails to install any monitoring device or method required to be maintained or followed under the Act shall, upon conviction, be punished by a fine pursuant to title 18 of the United States Code, or by imprisonment for not more than 2 years, or both. If a conviction of any person under this paragraph is for a violation committed after a first conviction of such person under this paragraph, the maximum punishment shall be doubled with respect to both the fine and imprisonment.

The permittee must comply with all conditions of this operating permit. Any permit noncompliance constitutes a violation of the Act and is grounds for enforcement action; for permit termination, revocation and reissuance, or modification; or for denial of a permit renewal application.

The Part 70 Operating Permit program requires three types of reports to be filed for all permits. All required reports must be certified by a responsible official.

Report #1: Monitoring Deviation Report (due at least every six months)

For purposes of this operating permit, the Division is requiring that the monitoring reports are due every six months unless otherwise noted in the permit. All instances of deviations from permit monitoring requirements must be clearly identified in such reports.

For purposes of this operating permit, monitoring means any condition determined by observation, by data from any monitoring protocol, or by any other monitoring which is required by the permit as well as the record keeping associated with that monitoring. This would include, for example, fuel use or process rate monitoring, fuel analyses, and operational or control device parameter monitoring.

Report #2: Permit Deviation Report (must be reported "promptly")

In addition to the monitoring requirements set forth in the permits as discussed above, each and every requirement of the permit is subject to deviation reporting. The reports must address deviations from permit requirements, including those attributable to upset conditions and malfunctions as defined in this Appendix, the probable cause of such deviations, and any corrective actions or preventive measures taken. All deviations from any term or condition of the permit are required to be summarized or referenced in the annual compliance certification.

For purposes of this operating permit, "upset" shall refer to both emergency conditions and upsets. Additional discussion on these conditions is provided later in this Appendix.

For purposes of this operating permit, the Division is requiring that the permit deviation reports are due every six months unless otherwise noted in the permit. Where the underlying applicable requirement contains a definition of prompt or otherwise specifies a time frame for reporting deviations, that definition or time frame shall govern. For example, quarterly Excess Emission Reports required by an NSPS or Regulation No. 1, Section IV.

In addition to the monitoring deviations discussed above, included in the meaning of deviation for the purposes of this operating permit are any of the following:

(1) A situation where emissions exceed an emission limitation or standard contained in the permit;

(2) A situation where process or control device parameter values demonstrate that an emission limitation or standard contained in the permit has not been met;

(3) A situation in which observations or data collected demonstrates noncompliance with an emission limitation or standard or any work practice or operating condition required by the permit; or,

(4) A situation in which an excursion or exceedance as defined in 40CFR Part 64 (the Compliance Assurance Monitoring (CAM) Rule) has occurred. (only if the emission point is subject to CAM)

For reporting purposes, the Division has combined the Monitoring Deviation Report with the Permit Deviation Report. All deviations shall be reported using the following codes:

1 = Standard:	When the requirement is an emission limit or standard
2 = Process:	When the requirement is a production/process limit
3 = Monitor:	When the requirement is monitoring
4 = Test:	When the requirement is testing
5 = Maintenance:	When required maintenance is not performed
6 = Record:	When the requirement is record keeping
7 = Report:	When the requirement is reporting

8 = CAM: A situation in which an excursion or exceedance as defined in 40CFR Part 64 (the Compliance Assurance Monitoring (CAM) Rule) has occurred.

9 = Other: When the deviation is not covered by any of the above categories

Report #3: Compliance Certification (annually, as defined in the permit)

Submission of compliance certifications with terms and conditions in the permit, including emission limitations, standards, or work practices, is required not less than annually.

Compliance Certifications are intended to state the compliance status of each requirement of the permit over the certification period. They must be based, at a minimum, on the testing and monitoring methods specified in the permit that were conducted during the relevant time period. In addition, if the owner or operator knows of other material information (i.e. information beyond required monitoring that has been specifically assessed in relation to how the information potentially affects compliance status), that information must be identified and addressed in the compliance certification. The compliance certification must include the following:

- The identification of each term or condition of the permit that is the basis of the certification;

- The identification of the method(s) or other means used by the owner or operator for determining the compliance status with each permit term and condition during the certification period and whether such methods or other means provide continuous or intermittent data. Such methods and other means shall include, at a minimum, the methods and means required in the permit. If necessary, the owner or operator also shall identify any other material information that must be included in the certification to comply with section 113(c)(2) of the Federal Clean Air Act, which prohibits knowingly making a false certification or omitting material information;

- The status of compliance with the terms and conditions of the permit, and whether compliance was continuous or intermittent. The certification shall identify each deviation and take it into account in the compliance certification. Note that not all deviations are considered violations.[1]

- Such other facts as the Division may require, consistent with the applicable requirements to which the source is subject, to determine the compliance status of the source.

The Certification shall also identify as possible exceptions to compliance any periods during which compliance is required and in which an excursion or exceedance as defined under 40CFR Part 64 (the Compliance Assurance Monitoring (CAM) Rule) has occurred. (only for emission points subject to CAM)

Note the requirement that the certification shall identify each deviation and take it into account in the compliance certification. Previously submitted deviation reports, including the deviation report submitted at the time of the annual certification, may be referenced in the compliance certification.

[1] For example, given the various emissions limitations and monitoring requirements to which a source may be subject, a deviation from one requirement may not be a deviation under another requirement which recognizes an exception and/or special circumstances relating to that same event. Further, periods of excess emissions during startup, shutdown and malfunction may not be found to be a violation of an emission limitation or standard where the source adequately shows that any potential deviations as a result of these infrequent periods were minimized to the extent practicable and could not have been prevented through careful planning, design, or were unavoidable to prevent loss of life, personal injury, or severe property damage.

Startup, Shutdown, Malfunctions, Emergencies, and Upsets

Understanding the application of Startup, Shutdown, Malfunctions, Emergency provisions, and the Upset provisions is very important in both the deviation reports and the annual compliance certifications.

Startup, Shutdown, and Malfunctions

Please note that exceedances of some New Source Performance Standards (NSPS) and Maximum Achievable Control Technology (MACT) standards that occur during Startup, Shutdown or Malfunctions may not be considered to be non-compliance since emission limits or standards often do not apply unless specifically stated in the NSPS. Such exceedances must, however, be reported as excess emissions per the NSPS/MACT rules and would still be noted in the deviation report. In regard to compliance certifications, the permittee should be confident of the information related to those deviations when making compliance determinations since they are subject to Division review. The concepts of Startup, Shutdown and Malfunctions also exist for Best Available Control Technology (BACT) sources, but are not applied in the same fashion as for NSPS and MACT sources.

Emergencies and Upsets

Under the Emergency provisions of Part 70 and the Upset provisions of the State regulations, certain operational conditions may act as an affirmative defense against enforcement action if they are properly reported.

DEFINITIONS

Malfunction (NSPS) means any sudden, infrequent, and not reasonably preventable failure of air pollution control equipment, process equipment, or a process to operate in a normal or usual manner. Failures that are caused in part by poor maintenance or careless operation are not malfunctions.

Malfunction (SIP) means any sudden and unavoidable failure of air pollution control equipment or process equipment or unintended failure of a process to operate in a normal or usual manner. Failures that are primarily caused by poor maintenance, careless operation, or any other preventable upset condition or preventable equipment breakdown shall not be considered malfunctions.

Emergency means any situation arising from sudden and reasonably unforeseeable events beyond the control of the source, including acts of God, which situation requires immediate corrective action to restore normal operation, and that causes the source to exceed a technology-based emission limitation under the permit, due to unavoidable increases in emissions attributable to the emergency. An emergency shall not include noncompliance to the extent caused by improperly designed equipment, lack of preventative maintenance, careless or improper operation, or operator error.

Upset means an unpredictable failure of air pollution control or process equipment which results in the violation of emission control regulations and which is not due to poor maintenance, improper or careless operations, or is otherwise preventable through exercise of reasonable care.

Monitoring and Permit Deviation Report - Part I

1. Following is the **required** format for the Monitoring and Permit Deviation report to be submitted to the Division on a semi-annual basis unless otherwise noted in the permit. The Table below must be completed for all equipment or processes for which specific Operating Permit terms exist.

2. Part II of this Appendix B shows the format and information the Division will require for describing periods of monitoring and permit deviations, or upset or emergency conditions as indicated in the Table below. One Part II Form must be completed for each Deviation. Previously submitted reports (e.g. EER-s or Upsets) may be referenced and the form need not be filled out in its entirety.

FACILITY NAME: Western Sugar Cooperative – Fort Morgan Plant
OPERATING PERMIT NO: 95OPMR050
REPORTING PERIOD: _____ (see first page of the permit for specific reporting period and dates)

Operating Permit Unit ID	Unit Description	Deviations noted During Period?[1]		Deviation Code [2]	Upset/Emergency Condition Reported During Period?	
		YES	NO		YES	NO
S001	Two Stoker/Babcock and Wilcox Stoker-Coal-Fired Steam Boilers.					
S002	Two Stearns/Rogers, Peabody Type MU24 (Order # 32971, 34882 -1952), Natural Gas Fired Beet Pulp Dryers.					
S003	Four Beet Pulp Pellet mills and Coolers.					
S004	Two Sugar Granulators (East and West).					
S006	Conveyor Transfer Points and Silo Filling.					
S007	Slaking/Hydration of Calcium Oxide from Lime Kiln.					
S008	Fugitive Dust Emissions from Truck Traffic and Exposed Grounds.					
S009	Starch Unloading					
S010	Two Powdered Sugar Mills					
S013	Powdered Sugar Production Line Packer					
S014	Fine Granulated Sugar Industrial Bag Packaging Line and Warehouse					
S015	Selected Powdered Sugar Packaging Line Points					
S017	Facility-wide ammonia emissions					
Section IV General Conditions						
Insignificant Activities						

[1] See previous discussion regarding what is considered to be a deviation. Determination of whether or not a deviation has occurred shall be based on a reasonable inquiry using readily available information.

[2] Use the following entries, as appropriate.

1 = Standard:	When the requirement is an emission limit or standard
2 = Process:	When the requirement is a production/process limit
3 = Monitor:	When the requirement is monitoring
4 = Test:	When the requirement is testing
5 = Maintenance:	When required maintenance is not performed
6 = Record:	When the requirement is record keeping
7 = Report:	When the requirement is reporting
8 = CAM:	A situation in which an excursion or exceedance as defined in 40CFR Part 64 (the Compliance Assurance Monitoring (CAM) Rule) has occurred.
9 = Other:	When the deviation is not covered by any of the above categories

Monitoring and Permit Deviation Report - Part II

FACILITY NAME: [Company Name] - [Facility Name]
OPERATING PERMIT NO: [Permit #
REPORTING PERIOD:

Is the deviation being claimed as an: Emergency _____ Upset _____ N/A _____

(For NSPS/MACT) Did the deviation occur during: Startup _____ Shutdown _____
Malfunction _____ Normal Operation _____

OPERATING PERMIT UNIT IDENTIFICATION:

Operating Permit Condition Number Citation

Explanation of Period of Deviation

Duration (start/stop date & time)

Action Taken to Correct the Problem

Measures Taken to Prevent a Reoccurrence of the Problem

Dates of Upsets/Emergencies Reported (if applicable)

Deviation Code: _____ Division Code QA: _____

SEE EXAMPLE ON THE NEXT PAGE

EXAMPLE

FACILITY NAME: Acme Corp.
OPERATING PERMIT NO: 96OPZZXXX
REPORTING PERIOD: 1/1/96 - 6/30/96

Is the deviation being claimed as an: Emergency _____ Upset _XX_ N/A ____

(For NSPS/MACT) Did the deviation occur during: Startup _____ Shutdown ____
Malfunction _____ Normal Operation ____

OPERATING PERMIT UNIT IDENTIFICATION:

Asphalt Plant with a Scrubber for Particulate Control - Unit XXX

Operating Permit Condition Number Citation

Section II, Condition 3.1 - Opacity Limitation

Explanation of Period of Deviation

Slurry Line Feed Plugged

Duration

START- 1730 4/10/96
END- 1800 4/10/96

Action Taken to Correct the Problem

Line Blown Out

Measures Taken to Prevent Reoccurrence of the Problem

Replaced Line Filter

Dates of Upsets/Emergencies Reported (if applicable)

4/10/96 to S. Busch, APCD

Deviation Code: _____ Division Code QA: _____

Monitoring and Permit Deviation Report - Part III

REPORT CERTIFICATION

SOURCE NAME: Western Sugar Cooperative – Fort Morgan Plant

FACILITY IDENTIFICATION NUMBER: 0850023

PERMIT NUMBER: 95OPMR050

REPORTING PERIOD _____ (see first page of the permit for specific reporting period and dates)

All information for the Title V Semi-Annual Deviation Reports must be certified by a responsible official as defined in Colorado Regulation No. 3, Part A, Section I.B.54. This signed certification document must be packaged with the documents being submitted.

STATEMENT OF COMPLETENESS

I have reviewed the information being submitted in its entirety and, based on information and belief formed after reasonable inquiry, I certify that the statements and information contained in this submittal are true, accurate and complete.

Please note that the Colorado Statutes state that any person who knowingly, as defined in Sub-Section 18-1-501(6), C.R.S., makes any false material statement, representation, or certification in this document is guilty of a misdemeanor and may be punished in accordance with the provisions of Sub-Section 25-7 122.1, C.R.S.

_____

Printed or Typed Name Title

_____

Signature of Responsible Official Date Signed

Note: Deviation reports shall be submitted to the Division at the address given in Appendix D of this permit. No copies need be sent to the U.S. EPA.

APPENDIX C
Required Format for Annual Compliance Certification Reports

Following is the format for the Compliance Certification report to be submitted to the Division and the U.S. EPA annually based on the effective date of the permit. The Table below must be completed for all equipment or processes for which specific Operating Permit terms exist.

FACILITY NAME: Western Sugar Cooperative – Fort Morgan Plant
OPERATING PERMIT NO: 95OPMR050
REPORTING PERIOD: _____

I. Facility Status

___ During the entire reporting period, this source was in compliance with **ALL** terms and conditions contained in the Permit, each term and condition of which is identified and included by this reference. The method(s) used to determine compliance is/are the method(s) specified in the Permit.

___ With the possible exception of the deviations identified in the table below, this source was in compliance with all terms and conditions contained in the Permit, each term and condition of which is identified and included by this reference, during the entire reporting period. The method used to determine compliance for each term and condition is the method specified in the Permit, unless otherwise indicated and described in the deviation report(s). Note that not all deviations are considered violations.

Operating Permit Unit ID	Unit Description	Deviations Reported [1]		Monitoring Method per Permit?[2]		Was compliance continuous or intermittent?[3]		Was Data Continuous?[4]	
		Previous	Current	Yes	No	Continuous	Intermittent	Yes	No
S001	Two Stoker/Babcock and Wilcox Stoker-Coal-Fired Steam Boilers.								
S002	Two Stearns/Rogers, Peabody Type MU24 (Order # 32971, 34882 - 1952), Natural Gas Fired Beet Pulp Dryers.								
S003	Four Beet Pulp Pellet mills and Coolers.								
S004	Two Sugar Granulators (East and West).								
S006	Conveyor Transfer Points and Silo Filling.								
S007	Slaking/Hydration of Calcium Oxide from Lime Kiln.								
S008	Fugitive Dust Emissions from Truck Traffic and Exposed Grounds.								

Operating Permit Unit ID	Unit Description	Deviations Reported [1]		Monitoring Method per Permit?[2]		Was compliance continuous or intermittent?[3]		Was Data Continuous?[4]	
		Previous	Current	Yes	No	Continuous	Intermittent	Yes	No
S009	Starch Unloading								
S010	Two Powdered Sugar Mills								
S013	Powdered Sugar Production Line Packer								
S014	Fine Granulated Sugar Industrial Bag Packaging Line and Warehouse								
S015	Selected Powdered Sugar Packaging Line Points								
S017	Facility-wide ammonia emissions								
Section IV - General Conditions[5]									
Insignificant Activities [5]									

[1] If deviations were noted in the previous deviation report (i.e. for the first six months of the annual reporting period), put an AX@ under Aprevious@. If deviations were noted in the current deviation report (i.e. for the last six months of the annual reporting period), put an AX@ under Acurrent@. Mark both columns if both apply.

[2] Note whether the method(s) used to determine the compliance status with each term and condition was the method(s) specified in the permit. If it was not, mark Ano@ and attach additional information/explanation.

[3] Note whether the compliance status with of each term and condition provided was continuous or intermittent. AIntermittent Compliance@ can mean either that noncompliance has occurred or that the owner or operator has data sufficient to certify compliance only on an intermittent basis. Certification of intermittent compliance therefore does not necessarily mean that any noncompliance has occurred.

NOTE:

The Periodic Monitoring requirements of the Operating Permit program rule are intended to provide assurance that even in the absence of a continuous system of monitoring the Title V source can demonstrate whether it has operated in continuous compliance for the duration of the reporting period. Therefore, if a source 1) conducts all of the monitoring and record keeping required in its permit, even if such activities are done periodically and not continuously, and if 2) such monitoring and record keeping does not indicate non-compliance, and if 3) the Responsible Official is not aware of any credible evidence that indicates non-compliance, then the Responsible Official can certify that the emission point(s) in question were in continuous compliance during the applicable time period.

[4] Note whether the method(s) used to determine the compliance status with each term and condition provided continuous or intermittent data.

[5] Compliance status for these sources shall be based on a reasonable inquiry using readily available information.

II. Status for Accidental Release Prevention Program:

A. This facility _____ is subject _____ is not subject to the provisions of the Accidental Release Prevention Program (Section 112(r) of the Federal Clean Air Act)

B. If subject: The facility _____ is _____ is not in compliance with all the requirements of section 112(r).

1. A Risk Management Plan _____ will be _____ has been submitted to the appropriate authority and/or the designated central location by the required date.

III. Certification

I have reviewed this certification in its entirety and, based on information and belief formed after reasonable inquiry, I certify that the statements and information contained in this certification are true, accurate and complete.

Please note that the Colorado Statutes state that any person who knowingly, as defined in §18-1-501(6), C.R.S., makes any false material statement, representation, or certification in this document is guilty of a misdemeanor and may be punished in accordance with the provisions of §25-7 122.1, C.R.S.

_____

Printed or Typed Name Title

_____

Signature Date Signed

NOTE: All compliance certifications shall be submitted to the Air Pollution Control Division and to the Environmental Protection Agency at the addresses listed in Appendix D of this Permit.

APPENDIX D

Notification Addresses

1. **Air Pollution Control Division**

Colorado Department of Public Health and Environment
Air Pollution Control Division
Operating Permits Unit
APCD-SS-B1
4300 Cherry Creek Drive S.
Denver, CO 80246-1530

ATTN: Jim King

2. **United States Environmental Protection Agency**

Compliance Notifications:

Office of Enforcement, Compliance and Environmental Justice
Mail Code 8ENF-T
U.S. Environmental Protection Agency, Region VIII
999 18th Street, Suite 300
Denver, CO 80202

Permit Modifications, Off Permit Changes:

Office of Partnerships and Regulatory Assistance
Air and Radiation Programs, 8P-AR
U.S. Environmental Protection Agency, Region VIII
999 18th Street, Suite 300
Denver, CO 80202

APPENDIX E

Permit Acronyms

Listed Alphabetically:

AIRS -	Aerometric Information Retrieval System
AP-42 -	EPA Document Compiling Air Pollutant Emission Factors
APEN -	Air Pollution Emission Notice (State of Colorado)
APCD -	Air Pollution Control Division (State of Colorado)
ASTM -	American Society for Testing and Materials
BACT -	Best Available Control Technology
BTU -	British Thermal Unit
CAA -	Clean Air Act (CAAA = Clean Air Act Amendments)
CCR -	Colorado Code of Regulations
CEM -	Continuous Emissions Monitor
CF -	Cubic Feet (SCF = Standard Cubic Feet)
CFR -	Code of Federal Regulations
CO -	Carbon Monoxide
COM -	Continuous Opacity Monitor
CRS -	Colorado Revised Statute
EF -	Emission Factor
EPA -	Environmental Protection Agency
FI -	Fuel Input Rate in MMBtu/hr
FR -	Federal Register
G -	Grams
GAL -	Gallon
GPM -	Gallons per Minute
HAPs -	Hazardous Air Pollutants
HP -	Horsepower
HP-HR -	Horsepower Hour (G/HP-HR = Grams per Horsepower Hour)
LAER	Lowest Achievable Emission Rate
LBS -	Pounds
M -	Thousand
MM -	Million
MMscf -	Million Standard Cubic Feet
MMscfd -	Million Standard Cubic Feet per Day
N/A or NA -	Not Applicable
NOx -	Nitrogen Oxides
NESHAP -	National Emission Standards for Hazardous Air Pollutants
NSPS -	New Source Performance Standards
P -	Process Weight Rate in Tons/Hr
PE -	Particulate Emissions
PM -	Particulate Matter

PM_{10} -	Particulate Matter Under 10 Microns
PSD -	Prevention of Significant Deterioration
PTE -	Potential To Emit
RACT -	Reasonably Available Control Technology
SCC -	Source Classification Code
SCF -	Standard Cubic Feet
SIC -	Standard Industrial Classification
SO_2 -	Sulfur Dioxide
TPY -	Tons Per Year
TSP -	Total Suspended Particulate
VOC -	Volatile Organic Compounds

APPENDIX F

Permit Modifications

DATE OF REVISION	TYPE OF MODIFICATION	SECTION NUMBER, CONDITION NUMBER	DESCRIPTION OF REVISION
April 8, 2003	Administrative Amendment	Section II, Summary Table 10	Starch unloading shown separately in error. The starch unloading is part of Selected Powdered Sugar Packaging Line Points. Remove Starch Unloading Row
		Section IV	Update language to current standard version.
April 13, 2007	Administrative	Section II, Summary Table 10	Revised the Fine Granulated Sugar emission factor to be consistent with the annual production maximum and the annual emission limit.

APPENDIX G

Compliance Assurance Monitoring (CAM) Plans

Copies of the Compliance Assurance Monitoring (CAM) plans follow this page.

WESTERN SUGAR
FORT MORGAN PLANT

COMPLIANCE ASSURANCE MONITORING

VENTURI SCRUBBER FOR PM CONTROL

A. Emission Unit

Facility:	Western Sugar Fort Morgan, Colorado
Identification:	S001
Description:	Two Babcock and Wilcox Coal Fired Boilers with Detroit Stoker Feeders Units have American Standard Series 301 Fly Ash collectors, low energy venturi scrubbers with one stack containing a mist eliminator

B. Applicable Regulations, Emission Limits and Monitoring Requirements

Regulation No.:	Colorado Regulation No. 1, Section III.A.1.b
Regulated Pollutant:	Particulate Matter
Emission Limit (Particulate Matter):	0.13 pound per million Btu of heat input
Monitoring Requirements:	Scrubber total water flow and pressure differential.

C. Control Technology

Each boiler has a low-energy venturi scrubber, the exhaust is combined in a common stack which has a chevron-style mist eliminator

D. Monitoring Approach

The key element of the monitoring approach for particulate matter, including the indicators to be monitored, indicator ranges and performance criteria are presented in Table 1 following.

MONITORING APPROACH

	Indicator No. 1	Indicator No. 2
I. Indicator	Scrubber water flow	Scrubber pressure drop
Measurement approach	Water flow – orifice plate with high and low pressure points connected to differential pressure transmitter	High and low pressure points connected to differential pressure transmitter
II. Indicator Range	An excursion is defined as the total water flow to the scrubber dropping below 100 gpm. The plug portion of the venturi and the cone portion both have water flow meters. Flow to each normally is greater than 100 gpm. An alarm signals if either flow drops below 100 gpm. An excursion triggers an inspection, corrective action, and a reporting requirement.	An excursion is defined as the pressure drop going below 2.5“ H_2O. An alarm sounds if the pressure drop is below 2.5”. An excursion triggers an inspection, corrective action and a reporting requirement.
III. Performance Criteria		
A. Data Representativeness	The orifice plates (minimum accuracy of ±5%) are located in the scrubber water line after the pumps and before the plug and cone.	The scrubber pressure drop connections are located upstream and downstream of the venturi scrubber in the air ducting.
B. Verification of Operational Status	NA – Existing equipment	NA – Existing equipment
C. QA/QC Practices	Orifice plates and differential pressure transmitters are inspected and calibrated each Intercampaign (annually).	Differential pressure transmitters are inspected and calibrated each Intercampaign (annually).
D. Monitoring Frequency	Water flow to the plug and cone portions of each venturi scrubber are measured continuously	Pressure drops across venturi scrubbers are measured continuously
E. Data Collection Procedure	A water flow value is recorded every 15 seconds on the computer graphic display. A water flow value is permanently recorded in the data acquisition system every 15 minutes.	A scrubber pressure differential value is recorded every 15 seconds on the computer graphic display. A scrubber pressure differential value is recorded in the data acquisition system every 15 minutes.
F. Averaging Period	Daily average of 15 minute instantaneous values recorded by Data Acquisition System	Daily average of 15 minute instantaneous values recorded by Data Acquisition System

JUSTIFICATION

I. Background

The pollutant is particulate matter from the combustion of coal in a stoker fed, traveling grate boiler. There are two boilers that are equipped with low-pressure venturi scrubbers. The emissions unit is the common stack from the two boilers and scrubbers. The scrubbers are the primary control devices for the control of particulate matter emissions. After the scrubbers, there is a common stack that has a chevron style mist eliminator and then the boiler exhaust gasses are vented to the atmosphere. The boilers are used to produce steam and electricity to run the process equipment. The boilers typically operate for about five to six months of the year. The emission unit is regulated under Colorado Regulation No. 1, Section III, A.1.b. The monitoring approach is reflected in the air permit as a specific permit condition.

II. Rationale for Selection of Performance Indicators

The following parameters will be monitored:

Scrubber water flow (total)
Scrubber pressure drop

A stack test was performed at each of several scrubber water flow rates and pressure drops. The results of those tests indicated the minimum flow rate necessary to be in compliance.

III. Rationale for Selection of Indicator Ranges

Stack testing to determine appropriate water flow and pressure drop to maintain particulate control was done in October 1996. EPA Methods 1-5 were followed. A stack test report was submitted to CDPHE. The results of the various stack test runs are shown in Table 1 (runs 1-3 were the formal compliance stack test at normal operating conditions).

Date of Stack Test		23-Oct-96		23-Oct-96		24-Oct-96		24-Oct-96	
		Run 4	Run 5	Run 6	Run 7	Run 8	Run 9	Run 10	Run 11
Blr 1	Plug gpm	153	153	107	106	203	203	151	150
	Cone gpm	155	152	106	105	211	210	150	148
	Total	308	305	213	211	414	413	301	298
Blr 2	Plug gpm	158	155	107	107	198	199	145	144
	Cone gpm	152	152	107	107	215	213	152	151
	Total	310	307	214	214	413	412	297	295
Blr 1	Delta P	5.3	5.7	5.0	5.0	4.4	4.5	3.4	3.5
Blr 2	Delta P	5.2	5.3	4.8	4.8	4.1	4.0	3.3	3.2
#/MMBTU		0.076	0.075	0.073	0.083	0.090	0.091	0.082	0.094

Water flow to the scrubber plug and cone is normally operated at 100 to 125 gpm each (a total of 200 to

250 gpm) as this keeps the scrubber surfaces wet and provides sufficient transport water for scrubbed particles. The scrubber pressure differential normally is operated at 3" to 5" and may be occasionally raised and lowered to flush the system of any buildup on the plug or cone surfaces.

The water flow rates to the venturi scrubber are a total flow rate number. The flow to the cone section and the flow to the plug section provides the total flow for each venturi scrubber. Stack tests were conducted down to a total combined plug-and-cone flow rate of 214 gpm for each scrubber and the emission results were approximately one-half of the permit limit. It was decided to set the permit limit at total flow in order to give a comfortable operating parameter that would ensure compliance. There are infinite combinations of air and water flow rates that could have been evaluated. The lowest water flow rate tested was below the minimum water flow rate operating experience found compatible with good operating performance. The same situation occurred for the pressure differential. The plug for the venturi scrubber can be raised to restrict the opening and thereby increase the pressure differential and enhance the contact time between the water and the boiler gases. Stack test data for a pressure differential in the 3.4 inches of water column range, again resulted in emissions at one-half of the permitted limit. The permit limit was set at 2.5 inches of water column to allow adjustments to be made to the plug location and have no issues with the performance --- the 3.4 inch water column setting was the lowest pressure differential that could be demonstrated under the testing protocol operating conditions.

An upper pressure differential limit does not need to be identified. The scrubbers are designed to operate effectively at a low differential pressure. A high pressure differential could indicate a high water flow rate through the scrubber resulting in improved gas scrubbing but more scrubber waste water for disposal. A high pressure differential could also signal the plug position is restricting the gas flow rate through the scrubber which would improve gas scrubbing but a waste of the energy needed to drive the gas flow.