

**MICHIGAN DEPARTMENT OF ENVIRONMENTAL QUALITY
AIR QUALITY DIVISION**

August 16, 2013

PERMIT TO INSTALL
340-08C

ISSUED TO
Almond Products, Incorporated

LOCATED AT
17150 148th Avenue
Spring Lake, Michigan

IN THE COUNTY OF
Ottawa

STATE REGISTRATION NUMBER
N6578

The Air Quality Division has approved this Permit to Install, pursuant to the delegation of authority from the Michigan Department of Environmental Quality. This permit is hereby issued in accordance with and subject to Section 5505(1) of Article II, Chapter I, Part 55, Air Pollution Control, of the Natural Resources and Environmental Protection Act, 1994 PA 451, as amended. Pursuant to Air Pollution Control Rule 336.1201(1), this permit constitutes the permittee's authority to install the identified emission unit(s) in accordance with all administrative rules of the Department and the attached conditions. Operation of the emission unit(s) identified in this Permit to Install is allowed pursuant to Rule 336.1201(6).

DATE OF RECEIPT OF ALL INFORMATION REQUIRED BY RULE 203:

August 2, 2013

DATE PERMIT TO INSTALL APPROVED:

August 16, 2013

SIGNATURE:

DATE PERMIT VOIDED:

SIGNATURE:

DATE PERMIT REVOKED:

SIGNATURE:

PERMIT TO INSTALL

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Common Abbreviations / Acronyms

Common Acronyms		Pollutant / Measurement Abbreviations	
AQD	Air Quality Division	BTU	British Thermal Unit
BACT	Best Available Control Technology	°C	Degrees Celsius
CAA	Clean Air Act	CO	Carbon Monoxide
CEM	Continuous Emission Monitoring	dscf	Dry standard cubic foot
CFR	Code of Federal Regulations	dscm	Dry standard cubic meter
CO ₂ e	Carbon Dioxide Equivalent	°F	Degrees Fahrenheit
COM	Continuous Opacity Monitoring	gr	Grains
EPA	Environmental Protection Agency	Hg	Mercury
EU	Emission Unit	hr	Hour
FG	Flexible Group	H ₂ S	Hydrogen Sulfide
GACS	Gallon of Applied Coating Solids	hp	Horsepower
GC	General Condition	lb	Pound
GHGs	Greenhouse Gases	kW	Kilowatt
HAP	Hazardous Air Pollutant	m	Meter
HVLP	High Volume Low Pressure *	mg	Milligram
ID	Identification	mm	Millimeter
LAER	Lowest Achievable Emission Rate	MM	Million
MACT	Maximum Achievable Control Technology	MW	Megawatts
MAERS	Michigan Air Emissions Reporting System	ng	Nanogram
MAP	Malfunction Abatement Plan	NO _x	Oxides of Nitrogen
MDEQ	Michigan Department of Environmental Quality (Department)	PM	Particulate Matter
MSDS	Material Safety Data Sheet	PM10	PM with aerodynamic diameter ≤10 microns
NESHAP	National Emission Standard for Hazardous Air Pollutants	PM2.5	PM with aerodynamic diameter ≤ 2.5 microns
NSPS	New Source Performance Standards	pph	Pounds per hour
NSR	New Source Review	ppm	Parts per million
PS	Performance Specification	ppmv	Parts per million by volume
PSD	Prevention of Significant Deterioration	ppmw	Parts per million by weight
PTE	Permanent Total Enclosure	psia	Pounds per square inch absolute
PTI	Permit to Install	psig	Pounds per square inch gauge
RACT	Reasonably Available Control Technology	scf	Standard cubic feet
ROP	Renewable Operating Permit	sec	Seconds
SC	Special Condition	SO ₂	Sulfur Dioxide
SCR	Selective Catalytic Reduction	THC	Total Hydrocarbons
SRN	State Registration Number	tpy	Tons per year
TAC	Toxic Air Contaminant	µg	Microgram
TEQ	Toxicity Equivalence Quotient	VOC	Volatile Organic Compound
VE	Visible Emissions	yr	Year

* For High Volume Low Pressure (HVLP) applicators, the pressure measured at the HVLP gun air cap shall not exceed ten (10) pounds per square inch gauge (psig).

GENERAL CONDITIONS

1. The process or process equipment covered by this permit shall not be reconstructed, relocated, or modified, unless a Permit to Install authorizing such action is issued by the Department, except to the extent such action is exempt from the Permit to Install requirements by any applicable rule. **(R 336.1201(1))**
2. If the installation, construction, reconstruction, relocation, or modification of the equipment for which this permit has been approved has not commenced within 18 months, or has been interrupted for 18 months, this permit shall become void unless otherwise authorized by the Department. Furthermore, the permittee or the designated authorized agent shall notify the Department via the Supervisor, Permit Section, Air Quality Division, Michigan Department of Environmental Quality, P.O. Box 30260, Lansing, Michigan 48909-7760, if it is decided not to pursue the installation, construction, reconstruction, relocation, or modification of the equipment allowed by this Permit to Install. **(R 336.1201(4))**
3. If this Permit to Install is issued for a process or process equipment located at a stationary source that is not subject to the Renewable Operating Permit program requirements pursuant to R 336.1210, operation of the process or process equipment is allowed by this permit if the equipment performs in accordance with the terms and conditions of this Permit to Install. **(R 336.1201(6)(b))**
4. The Department may, after notice and opportunity for a hearing, revoke this Permit to Install if evidence indicates the process or process equipment is not performing in accordance with the terms and conditions of this permit or is violating the Department's rules or the Clean Air Act. **(R 336.1201(8), Section 5510 of Act 451, PA 1994)**
5. The terms and conditions of this Permit to Install shall apply to any person or legal entity that now or hereafter owns or operates the process or process equipment at the location authorized by this Permit to Install. If the new owner or operator submits a written request to the Department pursuant to R 336.1219 and the Department approves the request, this permit will be amended to reflect the change of ownership or operational control. The request must include all of the information required by subrules (1)(a), (b), and (c) of R 336.1219 and shall be sent to the District Supervisor, Air Quality Division, Michigan Department of Environmental Quality. **(R 336.1219)**
6. Operation of this equipment shall not result in the emission of an air contaminant which causes injurious effects to human health or safety, animal life, plant life of significant economic value, or property, or which causes unreasonable interference with the comfortable enjoyment of life and property. **(R 336.1901)**
7. The permittee shall provide notice of an abnormal condition, start-up, shutdown, or malfunction that results in emissions of a hazardous or toxic air pollutant which continue for more than one hour in excess of any applicable standard or limitation, or emissions of any air contaminant continuing for more than two hours in excess of an applicable standard or limitation, as required in Rule 912, to the Department. The notice shall be provided not later than two business days after start-up, shutdown, or discovery of the abnormal condition or malfunction. Written reports, if required, must be filed with the Department within 10 days after the start-up or shutdown occurred, within 10 days after the abnormal conditions or malfunction has been corrected, or within 30 days of discovery of the abnormal condition or malfunction, whichever is first. The written reports shall include all of the information required in Rule 912(5). **(R 336.1912)**
8. Approval of this permit does not exempt the permittee from complying with any future applicable requirements which may be promulgated under Part 55 of 1994 PA 451, as amended or the Federal Clean Air Act.
9. Approval of this permit does not obviate the necessity of obtaining such permits or approvals from other units of government as required by law.
10. Operation of this equipment may be subject to other requirements of Part 55 of 1994 PA 451, as amended and the rules promulgated thereunder.

11. Except as provided in subrules (2) and (3) or unless the special conditions of the Permit to Install include an alternate opacity limit established pursuant to subrule (4) of R 336.1301, the permittee shall not cause or permit to be discharged into the outer air from a process or process equipment a visible emission of density greater than the most stringent of the following. The grading of visible emissions shall be determined in accordance with R 336.1303. **(R 336.1301)**
 - a. A six-minute average of 20 percent opacity, except for one six-minute average per hour of not more than 27 percent opacity.
 - b. A visible emission limit specified by an applicable federal new source performance standard.
 - c. A visible emission limit specified as a condition of this Permit to Install.

12. Collected air contaminants shall be removed as necessary to maintain the equipment at the required operating efficiency. The collection and disposal of air contaminants shall be performed in a manner so as to minimize the introduction of contaminants to the outer air. Transport of collected air contaminants in Priority I and II areas requires the use of material handling methods specified in R 336.1370(2). **(R 336.1370)**

13. The Department may require the permittee to conduct acceptable performance tests, at the permittee's expense, in accordance with R 336.2001 and R 336.2003, under any of the conditions listed in R 336.2001. **(R 336.2001)**

SPECIAL CONDITIONS

EMISSION UNIT SUMMARY TABLE

The descriptions provided below are for informational purposes and do not constitute enforceable conditions.

Emission Unit ID	Emission Unit Description (Process Equipment & Control Devices)	Flexible Group ID
EUSANDSTRIPPER	A Keppel Seghers, Inc. Fluid Clean B-3111/TNV/CEF/LIS fluidized bed sand stripper used to clean accumulated coatings from metal parts, racks, hooks, and/or hangers. The system includes a heated fluidized sand bed; a flame combustion zone maintained at the surface of the sand; a secondary afterburner; and a ceramic element filter particulate control system equipped with upstream exhaust air cooling.	NA
Changes to the equipment described in this table are subject to the requirements of R 336.1201, except as allowed by R 336.1278 to R 336.1290.		

The following conditions apply to: EUSANDSTRIPPER

DESCRIPTION: A Keppel Seghers, Inc. Fluid Clean B-3111/TNV/CEF/LIS fluidized bed sand stripper used to clean accumulated coatings from metal parts, racks, hooks, and/or hangers. The system includes a heated fluidized sand bed; a flame combustion zone maintained at the surface of the sand; a secondary afterburner; and a ceramic element filter particulate control system equipped with upstream exhaust air cooling.

Flexible Group ID: NA

POLLUTION CONTROL EQUIPMENT: A secondary afterburner; a ceramic element filter particulate control system equipped with upstream exhaust air cooling.

I. EMISSION LIMITS

Pollutant	Limit	Time Period / Operating Scenario	Equipment	Testing / Monitoring Method	Underlying Applicable Requirements
1. PM	0.006 lbs per 1000 lbs of exhaust gas ^a	Test Protocol*	EUSANDSTRIPPER	GC 13	R 336.1331(1)(c)
2. PM10	2.2 pph	Test Protocol*	EUSANDSTRIPPER	GC 13	40 CFR 52.21(c) & (d)
3. PM2.5	2.2 pph	Test Protocol*	EUSANDSTRIPPER	GC 13	40 CFR 52.21(c) & (d)
4. Hydrogen chloride (HCl)	9.6 lbs per batch	Test Protocol*	EUSANDSTRIPPER	SC V.1	R 336.1205, R 336.1224, R 336.1225
5. Hydrogen fluoride (HF)	11.5 lbs per batch	Test Protocol*	EUSANDSTRIPPER	SC V.1	R 336.1205, R 336.1224, R 336.1225
^a Calculated on a wet gas basis * Test protocol shall specify averaging time.					

6. Visible emissions from EUSANDSTRIPPER shall not exceed a six-minute average of 5 percent opacity. **(R 336.1301, R 336.1331)**

II. MATERIAL LIMITS

- The permittee shall not process more than 1,095 batches of material in EUSANDSTRIPPER that include coatings containing chromium or chromium compounds per 12-month rolling time period as determined at the end of each calendar month.¹ **(R 336.1224, R 336.1225)**
- The permittee shall not process more than 1,095 batches of material in EUSANDSTRIPPER that include coatings containing manganese or manganese compounds per 12-month rolling time period as determined at the end of each calendar month.¹ **(R 336.1224, R 336.1225)**
- The permittee shall not process more than 1,870 batches of material in EUSANDSTRIPPER that include coatings containing epoxy resins per 12-month rolling time period as determined at the end of each calendar month. **(R 336.1205, R 336.1224, R 336.1225)**
- The permittee shall not process more than 1,560 batches of material in EUSANDSTRIPPER that include coatings containing polytetrafluoroethylene (PTFE) resins per 12-month rolling time period as determined at the end of each calendar month. **(R 336.1205, R 336.1224, R 336.1225)**

5. The content of any coating removed from parts in EUSANDSTRIPPER shall not exceed 9.05 percent by weight of elemental chromium.¹ **(R 336.1224, R 336.1225)**
6. The content of any coating removed from parts in EUSANDSTRIPPER shall not exceed 5.5 percent by weight of manganese compounds.¹ **(R 336.1224, R 336.1225)**

III. PROCESS/OPERATIONAL RESTRICTIONS

1. The permittee shall not operate EUSANDSTRIPPER unless a malfunction abatement plan (MAP) as described in Rule 911(2), has been submitted within 60 days of permit issuance, and is implemented and maintained. The MAP shall, at a minimum, specify the following:
 - a. A complete preventative maintenance program including identification of the supervisory personnel responsible for overseeing the inspection, maintenance, and repair of air-cleaning devices, a description of the items or conditions that shall be inspected, the frequency of the inspections or repairs, and an identification of the major replacement parts that shall be maintained in inventory for quick replacement.
 - b. An identification of the source and air-cleaning device operating variables that shall be monitored to detect a malfunction or failure, the normal operating range of these variables, and a description of the method of monitoring or surveillance procedures.
 - c. A description of the corrective procedures or operational changes that shall be taken in the event of a malfunction or failure to achieve compliance with the applicable emission limits.

If at any time the MAP fails to address or inadequately addresses an event that meets the characteristics of a malfunction, the permittee shall amend the MAP within 45 days after such an event occurs. The permittee shall also amend the MAP within 45 days, if new equipment is installed or upon request from the District Supervisor. The permittee shall submit the MAP and any amendments to the MAP to the AQD District Supervisor for review and approval. If the AQD does not notify the permittee within 90 days of submittal, the MAP or amended MAP shall be considered approved. Until an amended plan is approved, the permittee shall implement corrective procedures or operational changes to achieve compliance with all applicable emission limits. **(R 336.1205, R 336.1225, R 336.1331, R 336.1702(a), R 336.1910, R 336.1911, 40 CFR 52.21(c) and (d))**

2. The permittee not shall process any material in EUSANDSTRIPPER other than cured coatings on metal parts, racks, hooks, and/or hangers. **(R 336.1205, R 336.1224, R 336.1225)**
3. The permittee shall dispose of all collected air contaminants in an acceptable manner in compliance with all applicable state rules and federal regulations. **(R 336.1224, R 336.1370)**

IV. DESIGN/EQUIPMENT PARAMETERS

1. The permittee shall not operate EUSANDSTRIPPER unless the secondary afterburner and ceramic element filter particulate control system equipped with upstream exhaust air cooling are installed, maintained, and operated in a satisfactory manner. Satisfactory operation of the secondary afterburner includes maintaining a minimum temperature of 1560°F (+/- 50°F) and a minimum retention time of 0.5 seconds. Satisfactory manner includes operating and maintaining each control device in accordance with an approved MAP as required in SC III.1. **(R 336.1205, R 336.1224, R 336.1225, R 336.1331, R 336.1702(a), R 336.1910, 40 CFR 52.21(c) and (d))**
2. The permittee shall install, calibrate, maintain and operate in a satisfactory manner a device to monitor and record the temperature for the secondary afterburner for EUSANDSTRIPPER on a continuous basis. **(R 336.1205, R 336.1224, R 336.1225, R 336.1702(a), R 336.1910)**
3. The permittee shall not operate EUSANDSTRIPPER unless the manufacturer's automatic temperature control system for the furnace and secondary afterburner is installed, maintained and operated in a satisfactory manner. **(R 336.1224, R 336.1225, R 336.1702(a), R 336.1910)**

4. The permittee shall not operate EUSANDSTRIPPER unless an interlock system that shuts down the furnace when the secondary afterburner is not operating properly is installed, maintained and operated in a satisfactory manner. **(R 336.1224, R 336.1225, R 336.1702(a), R 336.1910)**

V. TESTING/SAMPLING

Records shall be maintained on file for a period of five years. **(R 336.1201(3))**

1. Within 180 days after permit issuance, the permittee shall verify the HCl and HF emission rates from EUSANDSTRIPPER by testing at owner's expense, in accordance with Department requirements. No less than 30 days prior to testing, the permittee shall submit a complete test plan to the AQD Technical Programs Unit and District Office. The AQD must approve the final plan prior to testing. Verification of emission rates includes the submittal of a complete report of the test results to the AQD Technical Programs Unit and District Office within 60 days following the last date of the test. **(R 336.1205, R 336.1224, R 336.1225, R 336.2001, R 336.2003, R 336.2004)**

VI. MONITORING/RECORDKEEPING

Records shall be maintained on file for a period of five years. **(R 336.1201(3))**

1. The permittee shall complete all required records and calculations in a format acceptable to the AQD District Supervisor and make them available by the 15th day of the calendar month, for the previous calendar month, unless otherwise specified in any monitoring/recordkeeping special condition. **(R 336.1205, R 336.1224, R 336.1225, R 336.1702)**
2. The permittee shall maintain a current listing from the manufacturer of the chemical composition of each cured coating processed in EUSANDSTRIPPER, including the weight percent of each component. The data may consist of Material Safety Data Sheets, manufacturer's formulation data, or both as deemed acceptable by the AQD District Supervisor. **(R 336.1205, R 336.1224, R 336.1225)**
3. The permittee shall keep, in a satisfactory manner, continuous records of the afterburner temperature at all times when material is processed in EUSANDSTRIPPER. The permittee shall keep all records on file and make them available to the Department upon request. **(R 336.1205, R 336.1224, R 336.1225, R 336.1702(a), R 336.1910)**
4. The permittee shall conduct all necessary maintenance and make all necessary attempts to keep all components of EUSANDSTRIPPER maintained and operating in a satisfactory manner at all times. The permittee shall keep, in a satisfactory manner, a log of all significant maintenance activities conducted and all significant repairs made to EUSANDSTRIPPER. All records shall be kept on file and made available to the Department upon request. **(R 336.1205, R 336.1224, R 336.1225, R 336.1331, R 336.1702(a), R 336.1910, R 336.1911)**
5. The permittee shall keep the following information on a calendar month basis for EUSANDSTRIPPER:
 - a. The number of batches of material that include coatings containing chromium or chromium compounds processed per month and 12-month rolling time period as determined at the end of each calendar month.
 - b. The number of batches of material that include coatings containing manganese or manganese compounds processed per month and 12-month rolling time period as determined at the end of each calendar month.
 - c. The number of batches of material that include coatings containing epoxy resins processed per month and 12-month rolling time period as determined at the end of each calendar month.
 - d. The number of batches of material that include coatings containing PTFE resins processed per month and 12-month rolling time period as determined at the end of each calendar month.
 - e. The content of elemental chromium, in weight percent, of each chromium containing coating removed from parts in EUSANDSTRIPPER.

- f. The content of manganese compounds, in weight percent, of each manganese containing coating removed from parts in EUSANDSTRIPPER.
- g. The permittee shall keep records of any observations of excess ash on processed parts.

The permittee shall keep the records on file, in a format acceptable to the AQD District Supervisor, and make them available to the Department upon request. **(R 336.1205, R 336.1224, R 336.1225, R 336.1301, R 336.1331, R 336.1702(a), R 336.1910)**

VII. REPORTING

NA

VIII. STACK/VENT RESTRICTIONS

The exhaust gases from the stacks listed in the table below shall be discharged unobstructed vertically upwards to the ambient air unless otherwise noted:

Stack & Vent ID	Maximum Exhaust Diameter/ Dimensions (inches)	Minimum Height Above Ground (feet)	Underlying Applicable Requirements
1. SVSANDSTRIPPER	18	52	R 336.1225, 40 CFR 52.21(c) and (d)

IX. OTHER REQUIREMENTS

NA

Footnotes:

¹This condition is state only enforceable and was established pursuant to Rule 201(1)(b).