

## AIR QUALITY PERMIT

Issued to: Stone Container Corporation  
P.O. Box 4707  
Missoula, MT 59806-4707

Permit #2589-11  
Administrative Amendment (AA) Requests  
Received: 12/12/02, 4/21/03, 8/08/03, 9/10/03,  
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Department Decision on AA: 9/03/04  
Permit Final: 9/21/04  
AFS#: 030-063-0006

An air quality permit, with conditions, is hereby granted to the Stone Container Corporation (Stone) pursuant to Sections 75-2-204 and 211 of the Montana Code Annotated (MCA), as amended, and Administrative Rules of Montana (ARM) 17.8.740, *et seq.*, as amended, for the following:

### Section I: Permitted Facilities

#### A. Facility/Location

The Stone kraft pulp and liner mill is located in Frenchtown. A list of permitted equipment can be found below.

1. Three Recovery Boilers
  - a. #3 Recovery Boiler has a capacity of 385 million British thermal units (Btu) per hour input and is controlled with an electrostatic precipitator. It has continuous emission monitors (CEMs) for total reduced sulfur (TRS), required by state permit.
  - b. #4 Recovery Boiler has a capacity of 825 million Btu per hour input and is controlled with an electrostatic precipitator. It has CEMs for TRS, required by state permit.
  - c. #5 Recovery Boiler has a capacity of 330 million Btu per hour input and is controlled with an electrostatic precipitator. This boiler is subject to New Source Performance Standards (NSPS) and has CEMs for opacity and TRS. This recovery boiler is subject to NSPS Subpart BB.
2. Four Lime Kilns
  - a. #1 Lime Kiln has a capacity of 6.1 tons per hour of lime mud and is controlled with a wet venturi scrubber. The kiln has a CEM for TRS.
  - b. #2 Lime Kiln has a capacity of 6.1 tons per hour of lime mud and is controlled with a wet venturi scrubber. The kiln has a CEM for TRS.
  - c. #3 Lime Kiln has a capacity of 15.6 tons per hour of lime mud and is controlled with a wet venturi scrubber. The kiln has a CEM for TRS.
  - d. #4 Lime Kiln has a capacity of 12.7 tons per hour of lime mud and is controlled with a wet venturi scrubber. The kiln has a CEM for TRS. This lime kiln is subject to NSPS Subpart BB.

3. Three Dissolving Tanks

- a. #3 Smelt Dissolving Tank has a capacity of 29 tons per hour of black liquor solids. This dissolver is controlled with a wet scrubber.
- b. #4 Smelt Dissolving Tank has a capacity of 62.5 tons per hour of black liquor solids. This dissolver is controlled with a wet scrubber and a venturi scrubber.
- c. #5 Smelt Dissolving Tank has a capacity of 25 tons per hour of black liquor solids. This dissolver is controlled with a wet scrubber and is subject to NSPS Subpart BB.

4. Three Lime Slakers

- a. The #1 Lime Slaker is designed to accept a maximum green liquor flow of 400 gallons per minute (gpm). This slaker is controlled with a wet scrubber.
- b. The #2 Lime Slaker is designed to accept a maximum green liquor flow of 550 gpm. This slaker is controlled with a natural draft wet scrubber.
- c. The #3 Lime Slaker is designed to accept a maximum green liquor flow of 500 gpm. This slaker is controlled with a wet scrubber.

5. One Multi-fuel Boiler

This boiler is primarily fueled with wood residuals (other allowable fuels include natural gas, medium density fiberboard (MDF) pellets, old cardboard container (OCC) rejects, sludge, fuel oil and recycled oil). It has an input capacity of 537 million Btu per hour. The boiler is controlled with two wet venturi scrubbers, operated in parallel. The boiler is subject to NSPS Subpart D and has CEMs for both oxides of nitrogen (NO<sub>x</sub>) and sulfur dioxide (SO<sub>2</sub>).

6. One Natural Gas-Fired Boiler (Power Boiler)

This boiler is fired only with natural gas and has a capacity of 297 million Btu per hour. This boiler has no emission control on the stack.

7. Five Pulp Washers

- a. The PC Washer has a capacity of 20.2 tons per hour of air-dried pulp (ADP). This washer is controlled by a wet scrubber.
- b. The M&D Washer has a capacity of 17.2 tons per hour of ADP. This washer is a compaction baffle-type washer with no particulate emissions.
- c. The #1 Base Washer has a capacity of 38.6 tons per hour of ADP. This washer is controlled by a wet scrubber.
- d. The #2 Base Washer has a capacity of 38.6 tons per hour of ADP. This washer is controlled by a wet scrubber.

- e. The Top Washer has a capacity of 25.5 tons per hour of ADP. This washer is controlled by a wet scrubber.
8. Three Paper Machines
- a. #1 Paper Machine has a capacity of 29.5 tons per hour of ADP. There is no control on the paper machine ventilation.
  - b. #2 Paper Machine has a capacity of 29.5 tons per hour of ADP. There is no control on the paper machine ventilation.
  - c. #3 Paper Machine has a capacity of 59.6 tons per hour of ADP. There is no control on the paper machine ventilation.
9. Three Unloading Stations
- a. Salt Cake/Lime Unloading has a capacity of 20.0 tons per hour and is controlled with a baghouse.
  - b. Starch Unloading has a capacity of 7.5 tons per hour and is controlled with a baghouse.
  - c. Clay Unloading has a capacity of 13.0 tons per hour and is controlled with a baghouse.
10. Sawdust, Chip, and Hog Fuel Unloading
- a. #1 Dump (also called #5 Truck Dump) is used to unload trucks only and uses a belt system to convey chips and sawdust to the stockpiles. The sawdust conveyor shall be controlled by a hood and skirt at the end of the conveyor to limit the free drop height to a maximum of 10 feet.  
  
The length of the skirting will be determined at the time the hood and skirt are installed.  
  
A mechanism to allow for an inspector to measure the drop height must be provided at all times.
  - b. #2 Dump is used to unload trucks only and uses a conveyor belt to convey chips to the stockpiles.
  - c. #3 Dump is a combination truck or rail dump that conveys chips and sawdust, using a belt system, to the stockpiles. The sawdust conveyor shall be controlled by a hood and skirt at the end of the conveyor to limit the free drop height to a maximum of 10 feet.  
  
A mechanism to allow for an inspector to measure the drop height must be provided at all times.
  - d. Waste Fuel Combination Dumper is a combination truck or rail dump that conveys hog fuel by belt conveyor to the stockpiles or the scalping screen.

11. Sawdust, Chip, and Hog Fuel Handling
  - a. Sawdust is removed from storage using a screw reclaimer and disc scalping screen and conveyed to the digester with a pneumatic system and no other control.
  - b. Chips are removed from storage using hoppers and plate feeders or a drag chain and conveyed to the digesters with covered conveyers and no other control.
  - c. Hog fuel is removed from storage by a screw reclaimer and conveyed to the boilers with covered conveyer belts and no other control.
  
12. Sawdust and Chip Cyclones
  - a. M&D Cyclone delivers sawdust to the M&D Digester.
  - b. Pins Cyclone delivers chips to the Pins Digester.
  
13. Fiber Optimization and Raw Material Management System (FORMM) -- Screen Room
  - a. Nine gyratory screens and four disk screens will be used to separate sawdust and chips into overs, accept chips, pin chips, accept sawdust, fines, and hog fuel.
  - b. The FORMM System also contains a storage bin, a storage bin unloading system, and an enclosed belt conveying system.
  - c. Four air density separator (ADS) slicers will slice useable chips to acceptable thickness with a maximum rated capacity of 68,160 bone-dry lb/hour of chips per slicer. The limitations of the equipment installed with the slicers will limit the production of the slicers to 42,720 bone-dry lb/hour of chips per slicer.

The material to the slicers will have been screened. The transfer of the material to the slicers will be controlled by four ADS cyclones (one for each slicer).
  - d. A Micro-Pulsaire baghouse will be installed to control nuisance dust in the screen room. The cyclone for the sawdust in-feed will be connected to the baghouse.
  
14. Out-feed Systems Equipment
  - a. Kamyr chips shall be conveyed by covered belt conveyor to the Kamyr chip pile and no other controls.
  - b. Batch chips shall be conveyed by covered belt conveyor to the batch pile and no other controls.

- c. Pins shall be conveyed on a belt conveyor that discharges into a pneumatic conveying system, which transfers the pins to the pins pile and no other controls.
- d. The sawdust shall be fed from the surge bin into a new pneumatic conveying system that connects to the existing sawdust blow line and no controls. The sawdust blow line is existing.
- e. Fines from the chip screen and the sawdust screen shall be sent by a pneumatic conveying system to the hog fuel pile. These emissions will be controlled by a target plate and bunker at the end of the discharge pipe.
- f. ADS rejects shall be conveyed by belt conveyor to a truck or lugger bucket and transferred to the hog fuel pile by truck and no other controls.
- g. Sawdust overs to the chip pile shall be conveyed by a belt conveyor that discharges into a pneumatic system, which transfers the material to a cyclone discharging onto the chip pile outstocking belt conveyor. The outstocking belt conveyor transfers the chips to the chip stockpile. Stone shall install and maintain a weightometer on the sawdust overs belt to be used to determine the quantity of sawdust overs handled.

15. Sludge Dewatering Facility

Dewatered sludge from this facility is used as a fuel for the existing multi-fuel boiler. The rated output from the facility is 60 tons per day.

16. Other Equipment

Miscellaneous scales, gates, screens, blower, etc., as described in the drawings and the equipment list submitted with the application.

17. Cluster Rule MACT I Pollution Control Project

The Missoula Mill is classified as an unbleached Kraft pulp and paper mill following the discontinuation of bleaching operations at the mill during February 1999. Due to the fact that the Missoula Mill no longer operates a pulp bleaching system and has taken key bleach plant equipment out of service, the Cluster Rule standards for air emissions and effluent discharges related to the bleaching of pulp are not applicable to the Missoula Mill. The rule currently applicable to the Missoula Mill is 40 CFR 63, Subpart S (commonly referred to as "MACT I"). The Missoula Mill has installed and is operating the equipment described below to comply with the MACT I requirements, except for high volume, low concentration (HVLC) non-condensable gases (NCG), which have a compliance date of April 16, 2006.

a. Condensate Collection

The mill's condensate segregation system, which was installed and operating prior to the MACT I pollution control project involving digester and evaporator system condensates, has been modified to comply with the MACT I condensate segregation requirements. To comply with MACT I

requirements, condensate segregation and collection continues to occur on selected portions of evaporation and concentrator systems, Chip Kamyrdigester systems, and NCG system drains. A new condensate collection tank has been installed for storage of the segregated high-hazardous air pollutant (HAP) condensate prior to treatment. The mill has decommissioned the air stripper formerly used to treat collected condensate and replaced it with the steam stripper described below.

Depending on mill operations and equipment curtailments, condensate may be collected from any, or any combination, or the following sources: Nos. 1, 2, 3, 4, 5 Evaporators, Nos. 1 and 2 Concentrators, Turpentine Decanter, Batch Digester Blow Heat Recovery System, and the Low Volume, High Concentration (LVHC)-NCG Line Drains.

b. LVHC NCG Collection

To comply with the MACT I LVHC-NCG requirements, the mill modified its existing LVHC-NCG system, which has been operational since the early 1970's, to collect additional vents from the turpentine system, new foul condensate storage tank, selected portions of evaporator and concentrator systems including hotwells, a digester blow tank, a black liquor spill tank, and secondary and tertiary condensers on the batch blow heat recovery system, when operating.

c. Steam Stripper and Thermal Oxidizer

A new condensate steam stripper system has been installed at the Missoula Mill for treatment of the segregated high-HAP condensate. The condensate steam stripper system has been integrated with the mill's steam systems in order to most effectively use the steam required to operate the steam stripper system. The stripper overhead gas along with the LVHC-NCG is conveyed in a closed system to a new stand-alone thermal oxidizer designed to meet the MACT requirements for destruction of these gases.

Though not required by the MACT I requirements, the following process backup systems are currently being implemented should the new thermal oxidizer be unavailable:

- Modifications have been implemented to use No. 3 kiln for back-up combustion of the collected LVHC-NCG.
- When the steam stripper is down, the collected condensates are routed to the spill tank with the spill tank vent collected as part of the LVHC-NCG system. Condensate collected in the spill tank is processed through the mill's evaporator system.

B. Current Permit Action

Stone submitted a request for permit amendment on December 12, 2002, to make the Montana Air Quality permit (MAQP #2589-10) consistent with the Title V operating permit (OP2589-01). The requested changes include: removal of the hog fuel boiler and the No. 2 package boiler from the MAQP (these sources are no longer operational and have been removed), replacement of the term "Waste Fuel Boiler" with the term "Multi-

fuel Boiler” to reflect the true nature of the fuels burned in the boiler, updating the listing of sources in Section II.B of the MAQP that do not require annual testing per the testing requirements in the Title V permit, clarification of emission testing and reporting requirements, clarification of conditions/requirements of current operating scenarios already included in the Title V permit, and designation of all ambient air monitoring requirements as “State Only” (now possible under the revised ARM 17.8, Subchapter 7 rules (effective December 27, 2002)). In addition, Stone submitted de minimis requests on April 21, 2003; August 8, 2003; and September 10, 2003, which will be incorporated into the MAQP. The April 21, 2003, and September 10, 2003, requests included proposals to use wood residual pellets from the Plum Creek MDF Plant as a fuel in the multi-fuel boiler and to use recycled oil as a fuel in the lime kilns, multi-fuel boiler, and the recovery boilers. The Department determined that both fuels were consistent with currently permitted “wood waste” and “fuel oil” for those sources. The August 8, 2003, request included proposals for installation of the pollution control project for sources subject to 40 CFR 63, Subpart MM (hereinafter referred to as MACT II). The projects associated with MACT II are expected to provide a decrease in the Missoula Mill’s potential emissions. The August 4, 2004, request included comments on the amendment language previously discussed including clarifications to the permit to allow for the reporting timelines as specified in the Montana Source Test Protocol and Procedures Manual; deletion of NSPS limits when more stringent MACT II limits exist for the same unit (the NSPS limits remain applicable, but do not need to be listed in the MAQP in addition to the MACT II limits); modification of the multi-fuel boiler scrubbing solution pH limit to clarify that it must remain above 7 (alkaline) instead of increasing every time a stack test is performed, as it was previously stated; removal of requirements to report the number of hours above the 8 parts per million (ppm) 12-hour TRS standard for the lime kilns and recovery boilers because there was no regulatory authority for those requirements; and several other editorial clarifications. The August 9, 2004, request included a change to decrease the particulate matter (PM) and particulate matter less than 10 microns in size (PM<sub>10</sub>) emission limits on the FORMM baghouse to enable the removal of the hours of operation limit (previously 8544 hours) on that baghouse. The change would slightly decrease potential emissions.

## Section II: Limitations and Conditions

- A. The results of any single emission test or daily average from the continuous opacity monitors shall be evaluated against the specified hourly and daily maximum. Emission tests shall be conducted on the Recovery Boilers annually (semiannually if above 80% of the permit limit) and the Multi-fuel Boiler semiannually.
- B. The Micro-Pulsaire baghouse, Lime Slakers (No. 1, No. 2, and No. 3), Lime Kilns (No. 1, No. 2, No. 3, and No. 4), and Recovery Boiler Smelt Dissolving Tanks (No. 3, No. 4, and No. 5) shall be tested annually. Results of such tests shall be evaluated against the specified hourly and daily maximum.
- C. All source tests shall be conducted in accordance with the EPA sampling methods specified in 40 CFR Part 60, General Provisions, Appendix A, 40 CFR Part 51, Appendix M, and the Montana Source Test Protocol.
- D. Stone shall submit to the Department copies of all emission tests performed at Stone within 60 days of completion of each test or according to another reporting schedule as approved by the Department.

- E. All source tests to be used to demonstrate compliance with the conditions and limitations of this permit shall be performed at conditions, which are representative of maximum operating capacity or maximum permitted capacity of the affected facility or source, as required in the Montana Source Test Protocol and Procedures Manual, except for the following situations:
1. Stone shall test each recovery boiler annually for total particulate and PM<sub>10</sub> at 90% or greater of maximum rated capacity. If the results from the annual testing are at 80% of the permit limitation or greater, then testing shall occur on a semiannual basis. If Stone tests' results are below 80% of the permit limitations, then Stone may return to annual testing no later than one year from the last test date. The maximum daily operation rate shall be determined based on daily black liquor firing rate.
  2. Stone shall test the Multi-fuel Boiler semiannually for total particulate and PM<sub>10</sub> at 90% or greater of maximum daily average steam production rate achieved during the last three whole calendar months preceding the test. Daily average steam production shall be the average hourly steam production during a mill day (the 24-hour period from 5:00 am to 5:00 am).
  3. Stone shall report monthly the daily black liquor firing rate for each recovery boiler and the daily steam production for the Multi-fuel Boiler. This information shall be included with the monthly report.
- F. If a process is not operating, no testing, monitoring, or reporting will be required for that process during that time period.
- G. Individual Conditions For Sources:
1. #3 Recovery Boiler
    - a. Total suspended particulate emissions from this boiler shall not exceed 0.044 grains per dry standard cubic foot (gr/dscf) corrected to 8% oxygen (O<sub>2</sub>) concentration (ARM 17.8.342 and 40 CFR 63, Subpart MM) and, in no case, shall exceed 979 lb/calendar day and 40.79 lb/hr.
    - b. PM<sub>10</sub> emissions from this boiler shall not exceed 979 lb/calendar day and 40.79 lb/hr.
    - c. Total sulfate emissions from this boiler shall not exceed 979 lb/calendar day and 40.79 lb/hr.
    - d. TRS emissions from this boiler shall not exceed 5 ppm, 24-hour average.
    - e. Compliance with the above Section II.G.1.a-d standards shall be monitored by EPA source sampling methods specified in 40 CFR Part 60, Appendix A, including back-half particulate, and by monitoring as described in 40 CFR 63.864 or as approved by the Administrator, as applicable. PM<sub>10</sub> sampling methods are specified by 40 CFR Part 51, Appendix M. Total particulate results may be used as a surrogate for PM<sub>10</sub> if the impinger analysis ("back-half") is included. TRS emissions are determined by continuous monitoring with 24-hour averages.

- f. A CEM for TRS compounds is required for this source.
- g. The monthly average total suspended particulate shall not exceed 451 lb/day. Monthly emissions shall be monitored by continuous opacity monitoring. The opacity monitors will provide a 24-hour average opacity that will be converted to gr/dscf and then converted to lb/day and lb/month using the correlation between opacity and particulate emissions. Stone shall maintain a correlation between opacity and particulate emissions (from stack test results) and use this correlation to calculate daily and monthly averages.
- h. Stone shall submit to the Department, for approval, any proposed changes to the correlation between opacity and particulate emissions equation.
- i. Stone shall not discharge into the outdoor atmosphere emissions that exhibit 35% opacity or greater averaged over 6 consecutive minutes (ARM 17.8.321).
- j. Compliance with Section II.G.1.i above shall be monitored with the Continuous Opacity Monitoring System (COMS) as the primary measure of compliance with the opacity limit, except that 40 CFR Part 60, Appendix A, Method 9, may be used as a measure of compliance when there is reason to believe that COMS data is not accurate or when COMS data is unavailable (ARM 17.8.321(15)).

2. #4 Recovery Boiler

- a. Total suspended particulate emissions from this boiler shall not exceed 0.044 gr/dscf corrected to 8% O<sub>2</sub> concentration (ARM 17.8.342 and 40 CFR 63, Subpart MM) and, in no case, shall exceed 1253 lb/calendar day and 52.21 lb/hr.
- b. PM<sub>10</sub> emissions from this boiler shall not exceed 1253 lb/calendar day and 52.21 lb/hr.
- c. Total sulfate emissions from this boiler shall not exceed 1253 lb/calendar day and 52.21 lb/hr.
- d. TRS emissions from this boiler shall not exceed 5 ppm, 24-hour average.
- e. Compliance with the above Section II.G.2.a-d standards shall be monitored by EPA source sampling methods specified in 40 CFR Part 60, Appendix A, including back-half particulate, and by monitoring as described in 40 CFR 63.864 or as approved by the Administrator, as applicable. PM<sub>10</sub> sampling methods are specified by 40 CFR Part 51, Appendix M. Total particulate results may be used as a surrogate for PM<sub>10</sub> if the impinger analysis ("back-half") is included. TRS emissions are determined by continuous monitoring with 24-hour averages.
- f. A CEM for TRS compounds is required for this source.

- g. The monthly average total suspended particulate shall not exceed 928 lb/day. Monthly average emissions shall be monitored by continuous opacity monitoring. The opacity monitors will provide a 24-hour average opacity that will be converted to gr/dscf and then converted to lb/day and lb/month using the correlation between opacity and particulate emissions. Stone shall maintain a correlation between opacity and particulate emissions (from stack test results) and use this correlation to calculate daily and monthly averages.
- h. Stone shall submit for approval, to the Department, any proposed changes to the correlation between opacity and particulate emissions equation.
- i. Stone shall not discharge into the outdoor atmosphere emissions that exhibit 20% opacity or greater averaged over 6 consecutive minutes for more than 6% of the 6-minute time periods during which Stone is operating within a calendar quarter (ARM 17.8.321).
- j. Compliance with Section II.G.2.i above shall be monitored with COMS as the primary measure of compliance with the opacity limit, except that 40 CFR Part 60, Appendix A, Method 9, may be used as a measure of compliance when there is reason to believe that COMS data is not accurate or when COMS data is unavailable (ARM 17.8.321(15)).

3. #5 Recovery Boiler (NSPS- Subpart BB)

- a. Total suspended particulate emissions from this boiler shall not exceed 0.044 gr/dscf corrected to 8% O<sub>2</sub> concentration (ARM 17.8.340; 40 CFR 60, Subpart BB; ARM 17.8.342; and 40 CFR 63, Subpart MM) and, in no case, shall exceed 633.6 lb/day and 26.4 lb/hr.
- b. PM<sub>10</sub> emissions from this boiler shall not exceed 633.6 lb/day and 26.4 lb/hr.
- c. Total sulfate emissions from this boiler shall not exceed 633.6 lb/day and 26.4 lb/hr.
- d. TRS emissions from this boiler shall not exceed 5 ppm, 12-hour average.
- e. Compliance with the above Section II.G.3.a-d standards shall be monitored by EPA source sampling methods specified in 40 CFR Part 60, Appendix A, and by monitoring as described in 40 CFR 63.864, as applicable. PM<sub>10</sub> sampling methods are specified by 40 CFR Part 51, Appendix M. Total particulate results may be used as a surrogate for PM<sub>10</sub> if the impinger analysis (“back-half”) is included. TRS emissions are determined by continuous monitoring methods specified in 40 CFR Part 60, Appendix B, Performance Specifications 1 through 6, as applicable. Back-half is not required since this is an NSPS source.
- f. CEMs for opacity and TRS compounds are required for this source.

- g. The monthly average total suspended particulate shall not exceed 384 lb/day. Monthly average emissions shall be monitored by continuous opacity monitoring. The opacity monitors will provide a 24-hour average opacity that will be converted to gr/dscf and then converted to lb/day and lb/month, using the correlation between opacity and particulate emissions. Stone shall maintain a correlation between opacity and particulate emissions (from stack test results) and use this correlation to calculate daily and monthly averages.
  - h. Stone shall submit for approval, to the Department, any proposed changes to the correlation between opacity and particulate emissions equation.
  - i. Stone shall not discharge into the outdoor atmosphere emissions that exhibit 20% opacity or greater averaged over 6 consecutive minutes for more than 3% of the 6-minute time periods during which Stone is operating within a calendar quarter (ARM 17.8.321).
  - j. Compliance with Section II.G.3.i above shall be monitored with COMS as the primary measure of compliance with the opacity limit, except that 40 CFR Part 60, Appendix A, Method 9, may be used as a measure of compliance when there is reason to believe COMS data is not accurate or when COMS data is unavailable (ARM 17.8.321(15)).
4. #3 Smelt Dissolving Tank
- a. Total suspended particulate emissions from this source shall not exceed 0.20 lb/ton of black liquor solids processed (ARM 17.8.342 and 40 CFR 63, Subpart MM) and, in no case, shall exceed 140 lb/day and 5.83 lb/hr.
  - b. PM<sub>10</sub> emissions from this source shall not exceed 140 lb/day and 5.83 lb/hr.
  - c. Compliance with the above standards shall be monitored by EPA source sampling methods specified in 40 CFR Part 60, Appendix A, and by monitoring as described in 40 CFR 63.864, as applicable. PM<sub>10</sub> sampling methods are specified by 40 CFR Part 51, Appendix M. Total particulate results may be used as a surrogate for PM<sub>10</sub> if the impinger analysis (“back-half”) is included.
5. #4 Smelt Dissolving Tank
- a. Total suspended particulate emissions from this source shall not exceed 0.20 lb/ton of black liquor solids processed (ARM 17.8.342 and 40 CFR 63, Subpart MM) and, in no case, shall exceed 607 lb/day and 25.29 lb/hr.
  - b. PM<sub>10</sub> emissions from this source shall not exceed 607 lb/day and 25.29 lb/hr.
  - c. Compliance with the above standards shall be monitored by EPA source sampling methods specified in 40 CFR Part 60, Appendix A, and by monitoring as described in 40 CFR 63.864 or as approved by the

Administrator, as applicable. PM<sub>10</sub> sampling methods are specified by 40 CFR Part 51, Appendix M. Total particulate results may be used as a surrogate for PM<sub>10</sub> if the impinger analysis (“back-half”) is included.

6. #5 Smelt Dissolving Tank (NSPS- Subpart BB)
  - a. Total suspended particulate emissions from this source shall be limited to 0.20 lb/ton black liquor solids processed (ARM 17.8.342 and 40 CFR 63, Subpart MM), but in no case shall it exceed 120 lb/day and 5.0 lb/hr (ARM 17.8.340 and 40 CFR Part 60, Subpart BB).
  - b. PM<sub>10</sub> emissions from this source shall not exceed 120 lb/day and 5.00 lb/hr.
  - c. Compliance with the above standards shall be monitored by EPA source sampling methods specified in 40 CFR Part 60, Appendix A and Subpart BB, and by monitoring as described in 40 CFR 63.864 or as approved by the Administrator, as applicable. PM<sub>10</sub> sampling methods are specified by 40 CFR Part 51, Appendix M. Total particulate results may be used as a surrogate for PM<sub>10</sub> if the impinger analysis (“back-half”) is included.
  - d. Stone shall not discharge into the outdoor atmosphere emissions that exhibit 20% opacity or greater averaged over 6 consecutive minutes (ARM 17.8.304).
7. #1 Lime Kiln
  - a. Total suspended particulate emissions from this source shall not exceed 0.064 gr/dscf corrected to 10% O<sub>2</sub> concentration (ARM 17.8.342 and 40 CFR 63, Subpart MM) and, in no case, shall exceed 288 lb/day and 12.0 lb/hr.
  - b. PM<sub>10</sub> emissions from this source shall not exceed 288 lb/day and 12.0 lb/hr.
  - c. Total sulfate emissions from this source shall not exceed 259 lb/day and 10.79 lb/hr.
  - d. TRS emissions shall not exceed 20 ppm, 24-hour average.
  - e. Compliance with the above standards shall be monitored by EPA source sampling methods specified in 40 CFR Part 60, Appendix A, including back-half particulate, and by monitoring as described in 40 CFR 63.864, as applicable. PM<sub>10</sub> sampling methods are specified by 40 CFR Part 51, Appendix M, including back-half particulate. Total particulate results may be used as a surrogate for PM<sub>10</sub> if the impinger analysis (“back-half”) is included. TRS emissions are determined by continuous monitoring with 24-hour averages.
  - f. A CEM for TRS compounds is required for this source.
8. #2 Lime Kiln

- a. Total suspended particulate emissions from this source shall not exceed 0.064 gr/dscf corrected to 10% O<sub>2</sub> concentration (ARM 17.8.342 and 40 CFR 63, Subpart MM) and, in no case, shall exceed 266 lb/day and 11.08 lb/hr.
- b. PM<sub>10</sub> emissions from this source shall not exceed 266 lb/day and 11.08 lb/hr.
- c. Total sulfate emissions from this source shall not exceed 239 lb/day and 9.96 lb/hr.
- d. TRS emissions shall not exceed 20 ppm, 24-hour average.
- e. Compliance with the above standards shall be monitored by EPA source sampling methods specified in 40 CFR Part 60, Appendix A, including back-half particulate, and by monitoring as described in 40 CFR 63.864, as applicable. PM<sub>10</sub> sampling methods are specified by 40 CFR Part 51, Appendix M, including back-half particulate. Total particulate results may be used as a surrogate for PM<sub>10</sub> if the impinger analysis (“back-half”) is included. TRS emissions are determined by continuous monitoring, with 24-hour averages.
- f. A CEM for TRS compounds is required for this source.

9. #3 Lime Kiln

- a. Total suspended particulate emissions from this source shall not exceed 0.064 gr/dscf corrected to 10% O<sub>2</sub> concentration (ARM 17.8.342 and 40 CFR 63, Subpart MM) and, in no case, shall exceed 359 lb/day and 14.96 lb/hr.
- b. PM<sub>10</sub> emissions from this source shall not exceed 359 lb/day and 14.96 lb/hr.
- c. Total sulfate emissions from this source shall not exceed 323 lb/day and 13.46 lb/hr.
- d. TRS emissions shall not exceed 20 ppm, 24-hour average.
- e. Compliance with the above standards shall be monitored by EPA source sampling methods specified in 40 CFR Part 60, Appendix A, including back-half particulate, and by monitoring as described in 40 CFR 63.864, as applicable. PM<sub>10</sub> sampling methods are specified by 40 CFR Part 51, Appendix M, including back-half particulate. Total particulate results may be used as a surrogate for PM<sub>10</sub> if the impinger analysis (“back-half”) is included. TRS emissions are determined by continuous monitoring with 24-hour averages.
- f. A CEM for TRS compounds is required for this source.

10. #4 Lime Kiln (NSPS - Subpart BB)

- a. Total suspended particulate emissions from this source shall be limited to 0.064 gr/dscf corrected to 10% O<sub>2</sub> concentration (ARM 17.8.342 and 40

CFR 63, Subpart MM), and, in no case, shall exceed 204.0 lb/day and 8.50 lb/hr. This limitation is consistent with a maximum flow rate of 14,800 dscfm. The analysis for the coke conversion shows no increase in particulate emissions from this source (ARM 17.8.340 and 40 CFR Part 60, Subpart BB).

- b.  $PM_{10}$  emissions from this source shall not exceed 204.0 lb/day and 8.50 lb/hr.
- c. Total sulfate emissions from this source shall not exceed 204.0 lb/day and 8.50 lb/hr.
- d. TRS emissions shall not exceed 8.0 ppm, 12-hour average.
- e. Compliance with the above standards shall be monitored by EPA source sampling methods specified in 40 CFR Part 60, Appendix A and Subpart BB, and by monitoring as described in 40 CFR 63.864, as applicable.  $PM_{10}$  sampling methods are specified by 40 CFR Part 51, Appendix M. Total particulate results may be used as a surrogate for  $PM_{10}$  if the impinger analysis (“back-half”) is included. TRS emissions are determined by continuous monitoring, with 12-hour averages.
- f. A CEM for TRS compounds is required for this source.

NOTE: The permit analysis for the coke conversion project permitted in January 1987 shows no increase in the allowable particulate from the #4 Lime Kiln. Therefore, the Department feels the NSPS limit of 0.067 gr/dscf is still applicable to this source.

- g. Opacity is limited to 20% (ARM 17.8.304).

11. #1 Lime Slaker

- a. Total suspended particulate emissions from this source shall not exceed 110 lb/day and 4.58 lb/hr.
- b.  $PM_{10}$  emissions from this source shall not exceed 110 lb/day and 4.58 lb/hr.
- c. Compliance with the above standards shall be monitored by EPA source sampling methods specified in 40 CFR Part 60, Appendix A, including back-half particulate.  $PM_{10}$  sampling methods are specified by 40 CFR Part 51, Appendix M. Total particulate results may be used as a surrogate for  $PM_{10}$  if the impinger analysis (“back-half”) is included.

12. #2 Lime Slaker

- a. Opacity is limited to 20% (ARM 17.8.304).
- b. Total suspended particulate emissions from this source shall not exceed 146 lb/day and 6.08 lb/hr (ARM 17.8.752).
- c.  $PM_{10}$  emissions from this source shall not exceed 146 lb/day and 6.08 lb/hr (ARM 17.8.752).

- d. Compliance with the above standards shall be monitored by EPA source sampling methods specified in 40 CFR Part 60, Appendix A, including back-half particulate. PM<sub>10</sub> sampling methods are specified by 40 CFR Part 51, Appendix M. Total particulate results may be used as a surrogate for PM<sub>10</sub> if the impinger analysis (“back-half”) is included.
13. #3 Lime Slaker
- a. Total suspended particulate emissions from this source shall not exceed 72 lb/day and 3.00 lb/hr.
  - b. PM<sub>10</sub> emissions from this source shall not exceed 72 lb/day and 3.00 lb/hr.
  - c. Compliance with the above standards shall be monitored by EPA source sampling methods specified in 40 CFR Part 60, Appendix A, including back-half particulate. PM<sub>10</sub> sampling methods are specified by 40 CFR Part 51, Appendix M. Total particulate results may be used as a surrogate for PM<sub>10</sub> if the impinger analysis (“back-half”) is included.
14. Multi-fuel Boiler (NSPS, Subpart D)
- a. Consumption of dewatered sludge from the sludge dewatering plant by the multi-fuel boiler shall not exceed a total of 21,900 tons/year (ARM 17.8.752).
  - b. Sulfur content of the dewatered sludge used as fuel for the multi-fuel boiler shall not exceed 0.4% (ARM 17.8.752).
  - c. Any dewatered sludge used as fuel for the multi-fuel boiler shall originate from the primary clarifier (ARM 17.8.749).
  - d. The dewatered sludge shall be thoroughly blended with the existing hog fuel (ARM 17.8.749).
  - e. The pH of the scrubber water on the multi-fuel boiler shall be maintained at greater than 7 (ARM 17.8.749).
  - f. Emissions of SO<sub>2</sub> from the multi-fuel boiler shall be limited to 5.70 lb/hr (ARM 17.8.752).
  - g. Stone shall conduct an analysis of the dewatered sludge to determine compliance with the above sulfur limitation at least quarterly. The results of these analyses shall be retained by Stone for a minimum of 5 years and shall be submitted to the Department upon request.
  - h. Total suspended particulate emissions from this boiler shall not exceed 0.10 lb/million Btu fired and 52.04 lb/hr and 1249 lb/day (ARM 17.8.340 and 40 CFR, Part 60, Subpart D).
  - i. PM<sub>10</sub> emissions from this boiler shall not exceed 1249 lb/day and 52.04 lb/hr and 0.1 lb/million Btu fired.

- j. SO<sub>2</sub> emissions from this source shall not exceed 0.80 lb/million Btu and 429.6 lb/hr when firing liquid fossil fuel or liquid fossil fuel and wood residue (ARM 17.8.340 and 40 CFR, Part 60, Subpart D).
- k. Nitrogen dioxide (NO<sub>2</sub>) emissions from this boiler shall not exceed 0.30 lb/million Btu and 161.1 lb/hr when firing liquid or gaseous fossil fuel and wood residue. This limit also applies when firing exclusively on natural gas because of a malfunction of the wood feed or ash handling systems (ARM 17.8.340 and 40 CFR Part 60, Subpart D).
- l. Compliance with the above standards shall be monitored by EPA source sampling methods specified in 40 CFR Part 60, Appendix A and Subpart D. PM<sub>10</sub> sampling methods are specified by 40 CFR Part 51, Appendix M. Total particulate results may be used as a surrogate for PM<sub>10</sub> if the impinger analysis (“back-half”) is included.
- m. CEMs for SO<sub>2</sub>, NO<sub>2</sub>, and either O<sub>2</sub> or carbon dioxide (CO<sub>2</sub>) are required for this source.
- n. Opacity is limited to 20% (ARM 17.8.340 and 40 CFR Part 60, Subpart D).

15. Sawdust, Chips, and Hog Fuel Unloading, Storage, and Handling

- a. i. Sawdust - This activity is limited to 0.75 lb/ton of sawdust handled for total particulate and 0.27 lb/ton of sawdust handled for PM<sub>10</sub> (SCC #3-07-008-03) with hood and skirt controls at 25%.

The total sawdust pile emissions shall be calculated as:  $TSP = \{(Qty\ Sawdust\ overs) * (0.18 * [1-.25]) / 2000 + (Qty\ Sawdust\ receipts - Qty\ Sawdust\ overs) * (1.0 * [1-.25]) / 2000\} = Total\ tons\ total\ particulate\ emissions.$

The total sawdust pile emissions shall be calculated as:  $PM_{10} = \{(Qty\ Sawdust\ overs) * (0.065 * [1-.25]) / 2000 + (Qty\ Sawdust\ receipts - Qty\ Sawdust\ overs) * (0.36 * [1-.25]) / 2000\} = Total\ tons\ PM_{10}\ emissions.$

- ii. Stone shall ensure that the 10-ft maximum distance is met at all times. When the material under the belt is reclaimed, Stone shall shut down the conveyor, remove the material, and fill in the void with new material before restarting the conveyor to ensure the 10-ft maximum is met.
- b. Chips - This activity is limited to 0.18 lb/ton of chips handled for total particulate and 0.065 lb/ton of chips handled for PM<sub>10</sub> (State emission estimate).

- c. Hog Fuel - This activity is limited to 1.0 lb/ton of hog fuel handled for total particulate and 0.36 lb/ton of hog fuel handled for PM<sub>10</sub> (SCC #3-07-008-03).
  - d. Fines sent to hog fuel from chip screen - This activity is limited to 0.27 lb/ton (controlled) of fines handled for total particulate and 0.09 lb/ton (controlled) of fines handled for PM<sub>10</sub> (Stone emission estimate).
  - e. Fines sent to hog fuel from sawdust screen - This activity is limited to 0.75 lb/ton (controlled) of fines handled for total particulate and 0.27 lb/ton (controlled) of fines handled for PM<sub>10</sub> (Stone emission estimate).
  - f. Screened pins sent to stockpile - This activity is limited to 0.09 lb/ton of pins handled for total particulate and 0.005 lb/ton of pins handled for PM<sub>10</sub> (Stone emission estimate).
  - g. Screened chips to Kamyr pile - This activity is limited to 0.045 lb/ton of chips handled for total particulate and 0.001 lb/ton of pins handled for PM<sub>10</sub> (Stone emission estimate).
  - h. Screened chips to batch pile - This activity is limited to 0.045 lb/ton of chips handled for total particulate and 0.001 lb/ton of pins handled for PM<sub>10</sub> (Stone emission estimate).
  - i. Screened sawdust overs to chip pile - This activity is limited to 0.09 lb/ton of pins handled for total particulate and 0.005 lb/ton of pins handled for PM<sub>10</sub> (Stone emission estimate).
  - j. Visible emissions from the proposed storage bin and the proposed storage bin unloading system shall be limited to 20% opacity (ARM 17.8.308 and ARM 17.8.304).
16. Brown Stock Washers
- a. Particulate emissions from the Brown Stock Washers shall be limited to a total of 128 lb/day and 5.33 lb/hr.
  - b. Compliance with the above standards shall be monitored by EPA source sampling methods specified in 40 CFR Part 60, Appendix A. PM<sub>10</sub> sampling methods are specified by 40 CFR Part 51, Appendix M. Total particulate results may be used as a surrogate for PM<sub>10</sub> if the impinger analysis (“back-half”) is included.
17. Batch and Continuous Digesters
- a. All gaseous emissions from these units shall be ducted to the thermal oxidizer for oxidation of reduced sulfur compounds.
  - b. All gaseous emissions from the steam stripper shall be ducted to the thermal oxidizer for oxidation of reduced sulfur compounds.
18. M & D Cyclone
- a. Total suspended particulate emissions from this cyclone shall be limited to 60 lb/day and 2.5 lb/hr.

- b. PM<sub>10</sub> emissions from this cyclone shall be limited to 24 lb/day and 1.0 lb/hr.
- c. If the Department requires testing per ARM 17.8.105, compliance with the above standards shall be monitored by EPA source sampling methods specified in 40 CFR Part 60, Appendix A. PM<sub>10</sub> sampling methods are specified by 40 CFR Part 51, Appendix M. Total particulate results may be used as a surrogate for PM<sub>10</sub> if the impinger analysis (“back-half”) is included.
- d. This cyclone shall not be operated more than 8544 hours per year.

19. Pins Cyclone

- a. Total suspended particulate emissions from this cyclone shall be limited to 60 lb/day and 2.5 lb/hr.
- b. PM<sub>10</sub> emissions from this cyclone shall be limited to 24 lb/day and 1.0 lb/hr.
- c. If the Department requires testing per ARM 17.8.105, compliance with the above standards shall be monitored by EPA source sampling methods specified in 40 CFR Part 60, Appendix A. PM<sub>10</sub> sampling methods are specified by 40 CFR Part 51, Appendix M. Total particulate results may be used as a surrogate for PM<sub>10</sub> if the impinger analysis (“back-half”) is included.
- d. This cyclone shall not be operated more than 8544 hours/year.

20. Micro-Pulsaire Baghouse (controls sawdust transfer and nuisance dust for the FORMM system)

- a. Total suspended particulate emissions from this baghouse shall be limited to 22.8 lb/day and 0.95 lb/hr.
- b. PM<sub>10</sub> emissions from this baghouse shall be limited to 22.8 lb/day and 0.95 lb/hr.
- c. This baghouse shall be tested to monitor compliance with the limitations included in items 20.a and 20.b annually.
- d. Compliance with the above standards shall be monitored by EPA source sampling methods specified in 40 CFR Part 60, Appendix A. PM<sub>10</sub> sampling methods are specified by 40 CFR Part 51, Appendix M. Total particulate results may be used as a surrogate for PM<sub>10</sub> if the impinger analysis (“back-half”) is included.

21. ADS Slicers and Cyclones

- a. Total suspended particulate emissions from these sources shall not exceed 26.4 lb/day and 1.10 lb/hr for each cyclone.
- b. PM<sub>10</sub> emissions from this source shall not exceed 26.4 lb/day and 1.1 lb/hr for each cyclone.

- c. If the Department requires testing per ARM 17.8.105, compliance with the above standards shall be monitored by EPA source sampling methods specified in 40 CFR Part 60, Appendix A. PM<sub>10</sub> sampling methods are specified by 40 CFR Part 51, Appendix M. Total particulate results may be used as a surrogate for PM<sub>10</sub> if the impinger analysis (“back-half”) is included.
- d. These cyclones shall not be operated more than 8544 hours per year per cyclone.

22. Sawdust Overs Cyclone

- a. Total suspended particulate emissions from these sources shall not exceed 26.4 lb/day and 1.1 lb/hr for each cyclone.
- b. PM<sub>10</sub> emissions from this source shall not exceed 26.4 lb/day and 1.1 lb/hr for each cyclone.
- c. If the Department requires testing per ARM 17.8.105, compliance with the above standards shall be monitored by EPA source sampling methods specified in 40 CFR Part 60, Appendix A. PM<sub>10</sub> sampling methods are specified by 40 CFR Part 51, Appendix M. Total particulate results may be used as a surrogate for PM<sub>10</sub> if the impinger analysis (“back-half”) is included.
- d. This cyclone shall not be operated more than 8544 hours/year.

23. #3 Paper Machine

The yearly production from the #3 Paper Machine shall be limited to 481,000 tons of ADP per year. This limit includes pulp input from the pulp mill, as well as other sources (i.e., the old cardboard container (OCC) plant) and correlates to a limit of 460,993 machine tons of paper produced per year.

24. Scrubber Operational Checks

The following scrubber operational checks shall be performed on a weekly basis.

- a. Lime Kilns
  - i. Scrubber water flow
  - ii. Scrubber water solids
  - iii. Scrubber pressure differential
- b. Smelt Tank Vents
  - i. Scrubber shower water flows
  - ii. Scrubber pressure differential (for the No. 5 Dissolving Tank, this requirement is replaced by the requirement to check that the fan is operating)
  - iii. Bypass conditions
- c. Multi-fuel Boiler
  - i. Scrubber shower water flows
  - ii. Scrubber water solids

- iii. Scrubber pressure differential
    - iv. Scrubber water pH check (pH 7-9)
  - d. Stone shall maintain a record of such checks, which the Department may inspect at any time.
  
- 25. Plant-Wide SO<sub>2</sub> Limitation

Total SO<sub>2</sub> emissions from the mill shall not exceed 5000 lb/day. In the event of a total natural gas curtailment, Stone shall report, in addition to the normal report, the following:

  - a. Daily SO<sub>2</sub> emissions from recovery boilers and power boilers.
  - b. Dates and times of curtailment.
  - c. Quantity and sulfur content of fuel oil burned.
  - d. All fuel oil burned must comply with ARM 17.8.322 – Sulfur In Fuel Oil rule, unless sulfur dioxide emissions are controlled on an equivalent basis.
  
- 26. NSPS Testing Requirements -- Those sources subject to Federal New Source Performance Standards shall comply with the testing, monitoring, and reporting requirements as applicable (ARM 17.8.340 and 40 CFR 60).
  
- 27. Stone shall not cause or authorize emissions to be discharged into the atmosphere that exhibit an opacity of 40% or greater, based on a 6-minute average, from any source, stack or fugitive installed on or before November 23, 1968 (ARM 17.8.304 and ARM 17.8.308).
  
- 28. Stone shall not cause or authorize to be discharged into the atmosphere visible emissions that exhibit an opacity of 20% or greater, based on a 6-minute average, from any source, stack or fugitive installed or altered after November 23, 1968, unless otherwise specified (ARM 17.8.304 and ARM 17.8.308).
  
- 29. Stone shall not cause or authorize to be discharged into the atmosphere from the thermal oxidizer:
  - a. Any visible emissions that exhibit an opacity of 20% or greater (ARM 17.8.752); and
  - b. Any particulate matter emissions in excess of 0.10 gr/dscf corrected to 10% O<sub>2</sub> (ARM 17.8.752).
  
- 30. Stone shall comply with all applicable standards and limitations, and the reporting, recordkeeping, and notification requirements contained in 40 CFR 63, Subpart S (ARM 17.8.342 and 40 CFR 63, Subpart S).
  
- 31. Plant-wide Wood Pulp Limitation (ARM 17.8.749)

Total wood pulp production shall not exceed 535,000 oven-dry tons (ODT) per rolling 12-month period. Wood pulp production shall be calculated based on a mill day (24 hour period starting at 5:00 am) using the following methodology (equations a-c):

- a. Fiber usage on machines (tons, as produced) = Paper machine production (tons, as produced) +/- change in Cull production inventory (tons, as produced)
  - b. Fiber usage on machines (oven-dry tons) = Fiber usage on machines (tons, as produced) x (1.0 – moisture content of paper – chemical additive content of the linerboard)
  - c. Wood pulp production (ODT) = Fiber usage on machines (ODT) – OCC usage on machines (ODT) +/- Wood pulp high density storage change (ODT).
32. Stone shall comply with all applicable standards and limitations, and the reporting, recordkeeping, and notification requirements contained in 40 CFR Part 63, Subpart MM (ARM 17.8.342 and 40 CFR 63, Subpart MM).
33. The Department may require further testing (ARM 17.8.105).

### Section III: Continuous Emission Monitoring Systems

#### A. No. 3 and No. 4 Recovery Boilers

1. Opacity CEMs are to be operated and maintained on the No. 3 and No. 4 Recovery Boilers. These CEMs are required to conform to federal specifications. The opacity CEMs are required to provide a daily (calendar day) average opacity reading.
2. A TRS CEM is required by state permit for each boiler. This CEM is not required to conform to federal specifications. Stone already has Barton titrators in place to fulfill this requirement. These monitors do not meet federal specifications because the response time is too slow; however, it is sufficient to monitor this pollutant at this time.

#### B. #5 Recovery Boiler (NSPS, Subpart BB)

1. An opacity CEM is required by state permit and federal regulations. This CEM shall conform to Performance Specification 1 found in 40 CFR Part 60, Appendix B.
2. This opacity CEM shall have a span set at 70 percent opacity as required by 40 CFR, Part 60, Appendix B and Subpart BB.
3. A TRS CEM is required by state permit and federal regulation. This CEM shall conform to federal specifications as required by 40 CFR Part 60, Appendix B, Specification 5.

#### C. #1, #2, and #3 Lime Kilns

A TRS CEM is required by state permit for each kiln. This CEM is not required to conform to federal specifications. Stone already has Barton titrators in place to fulfill this requirement. These monitors do not meet federal specifications because the response time is too slow; however, it is sufficient to monitor this pollutant at this time.

D. #4 Lime Kiln (NSPS, Subpart BB)

A TRS CEM is required by state permit and federal regulations. This CEM shall conform to federal specifications as required by 40 CFR Part 60, Appendix B, Specification 5.

E. Multi-fuel Boiler (NSPS, Subpart D)

1. An SO<sub>2</sub> CEM is required by federal regulation and state permit when this boiler is fired on oil. This CEM shall conform to federal specifications as required by Specification 2 of 40 CFR Part 60, Appendix B.
2. A NO<sub>x</sub> CEM is required by federal regulation and state permit. This CEM shall conform to federal specifications as required by Specification 2 of 40 CFR Part 60, Appendix B.
3. Either an O<sub>2</sub> or CO<sub>2</sub> CEM is required as provided in 40 CFR Part 60.45.

Section IV: Reporting Requirements

A. Operational and Emission Inventory Reporting Requirements

1. Stone shall supply the Department with annual production information for all emission points, as required by the Department in the annual emission inventory request. The request will include, but is not limited to, all sources of emissions identified in the emission inventory contained in the permit analysis and sources identified in Section I of this permit.

Production information shall be gathered on a calendar-year basis and submitted to the Department by the date required in the emission inventory request. Information shall be in the units required by the Department and shall include, but is not limited to, the following (ARM 17.8.505):

<u>SOURCE</u>	<u>UNITS OF MATERIAL PROCESSED</u>
a. Multi-fuel Boiler	Hog Fuel (including MDF pellets) - ton/yr Nat Gas - MCF/yr Fuel Oil (including recycled oil) - Mgal/yr Dewatered Sludge - ton/yr
b. Power Boiler	Nat Gas - MCF/yr
c. #3 Recovery Boiler	Black Liquor - ton/yr Nat Gas - MCF/yr
d. #4 Recovery Boiler	Black Liquor - ton/yr Nat Gas - MCF/yr Fuel Oil (including recycled oil) - Mgal/yr
e. #5 Recovery Boiler	Black Liquor - ton/yr

	Nat Gas - MCF/yr Fuel Oil (including recycled oil) - Mgal/yr
f. #1 Lime Kiln	Nat Gas - MCF/yr Fuel Oil (including recycled oil) - Mgal/yr Lime Mud - ton/yr Petrol Coke - ton/yr
g. #2 Lime Kiln	Nat Gas - MCF/yr Fuel Oil (including recycled oil) - Mgal/yr Lime Mud - ton/yr Petrol Coke - ton/yr
h. #3 Lime Kiln	Nat Gas - MCF/yr Fuel Oil (including recycled oil) - Mgal/yr Lime Mud - ton/yr Petrol Coke - ton/yr
i. #4 Lime Kiln	Nat Gas - MCF/yr Fuel Oil (including recycled oil) - Mgal/yr Lime Mud - ton/yr Petrol Coke - ton/yr
j. #3 Dissolver	Black Liquor - ton/yr
k. #4 Dissolver	Black Liquor - ton/yr
l. #5 Dissolver	Black Liquor - ton/yr
m. #1 Slaker	Lime - ton/yr
n. #2 Slaker	Lime - ton/yr
o. #3 Slaker	Lime - ton/yr
p. Pulp Produced	Pulp - ADT/yr
q. Linerboard Produced	Linerboard - ADT/yr
r. OCC Waste Burned	OCC Waste - ton/yr
s. #1 Slicer	Chips Sliced - ton/yr
t. #2 Slicer	Chips Sliced - ton/yr
u. #3 Slicer	Chips Sliced - ton/yr
v. #4 Slicer	Chips Sliced - ton/yr
w. Sawdust Screen	Sawdust Screened - ton/yr

- x. #3 Paper Machine                      Air-dried pulp (including OCC plant input) - ton/yr
  
- y.        Hours of operation for the mill and each source if different from the mill operation time.
  
- z.        Fugitive dust information:
  - i.        Tons of chips received for the year
  - ii.       Tons of sawdust received for the year
  - iii.      Tons of hog fuel received for the year
  - iv.      Tons of fines sent to hog fuel from chip screen
  - v.        Tons of fines sent to hog fuel from sawdust screen
  - vi.      Tons of fines sent to storage bin from chip screen
  - vii.     Tons of fines sent to storage bin from sawdust screen
  - viii.    Tons of screened pins to pile
  - ix.      Tons of screened chips to Kamyrr pile
  - x.        Tons of screened chips to batch pile
  - xi.      Tons of ADS rejected to hog fuel pile
  - xii.     Tons of screened sawdust overs to chip pile (as determined by weightometer on the sawdust overs belt).
  
- 2.        Stone shall notify the Department of any construction or improvement project conducted pursuant to ARM 17.8.745, that would include a change of control equipment, stack height, stack diameter, stack flow, stack gas temperature, source location, or fuel specifications, or would result in an increase in source capacity above its permitted operation or the addition of a new emission unit. The notice must be submitted to the Department, in writing, 10 days prior to start up or use of the proposed de minimis change, or as soon as reasonably practicable in the event of an unanticipated circumstance causing the de minimis change, and must include the information requested in ARM 17.8.745(1)(d) (ARM 17.8.745).
  
- 3.        All records compiled in accordance with this permit must be maintained by Stone as a permanent business record for at least 5 years following the date of the measurement, must be available at the plant site for inspection by the Department, and must be submitted to the Department upon request (ARM 17.8.749).

B.        Monthly Reporting Requirements

1.        General Requirements

Stack tests performed by employees of the Missoula Mill shall be submitted with the monthly reports.

2. Lime Kilns

Stone shall report the daily average TRS for the No.1, No.2, and No. 3 Lime Kilns. Stone shall include, for the No. 4 Lime Kiln, a report of 12-hour averages.

3. Recovery Boilers

- a. Stone shall report the daily average TRS for all recovery boilers. Stone shall include, for recovery boilers subject to NSPS Subpart BB, a report on a 12-hour basis.
- b. Stone shall report a monthly average for pounds of sulfur emitted per 1000 pounds of black liquor burned for all recovery boilers.
- c. Stone shall, for recovery boilers subject to NSPS, report opacity on a 24-hour average basis.
- d. Stone shall report for all recovery boilers average daily and average monthly total particulate emissions as determined by the correlation equations used to determine the particulate mass emissions. This report shall include daily calculated grain loading (gr/dscf), air flow (dscfm), total particulate (lb/hour), and the 24-hour average opacity. For the #5 Recovery Boiler, Stone shall report percent O<sub>2</sub> and grain loading (gr/dscf) corrected for O<sub>2</sub>.
- e. Stone shall test the recovery boilers for total particulate annually (semiannually if above 80% of the permit limit). These tests shall conform to 40 CFR 60, Appendix A, with back-half included, unless NSPS is applicable.
- f. Stone shall report all exceedances of the opacity standard for recovery boilers subject to NSPS.

4. Multi-fuel Boiler

Stone shall report, for all boilers subject to NSPS, Subpart D, the 3-hour averages for SO<sub>2</sub> and NO<sub>x</sub> as specified by federal regulations.

5. Pulp Mill Production

Average daily pulp production shall be reported in air-dried tons of pulp per day and average daily black liquor burning rates for each recovery boiler in pounds per day.

6. Plant-wide Wood Pulp Production

Stone shall document, by month, plant-wide wood pulp production. By the 25<sup>th</sup> day of each month, Stone shall total the amount of plant-wide wood pulp production during the previous 12 months to verify compliance with the limitation in Section II.G.32 and have this information available for representatives of the Department. A written report, including the previous 12-month total ODT of pulp production, shall be submitted annually to the

Department no later than March 1 and may be submitted along with the annual emission inventory (ARM 17.8.749).

C. Quarterly Excess Emission Reports

Stone shall submit quarterly excess emission reports for all CEMs required by NSPS as specified in 40 CFR Part 60.7(c). This report shall include:

1. The magnitude of excess emissions computed in accordance with 60.13(h), any conversion factors used, and the date and time of commencement and completion of each time period of excess emissions.
2. Specific identification of each period of excess emissions that occurs during startups, shutdowns, and malfunctions of the affected facility; the nature and cause of any malfunction (if known); and the corrective action taken or preventative measures adopted.
3. The date and time identifying each period during which the continuous monitoring system was inoperative, except for zero and span checks, and the nature of the system repairs or adjustments.
4. When no excess emissions have occurred, or the continuous monitoring systems have been inoperative, such information shall be stated in the report.
5. The excess emission reports shall be completed in a format supplied or approved by the Department.

D. Failure to report CEM data required by this section, which is not available because of monitor downtime or insufficient quality assurance, shall not be considered a violation of the reporting requirements of this section. However, the unavailability of such data may be a violation of the monitoring requirements of Section III - Continuous Emission Monitoring Systems (ARM 17.8.749).

E. Stone shall comply with the recordkeeping and reporting in accordance with 40 CFR 63, Subpart S and 40 CFR 63.10 (ARM 17.8.342 and 40 CFR 63, Subparts A and S).

F. Stone shall comply with the recordkeeping and reporting in accordance with 40 CFR 63, Subpart MM and 40 CFR 63.10 (ARM 17.8.342 and 40 CFR 63, Subparts A and MM).

Section V: Compliance

Stone shall comply with all conditions contained in Attachment B and Attachment C, except for those conditions superseded by more stringent conditions contained in the main section of this permit.

Section VI: State-only Provisions (State-only enforceable): Ambient Air Monitoring Program

Stone shall conduct an ambient air monitoring program consisting of the following (see Attachment 1) (ARM 17.8.204):

- A. At least two analyzers to measure hydrogen sulfide (H<sub>2</sub>S).
- B. At least two PM<sub>10</sub> samplers.
- C. At least one wind system.

- D. Sampling sites, data reporting, and parameters to be monitored will be specified by the Department.

Section VII: General Conditions

- A. Inspection - Stone shall allow the Department's representatives access to the source at all reasonable times for the purpose of making inspections or surveys, collecting samples, obtaining data, auditing any monitoring equipment (CEMS, CERMS) or observing any monitoring or testing, and otherwise conducting all necessary functions related to this permit.
- B. Waiver - The permit and all the terms, conditions, and matters stated herein shall be deemed accepted if Stone fails to appeal as indicated below.
- C. Compliance with Statutes and Regulations - Nothing in this permit shall be construed as relieving Stone of the responsibility for complying with any applicable federal or Montana statute, rule or standard, except as specifically provided in ARM 17.8.740, *et seq.* (ARM 17.8.756).
- D. Enforcement - Violations of limitations, conditions and requirements contained herein may constitute grounds for permit revocation, penalties or other enforcement as specified in Section 75-2-401 *et seq.*, MCA.
- E. Appeals - Any person or persons jointly or severally adversely affected by the Department's decision may request, within 15 days after the Department renders its decision, upon affidavit setting forth the grounds therefore, a hearing before the Board of Environmental Review (Board). A hearing shall be held under the provisions of the Montana Administrative Procedures Act. The filing of a request for a hearing does not stay the Department's decision, unless the Board issues a stay upon receipt of a petition and a finding. The issuance of a stay on a permit by the Board postpones the effective date of the Department's decision until conclusion of the hearing and issuance of a final decision by the Board. If a stay is not issued by the Board, the Department's decision on the application is final 16 days after the Department's decision is made.
- F. Permit Inspection - As required by ARM 17.8.755, Inspection of Permit, a copy of the air quality permit shall be made available for inspection by Department personnel at the location of the permitted source.
- G. Construction Commencement - Construction must begin within 3 years of permit issuance and proceed with due diligence until the project is complete or the permit shall be revoked.
- H. Permit Fees - Pursuant to Section 75-2-220, MCA, as amended by the 1991 Legislature, failure to pay by Stone of an annual operation fee may be grounds for revocation of this permit, as required by that section and rules adopted thereunder by the Board.

## ATTACHMENT B

Modified June 14, 1989  
Conditions of Permit #2589

This Attachment B, Conditions of Permit #2589, hereby replaces the original Permit #2344 as issued May 22, 1987.

### Section I: Permitted Facilities

- A. A fuel change is requested for all four existing lime kilns. These kilns are currently fired on natural gas. The permit application requests permission to use an 80% petroleum coke, 20% natural gas fuel combination on a Btu basis. The kilns currently burn approximately 1,216 million cubic feet of natural gas per year. The fuel change will replace 80% of this with approximately 35,285 tons/year of petroleum coke supplied by Exxon Refinery.
- B. The general associated facilities are:
  - 1. Two coke storage bins with vents;
  - 2. Coke unloading station with enclosed conveying systems to transport the coke to storage; and
  - 3. Pulverizer and burner system to feed the coke into the kilns.

### Section II: Limitations and Conditions

- A. The fuel change shall be limited to a maximum of 80% petroleum coke substitution for the natural gas currently used in each kiln.
- B. Stone shall provide the Department with a current analysis of the coke used in the kilns on a yearly basis. The report shall contain the heat content of the coke in Btu/lb and the concentration of the following parameters: fixed carbon, volatiles, sulfur, ash, vanadium, beryllium, cadmium, mercury, nickel, and lead. A change to any other type of fuel, which increases any air pollution emissions, is subject to the new source review requirements in accordance with ARM 17.8.740, *et seq.*, and/or ARM 17.8.801, *et seq.* This report is due by July 15 each year. No report is required for 1987.
- C. The coke unloading, storage, and handling system shall use reasonably available control technology to control fugitive dust.
- D. NO<sub>x</sub> emissions shall not exceed 408 tons/year from all four lime kilns. Compliance with this requirement shall be determined by conducting stack testing in accordance with the frequency specified in condition E of this section. Compliance with this limitation shall be deemed achieved provided the results of all stack sampling conducted within any calendar year do not exceed any of the values provided below:

$$\text{Kiln \#1: } (X + 7.63/N^{1/2})(0.69)$$

$$\text{Kiln \#2: } (X + 7.63/N^{1/2})(0.68)$$

$$\text{Kiln \#3: } (X + 7.63/N^{1/2})(1.25)$$

$$\text{Kiln \#4: } (X + 7.63/N^{1/2})$$

Units are pounds per hour.

Where: N = number of stack tests or hourly readings obtained  
in the subject calendar year as presented below.

$$X = (\text{Coke \%}) \cdot (.26) + 4.9$$

Coke % is measured on a Btu basis.

The value of N shall be determined as follows:

1. For stack tests conducted in accordance with 40 CFR Part 60, Appendix A, Method 7, N shall equal three for each completed test (not the same as runs). A minimum of two tests is required.
2. For stack tests conducted using continuous emission sampling devices (such as that conducted in support of this application), N shall equal the number of valid hourly samples. The minimum number of samples required for each applicable kiln shall be 50.

Average coke feed rate during the testing period shall not be less than 5 percentage points than the average coke feed rate in use by Stone over the preceding 3 months. Average coke feed rate shall be calculated on a percent Btu basis excluding all time periods in which coke was not a fuel to the lime kiln in question.

- E. An annual stack test at Kiln #4 shall be required to verify compliance with condition D. of this section and to otherwise inventory the emissions from this source. Kilns #1, #2 and #3 only need be tested once following conversion to coke. The Department, however, reserves the right to require further testing in accordance with the provisions of ARM 17.8.105 as it deems necessary to inventory air pollution emissions or to verify compliance with this permit or any other air quality rule. The requirements of this section, however, shall not be deemed a relaxation of testing requirements found in other permits issued to Stone. The test required by this section shall also include an analysis of SO<sub>2</sub> and carbon monoxide (CO) and be performed according to the applicable EPA test methods as specified in 40 CFR Part 60, Appendix A. In the case of CO, however, Stone may conduct this test using the ORSAT method. Alternative equivalent methods to 40 CFR Part 60, Appendix A, may be used only upon written approval by the Department.
- F. Each lime kiln shall be equipped with a stack that has safe access to the test ports and that meets the criteria of 40 CFR Part 60, Appendix A, Method 1.
- G. For all stack tests, a pretest conference shall be held at least 30 days prior to the test between Stone, the tester, and the Department. The Department may require a written testing protocol, including quality assurance procedures, prior to the pretest conference.
- H. Stone shall discontinue the burning of coke within 12 hours of being notified by the Missoula City-County Health Department that a Stage II, III, or IV Alert is in progress within the air stagnation zone. Stone may resume using coke as soon thereafter as the alert has been canceled.

- I. Stone shall discontinue the burning of coke as soon as reasonably possible, but not more than 1 hour, when a malfunction of the kiln or scrubber occurs, provided such a malfunction has the potential to increase emissions of sulfur dioxide into the outdoor atmosphere.

Section III: State-only Provisions (State-only enforceable): Ambient Air Monitoring and Reporting Requirements (ARM 17.8.204)

- A. Stone Container shall install, operate and maintain one ambient air monitoring site in the vicinity of its kraft pulp and linerboard facility. The monitoring site shall consist of all equipment, supplies and personnel resources necessary and sufficient to monitor nitrogen dioxide levels in the ambient air in accordance with the procedures provided below (ARM 17.8.204).
- B. Stone shall commence air monitoring within 90 days after the start of burning of petroleum coke in each of the four lime kilns (ARM 17.8.204).
- C. For purposes of choosing an applicable site location, the Department, in conjunction with Stone, the Missoula City-County Health Department, and interested citizens, shall form an ad hoc ambient air quality monitoring committee. The committee shall consist of the following members (ARM 17.8.204):

Stone Container	- 1 member
Missoula City-County Health Dept.	- 1 member
Department	- 1 member
Interested Citizens	- 2 members and 2 alternates

Each organization shall choose their respective committee member, except that the Department shall choose the citizen members from a list of names of persons expressing interest in this subject. The Department shall serve as chair for the committee.

- D. The purpose of the monitoring committee in C above is to choose the ambient air quality monitoring site for the continuous measurement of NO<sub>x</sub>. The chosen monitoring site must meet the minimum quality assurance requirements found in the Montana Quality Assurance Manual, including siting criteria. The site must also have adequate access and power requirements within a reasonable distance of the proposed monitoring station. In the event a consensus on-site selection cannot be reached, the Department shall determine the final site location. The monitoring site must remain in the same location for at least 4 consecutive quarters. It may be moved following 4 consecutive quarters in accordance with paragraph E (ARM 17.8.204).
- E. The ambient air quality monitoring of nitrogen dioxide (NO<sub>2</sub>) will continue for at least 4 consecutive quarters after the applicable lime kiln has been converted to coke and a maximum burn rate has been established. Following the successful gathering of 4 consecutive quarters of valid ambient air quality data collected in accordance with the requirements of H below, the committee shall review the data and make a determination of whether or not to continue monitoring the effects of the coke conversion project or otherwise increase or decrease the network size. The committee's decision of whether or not to increase, decrease, or alter the network configuration in order to measure the impact of the coke conversion project will be based upon the NO<sub>2</sub> ambient monitoring results as they relate to potential damage to human health, vegetation, animals, or otherwise threaten compliance with the ambient air quality standards. In the event a consensus cannot be reached by the committee, the Department shall determine any future ambient air quality monitoring for NO<sub>2</sub> (ARM 17.8.204).

- F. Any changes in the ambient monitoring network not related to site location and duration of monitoring must be approved in writing by the Department. The Department shall notify the committee of any approved changes to the monitoring network (ARM 17.8.204).
- G. The committee may choose to develop a more comprehensive monitoring plan of the effects of the coke conversion project relating to vegetation and animal monitoring. None of the members of the committee, however, are bound to supply financial or other resources for completing these plans. As funding allows, it is the intent of the Department that such a plan be a cooperative effort between the Department, Stone, City-County Health Department, the University of Montana, and any other citizen or professional resources in the Missoula Valley (ARM 17.8.204).
- H. Stone shall utilize air monitoring and quality assurance procedures, which equal or exceed the requirements described in the Montana Quality Assurance Manual, including revisions; the EPA quality assurance manual, including revisions; 40 CFR Parts 53 and 58; and any other requirements specified by the Department. These requirements extend to all aspects of air monitoring, including, but not limited to, siting criteria, shelter design, equipment selection, calibration, maintenance, repair, zero/span procedures, precision, accuracy, data handling, control limits, and data validation (ARM 17.8.204).
- I. Stone shall submit monthly data reports to the Department within 45 days after the end of each month and an annual data report within 90 days after the end of the calendar year. Stone may, at their discretion, submit required data from the existing monitoring network at the same intervals and reporting requirements specified in this section (ARM 17.8.204).
1. The monthly report shall consist of a narrative data summary. The monthly report to the Department must also consist of a data submittal of all data points on SAROAD format on floppy diskettes that are compatible with the Department's computer system. The narrative data summary shall include:
    - a. The first and second highest 24-hour concentrations for NO<sub>2</sub>
    - b. The first and second highest 1-hour concentrations for NO<sub>2</sub>
    - c. The monthly wind roses (from Stone's site #1)
    - d. A summary of the data collection efficiency
    - e. A summary of the reasons for missing data
    - f. A precision and accuracy summary
    - g. Calibration information
  2. The annual report shall consist of a narrative data summary containing:
    - a. A pollution trend analysis
    - b. The annual means, first and second highest 24-hour concentrations, and first and second highest 1-hour concentrations for NO<sub>2</sub> at each site

- c. The annual wind roses from each site
- d. An annual summary of data collection efficiency
- e. An annual summary of precision and accuracy data
- f. An annual summary of any ambient standard exceedances
- g. Recommendations for future monitoring

## ATTACHMENT C

Modified June 14, 1989  
Conditions of Permit #2589

Air quality Permit #2589 (originally #792-013075) is hereby altered to include the OCC facility to be installed during the summer of 1989. This alteration is conducted in accordance with ARM 17.8.748. Since there is no significant increase in emissions, only ARM 17.8.740, Montana Permit Rule, will apply. This rule requires Best Available Control Technology (BACT) to be applied to the air pollution control equipment.

### Section I: Permitted Facilities

- A. The general facilities associated with this project are:
1. Unloading docks for 400 tons per day (TPD) of old cardboard
  2. Shredder and repulping tank
  3. Cleaning facilities to remove burnable and nonburnable waste from the old cardboard
  4. Disposal systems for all waste removed from the old cardboard

B. Emission Inventory for the Multi-fuel Boiler

Current average fuel consumption is:

Waste wood - 7955 ton/mo x 12 = 95,460 ton/yr  
Natural gas - 3648 MCF/mo x 12 = 43,776 MCF/yr

1. Current Emissions (from wood combustion):

	<u>Emissions</u>
Particulate from company stack test	18.0 TPY
SO <sub>2</sub> - .15 lb/ton x .5 scrub eff x 95460 ton wood/yr x 1/2000	3.5 TPY
NO <sub>x</sub> - 2.8 lb/ton x 1 scrub eff x 95460 ton wood/yr x 1/2000	133.6 TPY
CO - 4.0 lb/ton x 1 scrub eff x 95460 ton wood/yr x 1/2000	190.9 TPY
Volatile Organic Compounds –Non-Methane (VOC <sub>(NM)</sub> )	
- 1.4 lb/ton x 1 scrub eff x 95460 ton wood/yr x 1/2000	66.8 TPY
(from AP-42 1.6-1)	

Natural gas emissions are negligible. The highest contribution from natural gas would be approximately 1 ton/yr of NO<sub>x</sub>; all other pollutants are less than 1 ton/yr.

2. Emissions from Waste Plastic Combustion:

Waste combustion rate: 15.1 ton/day, 468 ton/mo, 5616 ton/yr  
AP-42 2.1-3 Uncont. E.F. for Commercial and Ind. Refuse  
Particulate = 7 lb/ton x .04 scrub eff x 5616 x 1/2000 = 0.8 TPY  
(Multichamber)

SO <sub>2</sub>	2.5	x .5	x 5616 x 1/2000 = 3.5 TPY
NO <sub>x</sub>	3	x 1	x 5616 x 1/2000 = 8.4 TPY
VOC	3	x 1	x 5616 x 1/2000 = 8.4 TPY
CO	10	x 1	x 5616 x 1/2000 = 28.0 TPY

3. Toxics Review

These emissions are calculated from laboratory results of two samples of plastic waste, which were collected from two paper recycling plants currently in operation. Analysis was done by Badger Laboratories for Stone Container (letter from Ms. Jenny Brown to W. Norton, dated 2-14-89)

Chloride analysis (as total halide)

Max. value -  $0.43\% \times 15.1 \text{ ton/day} \times 365 \text{ day/yr} \times .04 \text{ scrub eff} \times 2000 \text{ lb/ton} = 1896 \text{ lb/yr}$

(This assumes all chloride goes to scrubber; some may remain in bottom ash.)

Beryllium

Max. value -  $.05 \text{ ppm} \times 15.1 \text{ ton/day} \times 2000 \text{ lb/ton} \times 365 \text{ day/yr} = 0.55 \text{ lb/yr}$

Cadmium

Max. value -  $<.05 \text{ ppm} \times 15.1 \text{ ton/day} \times 2000 \text{ lb/ton} \times 365 \text{ day/yr} = <0.5 \text{ lb/yr}$

Lead

Max. value -  $12.6 \text{ ppm} \times (11.02) = 138.9 \text{ lb/yr}$

Mercury

Max. value -  $<0.01 \times 11.02 = <0.1 \text{ lb/yr}$

4. Emission Summary

<u>Parameter</u>	<u>Existing</u>	<u>Plastic Emissions</u>	<u>Total Proposed</u>
Particulate	18 TPY	1 TPY	19 TPY
SO <sub>2</sub>	4	3	7
NO <sub>x</sub>	134	8	142
CO	191	28	219
VOC <sub>(NM)</sub>	67	8	75

<u>Parameter</u>	<u>Existing</u>	<u>Plastic Emissions</u>	<u>Total Proposed</u>
Toxics:			
Cl	--	1896 lb/yr	1896 lb/yr
Be	--	0.5	0.5
Cd	--	<0.5	<0.5
Pb	--	138.9	138.9
Hg	--	<0.1	<0.1

C. Applicable Regulations

1. NSPS - Not applicable - OCC plants are not a listed component of Kraft pulp mills (see Subpart BB, CFR 60.280a).
2. PSD - Not applicable - emissions are not significant (See ARM 17.8.801).

3. State Permit Rule - ARM 17.8.764 is applicable and requires that BACT be applied to the permit alteration.
4. BACT Analysis

The applicant proposed the disposal of 15.1 tons per day of waste plastic in the hog fuel boilers. These boilers are currently controlled with wet scrubbers. The waste fuel boiler is subject to the NSPS limits and the Air Resources Management Bureau has accepted this scrubber as BACT for this case. The scrubber water maintains a pH between 7.0 and 9.0, which should provide good collection efficiencies for chloride gases. Therefore, the Department accepts this control as BACT for this case.

5. Other Toxic Emissions

Lead - Less than 0.6 TPY - exempt from permitting. Company analysis shows 138.9-lb/yr emission or 0.07 TPY. This is less than 12% of the lead emissions that require permitting under ARM 17.8.745.

Beryllium - Less than 0.0004 TPY-is not significant for PSD purposes. Company analysis shows 0.55 lb/yr or 0.0003 TPY.

Mercury - Less than 0.1 TPY-is not significant for PSD purposes. Company analysis shows 0.11 lb/yr or 0.00 TPY.

Therefore, a permit alteration will be required at this time for disposal of this plastic waste in the hog fuel boilers. However, a stack test for chloride emissions will be required after the system is operational to prove that actual emissions do not exceed the worst case analysis referred to above.

## Section II: Limitations and Conditions

- A. All emission limitations for the hog fuel and waste fuel boilers shall remain as stated in Attachment A.
- B. The boiler used for disposal of the burnable waste shall be tested for particulate and for chloride emissions to prove compliance with existing regulations. The chloride emissions shall be compared with the estimated emissions from the permit application. These tests shall conform to EPA stack testing methods 1-5, and the Montana Source Test Protocol and Procedures Manual.
- C. A one-time check on the levels of heavy metals emitted from the combustion of waste plastic is required. This shall consist of an analysis of the stack gas for lead, cadmium, beryllium and mercury. These tests shall be done by methods acceptable to EPA and the Department, and be performed at the same time the particulate and chloride tests are done. These tests shall be completed within 1 year of the start-up date for the used fiber recycle plant.

## Section III: Ambient Air Monitoring and Reporting Requirements

No additional ambient monitoring requirements apply at this time.

## ATTACHMENT D

### Stone Container Corporation Test Plan for Determining Back-half Emissions

Stone and the Air Resources Management Bureau (ARMB) have worked together to develop the following test plan to determine back-half emissions from the recovery boilers. The following assumptions were made at the beginning of the test plan.

1. For the purposes of this test plan, particulate formation from SO<sub>2</sub> will not be considered. However, if the State Implementation Plan (SIP) requires a demonstration of the impact of SO<sub>2</sub> particulate conversion on the nonattainment area, the ARMB intends to use SO<sub>2</sub> emissions reported by the CEMS on the #3, #4, and #5 Recovery Boilers to determine actual SO<sub>2</sub> emissions. These emissions will be modeled using a conversion rate based on the best available information at the time of the modeling to determine the impact of SO<sub>2</sub> precursors. Modeling of this sort has been done in Utah as part of their PM<sub>10</sub> non-attainment modeling, with the assumption that 100% of the SO<sub>2</sub> is converted to particulate in the nonattainment area.
2. Stone shall perform back-half tests on the #3 and #4 Recovery Boilers. If the data shows the emissions from these two sources to be similar and to be representative of recovery boilers, then the back-half emissions from the #5 Recovery Boiler will be assumed to be the same. If the test information from the two sources shows significant disparity, then additional testing may be required for the #5 Recovery Boiler.

Based on these assumptions, the following plan was developed.

#### **Back-half Testing Plan**

Start date: Third calendar quarter of 1993.

Test Schedule:

As part of quarterly compliance tests for these sources:

#3 Recovery Boiler

#4 Recovery Boiler

Capacity: Each source shall be tested at 90% of maximum rated capacity once a year. Additional tests shall be conducted at the maximum operating rate of the equipment for the proceeding calendar quarter, not including the operating rate during stack test days.

Methods: EPA approved methods:

Method 5 (front-half emissions)

Method 202 (back-half emissions)

Protocol: All testing shall be done in accordance with the Montana Source Test Protocol and Procedures Manual and 40 CFR Part 60, Appendix A.

Stone shall submit a testing protocol to the ARMB prior to testing, as required in the Montana Source Test Protocol and Procedures Manual. This protocol shall include any variations from the methods and should include information such as use of a glass probe during testing.

Format of Tests:

The ARMB will allow Stone to conduct testing over a 2-day period, but prefers that testing be done in 1 day. Timing of planned tests shall be included as part of the protocol.

**Review**

**Test Results:** Stone shall submit all test results to the ARMB. Test reports shall contain information on process rate, all raw data, calculations, and analysis.

**Plan Review:** Stone and the ARMB shall review the results of the test plan after 1 year (or 4 quarters) of data has been collected to determine:

1. Need for continuing collection of information.
2. Additional points needed to fill in information.
3. Relationship between emissions and capacity of equipment.

**Conclusions**

At the end of the test plan (expected to be approximately the end of 1994), the ARMB and Stone will work together to determine the need for additional emission limitations for the #3, #4, and #5 Recovery Boilers. The ARMB and Stone will also work together to determine appropriate emission limitations. If needed, the emission limitations are expected to be identified as a total limit for each source, which will be in addition to existing front-half limits.

The ARMB and Stone shall also work together to determine the appropriate schedule for future testing for back-half or total emissions.

Attachment 1

State-only Provision (State-only enforceable): AMBIENT AIR MONITORING PLAN  
 STONE CONTAINER CORPORATION  
 Permit #2589-11

1. This ambient air monitoring plan is required by air quality Permit #2589-11, which applies to Stone's Kraft pulp mill operation located approximately 10 miles northwest of Missoula, Montana. This monitoring plan may be modified by the Department. All requirements of this plan are considered state-only enforceable conditions of the permit (ARM 17.8.204).
2. Stone shall operate and maintain two air monitoring sites in the vicinity of the mill and facilities. The exact locations of the monitoring sites must be approved by the Department and meet all the siting requirements contained in the Montana Quality Assurance Manual, including revisions; the EPA Quality Assurance Manual, including revisions; and Parts 53 and 58 of the Code of Federal Regulations; or any other requirements specified by the Department (ARM 17.8.204).
3. Stone shall continue air monitoring for at least 2 years after normal production is achieved. The air monitoring data will be reviewed by the Department and the Department will determine if continued monitoring or additional monitoring is warranted. The Department may require continued air monitoring to track long-term impacts of emissions from the facility or require additional ambient air monitoring or analyses if any changes take place in regard to quality and/or quantity of emissions or the area of impact from the emissions (ARM 17.8.204).
4. Stone shall monitor the following parameters at the sites and frequencies described below (ARM 17.8.204):

<u>AIRS # and Site Name</u>	<u>UTM Coordinates</u>	<u>Parameter</u>	<u>Frequency</u>
30-063-0034	Zone 11		
Moccasin Lane #1A	N 520 3200 E 719 000	PM <sub>10</sub> <sup>1</sup> PM <sub>10</sub> collocated <sup>2</sup> H <sub>2</sub> S <sup>4</sup> Wind speed and direction, standard deviation of Wind direction (sigma theta)	Every 3 <sup>rd</sup> /6 <sup>th</sup> day <sup>3</sup> Every 6 <sup>th</sup> day Continuous " " " "
30-063-0016	Zone 11		
Well Field #2	N 520 2351 E 712 804	PM <sub>10</sub> H <sub>2</sub> S	Every 3 <sup>rd</sup> /6 <sup>th</sup> day Continuous

<sup>1</sup> PM<sub>10</sub> = particulate matter less than 10 microns.

<sup>2</sup> The requirement for a collocated PM<sub>10</sub> sampler may be waived if the monitor operator operates a collocated PM<sub>10</sub> sampler at another site.

<sup>3</sup> Every 3<sup>rd</sup> day during October-March; every 6<sup>th</sup> day during April-September.

<sup>4</sup> H<sub>2</sub>S = hydrogen sulfide.

Trace metal analyses of sample filters will not be required at this time; however, the Department may require these analyses in the future.

Data recovery for all parameters shall be at least 80 percent, computed on a quarterly and annual basis. The Department may require continued monitoring if this condition is not met. The following equations shall be used to calculate data recoveries:

Manual Methods % Data Recovery

$$= 100 \times \frac{\text{Number of valid samples collected in quarter (or year)}}{\text{Total possible number of samples according to monitoring schedule (in quarter or year)}}$$

Automated Methods % Data Recovery

$$= 100 \times \frac{\text{Total number of hours in quarter (or year) - number of lost data* hours in quarter (or year)}}{\text{Total number of hours in quarter (or year)}}$$

\* - Hours the analyzer or sensor was offline and not sampling ambient air. Lost data examples include: missing data as a result of collection errors, i.e., data not available from the primary or secondary collection sources; invalid data due to analyzer malfunctions, bad weather, and collection errors; quality control/quality assurance activities such as auto/manual checks, calibrations, and audits; and maintenance and repairs.

5. Any ambient air monitoring changes proposed by Stone must be approved, in writing, by the Department (ARM 17.8.204).
6. Stone shall utilize air monitoring and quality assurance procedures, which are equal to or exceed the requirements described in the Montana Quality Assurance Manual, including revisions; the EPA Quality Assurance Manual, including revisions; 40 CFR Parts 53 and 58 of the Code of Federal Regulations; and any other requirements specified by the Department (ARM 17.8.204).
7. Stone shall submit quarterly data reports within 45 days after the end of the calendar quarter and an annual data report within 90 days after the end of the calendar year. The annual report may be substituted for the fourth quarterly report if all information in 8 below is included in the report (ARM 17.8.204).
8. The quarterly report shall consist of a narrative data summary and a data submittal of all data points on AIRS formatted paper input forms, disks or magnetic tapes that are compatible with the Department's computer system. The narrative data summary shall include (ARM 17.8.204):
  - a. A topographic map of appropriate scale with Universal Transverse Mercator (UTM) coordinates and a true north arrow showing the air monitoring site locations in relation to the mill and facilities and the general area
  - b. A hard copy of the individual data points
  - c. The quarterly and monthly means for PM<sub>10</sub> and wind speed
  - d. The first and second highest 24-hour concentrations for PM<sub>10</sub> at each site
  - e. The first and second highest hourly concentrations for H<sub>2</sub>S at each site
  - f. The quarterly and monthly wind roses
  - g. A summary of the data collection efficiency
  - h. A summary of the reasons for missing data
  - i. A precision and accuracy (audit) summary
  - j. A summary of any ambient air standard exceedances
  - k. Calibration information
9. The annual data report shall consist of a narrative data summary containing (ARM 17.8.204):

- a. A topographic map of appropriate scale with UTM coordinates and a true north arrow showing the air monitoring site locations in relation to the mill and facilities and the general area
  - b. A pollution trend analysis
  - c. The annual means for PM<sub>10</sub> per site and wind speed
  - d. The first and second highest 24-hour concentrations for PM<sub>10</sub> at each site
  - e. The first and second highest hourly H<sub>2</sub>S concentrations at each site
  - f. The annual wind rose
  - g. An annual summary of data collection efficiency
  - h. An annual summary of precision and accuracy (audit) data
  - i. An annual summary of any ambient standard exceedance
  - j. Recommendations for future monitoring
10. The Department may audit, or may require Stone to contract with an independent firm to audit, the air monitoring network, the laboratory performing associated analyses, and any data handling procedures at unspecified times. On the basis of the audits and subsequent reports, the Department may recommend or require changes in the air monitoring network and associated activities in order to improve precision, accuracy and data completeness (ARM 17.8.204).

Permit Analysis  
Stone Container Corporation - Missoula  
Frenchtown Facility  
Permit #2589-11

I. Introduction/Process Description

A. Process Description

Stone Container Corporation (Stone) operates a kraft pulp and liner mill in Section 24, Township 14 North, Range 21 West in Missoula County. This facility produces linerboard and other paper products by converting wood chips into pulp and then into paper. Stone uses a typical kraft recovery plant in which the cooking salts are recovered from the digestion process and reused. Stone uses several batch digesters and two continuous digesters to separate the wood fiber from the wood matrix. Digestion gases are controlled with a condenser and all noncondensable gases are incinerated in the lime kilns. The black liquor recovered from this process is used as a fuel in the recovery furnaces and the cooking salts are recovered to be used again. The recaust portion of the plant uses several lime kilns to convert calcium carbonate to calcium oxide, which is then used in converting green liquor from the recovery furnaces into the white cooking liquor. This is then reused to start the digestion process over again. The plant has three recovery boilers, four lime kilns, and three paper machines with all of the peripheral equipment required by the kraft process.

The Fiber Optimization and Raw Material Management Transfer System (FORMM) at the facility allows Stone to more efficiently use the raw materials available. Stone can now screen the materials more thoroughly before they enter the digesters. Having more uniform materials allows for better heating and digesting of the sawdust and chips. This system also provides for a more efficient use of chips and sawdust delivered to the plant.

B. Facility History

1. Stone currently operates a pulp mill and linerboard facility at the Frenchtown site, located approximately 10 miles northwest of Missoula. The plant underwent a major expansion during the mid-1970s, which added several New Source Performance Standards (NSPS) units. The basic plant capacity was designed for about 1850 tons per day of air-dried pulp. An air quality permit covered individual units at that time. In 1987, the permit was revised to allow Stone to burn petroleum coke in all four lime kilns. In 1989, the permit was revised again to allow Stone to install and operate a recycled cardboard facility at the plant. This revision increased the capacity of the plant by approximately 400 air-dried tons per day.
2. On July 1, 1987, the Environmental Protection Agency (EPA) promulgated new ambient air quality standards for particulate matter with an aerodynamic diameter of 10 microns or less (PM<sub>10</sub>). The annual standard is 50 micrograms per cubic meter and the 24-hour standard is 150 micrograms per cubic meter. These standards were adopted by the Montana Board of Health and Environmental Sciences on April 15, 1988.

Due to violations of these standards, Missoula was designated as a PM<sub>10</sub> nonattainment area. As a result of this designation, the Montana Department of Health and Environmental Sciences (Department, now the Department of Environmental Quality) and the Missoula County Air Pollution Control Agency were required to develop a plan to control these emissions and bring the area into compliance with the federal and state ambient air quality standards.

In order to identify the emission sources contributing to the violation of the PM<sub>10</sub> standard, Missoula County conducted a chemical mass balance study (CMB) of the area. The Stone Container mill recovery boilers were identified as significant contributors to this area. Permit #2589-M was a modification to add general fugitive dust control measures to this facility and to correct emission limitations for the #5 Recovery Boiler and the #4 Lime Kiln to agree with NSPS limits. These corrections decreased the allowable emissions enough to satisfy the State Implementation Plan (SIP) control plan for the area.

3. Stone requested an alteration to their permit to allow for the installation of a new FORMM System. This permit allowed the construction of the new screening room and the addition of the needed fugitive sources to allow Stone to better use the raw materials available and was given Permit #2589-02.
4. In August of 1992, the EPA submitted comments on the Missoula SIP concerning a completeness determination and requesting additional information. In response to EPA's concern about the correlation between opacity and mass emissions, the Air Quality Division modified Stone's permit to clarify the language in the permit. The Air Quality Division also addressed the opacity requirements for the equipment at Stone and the opacity monitor range for the #5 Recovery Boiler. This permit was given Permit #2589-03.
5. In April 1994, Stone applied for Permit #2589-04, which allowed Stone to make a change in the existing FORMM system. The FORMM transfers the fines from the chip screens and the fines from the sawdust screens to the hog fuel pile. This alteration allowed Stone to transfer material from the FORMM, via an enclosed belt conveyor, to an enclosed storage bin, rather than to the hog fuel pile. This material could then be transferred to trucks for distribution off site. To accomplish this, Stone needed to construct a storage bin, a storage bin unloading system, and an enclosed belt conveying system. This proposed system and the existing system cannot be physically operated at the same time, but rather can be operated interchangeably. This alteration resulted in a net decrease in total particulate emissions of 44.09 tons per year (tpy) and a net decrease in PM<sub>10</sub> emissions of 15.89 tpy. There is an emission decrease because the material is conveyed by an enclosed conveyor into an enclosed storage bin.

In addition to the change in the FORMM system, the permit also reflected the fact that in June 1992 Stone replaced the existing #2 Lime Slaker with a larger lime slaker. The new #2 Lime Slaker has a maximum capacity of 550 gallons per minute (gpm) of green liquor and is controlled by a natural draft wet scrubber. The new #2 Lime Slaker has the same permit limits as the previous slaker. Emissions from the new slaker are also expected to be similar to the old slaker. Even though the new slaker is slightly larger than the old slaker, the emissions would not increase since the vapor velocity in the new slaker is lower than the vapor velocity of the old slaker.

6. On March 24, 1995, Stone applied for Permit #2589-05, which would allow Stone to utilize dewatered sludge from the sludge dewatering facility as fuel for the existing waste fuel and hog fuel boilers at the facility. The dewatered sludge is very similar in nature to hog fuel, with the exception that a lab analysis conducted on the sludge indicated the sludge contains approximately 0.178% sulfur and 1420 milligram per kilogram (mg/kg) of chloride (dry-weight basis). Stone supplied the Department with additional information indicating the sulfur

content of the dewatered sludge may be as high as 0.4%. The maximum rated output from the sludge dewatering facility is 60 tons/day. Both boilers have an alkaline scrubber for control; therefore, this change in fuel would result in a maximum actual emission increase of 17.5 tpy of sulfur dioxide (SO<sub>2</sub>). Stone still has to comply with the existing facility-wide SO<sub>2</sub> limit of 5000 lb/day. There would not be an increase in emissions of oxides of nitrogen (NO<sub>x</sub>), total suspended particulate (TSP), PM<sub>10</sub>, carbon monoxide (CO), or volatile organic compounds (VOCs) as a result of this change in fuel. Permit #2589-05 replaced Permit #2589-04.

Once the Department issued its Preliminary Determination (PD) on Stone's permit application, the Department received extensive comments on the proposal. All the comments received were answered and are available from the Department upon request. The majority of the comments were received from the Missoula City-County Health Department asking the Department to regulate the hog fuel and waste fuel boilers as incinerators and to require a health risk analysis to determine if there would be any adverse health impacts from dioxin/furan emissions from this proposal, as well as from the June 14, 1989, permit that allowed Stone to burn old cardboard container (OCC) rejects in these boilers. In response to these comments, the Department performed an extensive review of the incinerator definition and the potential health impacts of dioxin/furan emissions from this proposal. The Department concluded that these boilers do not fit the definition of an incinerator and, because there would be no increase in dioxin/furan emissions at Stone's facility from this proposal, this permitting action would not result in an adverse impact to human health or the environment. The Department reported these findings at a meeting of the Missoula Air Pollution Control Board on June 15, 1995.

7. Permit Alteration **#2589-06** was issued on February 25, 1996, and allowed Stone to replace the existing third press in the #3 Paper Machine with a shoe press. The change increased the quality of the linerboard produced and allowed the machine to be operated at a higher production rate, from the current capacity of 59.6 tons of air-dried pulp per hour to 64.8 tons air-dried pulp per hour. The permit alteration also limited the yearly production of the #3 Paper Machine. Minor wording changes were also made to the permit at Stone's request. A more detailed description of the change is included in the analysis for Permit #2589-06.
8. On June 7, 1996, Stone was issued Permit **#2589-07** for modifications to the existing scrubbing system on the #4 Smelt Dissolver. A venturi scrubber was added prior to the current scrubber and before the internal design and packing of the current scrubber was modified.

The allowable emissions from the dissolver did not change as a result of this action. However, because the new system operates with an increased efficiency, actual particulate emissions from the dissolver were expected to decrease by 9 tpy.

The scrubber system modification was scheduled to be completed in two phases. Phase I consisted of modifications to the existing scrubber, including replacing the current packing with structured packing, reinforcing the shell to allow for the higher vacuum required for the operation of the venturi scrubber and installing new mist eliminators and spray bars. After completion of Phase I, the efficiency of the scrubber should be comparable to the current unmodified scrubber.

Phase II of the project consisted of installing the additional venturi scrubber upstream of the modified scrubber. The addition of the venturi scrubber was expected to increase the efficiency of the system and result in the anticipated decrease in actual emissions.

Permit Alteration #2589-07 allowed Stone to modify the scrubbing system on the #4 Smelt Dissolver. The scrubber was a packed tower design, using an alkaline solution as the scrubbing liquid. Scale and particulate build-up on the existing packing caused channeling in the scrubber, which decreases the efficiency of the system. Acid cleaning to remove the scale was needed up to three times a year.

The modifications to the scrubber system changed the internal design and packing of the original scrubber and installed a venturi scrubber prior to the modified scrubber. The proposed scrubber system would reduce the need for acid cleaning, as well as provide increased particulate removal efficiency. Based on the manufacturer's specifications, actual particulate emissions from the #4 Dissolver would decrease by approximately 9 tpy.

After issuance of the preliminary determination on May 2, 1996, it was determined that installation of a more efficient control device did not warrant increasing the operational monitoring requirements. The Department determined that the current requirement to monitor scrubber operation weekly, along with annual stack testing, is sufficient to ensure compliance with emission limitations. The scrubber monitoring requirements in Section II.F.5.d. of the preliminary determination of Permit #2589-07 were deleted. Reporting requirements for the dates of construction of the scrubber modification were also added. Permit #2589-07 replaced Permit #2589-06.

9. On December 14, 1999, Stone applied for Permit #2589-08, an alteration to Permit #2589-07. Stone requested the alteration to include conditions for a thermal oxidizer to be installed as part of the Maximum Achievable Control Technology (MACT) I Cluster Rule requirements. Stone is subject to 40 CFR 63, Subpart S (MACT I), for the pulp and paper industry. In order to comply with the regulations, Stone proposed to install and operate a steam stripper and a thermal oxidizer. A steam stripper was installed to reduce air emissions by removing potential pollutants from segregated high methanol condensates. The steam stripper replaced the previous air stripper. The thermal oxidizer was installed to combust the stripper off-gas (SOG) and low volume, high concentration (LVHC) gases from the digester, black liquor evaporator, and turpentine recovery systems.

The Department approved the project as a pollution control project (PCP) under the Prevention of Significant Deterioration (PSD) regulations. The Department reviewed the project and the 1994 EPA memo entitled *Pollution Control Projects and New Source Review (NSR) Applicability*, and determined that the project will be environmentally beneficial. However, the potential emissions for NO<sub>x</sub> were determined to exceed the significance levels under the PSD regulations. Stone conducted modeling to determine the impacts of the NO<sub>x</sub> emissions. The Department reviewed the modeling results, along with previous modeling completed by Stone, and determined that the thermal oxidizer would not cause or contribute to a violation of the national ambient air quality standards, PSD increment, or adversely affect visibility or other air quality related values.

The project also included other activities such as construction of the LVHC-non-condensable gas (NCG) system and re-configuration of the batch digester vent. The permit format and the rule references were updated, as well as updates to conditions in which the Administrative Rule of Montana (ARM) 17.8.321 (Kraft Pulp Mills) applies. Permit #2589-08 replaced Permit #2589-07.

Stone was required to satisfy two requirements to have an approved PCP. Those requirements were: (1) have Departmental approval that the project is a PCP; and (2) provide the public the opportunity to comment. The Department agreed that the project was a PCP and the public was allowed to comment during the preliminary determination issuance.

Subsequently, the Department received comments from both Stone Container and the Montana Coalition for Health, Environmental, and Economic Rights (CHEER). The responses to comments are on file with the Department and the changes that were made to the permit are summarized below. The Department clarified Section II.F.18 by adding the thermal oxidizer and steam stripper to conditions 18.a and 18.b. These conditions now clarify where gaseous emissions are routed after installation and start up of the thermal oxidizer, and the steam stripper. After the installation and start up of the steam stripper and thermal oxidizer the Department can modify the permit to reflect the change. Sections II.F.1.j, 2.j, and 3.j were added to clarify the compliance demonstrations required for the opacity requirements under the kraft pulp mill rule contained in ARM 17.8.321. Section II.F.31.b was changed from requiring a correction to 12% carbon dioxide (CO<sub>2</sub>) to requiring a correction to 10% oxygen (O<sub>2</sub>). Stone demonstrated that because the process does not generate a large amount of CO<sub>2</sub>, the correction could incorrectly inflate the emission calculations. The correction to O<sub>2</sub> would more closely reflect the actual emissions from the thermal oxidizer. Stone also requested that an initial Method 5 test be required on the thermal oxidizer and this requirement was added to Section II.F.33.

10. Stone submitted a complete permit application on December 27, 2000, for the installation and operation of seven temporary, diesel-fired generators at their facility. This application was assigned Permit #2589-09. Stone asserted that the generators were necessary because the high cost of electricity had significantly impacted operations at Stone, forcing a reduction in manufacturing at the Frenchtown facility. The operation of the generators would not occur beyond 2 years and was not expected to last for an extended period of time, but rather only for the length of time necessary for Stone to acquire a permanent, more economical supply of power. Integral to the diesel generators are the electronic engine controls (EEC) and intake air cooling (IAC) for NO<sub>x</sub> emission control.

The temporary generators would only be used when commercial power is too expensive and is impacting mill operations; therefore, the amount of emissions expected during the actual operation of these generators was not anticipated to be major. In addition, the installation of these generators qualifies as a "temporary source" under the PSD permitting program because the permit would limit the operation of these generators to a time period of less than 2 years. As a result, Stone would not need to comply with ARM 17.8.804, 17.8.820, 17.8.822, and 17.8.824. Even though the portable generators were considered temporary, the Department required compliance with Best Available Control Technology (BACT) and public notice requirements; therefore, compliance with ARM 17.8.819 and 17.8.826 would be ensured. In addition, Stone was responsible for

complying with all applicable ambient air quality standards. Permit #2589-09 replaced Permit #2589-08.

The Department received comments on the PD. The comments generally asserted that the best available control technology analysis was incomplete or inadequate, asserted that the Environmental Assessment performed was incomplete or inadequate, requested either operational or emission controls be applied to the temporary generators, and stated that modeling should be conducted prior to permit issuance to assure compliance with ambient air quality standards.

The Department did perform modeling prior to issuing the PD on January 3, 2001, which demonstrated that emissions from the operation of the proposed temporary generators, at maximum potentials, would not violate either the National Ambient Air Quality Standards (NAAQS) or the Montana Air Quality Standards (MAAQS). The Department has since performed additional modeling using a refined model (ISC3) and 5 years of Missoula Meteorological data. The refined modeling also predicted compliance with both the NAAQS and the MAAQS standards at the maximum potential emissions of the proposed generators.

The Department updated the EA to address comments received on the PD. The revised EA expanded the discussion of 7(F) - Air Quality, and 8(E) - Human Health, to acknowledge the modeling conducted prior to issuance of the PD and the refined modeling that followed. In addition, the Department expanded the BACT analysis in response to the comments. The expanded BACT analysis was contained in Section III of the permit analysis.

11. **Permit #2589-10** was issued on September 9, 2003, for the proposed installation of a replacement chip-meter and low-pressure feeder for Stone's existing Chip Kamyr digester (Kamyr). Stone proposed changes to the chip bin to allow installation of the replacement chip-meter. The replacement of the Kamyr's chip-meter would allow that digester to increase its production. Stone intended to increase production of the Kamyr, while curtailing the other digesters. If such an increase in production were to be evaluated with respect to the full potential utilization of the other digesters with the Kamyr, a PSD review may be required. To ensure that the Kamyr project would not increase Stone's potential emissions above the PSD significance level, Stone proposed a mill-wide limitation of 535,000 oven dry tons (ODT) of wood pulp production per year. The Kamyr, when compared with the combined production of the digester systems, produces the highest pulp quality at the highest pulp yield and uses the least steam per ton of pulp, resulting in less black liquor solids generation per ton of pulp. Therefore, actual emissions resulting from the implementation of this project were expected to decrease.

Potential emissions for the 535,000 ODT of wood pulp production per year were calculated using emission factors for the Kamyr digester alone, as this represents the most likely scenario. However, Stone retains the ability to operate the other digesters as they are currently permitted, either alone, or in combination with the Kamyr. Permit #2589-10 replaced Permit #2589-09.

## C. Current Permit Action

Stone submitted a request for permit amendment on December 12, 2002, to make the Montana Air Quality permit (MAQP #2589-10) consistent with the Title V operating permit (OP2589-01). The requested changes include: removal of the hog fuel boiler and the No. 2 package boiler from the MAQP (these sources are no longer operational and have been removed), replacement of the term “Waste Fuel Boiler” with the term “Multi-fuel Boiler” to reflect the true nature of the fuels burned in the boiler, updating the listing of sources in Section II.B of the MAQP that do not require annual testing per the testing requirements in the Title V permit, clarification of emission testing and reporting requirements, clarification of conditions/requirements of current operating scenarios already included in the Title V permit, and designation of all ambient air monitoring requirements as “State Only” (now possible under the revised ARM 17.8, Subchapter 7 rules (effective December 27, 2002)). In addition, Stone submitted de minimis requests on April 21, 2003; August 8, 2003; and September 10, 2003, which will be incorporated into the MAQP. The April 21, 2003, and September 10, 2003, requests included proposals to use wood residual pellets from the Plum Creek Medium Density Fiberboard (MDF) Plant as a fuel in the multi-fuel boiler and to use recycled oil as a fuel in the lime kilns, multi-fuel boiler, and the recovery boilers. The Department determined that both fuels were consistent with currently permitted “wood waste” and “fuel oil” for those sources. The August 8, 2003, request included proposals for installation of the pollution control project for sources subject to 40 CFR 63, Subpart MM (hereinafter referred to as MACT II). The projects associated with MACT II are expected to provide a decrease in the Missoula Mill’s potential emissions. The August 4, 2004, request included comments on the amendment language previously discussed including clarifications to the permit to allow for the reporting timelines as specified in the Montana Source Test Protocol and Procedures Manual; deletion of NSPS limits when more stringent MACT II limits exist for the same unit (the NSPS limits remain applicable, but do not need to be listed in the MAQP in addition to the MACT II limits); modification of the multi-fuel boiler scrubbing solution pH limit to clarify that it must remain above 7 (alkaline) instead of increasing every time a stack test is performed, as it was previously stated; removal of requirements to report the number of hours above the 8 parts per million (ppm) 12-hour TRS standard for the lime kilns and recovery boilers because there was no regulatory authority for those requirements; and several other editorial clarifications. The August 9, 2004, request included a change in the to decrease the particulate matter (PM) and PM<sub>10</sub> emission limits on the FORMM baghouse to enable the removal of the hours of operation limit (previously 8544 hours) on that baghouse. The change would slightly decrease potential emissions. **Permit #2589-11** replaces Permit #2589-10.

D. Additional Information

Additional information, such as applicable rules and regulations, BACT determinations, air quality impacts, and environmental assessments, is included in the analysis associated with each change to the permit.

II. Applicable Rules and Regulations

The following are partial explanations of some applicable rules and regulations that apply to the facility. The complete rules are stated in the ARMs and are available, upon request, from the Department. Upon request, the Department will provide references for locations of complete copies of all applicable rules and regulations or copies where appropriate.

- A. ARM 17.8, Subchapter 1 – General Provisions, including, but not limited to:
1. ARM 17.8.101 Definitions. This rule includes a list of applicable definitions used in this chapter, unless indicated otherwise in a specific subchapter.

2. ARM 17.8.105 Testing Requirements. Any person or persons responsible for the emission of any air contaminant into the outdoor atmosphere shall, upon written request of the Department, provide the facilities and necessary equipment, including instruments and sensing devices, and shall conduct tests, emission or ambient, for such periods of time as may be necessary using methods approved by the Department.
3. ARM 17.8.106 Source Testing Protocol. The requirements of this rule apply to any emission source testing conducted by the Department, any source, or other entity as required by any rule in this chapter, or any permit or order issued pursuant to this chapter, or the provisions of the Clean Air Act of Montana, 75-2-101, *et seq.*, Montana Code Annotated (MCA).  
  
Stone shall comply with the requirements contained in the Montana Source Test Protocol and Procedures Manual, including, but not limited to, using the proper test methods and supplying the required reports. A copy of the Montana Source Test Protocol and Procedures Manual is available from the Department upon request.
4. ARM 17.8.110 Malfunctions. (2) The Department must be notified promptly by telephone whenever a malfunction occurs that can be expected to create emissions in excess of any applicable emission limitation, or to continue for a period greater than 4 hours.
5. ARM 17.8.111 Circumvention. (1) No person shall cause or permit the installation or use of any device or any means which, without resulting in reduction in the total amount of air contaminant emitted, conceals or dilutes an emission of air contaminant which would otherwise violate an air pollution control regulation. (2) No equipment that may produce emissions shall be operated or maintained in such a manner that a public nuisance is created.

B. ARM 17.8, Subchapter 2 – Ambient Air Quality, including, but not limited to:

1. ARM 17.8.210 Ambient Air Quality Standards for Sulfur Dioxide
2. ARM 17.8.211 Ambient Air Quality Standards for Nitrogen Dioxide
3. ARM 17.8.212 Ambient Air Quality Standards for Carbon Monoxide
4. ARM 17.8.213 Ambient Air Quality Standard for Ozone
5. ARM 17.8.214 Ambient Air Quality Standard for Hydrogen Sulfide
6. ARM 17.8.220 Ambient Air Quality Standard for Settled Particulate Matter
7. ARM 17.8.221 Ambient Air Quality Standard for Visibility
8. ARM 17.8.222 Ambient Air Quality Standard for Lead
9. ARM 17.8.223 Ambient Air Quality Standard for PM<sub>10</sub>

Stone must comply with all applicable ambient air quality standards.

C. ARM 17.8, Subchapter 3 – Emission Standards, including, but not limited to:

1. ARM 17.8.304 Visible Air Contaminants. This rule requires that no person may cause or authorize emissions to be discharged to an outdoor atmosphere from any source installed after November 23, 1968, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes.
2. ARM 17.8.308 Particulate Matter, Airborne. Under this rule, Stone shall not cause or authorize the use of any street, road, or parking lot without taking reasonable precautions to control emissions of airborne particulate matter.

3. ARM 17.8.309 Particulate Matter, Fuel Burning Equipment. This rule requires that no person shall cause, allow, or permit to be discharged into the atmosphere particulate matter caused by the combustion of fuel in excess of the amount determined by this section.
4. ARM 17.8.310 Particulate Matter, Industrial Process. This rule requires that no person shall cause, allow, or permit to be discharged into the atmosphere particulate matter in excess of amount set forth herein.
5. ARM 17.8.321 Kraft Pulp Mill. This rule applies to Kraft Pulp Mills operated in Montana. The rule contains exceptions to the opacity standards contained in this chapter, as well as additional requirement for Kraft Pulp Mills. Stone is required to comply with the requirements of the Kraft Pulp Mill rule.
6. ARM 17.8.322 (4) Sulfur Oxide Emissions – Sulfur in Fuel. This section applies to the portable generators. Stone shall not burn liquid or solid fuels containing sulfur in excess of 1 lb per million British thermal unit (Btu) fired.
7. ARM 17.8.322 (5) Sulfur Oxide Emissions – Sulfur in Fuel. Commencing July 1, 1971, no person shall burn any gaseous fuel containing sulfur compounds in excess of 50 grains per 100 cubic feet of gaseous fuel, calculated as hydrogen sulfide at standard conditions.
8. ARM 17.8.340 Standard of Performance for New Stationary Sources. This rule incorporates, by reference, 40 CFR Part 60, NSPS. The owner or operator or any stationary source or modification, as defined and applied in 40 CFR Part 60, shall comply with the applicable standards and provisions of 40 CFR Part 60.

40 CFR 60, Subpart A – General Provisions. This subpart applies to all affected equipment or facilities subject to an NSPS subpart listed below.

40 CFR 60, Subpart D – Standards of Performance Fossil Fuel Fired Steam Generators. This subpart would apply to the waste-fuel boiler because it is a fossil-fuel-fired steam generator with a heat input capacity greater than 250 MMBtu/hr that commenced construction after August 17, 1971.

40 CFR 60, Subpart BB – Standards of Performance for Kraft Pulp Mills. This subpart would apply to the #5 Recovery Boiler, #4 Lime Kiln, and #5 Smelt Dissolving Tank because Stone is a kraft pulp mill and these units are listed as affected facilities that commenced construction or modification after September 24, 1976.

9. ARM 17.8.342 Emission Standards for Hazardous Air Pollutants for Source Categories. The source, as defined and applied in 40 CFR Part 63, shall comply with the requirements of 40 CFR Part 63, as listed below:

40 CFR 63, Subpart A – General Provisions. This subpart applies to all equipment or facilities subject to an MACT Subpart as listed below.

40 CFR 63, Subpart S – Cluster Rule for the Pulp and Paper Industry

40 CFR 63, Subpart MM – National Emission Standards for Hazardous Air Pollutants for Chemical Recovery Combustion Sources at Kraft, Soda, Sulfite, and Stand-Alone Semichemical Pulp Mills

D. ARM 17.8, Subchapter 5 – Air Quality Permit Application, Operation and Open Burning Fees, including, but not limited to:

1. ARM 17.8.504 Air Quality Permit Application Fees. This rule requires that an applicant submit an air quality permit application fee concurrent with the submittal of an air quality permit application. A permit application is incomplete until the proper application fee is paid to the Department. The current permit action is an administrative action; therefore, no fee was required.
2. ARM 17.8.505 Air Quality Operation Fees. An annual air quality operation fee must, as a condition of continued operation, be submitted to the Department by each source of air contaminants holding an air quality permit, excluding an open burning permit, issued by the Department; and the air quality operation fee is based on the actual or estimated actual amount of air pollutants emitted during the previous calendar year.

An air quality operation fee is separate and distinct from an air quality permit application fee. The annual assessment and collection of the air quality operation fee, described above, shall take place on a calendar-year basis. The Department may insert into any final permit issued after the effective date of these rules, such conditions as may be necessary to require the payment of an air quality operation fee on a calendar-year basis, including provisions which pro-rate the required fee amount.

E. ARM 17.8, Subchapter 7 – Permit, Construction and Operation of Air Contaminant Sources, including, but not limited to:

1. ARM 17.8.740 Definitions. This rule is a list of applicable definitions used in this chapter, unless indicated otherwise in a specific subchapter.
2. ARM 17.8.743 Montana Air Quality Permits – When Required. This rule requires a person to obtain an air quality permit or permit alteration to construct, alter, or use any air contaminant sources that have the Potential to Emit (PTE) more than 25 tons per year of any pollutant. Stone has a PTE greater than 25 tons per year of PM<sub>10</sub>, NO<sub>x</sub>, SO<sub>2</sub>, CO and VOCs; therefore an air quality permit is required.
3. ARM 17.7.744 Montana Air Quality Permits – General Exclusions. This rule identifies the activities that are not subject to the Montana Air Quality Permit program.
4. ARM 17.8.745 Montana Air Quality Permits – Exclusion for De Minimis Changes. This rule identifies the de minimis changes at permitted facilities that do not require a permit under the Montana Air Quality Permit Program.
5. ARM 17.8.748 New or Modified Emitting Units – Permit Application Requirements. (1) This rule requires that a permit application be submitted prior to installation, alteration or use of a source. Stone submitted the required permit application for the current permit action. (7) This rule requires that the applicant notify the public by means of legal publication in a newspaper of general circulation in the area affected by the application for a permit. The current

permit action is an administrative action; therefore, no public notice was required.

6. ARM 17.8.749 Conditions for Issuance or Denial of Permit. This rule requires that the permits issued by the Department must authorize the construction and operation of the facility or emitting unit subject to the conditions in the permit and the requirements of this subchapter. This rule also requires that the permit must contain any conditions necessary to assure compliance with the Federal Clean Air Act (FCAA), the Clean Air Act of Montana, and rules adopted under those acts.
7. ARM 17.8.752 Emission Control Requirements. This rule requires a source to install the maximum air pollution control capability that is technically practicable and economically feasible, except that BACT shall be utilized. The required BACT analysis is included in Section III of this permit analysis.
8. ARM 17.8.755 Inspection of Permit. This rule requires that air quality permits shall be made available for inspection by the Department at the location of the source.
9. ARM 17.8.756 Compliance with Other Requirements. This rule states that nothing in the permit shall be construed as relieving Stone of the responsibility for complying with any applicable federal or Montana statute, rule, or standard, except as specifically provided in ARM 17.8.740, *et seq.*
10. ARM 17.8.762 Duration of Permit. An air quality permit shall be valid until revoked or modified, as provided in this subchapter, except that a permit issued prior to construction of a new or altered source may contain a condition providing that the permit will expire unless construction is commenced within the time specified in the permit, which in no event may be less than 1 year after the permit is issued.
11. ARM 17.8.763 Revocation of Permit. An air quality permit may be revoked upon written request of the permittee, or for violations of any requirement of the Clean Air Act of Montana, rules adopted under the Clean Air Act of Montana, the FCAA, rules adopted under the FCAA, or any applicable requirement contained in the Montana SIP.
12. ARM 17.8.764 Administrative Amendment to Permit. An air quality permit may be amended for changes in any applicable rules and standards adopted by the Board of Environmental Review (Board) or changed conditions of operation at a source or stack that do not result in an increase of emissions as a result of those changed conditions. The owner or operator of a facility may not increase the facility's emissions beyond permit limits unless the increase meets the criteria in ARM 17.8.745 for a de minimis change not requiring a permit, or unless the owner or operator applies for and receives another permit in accordance with ARM 17.8.748, ARM 17.8.749, ARM 17.8.752, ARM 17.8.755, and ARM 17.8.756, and with all applicable requirements in ARM Title 17, Chapter 8, Subchapters 8, 9, and 10.
13. ARM 17.8.765 Transfer of Permit. This rule states that an air quality permit may be transferred from one person to another if written notice of Intent to Transfer, including the names of the transferor and the transferee, is sent to the

Department.

14. ARM 17.8.770 Additional Requirements for Incinerators. This rule specifies the additional information that must be submitted to the Department for incineration facilities subject to 75-2-215, MCA.

F. ARM 17.8, Subchapter 8 – Prevention of Significant Deterioration of Air Quality, including, but not limited to:

1. ARM 17.8.801 Definitions. This rule is a list of applicable definitions used in this subchapter.
2. ARM 17.8.818 Source Applicability and Exemptions. The requirements contained in ARM 17.8.819 through ARM 17.8.827 shall apply to any major stationary source and any major modification with respect to each pollutant subject to regulation under the FCAA that it would emit, except as this subchapter would otherwise allow.

Stone is a "major stationary source" because it is a listed source and has a PTE greater than 100 tons of any pollutant. The current permit action is considered an administrative permit action and does not involve any increase in emissions.

G. ARM 17.8, Subchapter 12 – Operating Permit Program Applicability, including, but not limited to:

1. ARM 17.8.1201 Definitions. (23) Major Source under Section 7412 of the FCAA is defined as any stationary source having:
  - a. PTE > 100 tons/year of any pollutant;
  - b. PTE > 10 tons/year of any one Hazardous Air Pollutant (HAP), PTE > 25 tons/year of a combination of all HAPs, or lesser quantity as the Department may establish by rule; or
  - c. PTE > 70 tons/year of PM<sub>10</sub> in a serious PM<sub>10</sub> nonattainment area.
2. ARM 17.8.1204 Air Quality Operating Permit Program Applicability. (1) Title V of the FCAA Amendments of 1990 requires that all sources, as defined in ARM 17.8.1204 (1), obtain a Title V Operating Permit. In reviewing and issuing Air Quality Permit #2589-11 for Stone, the following conclusions were made:
  - a. The facility's PTE is greater than 100 tons/year for PM<sub>10</sub>, SO<sub>2</sub>, NO<sub>x</sub>, CO, and VOCs.
  - b. The facility's PTE is greater than 10 tons/year of any one HAP and greater than 25 tons/year of all HAPs.
  - c. This source is not located in a serious PM<sub>10</sub> nonattainment area.
  - d. This facility is subject to current NSPS standards (40 CFR 60, Subparts D and BB).
  - e. This facility is subject to current NESHAP standards.

- f. This source is not a Title IV affected source.
- g. This source is not an EPA designated Title V source.

Based on these facts, the Department has determined that Stone is a major source of emissions as defined under Title V. Stone's Title V Operating Permit (OP2589-01) was issued final and effective on January 22, 2002.

H. MCA 75-2-103, Definitions provides in part as follows:

1. An incinerator means any single or multiple-chambered combustion device that burns combustible material, alone or with a supplemental fuel or catalytic combustion assistance, primarily for the purpose of removal, destruction, disposal, or volume reduction of all or any portion of the input material.
2. Solid waste means all putrescible and nonputrescible solid, semisolid, liquid, or gaseous wastes including, but not limited to, ...air pollution control facilities...

I. MCA 75-2-215, Solid or hazardous waste incineration -- additional permit requirements including, but not limited to, the following requirements:

The Department may not issue a permit to a facility until: (d) the Department has reached a determination that the projected emissions and ambient concentrations will constitute a negligible risk to the public health, safety, and welfare and to the environment.

A health risk analysis to estimate the risk from the burning of hazardous air pollutants in the thermal oxidizer was completed as part of Permit Application #2589-08. The risk analysis contained the HAPs from the 1990 FCAA Amendments with an established risk value. The ambient concentrations were determined using SCREEN3. The SCREEN3 model results indicated that a health risk assessment was not necessary because the HAP concentrations shown in Table I were less than the levels contained in ARM 17.8.770.

**Table I. Health Risk Analysis HAP Concentrations**

Pollutant	Modeled Level	Cancer De Minimis Level	Non-Cancer De Minimis Level (chronic)
Acetaldehyde	3.84*10 <sup>-3</sup>	4.5455*10 <sup>-2</sup>	9.00*10 <sup>-2</sup>
Benzene	8.02*10 <sup>-3</sup>	1.2048*10 <sup>-2</sup>	7.10*10 <sup>-1</sup>
Formaldehyde	3.74*10 <sup>-3</sup>	7.6923*10 <sup>-3</sup>	3.60*10 <sup>-2</sup>
n-Hexane	1.49*10 <sup>-3</sup>	NA	2.00
Methanol	1.87*10 <sup>-1</sup>	NA	6.20
Methyl ethyl keytone	4.13*10 <sup>-3</sup>	NA	1.00*10 <sup>1</sup>
Styrene	2.20*10 <sup>-4</sup>	NA	1.00*10 <sup>1</sup>
1,2,4-Trichlorobenzene	2.83*10 <sup>-3</sup>	NA	NA
M,p-Xylene	1.15*10 <sup>-3</sup>	NA	3.00
o-Xylene	6.20*10 <sup>-4</sup>	NA	3.00

The health risk analysis demonstrated that the installation and operation of the thermal oxidizer would constitute a negligible risk to the public health.

### III. BACT Determination

A BACT determination is required for each new or altered source for which an MAQP is required. Stone Container shall install on the new or altered source the maximum air pollution control capability, which is technically practicable and economically feasible, except that BACT shall be utilized. This permit action does not address any new or altered source (that have increased emissions); therefore, no BACT analysis or determination is required.

IV. Emission Inventory: Permit #2589-11

Previous emission inventories completed are on file with the Department. This action does not involve any permitted increases; therefore, no emission inventory information was included.

V. Existing Air Quality

The Missoula area is currently a nonattainment area for PM<sub>10</sub> and CO standards. Stone is a source outside the nonattainment area that has been shown to impact the area. The current permit action does not increase allowable PM<sub>10</sub> levels.

VI. Ambient Air Monitoring Plan

Stone shall conduct ambient monitoring as described in Attachment 1. On April 9, 1992, Stone requested not to operate a collocated PM<sub>10</sub> sampler at Site #1A. The Department reviewed this request and on April 14, 1992, sent a letter to Stone waiving this requirement as long as Missoula County calibrates and maintains the PM<sub>10</sub> samplers, processes the PM<sub>10</sub> filters in the county laboratory, and performs the necessary calculations. If Stone changes the handling of the equipment and filters, then operation of a collocated sampler will be required (See Attachment 1 of the permit).

VII. Air Quality Impacts

The current permit action does not increase allowable emissions for the facility. Therefore, anticipated air quality impacts would be minor.

VIII. Takings or Damaging Implication Analysis

As required by 2-10-101 through 105, MCA, the Department conducted a private property taking and damaging assessment and determined there are no taking or damaging implications.

IX. Environmental Assessment

An environmental assessment was not required for this action because it is an administrative action.

Permit Analysis Prepared by: Debbie Skibicki

Date: August 18, 2004